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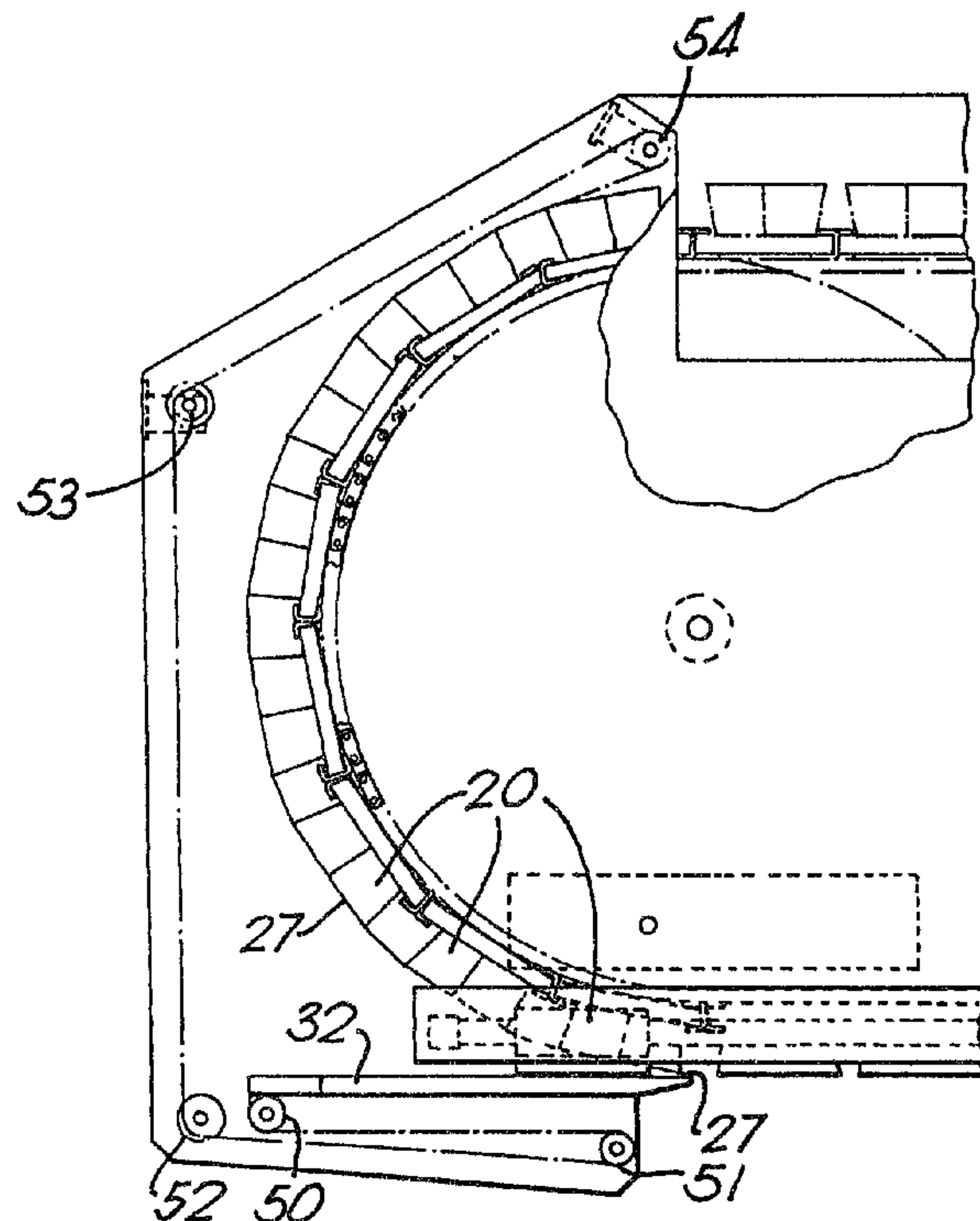
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(54) Titre : SYSTÈME DE VIDAGE

(54) Title: EMPTYING SYSTEM



(57) Abrégé/Abstract:

Emptying bowls are transported by an intermittently travelling endless conveyor having an upper run for transporting the bowls in an upright position and a lower run for transporting the bowls in an inverted position. A belt which travels intermittently in synchrony with the conveyor is positioned to contact and cover the open tops of the bowls for retaining contents of the bowls therein as the bowls are transported from an upright position on the upper run to an inverted position on the lower run. The belt is retracted at a position beneath the lower run when the conveyor is stationary to release the contents from the bowls.



ABSTRACT

Emptying bowls are transported by an intermittently travelling endless conveyor having an upper run for transporting the bowls in an upright position and a lower run for transporting the bowls in an inverted position. A belt which travels intermittently in synchrony with the conveyor is positioned to contact and cover the open tops of the bowls for retaining contents of the bowls therein as the bowls are transported from an upright position on the upper run to an inverted position on the lower run. The belt is retracted at a position beneath the lower run when the conveyor is stationary to release the contents from the bowls.

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The present invention relates to an emptying system more particularly to an automatic mechanised system of emptying and transferring a product from emptying bowls to a receiving means.

In food factories and in many production lines where products are packed in pouch machines the emptying of bowls containing the product travelling from the feed conveyor to the pouch machine is carried out manually. Such an operation is very tedious and causes many back and neck problems to the personnel owing to the repetitive turning and leaning movements required.

SUMMARY OF THE INVENTION

The present invention provides automatic apparatus and process systems for emptying and transferring non-liquid ingredients from emptying bowls to a receiving means.

Emptying bowls are transported by an intermittently travelling endless conveyor having an upper run for transporting the bowls in an upright position and lower run for transporting the bowls in an inverted position. A belt which travels intermittently in synchrony with the conveyor is positioned to contact and cover the open tops of the bowls transported from an upright position on the upper unto and in an inverted position on the lower run for retaining contents of the bowls therein. The belt is retracted at a position beneath the lower run when the conveyor is stationary to release the contents from the bowls.

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DETAILED DESCRIPTION OF THE INVENTION

Accordingly, the present invention provides an emptying system for emptying and transferring non-liquid ingredients from emptying bowls to a receiving means which comprises

- a) an endless conveyor belt adapted to travel intermittently for carrying the filled emptying bowls from an upright position on the upper run to an inverted position on the lower run,
- b) means for feeding filled emptying bowls to the upper run of the endless conveyor belt,
- c) means for removing empty emptying bowls from the endless conveyor belt,
- d) means for feeding the receiving means beneath the inverted emptying bowls on the lower run of the endless conveyor belt, and

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e) a retracting conveyor belt adapted to travel intermittently in synchrony with the endless conveyor belt and to contact and cover the open ends of the filled emptying bowls as they travel from the upper run to the lower run of the endless conveyor belt, the lower downstream end of the retracting conveyor belt being adapted to retract when the endless conveyor belt is stationary and the downstream inverted filled emptying bowl is positioned above a receiving means, to uncover the downstream inverted filled emptying bowl enabling the contents to be transferred to the receiving means.

The receiving means may simply be a conveyor belt or it may be any kind of receptacle such as a tray or a container having any suitable shape e.g. circular, square or rectangular. Advantageously, the shape of the container may match the shape of the emptying bowl. The container may, for instance, be a pouch.

The endless conveyor belt is advantageously a chain conveyor belt fitted with means for securing the emptying bowls to the belt e.g. carriers welded to the chain. The endless conveyor belt is conveniently trained around a chain wheel at each end.

The means for feeding filled emptying bowls to the upper run of the endless conveyor belt is conveniently a pusher positioned on a conveyor belt travelling laterally towards the upper run which pusher is activated when the endless conveyor belt is stationary. The means for removing empty emptying bowls from the endless conveyor belt is advantageously also a pusher positioned on a conveyor belt travelling laterally away from the upper run which pusher is also activated when the endless conveyor belt is stationary. The belts travelling laterally towards and away from the upper run

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of the endless conveyor belt conveniently are part of a conveyor dosing and weighing system for the containers.

5 The retracting conveyor belt prevents the ingredients falling out of the emptying bowls as they travel from the upper run to the lower run of the endless conveyor belt and thus become inverted. Means are provided to take up the slack when the lower downstream end of the retracting conveyor retracts in order to ensure that it
10 remains in contact with the emptying bowls that it covers e.g. a pneumatic cylinder acting on one of the rollers around which the retracting conveyor is trained, a spring or a counterweight.

15 Advantageously, a vibrating unit lies adjacent the base of an inverted emptying bowl positioned above a receiving means adapted to act on the base to ensure that substantially all the ingredients fall out of the emptying bowl.

20 When the receiving means comprises receptacles such as trays or containers preferably, between the lower downstream end of the retracting conveyor and a receptacle there is located a depositing screen to
25 prevent ingredients falling from the emptying bowl onto the sealing surface of the receptacle.

30 When the receiving means comprises receptacles, the receptacles conveniently travel intermittently beneath the bowl emptying system on a conveyor belt. There may be various receptacle arrangements, for instance, they may be arranged in two rows. When the receptacles are pouches, they are conveniently contained in a conventional pouch machine.

