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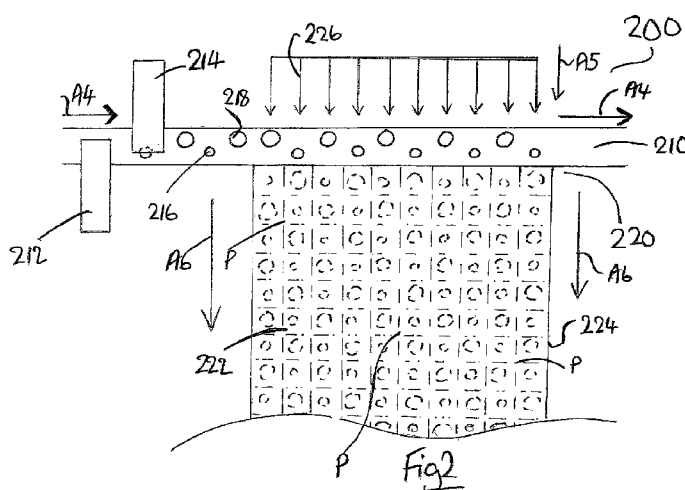
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(54) **Title:** APPARATUS AND METHOD FOR MAKING A RESILIENT UNIT



(57) **Abstract:** Apparatus for forming a resilient unit comprises a conveyor (210) and first and second spring supply stations (212 and 214), arranged in use to deposit respectively first and second spring types (216 and 218) under compression onto the conveyor. The conveyor is arranged in use to convey a row of the springs (216, 218) in a direction shown by Arrows A4 towards pocketing station (220). At the pocketing station (220) the springs are urged from the conveyor into positions between upper and lower sheets (222 and 224), by a plurality of inserter devices (226) that move together in a reciprocating fashion in the direction of arrow A5, before retracting to the position shown. After each row of springs is inserted between the sheets (222), upper and lower computer-controlled welding tools (not shown) come together at positions P between the springs to join the sheets together, forming pockets in which the springs are encased. After each welding event the resilient unit is indexed forwards a distance equal to one pocket width in the direction of Arrows A6 by computer-controlled drive means (not shown). The next row of springs is then conveyed into position ready for insertion between the sheets of material, and the process is repeated. The two spring supply stations are arranged to supply springs that differ from one another in at least one characteristic.

APPARATUS AND METHOD FOR MAKING A RESILIENT UNIT

5 The present invention relates to a resilient unit, and to an apparatus and a method for making a resilient unit, such as a mattress for example, and is concerned particularly, although not exclusively, with controlling the positioning of resilient elements during manufacture of such a unit.

10 A method and apparatus for making a resilient unit, such as a mattress, for example, are disclosed in our European patent number EP 1993 947 B. This describes the formation of a pocketed spring unit by feeding springs between upper and lower sheets of material, and joining the sheets together, for
15 example by welding, at locations between the springs, to form pockets around the springs.

Figure 1 shows schematically an example of apparatus
20 described in the abovementioned patent. Springs 100 are conveyed under compression to a spring-inserting position by spaced belts 110a and 110b, where they are pushed by mechanical pushers 120 that are driven by a motor 130 to move in a reciprocating motion,
25 indicated by arrow A1.

The pushers 120 push the springs into positions between sheets of material 130 fed from upper and lower supply rollers 140a and 140b via guide rollers
30 150a and 150b.

The sheets 130 are joined at positions between springs by the reciprocating action of an upper welding tool 160a in the direction shown by arrow A2 that presses the sheets together and fuses them on a welding anvil 160b. Rows of springs become encapsulated in pockets as the resilient unit 170 thus formed is advanced in the direction of Arrow A3.

The present invention is defined in the attached independent claims, to which reference should now be made. Further, preferred features may be found in the sub-claims appended thereto.

According to one aspect of the present invention, there is provided apparatus for making a resilient unit, the apparatus comprising at least first and second resilient element supply stations, and a pocketing station, wherein the first and second resilient element supply stations are arranged to supply respectively at least first and second resilient element types to the pocketing station, which first and second types differ from one another in at least one characteristic, and wherein the pocketing station is arranged in use to insert the resilient elements between superposed sheets of material, and to encapsulate the resilient elements in pockets formed by joining the sheets at least at positions between the springs.

