

May 27, 1941.

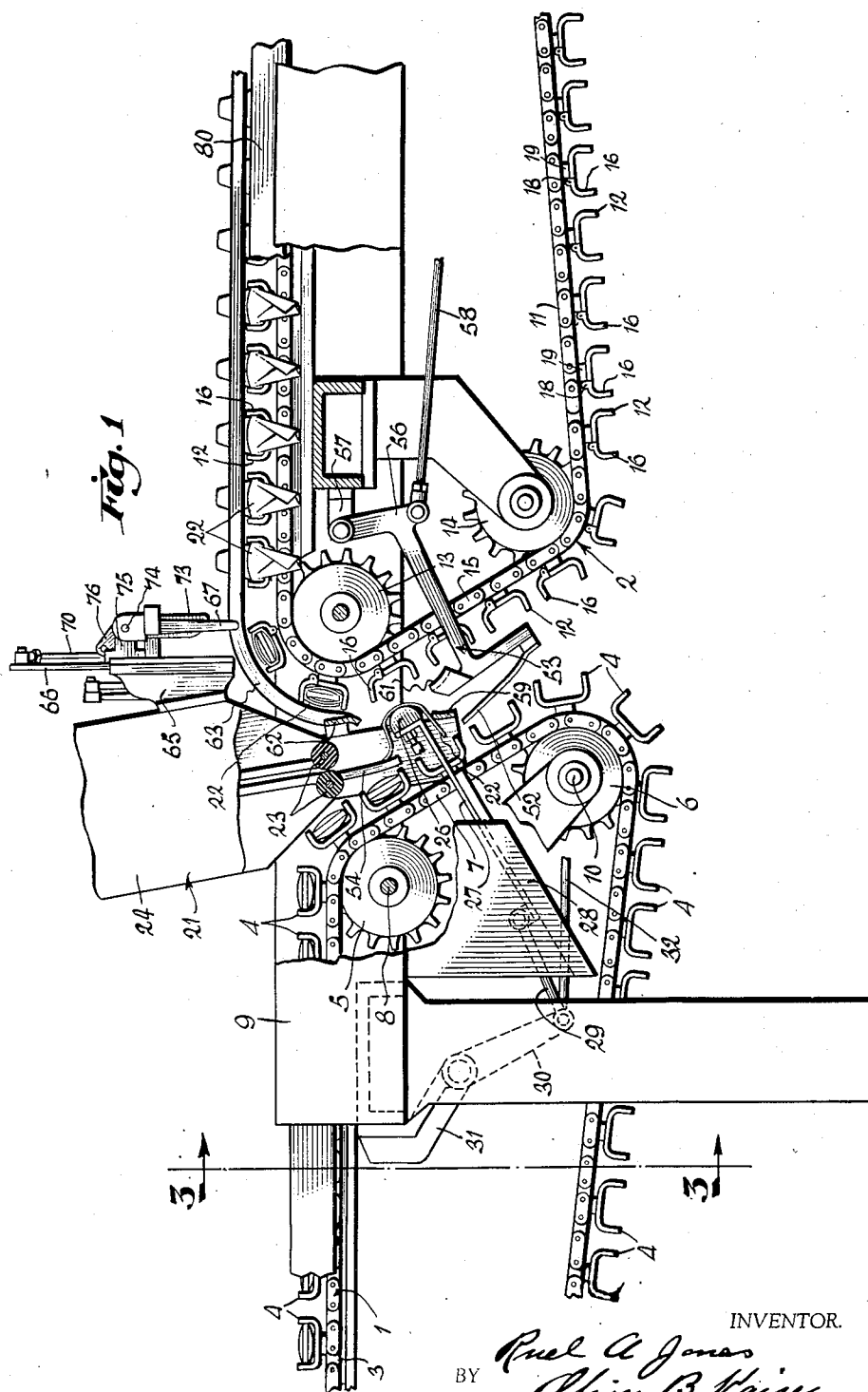
R. A. JONES

2,243,633

SOAP WRAPPING MACHINE

Filed March 8, 1940

6 Sheets-Sheet 1



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2,243,633

SOAP WRAPPING MACHINE

Filed March 8, 1940

6 Sheets-Sheet 2

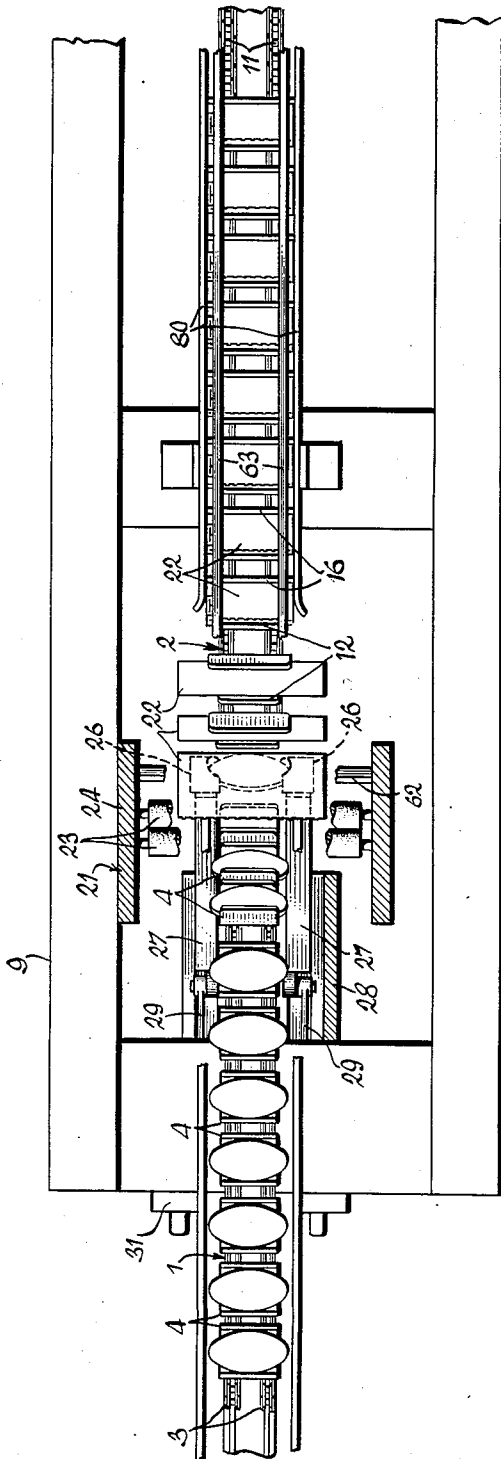


