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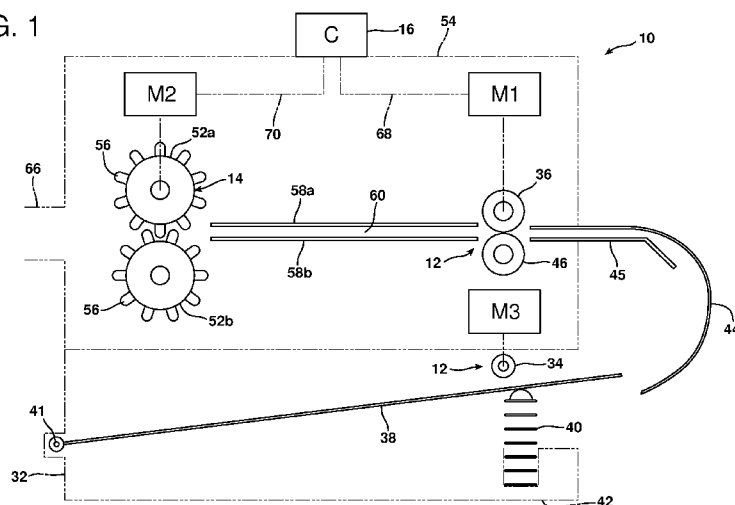
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(54) Title: METHOD AND MACHINE FOR PRODUCING PACKAGING CUSHIONING

FIG. 1



(57) Abstract: A method for producing packaging cushioning includes successively feeding sheets of a substrate at a first speed to a crumpling mechanism, crumpling the sheets at a second speed to convert the sheets into packaging cushion units, and controlling at least one of the first and second speeds to produce a desired degree of overlap between successive sheets, thereby generating a connected series of the packaging cushion units.

METHOD AND MACHINE FOR PRODUCING PACKAGING CUSHIONING

BACKGROUND OF THE INVENTION

The present invention relates generally to packaging materials and,
5 more specifically, to a machine and method for producing packaging cushioning from sheets of a selected substrate, such as paper.

Machines for producing packaging cushioning from paper are well-known in the art. Such machines generally operate by pulling a web of paper from a roll, manipulating the paper web in such a way as to convert the paper
10 into packaging cushioning, and then severing the cushioning into cut sections of a desired length.

While such machines are widely used and have been commercially successful, in many applications, there is a need for improved functionality. For example, paper rolls tend to be quite heavy and cumbersome to lift and
15 load onto cushion conversion machines. Although the volume of cushioning that can be produced from a roll of paper tends to off-set the weight disadvantage for high-volume packaging operations, for lower-volume packaging operations, a lighter, easier-to-handle alternative would be preferred.

Moreover, while severing mechanisms in roll-fed machines provide a
20 workable means for producing cushions of a desired length, such mechanisms present ongoing safety concerns, in both the design and operation of such machines. As such, it would be desirable to be able to produce packaging cushions of a desired length without the need for a
25 severing or perforation mechanism.

While individual sheets of paper can be used to make cushioning, no means is known for connecting the sheets in such a way that packaging cushions having any desired length can be produced.

Finally, in many packaging applications, it is necessary to vary the
30 density of the packaging cushions to suit the weight or nature of the objects being packaged. Currently, this can only be accomplished by adding additional paper rolls or changing rolls to paper of a different weight. In both cases, the machine must be shut down and the new roll(s) must be threaded

into the machine. It would be desirable to change the cushion-density without having to make such changes.

Accordingly, there is a need in the art for a machine and method for producing packaging cushioning that is capable of fulfilling the foregoing
5 performance requirements.

SUMMARY OF THE INVENTION

That need is met by the present invention, which, in one aspect, provides a method for producing packaging cushioning, comprising:

- 10 a. successively feeding sheets of a substrate at a first speed to a crumpling mechanism;
- b. crumpling the sheets in the crumpling mechanism, the crumpling mechanism crumpling the sheets at a second speed to convert the sheets into packaging cushion units; and
- 15 c. controlling at least one of the first and second speeds to produce a desired degree of overlap between successive sheets, thereby generating a connected series of the packaging cushion units, wherein the connected series of packaging cushion units has a density that is proportional to the degree of overlap between successive sheets.

20 In accordance with another aspect of the invention, a machine is provided for producing packaging cushioning, comprising:

- a. a feed mechanism for successively feeding sheets of a substrate at a first speed;
- b. a crumpling mechanism for receiving the sheets from the feed
25 mechanism and crumpling the sheets at a second speed to convert the sheets into packaging cushion units; and
- c. a controller for controlling at least one of the first and second speeds to produce a desired degree of overlap between successive sheets, thereby generating a connected series of the packaging cushion units,
- 30 wherein the connected series of packaging cushion units has a density that is proportional to the degree of overlap between successive sheets.

By employing individual sheets of a packaging substrate, e.g., paper, the machine and method of the present invention avoids the need to lift and load

heavy rolls of the substrate onto the machine. The use of individual sheets also avoids the need for a severing or perforation mechanism, as is generally the case when the substrate is supplied from a roll. At the same time, the machine and method of the present invention allow packaging cushion units
5 made from the sheets to be connected in such a way that packaging cushions having any desired length can be produced. Moreover, the density of the packaging cushions may be varied as desired to suit the various weights, shapes, and sizes of the objects being packaged. Significantly, such density variation may be accomplished on a real-time/on-demand basis and without
10 the need to add additional paper rolls and/or change rolls to paper of a different weight.

These and other aspects and features of the invention may be better understood with reference to the following description and accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWING

FIG. 1 is a schematic view of a machine for producing packaging cushioning in accordance with the present invention;

FIGS. 2-6 are similar to FIG. 1, and show the machine in various stages
20 of packaging cushion production;

FIG. 7 is a plan view of an alternative machine in accordance with the present invention;

FIG. 8 is a perspective view of the machine shown in FIG. 7, along lines 8

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8;

FIGS. 9A and 9B are similar to FIG. 7, and show the illustrated machine in two different stages of packaging cushion production;

FIG. 10 is a plan view of a connected string of packaging cushion units as produced in FIG. 9B;

FIG. 11 a cross-sectional view of the string of packaging cushion units shown in FIG. 10, taken along lines 11 – 11; and

FIG. 12 is similar to FIG. 10, except one of the packaging cushion units is separated from the connected string of packaging cushion units.

DETAILED DESCRIPTION OF THE INVENTION

FIG. 1 schematically illustrates a machine 10 in accordance with the present invention for producing packaging cushioning. Machine 10 comprises
5 a feed mechanism 12, a crumpling mechanism 14, and a controller 16.

As shown in FIGS. 2-6, feed mechanism 12 successively feeds sheets 18 of a substrate at a first speed, which is represented by arrow 20 (FIG. 2).

Crumpling mechanism 14 receives the sheets 18 from the feed mechanism 12, and crumples the sheets at a second speed, which is
10 represented by arrow 22 (FIG. 3). The crumpling of the sheets 18 is effected in such a manner that the sheets are converted into packaging cushion units 24.

Controller 16 controls at least one of the first and second speeds 20, 22 to produce a desired degree of overlap 26 between successive sheets 18
15 (FIG. 3). Such overlap 26, in combination with the crumpling in crumpling mechanism 14, generates a connected series 28 of packaging cushion units 24 (FIGS 4-6). In accordance with the present invention, the connected series 28 of packaging cushion units 24 has a density that is proportional to the degree of overlap 26 between successive sheets 18.

20 Sheets 18 may comprise any type of material desired for use in packaging cushions, including paper, e.g., kraft paper, fiberboard, thermoplastic film, etc., including recycled forms of the foregoing materials, as well as combinations thereof, e.g., laminated paper, coated paper, composite paper, etc. The sheets may have any desired shape, e.g., square,
25 rectangular, etc., with any desired dimensions, e.g., a 20 inch length dimension and a 15 inch width dimension.

Sheets 18 may be arranged for supply to machine 10 in any convenient form, e.g., as a stack 30 as shown, or in shingled, random, or individual form, etc., as desired. When sheets 18 are arranged as a stacked supply 30 as
30 shown, machine 10 may further include a supply tray 32, which is configured and dimensioned for holding the sheets in a stacked arrangement of desired height, i.e., to accommodate a desired maximum number of sheets 18 in stack 30. When such an embodiment is employed, feed mechanism 12 may

be disposed and configured for feeding the sheets 18 from supply tray 32 to crumpling mechanism 14. As such, the feed mechanism 12 may comprise a first feed roller 34 to advance the sheets 18 from the supply 30 thereof, and a second feed roller 36 to receive the sheets from the first feed roller 34 and
5 feed the sheets into crumpling mechanism 14.

The first feed roller 34 may be associated with a motor, schematically designated as motor "M3" in the drawings, to drive the rotation of the feed roller. The feed roller 34 may be in a fixed position relative to tray 32, with the tray including a movable tray base 38, e.g., pivotally movable as shown, which
10 may be biased towards feed roller 34, e.g., via spring 40. In this manner, as the stacked supply 30 of sheets 18 depletes, the sheets are continuously urged against the feed roller 34 so that the feed roller can continue to advance the sheets sequentially from the stack.

FIGS. 2-6 illustrate tray 32 with a relatively full stack 30, such that
15 spring 40 is fully compressed and tray base 38 is substantially aligned with the bottom 42 of tray 32. The pivot point for tray base 38, e.g., hinge 41 as shown, may be placed at any desired location along the bottom 42 of tray 32, e.g., opposite from spring 40 as shown or, e.g., closer to spring 40 such that the movable tray base 38 is shorter than as shown.

20 Instead of, or in addition to, a movable tray base 38, the first feed roller 34 may be movably biased towards the stack 30.

First feed roller 34 may be accompanied by as many additional feed rollers as necessary to advance the sheets 18. For example, two or more feed rollers 34 may be arrayed across the width of the sheets 18, e.g., as
25 shown in FIG. 8 (wherein first feed roller 34 is shown as a pair 34a, b of such feed rollers).

As shown in the illustrated embodiment, the second feed roller 36 is positioned to receive the sheets 18 from first feed roller 34, e.g., via guide member 44, and then feed the sheets into the crumpling mechanism 14. The
30 second feed roller 36 may be associated with a motor, schematically designated as motor "M1" in the drawings, to drive the rotation of the feed roller. As an alternative to the illustrated embodiment in which separate motors M3 and M1 are employed to drive the rotation of the first and second

feed rollers 34 and 36, respectively, a single motor (not shown) may be employed to drive the rotation of both the first and second feed rollers 34 and 36, e.g., via appropriate linkage, which may include drive belt(s), drive chain(s), drive axel(s), etc.

5 Second feed roller 36 may be accompanied by as many additional feed rollers as necessary to advance the sheets 18. For example, two or more feed rollers 36 may be arrayed across the width of the sheets 18, e.g., as shown in FIG. 8 (wherein second feed roller 36 is shown as a pair 36a, b of feed rollers).

10 A backing member 46 may be included, to provide a support against which second feed roller 36 rotates, to thereby facilitate the feeding of sheets 18 into crumpling mechanism 14. Backing member 46 may be a static member, which provides frictional resistance to the rotation of roller 36 such that the sheets 18 are compressed between the roller 36 and backing
15 member 46 while passing therebetween, with the sheets making sliding contact with the member 46. Alternatively, backing member 46 may be a rotational member, which rotates passively via rotational contact with the driven roller 36. As a further alternative, the relative position of the second feed roller 36 and backing member 46 may be switched such that the driven
20 roller 36 is beneath the backing member 46. This orientation may be particularly convenient when a single motor is employed to power the rotation of both the first and second feed rollers.

 As may be appreciated, feed mechanism 12 generally defines a path of travel along which the sheets 18 move between the supply 30 of the sheets
25 and the crumpling mechanism 14. As mentioned briefly above, the feed mechanism 12 may further include guide member 44, which may be included to facilitate the movement of the sheets along the travel path, e.g., by directing the movement of the sheets from the first feed roller 34 to the second feed roller 36.

30 The guide member 44 may be structured and arranged to change the movement of the sheets 18 on the travel path, e.g., from a first direction 48, in which the sheets are fed from supply/stack 30, to a second direction 50, in which the sheets are crumpled (FIG. 2). Advantageously, this allows the

machine 10 to have a compact configuration or 'footprint,' e.g., in which the supply tray 32 with sheet supply 30 is positioned beneath crumpling mechanism 14 as shown.

