



(51) International Patent Classification:  
**B65G 47/14** (2006.01)

(21) International Application Number:  
PCT/US2012/027929

(22) International Filing Date:  
7 March 2012 (07.03.2012)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:  
13/047,418 14 March 2011 (14.03.2011) US

(71) Applicant (for all designated States except US): **THE PROCTER & GAMBLE COMPANY** [US/US]; One Procter & Gamble Plaza, Cincinnati, Ohio 45202 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **PAPSDORF, Clifford, Theodore** [US/US]; 439 Branch Hill Loveland Road, Loveland, Ohio 45140 (US). **MERS-KELLY, Michael, John** [US/US]; 1543 Bear Pond Road, Hartford, Maine 04220 (US). **RICHARDS, Christopher, Michael** [US/US]; 37 Sawyer Road, Poland, Maine 04274 (US).

(74) Common Representative: **THE PROCTER & GAMBLE COMPANY**; c/o Eileen L. Hughett, Global

Patent Services, 299 East Sixth Street, Sycamore Building, 4th Floor, Cincinnati, Ohio 45202 (US).

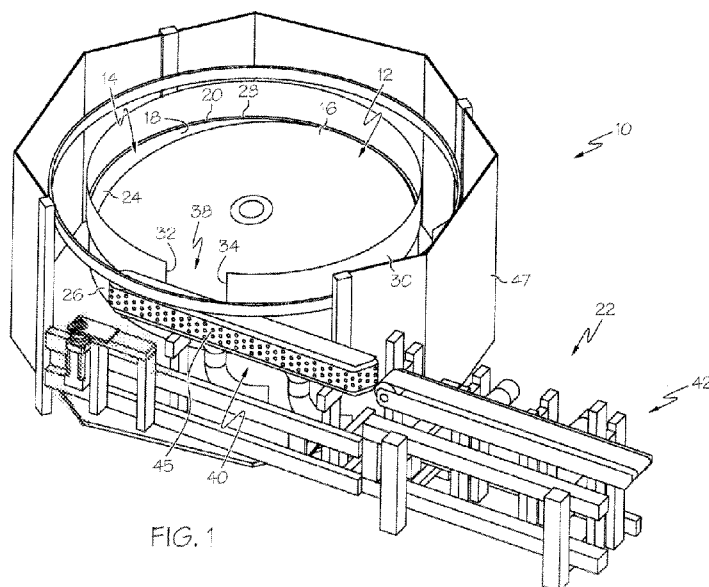
(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:

— with international search report (Art. 21(3))

(54) Title: ARTICLE FEED SYSTEM FOR ALIGNING AND SINGULATING ARTICLES



(57) Abstract: An article feed system for aligning and singulating incoming articles includes a rotatable upper rim surface and an article delivery device that delivers articles received by the article delivery device to the upper rim surface. A drive system is operatively connected to the outer bowl that rotates the outer bowl. A guide wall extends upwardly above the upper rim surface that guides the articles travelling along the upper rim surface toward an exit opening in the guide wall. A vertically oriented article engaging-type conveyor is at the exit opening in the guide wall. The vertically oriented article engaging-type conveyor includes a moving article engaging surface that is exposed to the exit opening in the guide wall for receiving the articles when they exit the exit opening.

## ARTICLE FEED SYSTEM FOR ALIGNING AND SINGULATING ARTICLES

## TECHNICAL FIELD

5           The present invention is generally directed to article feed systems for aligning and singulating articles.

## BACKGROUND

10           Various systems have been developed to orient and singulate articles to facilitate automated feed into associated processing equipment. As an example, a rotary feeder may be used to singulate and orientate the articles as they are supplied to associated equipment, with the articles arranged into a sequential stream. This type of technology is typically employed where relatively high throughput is required. Conventional rotary feeders are disclosed in U.S. Patent Nos. 7,472,782, 6,578,699, 5,145,051 and 4,429,808.

15

## SUMMARY

20           In one embodiment, an article feed system for aligning and singulating incoming articles includes a rotatable upper rim surface and an article delivery device that delivers articles received by the article delivery device to the upper rim surface. A drive system is operatively connected to the outer bowl that rotates the outer bowl. A guide wall extends upwardly above the upper rim surface that guides the articles travelling along the upper rim surface toward an exit opening in the guide wall. A vertically oriented article engaging-type conveyor is at the exit opening in the guide wall. The vertically oriented article engaging-type conveyor includes a moving article engaging surface that is exposed to the exit opening in the guide wall for receiving the articles when they exit the exit opening.

25

30           In another embodiment, a centrifugal article feed system for orienting and aligning incoming articles includes an outer bowl having an upper rim surface. An inner disk is disposed within the outer bowl and extends at an incline from a lower portion of the outer bowl upwardly adjacent the upper rim surface for delivering articles from the lower portion of the outer bowl upwardly to the upper rim surface. A drive system is operatively connected to the outer bowl and the inner disk that rotates the outer bowl and the inner disk. A guide wall extends upwardly above the upper rim surface that guides the articles travelling along the upper rim surface toward an end of the guide wall. A distance between the guide wall and an inner edge of the upper rim surface is substantially

constant over an article guide distance along which the articles travel on the upper rim surface. The distance between the guide wall and the inner edge of the upper rim surface is no greater than about 150 percent of a width of the article.

