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(71) Applicant: **CURT G. JOA, INC.** [US/US]; 100 Crocker Avenue, Sheboygan Falls, WI 53083 (US).

(72) Inventors; and

(71) Applicants : **DAVIDSON, Benjamin, T.** [US/US]; 1121 Millersville Avenue, Howards Grove, WI 53083 (US). **INGOLE, Sudeep** [US/US]; 3527 Lakeshore Road, ID, Sheboygan, WI 53083 (US).

(74) Agents: **KROMHOLZ, Joseph, A.** et al.; Ryan Kromholz & Manion, S.C., PO Box 26618, Milwaukee, WI 53226 (US).

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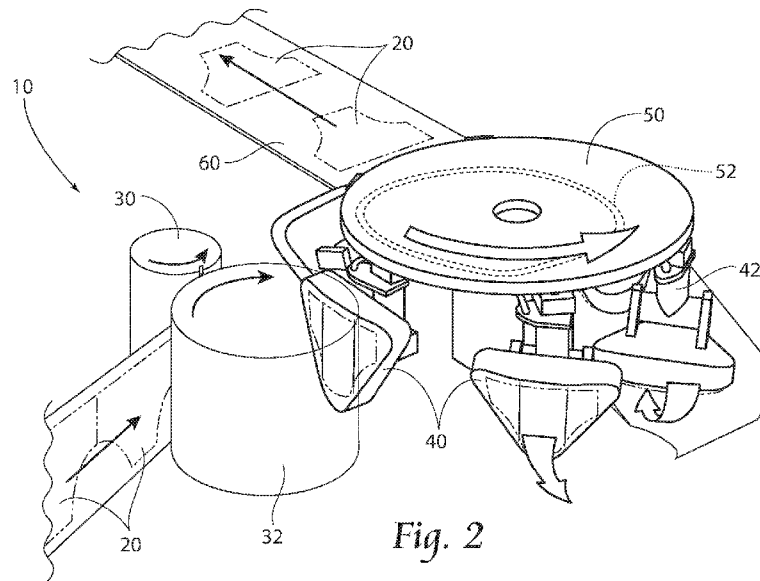


Fig. 2

(57) Abstract: An apparatus is disclosed for severing a continuous web into discrete pieces, and re-orienting the discrete pieces by turning and placing the discrete pieces onto a moving conveyor for further processing as desired.

- 1 -

PRODUCT TURNER AND PLACER

Related Application

This application claims the benefit of
co-pending U.S. Provisional Patent Application Serial No.
5 62/107,833, filed 26 January 2015.

Background of the Invention

The invention disclosed herein relates to an
apparatus and methods for producing disposable products
such as diapers at very high speeds. While the
10 description provided relates to diaper manufacturing, the
apparatus and method are easily adaptable to other
applications. In particular this invention relates to an
apparatus for turning and placing either portions of or
discrete disposable products such as diapers.

15 Generally, diapers comprise an absorbent insert
or patch and a chassis, which, when the diaper is worn,
supports the insert proximate a wearer's body.
Additionally, diapers may include other various patches,
such as tape tab patches, reusable fasteners and the
20 like. The raw materials used in forming a representative
insert are typically cellulose pulp, tissue paper, poly,
nonwoven web, acquisition, and elastic, although
application specific materials are sometimes utilized.
Usually, most of the insert raw materials are provided in
25 roll form, and unwound and applied in continuously fed

- 2 -

fashion.

In the creation of a diaper, multiple roll-fed web processes are typically utilized. To create an absorbent insert, the cellulose pulp is unwound from the provided raw material roll and de-bonded by a pulp mill. Discrete pulp cores are created using a vacuum forming assembly and placed on a continuous tissue web. Optionally, super-absorbent powder may be added to the pulp core. The tissue web is wrapped around the pulp core. The wrapped core is debulked by proceeding through a calender unit, which at least partially compresses the core, thereby increasing its density and structural integrity. After debulking, the tissue-wrapped core is passed through a segregation or knife unit, where individual wrapped cores are cut. The cut cores are conveyed, at the proper pitch, or spacing, to a boundary compression unit.

While the insert cores are being formed, other insert components are being prepared to be presented to the boundary compression unit. For instance, the poly sheet is prepared to receive a cut core. Like the cellulose pulp, poly sheet material is usually provided in roll form. The poly sheet is fed through a splicer and accumulator, coated with an adhesive in a predetermined pattern, and then presented to the boundary compression unit. In addition to the poly sheet, which may form the bottom of the insert, a two-ply top sheet may also be formed in parallel to the core formation. Representative plies are an acquisition layer web material and a nonwoven web material, both of which are fed from material parent rolls, through a splicer and accumulator. The plies are coated with adhesive, adhered together, cut to size, and presented to the boundary compression unit. Therefore, at the boundary compression unit, three components are provided for assembly: the poly bottom

- 3 -

sheet, the core, and the two-ply top sheet.

A representative boundary compression unit includes a profiled die roller and a smooth platen roller. When all three insert components are provided to
5 the boundary compression unit, the nip of the rollers properly compresses the boundary of the insert. Thus, provided at the output of the boundary compression unit is a string of interconnected diaper inserts. The diaper inserts are then separated by an insert knife assembly
10 and properly oriented, such as disclosed in co-pending U.S. Application No. 61/426,891, owned by the assignee of the present invention and incorporated herein by reference. At this point, the completed insert is ready for placement on a diaper chassis.