35 The bowl emptying system may be driven by conventional means, for example, by an electrical step motor or a pneumatic cylinder providing intermittent motion so that

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when the endless conveyor belt is stationary, filled
emptying bowls are fed onto the upper run, empty
emptying bowls are removed, the retracting conveyor belt
retracts and the contents of the downstream filled
5 inverted emptying bowl are transferred to the receiving
means. When the receiving means comprises receptacles,
the system may be automated with the receptacles whereby
the conveyor belt transporting the receptacles travels
intermittently and stops so that a receptacle is at
10 position below and in alignment with a downstream
emptying bowl to enable the contents of an emptying bowl
to fall into a receptacle.

Ingredients that may be handled include rice, meat
15 chunks, diced meat, sliced meat, shrimps, potatoes
sausages, meat balls, vegetables and vegetable mix.

The present invention also provides a process for
emptying and transferring non-liquid ingredients from
20 emptying bowls to a receiving means which comprises

- a) feeding filled emptying bowls in an upright
position to the upper run of an intermittently
running endless conveyor belt,
25
- b) advancing the endless conveyor belt to enable the
filled emptying bowls to travel from the upper run
to the lower run until the downstream filled
emptying bowl is in an inverted position,
30
- c) feeding a receiving means beneath the inverted
emptying bowls on the lower run of the endless
conveyor belt, and
- 35 d) contacting and covering the open ends of the filled
emptying bowls with a retracting conveyor belt
travelling intermittently in synchrony with the
endless conveyor belt, whose lower downstream end

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retracts when the endless conveyor belt is stationary to uncover the downstream inverted filled emptying bowl enabling the contents to be transferred to the receiving means.

5

The present invention will now be further illustrated by way of example only with reference to the accompanying drawings in which

10

Figure 1 is a perspective view of a line including the system,

Figure 2 is a side plan view of the same line,

15

Figure 3 is a top plan view of the same line,

Figure 4 is a diagrammatic transverse sectional view of the bowl emptying unit, and

20

Figure 5 is a sectional view of a half of the bowl emptying unit looking in the direction A-A of Figure 4.

Figure 6 is a top plan view of a bowl emptying unit,

25

Figure 7 is a side view of Figure 6 looking in the direction B-B.

Figure 8 is an enlarged view of part of the bowl emptying unit of Figure 4 showing the shuttle board in the forward position,

30

Figure 9 is an enlarged view of the same part of the bowl emptying unit as shown in Figure 8 showing the shuttle board in its retracted position,

35

Figure 10 is an enlarged view of part of Figure 5, and

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Figures 11, 12, 13 and 14 are diagrammatic transverse sectional views of part of the bowl emptying unit showing different methods of taking up the slack of the retracting conveyor belt.

Referring to the drawings, the line comprises a bowl filling and conveying unit 10, a bowl emptying unit 11 and a pouch machine 12. The bowl filling unit comprises a dosing unit 13, a multi-head weigher 14, a check weigher 15, a flow divider 16 and a continuously travelling conveyor belt 17 having one run 18 travelling towards and one run 19 travelling away from the bowl emptying unit 11. Filled bowls 20 and emptied bowls 21 are shown in Figure 1 travelling towards and away from the bowl emptying unit 11 on conveyor belt runs 18 and 19 respectively.

The bowl emptying unit comprises a support frame 22 supporting in intermittently travelling chain conveyor 23 carrying bowls 20, 21 by means of carriers 24 welded to the chain trained around chain wheels 25, 26. A retracting belt 27 is trained around rollers 28, 29, 30, 31 and a reciprocating solid plastics shuttle board 32. Two vertically reciprocating pneumatic cylinders 33 act on roller 29 to take up the slack of the retracting conveyor belt when the part of it trained around the shuttle board 32 retracts. Alternative methods of taking up the slack are by means of a spring 47 or a counterweight 48.

At the infeed end and beneath the run 18 of conveyor belt 17 is a vertically reciprocating stop 34 for the filled emptying bowls 20. Positioned above runs 18 and 19 are pushers 35 and 36 with vertically reciprocating cylinders 37 and 38 respectively.

The pouch machine 12 (Multivac or Mahaffy Harder) feeds two rows of empty pouches 39 to pass beneath the bowl

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emptying unit 11 and transports filled pouches 40 away. Positioned between the shuttle board 32 and the empty pouches 39 are depositing screens 41 to prevent the contents of the emptying bowl 20 landing on the sealing surfaces of the pouches. A vibrating unit (not shown) acts on the base of the emptying bowls 20 to ensure that the contents are emptied out. The shuttle board 32 is fixed by means of two blocks 42 to a driving unit comprising two horizontally located pneumatic cylinders 43 working in parallel to reciprocate the shuttle board 32 and connected by means of two turning arms 44 to the axle 45 of the chain wheel 26. Each turning arm is provided with a reciprocating meshing cylinder 46.

In operation, empty bowls 21 are filled with rice at the dosing unit 13 of the bowl filling and conveying unit 10 and travel along the conveyor belt 17 in the direction of the arrows to a multi-head weigher 14, a check weigher 15 and a flow divider 16 to form two rows of filled bowls 20 which travel towards the intermittently travelling chain conveyor 23 of the bowl emptying unit 11 where they are prevented from passing onto the chain conveyor 23 when it is in motion by means of the reciprocating stop 34 in its upper position. When the chain conveyor 23 is stationary, the stop 34 and the cylinder 37 of pusher 35 descend and two rows of two bowls are pushed onto chain conveyor 23 at position X (Fig. 4) by means of a pusher 35 moving to the left shown by the arrow in Figs. 6 and 7. Immediately afterwards, chain conveyor 23 advances, stop 34 and cylinder 37 ascend and pusher 35 returns to the position shown in Figs. 6 and 7. At the same time, as the filled bowls are pushed onto the chain conveyor 23, two rows of two empty bowls 21 are pushed off the chain conveyor 23 by means of a pusher 36 at position Y onto the conveyor belt 19 where they travel in the direction of the arrows to the dosing unit 13. The chain conveyor 23 advances when the pneumatic cylinders 43 drive the turning arm 44

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by means of the cylinder 46 on the turning arm 44 meshing with chain wheel 26 at position Z_1 and the turning arm 44 travels to position Z_2 , and then stops at which point the reciprocating cylinder 46 unmeshes from the chain wheel and the turning arm travels back to position Z_1 where the cycle recommences.

The filled bowls 20 are held in position on the chain conveyor 23 by the carriers 24 and as they travel around the chain wheel 26 to an inverted position on the lower run of the chain conveyor 23 their open tops are covered by the retracting belt 27 travelling at the same peripheral speed as the open tops of the bowls 20 which prevents the ingredients falling out. When two rows of two filled bowls 20 reach a position directly above two rows of two empty pouches 39 transported intermittently in the pouch machine, the retracting conveyor belt 27 and the chain conveyor 23 stop with the turning arm 44 at position Z_2 and the cylinder 46 unmeshes from the chain wheel 26 whereupon the pneumatic cylinders 43 move to the left in Figure 4 causing the turning arm 44 to return to position Z_1 and the shuttle board 32 to move to its retracted position as shown in Figure 9 carrying with it that part of the retracting conveyor belt 27 trained around it thus uncovering the filled bowls 20 whose contents fall out helped by the vibrating unit 37 into the pouches 39 which are stationary. The depositing masks 41 prevent any rice falling onto the sealing surfaces of the pouches. As the shuttle board moves to the retracted position, the slack in the retracting conveyor belt 27, which is also stationary at this time, is taken up by the action of the pneumatic cylinders 33 which ascend and cause roller 29 to ascend also. This ensures that remaining filled bowls positioned around the chain wheel 26 on the chain conveyor 23 are covered by the retracting conveyor belt and the contents do not fall out. At this time also, further filled bowls 20 are pushed onto the chain conveyor and further empty bowls

21 are pushed off the chain conveyor. Alternative methods of taking up the slack in the retracting conveyor belt 27 are by means of an extension spring 47 causing roller 29 to ascend (Fig. 12), by means of a counterweight 48 causing roller 29 to descend in which case a further roller 49 is provided (Fig. 13) and by means of a roller 50 attached to and moving together with the shuttle board 32 together with stationary rollers 51, 52, 53 and 54 (Fig. 14).

The cylinder 46 then meshes with chain wheel 26, and the pneumatic cylinders 43 move to the right in Figure 4 causing the shuttle board 32 to move to the right as shown in Figure 8 carrying with it the retracting belt 27 as well as causing the turning arm 44 to travel to position Z_2 which in turn causes the chain conveyor to advance a sufficient distance for a further batch of two rows of two filled bowls 20 to reach a position above a further batch of two rows of two pouches 39 which have advanced on the pouch machine. The cycle is then repeated and can work at a speed of 60 cycles per minute which means that, with a pouch arrangement of two rows of two, a capacity of 240 pouches per minute can be filled.

Different ingredients can be handled at the same time for dual products e.g. rice in one pouch and meat in the other.