5 In the presently illustrated embodiment, the crumpling mechanism 14, second feed roller 36, backing member 46, and motors M1, M2 may be contained within a housing 54 (shown in phantom). The first direction 48 may be substantially parallel to and substantially opposite from the second direction 50 (see, FIG. 2), such that the housing 54 may be positioned substantially directly above the supply tray 32, e.g., in a stacked configuration as shown. Guide
10 member 44 may thus define an arcuate path of travel for sheets 18 as shown, e.g., with approximately 180 degrees of curvature. With such a structure, secondary or inner guide member 45 may also be included, and may have a complementary position on the inside of the arcuate path defined by guide member 44 as shown.

15 In the above-described embodiment, the second feed roller 36 receives the sheets 18 indirectly from the first feed roller 34, e.g., via guide member 44. Alternatively, the feed mechanism 12 may define a more linear path of travel for the sheets 18, in which the sheets are advanced from supply 30 in substantially the same direction as they are crumpled in crumpling mechanism 14. This may
20 be accomplished, e.g., by positioning the supply tray 32 beside, rather than beneath, housing 54. In such embodiment, the second feed rollers may receive the sheets 18 substantially directly from the first feed roller 34, i.e., with no intervening guide member 44. More generally, supply tray 32 and housing 54 may have any desired relative orientation. For example, the tray 32 and housing
25 54 may be positioned at 90 degrees to one another, e.g., with the housing 54 having a substantially horizontal orientation and the tray 32 having a substantially vertical orientation.

Feed rollers 34, 36 may comprise any material suitable for conveying sheets 18, such as metal (e.g., aluminum, steel, etc.), rubber, elastomer (e.g.,
30 RTV silicone), urethane, etc., including combinations of the foregoing materials. As an alternative to wheel-type rollers as shown, one or both feed rollers 34, 36 may comprise one or more counter-rotating drive belts, drive bands, etc. As a further alternative to feed rollers 34, 36, or in addition thereto, feed mechanism

12 may convey the sheets 18 via any suitable sheet-handling means, including pneumatic conveyance, electrostatic conveyance, vacuum conveyance, etc.

Crumpling mechanism 14 may comprise a pair of compression members 52a and 52b that convert the sheets 18 into packaging cushion units 24 by compressing the sheets therebetween. The compression members 52a, b may comprise a pair of counter-rotating wheels, belts, etc., or, as shown, a pair of counter-rotating gears, which may have radially-extending teeth 56 that mesh together to effect the crumpling of the sheets 18, e.g., as illustrated in FIGS. 3-6. The teeth 56 are preferably sized and shaped to convey and crumple the sheets 18 without tearing the sheets. The compression members 52a, b and teeth 56 may be formed of any material capable of conveying and crumpling the sheets 18, and preferably with sufficient toughness to withstand wear but without causing damage to the sheets 18. Many suitable materials exist. Examples include polymeric materials such as ultra-high molecular weight polyethylene (UHMWPE), polyimide, fluorocarbon resins such as polytetrafluoroethylene (PTFE) and perfluoropropylene, acetal resins, i.e., resins based on polyoxymethylene, including homopolymers (e.g., Delrin[®] brand polyoxymethylene), copolymers, and filled/impregnated grades, such as PTFE-filled acetal resins; various metals such as aluminum, steel, etc.; metals with low-COF coatings, e.g., anodized aluminum or nickel impregnated with low-COF polymers such as PTFE or other fluorocarbon resins; and mixtures or combinations of the foregoing.

In accordance with the present invention, the compression members 52a, b connect the packaging cushion units 24 together by crumpling the sheets 18 at the overlap 26 between successive sheets. That is, the inventors found that the action of crumpling two overlapped sheets together has the effect of joining the sheets together at the overlapped portions of the sheets. By controlling the first speed 20 relative to the second speed 22, the overlap 26 can have any desired degree. Preferably, the overlap 26 is only a partial overlap such that a chain of the sheets 18, as converted into packaging cushion units 24, may be connected together, i.e., to form connected series 28.

FIGS. 2-6 illustrate a sequence of events that lead to the conversion of sheets 18 into packaging cushion units 24, and to their being connected together to form a connected series 28 of the packaging cushion units 24.

FIG. 2 illustrates the beginning of the production process, in which first
5 feed roller 34 of feed mechanism 12 engages the upper-most sheet 18a in stack 30, and rotates in the direction of the indicated arrow to move the sheet in first direction 48. Sheet 18a immediately encounters guide member 44, which causes it to change course to second direction 50, thereby leading the sheet 18a into the nip between second feed roller 36 and backing member 46.
10 Motor M1 is powering the rotation of the second feed roller 36, as indicated by the rotational arrows associated with the feed roller 36 and backing member 46, such that sheet 18a is fed towards crumpling mechanism 14 at first speed 20. The magnitude of first speed 20 is determined by the output of motor M1. Motors M1 and M3 may be synchronized such that the speed at which the
15 sheets 18 are advanced from supply 30 is the same as the speed 20 at which the sheets are fed to the crumpling mechanism 14. As noted above, this may be accomplished by employing only one motor in place of the separate motors M1 and M3, and transmitting the rotational output of such motor to both the first and second feed rollers 34, 36. Alternatively, by operating the first and
20 second feed rollers 34, 36 at different speeds, compressive or tensional forces may be imparted on the sheets 18 prior to their conveyance to the crumpling mechanism 14.

The feeding of the sheets 18 by the feed mechanism 12 may be facilitated by including a second guide member, which may include upper and
25 lower guide plates 58a, b. As shown, guide plates 58a, b may be positioned between second feed roller 36 and crumpling mechanism 14, and arranged to form a passage 60 therebetween to guide the movement of the sheets 18 as they are fed by the second feed roller 36 and into the crumpling mechanism 14.

30 In FIG. 3, a second sheet 18b has been withdrawn from supply stack 30 by first feed roller 34, transferred to second feed roller 36, and is being fed through passage 60 towards crumpling mechanism 14 by the second feed roller 36 at first speed 20. At the same time, the first sheet 18a has reached

crumpling mechanism 14 and is being crumpled and conveyed thereby at second speed 22. Second speed 22 results from the rotational speed at which the compression members 52a, b counter-rotate against one another, as indicated by the rotational arrows. The rotational speed of the
5 compression members 52a, b, in turn, is determined by the output of motor M2.

In accordance with the present invention, at least one of the first and second speeds 20, 22 are controlled to produce a desired degree of overlap 26 between successive sheets 18, thereby generating the connected series
10 28 of packaging cushion units 24. As shown in FIG. 3, the overlap 26 is produced between the trailing end 62 of sheet 18a and the leading end 64 of sheet 18b. Such overlap may result from a speed differential between first speed 20 and second speed 22.

For example, the crumpling mechanism 14 and second feed roller 36
15 may be operated such that second speed 22 is slower than first speed 20. In this manner, when sheet 18a is released from feed mechanism 12 and engaged only by crumpling mechanism 14, it will be moving at the slower second speed 22. Conversely, while the next sheet 18b is engaged only by the feed mechanism 12, i.e., prior to the leading end 64 thereof reaching the
20 crumpling mechanism 14, it (sheet 18b) moves at the relatively higher first speed 20. As a result, the leading end 64 of sheet 18b overtakes and slides over or under the trailing end 62 of sheet 18a, to form overlap 26 as shown. The degree of the overlap 26 will continue to increase until the leading end 64 of sheet 18b reaches the crumpling mechanism 14 and/or sheet 18b is
25 released from feed mechanism 12.

That is, as shown in FIG. 4, once the leading end 64 of sheet 18b becomes engaged by the crumpling mechanism 14, the speed at which the sheet 18b moves through machine 10 will decrease from first speed 20 to second speed 22. At that point, with both sheets 18a, b moving at the same
30 speed, i.e., speed 22, and both sheets being engaged by crumpling mechanism 14, no further relative movement of sheets 18a, b will occur, such that no further increase in the overlap 26 will occur. Thus, as shown, the overlapped section 26 of successive sheets 18a and 18b are crumpled

together in crumpling mechanism 14, which has the effect of joining the trailing end 62 of sheet 18a to the leading end 64 of the following sheet 18b. This, in turn, results in the connection of the packaging cushion unit 24a, as formed by the crumpled sheet 18a, to the next packaging cushion unit 24b, which is being formed in FIG. 4 from sheet 18b as it is crumpled in crumpling mechanism 14.

In FIG. 5, the connection process between packaging cushion units 24a and 24b is complete in that the overlap 26 between the respective successive sheets 18a and 18b has moved through and past crumpling mechanism 14. The remainder of sheet 18b is being crumpled to complete its conversion into packaging cushion unit 24b. The resultant series 28 of connected packaging cushion units is being conveyed out of machine 10, e.g., via outlet 66 in housing 54. If desired, a receptacle, e.g., a storage bin or the like (not shown), may be employed for containment of the connected series 28 of packaging cushion units 24 until such cushion units are needed for use. In such case, the outlet 66 may be configured to guide the connected series 28 directly into the receptacle.

Also in FIG. 5, first feed roller 34 of feed mechanism 12 engages the next sheet 18c in stack 30, and advances it towards second feed roller 36 via guide member 44. The sheet 18c then moves through the nip between second feed roller 36 and backing member 46 at first speed 20 towards the preceding sheet 18b, which is moving at a slower second speed 22 as a result of its engagement by crumpling mechanism 14. The speed differential between speeds 20 and 22 will result in leading end 64 of sheet 18c overtaking the trailing end 62 of the preceding sheet 18b to form another overlap 26 (shown in FIG. 6), as described above relative to FIG. 3.

In FIG. 6, an overlap 26 has formed between the leading end 64 of sheet 18c and the trailing end 62 of the preceding sheet 18b. Such overlap 26 is being crumpled together in crumpling mechanism 14, which has the effect of joining the trailing end 62 of sheet 18b to the leading end 64 of the following sheet 18c. This, in turn, results in the connection of the packaging cushion unit 24b, as formed by the crumpled sheet 18b, to the next packaging cushion unit 24c,

which is being formed from sheet 18c as it is crumpled in crumpling mechanism 14.

As also shown in FIG. 6, as the supply 30 of sheets 18 in tray 32 depletes, spring 40 extends, and thereby causes the tray base 38 to pivot upwards to maintain the uppermost sheet in the supply stack in contact with first feed roller 34.

The foregoing process may continue for as long as desired, e.g., until supply 30 of sheets 18 in tray 32 is depleted, in order to add as many additional packaging cushion units 24 as desired to the connected series 28.

First speed 20 and/or second speed 22 may be controlled by controlling the rotational speed of the second feed roller 36 and/or that of the crumpling mechanism 14, respectively. Controller 16 may thus be in electrical communication with motor M1 and/or M2. Thus, for example, the speed at which motor M2 drives the rotation of the compression members 52a, b may be fixed, while controller 16 may be operably linked to motor M1 to cause the motor to provide a range of controllable output speeds which, in turn, produce a range of rotational speeds for second feed roller 36. Alternatively, the speed of motor M1 may be fixed while motor M2 is a variable speed motor, the speed of which is controlled by controller 16. As a further alternative, both motors M1 and M2 may be variable-speed motors, and both may be operably linked to controller 16, e.g., via control wires 68 and 70 as shown, so that the speed of one or both of motors M1, M2 may be controlled.

Controller 16 may be an electronic controller, such as a printed circuit assembly containing a micro controller unit (MCU), which stores pre-programmed operating codes; a programmable logic controller (PLC); a personal computer (PC); or other such control device which allows the speed of motors M1 and/or M2 to be controlled via local control, e.g., via an operator interface; remote control; pre-programmed control, etc.

Controller 16 may control the operation of motor M1 and/or M2, thereby controlling at least one of the first and second speeds 20, 22, automatically, manually, or via a combination of both automatic and manual control. In some embodiments, controller 16 may be configured to receive input from an operator, i.e., from an operator interface such as a foot pedal, hand switch,

control panel, etc., including combinations of the foregoing. An operator may thus be able to select a desired degree of overlap between successive sheets, as well as the number of packaging cushion units to be connected in a given series of such units.

5 Thus, for example, controller 16 may include, or be electronically associated with, an operator input device, e.g., a switch or the like (not shown), which allows the operator to select a desired degree of overlap between successive sheets. A two-position switch, for example, could allow an operator to choose between a 'low-density' mode of operation and a 'high-

10 density' mode of operation.