In another embodiment, a method of aligning and orienting articles using a centrifugal article feed system comprising an outer bowl having an upper rim surface and an inner disk disposed within the outer bowl and extending at an incline from a lower portion of the outer bowl upwardly toward the upper rim surface. The method includes rotating the outer bowl and the inner disk disposed within the outer bowl. Articles fed to the article feed system are moved along the inner disk from the lower portion of the outer bowl upwardly to the upper rim surface. The articles are transferred from the inner disk to the upper rim surface. The articles are guided as the articles travel with the upper rim surface using a guide wall that extends upwardly above the upper rim surface. The articles are transferred from the upper rim surface through an exit opening in the guide wall to a vertically oriented vacuum conveyor providing a conveyor transfer path that is substantially tangential to a periphery of the outer bowl at the upper rim surface.

#### BRIEF DESCRIPTION OF THE DRAWINGS

The following detailed description of specific embodiments of the present invention can be best understood when read in conjunction with the drawings enclosed herewith.

FIG. 1 is a perspective view of an embodiment of a centrifugal article feed system;

FIG. 2 is another perspective view of the centrifugal article feed system of FIG. 1;

FIG. 3 is a diagrammatic side view of the centrifugal article feed system of FIG. 1 illustrating an exemplary drive system;

FIG. 4 is a diagrammatic top view of the centrifugal article feed system of FIG. 1;

FIG. 5 illustrates an exemplary article control system for use with the centrifugal article feed system of FIG. 1; and

FIG. 6 illustrates an exemplary method of aligning and orienting articles using the centrifugal article feed system of FIG. 1.

The embodiments set forth in the drawings are illustrative in nature and not intended to be limiting of the invention defined by the claims. Moreover, individual features of the drawings and invention will be more fully apparent and understood in view of the detailed description.

#### DETAILED DESCRIPTION

5           The following text sets forth a broad description of numerous different embodiments of the present invention. The description is to be construed as exemplary only and does not describe every possible embodiment since describing every possible embodiment would be impractical, if not impossible, and it will be understood that any feature, characteristic, component, composition, ingredient, product, step or methodology described herein can be deleted, combined with or  
10 substituted for, in whole or part, any other feature, characteristic, component, composition, ingredient, product, step or methodology described herein. Numerous alternative embodiments could be implemented, using either current technology or technology developed after the filing date of this patent, which would still fall within the scope of the claims. All publications and patents cited herein are incorporated herein by reference.

15           It should also be understood that, unless a term is expressly defined in this specification using the sentence "As used herein, the term `\_\_\_\_\_` is hereby defined to mean..." or a similar sentence, there is no intent to limit the meaning of that term, either expressly or by implication, beyond its plain or ordinary meaning, and such term should not be interpreted to be limited in scope based on any statement made in any section of this patent (other than the language of the claims). No term is  
20 intended to be essential to the present invention unless so stated. To the extent that any term recited in the claims at the end of this patent is referred to in this patent in a manner consistent with a single meaning, that is done for sake of clarity only so as to not confuse the reader, and it is not intended that such a claim term be limited, by implication or otherwise, to that single meaning. Finally, unless a claim element is defined by reciting the word "means" and a function without the recital of any  
25 structure, it is not intended that the scope of any claim element be interpreted based on the application of 35 U.S.C. § 112, sixth paragraph.

Embodiments described herein generally relate to centrifugal article feed systems for aligning and singulating articles. These centrifugal article feed systems may include apparatus known as bowl sorter assemblies. Such bowl sorter assemblies may include a rotatable disk assembly and a  
30 rotatable bowl assembly. The rotatable disk assembly is used to deliver articles outwardly to the rotatable bowl assembly. The articles are then transported by the rotatable bowl assembly to a discharge conveyor in an aligned, singulated fashion.

The systems and methods described herein may be useful in handling mass quantities of a number of articles, particularly relatively lightweight articles of less than about 1000 grams, such as absorbent articles that include a wrapper, such as wrapped tampons having a wrapper material for feminine hygiene. Often times, lightweight articles, such as wrapped tampons, may be somewhat easily damaged during mass product handling. Damage can be to the tampon itself and/or to the wrapper.

By "tampon" it is meant herein an absorbent article, in some embodiments, a disposable one, comprising absorbent material usually being compressed into a self-sustaining, generally oblong, typically essentially cylindrical shape. In most cases the absorbent material comprises fibrous material, e.g. rayon, wood pulp fluff, cotton, synthetic fibers and/or the like.

By "length" of a tampon it is meant herein the linear extension of a tampon along its largest dimension.

By "width" of a tampon it is meant the maximum width of a tampon in the widthwise direction perpendicular to the length.

"Wrapper" as used herein refers to a structure, which is formed of a wrapper material and which substantially encloses an individual absorbent article, in some embodiments, an individual tampon, for packaging purposes. The wrapper may be constituted of one connected piece of wrapper material, though a wrapper can also be made from multiple pieces of material sufficiently joined together such that it substantially acts as one connected piece of wrapper material.

