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(54) Title: AUTOMATIC STORAGE AND DISTRIBUTION SYSTEM, AND HOUSING UNIT AND PICKING UNIT FOR PRODUCTS PACKAGED IN UNIT DOSES

(57) Abstract: A storage and distribution system for products in unit doses, comprising a plurality of housing units (20), each of which comprises a plurality of locations for products in unit doses. The housing units (20) can be organised on a substantially vertical plane so as to produce at least one portion of a picking wall (15, 16), in which the locations for products in unit doses face selective picking means (18). A picking unit comprises picking means (130) that can be oriented the picking wall (15, 16) for picking products packaged in unit doses. A collecting unit (110), arranged on a second side of the picking unit, comprises a rack (114) having a plurality of pegs (116) facing towards the first side of the picking unit. The pegs (116) can be reached by the picking means (130) so as to pick therefrom or deposit thereon products packaged in unit doses. The plurality of pegs (116) as a whole can collect a smaller number of unit dose products than those that can be stored in the automatic store.

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AUTOMATIC STORAGE AND DISTRIBUTION SYSTEM, AND HOUSING UNIT AND PICKING UNIT FOR PRODUCTS PACKAGED IN UNIT DOSES

Field of the invention

The present invention relates to the sector of the storage and distribution of unit dose products. The invention was developed with particular regard, although not exclusively, to the storage and distribution of unit dose drugs.

Technological background

There are known automatic systems for the storage of unit dose drugs and the distribution thereof in groups determined in accordance with specific medical prescriptions. Storage systems for unit dose drugs are widespread in hospital pharmacies. Medical prescriptions for individual patients, to whom one or more drugs have to be administered daily or several times a day, arrive from the hospital departments. Hospital pharmacies make arrangements to recover the drugs requested from the store of unit dose drugs, and to distribute them to the various hospital departments, grouped together according to the specific medical prescriptions.

An automatic store of the above-mentioned type is described in EP 1346929 from the same applicant. The automatic store for unit dose drugs comprises a plurality of endless belts. Pegs are fixed to each endless belt, from which pegs small packets can be hung, each of which contains a unit dose of a corresponding drug or other product used in hospital departments, for example a syringe, gauze, an ampoule or bottle of normal saline, and so on. A picking system is arranged on one side of the automatic store for picking the packets of unit dose products that are presented progressively following a rotation of the belts. Picking
devices of a known type generally comprise a grasping member, for example a pincer or suction member, that can be displaced on a vertical plane, for example along two Cartesian axes X-Y, so as to be successively positioned opposite the various unit dose products to be picked according to the various medical prescriptions. Each product picked in this way is sent to a system for preparing the specific medical prescriptions, by grouping together several unit dose products, for example by means of the system described in EP 1346931 from the same applicant.

Although the automatic store described in EP 1346929 provides satisfactory performance, there is an ever-greater demand in the sector for increasing performance in the storage and distribution of unit dose drugs, and particularly for increasing the storage density of unit doses. The applicant has developed a specific support for drug unit doses that allows greater storage density and lower cost per packet. This involves a card-shaped support, as described in WO 2014/207507, provided with a hole by which the support can be hung from a peg. This support is particularly compact and economical and makes it possible to increase the storage density of the unit dose drugs. There is, however, still a perceived need to have a store with a more compact configuration than that of known stores, which can receive these card-shaped supports for convenient and compact storage thereof. Preferably, such a store should be capable of also accommodating known types of packets, so as to allow them to be stored and managed separately or in combination with the card-shaped supports. Furthermore, greater storage density leads to an even more pressing need to accelerate the process of picking from the store of unit dose drugs, for faster and more efficient distribution thereof to the various hospital departments.
One object of the present technology is that of producing an automatic system for storing and distributing unit dose products that is compact and proves efficient and reliable. Another object of the technology is that of producing a unit for storing and distributing unit dose products that is simple to manage. Another object of the technology is that of producing an automatic system that makes it easy, fast and safe to pick unit dose products. Another object of the present technology is that of accelerating and optimising the process of picking and distributing products packaged in unit doses stored in an automatic store system. Another object of the technology is that of providing a unit for picking products packaged in unit doses that is compact, can be expanded in modules and proves efficient and reliable. Another object of the technology is that of producing a unit for picking products packaged in unit doses that can be used in combination with any store for drugs that are packaged in unit doses so as to be hung from pegs or similar supports. Another object of the technology is that of producing a unit for picking products packaged in unit doses that is simple to manage. Another object of the technology is that of producing an automatic system that makes it easy, fast and safe to pick and group together products packaged in unit doses. Another object of the technology is that of producing a collecting unit that can be added, even retrofitted, to a pre-existing picking unit in an automatic store for products packaged in unit doses.