The bowl emptying unit 11 is attached to and connected with the pouch machine 12, but can easily be disconnected for making hygienic. A continuous cleaning device may, if desired, be added beneath the bowl emptying unit for cleaning the bowls.

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CLAIMS:

1. An article transfer apparatus comprising:

an endless conveyor having an upper run for holding and transporting emptying bowls having an open top in an upright position and a lower run for holding and transporting the bowls in an inverted position;

means for intermittently advancing the endless conveyor;

a belt positioned to cover open tops of the bowls transported from the upright position on the upper conveyor run to and in the inverted position on the lower conveyor run for retaining contents of the bowls therein;

means for intermittently advancing the belt in synchrony with the endless conveyor;

means for retracting the belt from the bowls at a position on the lower conveyor run to uncover an inverted bowl to release the contents from the bowl, the means for retracting the belt having shuttle means around which the belt is trained and reciprocating means for moving the shuttle means and the belt to a retracted position; and

means positioned for receiving the contents released from the uncovered bowl.

2. The apparatus according to claim 1 further comprising means for feeding the bowls to the upper conveyor run for being transported by the endless conveyor and means for removing empty bowls from the upper conveyor run.

3. The apparatus according to claim 2 wherein the means for feeding and the means for removing the bowls to and from the conveyor are pushing devices positioned on conveyors having a run positioned lateral to the endless conveyor runs at a position above the endless conveyor upper run.

4. The apparatus according to claim 1 wherein the means for

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retracting the belt includes means to take up slack in the belt as the belt retracts.

5. The apparatus according to claim 4 wherein the means for taking up slack comprise at least one roller about which the belt is trained and means for moving the at least one roller to take up the slack.

6. The apparatus according to claim 1 wherein the shuttle means includes a shuttle board.

7. The apparatus according to claim 1 further comprising a vibratory unit positioned for vibrating bowls uncovered by the belt for assisting releasing contents from the bowls.

8. The apparatus according to claim 1 wherein the endless conveyor is a chain conveyor having means to secure the bowls.

9. The apparatus according to claim 1 wherein the bowl is a container having a shape selected from the group consisting of circular, square and rectangular shapes.

10. A process for transferring non-liquid articles comprising:
intermittently transporting emptying bowls, which have an open top and which have contents contained therein, on an endless conveyor so that the bowls are held and transported on an upper run of the conveyor in an upright position and on a lower run of the conveyor in an inverted position;

intermittently advancing a belt in synchrony with the conveyor and bowls to contact and to cover the open tops of the bowls transported from the upright position on the upper conveyor run to and in the inverted position on the lower conveyor run for retaining the contents in the bowls therein;

feeding a receiving means to a position beneath the lower conveyor run and belt; and

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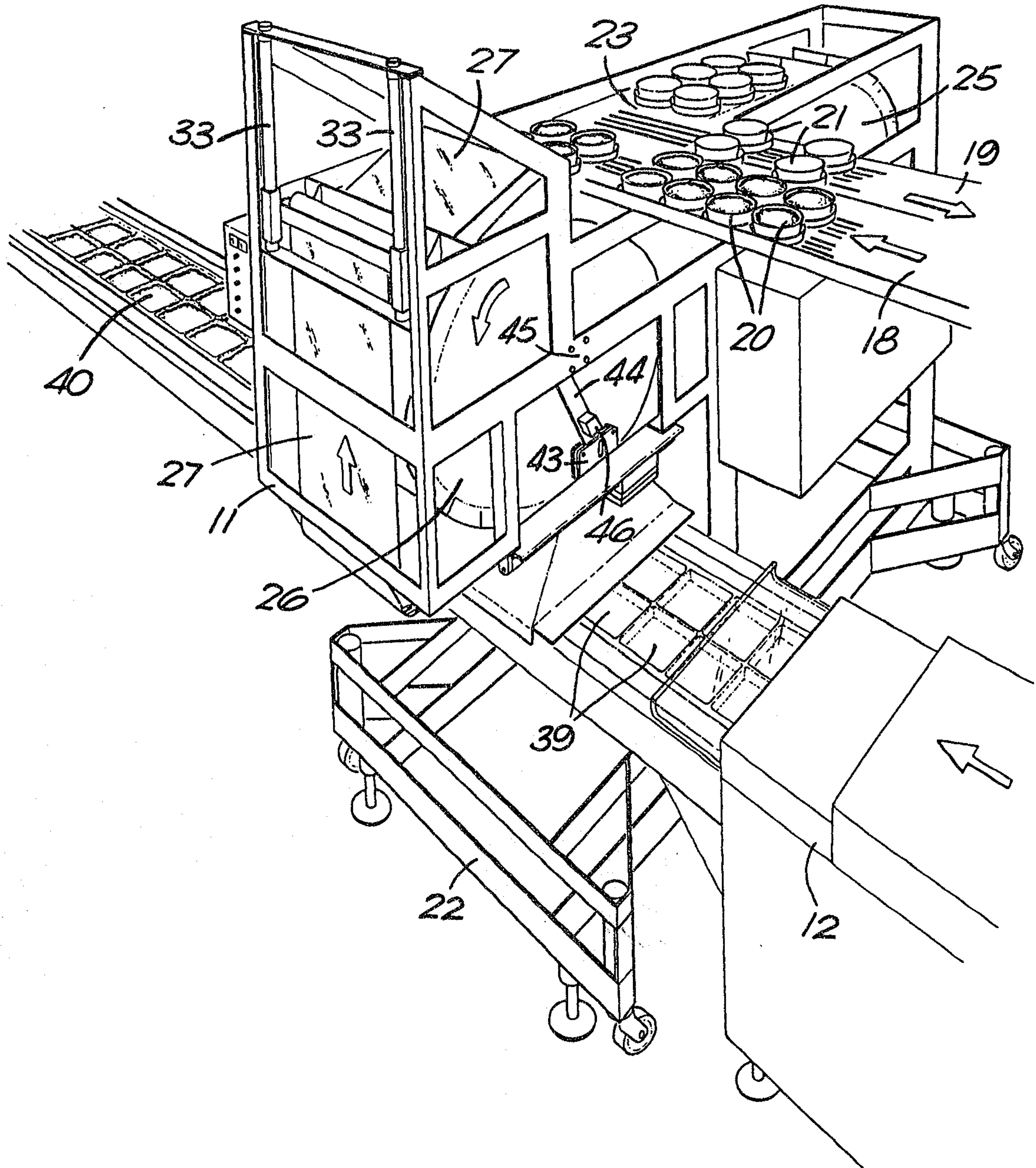
retracting the belt at a position above the receiving means at a time when the endless conveyor is stationary to uncover inverted bowls to release the contents from the bowls into the receiving means.

11. The process according to claim 10 further comprising vibrating the bowls uncovered to assist releasing the contents from the bowls.

12. The process according to claim 10 further comprising feeding the bowls to and removing the bowls from the upper conveyor run.