By "wrapper material" it is meant herein any material suitable to be used for hygienically wrapping tampons. Various wrappers and wrapper materials are described in, for example, U.S. Patent No. 6,955,665.

Referring to FIGS. 1 and 2, a centrifugal article feed system 10 for use in aligning and singulating articles includes a bowl sorter assembly that includes a rotatable disk assembly 12 and a rotatable bowl assembly 14. The rotatable disk assembly 12 includes an article delivery device, in this embodiment, a rotatable inner disk 16 disposed within an outer bowl 18 of the rotatable bowl assembly 14. The inner disk 16 may be disposed at an incline extending from a lower portion of the outer bowl 18 upwardly toward an upper rim surface 20 of the outer bowl 18. In some embodiments, the amount of incline of the inner disk 16 may be adjustable. The inner disk 16 can deliver articles

from the lower portion of the outer bowl 18 upwardly to the upper rim surface 20 for delivery to a discharge conveyor assembly 22, as will be described in greater detail below.

The rotatable bowl assembly 14 includes the outer bowl 18 having an interior surface 24, an exterior surface 26 and an upper rim 28 that extends about a periphery of the outer bowl 18. A guide wall 30 coextends with the upper rim surface 20. The guide wall 30 includes a terminating edge 32 and a beginning edge 34. The terminating edge 32 and the beginning edge 34 are spaced apart to form an exit opening 38 through which articles may exit and be delivered to the discharge conveyor assembly 22. In some embodiments, an outer guard wall 47 may extend about the rotatable bowl assembly 14.

The discharge conveyor assembly 22 includes a discharge conveyor 40 and a product conveyor 42 (FIG. 1). In some embodiments, the discharge conveyor 40 may be a vertically oriented conveyor. By vertically oriented, it is meant that the conveying surface provided by the discharge conveyor 40 is substantially at an angle (e.g., 90 degrees) to a horizontal plane. The vertical conveyor does not need to be exactly vertical and would still provide benefit at other angles such as 15 degrees from the vertical plane. In some embodiments, the discharge conveyor 40 may be a vertically oriented vacuum conveyor. Negative pressure supplied at the conveying surface through openings 43 of a conveyor belt 45 of the discharge conveyor 40 draws the articles to the conveying surface providing an article engaging surface that is exposed to the exit opening 38 in the guide wall 30 for receiving the articles when they exit the exit opening 38. The articles are adhered by vacuum to the conveying surface which prevents the articles from falling off of the vertical conveyor surface due to gravity. Alternative embodiments of the vertical conveyor 40 can maintain control of the articles and overcome gravitational acceleration. A mechanical gripper may be employed to maintain control of the articles. Frictional force between the article and conveyor belt can also be generated to maintain control of the articles by magnetic, electrostatic, or adhesive forces. If the article is traveling at a high rate of speed, the centrifugal acceleration acting on the article just before the article transitions to the conveyor 40 can generate sufficient frictional force to keep the article under control on the vertical conveyor 40 due to the inertia of the article.

In some embodiments, the article will transition from the vertical conveyor 40 to a product conveyor 42. The product conveyor 42 may be horizontally oriented or could be an additional vertical conveyor. The product conveyor 42 may be a vacuum conveyor or any other suitable conveyor type. In some embodiments, the product conveyor 42 is not used and articles may be delivered directly from vertical conveyor 40 to the downstream process.

The discharge conveyor 40 and the product conveyor 42 may each be driven to control the speed of transported article. These conveyors 40 and 42 can be driven at the same speed as the speed of the article discharging the sorting bowl or can be driven at different speeds. If for example, the speed of the discharge conveyor 40 is greater than the discharge speed of the article exiting the sorting bowl, the relative spacing between sequential articles is increased. This can be useful for singulating the articles. If the speed of the product conveyor 42 is greater than discharge conveyor 40, this will also increase the relative spacing between sequential articles. In some embodiments, guide rails 51 may be used to control the position of the articles as they are carried by the discharge and/or product conveyors 40 and 42.

Referring to FIG. 3, a diagrammatic driving system arrangement for the centrifugal article feed system 10 is illustrated. In this embodiment, the rotatable disk assembly 12 and the rotatable bowl assembly 14 are each driven by separate motors 44 and 46, respectively. In another embodiment, a single motor (or other suitable drive mechanism) may be used to rotate both the rotatable disk assembly 12 and the rotatable bowl assembly 14. The rotatable disk assembly 12 and the rotatable bowl assembly 14 may rotate the same direction and at the same or different speeds during operation. In some instances, the rotatable disk assembly 12 rotates faster than the rotatable bowl assembly 14 for delivering the articles upwardly toward the upper rim surface 20. In one configuration, the rotatable disk assembly 12 rotates at a slower rotational speed than the rotatable bowl assembly 14 to create some space between articles supplied to upper rim surface 20.