In view of the above-mentioned objects, the technology described relates to an automatic storage and distribution system. The technology described also relates to a housing
unit. The technology described also relates to a method for distributing unit dose products. The technology described also relates to a unit for picking products packaged in unit doses. The technology described also relates to a method for picking and distributing products packaged in unit doses.

According to a first aspect described, the storage and distribution system for products in unit doses comprises a plurality of housing units. Each of these units comprises a plurality of locations for products in unit doses. The housing units can be organised on a substantially vertical plane so as to produce at least one portion of a picking wall. The locations for products in unit doses on said picking wall face selective picking means. The dynamic implementation of such a picking wall, by organising the housing units, which can be placed, removed or substituted on the picking wall portion, makes it particularly flexible and fast to present unit dose products to the selective picking means.

According to a particular aspect, each housing unit comprises a box-shaped body having at least one front opening from which the unit dose products can be picked. The box-shaped bodies can be housed in at least one shelf so as to form the at least one portion of the picking wall. The use of box-shaped bodies makes it particularly simply to handle the housing units, and to house them on one or more shelves so as to form the at least one picking wall portion.

According to another particular aspect, the at least one shelf is open on two sides, one facing the selective picking means and the other communicating with a storage zone for the housing units. In this way, the housing units can be inserted into the shelves from the rear, into which the storage zone
extends, without interfering with the selective picking means placed at the front of the shelves.

According to another particularly advantageous aspect, the at least one shelf comprises a plurality of bearing planes, on which the housing units are selectively placed so that the box-shaped bodies have their front opening facing the picking zone.

Advantageously, the distance between bearing planes substantially corresponds to the height of the box-shaped bodies of the housing units, so that these are inserted securely between one bearing plane and another. Advantageously, on each bearing plane, stop means are produced for the box-shaped bodies of the housing units. In this way, the housing units can be inserted into the shelves from the rear until they meet the stop means, preferably placed at the front of the bearing planes and locked in the most suitable position for picking the unit dose products. The stop means are releasable, for example of the snap-on type, so that with sufficient force the handling means of the housing units can unhook them from the stop means on the bearing planes so as to extract them from the shelves.

According to another aspect, a description is given of a housing unit particularly well suited for use in a storage and distribution system of the above-mentioned type. The housing unit comprises a box-shaped body having a front opening. Support elements are arranged in the box-shaped body for a plurality of supports for unit dose products. Advantageously, the support elements are pegs that project from a rear wall and face the front opening of the box-shaped body. According to a particular aspect, there is more than one peg for each housing unit. Said pegs are also tilted upwards and are aligned horizontally relative to each other.
The pegs are arranged close to an upper wall of the box-shaped body (21) so that supports for unit dose products of different lengths can be hung therefrom.

According to another advantageous aspect, the housing unit comprises a selectively removable cover for closing the front opening of the box-shaped body, for example to prevent unit dose products from falling out in the case of external transport.

According to another aspect, a method is described for distributing unit dose products housed in a housing unit. By means of a storage and distribution system, there is provision for transporting one or more housing units and organising them on a substantially vertical plane so as to produce at least one portion of a picking wall. The locations for products in unit doses on the portion of picking wall face selective picking means. The method provides for asynchronously activating the selective picking means, so as to pick desired unit dose products from the housing units. The fact that the selective picking means are activated asynchronously from the transport of the housing units allows the distribution operations to be organised logistically so as to operate in picking mode substantially without interruption.

