

(19) World Intellectual Property Organization
International Bureau



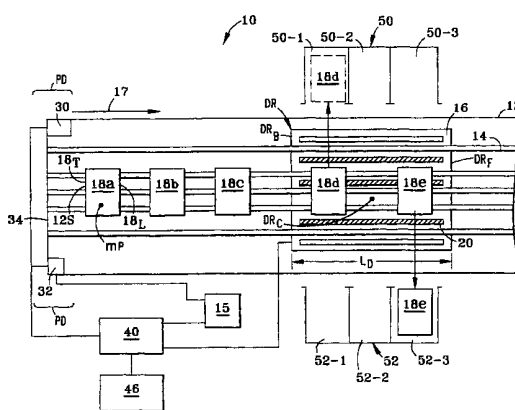
(43) International Publication Date
8 March 2001 (08.03.2001)

PCT

(10) International Publication Number
WO 01/16000 A2

- (51) International Patent Classification⁷: **B65G**
- (21) International Application Number: PCT/US00/18460
- (22) International Filing Date: 6 July 2000 (06.07.2000)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data:
09/347,765 6 July 1999 (06.07.1999) US
- (71) Applicant: **QUANTUM CONVEYOR SYSTEMS, LLC** [US/US]; 119 Rockland Avenue, Northvale, NJ 07647 (US).
- (72) Inventors: **LEM, Hans, J.**; 863 Pines Terrace, Franklin Lakes, NJ 07417 (US). **PONG, William**; 49 Buckmaster Drive, Concord, MA 01742 (US).
- (74) Agent: **MEIER, Lawrence, H.**; Downs Rachlin & Martin, PLLC, 199 Main Street, P.O. Box 190, Burlington, VT 05402-0190 (US).
- (81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CR, CU, CZ, DE, DK, DM, DZ, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, UZ, VN, YU, ZA, ZW.
- (84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).
- Published:**
— Without international search report and to be republished upon receipt of that report.
- For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(54) Title: MULTI-FIRE AND VARIABLE FIRE DIVERTER CONVEYOR SYSTEM AND METHOD



(57) Abstract: A conveyor system (10) for transporting items in a first direction and diverting the items to one of a plurality of stations (50, 52). The system comprises at least one diverter region (DR), and a diverter (16) arranged in the one of the at least one diverter regions. The diverter diverts the items transported by the conveyor in the first direction to one of the plurality of stations (50-1, 2, 3 and 52-1, 2, 3) adjacent said diverter that are spaced from one another in the first direction, when positioned in a diverter region of the conveyor, in response to a fire signal. The conveyor system further includes a source of destination information (46) identifying one of the plurality of stations to which the items transported by the conveyor are to be diverted. The conveyor system also includes a controller system (40) connected to the at least one diverter and the source for generating, and providing to said at least one diverter, a fire signal for each item transported by the conveyor based on destination information from the source regarding which one of the plurality of stations the item is to be diverted. Further, the conveyor system is capable of activating the diverter so as to divert items when the item is aligned with either a central axis (A) or a divert axis (B), as a function of item length L_I .



WO 01/16000 A2

MULTI-FIRE AND VARIABLE FIRE DIVERTER CONVEYOR SYSTEM AND METHOD

Field of the Invention

5 The present invention relates to conveyor systems and conveying methods and, in particular, to such systems and methods having a multi-fire mode of operation involving multiple diversion points on a single diverter, and a variable fire mode of operation involving a variable diversion point on a single diverter.

10 Background of the Invention

Conveyor sorting systems and methods for sorting items (e.g., packages) are common in the prior art. Conventional sorting is accomplished by providing a reader to read a preprinted code on an item to be sorted that has been placed onto the conveyor system, and thereafter activating an appropriate diverter in the proximity of the reader to cause
15 the item to be diverted from the conveyor to an adjacent station. An exemplary prior art sorting system is described in U.S. Patent No. 4,249,661 (the '661 patent). Other examples of high-speed sorting apparatus are disclosed in U.S. Patent Application Serial No. 08/797,025 and U.S. Patent Application Serial No. 08/752,587, which applications are hereby incorporated by reference.

20

It is often desirable to sort items traveling on a conveyor into different bins, stackers, conveyors or other devices, referred to generically herein as "stations," off to the side of the conveyer, depending on the nature of the item. Presently, this type of sorting is accomplished using a separate diverter for station, such as illustrated in FIG. 3 of the
25 '661 patent. However, the need for multiple diverters for such sorting increases the complexity and expense of the conveyer system.

It is also often desirable to sort items of various size based on their position relative to the diverter. For example, for relatively long items it is often desirable to divert the item
30 from the conveyor when its center in the long dimension reaches a mid-point of the diameter. Similarly, for relatively short items it is often preferable to activate ("fire") the

diverter when a different portion of the package (e.g., its leading edge) reaches the beginning of the diameter.

As described in U.S. Patents Nos. 3,242,342, 3,515,254 and 3,512,624, it is known to
5 divert packages from a conveyor when the center of the package reaches the mid-point of the diverter. It is also known to take various actions in a conveyor system as a function of the length of a package being conveyed. See U.S. Patent No. 3,680,692.

Unfortunately, it is believed no conveyor systems exist that determine the length of a package and then fire a diverter when a selected position on the package reaches a
10 selected position on the diverter as a function of the length of the package. As such, known conveyor systems are not particularly well adapted to conveying packages of widely varying lengths, with the result that packages are often mis-diverted, turned in an undesirable orientation or not diverted at all.

15 **Summary of the Invention**

The present invention relates to conveyor systems and methods, and in particular such systems and methods having a multi-fire operation involving multiple diversion points on a single diverter, and a variable fire operation involving a variable diversion point on a single diverter.

20 A first aspect of the invention is a diverter system for diverting items to one of a plurality of stations on either side of a conveyor. The diverter system is designed for use with a conveyor for transporting items in a first direction. The conveyor includes at least one diverter region in which the diverter system is positionable. The diverter system
25 comprises a diverter for diverting items transported by the conveyor in the first direction to one of a plurality of stations adjacent the diverter that are spaced from one another in the first direction, when positioned in a diverter region of the conveyor, in response to a fire signal. The diverter system also includes a source of destination information identifying one of the plurality of stations to which items transported by the conveyor are
30 to be diverted, and a controller system connected to the diverter and the source for generating, and providing to the diverter, a fire signal for each item transported by the

conveyor based on destination information from the source regarding the one of the plurality of stations to which the item is to be diverted.

5 A second aspect of the invention is a method of diverting an item traveling on a conveyor having a diverter and a plurality of stations adjacent the diverter onto one of the stations. The method comprising the steps of first, determining the item length L_1 of the item and an item tracking point on the item, then acquiring station destination information for the item identifying a one of the plurality of stations to which the item is to be diverted. Then, one of a distance or time for the item tracking point to align with the one station is
10 determined. Finally, the diverter is fired when the item tracking point aligns with the one station so as to divert the item to the one station.

A third aspect of the invention is a method of diverting an item traveling on a conveyor having a diverter to a station adjacent the conveyor, the station having a central axis and
15 a divert axis. The method comprising the steps of first, determining an item length L_1 , a leading edge position and a trailing edge position of the item, then comparing item length L_1 to a threshold length L_R , then, if $L_1 > L_R$, setting an item tracking point to be between the leading edge and the trailing edge position, and if $L_1 < L_R$, setting the item tracking point adjacent the leading edge, and then calculating one of a time or a distance for the
20 item tracking point to align with one of the station axis and the divert axis, then, if $L_1 > L_R$, firing the diverter when the item tracking point aligns with the central axis, and if $L_1 < L_R$, firing the diverter when the item tracking point aligns with the divert axis.

25 **Brief Description of the Drawings**

FIG. 1 is a schematic plan view of a conveyer system according to the present invention;

FIG. 2 is a schematic diagram of the controller unit for the conveyor system of FIG. 1;

30 FIG. 3 is a flow diagram setting forth the initial steps for controlling the operation of the conveyor system of FIG. 1;

FIG. 4 is a flow diagram setting forth the steps for determining the length of an item conveyed by the conveyor system of FIG. 1, and the position of its leading edge, trailing edge and mid-point;

5 FIG. 5 is a flow diagram setting forth the steps for implementing the multi-fire mode of operation with the conveyor system illustrated in FIG. 1;

FIG. 6 is a flow diagram setting forth the steps for implementing the variable fire mode of operation with the conveyor system illustrated in FIG. 1;

10

FIG. 7 is a schematic diagram of the conveyor system illustrating the diversion of an item in accordance with the variable fire mode of operation;

FIG. 8 is a flow diagram setting forth the steps for performing the enhanced diverting method according to the present invention, which involves both variable fire and multi-fire modes; and

15

FIG. 9 is a schematic diagram of a conveyor system of the present invention comprising multiple conveyor sections.