Referring to FIG. 4, a top view of the centrifugal article feed system 10 including the upper rim surface 20 is illustrated. As can be seen, the guide wall 30 extends about a periphery of the outer bowl 18. The guide wall 30 includes the terminating edge 32 and the beginning edge 34 that is spaced from the terminating edge 32 to provide the exit opening 38 through which articles may exit and be delivered to the discharge conveyor assembly 22. The guide wall 30 is spaced radially a distance D from an interior edge 35 of the upper rim surface 20. In some embodiments, the distance D is substantially the same along the entire length of the guide wall 30. In some embodiments, the distance D is substantially the same for an entire article guide distance, which may be defined as the distance from an imaginary starting line including the highest point P of the inner disk 16 to the exit opening 38 along which the articles travel along the upper rim surface 20. In some embodiments, the distance D may be selected to have a relationship with a width W of the article (FIG. 5). For some articles, the distance D may be set to less than the width of the article, such as about 75 percent of W. One exemplary range for D is between about 50 and about 150 percent of maximum width of article

W. By correlating the width of the article and the distance D, it may be less likely that articles will travel side-by-side on the upper rim surface 20 during operation and can make it easier to provide a single file stream of product.

Exemplary articles 56A-56G depict the articles in various positions along the feed system.

5 The articles 56A-56G are automatically and/or manually introduced onto the rotatable inner disk 16. Article 56A depicts a typical position for an article recently introduced to the feed system. The article 56A is driven by friction with disk 16 and rotates following an arcuate path. The centrifugal acceleration of the rotating article 56A causes the article 56A to move radially outward toward the rotatable bowl assembly 14. The article 56B has come in contact with the inside wall of outer bowl  
10 18 which aligns the product longitudinally with the inside tangent surface of the inside wall of outer bowl 18. Article 56C has moved onto the upper rim surface 20 and is driven in an arcuate path by friction with the upper rim surface 20 and slides past stationary guide wall 30. The article 56D continues to travel along the arcuate path defined by guide wall 30 and is driven by friction with upper rim surface 20. A plurality of air nozzles 52, 54, and 58 can be used to singulate the article as  
15 it travels through the article control system 50. Article 56E is transitioning from the upper rim surface 20 to the vertical discharge conveyor 40 as it exits the terminating edge 32 of guide wall 30. Article 56F is conveyed in a straight line by vertical discharge conveyor 40. Article 56G is conveyed by horizontal product conveyor 42.

Referring to FIGS. 4 and 5, an article control system 50 may include a number of air nozzles  
20 52, 54, and 58 that are strategically placed to create a single file stream of articles 56. A plurality of nozzles 52 may blow a stream of air through holes in the guide wall 30 directed toward the axis of rotation of the outer bowl 18. The nozzles 52 may be installed above the path of a single article 56 to blow off other articles that are vertically stacked on top of each other. The nozzles 52 may be adjusted to a vertical elevation greater than W above the upper rim surface 20. The nozzles 54 direct  
25 an air stream in a downward direction just inside of the upper rim surface 20. The nozzles 54 can eliminate adjacent side by side articles 56 that are traveling together on top of rim surface 20. The nozzles 58 can direct a targeted pulsed air stream directly at an article 56 to systematically eliminate articles. The nozzles 58 work in conjunction with sensors 60 which detect the relative position of sequential articles and can signal when nozzles 58 should remove an unwanted article for instance  
30 when articles are too close together in sequence. Air pulses for the nozzles 58 may be controlled by an electrical signal to a solenoid valve 66. A PLC or industrial computer can interpret signals from sensors 60 to command when an air pulse is needed. Compressed air is supplied by reservoir 62 and



pressure to nozzles 52, 54, and 58 is adjustable by pressure regulators 64A, 64B, and 64C. Locations for control system 50; nozzles 52, 54, and 58; and sensors 60 shown in FIG. 4 are exemplary and other configurations are possible.

It is also possible for the feeding system to align and singulate articles with none or some of the article control system 50 in use. Articles traveling through the feeding system may be naturally singulated by the narrow ledge created by guide wall 30 and upper rim surface 20 and tangential transfer to vertical conveyor 40. Mechanical means such as plows, guides, fingers, and driven ejection pins and diverter gates can also be employed.

Referring to FIG. 6, an exemplary method 70 of aligning and singulating articles using the centrifugal article feed system 10 is illustrated. At step 72, the outer bowl 18 and the inner disk 16 are rotated using one or both of the motors 44 and 46. In some embodiments, the outer bowl 18 and the inner disk 16 are rotated at substantially the same speed. Alternatively, the outer bowl 18 and the inner disk 16 may be rotated at different speeds (e.g., the outer bowl may rotate faster or slower than the inner disk). At step 74, multiple articles 56 (e.g., wrapped tampons) are fed onto the inner disk 16. Centrifugal acceleration acts on the articles 56 to accelerate them radially outward along inner disk 16 toward the outer bowl assembly 18. The articles 56 travel with the inner disk 16 and move along the inner disk from a lower portion of the outer bowl 18 upwardly to the upper rim surface 20 at step 76. Due to the motion imparted on the articles 56, the articles 56 transfer from the inner disk 16 to the upper rim surface 20 at step 78. At step 80, the articles 56 are guided along the guide wall 30 as the articles 56 travel with the upper rim surface 20. In some embodiments, air jets may be directed downwardly onto the articles 56 traveling on the upper rim surface 20 control position of the articles 56 on the upper rim surface 20 of to remove articles from the upper rim surface 20. At step 82, articles 56 are conditioned to singulate products and create a single file stream. This conditioning can be due to the natural movement of articles 56 through the feeder system or in some embodiments the article control system 50 employing the air nozzles 52, 54, and 58 or other mechanical means can be used to adjust article positions and remove articles 56 not in single file. At step 84, the articles 56 are transferred from the upper rim surface 20 through the exit opening 38 in the guide wall 30 to the vertically oriented discharge conveyor 40 providing a conveyor transfer path that is substantially tangential to the periphery of the outer bowl 18 at the upper rim surface 20. The articles 56 may then be transported, e.g., in single file fashion to a downstream packaging operation.

