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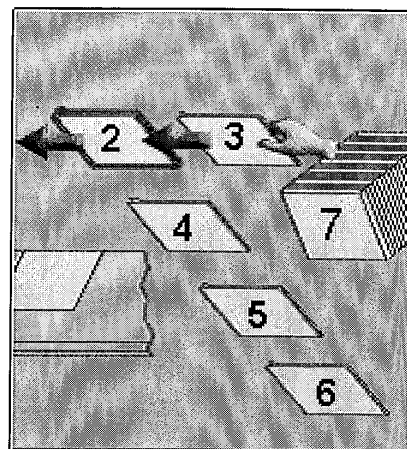
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(54) **A bookbinding machine with improved sequencing error identification**

(57) A method for identifying signatures in a bookbinding machine is proposed. The method includes the steps of: providing (404-418) a representation of each signature of a predetermined sequence to be repeatedly processed by the bookbinding machine, for each cycle of the bookbinding machine involving the processing of a current signature, acquiring (404-405) a digital image of the current signature, comparing (420-424) the digital

image of the current signature with the representation of an expected signature in the sequence, in response to a negative result of the comparison of the digital image of the current signature, comparing (448-458) the digital image of the current signature with the representation of at least one signature being adjacent to the expected signature in the sequence, and identifying (460) the current signature according to the results of the comparisons of the digital image of the current signature.

Numbers of expected signatures		Numbers of processed signatures	
$I_{e_2}$	5	5	$I_{p_2}$
$I_{e_1}$	4	4	$I_{p_1}$
$I_{e_0}$	3	2	$I_{p_0}$
$I_{e_{-1}}$	2	2	$I_{p_{-1}}$



**FIG.5a**

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EUROPEAN SEARCH REPORT

Application Number  
EP 05 10 2936

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
A	US 5 276 628 A (SCHNEIDERHAN EDWARD M [US]) 4 January 1994 (1994-01-04) * column 1, lines 44-57 * * column 3, lines 6-38 * * column 5, lines 3-22 * * column 7, lines 25-59 * * column 9, lines 37-53; figures 1,3,6a,6b *	1-10	INV. G06K9/00 B65H7/14 B42C1/12 B42C19/08
A	US 4 799 661 A (NAIL JAMES W [US]) 24 January 1989 (1989-01-24) * column 1, lines 7-10 * * column 2, lines 3-63; figures 1,5 * -----	1-10	
A	US 4 953 841 A (POLAREK KENNETH J [US]) 4 September 1990 (1990-09-04) * column 1, lines 24-37 * * column 2, lines 17-35 * * column 4, line 59 - column 5, line 9; claim 1; figures 1,2 * -----	1-10	
			TECHNICAL FIELDS SEARCHED (IPC)
			G06K B42C B65H
The present search report has been drawn up for all claims			
Place of search <b>Munich</b>		Date of completion of the search <b>26 November 2010</b>	Examiner <b>D'Incecco, Raimondo</b>
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ..... & : member of the same patent family, corresponding document	

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**ANNEX TO THE EUROPEAN SEARCH REPORT  
ON EUROPEAN PATENT APPLICATION NO.**

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For more details about this annex : see Official Journal of the European Patent Office, No. 12/82