 In the 'low-density' mode, controller 16 would command machine 10 to connect packaging cushion units 24 together with a minimum degree of overlap, e.g., just enough to form a connection, such as between about 1 and about 3 inches of overlap between successive sheets. The advantage of the

15 low-density mode is that a minimal amount of sheets 18 are used for a given length of connected packaging cushion units 24, thus providing an economical mode of operation as would be appropriate, e.g., for lighter weight objects to be packaged. As an example, for sheets 18 having a length of 20 inches and a width of 17 inches, such low-density/minimal overlap mode was achieved

20 when machine 10 was configured as alternative machine 10' as shown in FIGS. 7-9, and was operated at a first speed 20 of about 40 inches/second and a second speed 22 of about 26 inches/second, or a first speed 20/second speed 22 ratio of about 1.5. Such speed ratio of about 1.5 resulted in an overlap 26 of about 2 inches.

25 In the 'high-density' mode, controller 16 would command machine 10 to connect packaging cushion units 24 together with a greater degree of overlap, e.g., between about 4 and about 6 inches of overlap between successive sheets. Although a greater number of sheets 18 are used to produce a given length of connected packaging cushion units 24, i.e., as compared with the

30 low-density mode, an increase in the density of the packaging cushions often becomes necessary when the packaging application changes, e.g., to properly protect higher-weight objects that need to be packaged. As an example, for sheets 18 having a length of 20 inches and a width of 17 inches,

such high-density/higher overlap mode was achieved when machine 10 was configured as alternative machine 10' as shown in FIGS. 7-9, and was operated at a first speed 20 of about 28 inches/second and a second speed 22 of about 12 inches/second, resulting in a speed differential of about 16 inches/minute. Such speed differential of 16 inches/minute resulted in an overlap 26 of about 5 inches. Stated differently, the speed ratio between first speed 20 (28 inches/second) and second speed 22 (12 inches/minute) in this example was about 2.33.

An alternative control scheme is to enable the operator to select any desired differential or ratio between first speed 20 and second speed 22, between pre-set minimum and maximum amounts. For example, a potentiometer that adjusts the speed ratio between first speed 20 and second speed 22 may be employed, wherein a setting of "0" (zero) corresponds to the minimum allowed differential between speeds 20 and 22 (minimum allowed overlap between successive sheets/minimum density), and "10" (ten) corresponds to the maximum allowed differential between such speeds (maximum allowed overlap/maximum density). Another alternative would be to have a multitude of preset density conditions, which the operator can select by switching between predetermined ratio settings using a multi-position switch.

As a further alternative, controller 16 may be configured to allow an operator to set the operating speeds of motor M1 and/or M2 manually, e.g., as the sole means of control. In such embodiment, controller 16 may be a simple device containing, for example, a multi-position switch or dial to control the speed of motor M1/second feed roller 36 and/or a second switch or dial to control the speed of motor M2/compression members 52a, b.

As may be appreciated, the ability to easily change the density of the connected series 28 of packaging cushion units 24 as needed, i.e., without having to change to a different type/weight of sheet, or add sheets from a different source, in order to suit the changing needs of differing packaging applications is a distinct advantage of the present invention.

The controller 16 may further include or be associated with a dial or the like, which allows an operator to select a desired number of packaging

cushion units to be produced upon a further command from the operator, such as the actuation of a foot pedal or hand switch (not shown) in electrical communication with the controller. Such actuation by the operator will then result in machine 10 commencing operation and continuing to operate until
5 the selected number of packaging cushion units are produced.

In one mode of operation, controller 16 may be programmed by specifying, via appropriate input command, the diameter of both the first and second feed rollers 34, 36, as well as the length of the sheets 18. When controller 16 is operably linked to motor M1 as described above (i.e., via
10 control wire 68), and also to motor M3 (control wire not shown; M1 and M3 may be the same motor) the speed of motors M1 and M3 may be controlled by controller 16. Based on the operational run-time and rotational-speed commands that the controller has given to each of the feed rollers 34, 36, coupled with any necessary feed-back to verify that such commands have
15 been carried out, the controller 16 will “know”, through simple calculations, the approximate number of sheets 18 that have been fed by the first feed roller 34 and by the second feed roller 36. In this manner, controller 16 can maintain an approximate count of the number of packaging cushion units produced each time that an operator commands the machine to run, e.g., so that the
20 controller 16 can automatically command the machine to stop when the requested number of cushion units has been produced. Other means for counting the number of cushion units produced, which will generally be more precise but also more costly, are also possible, e.g., photo-eyes, motor encoders, etc. Such devices may be employed to provide feed-back to
25 controller 16 regarding the number of sheets and/or cushion units that have passed a given point in machine 10.

Controller 16 may include or be associated with a further operator input device, e.g., a switch or the like, which allows the operator to select an ‘eject’ mode, wherein machine 10 ejects the resultant string of packaging cushion
30 units, e.g., into a bin or other receptacle, or a ‘hold’ mode, wherein machine 10 holds the last packaging cushion unit produced in a string of cushions in the outlet 66 for manual removal by the operator.

For example, with reference to FIG. 6, if the operator selects a string of about three (3) packaging cushion units 24 to be produced, and also selects the 'eject' mode, controller 16 will command motor M3 and then M1 to discontinue operations once it (the controller 16) determines that sheets 18a-c have passed through the first and second feed rollers 34, 36. In this case, the resultant series 28 of three (3) connected packaging cushion units would be ejected out of machine 10 via conveyance by crumpling mechanism 14, which the controller 16 will command to continue to operate for a predetermined time (based on speed 22 and the pre-programmed length of sheets 18) after second feed roller 36 ceases to operate.

Using the same example, if the operator selects the 'hold' mode, an additional sheet, e.g., a fourth sheet 18d (not shown), will be connected to sheet 18c (or to the last sheet to be included in the series) via an overlap 26 (also not shown), and the controller 16 will command all motors M1 – M3 to stop once that overlap has cleared the compression members 52a, b, such that the resultant series 28 of about three (3) connected packaging cushion units is extending from outlet 66, connected to a partially formed cushion unit formed by the next sheet (e.g., 18d), which is held in the machine by the compression members 52a, b. To remove such connected series 28, the operator simply pulls cushion unit 24c to release it from the overlapped connection 26 with the partially-formed cushion unit formed from the next sheet (e.g., 18d).

An alternative means for achieving a speed differential between the speed at which the sheets are crumpled vs. the speed at which the sheets are fed, in order to achieve a desired degree of overlap, may be effected by varying the relative positioning of the crumpling mechanism 14 vs. the feed mechanism 12 during the movement of the sheets. This may be accomplished by effecting relative translational movement of the crumpling and/or feed mechanisms 14, 12 during transport of the sheets 18, wherein the timing and magnitude of such translational movement is controlled to achieve a desired degree of overlap between successive sheets. With reference to FIG. 3, for example, overlap 26 can be provided by the relative movement of crumpling mechanism 14 towards second feed roller 36 such that the leading

end 64 of sheet 18b overtakes and overlaps the trailing 62 of preceding sheet 18a. The entire crumpling mechanism 14, for example, could be placed on a track, rail, or other means of guided translational movement, and moved towards second feed roller 36 via an appropriate actuator, e.g., a piston, to
5 produce the overlap 26. When the overlap 26 reaches and becomes engaged by the compression members 52a, b, the crumpling mechanism 14 can then be returned to its starting position, i.e., translated away from second feed roller 36, and thus in position for a subsequent overlap-causing movement.

Accordingly, relative to a fixed point on machine 10, the second speed
10 (at which the sheets are crumpled) may be controlled via translational movement of crumpling mechanism 14 to achieve a desired degree of overlap between successive sheets. Similarly, control of the first speed could be achieved by effecting translational movement of the feed mechanism 12 relative to the crumpling mechanism 14.

As illustrated in the drawings, crumpling mechanism 14 receives sheets 18 indirectly from feed mechanism 12, i.e., via guide plates 58a, b, which are interposed between the feed mechanism 12 and the crumpling mechanism 14. Alternatively, such guide plates 58a, b may be omitted such that the crumpling mechanism 14 receives the sheets directly from the feed
20 mechanism 12.

As a further alternative, a machine in accordance with the present invention may include a convergence device in place of guide plates 58a, b. As shown in FIGS. 7-9, in alternative machine 10', at least part of convergence device 72 may be positioned between feed mechanism 12 and crumpling mechanism 14 for reducing the width dimension of the sheets 18. As
25 shown, convergence device 72 may be in the form of a chute, with a relatively wide entrance portion 74 and a relatively narrow exit portion 76. Second feed roller 36 may be in the form of a pair of such feed rollers 36a, b, which may be positioned at or near the entrance portion 74 of convergence device 72, and
30 driven by motor M1 via a common drive axle 78. With this arrangement, the feed mechanism 12 feeds the sheets 18 into crumpling mechanism 14 by pushing the sheets through the convergence device 72 and then into the crumpling mechanism 14.

Exit portion 76 may be positioned adjacent the crumpling mechanism 14, such that sheets 18 exiting the convergence device 72 are directed into the crumpling mechanism. A guide channel 80 may extend from convergence device 72 as shown, to contain and direct the sheets 18 as they are crumpled in mechanism 14. In alternative machine 10', crumpling mechanism 14 may thus be positioned within the guide channel 80, and may be driven by motor M2 via drive axle 82.

As perhaps best shown in FIG. 8, convergence device 72 may include opposing side walls 88a, b, which converge in a direction leading from the entrance portion 74 to the exit portion 76, i.e., along second direction 50. Side walls 88a, b may be included as necessary to facilitate the convergence of sheets 18 by helping to contain and direct the sheets as their width is reduced.

As also shown in FIG. 8, first feed roller 34 may comprise a pair of rollers 34a, b, which may be driven by motor M3 via common drive axle 84. A pair of springs 40, indicated as springs 40a, b in FIG. 8, may be included to bias tray base 38 towards the feed rollers 34a, b. Tray base 38 may be pivotally attached to the bottom 42 of tray 32 via multiple hinges 41a-c.

FIG. 9A is essentially a plan view of FIG. 2, in that sheet 18a is being fed from stack 30 and into crumpling mechanism 14 at first speed 20. In FIG. 9A, however, machine 10' includes convergence device 72, instead of guide plates 58a, b, through which sheet 18a is being conveyed en route to crumpling mechanism 14.

As may be appreciated, sheets 18 generally have a length dimension and a width dimension, each of which may be the same or different among the various sheets in stack 30. With respect to sheet 18a for example, the width dimension "W1" thereof is shown in FIG. 9A; the length dimension "L" of the sheets is shown in FIG. 2. The sheets 18 generally also have a pair of opposed lateral sides 86a, b (FIG. 9A).

Accordingly, when alternative machine 10' is employed, i.e., with convergence device 72, a method in accordance with the present invention may further include the step of reducing the width dimension of the sheets. As shown in FIG. 9A, such width reduction step may occur prior to the crumpling step in crumpling mechanism 14, and may be effected by directing the sheets 18

through convergence device 72. Thus, as the sheets 18 move from the entrance portion 74 to the exit portion 76 along second direction 50, the convergence device 72 causes the lateral sides 86a, b to converge towards one another.

For example, as shown in FIG. 9A, the initial width W1 of sheet 18a
5 may be slightly less than that of the entrance portion 74 of convergence device 72 so that the sheet can be fed into the device 72. As the sheet moves along second direction 50, the lateral sides 86a, b of the sheet come in contact with the convergent side walls 88a, b. Such convergent contact
10 between the lateral sides 86a, b and the side walls 88a, b causes the lateral sides 86a, b of the sheet to converge towards one another as shown. As a result, upon reaching the exit portion 76 of the convergence device 72, and then traveling through the guide channel 80, the width of the sheet is reduced from width W1 to width W2.

The side walls 88a, b may be curved as shown in FIG. 8, or may have
15 any other shape, e.g., square or rectangular, that facilitates the convergence of the lateral sides 86a, b. The convergence device 72 may include a bottom surface 90 as shown, and may also include a top surface (not shown), e.g., similar to upper guide plate 58a as shown in FIGS. 1-6 with respect to machine 10. As shown in FIGS. 7-8, cut-outs 91 in bottom surface 90 may be
20 provided for second feed rollers 36a, b and backing members 46. Alternatively, both the backing members 46 and cut-outs 91 may be omitted as shown in FIGS. 9A-B, wherein feed rollers 36a, b drive the sheets 18 against the bottom surface 90 of convergence device 72.