The above-described centrifugal article feed systems for aligning and singulating articles in the form of bowl sorters may improve quality by creating more consistent article spacing and

alignment. For example, the articles may be wrapped tampon products that are aligned in a single file generally in the length direction of the wrapped tampons. The articles may transfer more reliably from the upper rim surface to a vertically oriented vacuum conveyor. This can reduce damage that can occur when an article such as a wrapped tampon article is pulled across the transfer to a conventional horizontally oriented discharge conveyor. This configuration also produces and maintains more consistent spacing between products which can be beneficial to downstream packing equipment. This configuration can also eliminate overlapping adjacent articles that can create jams and miscounts in downstream equipment.

It is noted that terms like “preferably,” “generally,” “commonly,” and “typically” are not utilized herein to limit the scope of the claimed embodiments or to imply that certain features are critical, essential, or even important to the structures or functions. Rather, these terms are merely intended to highlight alternative or additional features that may or may not be utilized in a particular embodiment.

For the purposes of describing and defining the various embodiments it is additionally noted that the term “substantially” is utilized herein to represent the inherent degree of uncertainty that may be attributed to any quantitative comparison, value, measurement, or other representation. The term “substantially” is also utilized herein to represent the degree by which a quantitative representation may vary from a stated reference without resulting in a change in the basic function of the subject matter at issue.

All documents cited in the Detailed Description are, in relevant part, incorporated herein by reference; the citation of any document is not to be construed as an admission that it is prior art. To the extent that any meaning or definition of a term in this written document conflicts with any meaning or definition of the term in a document incorporated by reference, the meaning or definition assigned to the term in this written document shall govern.

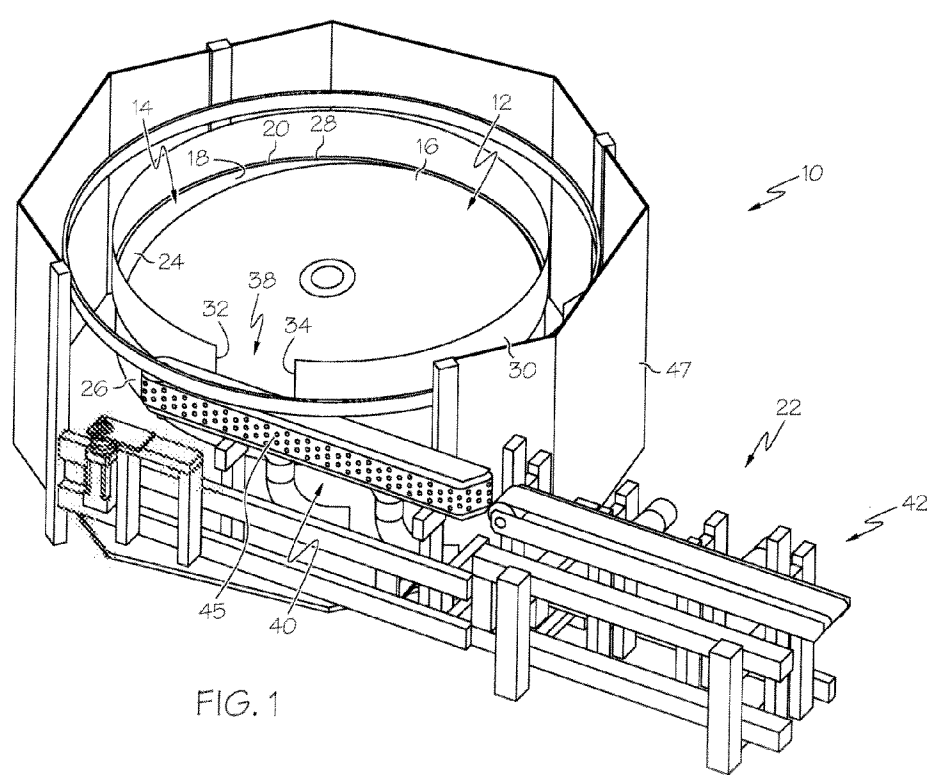
While particular embodiments have been illustrated and described, it would be obvious to those skilled in the art that various other changes and modifications can be made without departing from the spirit and scope of the invention. It is therefore intended to cover in the appended claims all such changes and modifications that are within the scope of this invention.