Fig. 2

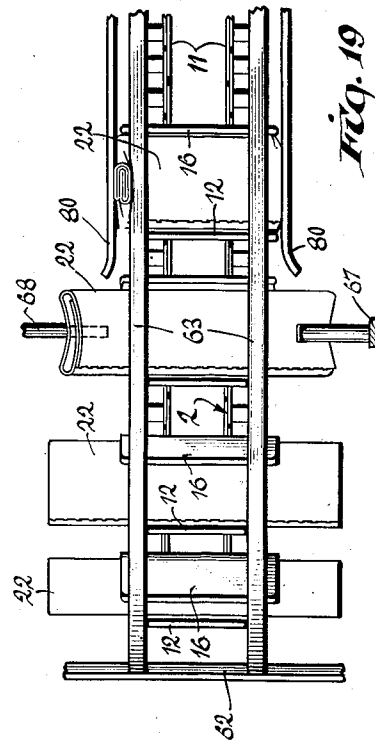


Fig. 19

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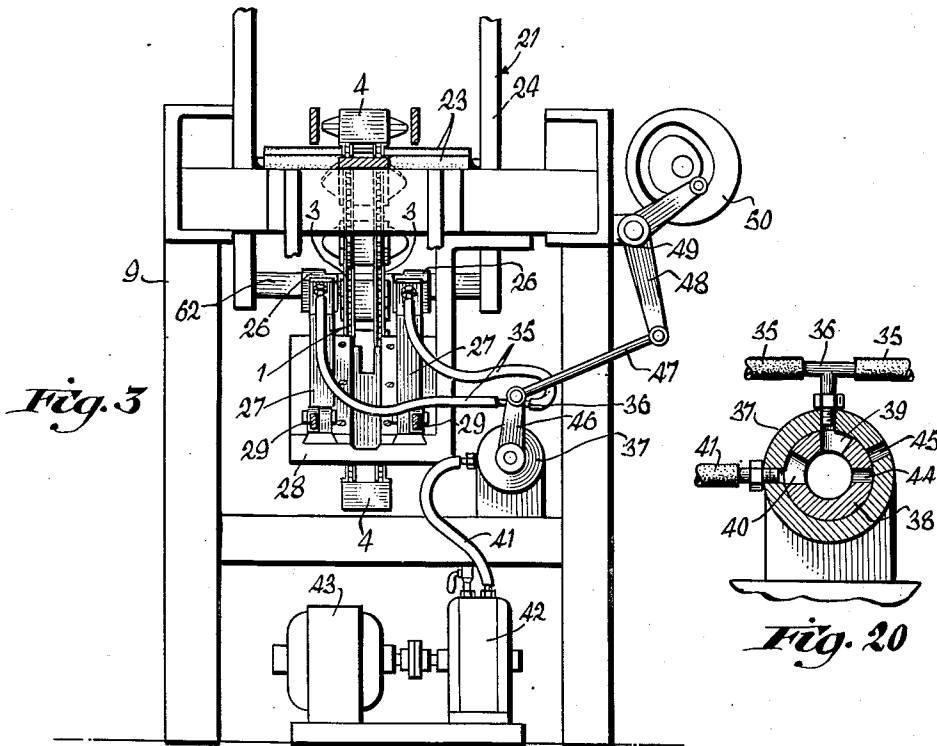
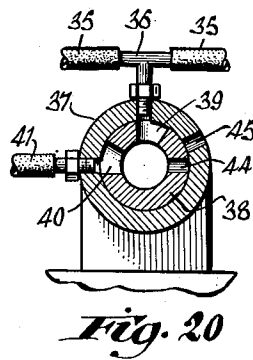
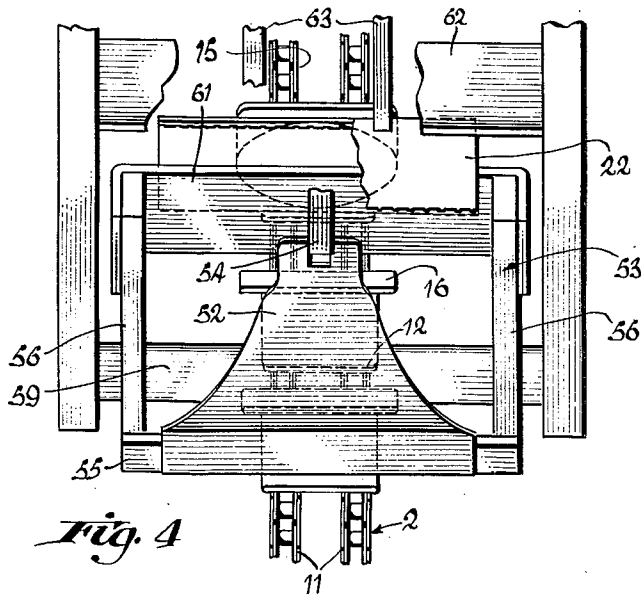
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SOAP WRAPPING MACHINE