20

Detailed Description of the Invention

The present invention relates to conveyor systems and conveying methods and, in particular, to such systems and methods having a multi-fire mode of operation involving multiple diversion points on a single diverter, a variable fire mode of operation involving a variable diversion point on a single diverter and a combination of both.

25

With reference to FIG. 1, a first aspect of the invention is a conveyer system 10 comprising a frame 12 which supports a plurality of parallel conveyor belts 14 that move from left to right over the frame at a speed determined by a conveyor belt drive controller 15 operatively connected to the conveyor belts. System 10 further includes one or more diverter regions DR with a front edge DR_F , a back edge DR_B and a center DR_C , in which

30

is located a diverter 16 for diverting items 18, such as items 18a-18e, from the direction of travel of conveyor belts 14, as indicated by arrow 17. Diverter 16 includes a plurality of rollers 20 located between and parallel to belts 14. Rollers 20 are preferably disposed below the level of belts 14 and are capable of being raised to the level of belts 14 or slightly above, so as to engage one or more of items 18a-18e when one or more of the items needs to be diverted from conveyor 10, as described in more detail below. A suitable diverter 16 is disclosed in U.S. Patent Application Serial No. 08/797,025.

System 10 also includes a photodetector system PD arranged upstream of diverter 16 at or near an input end 34 of conveyor system 10 at a predetermined distance from diverter region DR. Photodetector system PD comprises a photodetector 30 on one side of frame 12 and a "tick" generator 32, shown located on the opposite side of the frame.

Photodetector 30 may be, for example, a diffuse photoeye. Tick generator 32 is in electrical communication with controller 15 and controller unit 40 (discussed below) and generates ticks corresponding to the speed of conveyor belts 14. Tick generator 32 may include, for example, a light source and a detector with a beam chopper disposed therebetween, with the beam chopper driven in proportion to the speed of conveyor belts 14. An exemplary tick generator 32 is made by Telemecanique (a division of Square D), model no. XUB-JO83135D. An exemplary photodetector 30 is a transmissive opto schmitt sensor made by Honeywell, model no. HOA0973-N55.

Tick generator 32 emits ticks, the timing of which is related to the speed of conveyor belts 14. Thus, each tick interval P corresponds to a distance of travel x of conveyor belts 14, e.g., one tick for each inch of travel, and hence the distance of travel of an item carried thereon. Thus, for n ticks, the distance of travel of an item down the conveyor is nx .

System 10 further includes a controller unit 40 in electrical communication with photodetector system PD, conveyor belt drive unit 15, diverter 16 and tick generator 32. A suitable controller unit 40 for the present invention may be the controller described in U.S. Patent Applications Serial Nos. 08/797,025 and 08/752,587. Controller unit 40

controls the functions and operation of conveyor apparatus 10 of the present invention, including diverter 16, as described in more detail below.

System 10 also includes destination information source 46, which is in electrical
5 communication with control unit 40. Destination information source 46 contains information regarding which diverter 16 in system 10 will be used to divert a given item 18 and, optionally, which station 50 and 52 (described below) adjacent the diverter will receive the item. Destination information source 46 may comprise a conventional
10 bar code reader system for detecting and decoding information contained in a bar code (not shown) applied to an item 18. Suitable known bar code reader systems are described in U.S. Patents Nos. 5,323,878, 5,412,196 and 5,412,197, which are incorporated herein by reference. Bar codes applied to items 18 may contain a unique identification code for the item, its final destination (e.g., shipping address of the party receiving the item), the
15 diverter 16 to be used to divert the item and, optionally, the station 50 or 52 within a given diverter to which the item is to be diverted.

Alternatively, destination information source 46 may include computer memory (not shown) for storing a sequence table that assigns a destination based on the order of
20 arrival of items at photodetector system PD. For example, if there is a conveyor system, such as multiple conveyor system 400 described below, where there are n diverters 16a, 16B...16n, the sequence table could be configured to send a first item to diverter 16a, a second item to diverter 16b, a third item to diverter 16c, a fourth item to diverter 16a, a fifth item to diverter 16b, etc. Alternatively, the sequence table could also be configured
25 to send the first three items to diverter 16a, the next three to diverter 16c, the next three to diverter 16c, the next three to diverter 16a, etc. In any event, destination information source 46 preferably comprises a lookup table that contains the above-described destination information for each item 18 being conveyed, or that will be conveyed, by
system 10.

30 Located adjacent conveyor system 10 on either side of diverter 16 are a plurality of stations 50 and 52, illustrated in FIG. 1 as including stations 50-1, 50-2, 50-3 and 52-1,

52-2, 52-3, respectively, arranged along the direction of travel on either side of the conveyor system, for receiving one or more items 18a-18e that are diverted from the conveyor system. Stations 50 and 52 may comprise, for example, a stacker, one or more bins, a conveyor or other known devices for receiving an item 18. While stations 50 and 52 have been illustrated in FIG. 1 to each have three stations, it is to be appreciated greater and lesser numbers of stations may be used.

With reference now to FIG. 2, controller unit 40 is now described in more detail. Controller unit 40 comprises a processor 60, a read-write memory 61, status lights 62, a signal generator 63, a battery 64, input/output (I/O) port 66 and an amplifier 67. Also included is at least one inflow bi-directional communications port 68 (68a, 68b) and corresponding outflow bi-directional communications port 70 (70a, 70b). The bi-directional communication ports 68 and 70 are preferably RS485 connectors with two RJ31X modular connections. Below is described in detail a conveyor system 400 made up of a plurality of conveyor systems 10. In this conveyor system 400, individual controller units 40 are interconnected to each other for bi-directional communication therebetween.

Controller unit 40 is powered in any of a number of ways. In one embodiment, electrical power is supplied to the controller via a cable interconnecting communication ports 68 and 70 of each controller unit. Thus, each controller unit 40 may be powered from a central source. The central power supply provides power in the range of from about 20 Vac to about 52 Vac and preferably is about 24 Vac or about 48 Vac. Alternatively, each controller unit 40 or a group of such controller units is connected to a power supply in the above voltage ranges.

Battery 64 is preferably a 3V Lithium coin cell or any long-life type battery known in the art. Battery 64 supplies backup power to read/write memory 61 in the event of a power failure, so that data is retained until power is restored. For a conveying or sorting system application, the information retained includes item tracking information and configuration parameters for conveyor system 10. Also included is information

concerning items 18 traversing the section of conveyor system 10 under the control of the controller unit 40, and any sorting or routing instructions for these items. Alternatively, or in addition to battery 64, controller 40 may use non-volatile memory of the type that retains information when there is a power failure.

5

Additionally, one or more external input devices 74 can be disposed along conveyor system 10 to sense the item being diverted or sorted. In this way, processor 60 can determine if a proper diversion was made or whether conveyor system 10 performed an incorrect diverting operation.

10

Processor 60 can thus evaluate these and other inputs to determine if conveyor system 10 is in a failed or faulted condition, and can provide an output indicating this failed condition to prevent further operation or action by the failed/faulted conveyor system.

15 Processor 60 preferably includes a non-volatile random access memory (NVRAM) 76, an EEPROM 78, and a central processing unit (CPU) 80. The applications program or software routines for operating conveyor system 10 are preferably stored in EEPROM 78, which is easily removed in the field for replacement. The configuration parameters preferably are stored in NVRAM 76 so they are easily changed in the field, particularly
20 by the user.

NVRAM 76 stores data and any parameters required for the operation and/or configuration of each controller unit 40. For example, the data regarding items in an area or section under the control of a given controller unit 40, and any related tracking and
25 routing data for each of these items is stored in the NVRAM. Further, the configuration parameters required to enable the control routines for a given section type of a conveying system are also stored therein.

A suitable CPU 80 is a PIC17C43 by MicroChip Corp., and alternatively may be
30 PIC17C44 by MicroChip Corp. The software routines stored in EEPROM 78 are loaded

into CPU 80 and specific routines are enabled by means of the configuration parameters retrieved from NVRAM 76.

5 With reference to FIGS. 1-3, the operation of conveyor system 10 according to a first aspect of the present invention is now described. The operation steps described below are implemented via a software program preferably stored in EEPROM 78 which is executed by CPU 80 in combination with NVRAM 76. As those skilled in the art will appreciate, the operational steps described below may be implemented with one of a variety of programming languages. In the first step 102, one of items 18a-18e is placed
10 onto the conveyor belts 14 at input end 34. Next, in step 104, photodetector system PD detects the presence of item 18 as it passes therethrough. Based on information provided by photodetector system PD, controller unit 40 determines the length L_1 of item 18 in the direction of travel of conveyor belts 14, represented by arrow 17, and the relative positions of the item's leading edge 18_L , trailing edge 18_T , and/or mid-point MP (see item
15 18a in FIG. 1).