15 A representative diaper chassis comprises nonwoven web material and support structure. The diaper support structure is generally elastic and may include leg elastic, waistband elastic and belly band elastic. The support structure is usually sandwiched between
20 layers of the nonwoven web material, which is fed from material rolls, through splicers and accumulators. The chassis may also be provided with several patches, besides the absorbent insert. Representative patches include adhesive tape tabs and resealable closures.

25 The process utilizes two main carrier webs; a nonwoven web which forms an inner liner web, and an outer web that forms an outwardly facing layer in the finished diaper. In a representative chassis process, the nonwoven web is slit at a slitter station by rotary knives along
30 three lines, thereby forming four webs. One of the lines is on approximately the centerline of the web and the other two lines are parallel to and spaced a short distance from the centerline. The effect of such slitting is twofold; first, to separate the nonwoven web into two
35 inner diaper liners. One liner will become the inside of

- 4 -

the front of the diaper, and the second liner will become the inside of the back of that garment. Second, two separate, relatively narrow strips are formed that may be subsequently used to cover and entrap portions of the leg-hole elastics. The strips can be separated physically by an angularly disposed spreader roll and aligned laterally with their downstream target positions on the inner edges of the formed liners. This is also done with turn bars upon entrance to the process.

10 After the nonwoven web is slit, an adhesive is applied to the liners in a predetermined pattern in preparation to receive leg-hole elastic. The leg-hole elastic is applied to the liners and then covered with the narrow strips previously separated from the nonwoven web. Adhesive is applied to the outer web, which is then combined with the assembled inner webs having elastic thereon, thereby forming the diaper chassis. Next, after the elastic members have been sandwiched between the inner and outer webs, an adhesive is applied to the chassis. The chassis is now ready to receive an insert.

25 In diapers it is preferable to contain elastics around the leg region in a cuff to contain exudates for securely within the diaper. Typically, strands of elastic are held by a non-woven layer that is folded over itself and contains the elastics within the overlap of the non-woven material. The non-woven is typically folded by use of a plow system which captures the elastics within a pocket, which is then sealed to ensure that the elastics remain in the cuff.

30 Most products require some longitudinal folding. It can be combined with elastic strands to make a cuff. It can be used to overwrap a stiff edge to soften the feel of the product. It can also be used to convert the final product into a smaller form to improve the packaging.

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- 5 -

To assemble the final diaper product, the insert must be combined with the chassis. The placement of the insert onto the chassis occurs on a placement drum or at a patch applicator. The inserts are provided to the
5 chassis on the placement drum at a desired pitch or spacing. The generally flat chassis/insert combination is then folded so that the inner webs face each other, and the combination is trimmed. A sealer bonds the webs at appropriate locations prior to individual diapers being
10 cut from the folded and sealed webs.

Roll-fed web processes typically use splicers and accumulators to assist in providing continuous webs during web processing operations. A first web is fed from a supply wheel (the expiring roll) into the manufacturing
15 process. As the material from the expiring roll is depleted, it is necessary to splice the leading edge of a second web from a standby roll to the first web on the expiring roll in a manner that will not cause interruption of the web supply to a web consuming or
20 utilizing device.

In a splicing system, a web accumulation dancer system may be employed, in which an accumulator collects a substantial length of the first web. By using an accumulator, the material being fed into the process can
25 continue, yet the trailing end of the material can be stopped or slowed for a short time interval so that it can be spliced to leading edge of the new supply roll. The leading portion of the expiring roll remains supplied continuously to the web-utilizing device. The accumulator
30 continues to feed the web utilization process while the expiring roll is stopped and the new web on a standby roll can be spliced to the end of the expiring roll.

In this manner, the device has a constant web supply being paid out from the accumulator, while the
35 stopped web material in the accumulator can be spliced to

- 6 -

the standby roll. Examples of web accumulators include
that disclosed in U.S. Patent Application Serial No.
11/110,616, which is commonly owned by the assignee of
the present application, and incorporated herein by
5 reference.

As in many manufacturing operations, waste
minimization is a goal in web processing applications, as
products having spliced raw materials cannot be sold to
consumers. Indeed, due to the rate at which web
10 processing machines run, even minimal waste can cause
inefficiencies of scale. In present systems, waste
materials are recycled. However, the act of harvesting
recyclable materials from defective product is intensive.
That is, recyclable materials are harvested only after an
15 identification of a reject product at or near the end of
a process. The result is that recyclable materials are
commingled, and harvesting requires the extra step of
separating waste components. Therefore, the art of web
processing would benefit from systems and methods that
20 identify potentially defective product prior to product
assembly, thereby eliminating effort during recyclable
material harvesting.

Furthermore, to improve quality and production
levels by eliminating some potentially defective product,
25 the art of web processing would benefit from systems and
methods that ensure higher product yield and less machine
downtime.

Some diaper forming techniques are disclosed in
co-pending U.S. Application No. 12/925,033 which is
30 incorporated herein by reference. As described therein, a
process wherein a rotary knife or die, with one or more
cutting edges, turns against and in coordination with a
corresponding cylinder to create preferably trapezoidal
ears. Ear material is slit into two lanes, one for a left
35 side of a diaper and the other for a right side of a

- 7 -

diaper. Fastening tapes are applied to both the right and the left ear webs. The ear material is then die cut with a nested pattern on a synchronized vacuum anvil.