Filed March 8, 1940

6 Sheets-Sheet 3



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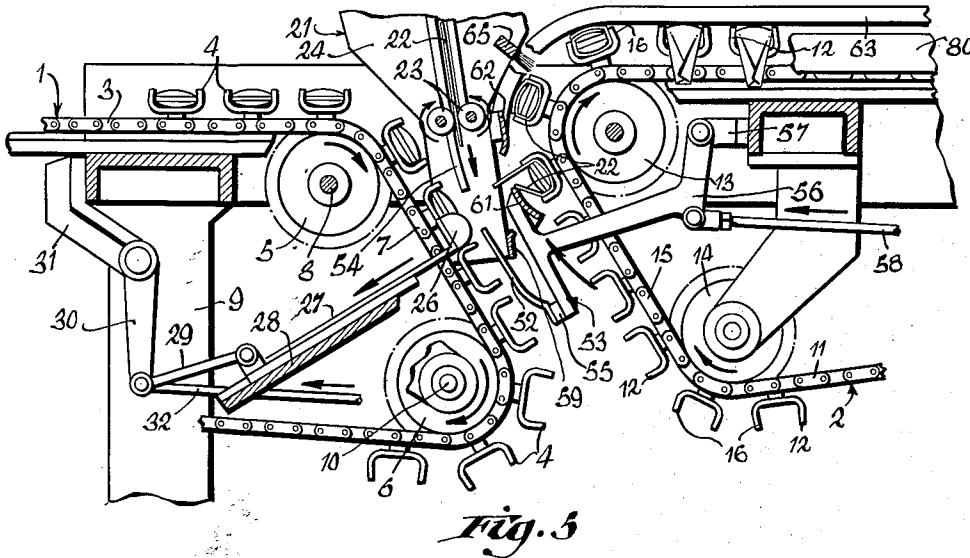
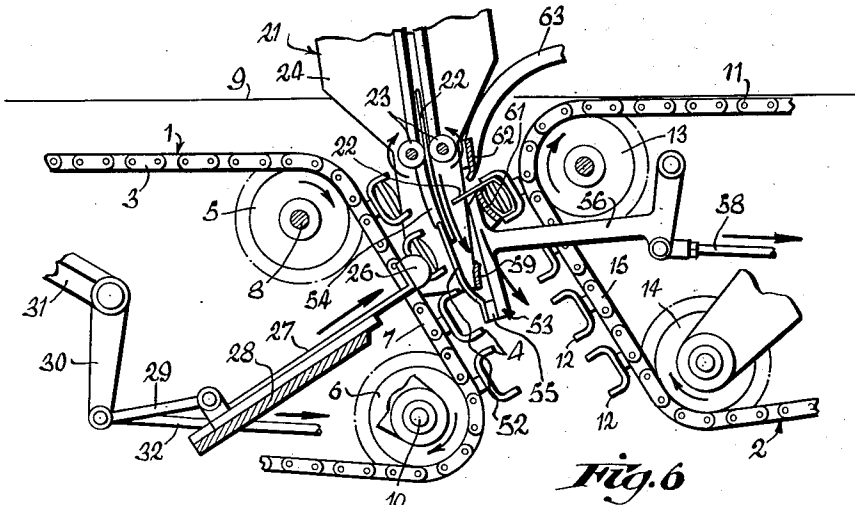
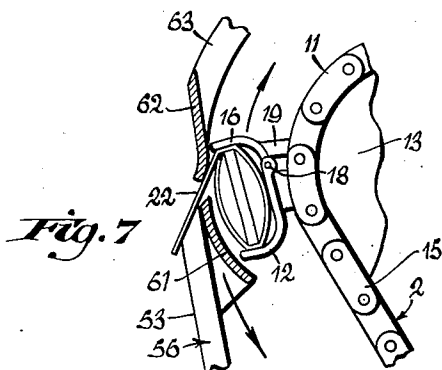
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SOAP WRAPPING MACHINE