Referring now to also to FIG. 4, step 104 itself includes a number of steps 104a - 104e pertaining to how the length L_1 of items 18 and the item's leading edge 18_L , trailing edge 18_T , and/or mid-point MP are determined. The position of item 18 relative to a point
20 on conveyor system 10 (e.g., input end 34) is continuously updated as the item travels down the conveyor system, as described below.

In step 104a, as item 18 passes photodetector PD a light signal is reflected from the item and received by the photodetector 30, causing the signal to go high for N ticks
25 (alternatively, the signal could go low). Next, in step 104b, photodetector 30 transmits an electrical signal to controller unit 40 indicating the presence of item 18, i.e., a high signal, while tick generator 32 continuously transmits a pulse train of ticks to controller 40. Then, in step 104c, based on the signals transmitted in step 104b, controller unit 40 calculates the length L_1 of the item 18 along its direction of travel by multiplying the
30 number of ticks, during the time the output of photodetector 30 indicates the presence of an item, by the distance of travel per tick x , i.e., $L_1 = Nx$. For example, controller unit 40

may be programmed to interpret one tick as equivalent to one inch of travel, plus or minus ten percent. The actual conversion factor may vary because of mechanical tolerance build-up. In practice, the conversion factor may be measured via observation after the conveyor system is assembled.

5

Also, it will be apparent to one skilled in the art that either a time-based or distance-based calculation may be used in implementing the present invention. It may be preferable in some instances to use a distance-based calculation, because the conveyor belts 14 could stop for periods of time. In this case, tick generator 32 would stop
10 generating ticks. On the other hand, the time-based calculation can be suspended when there is no movement of items 18 down conveyor system 10. Accordingly, the present invention is not limited to either a time-based or a distance-based calculation in its implementation.

15 Next, in step 104d, controller unit 40 also calculates the position of leading edge 18_L , trailing edge 18_T , and/or mid-point MP of item 18, as selected, passing through photodetector system PD relative to the photodetector system. This is accomplished by noting the arrival of the leading edge 18_L and counting the number of ticks until trailing edge 18_T or mid-point MP of the item passes through photodetector system PD. This
20 number is N, as discussed above. The distance the leading edge 18_L of item 18 has traveled down conveyor system 10 is equal to the length $L_1 = N \times$ when the moment the leading edge of the item passes photodetector system PD. The position of the leading edge and trailing edge of item 18 is continuously updated as the item travels down conveyor system 10 at a fixed rate of speed s. Thus, tick generator 32 (or signal
25 generator 63) provides a signal at an interval t that is used in calculating the distance an item 18 travels. Controller unit 40 determines the distance X an item 18 has traveled at any instant by counting the number of ticks emitted from tick generator 32, so that $X = s(nt)$. Controller unit 40 maintains an array of data records for each item 18 under its control. These records correlate an item 18 identification with the item's position.
30 Further, controller unit 40 is programmed with the number of ticks between a reference

point on conveyor system 10 and various points along the direction of travel of an item, such as back edge DR_B , front edge DR_F , or points therebetween.

5 Finally, in step 104e, the position X_{MP} of the mid-point of item 18 is calculated and tracked as the item travels down the conveyor. Position X_{MP} of the mid-point is simply half-way between the leading and trailing edge locations of item 18, as ascertained above. If the leading and trailing edge positions as a function of time relative to a reference point on conveyor system 10 are $X_{LE}(t)$ and $X_{TE}(t)$, respectively, then the location of the item's mid-point as a function of time is $X_{TE}(t) + L_i/2$, or $X_{LE}(t) - L_i/2$. If
10 the variable fire functionality of conveyor system 10, described below, is not used, step 104e may be omitted.

With reference again to FIG. 3, at step 106, destination information is acquired by control unit 40 for an item 18 from destination information source 46. As noted above, this
15 information includes the diverter 16 to be used to divert the item and, optionally, the station 50 or 52 to which the item is to be diverted.

Multi-fire Mode

With continuing reference to FIG. 3 and flow diagram 100, at query step 110, a
20 determination is made whether system 10 is to be operated in a multi-fire mode, a variable fire mode or both. The multi-fire mode is used when it is desired to divert items 18 to different stations within stations 50 or 52 in a given diverter 16, such as stations 50-1 to 50-3 and/or stations 52-1 to 52-3. The multi-fire mode of operation provides greatest benefit when length L_i of items 18 is significantly less than the length
25 L_D of diverter 16.

The multi-fire mode of operation is described with reference again to FIG. 1 and also to flow diagram 120 of FIG. 5, which is a continuation of flow diagram 100 of FIG. 3. In step 122, a station and station destination is retrieved for the item (e.g., item 18d to
30 station 50-1) based on information contained in destination information source 46. This information is provided to controller unit 40. Controller unit 40 also includes

information pertaining to the distance from input end 34 of conveyor system 10 (or any other fixed location on the conveyor system) to positions along the length of each diverter 16 (in the direction of arrow 17) where a corresponding respective station 50 or 52 is located. This information may be in the form of the number of ticks, which
5 represent a given distance as discussed above.

Next, at step 124, controller unit 40 calculates the amount of time or distance (number of ticks) it takes either the leading edge 18_L , mid-point MP, trailing edge 18_T or other point (such points are hereinafter referred to generally as item tracking point 125, e.g., trailing
10 edge 18_T of item 18a) after passing through photodetector system PD to reach alignment with the selected station 50 or 52 to which the item 18 is to be diverted. This calculation may be made by controller unit 40 in absolute time units or in terms of distance based on the number of ticks emitted by tick generator 32 during the period when item tracking
15 point 125 of item 18 travels from a given reference point, e.g., leading edge 34, on conveyor system 10 to the position in diverter 16 adjacent a selected station 50 or 52. Controller unit 40 then generates a diverter fire signal based on this calculation which is provided to diverter 16. This diverter fire signal contains information that directs
diverter 16 when to fire.

20 In practice, calculation of a diverter fire signal may simply consist of controller unit 40 referencing predetermined distances or ticks between stations 50 and 52 stored in destination information source 46 or EEPROM 78. For example, a diverter 16 may be spaced the distance represented by 300 ticks provided by tick generator 32 from leading
edge 34 of conveyor system 10. Each station 50 or 52 may be spaced from adjacent
25 stations by the distance represented by 12 ticks. Controller unit 40 counts down such tick amount beginning when an item tracking point passes a reference point on conveyor system 10, e.g., photodetector 30 or a station 50 or 52. When such tick count is completed this defines when the item tracking point has arrived at a location where it is intended diverter 16 should fire. At such location, controller unit 40 queries destination
30 information source 46 to assess if controller unit 40 should provide a diverter fire signal

to diverter 16. If so, a fire signal is provided. If not, a new tick count is retrieved and a new tick countdown commences.

In step 126, pursuant to information in the diverter fire signal provided by controller unit
5 40, the diverter fires. This diverts the item 18 into its assigned station 50 or 52. This firing step involves diverter 16 operating, e.g., by initiating rotation of rollers 20 in the appropriate direction, and raising the rollers above the level of belts 14, so as to divert the item 18. For example, in FIG. 1, item 18d is shown being diverted into its assigned station 50-1 on one side of the conveyor, and item 18e is shown being diverted into its
10 assigned station 52-3 on the other side of the conveyor at a location downstream from station 50-1.

Variable Fire Mode

With reference again to FIG. 3 and flow diagram 100, if at query step 110 the variable
15 fire mode is selected, then the operation of conveyor system 10 is controlled in accordance with flow diagram 140 illustrated in FIG. 7. The variable fire mode of operation involves diverting an item 18 from conveyor system 10 when item tracking point 125 reaches a selected position along the length of diverter 16 as a function of the item length L_1 .

20 Accordingly, with reference to FIGS. 1, 3, 6 and 7, to facilitate description of the variable fire mode of operation there is shown a conveyor system 130 which is identical to conveyor system 10 of FIG. 1, described above, except that stations 50 and 52 have been replaced with a station 137 having a central axis A, the station being arranged adjacent
25 frame 12 next to diverter region DR.

Assuming the query at step 110 results in selection of the variable fire option, operation of conveyor system 10 proceeds in accordance with the steps of flow diagram 140. At
30 step 141, a determination is made whether length L_1 of item 18 is greater than a predetermined reference length L_R . The latter may be equal to the length L_D of diverter region DR, or may be of greater or lesser length, as those of ordinary skill in the art may

readily determine by routine testing. If item 18, e.g., item 18' in FIG. 7, has a length L_1 greater than L_R , then in step 142 controller unit 40 sets a selected item tracking point 125 as the point of item 18' to be aligned with central axis A when the diverter 18 is fired. In the immediately following discussion item tracking point 125 is assumed to be mid-point MP, for the sake of simplicity.