Preferably the supply stations are arranged to supply the resilient elements to the pocketing station in at least one row. In a preferred

arrangement, the apparatus is arranged to insert resilient elements between the sheets, one row at a time, and the sheets are joined together before the unit is advanced, and the next row is inserted. The
5 apparatus is preferably arranged to supply the resilient elements to the pocketing station in a row in which the first and second types of resilient element are offset with respect to each other.

10 The resilient elements may be supplied to the pocketing station, preferably in a compressed state, on a conveyor, which may comprise one or more belts, or a belt and a compression plate, for example.

15 The resilient element types may differ from one another according to at least one characteristic, which may comprise any of a list including but not limited to: material composition, stiffness or resilience, height, width, colour, shape and
20 handedness, i.e. direction of coil.

There may be three or more resilient element supply stations, arranged in use to supply respectively three or more resilient element types, which may
25 differ from one another according to one or more characteristics.

The resilient elements may be supplied to the pocketing station in a row comprising a plurality of
30 discrete resilient element locations. The individual element locations may be occupied by a resilient element of a first type, or a resilient element of a

second, third or successive type, or may not be occupied by a resilient element at all.

5 The array of resilient units may therefore include resilient elements of one or more types, and may include locations in which there is no resilient element, so that one or more spaces may be located within the array.

10 The pockets may contain resilient elements of one or more various kinds or no resilient element.

15 One, more than one, or all, of the resilient elements may comprise a spring, which may be a coil spring and is preferably of metal. The first and second resilient element types may comprise first and second spring types, which may differ from one another in spring shape, characteristic, stiffness, gauge, diameter and/or other respects.

20 At least some of the resilient elements may comprise a first spring inside of which is a second spring. The second, inner spring is preferably not itself independently pocketed/encased.

25 The resilient unit may comprise an upholstered unit and/or may comprise an article from the following non-exhaustive list, including but not limited to: mattress, seat, table, pad, flooring, and may be used in various applications, in particular where
30 resilience is needed for comfort, convenience, support or protection, for example.

In accordance with a second aspect of the present invention there is provided a method of making a resilient unit, the unit comprising an array of resilient elements in pockets formed between
5 superposed sheets of material, the apparatus comprising: supplying at least first and second resilient element types from at least first and second supply stations to a pocketing station, which first and second types differ from one another in at
10 least one characteristic, and inserting the resilient elements between superposed sheets of material at the pocketing station, to encapsulate the resilient elements in pockets formed by joining the sheets at least at positions between the
15 springs.

The method preferably comprises supplying the resilient elements to the pocketing station in at least one row. Preferably the method comprises
20 inserting the resilient elements in between the sheets, one row at a time, and joining together the sheets before the unit is advanced, and the next row is inserted. The resilient elements may be supplied to the pocketing station in a row in which the first
25 and second types of resilient element are offset with respect to each other.

The method may include supplying the resilient elements to the pocketing station, preferably under
30 compression, on a conveyor, which may comprise one or more belts, or a belt and a compression plate.

The method may comprise supplying the resilient elements to the pocketing station in a row comprising a plurality of discrete resilient element locations. The individual element locations may be occupied by a resilient element of a first type, or a resilient element of a second, third or successive type, or may not be occupied by a resilient element at all.

The array of resilient units made according to the method may, therefore, include resilient elements of one or more types, and may include locations in which there is no resilient element, so that one or more spaces may be located within the array.

The method may comprise arranging resilient elements in the resilient unit such that one or more zones are formed, in which the resilient elements have different characteristics. The method may include arranging resilient elements in the resilient unit such that a pattern is formed in the resilient unit, which pattern may provide a visual, aesthetic or structural effect.

In a further aspect, the invention provides a computer programme product on a computer readable medium, comprising instructions that, when executed by a computer, cause the computer to perform a method of making a resilient unit, the unit comprising an array of resilient elements in pockets formed between superposed sheets of material, the apparatus comprising: supplying at least first and

second resilient element types from at least first and second supply stations to a pocketing station, which first and second types differ from one another in at least one characteristic, and inserting the resilient elements between superposed sheets of material at the pocketing station, to encapsulate the resilient elements in pockets formed by joining the sheets at least at positions between the springs.