The resulting discrete ear pieces however, due
5 to the trapezoidal pattern of the ears, alternate between a correct orientation and an incorrect (reversed) orientation. The reversed ear is required to be rotated 180° into the correct orientation such that the ears and associated tape present a left ear and a right ear on the
10 diaper.

To accomplish the reversal of the ear pattern, discrete ear pieces are picked up at the nested ear pitch by an ear turner assembly that will expand to a pitch large enough for ears to be unnested and allow clearance
15 for every other ear to be rotated. The rotated ears are then unnested and into the correct orientation.

Two ear turner assemblies can be provided, to rotate every other ear applied to the right side of the product, and every other ear applied to the left side of
20 the product. In this manner, for a single product, one of the two ears will have been rotated 180°.

Ear application to a chassis web can be by a bump method with intermittent adhesive applied to the chassis web, or can be by vacuum transfer.

25 Two side panel assemblies, including fastening mechanisms, can be attached to two ears, the side panel assemblies attached in a pre-folded condition. Two more ears can coupled to a chassis web to create a front panel to wear about the waist of a user.

30 Chips of material can also be removed from the ears to provide a diaper with contoured leg openings. In one embodiment, the chips may be removed from the ears before the ears are attached to the chassis web. In an additional embodiment the chips may be removed from the
35 ears after the ears are attached to the chassis web. In

- 8 -

an additional embodiment the chips may be removed from the ears and a portion of the chassis web removed after the ears are attached to the chassis web.

Generally, diapers comprise an absorbent insert
5 or patch and a chassis, which, when the diaper is worn, supports the insert proximate a wearer's body. Additionally, diapers may include other various patches, such as tape tab patches, reusable fasteners and the like. The raw materials used in forming a representative
10 insert are typically cellulose pulp, tissue paper, poly, nonwoven web, acquisition, and elastic, although application specific materials are sometimes utilized. Usually, most of the insert raw materials are provided in roll form, and unwound and applied in assembly line
15 fashion. As in many manufacturing operations, waste minimization is a goal in web processing applications, as products having spliced raw materials cannot be sold to consumers. Indeed, due to the rate at which web processing machines run, even minimal waste can cause
20 inefficiencies of scale.

In present systems, waste materials are recycled. However, the act of harvesting recyclable materials from defective product is intensive. That is, recyclable materials are harvested only after an
25 identification of a reject product at or near the end of a process. The result is that recyclable materials are commingled, and harvesting requires the extra step of separating waste components. Therefore, it is beneficial to use up all of incoming rolls, so that a portion of the
30 incoming rolls do not become waste. That objective is accomplished with the present invention

When manufacturing hygiene products, such as baby diapers, adult diapers, disposable undergarments, incontinence devices, sanitary napkins and the like, a
35 common method of applying discrete pieces of one web to

- 9 -

another is by use of a slip-and-cut applicator. A slip-and-cut applicator is typically comprised of a cylindrical rotating vacuum anvil, a rotating knife roll, and a transfer device. In typical applications, an
5 incoming web is fed at a relatively low speed along the vacuum face of the rotating anvil, which is moving at a relatively higher surface speed and upon which the incoming web is allowed to "slip". A knife-edge, mounted on the rotating knife roll, cuts a off a segment of the
10 incoming web against the anvil face. This knife-edge is preferably moving at a surface velocity similar to that of the anvil's surface. Once cut, the web segment is held by vacuum drawn through holes on the anvil's face as it is carried at the anvil's speed downstream to the
15 transfer point where the web segment is transferred to the traveling web.

Continual improvements and competitive pressures have incrementally increased the operational speeds of disposable diaper converters. As speeds increased, the
20 mechanical integrity and operational capabilities of the applicators had to be improved accordingly.

In some instances, disposable products manufacturers choose to use pre-formed stretched laminate to construct products such as diapers. In a typical
25 diaper, it is preferred to have a stretch from side to side across the waist of a user. In prior art diaper construction techniques, machines are used that construct stretch laminates in a machine direction, and then rotate the stretch laminates to receive an absorbent core
30 roughly perpendicular to the front and rear panels. However, if the pre-formed stretched laminate is supplied with the stretch perpendicularly to the unwind or machine direction, the prior art machines would not orient the stretch characteristics of the front and rear or back
35 panels properly. Therefore, a machine is necessary to

- 10 -

fabricate diapers from an unwind roll that presents the stretch direction perpendicular to the machine direction.

Summary of the Invention

5 A core forming unit feeds a core to a cutting unit, where a core is wrapped with a core topsheet and backsheet. The core insert is folded and a front wing web and a back wing web are coupled to the folded core. If a pant type diaper is desired, side seams of the front wing web and back wing web are bonded together at side seam
10 regions. Disclosed in this application are methods and apparatus for severing a continuous web, such as but not limited to a continuous web of formed and seamed pant-type diaper products, into discrete pieces, and re-orienting the discrete pieces by turning and placing the
15 discrete pieces. Next, portions of the front wing web and back wing web are folded over to create a compact product for packaging and shipment.

A method of processing a continuous web is disclosed, the method comprising providing an incoming
20 continuous web of material at a first orientation relative to horizontal, severing the web into discrete pieces, each piece comprising a leading edge, a trailing edge, a top edge and a bottom edge, acquiring a discrete piece with a rotating and pivoting unit, rotating said
25 discrete piece about an axis of the first orientation, spacing adjacent pieces by separating a trailing edge of a first discrete piece from a leading edge of a second discrete piece, reorienting said discrete pieces from said first orientation relative to horizontal to a second
30 orientation relative to horizontal, depositing said pieces and spacing adjacent pieces by separating a top edge of said first discrete piece from a bottom edge of said second discrete piece.