Next, in step 144, based on the speed of travel of item 18, controller unit 40 calculates the distance to be traveled (in ticks), or time it takes, for mid-point MP of item 18, determined at step 104, to align with central axis A of station 137. Central axis A is at or near the mid-point of diverter 16, as measured in the direction of arrow 17. Based on this determination, controller unit 40 generates a diverter fire signal provided to diverter 16 in response to this timing information. More specifically, the timing of the diverter fire signal may be calculated by determining the number of ticks generated by tick generator 32 it takes for item mid-point MP to travel to central axis A. In step 146, when such alignment occurs, diverter 16 fires, thereby diverting item 18 to station 137. This allows a large package to be diverted to a station 137 without being twisted or spun.

While it is often preferred to fire diverter 16 when an item 18 having a length L_1 that is $> L_R$ is positioned so that its mid-point MP is aligned with central axis A, the present invention is not so limited. At step 142, the item tracking point 125 may be set at any point between leading edge 18_L and trailing edge 18_T of item 18'. This is accomplished by controller unit 40 performing a calculation, in accordance with user input, that sets the item tracking point 125 at any selected location between leading edge 18_L and trailing edge 18_T . For example, to establish an item tracking point 125 that is directly in between leading edge 18_L and mid-point MP, controller unit 40 takes the average of the position of leading edge 18_L and mid-point MP.

In the next step 144, controller unit 40 calculates the distance to be traveled (in ticks) or time for the selected item tracking point 125 to align with the station central axis A. In step 146, when such alignment occurs, diverter 16 fires in response to a fire signal generated by controller unit 40, thereby diverting item 18' to station 137.

With continuing reference to FIG. 6, if at step 141 it is determined that item 18 has a length L_1 that is not $> L_R$, then operation of conveyor system 130 proceeds to step 152. There, item tracking point 125 is set, preferably at or near leading edge 18_L . Next, at step 154, controller unit 40 calculates the distance to be traveled (in ticks) or the time required for the item tracking point 125 to align with divert axis B, as described above in connection with the description of such time calculation with respect to central axis A. Typically, but not necessarily, divert axis B is not coincident with central axis A, and is usually positioned closer to back edge DR_B of diverter 16 than central axis A. The exact position of divert axis B will vary as a function of the speed of conveyor system 130, the weight and size of item 18" and other factors, and may be readily determined by those of ordinary skill in the art through routine experimentation. Finally, at step 156, diverter 16 is fired in accordance with a fire signal received from controller unit 40, which such unit generates based on the distance or time calculation described above.

The concept of variable diversion is of particular importance for high-speed conveyors. For example, when a relatively small item 18, such as item 18", travels on a high-speed conveyor, it acquires a momentum $P = mv$, where m is the mass of the package and v is its velocity. Because of this momentum, item 18 may follow a curved path when it is diverted from the conveyor system 10 or 130. Accordingly, it is necessary to fire diverter 16 so that the curved path along which item 18 travels when diverted results in the items being appropriately positioned on station 137.

Enhanced diverting method

The multi-fire variable modes of operation were described above as separate operations to facilitate description of the invention. However, these two methods are combinable in a single enhanced diverting method. With reference again to FIGS. 1-3 and 8, if at step 110 (FIG. 3) a determination is made to select both multi-fire and variable fire modes of operation, then the operation of controller system 10 proceeds in accordance with the steps of flow diagram 300. The steps of flow diagram 300 comprise a combination of various steps of the flow diagrams earlier described.

First, in step 302, the item length L_1 is determined, as described above in connection with step 104. Next, in query step 304, the item length L_1 is compared to reference length L_R , as described above in connection with step 141. For example, the latter may be set to be substantially equal to length L_D of diverter 16, to $L_D/2$ or to another value. If the item

5 length L_1 is longer than reference length L_R , then the method proceeds to step 306, where item tracking point 125 is set at a selected point on item 18 between its leading edge 18_L and trailing edge 18_T , often adjacent mid-point MP, as described above in connection with step 142. If at step 304 item length L_1 is not $>L_R$, then the process continues to step 308. There, item tracking point 125 is set, typically proximate leading edge 18_L , as

10 described above in connection with step 152. After both steps 306 and 308, the process proceeds to step 310 where one of stations 50 and 52 and associated stations on diverter 16 is retrieved, as described above in connection with step 122. Then, at step 312, the distance to be traveled or amount of time required for the selected item tracking point 125 to become aligned with the assigned station 50 or 52 is calculated, as

15 described above in connection with step 124. Finally, at step 312, diverter 16 fires when the selected item tracking point 125 is aligned, pursuant to a diverter fire signal provided by controller unit 40.

Multiple conveyor system

20 With reference now to FIG. 9, a conveyor system 400 according to a second aspect of the invention is now described. Conveyor system 400 includes n conveyor sections 10a, 10b, ...10n arranged in series, with each equivalent to a single conveyor system 10, described above. Each section 10a, 10b, ...10n also includes a photodetector system PDa, PDb, ...PDn, respectively, and a diverter 16a, 16b, ...16n, respectively, and controller units

25 40a, 40b, ...40n, respectively. In conveyor sections 10a-10n, destination information source 46 is not required, but is included in conveyor system 400, as discussed below. In addition, controller units 40a, 40b, ...40n are connected to form what is effectively a single controller unit 410 for system 400. Controller units 40a, 40b, ...40n are in electrical communication with a host controller 412. Associated with sections 10a,

30 10b, ...10n are stations 50a, 50b, ...50n, and stations 52a, 52b, ...52m, respectively. Thus, conveyor system 400 is a modular conveyor system.

During set-up of conveyor system 400, the relative distances between diverters 16a, 16b,...16n is programmed into each controller unit 40a, 40b,...40n. This information is generated by determining the distance from the beginning of a conveyor section, e.g., 10a, to the location of a diverter 16a, 16b,...16n, and the distance between conveyor sections. The distance between diverter 16a, 16b,...16n is used to time the firing of the diverters. This distance may be represented in the form, the number of ticks, or timing signals generated by signal generator 63 in host controller 412. In any event, a signal representative of distance between diverters is sent to all controller units 40a, 40b,...40n so that a universal reference is established.

10

For a more detailed description of conveyor system 400, attention is directed to U.S. Patent Applications Serial Nos. 08/797,025 and 08/752,578, which contain a description of suitable modular conveyor controller systems.

15

In operation, an item 18 enters conveyor section 10a at input end 34. As described above, as item 404 passes photodetector system PDa, it is assigned a station to which it is to be diverted from information obtained by host controller 412 from destination information source 46 in electrical communication therewith. This diversion might involve the multi-fire mode of operation, the variable fire mode of operation, or both.

20

This information is passed from host controller 412 to first control unit 40a. If item 18 is to be diverted to, for example, to station 52n, then item 18 needs to be conveyed from section 10a to section 10n without being diverted. To accomplish this, controller unit 40a passes the diverting information pertaining to item 18 to controller unit 40b, which in turn passes this information to the next controller unit, until the information reaches controller unit 40n. In other words, the responsibility for diverting item 18 is transferred in daisy chain fashion until it reaches the controller unit 40m for the section 10n in which the item 18 is to be diverted.

25

Controller units 40a-40n are preferably interconnected to each other for communication by appropriately interconnecting the inflow and outflow bi-directional communications ports 68 and 70 of adjacent controller units. Controllers 40a-40n are preferably

30

connected to each other using a “daisy chain” topology, e.g., by interconnecting to an outflow bi-directional communications port 70a of controller unit 40a and into an inflow bi-directional communications port 68b of second controller unit 40b. Thus, a bi-directional communications link is established between all controller units 40a to 40n for the communication of data and information therebetween. Such interconnection and bi-directional communication is also described in more detail in connection with the controller system described in U.S. Patent Applications Nos. 08/752,587 and 08/797,025.

10 While the present invention has been described in connection with preferred embodiments, it will be understood that it is not so limited to those embodiments. On the contrary, it is intended to cover all alternatives, modifications, and equivalents as may be included within the scope of the invention as defined in the appended claims

What is claimed is:

- 1 1. A diverter system for diverting items to one of a plurality of stations, the diverter
2 system designed for use with a conveyor for transporting items in a first direction,
3 the conveyor having at least one diverter region in which the diverter system is
4 positionable, the diverter system comprising:
 - 5 a) a diverter for diverting items transported by the conveyor in the first
6 direction to one of a plurality of stations adjacent said diverter that are
7 spaced from one another in the first direction, when positioned in a
8 diverter region of the conveyor, in response to a fire signal;
 - 9 b) a source of destination information identifying one of the plurality of
10 stations to which items transported by the conveyor are to be diverted; and
 - 11 c) a controller system connected to said diverter and said source for
12 generating, and providing to said diverter, a fire signal for each item
13 transported by the conveyor based on destination information from said
14 source regarding one of the plurality of stations to which said item is to be
15 diverted.