10

The invention also comprises a program for causing a device to perform a method of making a resilient unit, the unit comprising an array of resilient elements in pockets formed between superposed sheets of material, the apparatus comprising: supplying at least first and second resilient element types from at least first and second supply stations to a pocketing station, which first and second types differ from one another in at least one characteristic, and inserting the resilient elements between superposed sheets of material at the pocketing station, to encapsulate the resilient elements in pockets formed by joining the sheets at least at positions between the springs.

20

The invention also includes a resilient unit made by apparatus or in accordance with a method as described herein.

25

According to another aspect of the present invention, there is provided a resilient unit, comprising an array of first springs located in discrete pockets

formed between superposed sheets of material joined at least at positions between the springs, wherein inside at least some of the first springs are located second, inner, non-pocketed springs.

5

Preferably the springs are held under compression in the pockets.

10

In a preferred arrangement the second spring is taller/longer than the first spring. This may allow the second spring to be held by the fabric of the pocket, restricting its movement inside the first spring, and hence inhibiting contact between the first and second springs.

15

In a particularly preferred arrangement, the first spring may be wider than it is tall. The second spring may be taller than it is wide.

20

Preferably the first springs are of wire of a first gauge and the second springs are of wire of a second, different gauge.

25

Preferably the first gauge is greater, ie thicker, than the second gauge. In other words, the average diameter of the wire from which the first springs are made is greater than the average diameter of the wire from which the second springs are made.

30

The average diameter of the wire from which at least one of the first and second spring types is made may be below 1mm.

In a preferred arrangement, the average diameter of the wire of the first springs is in a range 0.5mm to 1.0mm. The average diameter of the wire in the second
5 spring type may be in a range 0.5mm to 0.7mm.

The invention may include any combination of the features or limitations referred to herein, except such a combination of features as are
10 mutually exclusive, or mutually inconsistent.

A preferred embodiment of the present invention will now be described, by way of example only, with reference to the accompanying diagrammatic
15 drawings, in which:

Figure 1 shows in side schematic view a previously considered apparatus for forming a resilient unit;

20 Figure 2 shows schematically an arrangement of spring supply stations and a pocketing station, according to an embodiment of the present invention;

Figures 3 to 7 show schematically examples of variants
25 in the resilient unit made using the apparatus of Figures 1 and 2; and

Figures 8a and 8b show examples of alternative combinations of spring according to an embodiment of
30 the present invention.

Turning to Figure 2, this shows schematically at 200
apparatus for forming a resilient unit. The apparatus
comprises a conveyor 210 and first and second spring
supply stations 212 and 214, arranged in use to
5 deposit respectively first and second spring types 216
and 218 under compression onto the conveyor. The
conveyor is arranged in use to convey a row of the
springs 216, 218 in a direction shown by Arrows A4
10 towards pocketing station 220. The conveyor may be
according to any suitable design that allows the
springs to be transported securely, preferably under
compression. For example a pair of superposed belts or
a single belt opposite a stationary plate can be used.

15 At the pocketing station 220 the springs are urged
from the conveyor into positions between upper and
lower sheets 222 and 224, by a plurality of inserter
devices 226 that move together in a reciprocating
20 fashion in the direction of arrow A5, before
retracting to the position shown.

After each row of springs is inserted between the
sheets 222, upper and lower computer-controlled
25 welding tools (not shown) come together at positions P
between the springs to join the sheets together,
forming pockets in which the springs are encased.
After each welding event the resilient unit is indexed
forwards a distance equal to one pocket width in the
30 direction of Arrows A6 by computer-controlled drive
means (not shown). The next row of springs is then

conveyed into position ready for insertion between the sheets of material, and the process is repeated.

5 The two spring supply stations are arranged to supply springs that differ from one another in at least one characteristic. In this case the springs 216 are of smaller diameter and are taller and stiffer than the springs 218. The result is a resilient unit in which alternate springs are taller and stiffer than their
10 immediate neighbours. Because of its appearance this type of unit is sometimes referred to as a "hi-lo" unit.

15 Figures 3 to 7 depict some examples of the different patterns of resilient unit that can be obtained by using the apparatus of Figure 2. In particular, using the twin supply stations, it is possible to make up a row for insertion in which each one of a plurality of defined spring locations is occupied
20 either by a spring of a first kind, a spring of a second kind or else no spring - i.e. the absence of a spring (when one of the supply stations suspends its deposition of a spring for one cycle.