According to another aspect described, the unit for picking products packaged in unit doses comprises picking means that can be oriented towards a first side and an opposite, second side of the picking unit. When oriented towards the first side, the picking means are suitable, in use, for picking products packaged in unit doses from one face of an automatic store of the above-mentioned type and described below in one of its preferred but not restrictive embodiments. A collecting unit is arranged on the second
side, opposite the first side relative to the picking means, of the picking unit. The collecting unit comprises a rack having a plurality of pegs facing towards the first side. The pegs of the rack can be reached by the picking means so as to pick therefrom or deposit thereon products packaged in unit doses. The pegs as a whole can collect a smaller number of unit dose products than those that can be stored in the automatic store. The collecting unit thereby acts as a temporary buffer for products before their final grouping together and delivery, or also as an auxiliary store for more widely consumed or more urgently used products, so as to optimise the picking times for these products and their automatic distribution.

According to a particular aspect, the rack comprises at least two distinct rack zones, in which the spacing between the various pegs is correspondingly different, so as to house at least two corresponding pack sizes for unit dose products. In this way, the requirements for storing products even with very different sizes from each other are reconciled with the requirements of maintaining a high degree of compactness and storage density of products on the collecting unit as well as in the automatic store.

According to a particular aspect, each peg on the rack is placed beside means for aligning the packs of unit dose products hanging from said pegs and separating them from the packs of unit dose products hanging from an adjacent peg. In this way, it is possible to accelerate the operations of picking products from and/or positioning them on the pegs of the rack, without having to worry about any oscillations in the packs of unit dose products that might interfere with the packs hanging from adjacent pegs.
According to a particular aspect, the collecting unit comprises a frame for supporting substantially vertical panels defining a base of the rack. The structure of the rack is thereby simplified. Furthermore, the base panels of the rack can be changed quickly for maintenance or for changing the configuration or number of pegs.

According to a particular feature, the collecting unit comprises supports for members for grouping together the products packaged in unit doses. In particular, shelves for supporting the grouping members can be fixed to the frame of the collecting unit. In this way, the rack of the collecting unit is placed close to the grouping members, making it faster to transfer the products from the first to the second grouping members, also because the picking member does not have to turn from side to side as when picking products from the automatic store to transfer them to the grouping members. It is therefore possible to preset on the rack of the collecting member, and pick well in advance from the automatic store those products that will be used together later in a single grouping, consequently saving time and making the grouping operations faster, it being possible to use the downtime in which no operation of grouping and distributing said products is required, for transferring products from the automatic store to the collecting unit.

According to another aspect, the collecting unit comprises means for selective coupling to a structure for supporting and handling the picking means. This makes the collecting unit an element that can optionally be combined with a handling assembly for the picking means, so that it can also be connected easily and securely to a pre-existing picking unit that does not have a collecting module.
According to another aspect, a method is described for picking and distributing products packaged in unit doses, using a picking unit of the above-mentioned type. According to this method, the picking means are controlled selectively when picking so as to perform one of the three following movements according to need:

a) from the first side to the second side, in order to collect at least one product packaged in a unit dose from an automatic store and to transfer it either to a predetermined peg of the rack or to a loading zone of a grouping member, or

b) from a given position on the rack on the second side to another given position on the rack on the second side, in order to transfer a product packaged in a unit dose from one position to the other on the rack of the collecting unit, or

c) From a given position on the rack on the second side to a predetermined zone on the second side corresponding to a loading zone of a grouping member.

**Brief description of the figures**

Further features and advantages will become apparent from the following detailed description of some preferred embodiments of the technology, given purely by way of non-restrictive example, with reference to the attached drawings, in which:

- Fig. 1 is a diagrammatic elevation view of an automatic store according to the present technology;

- Fig. 2 is a diagrammatic plan view of the automatic store in Fig. 1;

- Fig. 3 is an enlarged view of the device for picking products from the automatic store in Fig. 1;
- Fig. 4 is a perspective view of a storage unit according to the present technology, provided with an optional cover;

- Fig. 5 is a diagrammatic perspective view of an example of a picking unit provided with a collecting unit according to the present technology, and not provided with the outer covering for clarity of illustration and shown from the side that, during use, faces towards the store of products packaged in unit doses as shown in Fig. 1;

- Fig. 6 is an elevation view in the direction of the arrow VI in Fig. 5;

- Fig. 7 is a perspective enlarged view of a detail of the collecting unit of Fig. 5 and 6; and

- Fig. 8 is a diagrammatic perspective view of the collecting unit of Fig. 5 to 7, shown from the side opposite that in Fig. 5, which, during use, faces towards the unloading of the groups of products packaged in unit doses.