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6 Sheets-Sheet 4



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SOAP WRAPPING MACHINE

Filed March 8, 1940

6 Sheets-Sheet 5

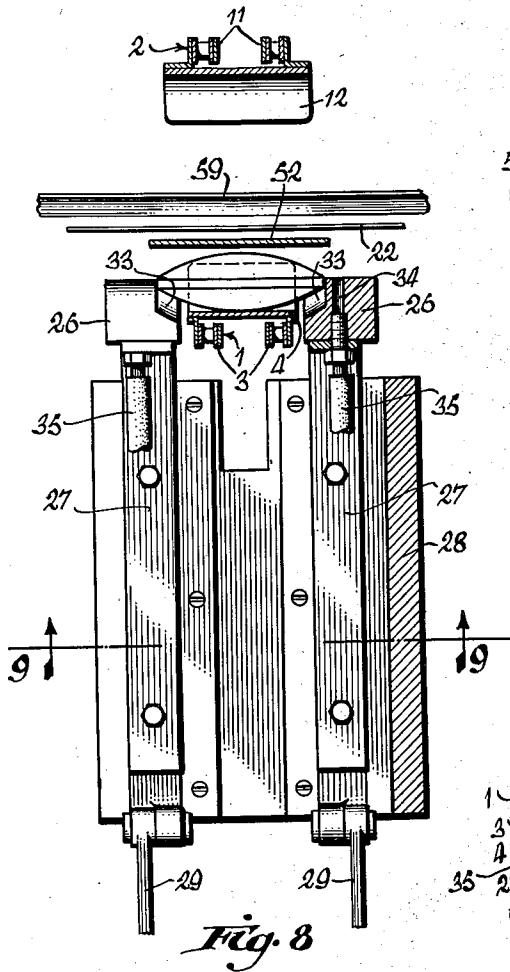


Fig. 8

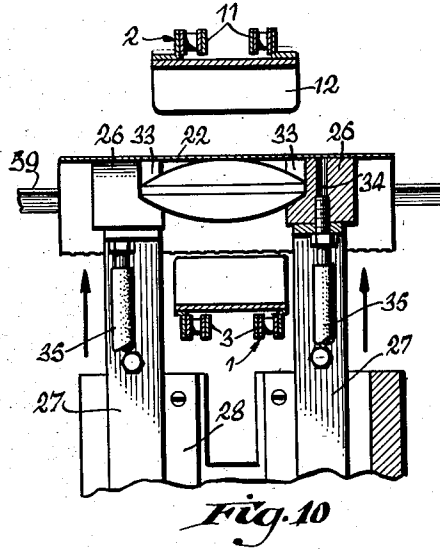


Fig. 10

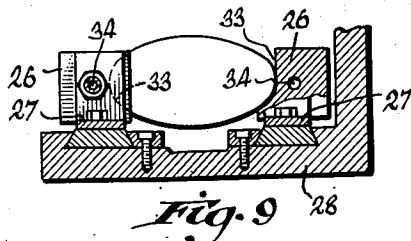


Fig. 9

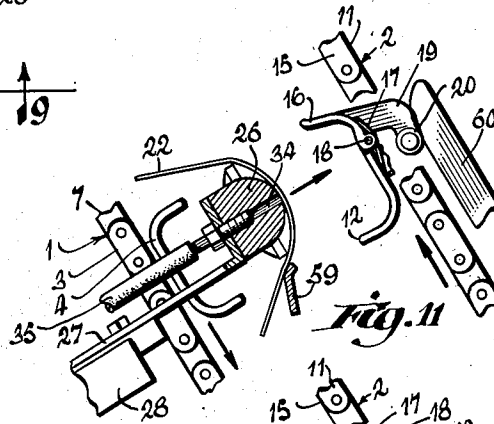


Fig. 11

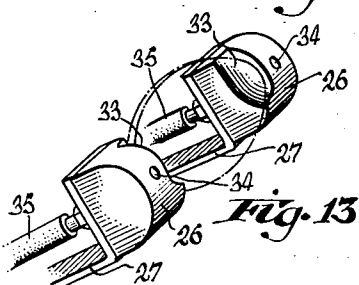


Fig. 13

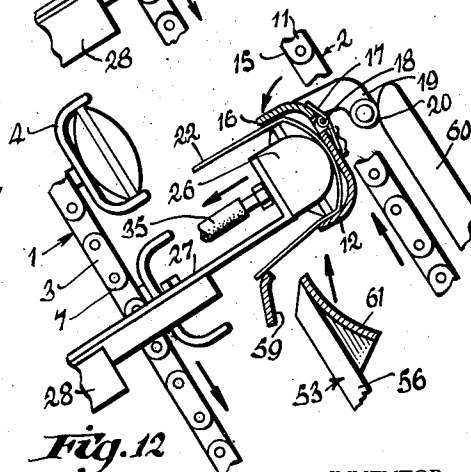


Fig. 12

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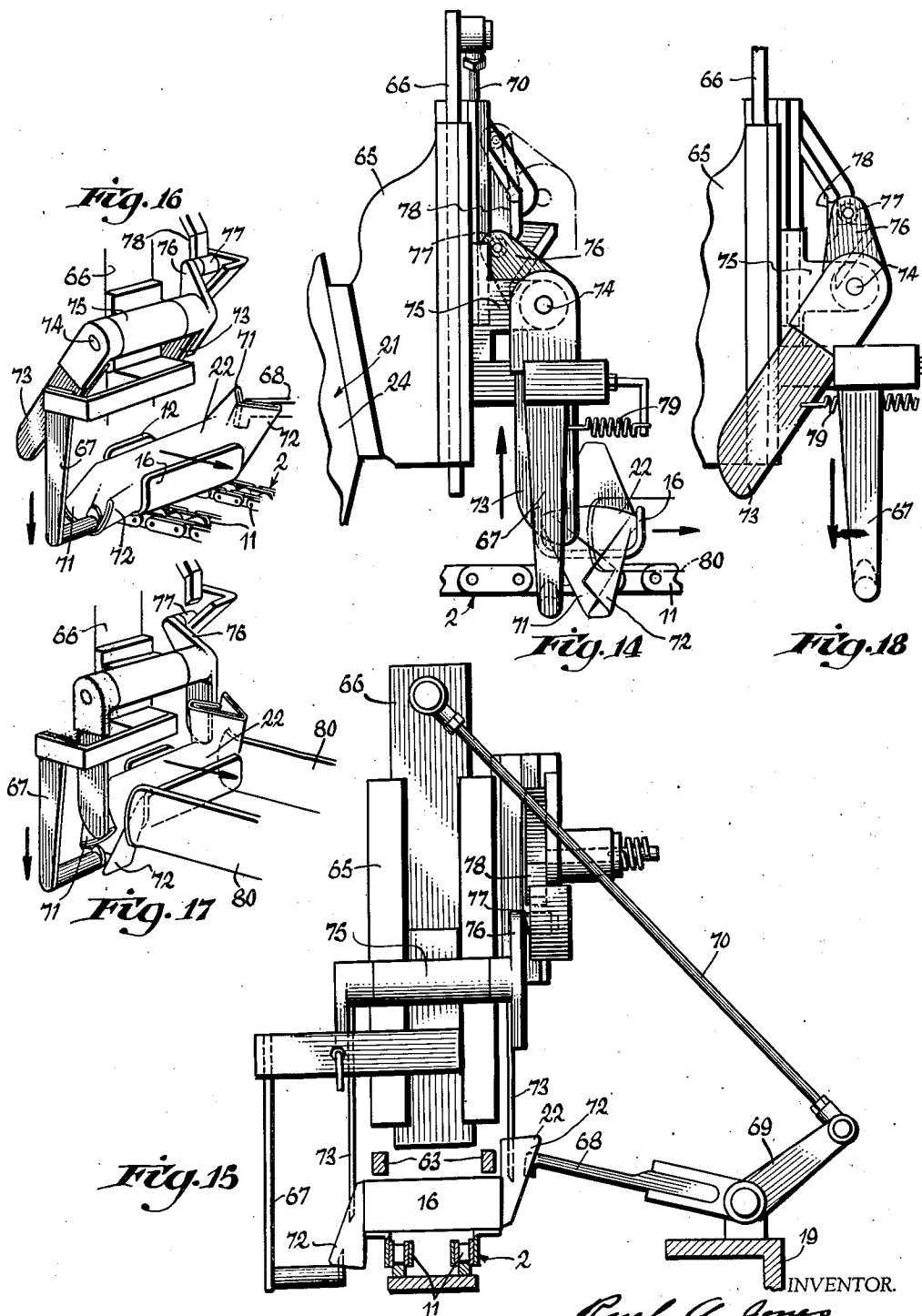
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SOAP WRAPPING MACHINE

Filed March 8, 1940

6 Sheets-Sheet 6



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UNITED STATES PATENT OFFICE

2,243,633

SOAP WRAPPING MACHINE

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Application March 8, 1940, Serial No. 322,967

6 Claims. (Cl. 93—2)

This invention relates to improved apparatus and method for wrapping soap cakes and other articles, enclosing a soap cake with a wrapping sheet.