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FIG. 1



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FIG. 2

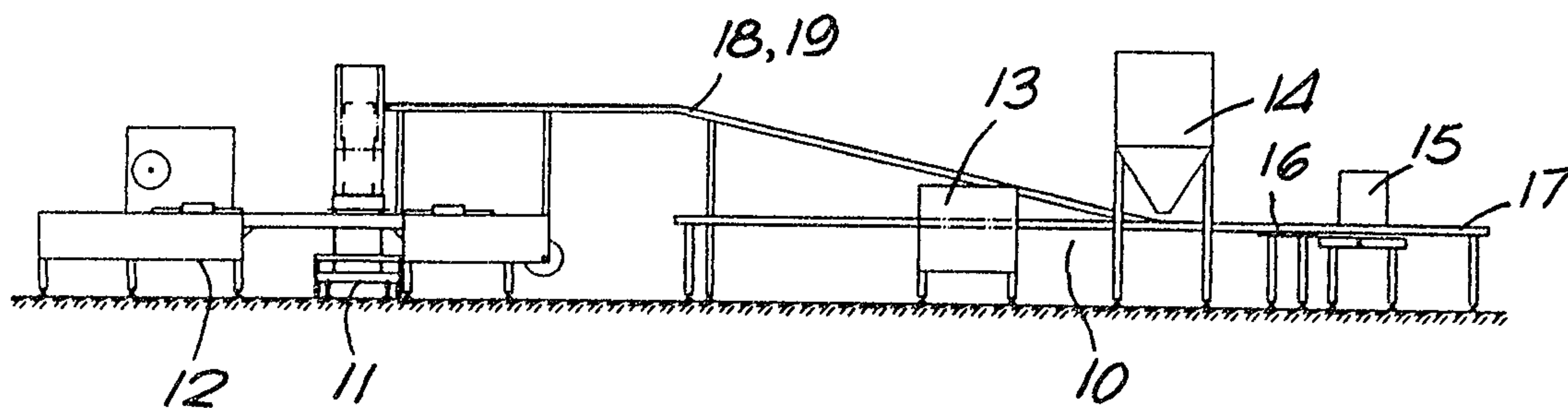


FIG. 3

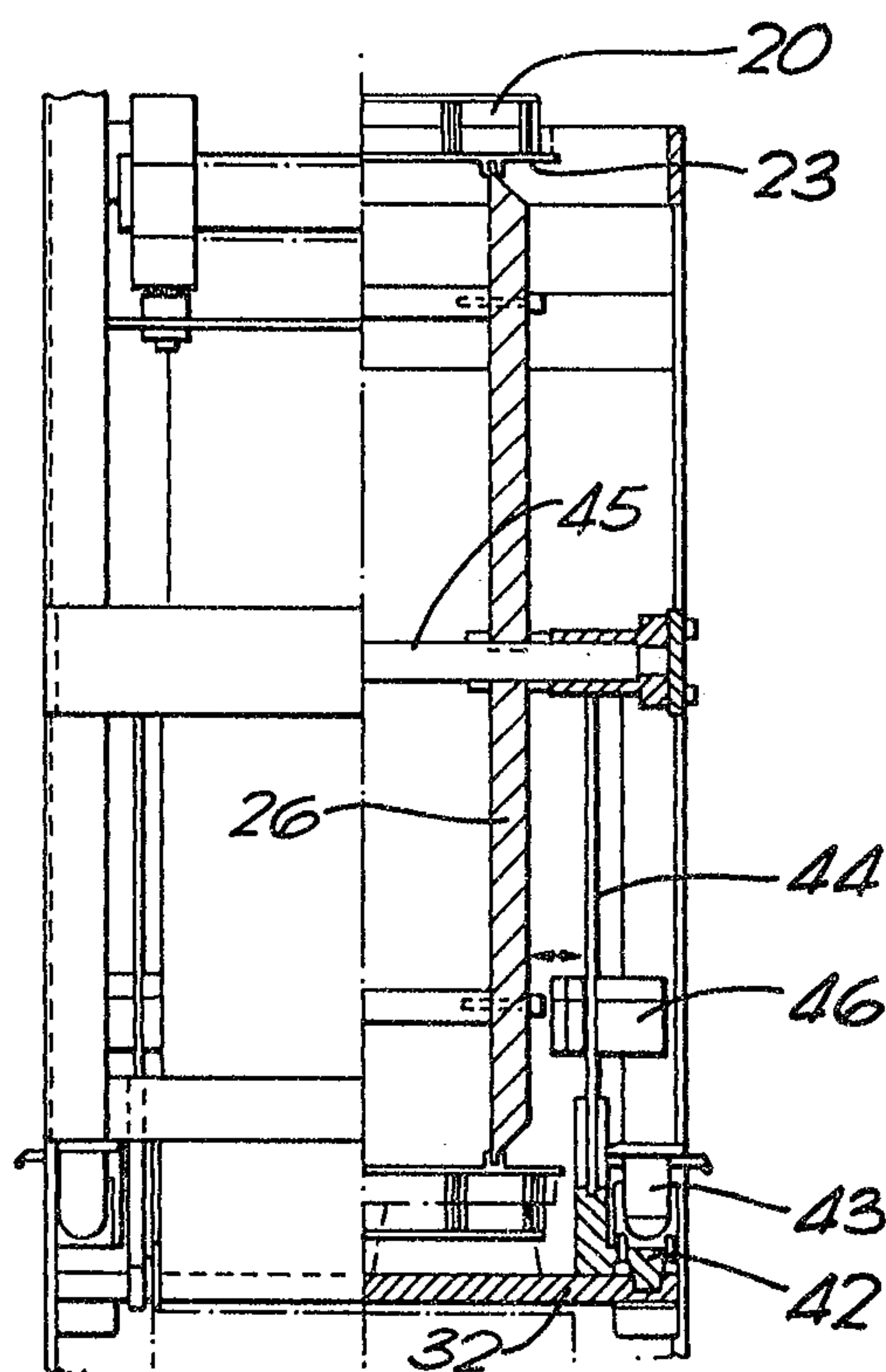
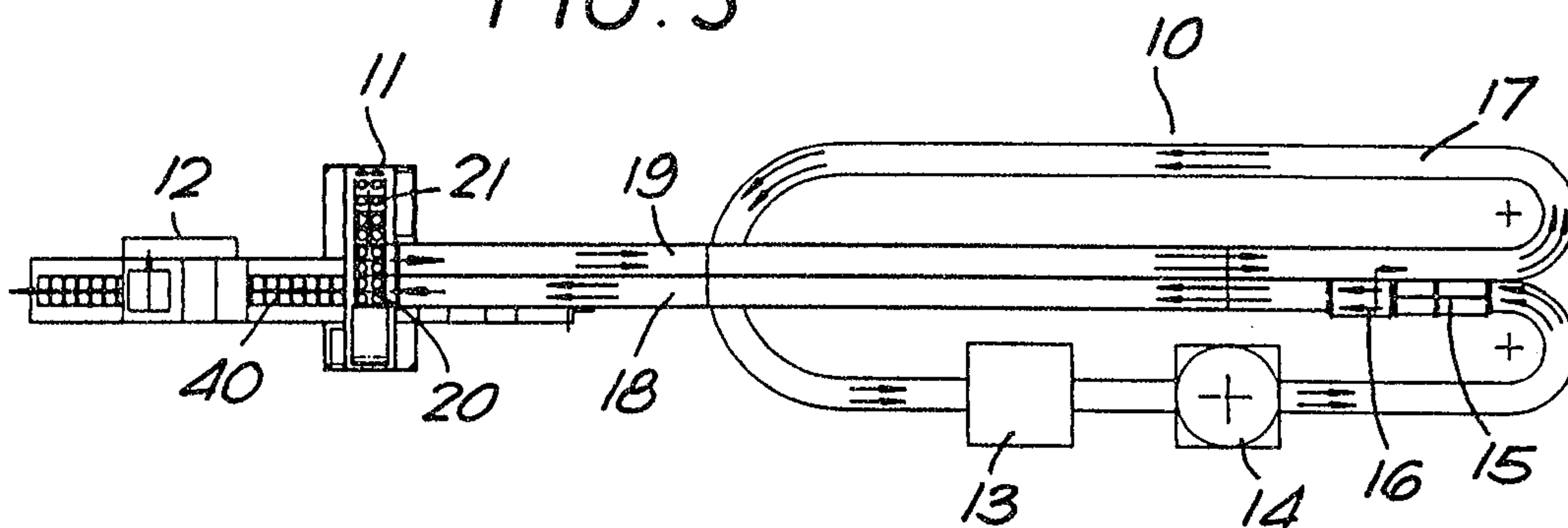
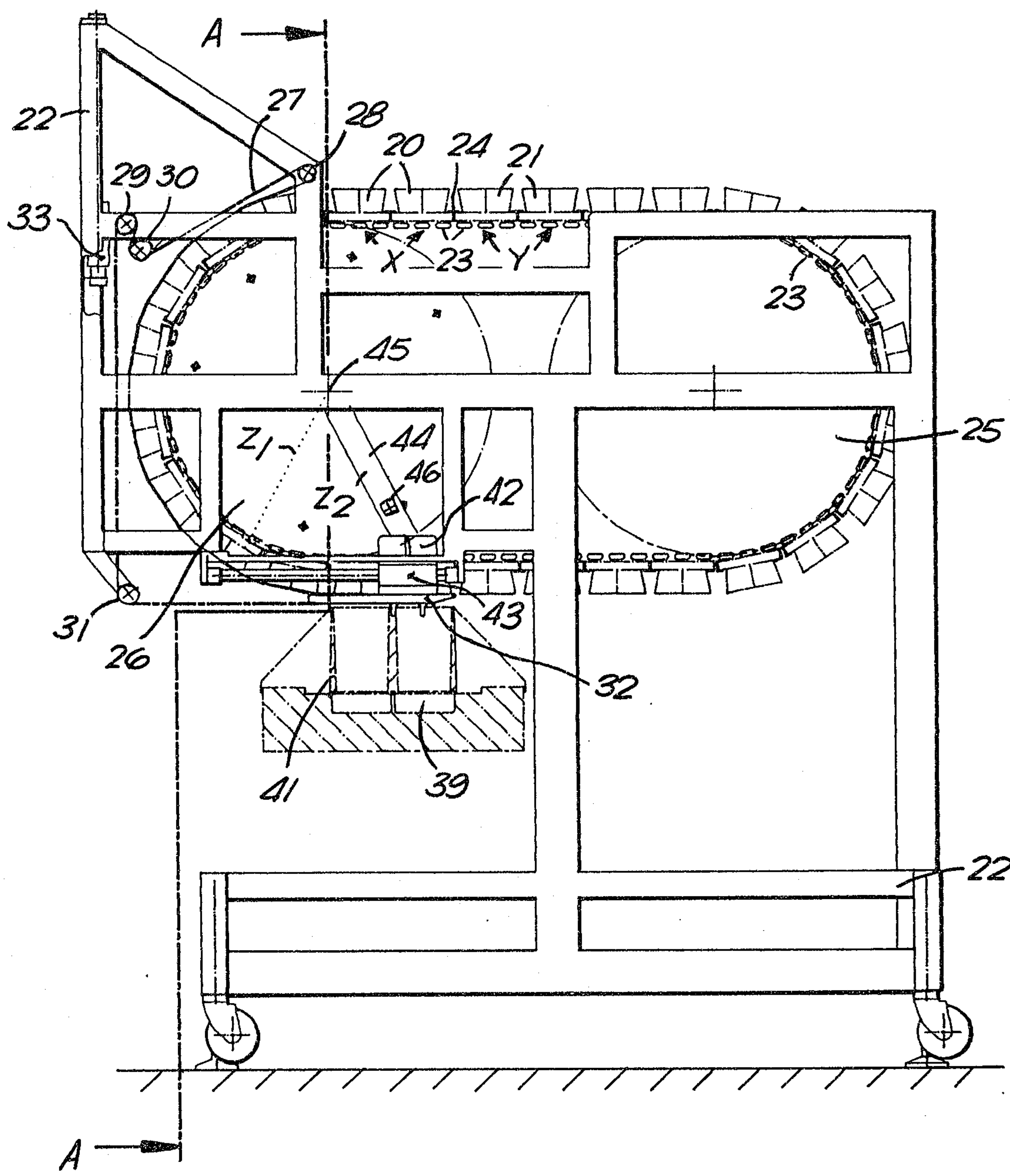