**Detailed description**

With reference now to Fig. 1 to 4, an automatic store 10 is intended for the storage of unit dose products. The unit dose products are preferably drugs or other related, medically prescribed products such as syringes, ampoules or bottles of normal saline, gauze, dressings, sterile compresses, and so on. The automatic store 10 is provided mainly, although not exclusively, for use with unit dose products supported by appropriate supports that can be hung from a peg.

The automatic store 10 is suitable for storing a plurality of housing units 20 that are more clearly visible in Fig. 4. Each housing unit 20 comprises a box-shaped body 21. The box-shaped body 21 is defined by an upper wall 22, a
lower wall 23, two sides 24 and a rear wall 25, which overall define a front opening 19 in the box-shaped body 21. Inside the box-shaped body 21, some pegs 26 are provided, projecting out from the rear wall 25. From each peg 26, one or more supports S for unit dose products can be hung. Preferably, there is more than one peg for each housing unit 20, and even more preferably, there are three or four, as illustrated in Fig. 4. The pegs 26 are tilted upwards from the rear wall 25. The ends of the pegs 26 are aligned horizontally relative to each other. Fundamentally, the pegs 26 are parallel to each other and lie on the same plane, slightly tilted relative to the horizontal. The pegs 26 are arranged close to the upper wall 22 of the box-shaped body 21. The pegs 26 are tilted upwards so that the supports S for the unit dose products hanging therefrom rest on each other and against the rear wall 25. The housing unit 20 can thus be transported without any risk of the products housed therein falling. Preferably, inside the box-shaped body 21 of the housing unit 20, separating partitions 27 are produced, keeping the supports S for the unit dose products aligned and preventing or reducing their oscillation during transport. The pegs 26 are the preferred support elements for the supports S of unit doses, but naturally supports having a different shape can be provided, such as rods, guide bars, combs, slots and the like, also depending on the shape of the supports S.

The size of the housing unit 20 is preferably standardised so that it can be managed interchangeably within the automatic store 10, as will be explained more clearly below. In particular cases, two or more types of housing unit 20 can be provided, for example a first type of housing unit 20' for unit dose drugs, and a second type of housing unit 20" for more bulky products, for example syringes, dressings, gauze, bottles and the like.
Preferably, each housing unit 20 is identified by means of a barcode 28 and/or an RFID tag 29 placed on the box-shaped body 21. On the sides 24, gripping notches 30 are provided, in which the members for handling the box-shaped bodies 21 within the store 21 engage, for example the jaws of a handling robot or a stacker crane of a generally known type. In an area at the front of the box-shaped body 21, preferably on the lower wall 23, there is a coupling or locking system, for example a slot 33 or other element for removably securing the box-shaped body 21 on a shelf, for storage or picking purposes, as described more clearly below.

The unit dose products are preferably transported in groups of products contained in the housing unit 20. Preferably but not restrictively, the unit dose products supported by the same peg 26 are products of the same type. The unit dose products supported by different pegs 26 inside the same housing unit 20 can be of the same type or different types. The housing unit is moved around inside the automatic store 10 while preferably keeping it in the vertical position illustrated in Fig. 4. As stated above, handling is done by means of a known type of handling apparatus, such as a stacker crane, a robot, a shuttle or similar means, provided with grasping means such as pincers or jaws or the like, capable of engaging in the gripping notches 30. Controlling the accelerations when handling the housing unit 20 prevents the unit dose products from coming off from the pegs 26 and out of the housing unit 20 itself. Where it is not possible to control the accelerations, or where it is wished to achieve very high speeds when transferring the housing units 20, or where it is necessary to transport the housing units 20 outside the automatic store 20, for example if they are to be loaded by an external system, it is possible to provide a cover 31 for closing off the box-shaped body 21. The cover 31
is preferably locked onto the box-shaped body 21, for example by means of teeth or pins 32 that engage in the gripping notches 30, and/or by means of a locking system 34 that interacts with the slot 33 made in the front part of the box-shaped body 21. The cover 31 allows the housing unit 20 to also be moved into positions other than the vertical position illustrated in Fig. 4, because the unit dose products are held on the pegs 26 by the cover 31, which in its closed position preferably touches the ends of the pegs 26.