Brief Description of the Drawings

35 Fig. 1 is a schematic of a representative web

- 11 -

processing system;

Fig. 2 is a perspective view of a machine for severing a continuous web into discrete pieces and re-orienting the discrete pieces by turning and placing the discrete pieces;

Fig. 3 is an exploded view of portions of the machine of Fig. 2;

Fig. 4 is a top view of portions of the machine of Fig. 2;

Figs. 5a-5d are a sequential series of side views of a rotating puck of the present invention picking up discrete pieces from an anvil roll at an acquisition point and rotating and pivoting the puck to a deposition point.

15 **Description of the Preferred Embodiment**

Although the disclosure hereof is detailed and exact to enable those skilled in the art to practice the invention, the physical embodiments herein disclosed merely exemplify the invention which may be embodied in other specific structures. While the preferred embodiment has been described, the details may be changed without departing from the invention, which is defined by the claims.

In traditional diaper manufacturing techniques, a stretch laminate is formed by laying down elastic sheets or strands in a machine direction. This laminate is then re-oriented to receive an absorbent core also running and applied in the machine direction. In the present case, a pre-made unidirectional stretch material can be employed (or the stretch laminate is formed upstream) and the direction of stretch is in the cross machine direction during the manufacturing process.

Referring to Fig. 1, a schematic representation of the present methods and machinery is shown. First, a core forming procedure takes place at core forming unit

- 12 -

102. A continuous core is cut into individual core portions at core cutter 108, and the cut core is wrapped by placing a topsheet 116 and a backsheet 118 about the cut core. It is noted that the core could remain
5 continuous and cut individually after receiving a wrap such as with topsheet 116 and backsheet 118.

Next, the core is folded by a folder 124 such as a tucker blade. The folded core is introduced into a combining unit where the folded core receives on one side
10 a front wing web 140, which has been pre-cut and applied with adhesive for bonding with the folded core. The folded core receives on the other side a back wing web 130, which has also been pre-cut and applied with adhesive for bonding with the folded core.

15 The core, front wing and back wing combination is passed to a side seam bonding unit 150, such as an ultrasonic bonding unit, where the front wing and back wing are bonded together at side seam regions. At this point the diaper is fully formed, but in a continuous
20 web.

The present application is primarily directed at station 160, which is an apparatus for severing a continuous web of fully formed diapers into discrete
25 diapers, and re-orienting the discrete diapers by turning and placing the discrete diapers. It is noted that the apparatus of the present invention can also be used for cutting, turning, and otherwise re-orienting continuous webs of materials other than a continuous web of fully formed diapers.

30 For ease of packaging and shipping, portions of the front wing and back wing which extend widthwise outwardly of the folded core can be folded over the folded core, for instance using a canoe folder by folding unit 170. If desired, the product can then be folded in
35 half again for compact packaging by folding unit 180. The

- 13 -

product is then passed on at the product exit 190 for further processing as desired.

Referring now to Fig. 2, an incoming web such as a web of continuous formed and sideseam bonded pants type paper products 20 is shown entering a vertically oriented knife 30 and anvil 32 arrangement. Anvil 32 carries discrete pants type diapers 20 about the anvil 32 to a puck 40, which acquires the pant type diaper 20 from the anvil 32 at an acquisition point. A series of pucks 40 are rotatably mounted, carried, and rotated by a rotating unit 50. The pucks 40 acquire the individual pant type diapers 20 in a vertical orientation and, as shown, the pucks 40 rotate in a counterclockwise direction. As the pucks 40 rotate in the counter clockwise direction, pucks 40 also pivot downwardly, to transition the pant type diaper 20 from a vertical orientation to a horizontal orientation. The pucks 40 are preferably vacuum pucks to retain the pant-type diapers 20 upon a carrying surface of the pucks 40. However, other attraction or retaining forces can be employed to retain the pant-type diapers 20 on the carrying surface of the pucks 40. The pucks 40 release individual pant type diapers 20 onto a conveyor 60, at a deposition point. In this manner a continuous web of formed pant-type diapers is separated into discrete pant-type diapers 20 and re-oriented from a vertical orientation entering anvil 32/knife 30 combination to a horizontal orientation when carried by conveyor 60.

Continuing their revolution, pucks 40 pivot from their horizontal orientation at the deposition point of the individual pant-type diapers 20 onto the conveyor 60, to their original vertical orientation upon returning to the acquisition point proximal to anvil 32.

Instead of, or in addition to depositing the pant-type diapers 20 onto a conveyor 60, in an

- 14 -

alternative embodiment of the present invention, the unit shown in Fig. 2 can be used to space and reposition other discrete pieces in addition to individually cut pant-type diapers 20. For instance, the turner/placer of Fig. 2
5 can be used to turn and space other discrete elements of disposable products, such as ear webs, side panel webs, waist band features, or any other discrete object. Instead of depositing discrete pieces 20 onto a conveyor 60, a running web of material can take the place of the
10 conveyor 60, and a bonding unit can be used to bond discrete pieces coming from the product turner/placer onto the running web of material. In this manner, the discrete pieces can be placed at one or more outboard edges of the running web (for instance if ears or side
15 panels are desired to be place), or within the cross-machine direction width of the running web (for instance a desirable placement of an absorbent core, to turn, place, and space adjacent cores onto a running web).