FIG. 10

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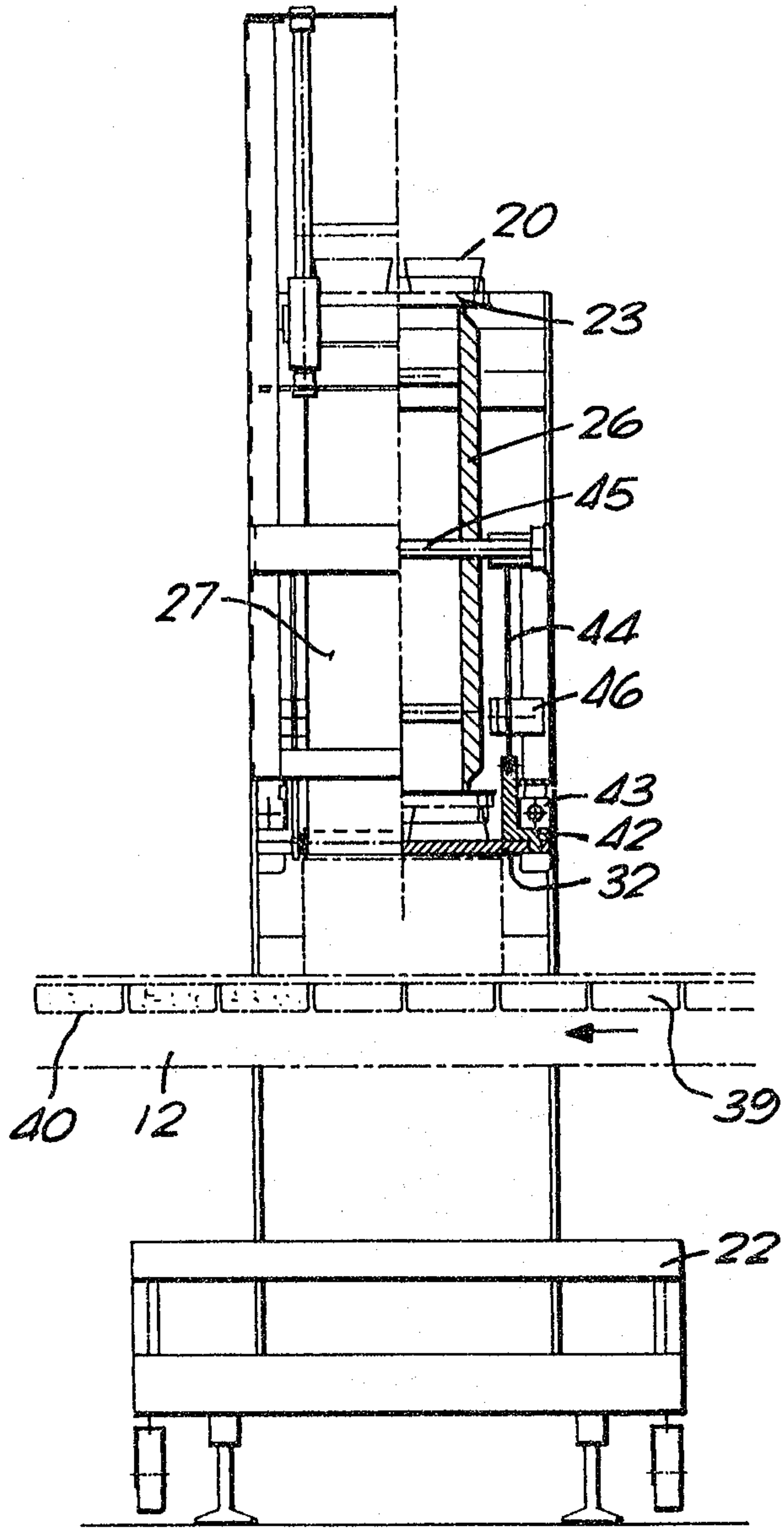
FIG. 4



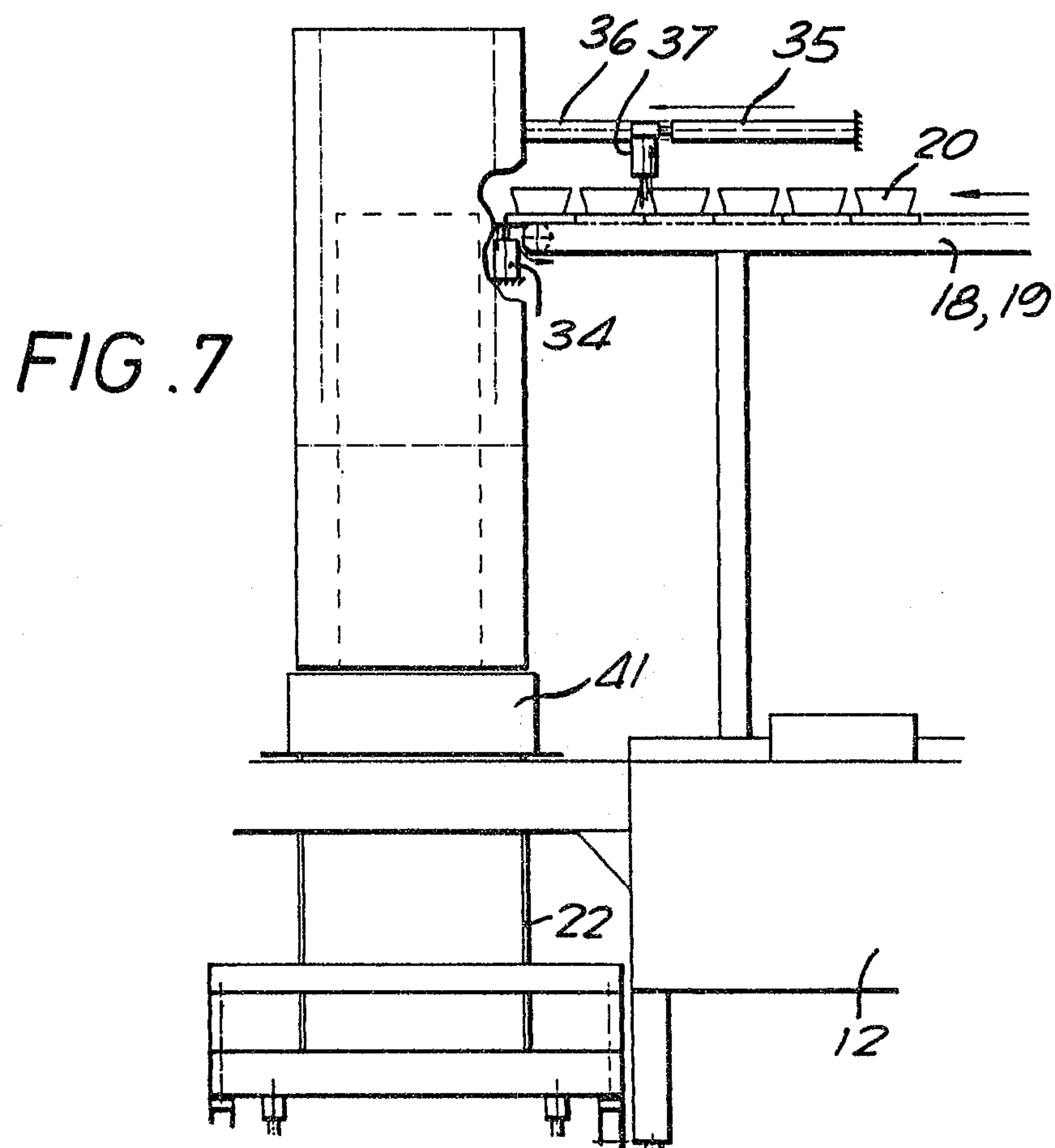
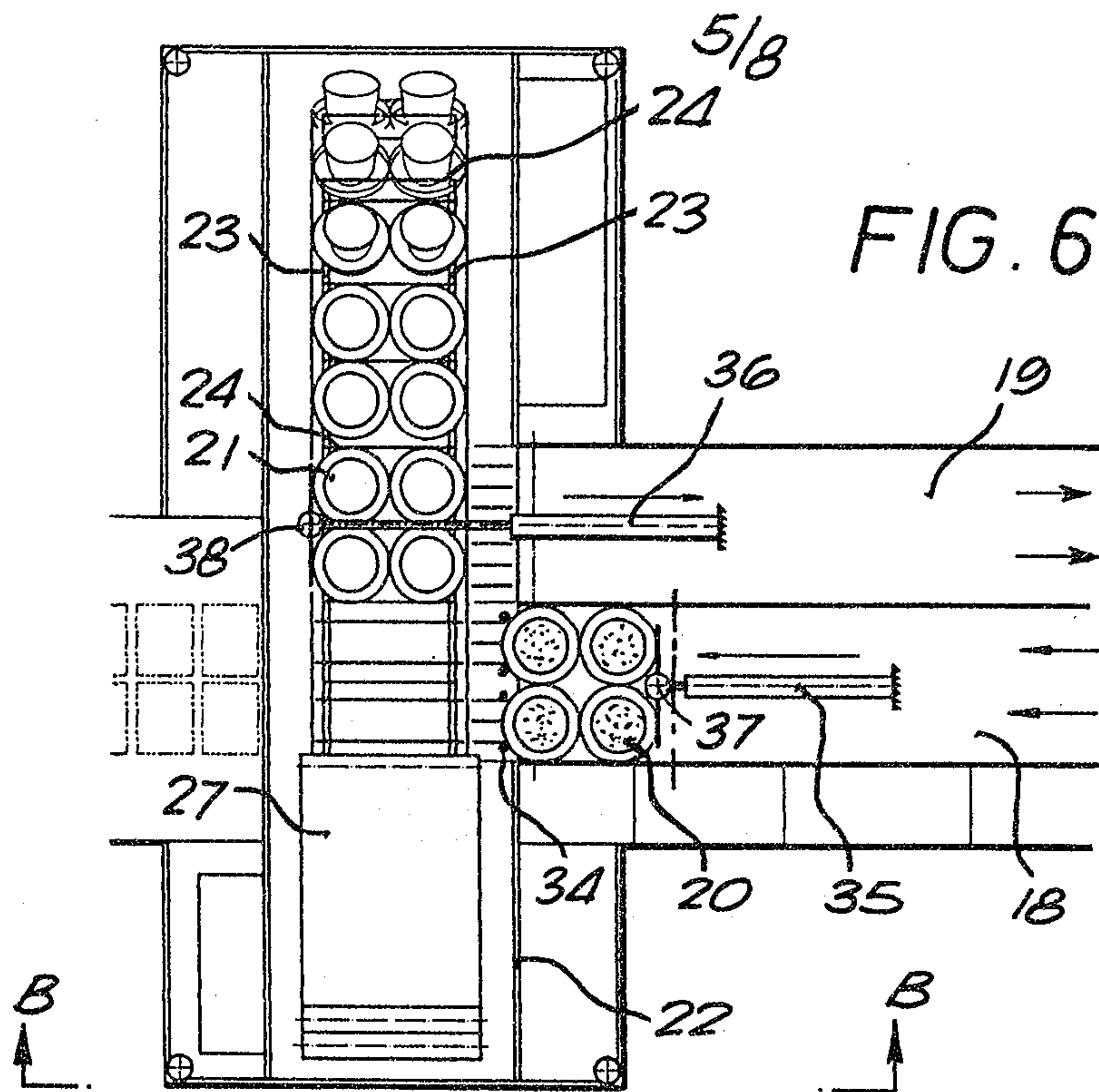
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FIG. 5