With reference now to Fig. 1 and 2, the automatic store 10 comprises a storage zone 12 intended to receive a multiplicity of housing units 20. The housing units 20 are positioned so as to be removable on shelves 14, from which they can be picked or onto which they can be put by known handling members, such as stacker cranes, cradles, shuttles, manipulators, robots and other means generally known to experts in the sector, which will not be described more fully below.

The automatic store 10 also comprises a picking zone 16 from which it is possible to pick the desired unit dose products for the subsequent distribution thereof according to desired methods, for example by grouping them together according to specific medical prescriptions for a particular patient or for particular hospital departments. The picking zone 16 comprises one or more shelves 15 open on two sides, both towards the storage zone 12 and towards the outside of the automatic store 10. One or more picking members 18 and one or more grouping members R are arranged facing the picking zone 16. The latter can be of a generally known type, for example as described in EP 1346931 from the same applicant, and will not be described here in any greater detail.
As can be seen more clearly in Fig. 3, each shelf 15 of the picking zone 16 comprises a plurality of bearing planes 40, on which one or more housing units 20 can be put, thrust in from inside the automatic store. The distance between bearing planes 40 substantially corresponds to the height of the box-shaped bodies 21 of the housing units 20, so as to create custom-made housings for the box-shaped bodies 21 and to reduce the empty spaces on the shelf 15. Fig. 4 shows, by way of example, two types of housing unit 20' and 20" having different heights, which can be inserted onto different shelf zones 15 depending on the distance between the bearing planes 40. On each bearing plane 40, in a position facing outwards, locators 42 are provided, into which the slots 33 of the box-shaped bodies 21 will be engaged. Fundamentally, the box-shaped bodies 21 can be placed on the planes 40 of the shelf 15 in predetermined positions, being thrust from behind by the store handling member, until the slots 34 hook onto the locators 42 so as to prevent them from coming away from the shelf 15. In this position, the pegs 16 face towards the outside of the automatic store 10, facing the picking members 18.

When a shelf 15 is full of housing units 20, from the outside this substantially constitutes a wall of pegs 16 from which suitable unit dose products can be picked, supported by the appropriate supports S. The automated picking system controls the manoeuvring of the picking members 18, directing them towards specific positions on the vertical plane of the shelf 15. A grasping member 17 mounted on the picking member 18, for example a sucker, arranges for the support S related to the required unit dose product to be moved away from the corresponding peg 16, so that it can be moved towards the grouping member R or towards any other member that is
provided downstream of the automatic store 10 for this purpose.

From a logistical point of view, the system of the present invention allows not only greater storage density but also a much higher picking and distribution speed for unit dose products than with the systems of the prior art. The management of the products is in fact subdivided into two subsystems: on the one hand, the housing units 20 are quickly moved away from and towards the picking zone 16 because this can be done by machines, such as stacker cranes, shuttles and similar means, that are very fast and efficient, particularly when handling standardised objects such as the box-shaped bodies 21. Moreover, the handling of the housing units 20 allows unit dose products of different types, housed in the same housing unit 20, to be quickly made available in the picking zone 16. The housing units 20 are also handled asynchronously relative to the picking of the products by the picking members 18: the housing units 20 not involved in picking can be removed from the picking zone 16 and replaced by other housing units 20 picked from the storage zone 12 in the meantime. On the other hand, with good logistical planning when handling the housing units 20 according to the unit dose products housed in each of the housing units, the unit dose products presented on the shelves 15 can be picked almost continuously. The housing units 20 placed on the bearing planes 40 of the picking zone 16 are in fact replaced continuously, anticipating picking requests for particular unit dose products. The housing units 20 on the shelves 15 are replaced, while the picking members 18 are busy with picking unit dose products already located in the picking zone 16, from other housing units 20. Naturally, the picking speed increases as the capacity of the picking zone 16 increases, and in particular depending on the number of
housing units 20 that can be placed simultaneously on the shelves 15.

