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(54) **ACCUMULATION CONVEYOR**

(57) With a simple structure, an accumulation conveyor can reduce the distance between articles to be conveyed, so as to improve its efficiency and conveyance efficiency. The accumulation conveyor 10 in accordance with the present invention comprises a motor 20, provided for each zone Z, for driving a carrier roller 18 constituting the zone Z to rotate; a sensor 22, provided for each zone Z, for detecting passing of an article C to be conveyed; and control means 26 for estimating according to

detection information of two articles C1, C2 adjacent to each other detected by the sensor 22 distance information concerning the distance between the articles and switching, when the estimated distance information falls within a predetermined range, a control input to a motor 20n of a zone Zn conveying the article C2 at the back on the upstream side or a motor 20n+1 of a zone Zn+1 adjacent downstream thereto such that the zone Zn has a conveying speed faster than that of the zone Zn+1.

Fig.1