An object of the invention is to provide for wrapping or enclosing a soap cake with a wrapping sheet while the cake is in transit or conveyed, as for example, during the continuous delivery of the cakes from a cake forming machine or press for packaging.

Another object of the invention is to provide for covering an elliptical shape cake, or shapes of cakes difficult to handle for mechanical wrapping, with a wrapping sheet during the continuous conveyance of the cake, and in which the application of the wrapping sheet is accomplished initially by the transfer of the cake from one conveyor to the second for intercepting a wrapping sheet, and bring the same about one face side of the cake, adapting the further folding operations, necessary for enclosing the cake, to be performed during the continuous travel of the cake without disturbance to its position on the carrier, thereby requiring but a minimum handling of the cake and in a manner which avoids any marring or injury to the cake surface.

It is another object of the invention to provide a simple and effective method for applying a wrapping sheet about a soap cake or other article during the continuous conveyance of the cakes, arranged in a consecutive order upon the conveyor, and with a minimum handling of the cake, and in a manner to avoid injury to the surface of a fresh soft cake.

Another object of the invention is to provide means applicable to the conveyor receiving end of a conventional carton loading machine for applying a wrapping sheet about a commodity, as a cake of soap, before packaging within a container.

Further objects and advantages of the invention will be more fully apparent from a description of the accompanying drawings, in which:

Figure 1 illustrates, in side elevation, a simplified embodiment of the invention, associated with a pair of endless conveyors.

Figure 2 is a top plan view thereof with the lower end of the sheet or web feeding mechanism shown in section, the feed rollers thereof in fragment to bring to view parts that would otherwise be hidden.

Figure 3 is a section on line 3—3, Figure 1.

Figure 4 is a front elevation of a movable web guide disposed within the spacing of the opposing ends of the soap conveyors at which the

soap cakes are transferred from one conveyor onto another, during which transfer period the cakes are wrapped.

Figures 5 and 6 are views similar to Figure 1, illustrating different operative stages.

Figure 7 is an enlarged end elevation of a section of the receiving conveyor, illustrating a cake of soap in a pocket of a conveyor and the final stage of enveloping the soap wrapper about the cake.

Figure 8 is a plan view of the soap handling plunger for transferring the cakes successively from the pockets of one conveyor into relative pockets of a second or receiving conveyor, the cake in the transfer intercepting a wrapper disposed between the conveyors.

Figure 9 is a section on line 9—9, Figure 8.

Figure 10 is a plan view of the forward end of the soap cake transfer plunger within the period of its forward stroke at the time of bringing a soap cake into contact with a wrapping sheet.

Figures 11 and 12 are detailed side elevations of the transfer plunger at different stages of operation.

Figure 13 is a perspective view of the forward end of the transfer plunger.

Figure 14 is an end elevation of the wrapper end folder.

Figure 15 is a front elevation thereof.

Figures 16 and 17 are perspective views of the wrapper end folder at different operative stages.

Figure 18 is a detailed end view similar to Figure 14, illustrating the moving parts at the commencement of the wrapper end folding cycle.

Figure 19 is a top plan view of the forward end of the soap cake receiving conveyor.

Figure 20 is a central vertical section of a suction or pneumatic control valve for the suckers carried by the soap transfer plunger.

The invention in the preferred embodiment is incorporated in or may be referred to as an addition to a carton loading machine employed for packaging soap cakes, or other commodities, each in an individual carton, so as to enclose or envelop each cake with a wrapping sheet before insertion into the carton. The carton loading machine is provided with an endless conveyor having definitely spaced pockets for carrying and advancing the cakes in a consecutive order, and thereby move alongside respectively in registry with the correspondingly advancing cartons for inserting each cake into a carton.

The mechanism for applying the wrapping sheet about the soap cakes is interposed between

and cooperates with a pair of endless conveyors arranged in tandem, the application of the wrapper being effected during the transfer of the cake from one conveyor to another. Therefore, one conveyor may be representative of the soap cake advancing conveyor of a carton loading machine, and the second as auxiliary thereto or a separated extension thereof, both moving in synchronism and advancing the cakes carried thereby in the same general direction. The conveyors also may be parts of a transporting system. Therefore, for the present purposes, sections of the adjoining ends of a pair of endless conveyors only, are illustrated.

Referring to the drawings, 1 indicates an endless chain conveyor of which only the delivery end is shown. The conveyor 1 adjoins in tandem a second conveyor 2, of which only the receiving end is shown. The conveyor 1 may be designated as an auxiliary or extension of the conveyor 2, both conveyors travelling in synchronism for transporting in the same general directions the articles carried thereby.

The conveyor 1 preferably is composed of a pair of spaced sprocket chains 3, 3, connected transversely by channel formed holders 4, providing open-ended pockets uniformly spaced apart, each for the reception of a cake of soap or other commodity. The sprocket chains for the delivery end of the conveyor respectively are engaged over a pair of idler sprocket wheels 5, 6, disposed at different elevations and relatively offset for effecting a section 7 of chain travel in an incline direction in the return loop of the conveyor.

The chains for the forward or receiving end of the conveyor, each is respectively engaged over a sprocket wheel which may constitute a driver for the conveyor, or either of the sprocket wheels 5, 6, may serve as a driver. The sprocket wheels 5 for the chains are fixed upon a shaft 8 to rotate as a unit, and the shaft is suitably journaled in bearings fixed to the machine frame 9. Likewise, the sprocket wheels 6 are fixed upon a shaft 10 to rotate as a unit, and the shaft is suitably journaled in bearings in the machine frame.

The conveyor 2, similar to the conveyor 1, is composed of a pair of spaced chains 11, 11, connected transversely by channel form of holders 12, providing open ended pockets uniformly spaced apart, each for the reception of a cake of soap or other commodity. The sprocket chains 11, 11, for the receiving end of the conveyor, respectively, are engaged over a pair of idler sprocket wheels 13, 14, disposed at different elevations and relatively offset for effecting a section or zone 15 of chain travel in an inclined direction in the return loop of the conveyor. The incline section 15 of the conveyor travel is in parallelism with the corresponding travel section 7 of the conveyor 1. The holders of both conveyors during the incline and parallel period of their travel respectively move in relative registry with the open side of the pockets of registering holders relatively opposing to permit a soap cake to be transferred from a holder of one conveyor into a registering holder of the second conveyor.