The automatic store 10 can be configured modularly according to the specific needs of each individual installation. In particular, the number and arrangement of the shelves 15 can vary from what has been described and illustrated above by way of example. It is in fact possible to produce an installation comprising, for example, more than one picking zone 16, each with one or more shelves 15, so as to adapt to the size and shape of the premises and operating methods of the staff of a particular hospital pharmacy or similar.

With reference now to Fig. 5 to 8, a collecting unit 110 for products packaged in unit doses comprises a frame 112 formed by uprights 111 and cross-pieces 113. In use, the frame 112 is covered by a protective casing, which is not illustrated in the figures for the sake of clarity. The frame 112 supports a rack 114 comprising a plurality of pegs 116 projecting out from a substantially vertical reference plane P. The reference plane P is preferably produced having one or more panels 118 side by side and fixed to the frame 112. The arrangement of the pegs 116 on the rack 114 preferably follows a pattern of rows and columns so that the position of each peg can easily be identified by a pair of whole values (A, B) corresponding to the corresponding row and column. Each pair of values is then associated with a precise pair of coordinates (X, Y) on the reference plane P corresponding to the actual position of each peg 116 relative to a predetermined reference origin. Preferably, but not restrictively, the rack 114 comprises two or more separate rack zones in which the reciprocal distance between the pegs is correspondingly different, so that each of the separate
rack zones can house packs of unit dose products in various sizes as compactly as possible. In the example in the figures, the rack 114 is subdivided into two superimposed separate rack zones 114a, 114b, in which the upper rack zone 114a has pegs 116 closer together, to receive packs of unit dose products that are smaller than the broader packs that can be received in the lower rack zone 114b.

The frame 112 is preferably provided with height-adjustable support feet 120, by means of which it is possible to adapt the frame both to the shape of the floor and to the height of the other components of the automatic store system. The frame 112 is further provided with coupling members 122 that allow the frame 112 to be joined securely to a picking unit 124 for products packaged in unit doses. In this way, the collecting unit 110 of the present invention can easily be used as an optional or additional unit in a pre-existing automatic store. Preferably but not restrictively, the frame 112 also supports and houses one or more grouping members 126 intended to group together and label one or more unit dose products for subsequent distribution thereof, for example to various hospital departments, to fulfil medical prescriptions for patients. Each grouping member 126 is mounted on a support plane 127 fixed to the frame 112. The products grouped together by a grouping member 126 are dispatched on an outlet ramp 129 that directs them onto conveyor belts 131 for delivery to the final picking or further management destination.

As can be seen more clearly in the enlargement in Fig. 3, the pegs 118 are mounted on the panels 118 so that they project towards the picking unit 124, and therefore towards the product picking face of the automatic store M, indicated only diagrammatically with a broken line in Fig. 4. The
automatic store M is connected in a known manner to the picking unit 124 for selectively picking products packaged in unit doses, which in this case is placed between the product picking face of the store M and the collecting unit 110.

The pegs 118 of the rack 114 are tilted slightly upwards, so that the products hanging therefrom bear against one another, and ultimately against the panels 118, by means of gravity. Naturally, each peg 118 can support one or more products packaged in unit doses, the packs of which are provided with holes, eyelets, hooks or similar elements, by which they can be hung from the pegs 118. On the sides of each peg 118, there are containing and separating tabs or partitions 119 projecting from the panels 118, allowing the packs of unit dose products hanging from each peg 118 to be held in a predefined position in order to prevent them from interfering with the packs hanging from an adjacent peg 118.