- 1 2. A conveyor system for transporting items in a first direction and diverting the
2 items to one of a plurality of stations, the system comprising:
 - 3 a) a conveyor having at least one diverter region;
 - 4 b) a plurality of stations adjacent said at least one diverter region that are
5 spaced from one another in the first direction;
 - 6 c) at least one diverter, arranged in said at least one diverter region, for
7 diverting each item transported by said conveyor in the first direction to
8 one of said plurality of stations in response to a fire signal;
 - 9 d) a source of destination information identifying one of the said plurality of
10 stations to which each item transported by the conveyor is to be diverted;
11 and
 - 12 e) a controller system connected to said at least one diverter and said source
13 for generating, and providing to said at least one diverter, a fire signal for

14 each item transported by the conveyor based on destination information
15 from said source.

1 3. A diverter system for diverting items to a station, the diverter system designed for
2 use with a conveyor for transporting items in a first direction, the conveyor
3 having at least one diverter region in which the diverter system is positionable,
4 the diverter system comprising:

- 5 a) a diverter for diverting items transported by the conveyor in the first
6 direction to a station adjacent said diverter, when positioned in a diverter
7 region of the conveyor, in response to a fire signal, said diverter having a
8 central axis and a divert axis;
- 9 b) an item measuring system for generating information representative of the
10 length of items transported by the conveyor and for providing a length
11 signal based on said information for each item indicating the length of the
12 item; and
- 13 c) a controller system connected to said diverter and said item measuring
14 system for generating a fire signal for each item and providing it to said
15 diverter, wherein said fire signal for each item is generated as a function
16 of said length signal for said item so that said fire signal causes said
17 diverter to divert items that are less than said first length substantially
18 when a first item tracking point on the item arrives at said divert axis and
19 for diverting items that are greater than said first length substantially when
20 a second item tracking point on the item substantially arrives at said
21 central axis.

1 4. A conveyor system for transporting items in a first direction and diverting the
2 items to a station, comprising:

- 3 a) a conveyor having at least one diverter region;
- 4 b) at least one station adjacent said at least one diverter region;
- 5 c) a diverter for diverting items transported by the conveyor in the first
6 direction to said at least one station arranged adjacent said diverter, in

- 7 response to a fire signal, said diverter having a central axis and a divert
8 axis;
- 9 c) an item measuring system for generating information representative of the
10 length of items transported by the conveyor and for providing a length
11 signal based on said information for each item indicating the length of the
12 item; and
- 13 d) a controller unit connected to said diverter and said item measuring
14 system for generating a fire signal for each item and providing it to said
15 diverter, wherein said fire signal for each item is generated as a function
16 of said length signal for said item so that said fire signal causes said
17 diverter to divert items that are less than said first length substantially
18 when a first item tracking point on the item arrives at said divert axis and
19 for diverting items that are greater than said first length substantially when
20 a second item tracking point on the item arrives at said central axis.

- 1 5. A method of diverting an item traveling on a conveyor having a diverter and a
2 plurality of stations adjacent the diverter onto one of the stations, the method
3 comprising the steps of:
- 4 a) determining the item length L_1 of the item and an item tracking point on
5 the item;
- 6 b) acquiring station destination information for the item identifying a one of
7 the plurality of stations to which the item is to be diverted;
- 8 c) determining one of a distance or time for the item tracking point to align
9 with said one station; and
- 10 d) firing the diverter when the item tracking point aligns with said one
11 station so as to divert the item to said one station.

- 1 6. A method according to claim 4, wherein said step a) includes the steps of:
2 a) generating N ticks, with each tick corresponding to a distance of travel x
3 of the conveyor;

- 4 b) passing the item through a detection system capable of providing a first
5 signal indicating the presence of the item; and
6 c) calculating said item length by the relationship $L_1 = Nx$, wherein N equals
7 the number of ticks generated during the period said first signal indicates
8 the presence of the item.

- 1 7. A method of diverting an item having a leading edge and a trailing edge, and
2 traveling on a conveyor having a diverter to a station adjacent the conveyor, the
3 station having a central axis and a divert axis, the method comprising the steps of:
4 a) determining an item length L_1 ;
5 b) comparing said item length L_1 to a threshold length L_R ;
6 c) if $L_1 > L_R$, setting an item tracking point to be between the leading edge
7 and the trailing edge position, and if $L_1 < L_R$, setting said item tracking
8 point adjacent the leading edge;
9 d) calculating one of a time or a distance for said item tracking point to align
10 with one of said station axis and said divert axis; and
11 e) if $L_1 > L_R$, firing said diverter when said item tracking point aligns with
12 said central axis, and if $L_1 < L_R$, firing said diverter when said item
13 tracking point aligns with said divert axis.

- 1 8. A method according to claim 7, wherein said step a) includes the steps of:
2 a) generating N ticks, with each tick corresponding to a distance of travel x
3 of the conveyor;
4 b) passing the item through a detection system capable of providing a first
5 signal indicating the presence of the item;
6 c) calculating said item length via $L_1 = Nx$, wherein N equals the number of
7 ticks generated during the period said first signal indicates the presence of
8 the item.