FIG. 9B is essentially a plan view of FIG. 5, except that convergence
25 device 72 is used instead of guide plates 58a, b. Thus, similar to FIG. 5, in FIG. 9B the connection process between packaging cushion units 24a' and 24b', from respective successive sheets 18a and 18b, is complete, with the overlap 26a between sheets 18a, b having moved through and past crumpling mechanism 14. The remainder of sheet 18b is being crumpled to complete its
30 conversion into packaging cushion unit 24b'. The next successive sheet 18c is being fed by feed mechanism 12 at first speed 20 towards the preceding sheet 18b, which is moving at a slower second speed 22 as a result of its engagement by crumpling mechanism 14. The speed differential between

speeds 20 and 22 will result in leading end 64 of sheet 18c overtaking the trailing end 62 of the preceding sheet 18b to form another overlap 26, e.g., as shown in FIG. 6.

It may be appreciated that the shape and characteristics of packaging cushion units 24', as produced by machine 10', are different than those of packaging cushion units 24, as produced by machine 10, in that, prior to crumpling, the convergence device 72 of machine 10' reduces the width dimension W1 of sheets 18, such that the width of the resultant packaging cushion units 24 is W2. Generally, the convergence device 72 may be configured to effect any desired width reduction in sheets 18. The ratio of W1:W2 may be, for example, within the range of 10:1 to 1:1, e.g., between about 9:1 to about 2:1, such as between about 8:1 to about 3:1, 7:1 to 4:1, etc.

In the present embodiment, convergence device 72 reduces such width by causing the lateral sides 86a, b to converge. For example, the convergence of the lateral sides 86a, b may be such that the lateral sides overlap one another and form the sheets 18 into a tube 93 as shown, e.g., with only lateral side 86a being visible. As shown, sheet 18b has been formed into a tube 93, and the width thereof is being reduced as it travels towards the exit portion 76 of convergence device 72. Sheet 18c is in the process of being formed into a tube. The differential between its speed 20 and that of sheet 18b (i.e., slower speed 22) will result in leading end 64 of the tube being formed from sheet 18c overtaking the trailing end 62 of the tube 93 formed from preceding sheet 18b, which will form another overlap of the tubes, i.e., as at 26 in FIG. 9B.

In the illustrated embodiment, the final width of the packaging cushion units 24 is shown to be essentially the same as that of the outlet 66 of housing 54, i.e., W2. It should be understood, however, that this is not necessarily the case. For example, the internal structure of housing 54 can be arranged such that the final width of the packaging cushion units 24 is less than the width of the outlet 66, e.g., as would be the case if the exit portion 76 of convergence device 72 is narrower than outlet 66.

Regardless of the manner in which the lateral sides 86a, b are converged in device 72, as shown in FIG. 9B, the crumpling mechanism 14 crimps the converged lateral sides, e.g., as the tube 93 passes through the crumpling mechanism. This has the effect of causing the resultant packaging cushion unit 24' to maintain a substantially tubular, i.e., longitudinally-rolled, form.

Referring now to FIGS. 10-11, the packaging cushion units 24' will be described in further detail. FIGS. 10-11 show a connected series 28' of packaging cushion units 24', comprising packaging cushion units 24'a-c, as made from machine 10'. A greater or less number of packaging cushion units may be included in any given connected series of such cushions. Each packaging cushion unit 24' comprises a pair of end regions 92 bounding a central region 94. As shown, the end regions 92 correspond to the overlap 26 between successive sheets 18. As indicated collectively in FIGS. 9B through 11, crumpling mechanism 14 crimps the overlapped end regions 92 of adjacent packaging cushion units 24' together. This has the effect of connecting the packaging cushion units 24' to thereby form the connected series 28'. Thus, in the illustration set forth in FIGS. 10-11, packaging cushion units 24a' and 24b' are connected at overlap 26a, while packaging cushion units 24b' and 24c' are connected at overlap 26b.

When machine 10' is employed, the overlapped end regions 26/92 may be formed by inserting the leading end 64 of a sheet 18, which is being formed into a tube 93, into the trailing end 62 of the preceding sheet that has already been formed into a tube 93. For example, as shown in FIG. 9B, sheet 18c is being formed into a tube, with the leading end 64 having a cone shape as a result of the converging side walls 88a, b of convergence device 72. As the sheet 18c moves towards the preceding sheet 18b at speed 20, the cone-shaped leading end 64 will be inserted into the trailing end 62 of the tube-shaped sheet 18b, which is moving at the slower speed 22.

Thus, the crumpling mechanism 14 as employed in machine 10' crimps both of the following:

1) the converged lateral sides 86a, b, which has the effect of causing the resultant packaging cushion unit 24' to maintain a substantially tubular, i.e., longitudinally-rolled, shape; and

2) the overlapped end regions 26/92 of adjacent packaging cushion units 24', which has the effect of connecting the packaging cushion units 24' together as a series 28'.

Regardless of whether machine 10 or 10' is employed, the connected series 28/28' of packaging cushion units 24/24' will generally have a density that is proportional to the degree of overlap 26 between successive sheets 18. Thus, the higher the degree of the overlap 26, the higher will be the average density of the connected series 28/28' of packaging cushion units. With a higher degree of overlap, more sheets 18 will be present per unit volume of the connected series 28/28' than when the degree of overlap is less.

The degree of overlap 26 is proportional to the speed differential between the first and second speeds 20, 22. Thus, the degree of overlap 26, and therefore the density of the connected series 28/28' of packaging cushion units 24/24', may be controlled by controlling such speed differential.

Generally, the degree of overlap between any two successive sheets 18 may range from greater than 0% to less than 100%, e.g., between about 1% and about 75% overlap, between about 2% and about 50% overlap, or between about 3% and about 40% overlap, etc. For example, sheets 18 having a width "W1" of 17 inches and a length "L" of 20 inches were formed on machine 10' into a connected series 28' of packaging cushion units 24' with an overlap of about 25%, i.e., with about 5 inches of overlap between successive sheets 18, by employing a first speed 20 of about 28 inches/second and a second speed 22 of about 12 inches/second, resulting in a speed differential of about 16 inches/minute or, stated differently, a speed ratio (first speed:second speed) of 2.33:1. The initial width W1 of the sheets 18 (17 inches) was reduced to a final width W2 in the resultant packaging cushion units of 3 – 3.5 inches, for a W1:W2 ratio of about 5:1. The density of the resultant series 28' of packaging cushion units 24' was about 1.4 lbs/ft³.

When a similar series 28' of connected packaging cushion units 24' was formed with an overlap 26 of 2 inches, i.e., a lower degree of overlap

than 5 inches as in the previous example, the resultant density of the connected series 28' was also lower – namely, about 1.2 lbs/ft³. In this example, the first speed 20 was about 40 inches/second and the second speed 22 was about 26 inches/second.

5 Referring now to FIG. 12, a further beneficial feature of the invention will be described. Namely, in accordance with some embodiments of the invention, the packaging cushion units may be connected such that each packaging cushion unit 24/24' is slidably separable from an adjacent packaging cushion unit 24/24'. As shown in FIG. 12, packaging cushion unit 10 24c' is being slidably separated from connected series 28'. More specifically, packaging cushion unit 24c' is being slidably separated from adjacent packaging cushion unit 24b' in the direction of arrows 96. This may be accomplished by connecting the cushion units 24b' and 24c' in such a way that the overlapped end regions 92 at which the two cushion units are 15 connected, i.e., at overlap 26b in FIGS. 10-11, are releasable. Such releasable connection may, for example, be effected via a friction fit, which is produced by the crumpling of sheets 18 at the overlap 26 between successive sheets.

A friction fit between adjacent packaging cushion units may be 20 achieved via the use of the crumpling mechanism 14 as described above, i.e. comprising counter-rotating compression members 52a, b, each of which have cooperative teeth 56 that intermesh together. The intermeshing teeth 56 may be shaped and arranged to crimp the sheets 18 so as to form an alternating series of convex impressions 98 and concave impressions 100 in 25 packaging cushion units 24', e.g., 'peaks' 98 and 'valleys' 100, as perhaps best shown in FIG 11. The width of the compression members 52a, b may be substantially equal to the final width W2 of the packaging cushion units 24' so that the peaks and valleys 98, 100 extend transversely across substantially the entire width W2 of the units 24'. Alternatively, as shown in FIGS. 9A/9B, 30 the width of the compression members 52a, b may be less than width W2, so that the peaks and valleys 98, 100 extend transversely across only a part of the width W2 of the packaging cushion units 24', e.g., across a center region

102 (FIG. 12), leaving longitudinally-extending outer regions 104 substantially without impressions 98, 100.

In the overlap areas 26, the peaks and valleys 98, 100 of the crimped end regions 92 of adjacent packaging cushion units 24' serve to connect the units 24' together with a friction fit, which also permits the units 24' to be
5 slidingly separated from one another, e.g., as shown in FIG. 12. In addition to the degree of overlap 26, the coefficient of friction of sheets 18, etc., the depth of the peaks and valleys 98, 100 will determine the strength of the connection between adjacent packaging cushion units 24/24'. The depth of the peaks
10 and valleys 98, 100, is based, at least in part, on the extent of intermeshing of the teeth 56 of counter-rotating compression members 52a, b. Thus, in addition to the selection of the degree of overlap 26 and the type of sheets 18, the depth of the peaks and valleys 98, 100 may be established to provide a desired amount of connection strength between adjacent packaging cushion
15 units, so that any two units may be disconnected from one another upon the application of a desired amount of tensional force, e.g., manual force, as exerted, e.g., in the direction of arrows 96 in FIG. 12.

Advantageously, in accordance with the present invention, packaging cushions of any desired size, e.g., comprising a desired number of connected
20 packaging cushion units 24/24', may be created by separating two of the packaging cushion units from one another to thereby remove a packaging cushion from the connected series 28/28' of packaging cushion units. With reference to FIG. 12, for example, a packaging cushion 106 may comprise connected packaging cushion units 24a' and 24b'. As may be appreciated,
25 the the density of packaging cushion 106 varies along its length dimension (parallel to arrows 96), with the density being higher in the overlap area 26a (at which the cushion units are connected) than in the remaining parts of the cushion 106. This is advantageous in packaging applications in which an object to be packaged has a relatively heavy or protruding portion; the higher density
30 part 26 of the packaging cushion can be placed in contact with such heavy or protruding portion to provide extra support thereto.

The foregoing description of preferred embodiments of the invention has been presented for purposes of illustration and description. It is not intended to be exhaustive or to limit the invention to the precise form disclosed, and modifications and variations are possible in light of the above teachings or may
5 be acquired from practice of the invention.

WHAT IS CLAIMED IS:

1. A method for producing packaging cushioning, comprising:
 - a. successively feeding sheets of a substrate at a first speed to a
5 crumpling mechanism;
 - b. crumpling said sheets in said crumpling mechanism, said crumpling mechanism crumpling said sheets at a second speed to convert said sheets into packaging cushion units; and
 - c. controlling at least one of said first and second speeds to
10 produce a desired degree of overlap between successive sheets, thereby generating a connected series of said packaging cushion units, wherein said connected series of packaging cushion units has a density that is proportional to said degree of overlap between successive sheets.
- 15 2. The method of claim 1, wherein:
said first speed is greater than said second speed; and
said degree of overlap between any two successive sheets ranges from greater than 0% to less than 100%.
- 20 3. The method of claim 1, wherein said packaging cushion units are connected such that each packaging cushion unit is slidingly separable from an adjacent packaging cushion unit.
4. The method of claim 1, wherein said packaging cushion units are
25 connected together via a friction fit, which is produced by said crumpling of said sheets at said overlap between successive sheets.
5. The method of claim 1, wherein:
each packaging cushion unit comprises a pair of end regions bounding
30 a central region;
said end regions correspond to said overlap between successive sheets; and

said crumpling mechanism crimps the end regions of adjacent cushion units together, thereby connecting said packaging cushion units together.

6. The method of claim 3, further including the step of separating two of
5 said packaging cushion units from one another to thereby remove a packaging cushion from said connected series of packaging cushion units, wherein said packaging cushion comprises a desired number of connected packaging cushion units.

10 7. The method of claim 6, wherein:
said packaging cushion comprises two or more packaging cushion units; and
the density of said packaging cushion varies along a length dimension thereof.

15 8. The method of claim 1, wherein:
said sheets have a length dimension and a width dimension; and
said method further includes the step of reducing the width dimension of the sheets.

20 9. The method of claim 8, wherein said width reduction step occurs prior to said crumpling step.