The automatic store M can be of the generally known type, for example from EP 1346929 from the same applicant, or of the type described above and shown in one of the preferred but not restrictive embodiments thereof in Fig. 1 to 4. The picking unit 124 coupled to the automatic store M preferably comprises a frame 126 that supports a handling assembly 128 of a picking member 130 that can be displaced into a desired position, identified by coordinates X-Y, on a substantially vertical plane facing the store M that is substantially parallel to the plane P of the rack 114 of the collecting unit. The picking member 130 can alternatively turn towards the store M so as to pick a unit dose product and towards the collecting unit 110 in order to place the unit dose product on the rack 114 or to deliver it to one of the grouping members 126. The picking member 130 can also operate by facing solely towards the collecting unit 110 so as to pick a
unit dose product from the rack 114 and deliver it to one of the grouping members 126. The picking member 130 can also be used for picking a unit dose product from a given position on the rack 114 or on the store M and transporting it to another given position on the rack 114 or on the store M, for the purposes of reorganising the unit dose products, for example to optimise their picking position on the basis of various kinds of criteria, for example relating to the rotational and usage speed of the products. From this point of view, the use of the collecting unit 110 is particularly beneficial for collecting mainly or even exclusively those products that are used continuously, a great deal or urgently in medical prescriptions, for example antibiotic or anti-inflammatory products, disinfectants, normal saline, syringes, dressings, gauze, etc.

The adoption of the collecting unit 110 makes it possible to optimise the operations of picking and distributing the products packaged in unit doses. The collecting unit can in fact act as a product collection buffer, on which various products picked from the store M can be positioned in turn while waiting to be grouped together by the grouping members 126. The operations of picking products from the store M can therefore occur at different times and not necessarily sequentially relative to the logistical organisation of grouping the products together by the grouping members 126 in order to make up and deliver the groups of products for a single medical prescription. This is particularly advantageous in order to best exploit the productive capacity of the grouping members 126, separating their feed flow from that of the picking of products from the store M. Moreover, picking products from the store M can advantageously exploit the downtime between one delivery and another, for example bringing forward the collection of
products from the store M during the night, bringing forward
the grouping of products for delivery the next day. Since the
rack 114 of the collecting unit 110 is right next to the
grouping members 126, and the products are all available on a
single plane P that can be quickly accessed by the picking
member 130, unit dose products can be supplied from the
collecting unit 110 to the grouping members 126 much quicker
than happens on average with direct picking from the store M,
in which the products generally have to be transferred each
time from locations inside the store to the front wall facing
the picking unit 124.

Naturally, without prejudice to the principle of the
invention, the embodiments and the implementation details can
vary greatly while remaining within the scope of the present
technology.
 CLAIMS

1. Storage and distribution system for products in unit doses, comprising a plurality of housing units (20), each comprising a plurality of locations for products in unit doses, it being possible to organise the housing units (20) on a substantially vertical plane so as to produce at least one portion of a picking wall (15, 16), in which the locations for products in unit doses face selective picking means (18).

2. Storage and distribution system according to claim 1, wherein each housing unit (20) comprises a box-shaped body (21) having at least one front opening (19) from which unit dose products can be picked, it being possible to house the box-shaped bodies (21) in at least one shelf (15) so as to produce said at least one portion of picking wall (15, 16).

3. Storage and distribution system according to claim 2, wherein the at least one shelf (15) is open on two sides, one facing the selective picking means (18), the other communicating with a storage zone (12) for the housing units (20).

4. Storage and distribution system according to either claim 2 or claim 3, wherein the at least one shelf (15) comprises a plurality of bearing planes (40) on which the housing units (20) are selectively placed so that the box-shaped bodies (21) have their front opening (19) facing the selective picking means (18) placed in a picking zone (16).

5. Storage and distribution system according to claim 4, wherein the distance between bearing planes (40) substantially corresponds to the height of the box-shaped bodies (21) of the housing units (20).
6. Storage and distribution system according to either claim 4 or claim 5, wherein, on each bearing plane (40), stop means (42) are produced for locking the box-shaped bodies (21) of the housing units (20) in the picking position facing the selective picking means (18).

7. Housing unit (20) for use in a storage and distribution system according to any one of the preceding claims, comprising a box-shaped body (21) having a front opening (19), support elements (26) for a plurality of supports (S) for unit dose products being provided in the box-shaped body (21).

8. Housing unit according to claim 7, wherein the support elements are pegs (26) that project from a rear wall (25) and face the front opening (19) of the box-shaped body (21).