Referring now to Fig. 3, pucks 40 are carried by
20 pivoting member 42 which pivots pucks 40 from vertical to horizontal orientations. Pivoting members 42 are carried by arms 44 extending radio Lee from an axis about which the pucks 40 can rotate. Also carried on arms 44 are slots 56 for slidably receiving cam followers 54, which
25 control the radial position of the pucks 40. Cam followers 50 are operably engaged with cam slot 52, which is an eccentric shape disposed on frame member 50. As the pucks 40 rotate, cam follower 54 travels through the eccentric 52 and adjusts the lateral position of the
30 pucks 40, as desired. In this manner, the relative rotational speed of the pucks 40 can be changed.

Referring now to Fig. 4, it is seen that the cam followers 54 travel throughout the eccentric channel 52 provided on body 50. During rotation, the pucks 40 pivot
35 from a vertical orientation as seen at the bottom of Fig.

- 15 -

4, to a horizontal orientation pictured at the top of Fig. 4, and then the pucks 40 pivot back from the horizontal to the vertical orientation throughout rotation.

5 Referring now to Fig. 5A, a side view of a puck 40 is shown acquiring a discrete paper product 20 from a vertically oriented anvil drum 30, at an acquisition point. In Fig. 5B, the puck 40 has begun to rotate away from the acquisition point. As shown in figure 5C as the
10 puck 40 continues to rotate, the puck 40 begins to pivot operation of by pivoting member 42, from a vertical towards a horizontal orientation. Referring to Fig. 5D the puck 40 has now pivoted to a horizontal position and, at a deposition point, is in position to lay down a
15 discrete diaper 20 onto a conveyor 60.

After the discrete diaper products 20 are placed onto conveyor 60, as mentioned in Fig. 1, the discrete products 20 can be passed downstream for ear and product folding stations 170 and 180, if desired.

20 Those skilled in the art will recognize that the present configuration allows for easy size change operations. In a size change operation, machines are reconfigured to handle discrete portions of a web, such as diapers 20, of variable sizes for example from small
25 to large. In order to configure the machine of Fig. 2 for a size change, it may be necessary to adjust the position of the conveyor 60, upwardly or downwardly. Alternatively, one could adjust the position of the pucks 40, also upwardly or downward and inwardly or outwardly,
30 to receive larger or smaller discrete web portions.

The foregoing is considered as illustrative only of the principles of the invention. Furthermore, since numerous modifications and changes will readily occur to those skilled in the art, it is not desired to limit the
35 invention to the exact construction and operation shown

- 16 -

and described. While the preferred embodiment has been described, the details may be changed without departing from the invention, which is defined by the claims.

- 17 -

We Claim:

1. A method of processing a continuous web; the method comprising:
 - providing an incoming continuous web of material at a first orientation relative to horizontal;
 - severing the web into discrete pieces, each piece comprising a leading edge, a trailing edge, a top edge and a bottom edge;
 - acquiring a discrete piece with a rotating and pivoting unit;
 - rotating said discrete piece about an axis of the first orientation;
 - spacing adjacent pieces by separating a trailing edge of a first discrete piece from a leading edge of a second discrete piece;
 - reorienting said discrete pieces from said first orientation relative to horizontal to a second orientation relative to horizontal;
 - depositing said pieces and spacing adjacent pieces by separating a top edge of said first discrete piece from a bottom edge of said second discrete piece.
2. A method according to claim 1, wherein said first orientation relative to horizontal is vertical.
3. A method according to claim 1, wherein said second orientation relative to horizontal is horizontal.
4. A method of claim 1, said pieces deposited onto a conveyor.
5. A method of claim 1, said pieces deposited onto a running web of material.
6. A method of claim 1, said pieces comprising a diaper.

- 18 -

7. A method of processing a continuous web; the method comprising:

5 acquiring with a rotating and pivoting unit a series of discrete pieces comprising a leading edge, a trailing edge, a top edge and a bottom edge, said pieces traveling at a first orientation relative to horizontal;

10 rotating said discrete pieces about an axis of the first orientation;

spacing adjacent pieces by separating a trailing edge of a first discrete piece from a leading edge of a second discrete piece;

15 reorienting said discrete pieces from said first orientation relative to horizontal to a second orientation relative to horizontal;

depositing said pieces and spacing adjacent pieces by separating a top edge of said first discrete piece from a bottom edge of said second discrete piece.

8. A method according to claim 7, wherein said first orientation relative to horizontal is vertical.

9. A method according to claim 7, wherein said second orientation relative to horizontal is horizontal.

25 10. A method of claim 7, said pieces deposited onto a conveyor.