10. The method of claim 9, wherein:
25 said width reduction is effected by directing said sheets through a convergence device; and
said step of successively feeding sheets into said crumpling mechanism includes pushing said sheets through said convergence device and into said crumpling mechanism.

30

11. The method of claim 1, wherein:

said sheets are fed from a supply of sheets in a first direction and crumpled in a second direction; and

said first direction is different from said second direction.

5

12. The method of claim 11, wherein said supply of sheets is positioned beneath said crumpling mechanism.

13. A machine for producing packaging cushioning, comprising:

10 a. a feed mechanism for successively feeding sheets of a substrate at a first speed;

b. a crumpling mechanism for receiving said sheets from said feed mechanism and crumpling said sheets at a second speed to convert said sheets into packaging cushion units; and

15 c. a controller for controlling at least one of said first and second speeds to produce a desired degree of overlap between successive sheets, thereby generating a connected series of said packaging cushion units, wherein said connected series of packaging cushion units has a density that is proportional to said degree of overlap between successive sheets.

20

14. The machine of claim 13, wherein said feed mechanism comprises:

a. a first feed roller to advance the sheets from a supply thereof; and

25 b. a second feed roller to receive the sheets from said first feed roller and feed the sheets into said crumpling mechanism.

15. The machine of claim 13, wherein said crumpling mechanism comprises a pair of compression members that convert the sheets into packaging cushion units by compressing the sheets therebetween.

30

16. The machine of claim 13, wherein said crumpling mechanism comprises a pair of compression members that connect said packaging

cushion units together by crumpling said sheets at said overlap between successive sheets.

17. The machine of claim 13, wherein:

5 said sheets have a length dimension and a width dimension; and
 said machine further includes a convergence device, at least part of which is positioned between said feed mechanism and said crumpling mechanism for reducing the width dimension of the sheets.

10 18. The machine of claim 17, wherein:

 said sheets have a pair of opposed lateral sides;
 said convergence device causes said lateral sides to converge towards one another; and
 said crumpling mechanism crimps said converged lateral sides.

15 19. The machine of claim 18, wherein:

 each packaging cushion unit comprises a pair of end regions bounding a central region;

 said end regions correspond to said overlap between successive

20 sheets;

 said convergence device causes said lateral sides to converge towards one another within said end regions;

and

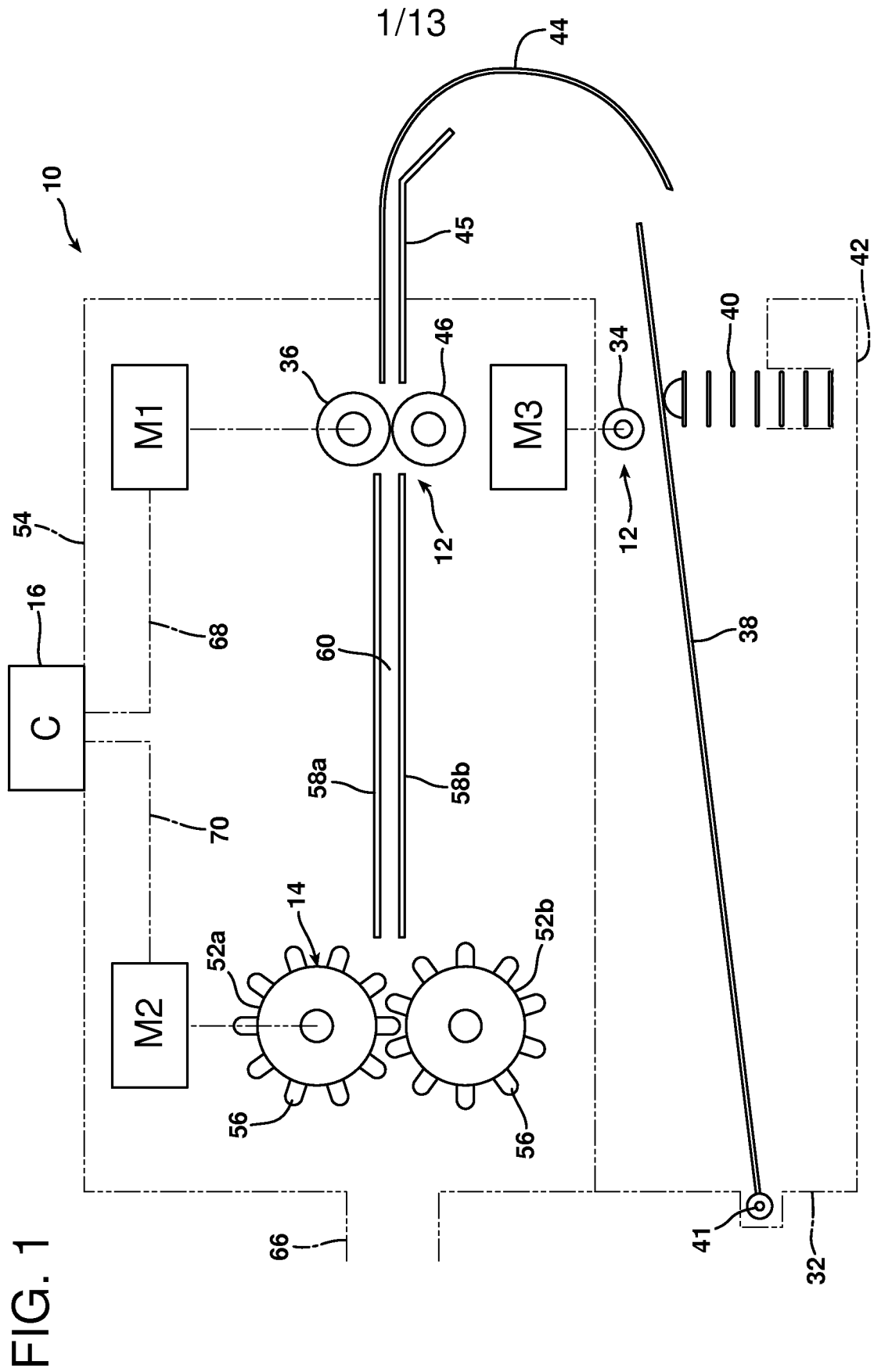
 said crumpling mechanism crimps the end regions of adjacent cushion
25 units together, thereby connecting said packaging cushion units together.

20. The machine of claim 13, further including a supply tray configured and dimensioned for holding the sheets arranged as a stack, wherein:

 said feed mechanism is disposed and configured for feeding the sheets
30 from said supply tray to said crumpling mechanism; and

 said supply tray is positioned beneath said crumpling mechanism.

21. The machine of claim 13, wherein:
- said feed mechanism defines a path of travel along which the sheets move between a supply of the sheets and said crumpling mechanism; and
- said feed mechanism further includes a guide member to change the
- 5 movement of the sheets on said travel path from a first direction, in which said sheets are fed from said supply, to a second direction, in which said sheets are crumpled.



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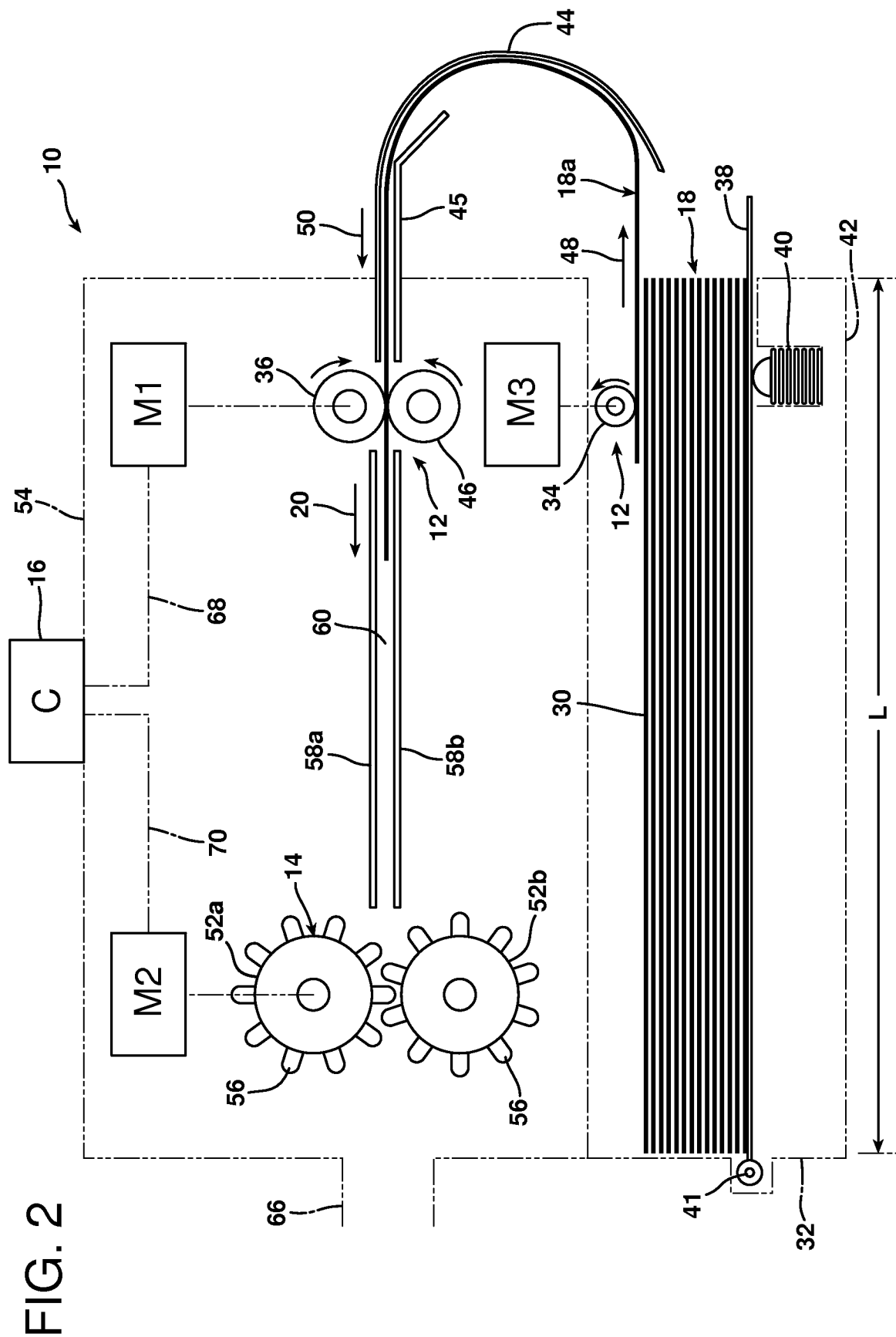