The holders 12 preferably are of two-part or sectional form, the sections hingedly connected, one fixed to the chains and the second section 16 hingedly connected to the first so as to adapt the same to be swung to an open position for widening the pocket space sufficiently to receive a cake of soap, and when released exert a

gripping pressure upon the cake for holding the same in the pocket. The hinge section 16 is preferably urged and held in its closed or normal position by a spring 17 engaged about a pivot rod or fulcrum 18, hingedly connecting the two sections of the holder, see Figures 11, 12. The hinge section 16 at its rear side has an arm 19 of angle shape projecting therefrom and at its free end journalling a roller 20 for engagement with a control rail to positively swing the hinged section to its open position and control its open period.

A sheet feeding apparatus 21 of conventional construction, suitably mounted to the machine frame above the conveyors, is employed for feeding a wrapper sheet designated as 22 into the spacing between the opposing ends of the conveyors 1 and 2. The sheet is fed in a plane and at a rate to be appropriately positioned for medial engagement with a cake of soap as the cake is transferred from a pocket of one conveyor into an aligned pocket of a second conveyor; the action in the transfer of the cake partially enveloping the wrapping sheet about the cake.

As the structure of the sheet feeding mechanism is separate and apart from the present invention, it may be of any type to appropriately deliver a sheet to be acted upon in a transfer of the cakes from one conveyor to the other. The mechanism in detail for the present purposes comprises a pair of co-acting rolls 23, 23, to impinge and advance the sheet interposed therebetween with the rotation of the rolls. The sheet supply may be either in packet form, or in a continuous web, reel wound and housed within the magazine 24. The sheets from the continuous web may be separated by a cutter, or readily detachable along weakened or tear lines. Each sheet as delivered by the feed rolls 23, 23, is guided by a guard to insure its proper presentation to the cake of soap to which it is to be applied.

The soap cakes, as illustrated, are of oval contour, a design of cake which has heretofore been difficult to mechanically wrap with a wrapping sheet. The length of the holders are of a dimension to permit the opposite ends of the soap cake to extend slightly therebeyond for engagement by and between a pair of spaced jaws 26, 26. The jaws 26, 26, each is respectively fixed to the forward end of a reciprocating slide 27 slidably mounted within a stationary guide plate 28 rigidly fixed to the machine frame. The guides preferably are of dovetailed form in cross section, and the slide therefore is gibbed therein.

The slide is disposed at right angles to the inclined traveling sections of the conveyors and reciprocates transversely thereto to withdraw a cake from a pocket or holder of one conveyor, and transfer the same into a pocket or holder of the second conveyor with each forward stroke of the slide. The slides are reciprocated in unison, and each at its rear end is pivotally connected to one end of a link 29. The opposite end of the link 29 is pivotally connected to one end of a hanger link 30, the opposite end of the hanger link being pivotally connected to a bracket 31 fixed to the machine frame. The connected ends of the link 29 and hanger link 30 are pivotally connected with one end of a connecting rod 32 to be transmitted by suitable power driven means as a crank.

The inner ends of the jaws 26, 26, are preferably each provided with a recess or socket 33 to

seat the opposite ends of the cake within the jaw and sustain the cake without pressure in its flight from one conveyor to a second. The forward side of each of the jaws 26 has an aperture 34 in communication with a tube 35 carrying a fitting for securing the tube to the jaw. The tube 35 for each jaw connects with a manifold 36 attached to a valve casing 37, and the suction pressure is controlled by a valve 38 oscillated within the valve casing.

The valve, as shown in Figures 3 and 20, is of sleeve type having a port 39 for communication with the manifold 36, a port 40 for communication with the tube 41 connecting with a suction pump 42 of rotary type in direct connection with an electric motor 43. The valve has a third port 44 for communication with a vent duct 45 extending through the valve casing, and open to the atmosphere. The valve is actuated at proper timed intervals by a lever arm 46, at one end fixed to the axis of a sleeve valve, and its opposite end pivotally connected to a link 47. The link 47 in turn pivotally connects with a bell-crank lever 48 pivotally supported upon a bracket 49 fixed to the machine frame. The bell-crank lever 48 engages with a cam 50 fixed upon a shaft, suitably journaled to the machine frame. The suction pressure is timed and controlled to hold a wrapping sheet 22 to the jaws against displacement during the transfer of the cake from one conveyor to a second.

The wrapping sheet, generally being of a limp or tissue type paper, makes it imperative to guard its leading end, and prevent its swinging to a vertical position in contact and obstructively with the moving pockets of the conveyor 1, travelling in an inclined direction.

A guard 52 at one end is fixed to a lever 53 movable to bring the forward end of the guard into cooperation with the stationary guard 54 dependently extending from the magazine 24. As shown in Figure 4, the movable guard 52 is in the form of a plate of increased width at its rear end at which it is connected to a cross bar 55 spanning and connecting the forward ends of a pair of companion levers 56, straddling the conveyor 2. The movable guard tapers to narrow its width toward its forward free end, which is notched or bifurcated to interfit with the forward end of the stationary guard 54. The interfitting of the two guard sections establishes continuity, and avoids the possibility of interruption to the advance of the leading end of the wrapping sheet.

The levers 56 operate as a unit, and are suitably pivotally mounted upon a bracket 57 fixed upon the machine frame and actuated at appropriate timed periods by a connecting link 58 in connection with suitable transmission means, not shown. With the time delivery of the wrapping sheet, a cake of soap is withdrawn from a pocket of the conveyor 1 by the plungers 26, and coordinately the control valve 38 is actuated to open the suction pressure to the jaws for binding the sheet to the forward curved end of the jaws. As shown in Figures 1 and 11, the movable guard 52 is moved to its retreat or normal position to clear the soap transferring plungers. The wrapping sheet in the soap cake transfer is partially folded about the cake of soap, in which position it enters a pocket of the conveyor 2. The sheet at one side of the cake engages a wiper or stationary folder blade 59, extending laterally from the downwardly projecting side of the magazine, see Figures 1, 11 and 12.