11. A method of claim 7, said pieces deposited onto a running web of material.

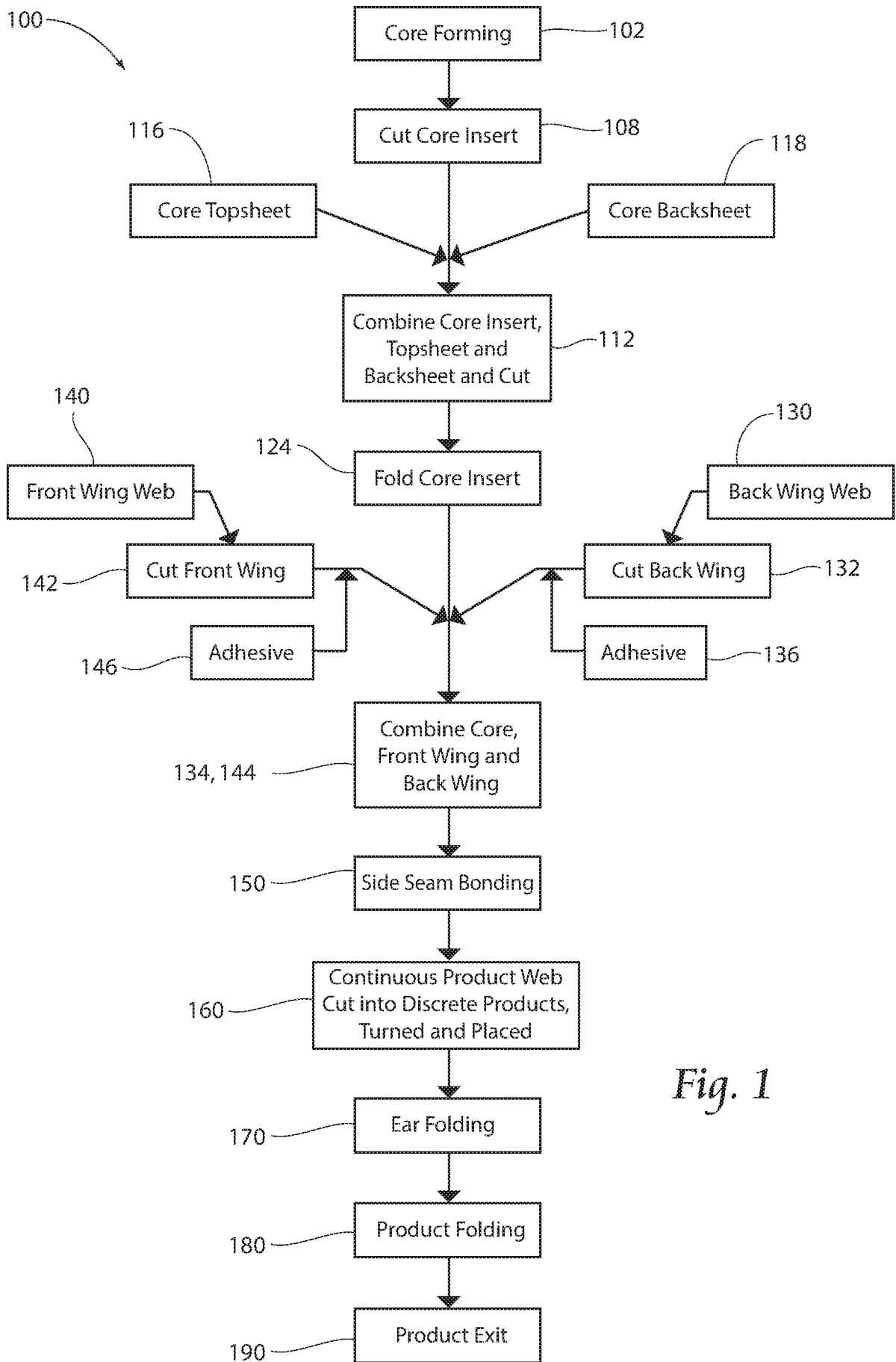


Fig. 1

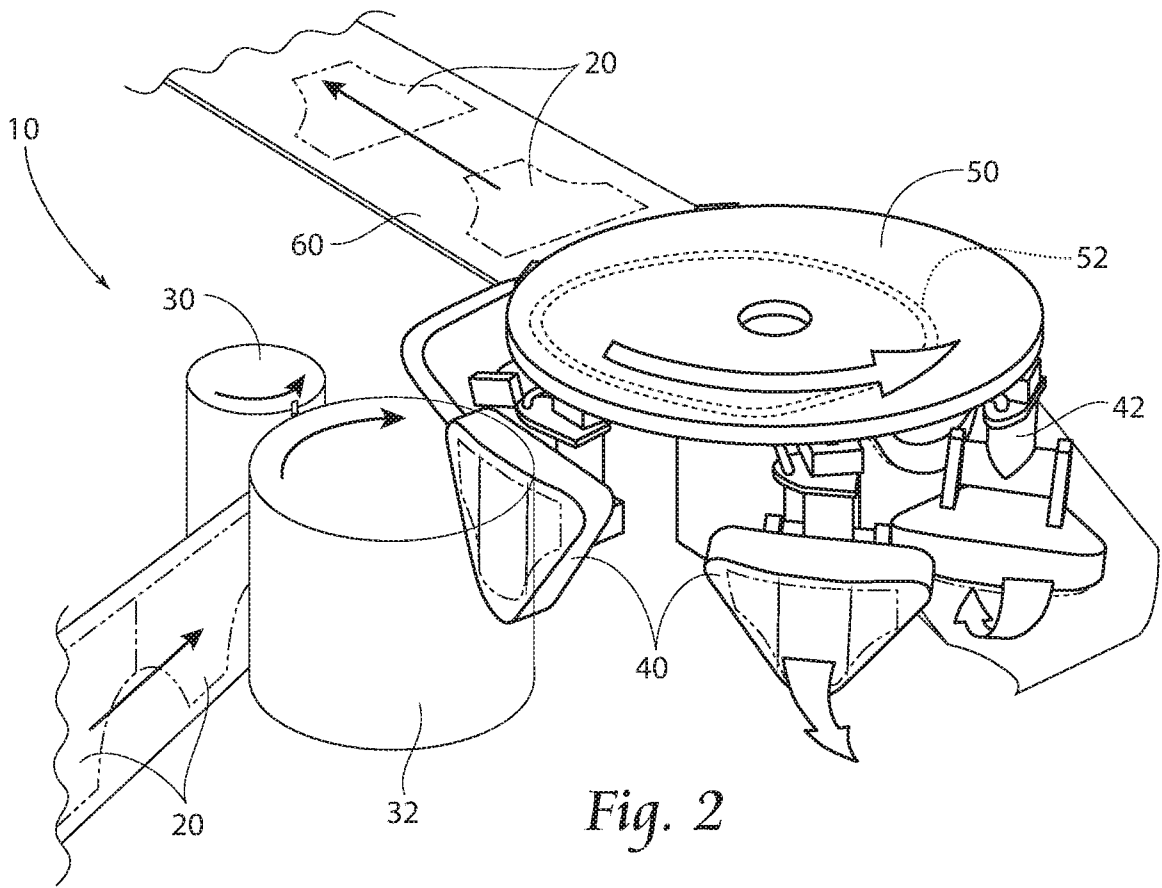


Fig. 2

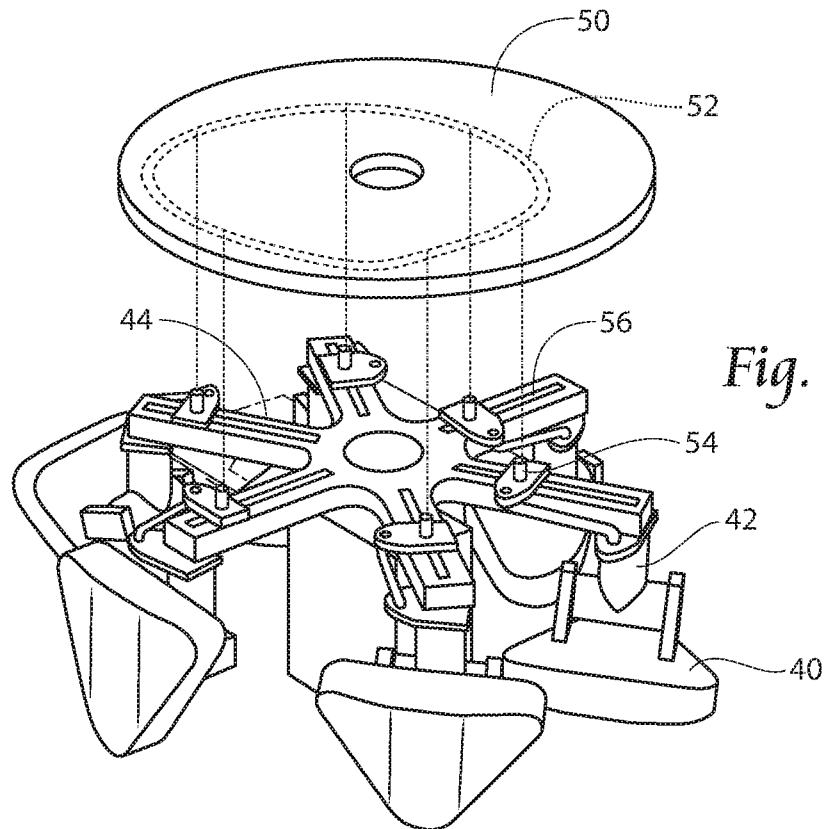


Fig. 3

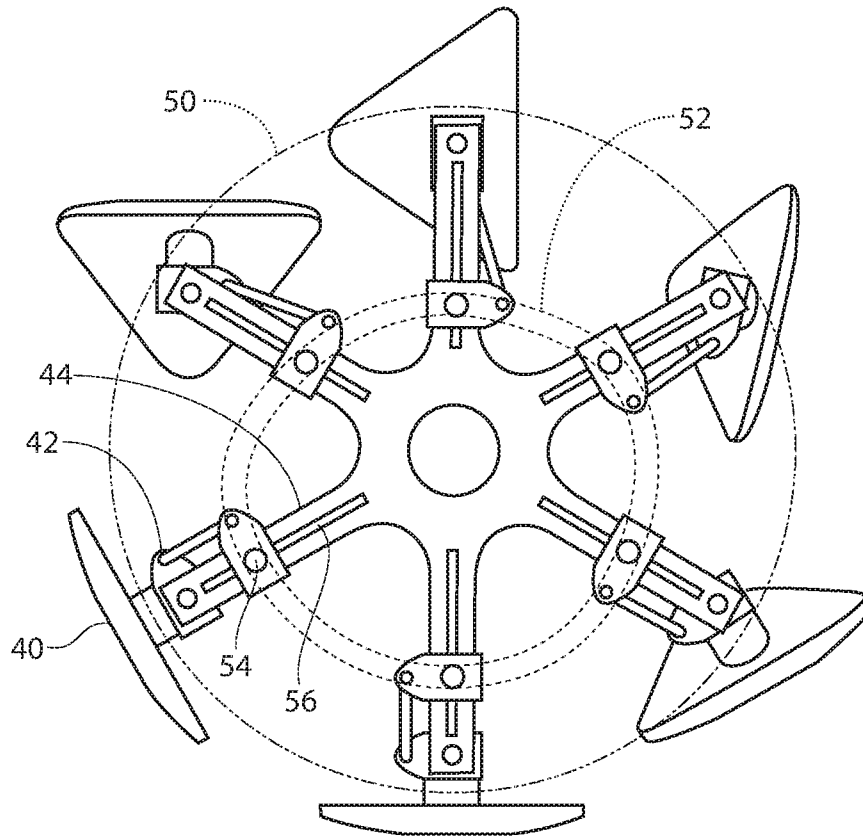


Fig. 4

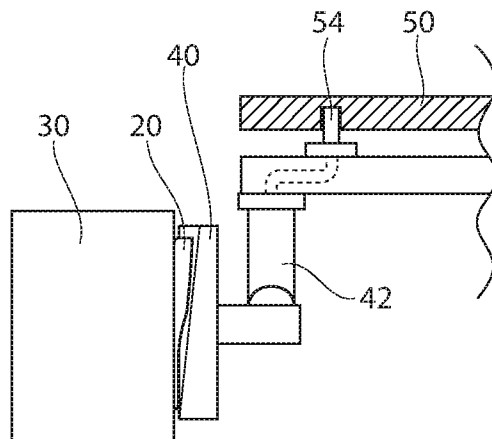


Fig. 5A

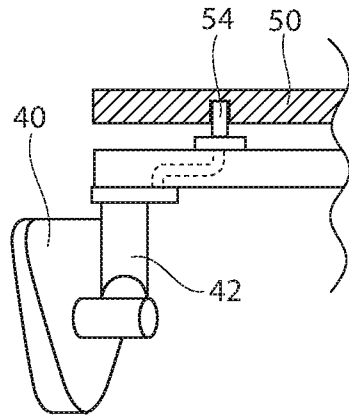


Fig. 5B

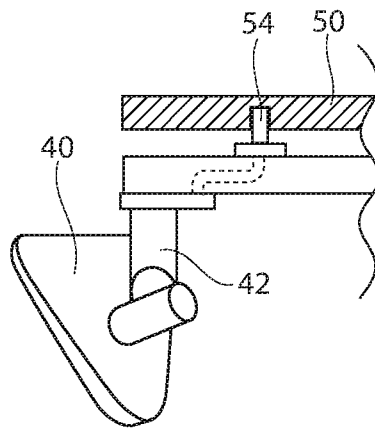


Fig. 5C

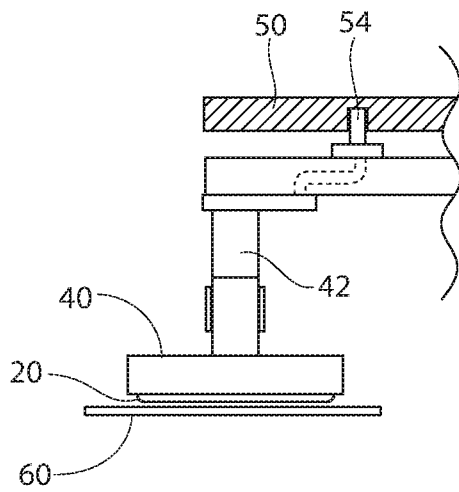


Fig. 5D

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US16/14717

A. CLASSIFICATION OF SUBJECT MATTER IPC(8) - B65H 5/12, 29/44; B65G 47/244 (2016.01) CPC - B65H 5/12, 29/44; B65G 47/244 According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED Minimum documentation searched (classification system followed by classification