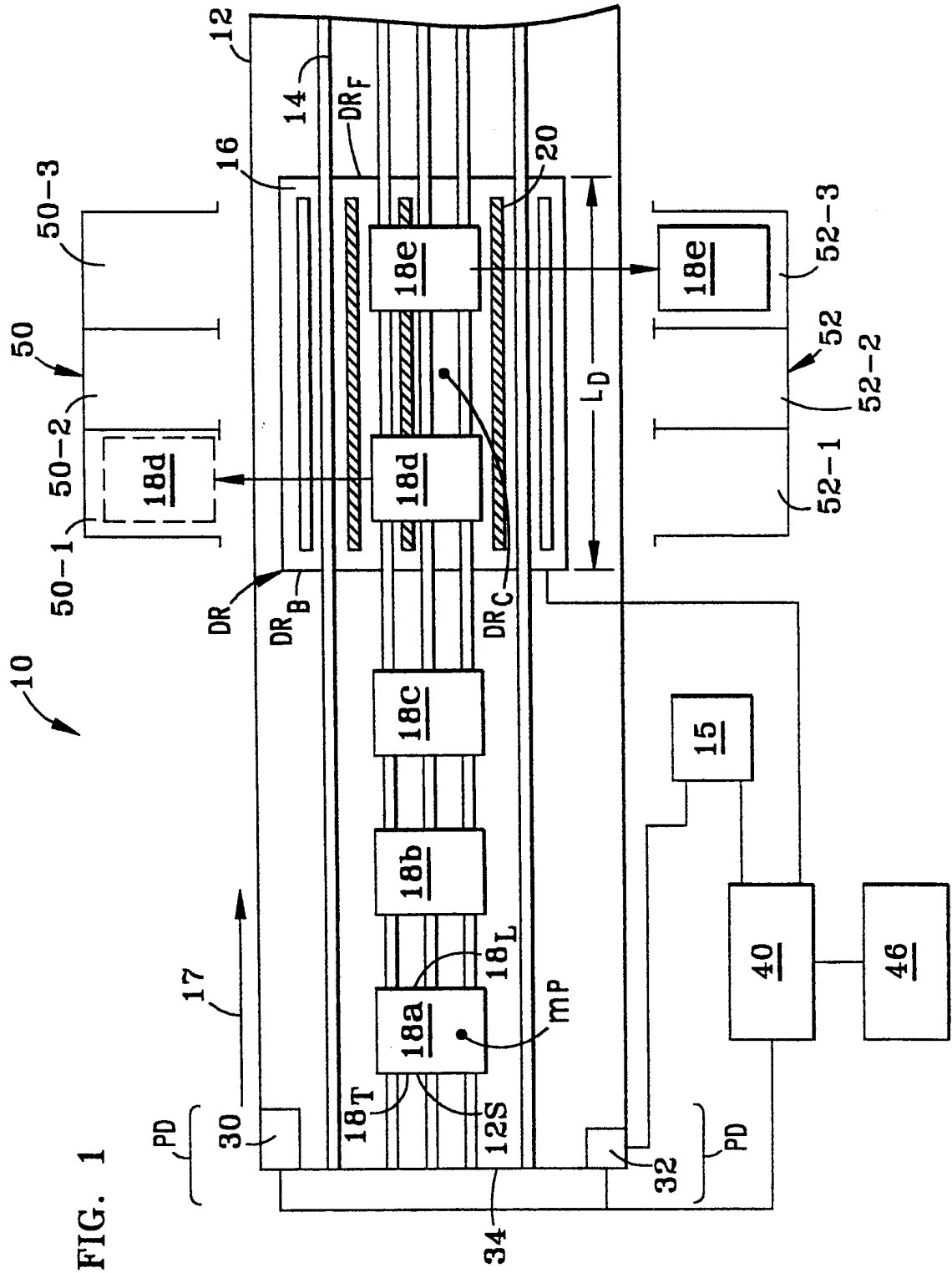


FIG. 1

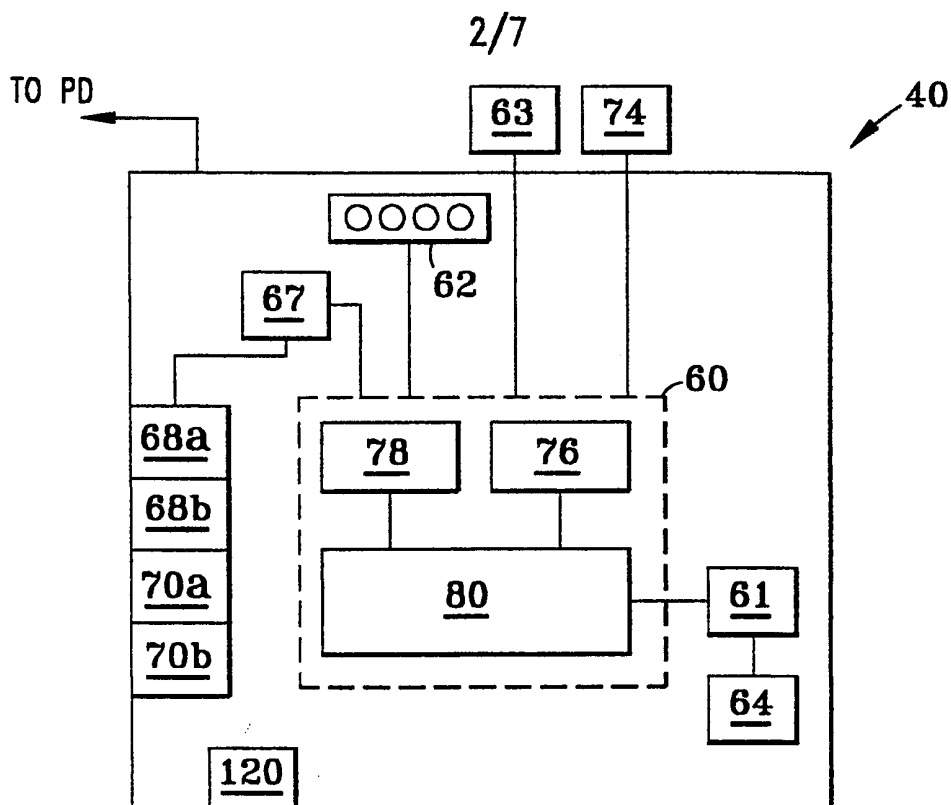


FIG. 2

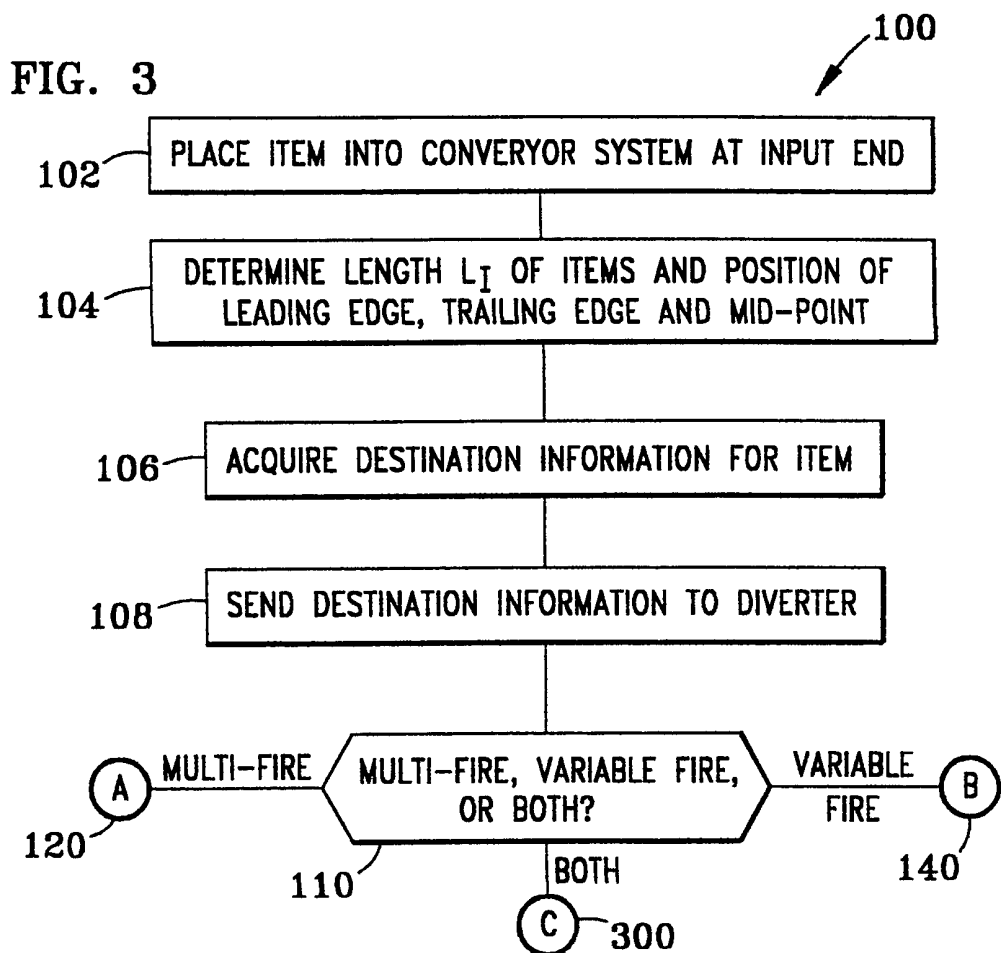


FIG. 3

3/7