FIG. 3

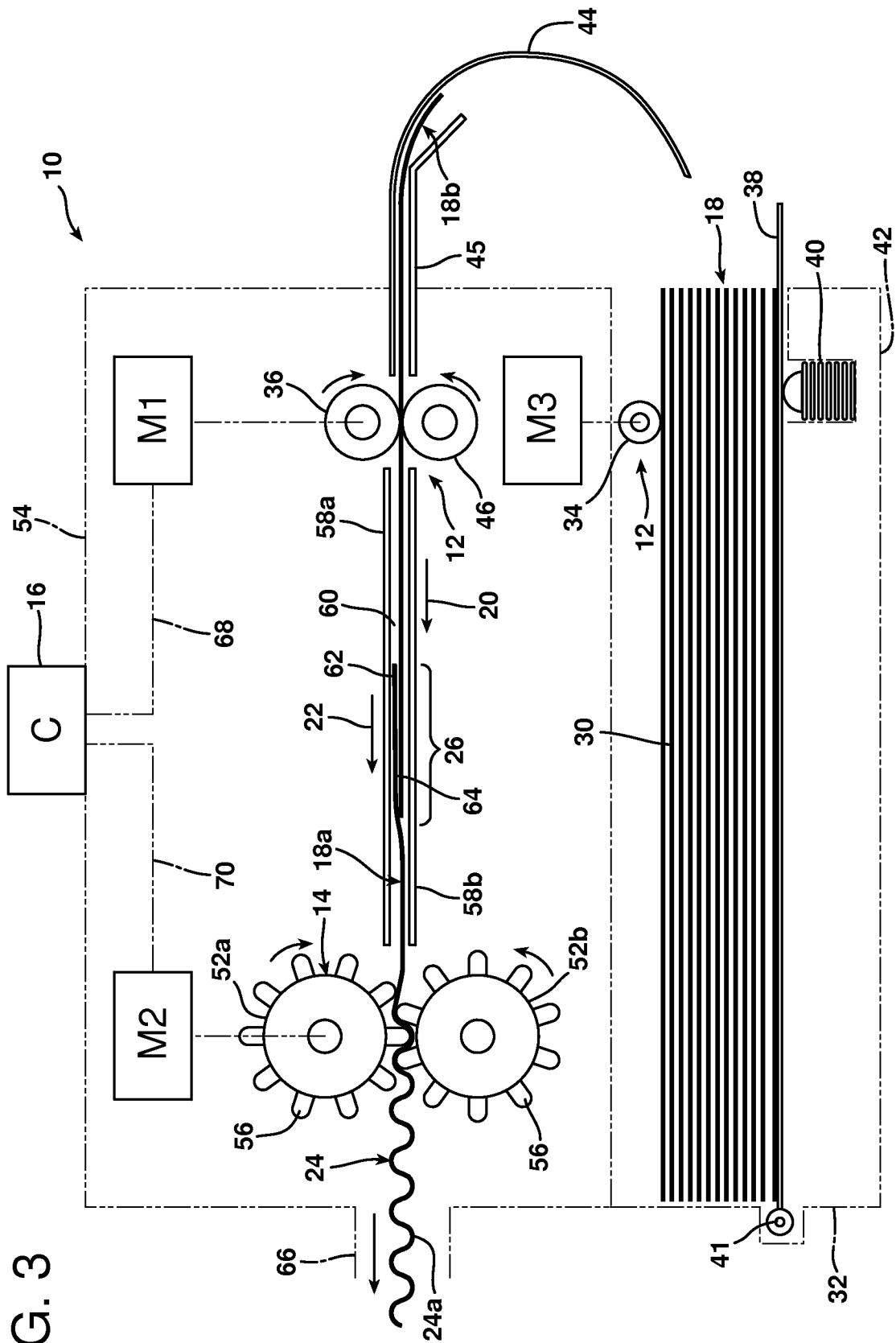


FIG. 4

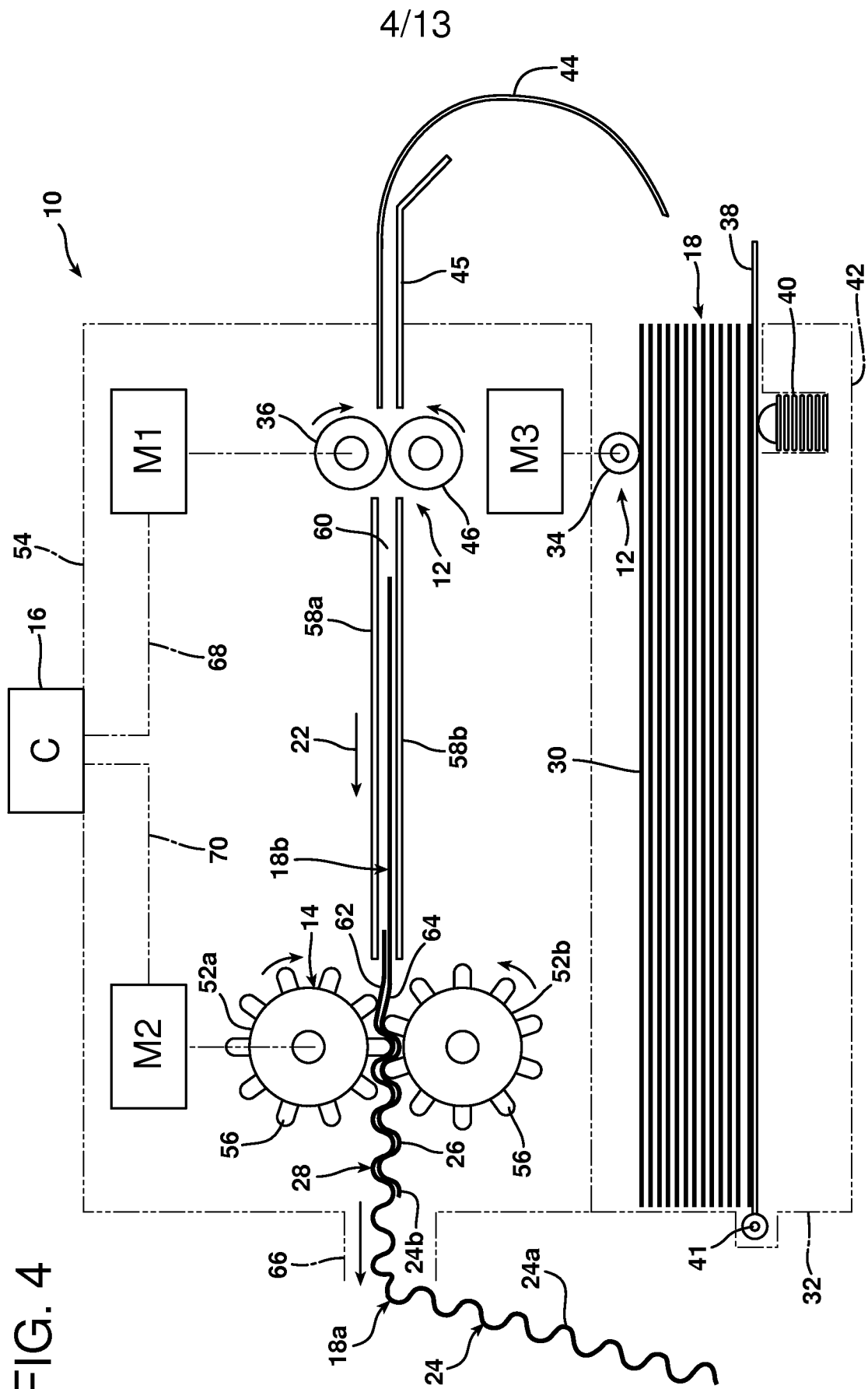
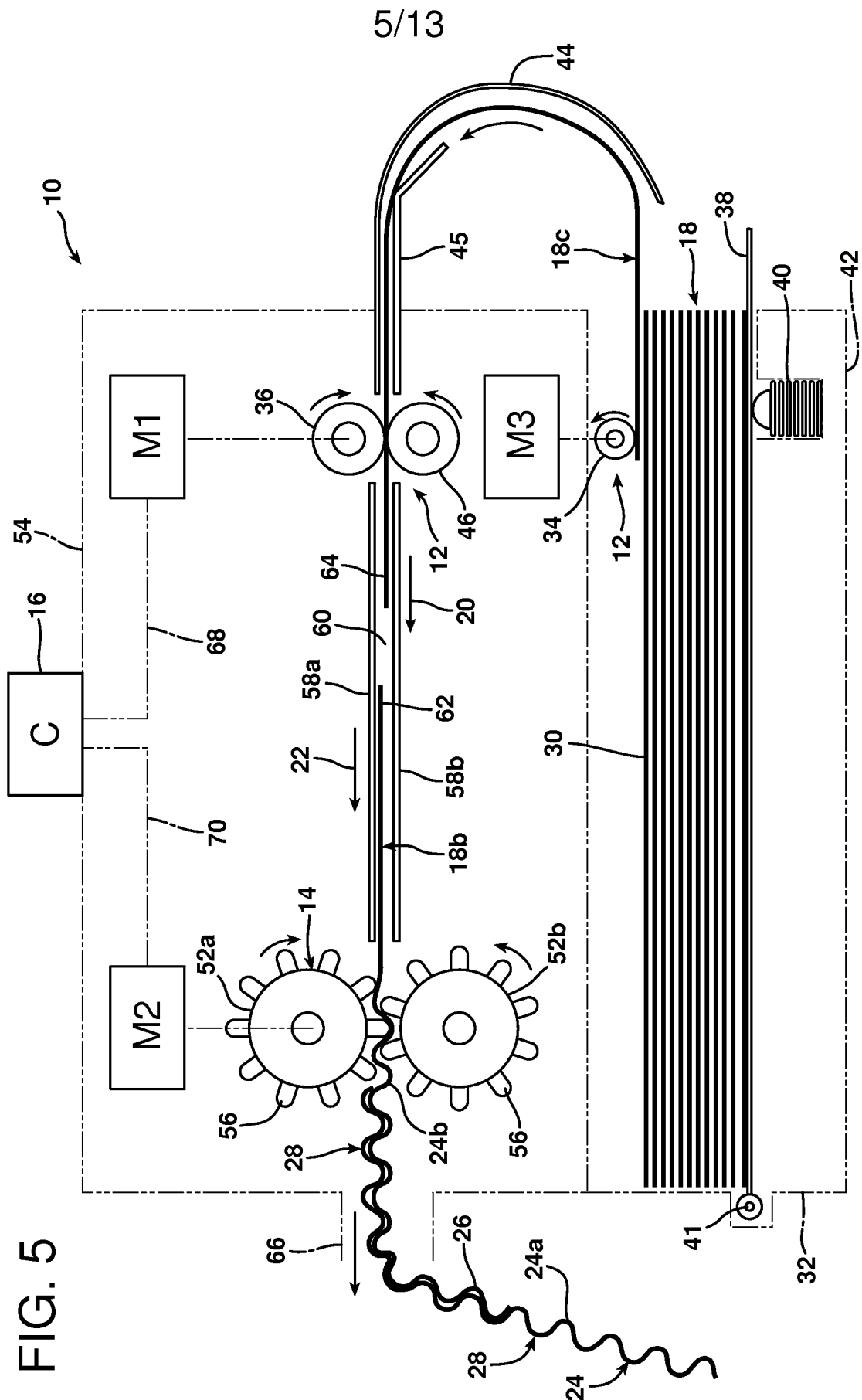
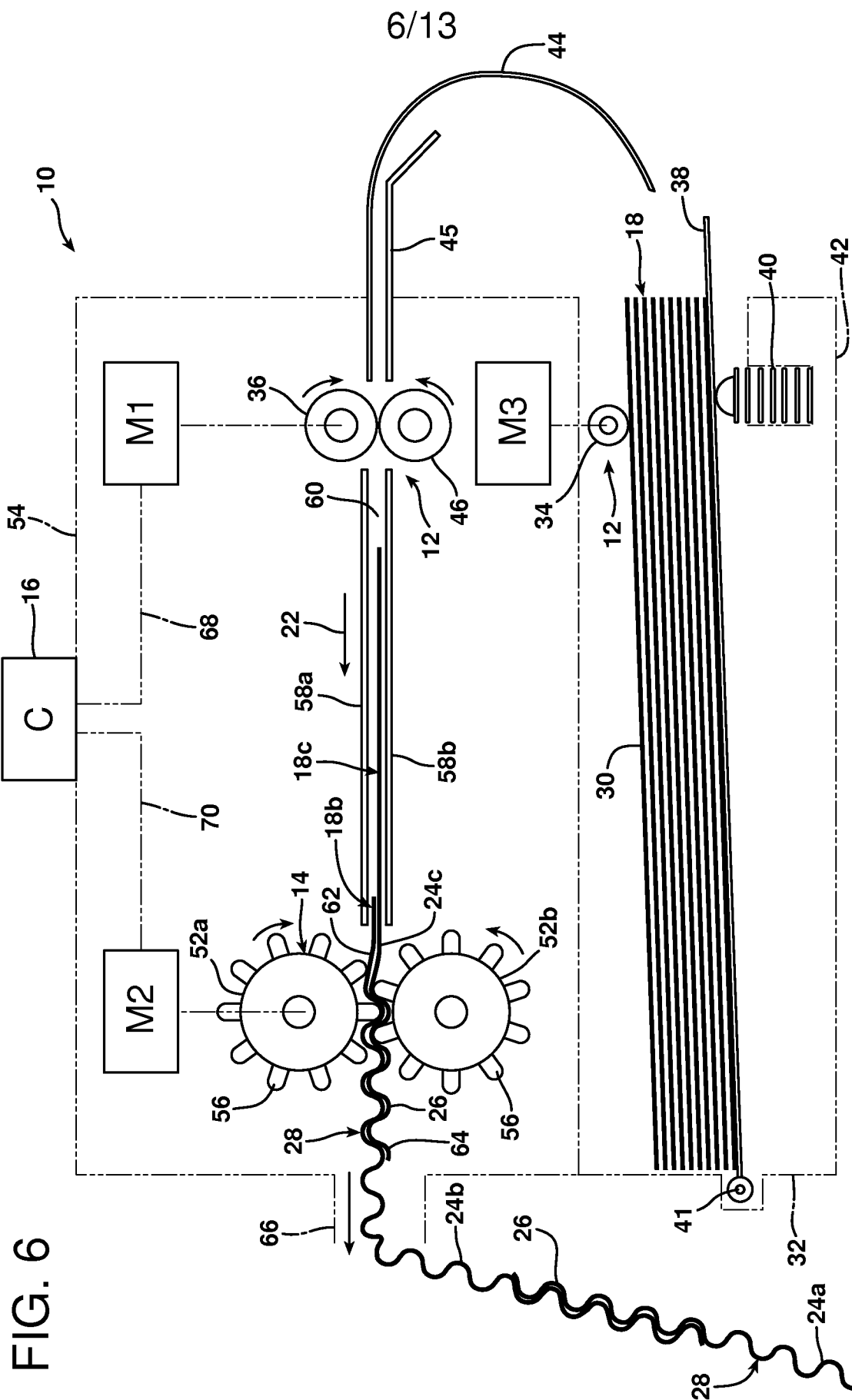