## CLAIMS

What is claimed is:

1. A centrifugal article feed system for orienting and aligning incoming articles, the centrifugal article feed system comprising:
  - an outer bowl having an upper rim surface;
  - an inner disk disposed within the outer bowl and extending at an incline from a lower portion of the outer bowl upwardly adjacent the upper rim surface for delivering articles from the lower portion of the outer bowl upwardly to the upper rim surface;
  - a drive system operatively connected to the outer bowl and the inner disk that rotates the outer bowl and the inner disk;
  - a guide wall extending upwardly above the upper rim surface that guides the articles travelling along the upper rim surface toward an end of the guide wall; and
  - a vertically oriented article engaging-type conveyor including a moving article engaging surface that receives the articles as the articles pass the end of the guide wall;wherein a distance between the guide wall and an inner edge of the upper rim surface is substantially constant over an article guide distance along which the articles travel on the upper rim surface;
- wherein the distance between the guide wall and the inner edge of the upper rim surface is no greater than about 150 percent of a width of the article.
2. The centrifugal article feed system of claim 1, wherein the engaging-type conveyor is a vertically oriented vacuum conveyor at the end of the guide wall that provides a conveyor transfer path that is substantially tangential to a periphery of the outer bowl at the upper rim surface, the vertically oriented vacuum conveyor comprising a belt including a series of openings through which air is drawn through the belt.
3. The centrifugal article feed system of claim 2 further comprising a horizontal product conveyor that receives articles from the vertically oriented vacuum conveyor.
4. The centrifugal article feed system of any one of claims 1 to 3, wherein the drive system is operatively connected to the outer bowl and the inner disk such that the outer bowl and the inner disk rotate at different speeds or at the same speed during operation.

5. The centrifugal article feed system of any one of claims 1 to 4 further comprising an article control system comprising a plurality of nozzles arranged and configured to deliver pulses of air to create a single file stream of articles by removing excess articles from the upper rim surface.
6. A method of aligning and orienting articles using a centrifugal article feed system comprising an outer bowl having an upper rim surface and an inner disk disposed within the outer bowl and extending at an incline from a lower portion of the outer bowl upwardly adjacent the upper rim surface, the method comprising:
- rotating the outer bowl and the inner disk disposed within the outer bowl;
  - moving articles fed to the article feed system along the inner disk from the lower portion of the outer bowl upwardly to the upper rim surface;
  - transferring the articles from the inner disk to the upper rim surface;
  - guiding the articles as the articles travel with the upper rim surface using a guide wall that extends upwardly above the upper rim surface; and
  - transferring the articles from the upper rim surface through an exit opening in the guide wall to a vertically oriented vacuum conveyor providing a conveyor transfer path that is substantially tangential to a periphery of the outer bowl at the upper rim surface.
7. The method of claim 6 comprising rotating the outer bowl and the inner disk at different speeds or at the same speed.
8. The method of claim 6 or 7 further comprising removing excess articles from the upper rim surface using an article control system comprising a plurality of nozzles arranged and configured to deliver pulses of air creating a single file stream of articles.
9. The method of any one of claims 6 to 8 further comprising drawing articles toward a vertically oriented conveying surface of the vertically oriented vacuum conveyor using negative pressure provided by the vertically oriented vacuum conveyor.
10. The method of any one of claims 6 to 9, wherein the articles are wrapped tampons.