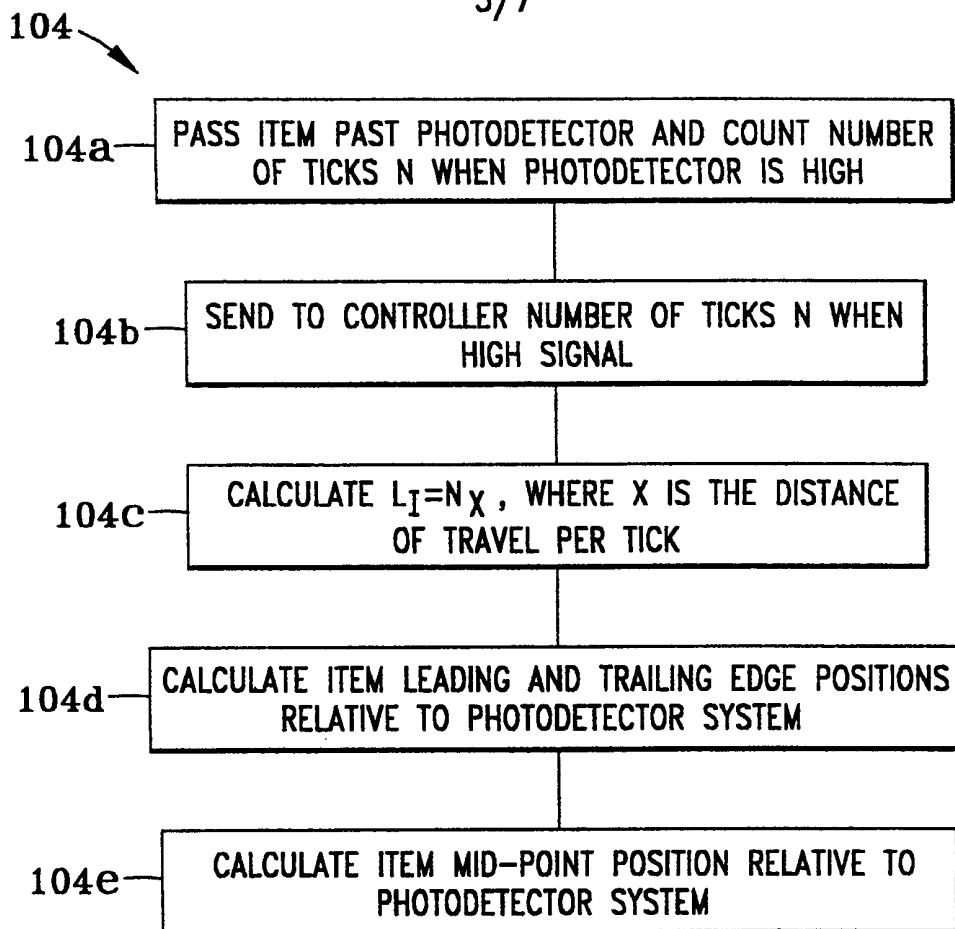


FIG. 4

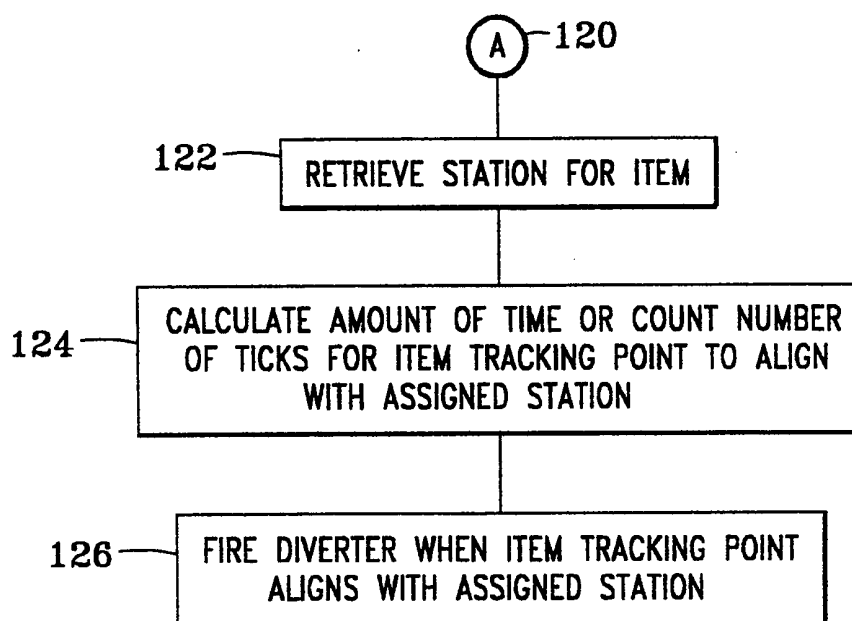


FIG. 5

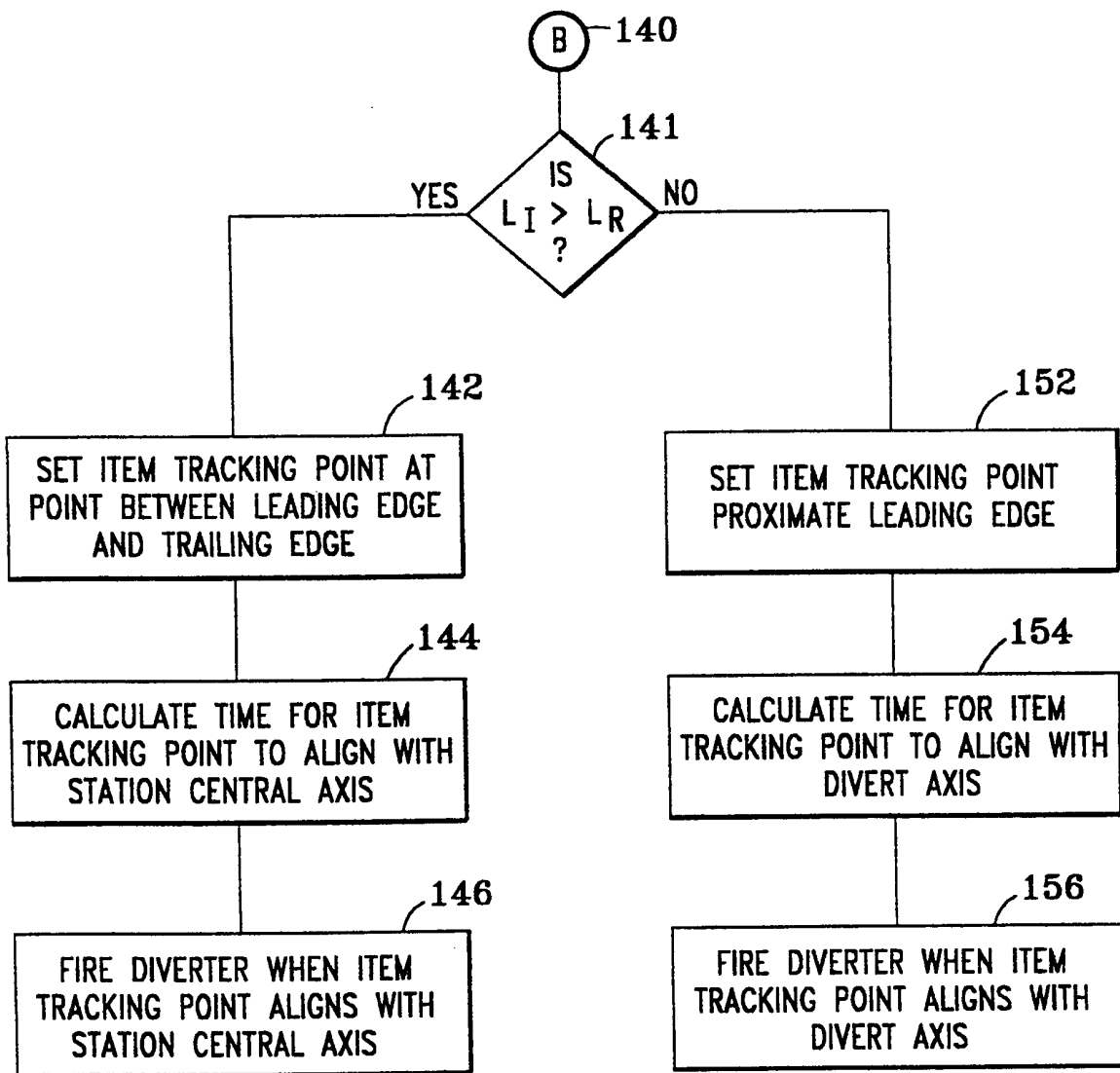
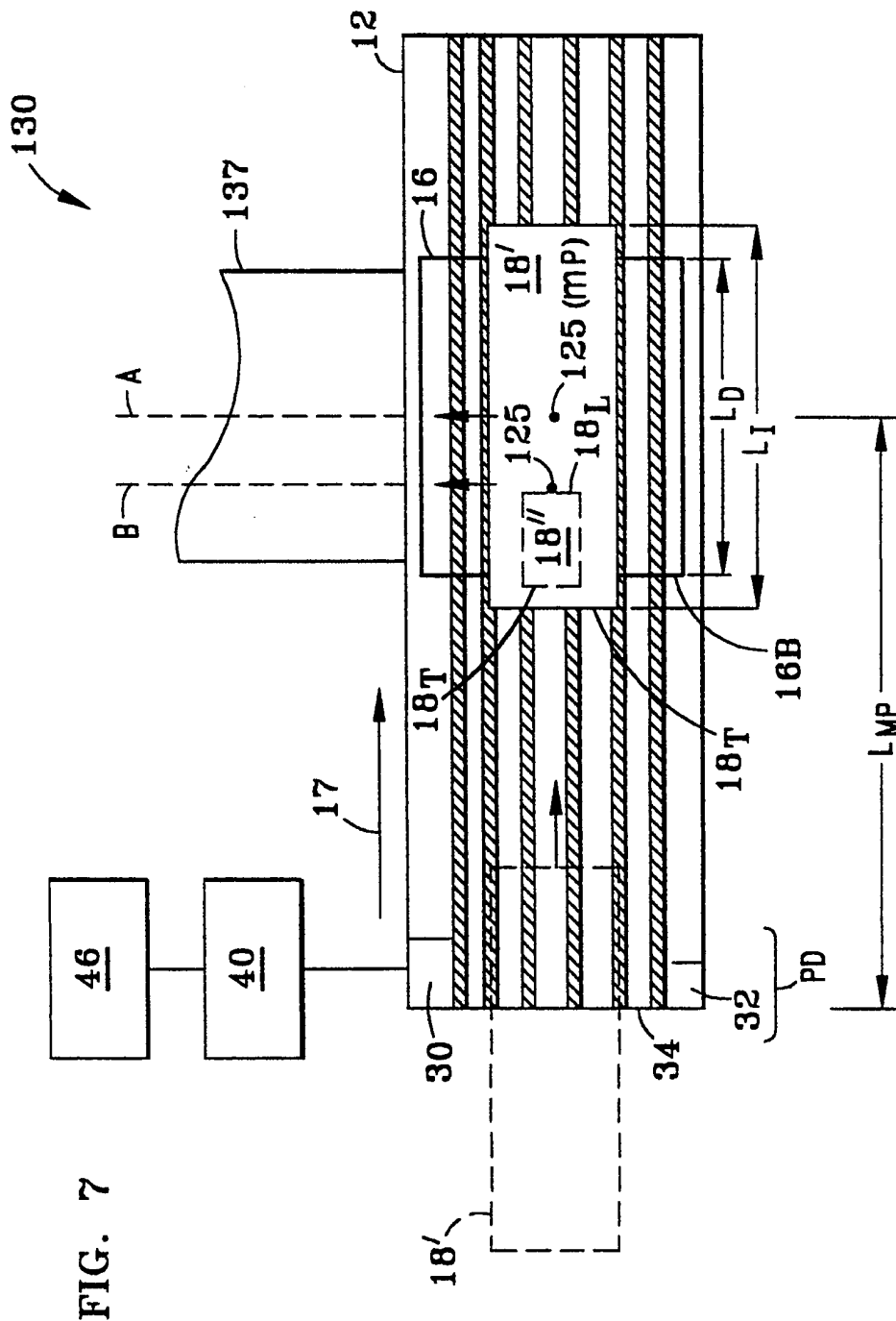