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FIG. 8

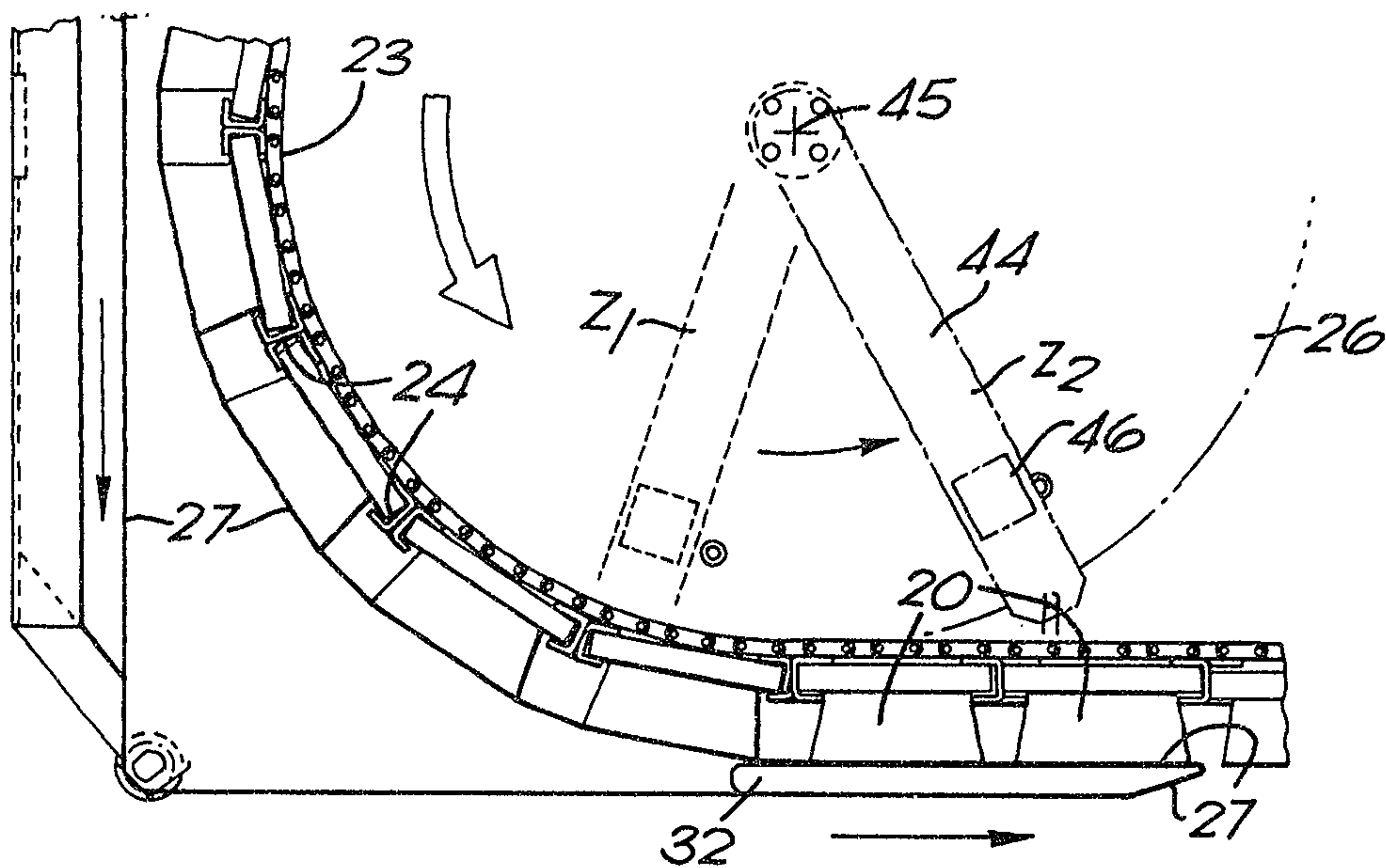
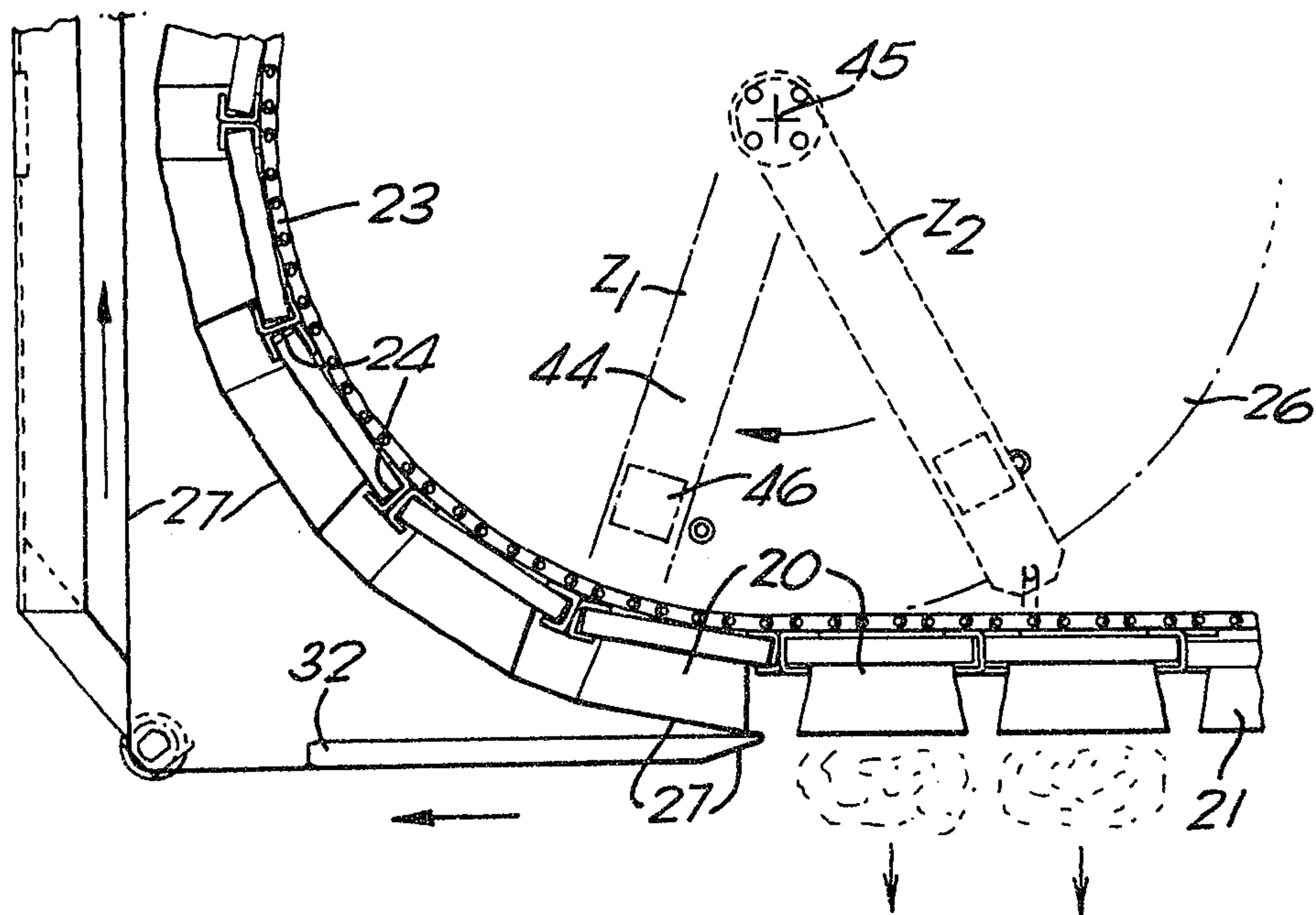