The receiving pockets or holders 12 of the conveyor, each has its hinge section 16 moved to an open position, timed slightly prior to its reception of a cake of soap, as shown in Figure 12, to permit the cake to be inserted with freedom to avoid injury thereto and to the wrapper.

The hinge section 16 is positively moved and held in its open position by a stationary control rail 60 fixed to the machine frame and extending in parallelism with the inclined travelling section of the conveyor 2. The hinge section is released to close and impingingly grip the cake as soon as its control arm 19 extending from the rear side of the hinged pocket section 16 rides off of the control rail, as shown in Figure 12.

Instantaneously with the delivery of a cake into a pocket of the conveyor 2, the suction pressure for the jaws of the transfer plungers is cut off, and the plungers retreat to their normal position. With the retreat of the transfer plungers, the lever 53 carrying the movable guard 52 is moved to its forward or active position for accommodating a successive wrapping sheet, and to bring a folder blade 61 mounted upon the levers 56 into cooperation with an end or fly section of the wrapper to fold the same over the outer or exposed face side of the cake within a pocket 12.

The forward end of the levers 53 preferably are of T-form, as viewed from the side, to provide an extended support at one end for mounting the movable guard 52 and at an opposite end the folder blade 61, as is illustrated in Figures 5 and 6. The folder blade 61 has a curved face in approximate conformity with the shape of the face side of the soap cake, which it overlies in folding over an end section of the wrapper so that the wrapper section is snugly folded over the adjoining face and side of the cake.

As the travel of the conveyor 2 is continuous, the folder blade at the forward limit of lever stroke merely overlies the cake surface without impingingly engaging the same nor brought in such proximity therewith as would offer any resistance to the travel of the cake. The retreat of the lever is controlled so as to guard the folded section against unfolding to any degree which would prevent a satisfactory folding or overlapping of the opposite end or fly section of the wrapper, which as the cake is deposited within a pocket 12 extends laterally outward from the pocket to be intercepted by a stationary folder blade 62.

The stationary folder blade 62 is fixed to a suitable support on the machine frame as a rigid cross bar, which also serves to support a pair of guard rails 63, 63, each having its forward extremity joining with the folder blade 62. The guard rails 63 are positioned in appropriately spaced parallelism with the conveyor 2 for holding the folded overlapped edge sections of the wrapper covering the body of the cake to their folded position.

As shown in Figure 5, a brush 64 is mounted upon the magazine casing, and extends between the guard rails 63 for brushing over the outer forward end section of the wrapper to smooth out the wrapper over the body of the cake before continued operation upon the wrapper to interfold and fold over the ends of the wrapper projecting beyond the opposite ends of the cake; which operation follows as the cake commences to travel in the straightaway forward course of the conveyor 2.

The mechanism employed for folding the

wrapper over the opposite ends of the cake, as it is illustrated in Figures 1 and 14 to 18 inclusive, and for one style of end closing, folds the wrapper sections at the opposite ends of the cake in relatively opposite directions to fold one end of the wrapper over one side of the cake, and at the other end over the opposite side of the cake. This, however, is merely selective, and permits simultaneous end closure folding for the opposite ends of the cake.

While the end closure folding of the wrapper for the opposite ends of the cake is in relative opposite directions to have the closure folding extend over opposite face sides of the cake, the means for molding the closure ends of the wrapper are approximately duplicate, excepting that certain parts for one end operate reversely of the corresponding parts of the opposite end.

A guide stock 65, as a bracket, is rigidly fixed to the machine frame, or as illustrated, mounted upon one side of the wrapper magazine casing, and slidably supports a vertically reciprocating slide 66. The slide 66 has a wiper 67 fixed to and dependently projecting from its lower end for collapsing and downwardly folding the tubular end of the wrapper.

The projecting ends of the wrapper formed in folding the wrapper about the body of the soap cake initially are in the form of a tube, which is collapsed when pressed together and across one end of the cake. The wiper 67 is of a shape or configuration to provide clearance for other parts of the folding mechanism, and is arranged to engage the tubular projecting end of the wrapper medially, as illustrated in Figures 16 and 17.

As the opposite tubular end of the wrapper is folded in a reverse direction to bring the same over the top side of the cake, the wiper therefor correspondingly operates in a reverse or upward direction from that of the opposite end. In such instance, a wiper 68 projects from the forward end of a lever 69 suitably pivoted to the machine frame and connected to one end of a link 70. The opposite end of the link 70 is pivotally connected to the upper end of the slide 66. In a down stroke of the slide 66, the wiper 67 moves correspondingly unitarily with the slide, while the wiper 68 through the interposed lever and link connection with the slide moves upwardly.

In Figure 15 the wipers are shown at their limit of active position and relatively reverse of one another. The wipers are permitted to dwell at the end of their active stroke for holding the fold to its angular position against rebound, while folding sections thereof in the form of opposite gussets 71, 72, which are intumed overlappingly. The gusset 71 is folded by an oscillating blade or movable folder 73 as an arm fixed to and depending from a rock shaft 74 journaled within a bracket or bearing 75 fixed upon and movable as a unit with the slide 66.

An arm 76, in union with one of the gusset holding blades 73, extends upwardly and rearwardly from the rock shaft 74 and carries a roller 77 journaled on their laterally extended axis for cooperating with a cam guide 78 controlling the movement of the blades 73 positively in one direction upon the descent of the slide, and at the proper interval is released by the cam guide and forcibly moved in a return or retreat direction under the tension of a spring 79 connected to the blade and slide.

The folder blades 73, when released by the cam guide, each is forcibly moved across the closure end of the wrapper, carrying and folding inward

a gusset section 71. An opposite gusset section is folded inwardly and overlappingly over the gusset section 71 through its conveyor travel by engagement between a pair of side rails 80, 80, as the holder, carrying the cake, interposingly moves between the rails in the forward course of the conveyor.

The side rails 80 are of a length to hold the closure ends of the wrapper in their folded condition until removed from the holder for cartoning either manually, mechanically, or otherwise.