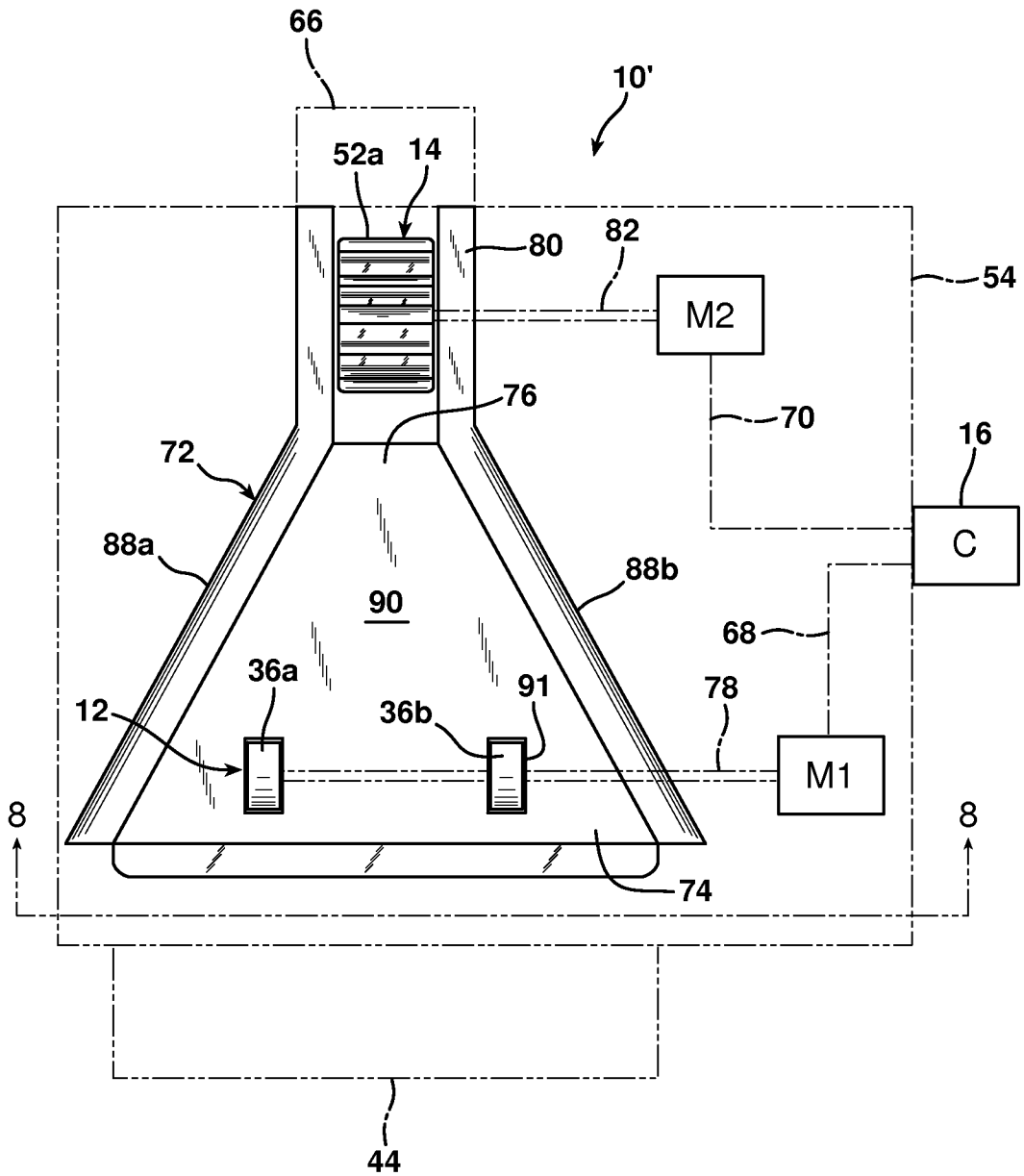
FIG. 5

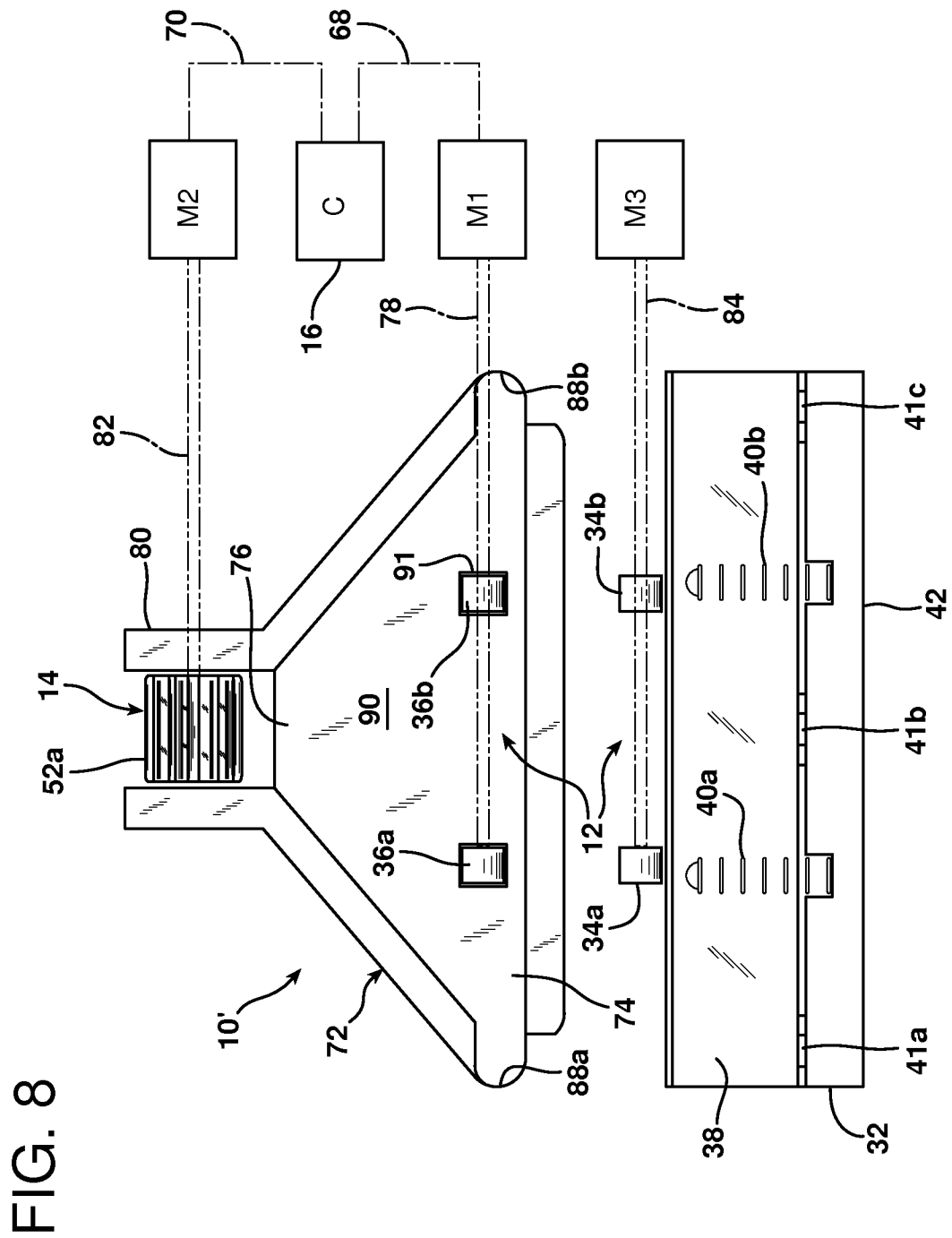




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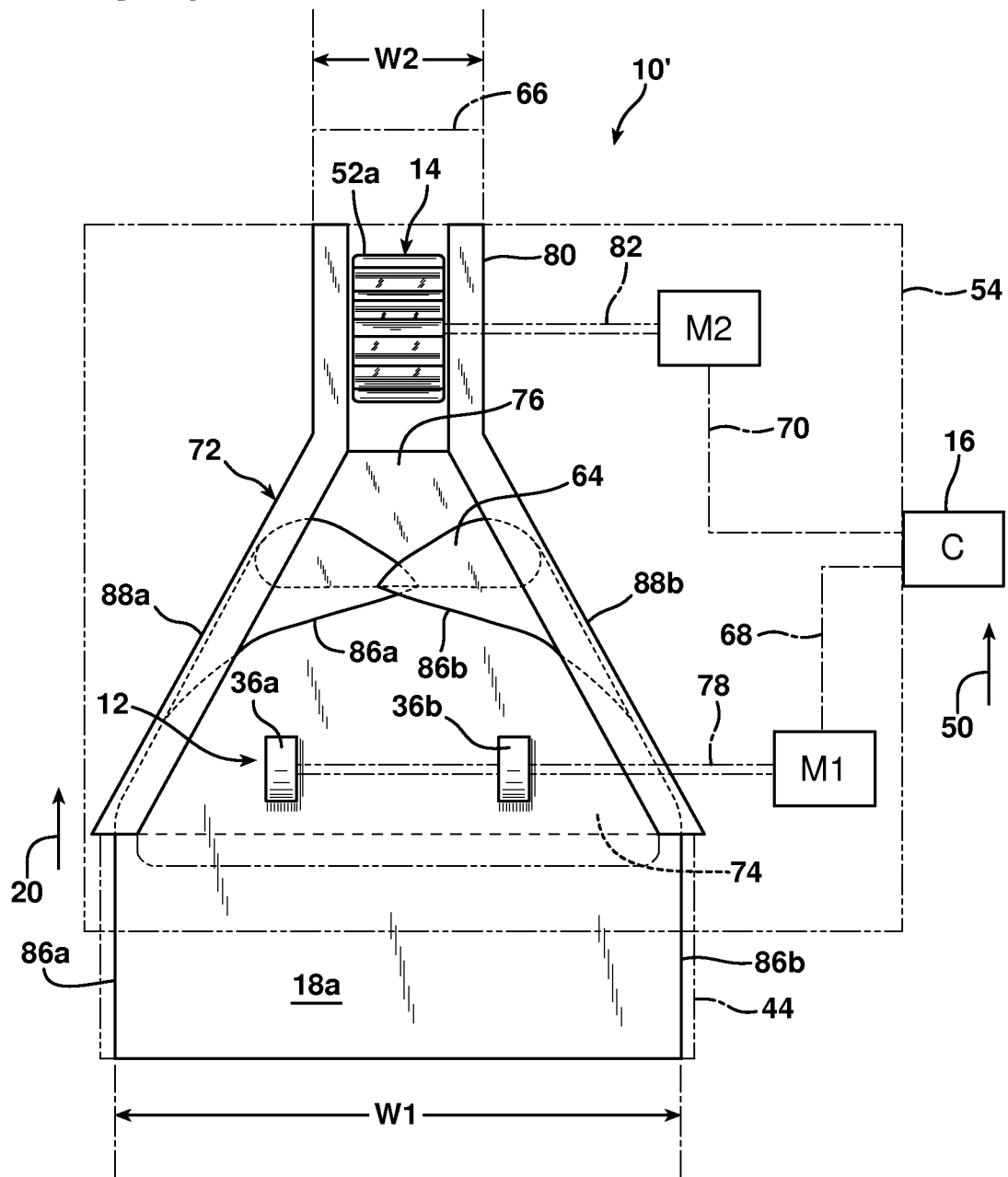
FIG. 7