FIG. 9



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FIG. 11

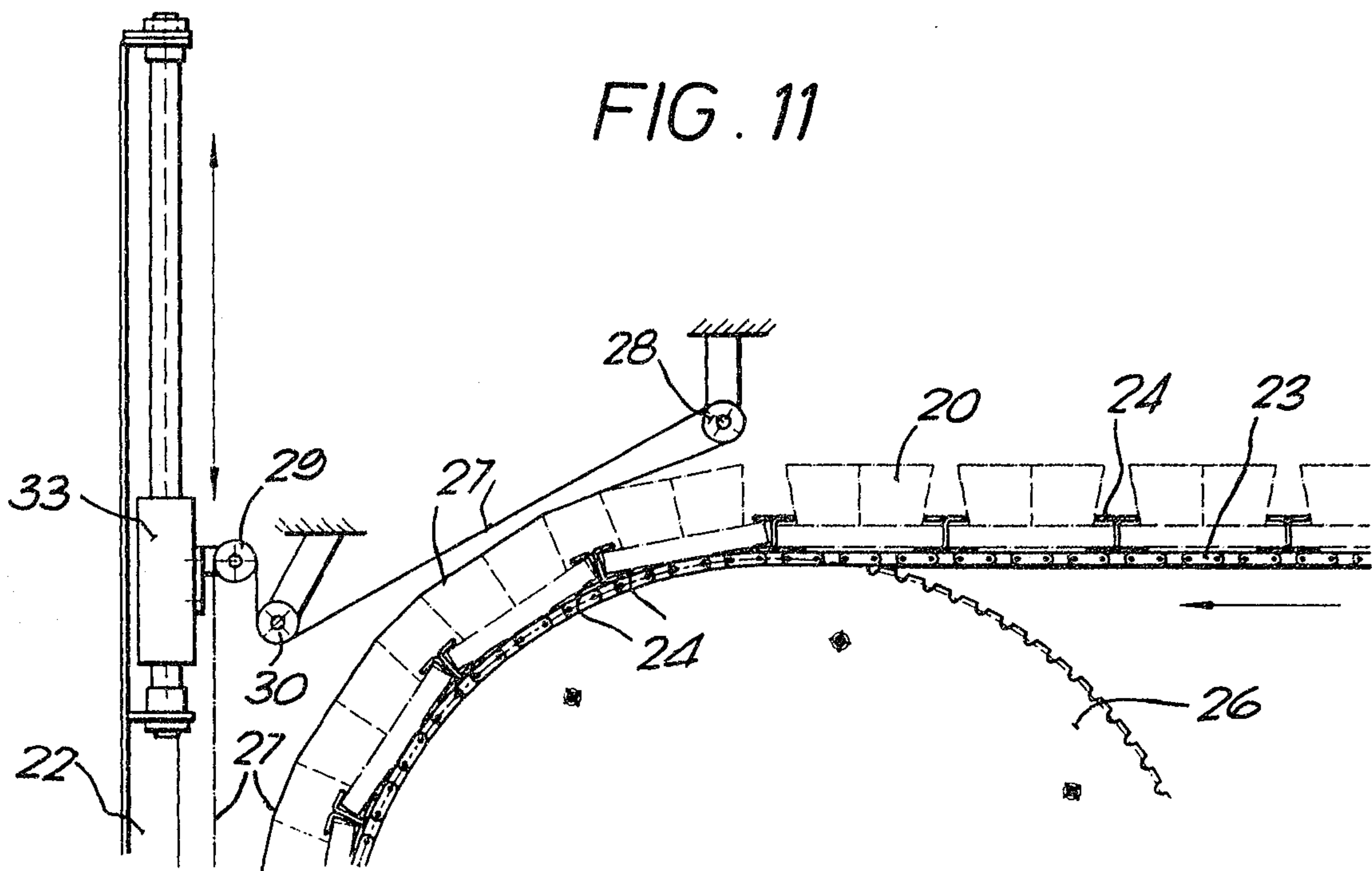
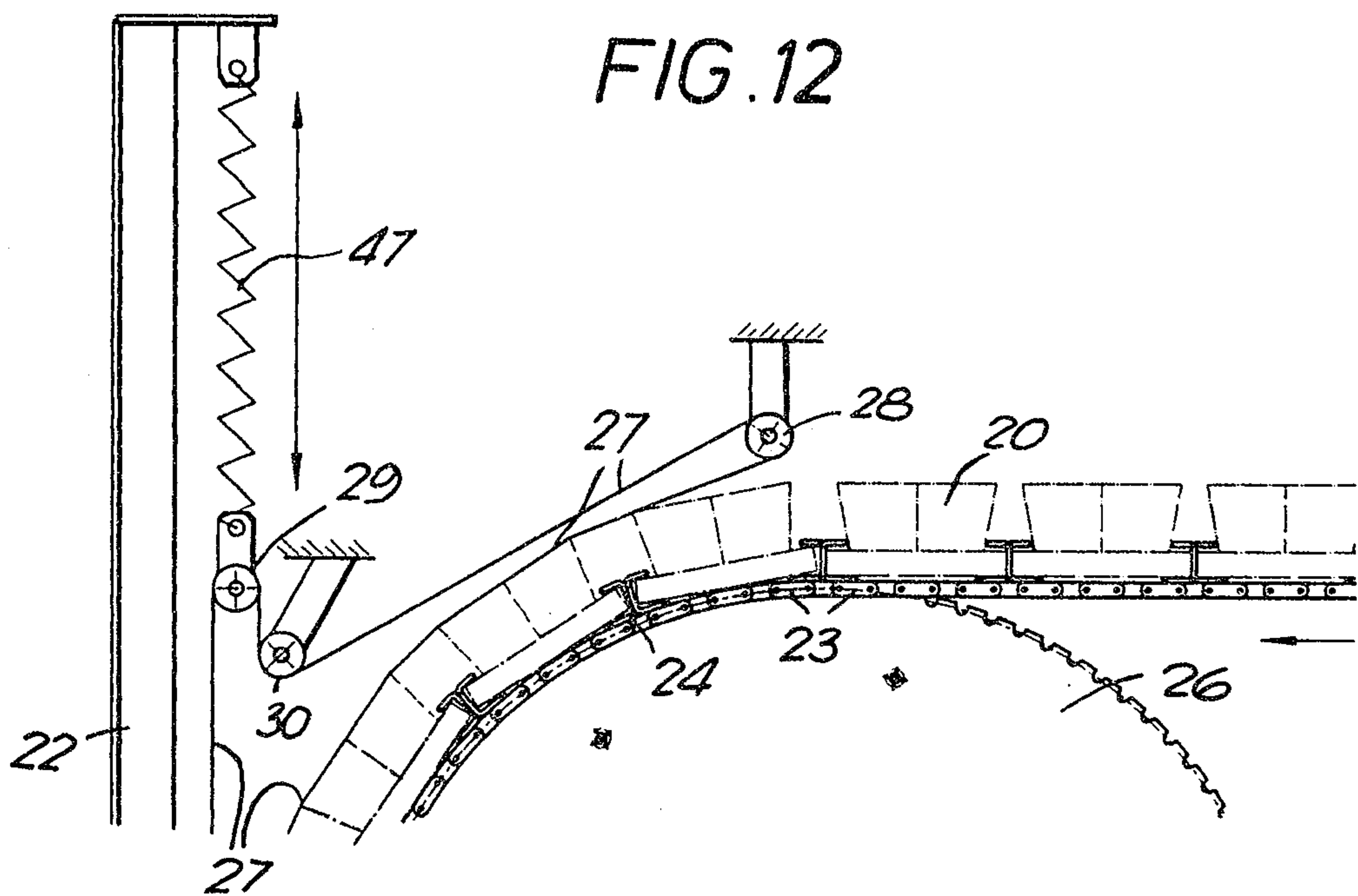