9. Housing unit according to claim 8, wherein there is more than one peg (26) for each housing unit (20), which pegs are tilted upwards, are aligned relative to each other and are arranged close to an upper wall (22) of the box-shaped body (21).

10. Housing unit according to any one of claims 7 to 9, comprising a selectively removable cover (31) for closing the front opening of the box-shaped body (21).

11. Unit for picking products packaged in unit doses, comprising picking means (130) that can be oriented towards a first side of the picking unit where they prove suitable, in use, for picking products packaged in unit doses from one face of an automatic store (M), a collecting unit (110) being arranged on a second side, opposite the first side relative to the picking means (130), of the picking unit, the collecting unit (110) comprising a rack (114) comprising a plurality of
pegs (116) facing towards the first side and reachable by the picking means for picking products packaged in unit doses from the pegs (116) or depositing them thereon, the plurality of pegs (116) as a whole being capable of collecting a smaller number of unit dose products than those that can be stored in the automatic store (M).

12. Picking unit according to claim 11 that is operatively connected to a system for storing and distributing unit dose products according to any one of claims 1 to 10, it being possible to orient the picking means (130) towards the first side of the picking unit where they prove suitable, in use, for picking products packaged in unit doses from at least one portion of picking wall (15, 16).

13. Picking unit according to either claim 11 or claim 12, wherein the rack (114) comprises at least two distinct rack zones (114a, 114b), in which the spacing between the various pegs (116) is correspondingly different, so as to house at least two corresponding pack sizes for unit dose products.

14. Picking unit according to any one of claims 11 to 13, wherein each peg (116) is placed beside alignment and separation means (119) for aligning the packs of unit dose products hanging from each peg (116) and separating them from the packs of unit dose products hanging from an adjacent peg (116).

15. Picking unit according to any one of claims 11 to 14, wherein the collecting unit (110) comprises a frame (112) for supporting substantially vertical panels (118) defining a base of the rack (114).
16. Picking unit according to any one of claims 11 to 15, wherein the collecting unit (110) comprises supports for members (126) for grouping together the products packaged in unit doses.

17. Picking unit according to any one of claims 11 to 16, wherein the collecting unit comprises means (122) for selective coupling to a structure (124) for supporting and handling the picking means (130).

18. Method for distributing unit dose products housed in a housing unit according to any one of claims 7 to 10, using a storage and distribution system according to any one of claims 1 to 6, comprising the steps of transporting one or more housing units (20) and organising them on a substantially vertical plane so as to produce at least one portion of a picking wall (15, 16), in which the locations for products in unit doses face selective picking means (18), and asynchronously activating the selective picking means (18) for picking desired unit dose products from the housing units (20).

19. Method for picking and distributing products packaged in unit doses, using a picking unit according to any one of claims 11 to 17, wherein the picking means (130) are controlled when selectively picking:

a) from the first side to the second side, in order to collect at least one product packaged in a unit dose from an automatic store (M) and to transfer it either to a predetermined peg (116) of the rack (114) or to a loading zone of a grouping member (126), or
b) from a given position on the rack (114) on the second side to another given position on the rack (114) on the second side, in order to transfer a product packaged in a unit dose from one position to the other on the rack (114) of the collecting unit, or

c) from a given position on the rack (114) on the second side to a predetermined zone on the second side corresponding to a loading zone of a grouping member (126).
# INTERNATIONAL SEARCH REPORT

**International application No**

PCT/IB2016/053087

## A. CLASSIFICATION OF SUBJECT MATTER

INV. G07F17/00 G07F11/64 G07F11/62 G07F11/16

**ADD.**

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

G07F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal, WPI Data

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

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<th>Relevant to claim No.</th>
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<td>WO 2009/115985 AI (INGEGNERIA BIOMEDICA SANTA LUC [IT]; LIQUORI PI ERANEO [IT]; RUDELO) 24 September 2009 (2009-09-24) page 1, lines 8-15; figures 1,6,7 page 4, lines 13-20 page 8, lines 23-28</td>
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## Date of the actual completion of the international search

24 August 2016

## Date of mailing of the international search report

31/08/2016

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