symbols) IPC(8): B65H 5/08, 5/12, 29/44; B65G 47/244; A61F 13/15 (2016.01) CPC: B65H 5/08, 5/12, 29/44; B65G 47/244; A61F 13/15; Y10T 156/133 Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) PatSeer (US, EP, WO, JP, DE, GB, CN, FR, KR, ES, AU, IN, CA, INPADOC Data); Google Patent; Google; Google Scholar; EBSCO; cut, sever, rotate, turn, pivot, deposit, place apply, orientation, continuous, discrete, web, sheet, material, method, process, leading, trailing, diaper		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 5,104,116 A (POHJOLA, DA) 14 April 1992; figures 1-2; column 1, lines 64-68; column 2, lines 54-60; column 3, lines 14-20; column 4, lines 4-17; column 6, lines 65-68; column 7, lines 1-15, 21-29, 40-53	1, 3-5, 7-11
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Y		2, 6
Y	US 2002/0003024 A1 (VOGT, BR et al) 10 January 2002; figure 1; paragraphs [0074], [114]-[115]	2, 6
A	US 5,716,478 A (BOOTHE, JL et al) 10 February 1998; entire document	1-11
A	WO 2014/066307 A1 (THE PROCTOR & GAMBLE COMPANY) 01 May 2014; entire document	1-11
<input type="checkbox"/> Further documents are listed in the continuation of Box C. <input type="checkbox"/> See patent family annex.		
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Date of the actual completion of the international search 20 March 2016 (20.03.2016)		Date of mailing of the international search report 08 APR 2016
Name and mailing address of the ISA/ Mail Stop PCT, Attn: ISA/US, Commissioner for Patents P.O. Box 1450, Alexandria, Virginia 22313-1450 Facsimile No. 571-273-8300		Authorized officer Shane Thomas PCT Helpdesk: 571-272-4300 PCT OSP: 571-272-7774