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FIG. 9A



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FIG. 9B

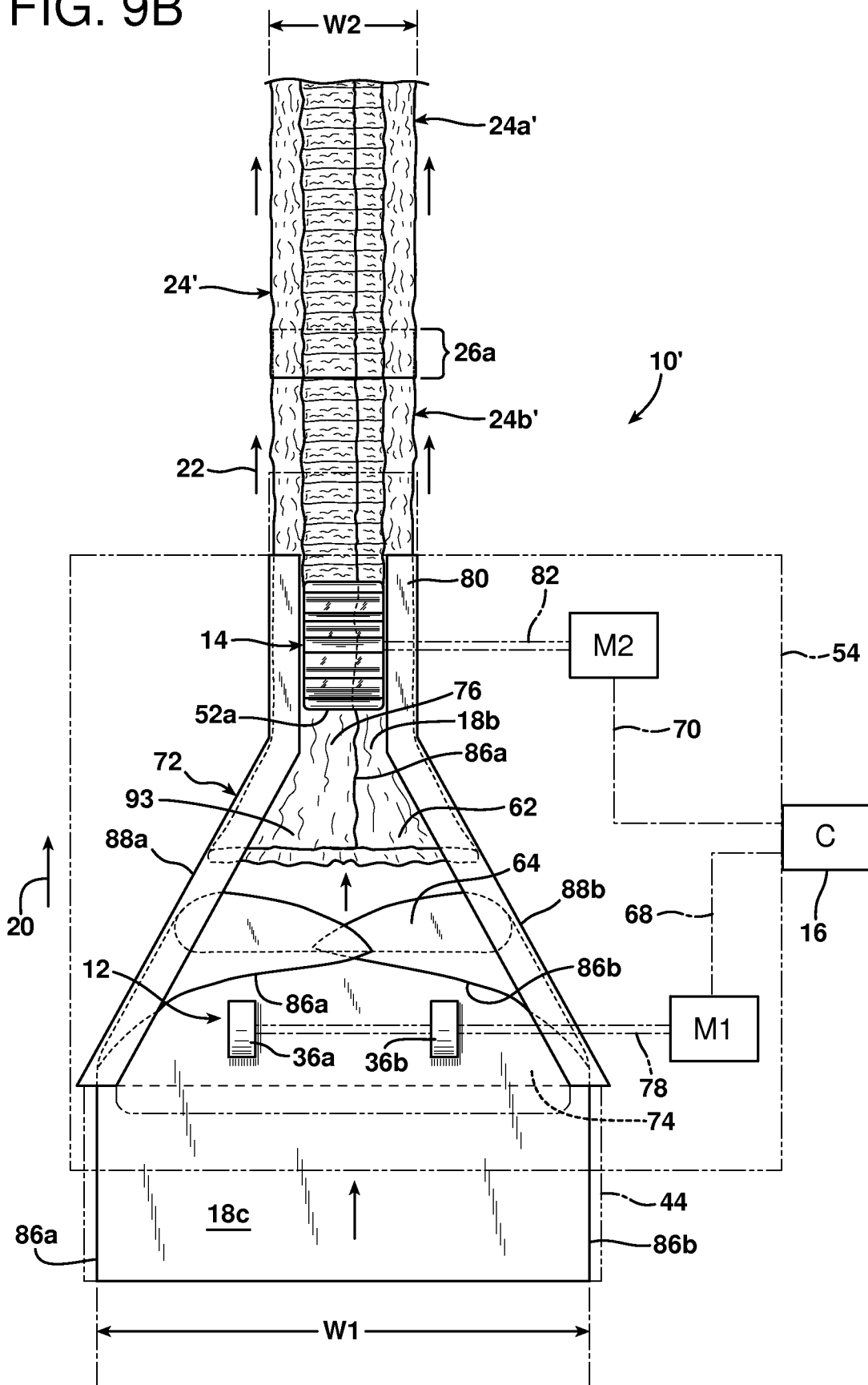


FIG. 10

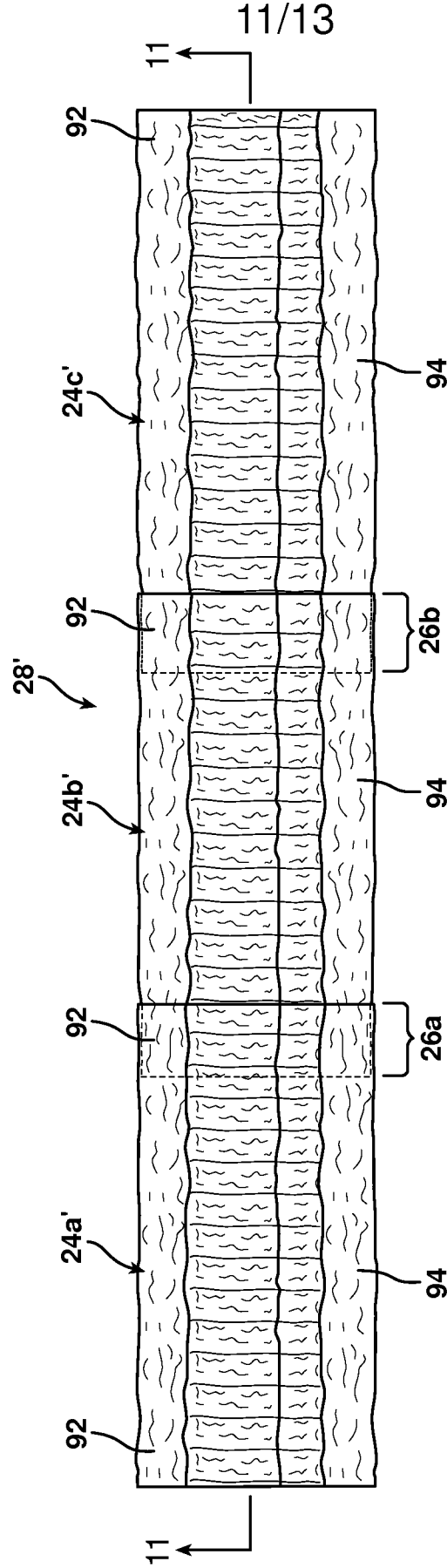


FIG. 11

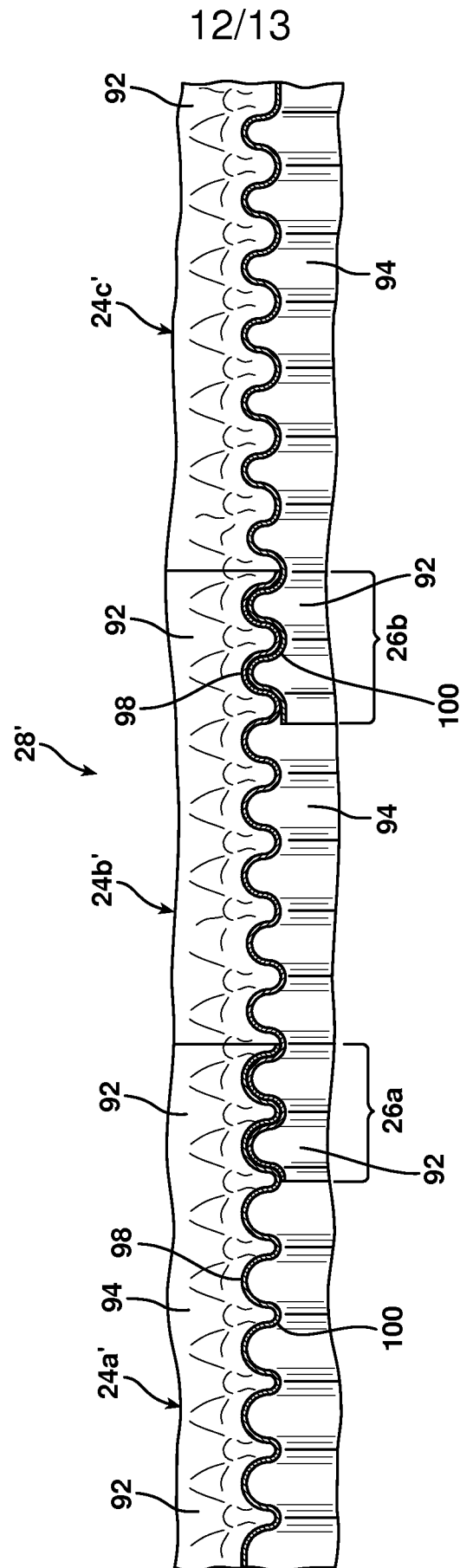
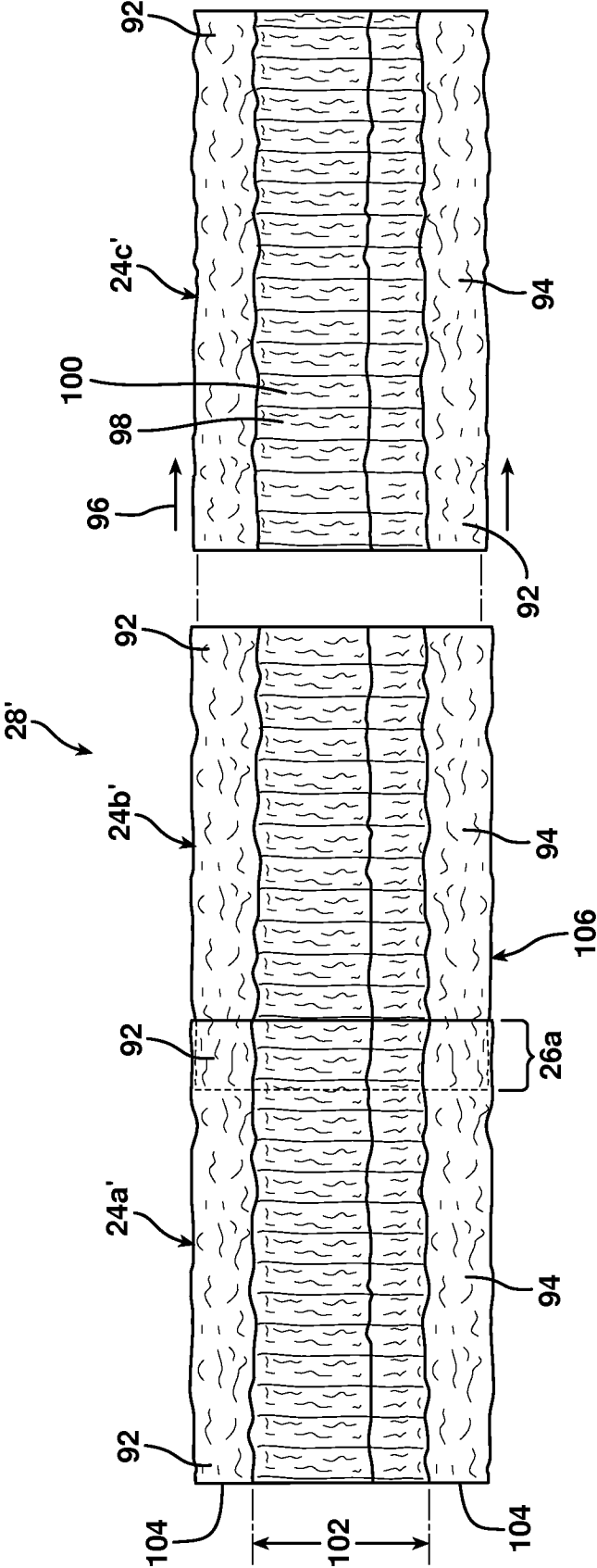


FIG. 12



INTERNATIONAL SEARCH REPORT

International application No

PCT/US2010/043359

A. CLASSIFICATION OF SUBJECT MATTER

INV. B31D5/00

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)

B31D B31F

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 practical, search terms used)

EPQ-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	EP 0 888 879 A1 (RANPAK CORP [US]) 7 January 1999 (1999-01-07) column 10, line 54 - column 11, line 19; figures 1-10	1,13
A	WO 2009/029882 A1 (PREGIS INNOVATIVE PACKAGING IN [US]; WETSCH THOMAS D [US]; TEGEL ROBER) 5 March 2009 (2009-03-05) paragraph [0038] - paragraph [0041]; figures 1-7	1,13
A	US 3 741 079 A (BOSSONS W ET AL) 26 June 1973 (1973-06-26) claim 1; figures 1-5	1,13
A	US 6 207 249 B1 (LENCOSKI MICHAEL J [US] ET AL) 27 March 2001 (2001-03-27) page 5, lines 19-32; figures 1-13	1,13



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

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Information on patent family members

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