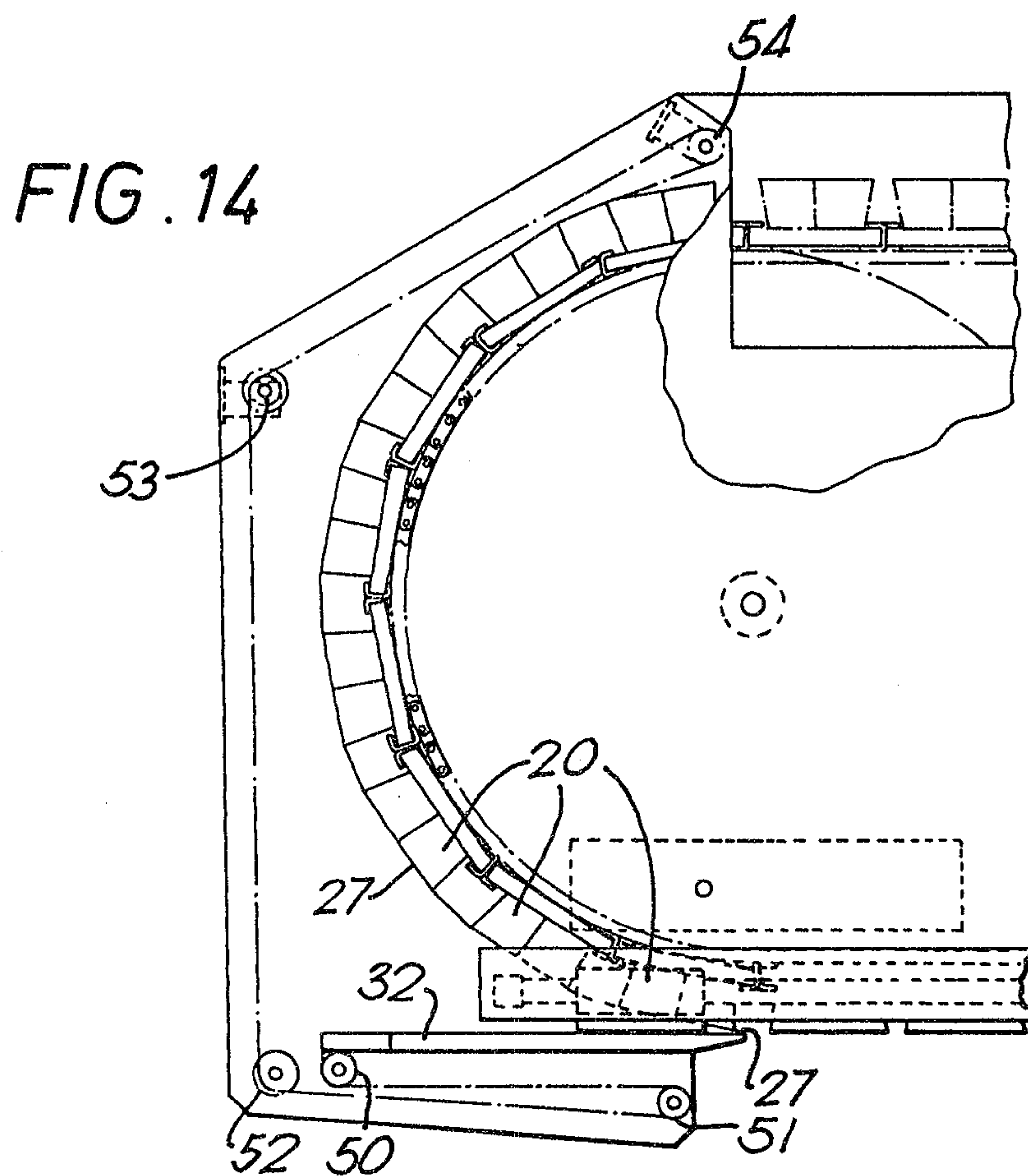
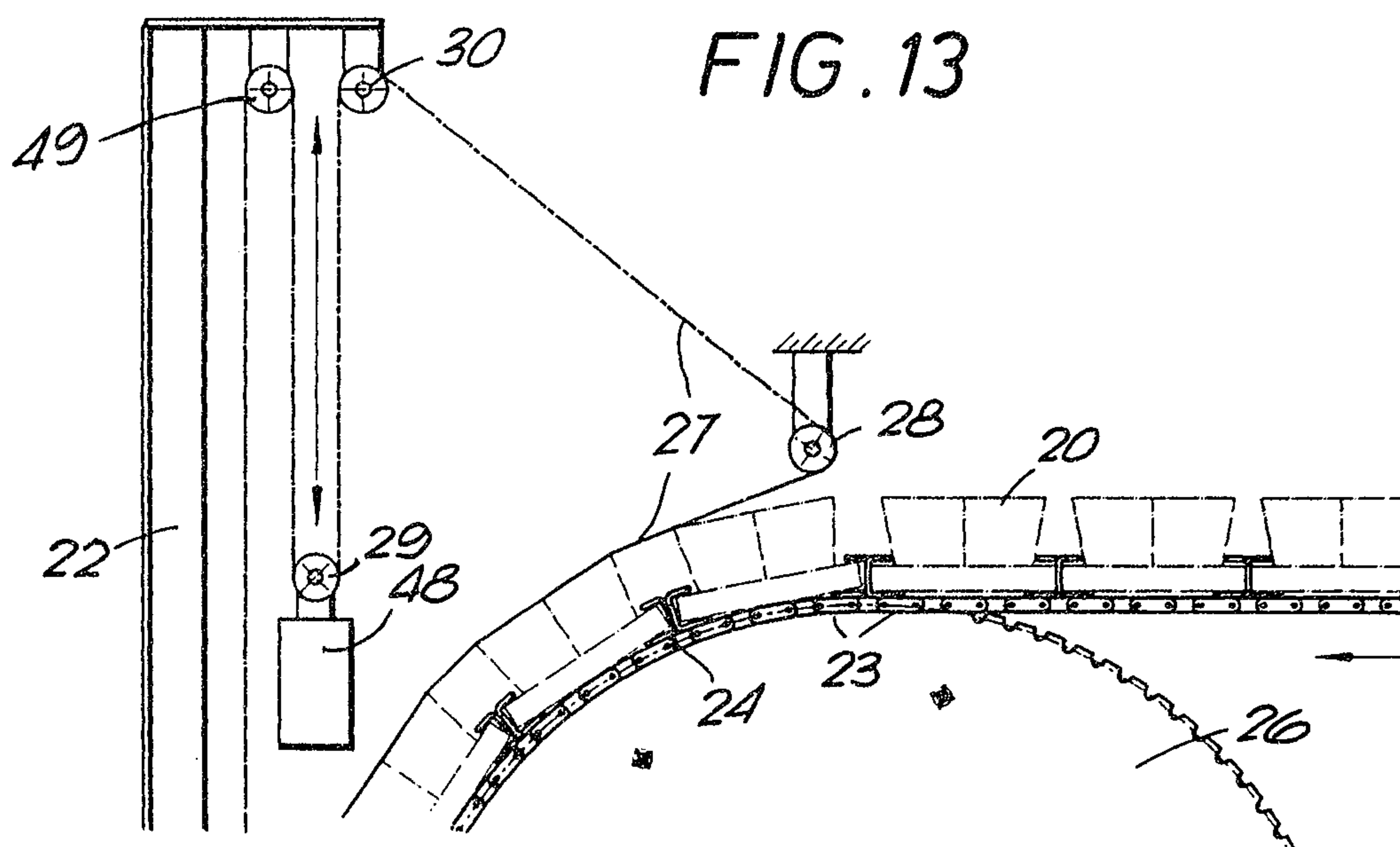


FIG. 12



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