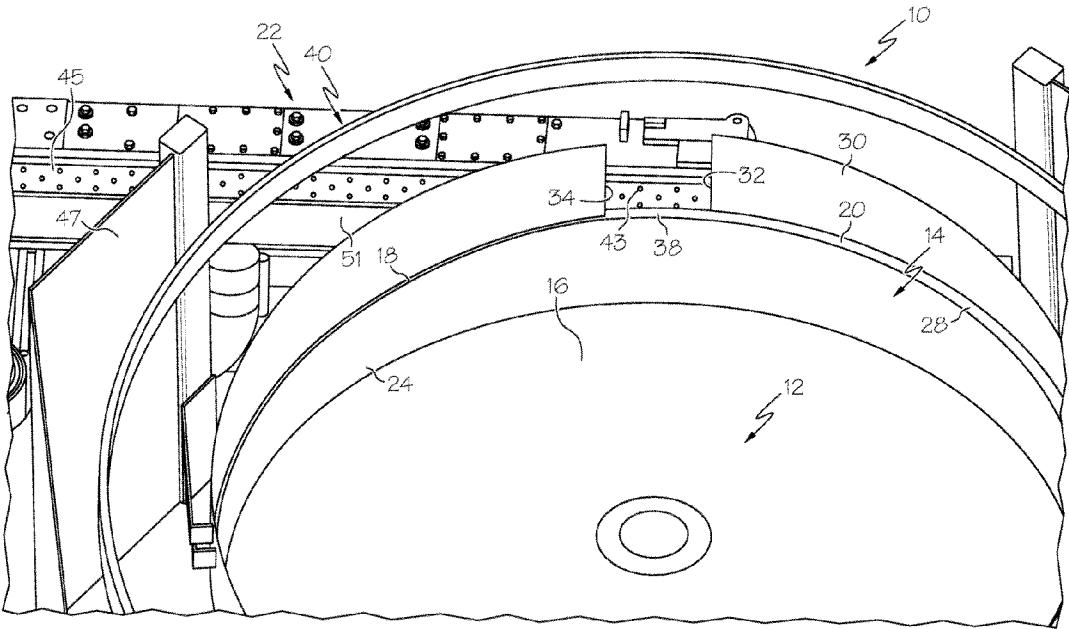


FIG. 2

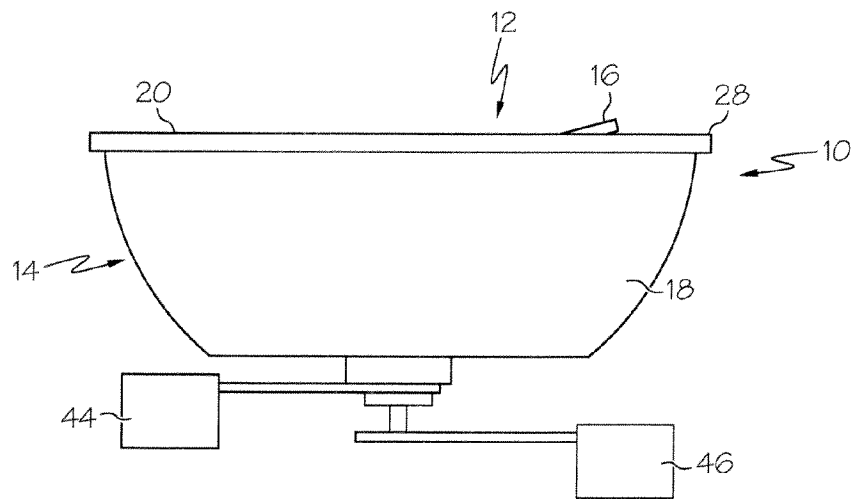


FIG. 3

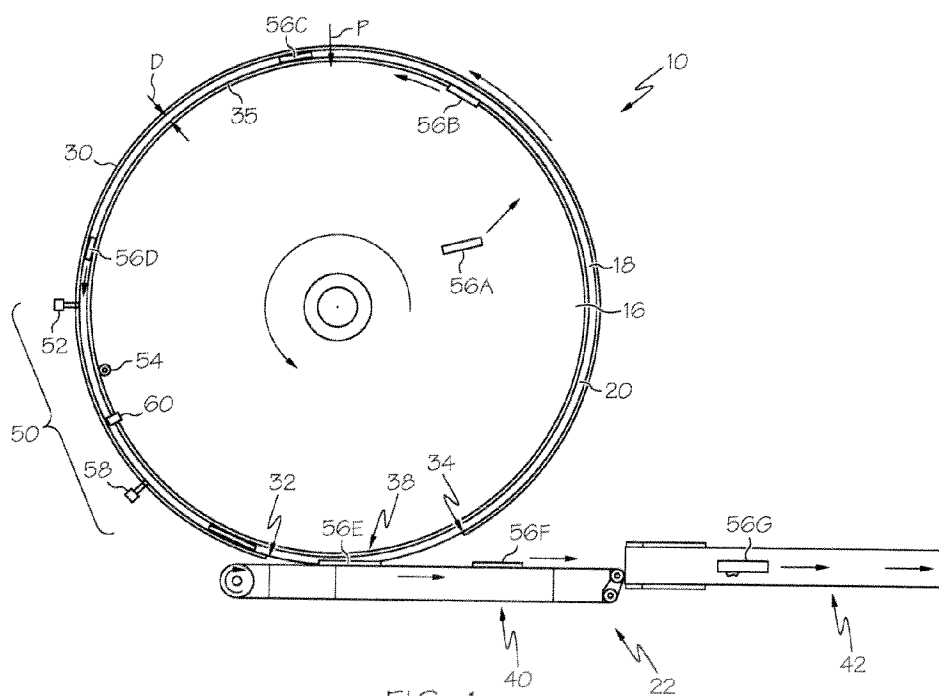


FIG. 4



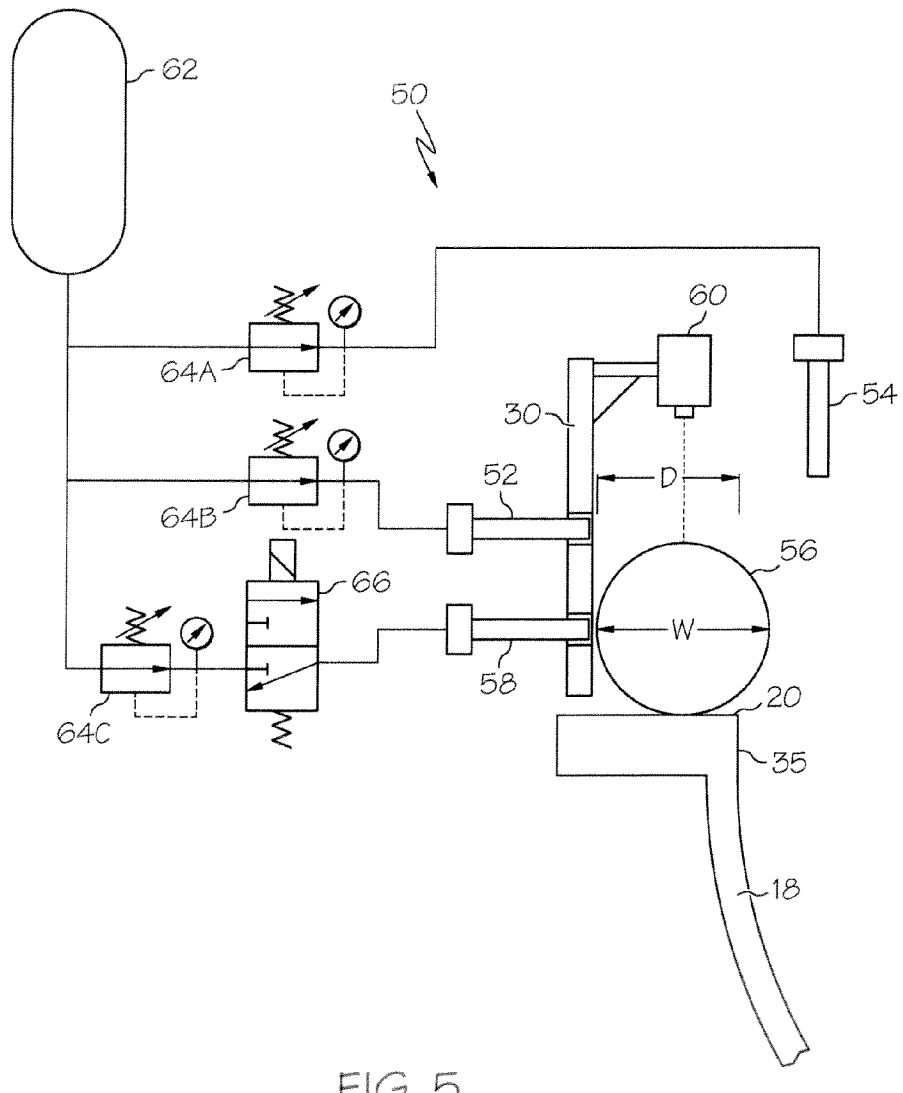


FIG. 5

6/6

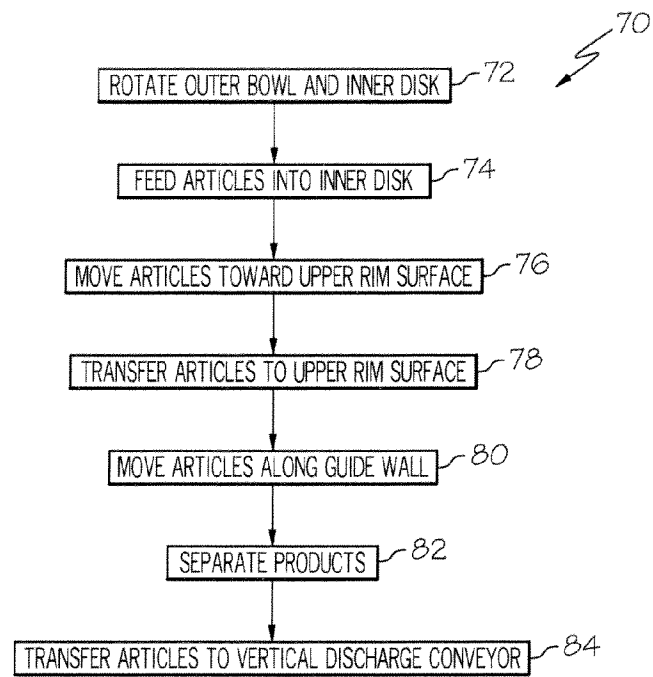


FIG. 6

## INTERNATIONAL SEARCH REPORT

International application No  
PCT/US2012/027929

A. CLASSIFICATION OF SUBJECT MATTER  
INV. B65G47/14  
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)  
B65G

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

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 6 578 699 B2 (BAIRD RANDY K [US] ET AL) 17 June 2003 (2003-06-17) cited in the application paragraphs [0019] - [0023]; figures 1-3 -----	1,4,6,7
A	GB 2 231 559 A (GD SPA [IT]) 21 November 1990 (1990-11-21) page 8, paragraph 2 - page 9, paragraph 1; figures 1,2 -----	1,6
A	US 4 995 503 A (GRAHAM S NEAL [US] ET AL) 26 February 1991 (1991-02-26) column 5, lines 32-47; figure 2 -----	5,8



Further documents are listed in the continuation of Box C.



See patent family annex.

## \* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

14 May 2012

Date of mailing of the international search report

22/05/2012

Name and mailing address of the ISA/

European Patent Office, P.B. 5818 Patentlaan 2  
NL - 2280 HV Rijswijk  
Tel. (+31-70) 340-2040,  
Fax: (+31-70) 340-3016

Authorized officer

Grentzius, Wim

# INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/US2012/027929

Patent document cited in search report		Publication date		Patent family member(s)		Publication date
US 6578699	B2	17-06-2003	GB	2382571 A		04-06-2003
			US	2003010605 A1		16-01-2003
-----						
GB 2231559	A	21-11-1990	BR	9002341 A		06-08-1991
			DE	4015103 A1		22-11-1990
			GB	2231559 A		21-11-1990
			IT	1234073 B		29-04-1992
			JP	2902050 B2		07-06-1999
			JP	3102009 A		26-04-1991
			US	5044487 A		03-09-1991
-----						
US 4995503	A	26-02-1991	NONE			
-----						