Each cake of soap, successively in its transfer from one conveyor to the second, medially intercepts a wrapping sheet to partially envelop the cake during the transfer and the folding continues progressively for a complete enclosure while conveyed by the second conveyor. The operation is comparatively quick and without interruption to the continuous travel of the conveyors.

The external shape or contour of the cake is immaterial, but the method very effectively handles an oval shape cake, which ordinarily heretofore has been very difficult to handle for wrapping mechanically. It requires no turning of the cake to fold the wrapper thereabout. The cake in its transfer from one conveyor to the other permits the wrapper to be brought over the side of the cake, which when deposited in the holder of the second conveyor is brought into adjoining position with the bottom of the holder, thus initially covering what may be termed the underside of the cake so that for completing the folding, no further turning or disturbance of the cake within the holder is necessary. This produces but a minimum handling of the cake, and in a manner in which there is no opportunity to mar the cake which usually at the time of wrapping is comparatively soft, and as is customary for oval shaped cakes to have the face sides carry considerable decoration or ornamentative embellishment produced in compressing the cake to its contour.

In some instances, it is desirable to employ a printed wrapper, and have the printed matter occupy a definite spacing on the wrapper which is to be appropriately disposed and in registry with the face side, or say, the longitudinal edges of the cake. The preliminary feed of the sheet in its delivery from the magazine or supply source is accurately timed and regulated with the traverse of the conveyor, so that the sheet will be appropriately positioned in relation to a pocket of the conveyor 1 from which a cake is withdrawn for cooperation with the wrapper.

Delivery of the wrapper sheet is therefore limited by the cross bar 55 on the lever 56 to bring a definite printing space of the wrapper in registry with a face side of the soap cake. As soon as the jaws 26 holding a cake of soap approach and contact with the sheet, the sheet is held against displacement from the cake and jaws by the suction pressure administered through the jaws, so that the printing space of the wrapper is disposed in registry with the face side of the cake or is subsequently brought to a selected position about the cake in folding the wrapper. This provides for uniform application of the wrappers to the cakes, which is desirable, particularly in further packaging a plurality of cakes in a single carton or container.

Having described my invention, I claim:

1. In an apparatus for applying a wrapping sheet about a soap cake or the like, comprising:

conveyor means for conveying cakes of soap in a consecutive order having sections moving in opposing spaced parallelism for effecting a transfer of the cake from one conveyor section onto the other, sheet feeding means for interposing a sheet between said sections for interception by a soap cake in its transfer from one section onto the other, and a carrier reciprocable transversely to said sections for transferring the cake from one section onto the other to initially apply the sheet and embody the same with the cake, and suction means in conduit connection with the carrier for administering a suction pressure through the carrier during the transfer of the cake from one conveyor section onto the other.

2. In an apparatus for applying a wrapping sheet about a soap cake or the like, comprising: aligned endless conveyors, each provisioned for holding cakes of soap in a consecutive order, the opposing ends of the conveyors traveling in spaced parallelism for effecting a transfer of the cake from one conveyor onto the other, sheet feeding means for interposing a wrapping sheet for each cake in the spacing between the ends of said conveyors for interception by a soap cake in its transfer from one conveyor onto the second, means movable transversely to the ends of said conveyors traveling in spaced parallelism for effecting a transfer of the cakes successively, said means recessed to respectively seat the opposite ends of the cake and sustain the same during the transferring period, the cake in its transfer carrying the sheet and embodying the same therewith to partially envelop the cake before deposit onto said second conveyor, and a movable guide for sustaining the sheet initially to its cooperation with the soap cake.

3. In an apparatus for applying a wrapping sheet about a soap cake or the like, comprising: aligned endless conveyors, each provisioned for holding cakes of soap in a consecutive order, the opposing ends of the conveyors traveling in spaced parallelism for effecting a transfer of the cake from one conveyor onto the other, sheet feeding means for interposing a wrapping sheet for each cake in the spacing between the ends of said conveyors for interception by a soap cake in its transfer from one conveyor onto the second, means movable transversely to the ends of said conveyors traveling in spaced parallelism for effecting a transfer of the cakes successively, said means recessed to respectively seat the opposite ends of the cake and sustain the same during the transferring period, the cake in its transfer carrying

the sheet and embodying the same therewith to partially envelop the cake before deposit onto said second conveyor, and means movable to sustain the sheet initially to its cooperation with the soap cake, and subsequently to fold a section thereof about a side of the cake after deposit upon the second conveyor.

4. In an apparatus for applying a wrapping sheet about a soap cake or the like, comprising: aligned endless conveyors, each provisioned for holding cakes of soap in a consecutive order, the opposing ends of the conveyors traveling in spaced parallelism for effecting a transfer of the cake from one conveyor onto the other, sheet feeding means for interposing a wrapping sheet for each cake in the spacing between the ends of said conveyors for interception by a soap cake in its transfer from one conveyor onto the second, and a carrier reciprocable transversely to the ends of said conveyors traveling in spaced parallelism for effecting a transfer of the cakes successively, said carrier recessed to respectively seat the opposite ends of the cake and sustain the same during the transferring period, the cake in its transfer carrying the sheet and embodying the same therewith to partially envelop the cake before deposit onto said second conveyor, and suction means in conduit connection with the carrier for administering a suction pressure through the carrier to hold the sheet to the cake and carrier during the conveyor transfer of the cake.

5. The method of initiating the application of a wrapping sheet about a cake of soap, which consists in interposing a wrapping sheet between opposing cake conveyor sections for interception by the cake in effecting a transfer of the cake from one conveyor onto another, and in the transfer of the cake holding the wrapper to the cake against displacement by suction administered through the means transferring the cake from one conveyor to the other.

6. The method of initiating the application of a wrapping sheet upon a cake of soap, which consists in transferring the cake in conveyor transit between opposing portions of the conveyor by a reciprocating transfer medium engageable with the opposite ends of the cake, interposing a wrapping sheet at the cake transferring point for interception and engagement by the cake and transfer medium, and with the aid of suction administered through the transfer medium holding the sheet against displacement during the cake transferring period.

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