FIG. 6



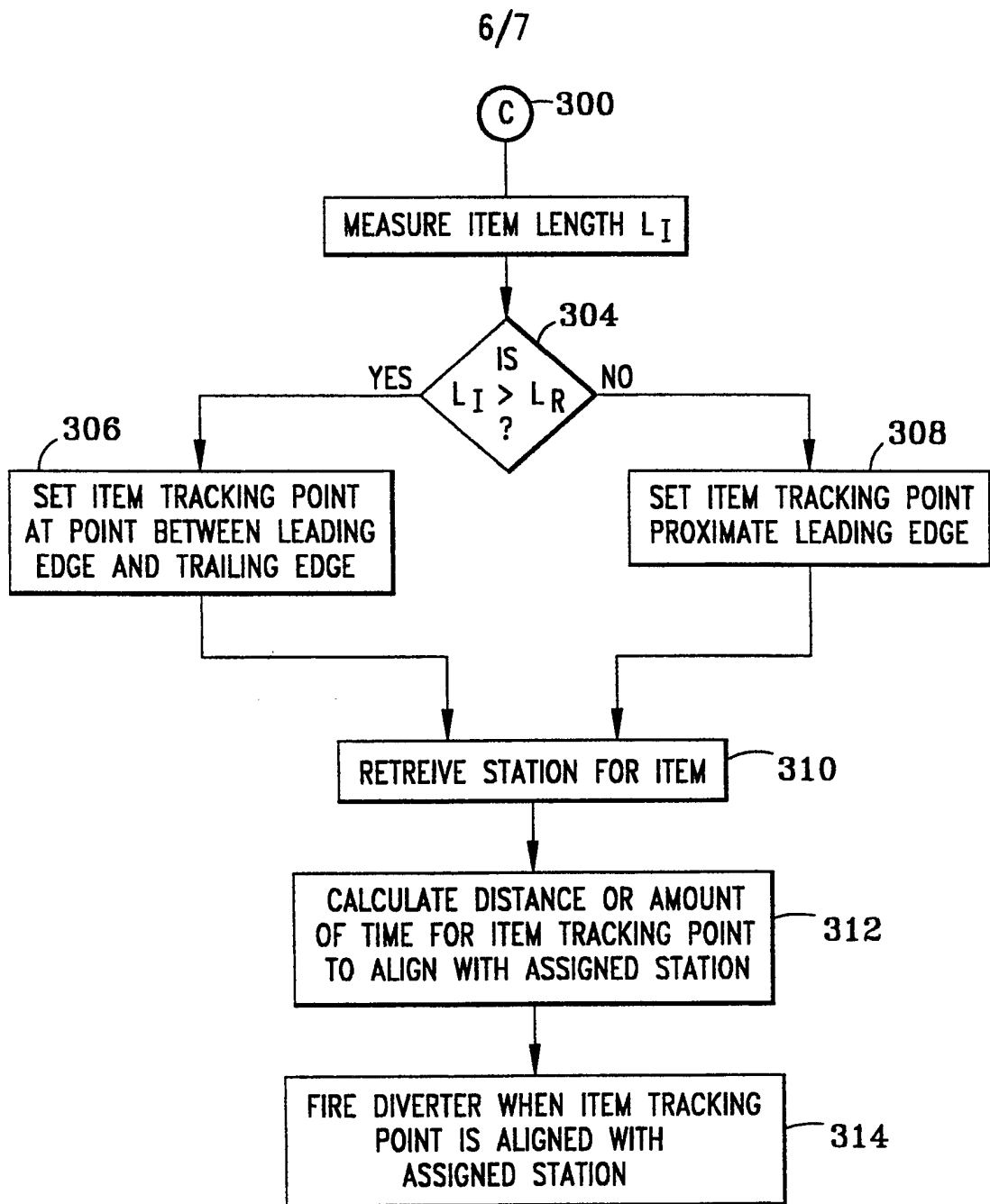


FIG. 8

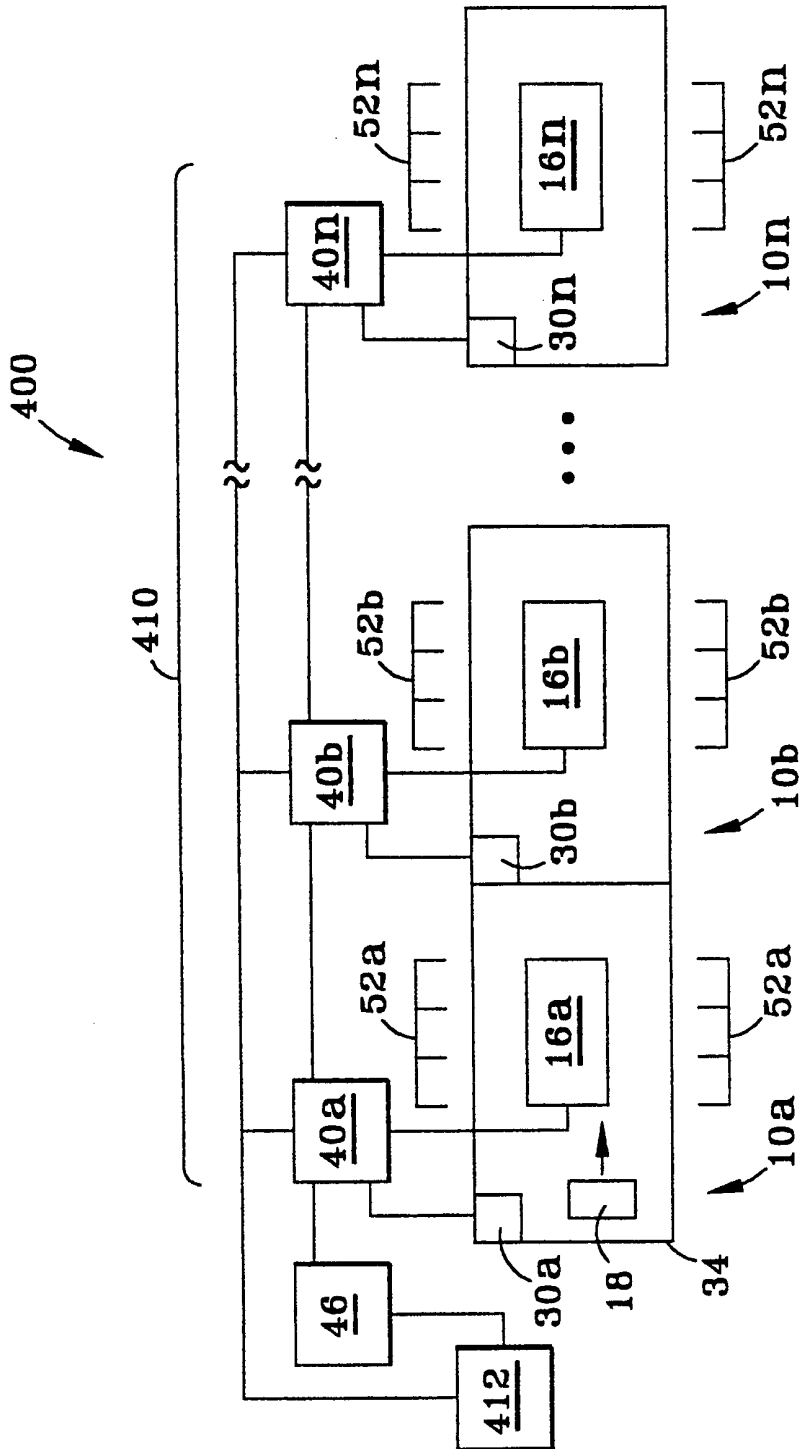


FIG. 9