25 The example of Figure 3 is one in which the a resilient unit 300 is made up of only one kind of spring, so that one supply station provides a spring of a certain kind in each location for each row.

30 Figure 4 shows an example in which the resilient unit comprises a main portion 310 of a first kind,

with a border of a second kind 320 of spring. The border may be made to have springs of a stiffer characteristic, for example.

5 Figure 5 is an example in which the resilient unit is made up of alternating zones 330, 340 of different springs, providing a different characteristic, such as stiffness.

10 Figure 6 uses a first kind of spring from one supply, combined with an absence of spring from the second supply, so that spaces appear to form a zig-zag visual pattern.

15 Figure 7 shows a resilient unit 300 in which springs of one type are combined with absent springs, so as to reduce the density of springs in the unit 300.

20 It will be apparent to the reader that by using combinations of types of spring, or absences of spring, including springs that differ from one another in respect of one or more characteristics, it is possible to provide a resilient unit having a wide variety of patterns, both for aesthetic and
25 functional purposes. Furthermore, the apparatus need not be confined to only two spring supply stations. With three or more supply stations the range of possibilities for more sophisticated patterns becomes still further extended.

30

5 The springs can differ from one another in respect of one or more characteristics such as from a list including but not limited to: stiffness, length, diameter, shape, colour and handedness - ie the direction of coil.

10 Furthermore, it is possible for a spring supply station to deposit more than one spring in the same location on the conveyor, for example by placing a pair of springs in a location, wherein one spring lies within the other, substantially coaxially.

15 Thus, in the assembled resilient unit, at least some of the pocketed springs may incorporate a second spring that is not encased in its own pocket -i.e. is not itself independently pocketed.

20 Figures 8a and 8b show examples of a pair 400 of springs encapsulated within a pocket formed by two superposed sheets 222a and 222b of material, as described above. In each case the pair comprises an outer spring 410 and an inner spring 420. In Figure 8a the outer spring 410 is taller than the inner spring. In Figure 8b the inner spring 420 is taller, 25 so that it protrudes slightly above the outer spring. Different spring combinations can provide finely tuned resilient characteristics. Ideally, the inner spring is at least as tall as the outer spring, and is more preferably taller than the outer 30 spring.

In one preferred embodiment, the inner spring may be taller than it is wide - i.e. its length is greater than its maximum diameter. The outer spring may be shorter than it is wide - i.e. its height/length is less than its maximum diameter.

If the inner spring is taller than the outer one, as shown in Figure 8b, and is held under compression in the pocket, its ends will press against, and be held by, the material or fabric of the pocket. This preferred arrangement means that the inner spring will be less likely to move within the pocket, and therefore less likely to contact the outer spring, which would result in unwanted noise.

Another measure that can be employed to minimize unwanted noise of springs rubbing against springs is to make the inner and outer springs have different handedness - ie for their directions of coil to be in an opposite sense, one left handed and one right handed, when viewed from an end. This also lessens the likelihood of the substantially coaxial springs meshing or jamming together.

The inner spring being taller than the outer one also affects the compression characteristic of the resilient unit, since the resistance to compression of the unit will come only from the inner spring in a first phase of compression, before further compression encounters resistance from the outer spring also. Such a dual tension micro-spring

provides a so-called "soft start" compression characteristic, which is often desirable, for example in a mattress.

5 The inner and outer springs can be of different basic types, or shapes. For example, possible shapes for the springs include, but are not limited to, cylindrical, conical, barrel-shaped, and also hybrid types such as are described in our UK patent
10 application no. 2495499.

The choice of gauge for the wire used in the springs is important. One of the springs - preferably the inner spring - should be of a smaller gauge, i.e. it
15 should be of wire having a smaller average diameter. This helps to reduce the potential for the pair of springs to make unwanted noise as they contact one another during compression or relaxation. The wire in at least one of the springs, and preferably both
20 the inner and outer spring, should be less than or equal to 1.0mm in diameter. In a preferred arrangement the wire of the inner spring should be of a diameter in the range 0.5mm to 0.7mm and the outer spring should be of wire having a diameter in
25 the range 0.5mm to 1.0mm.

At least some adjacent springs, or pairs of springs within springs, in the array are preferably arranged to be of different handedness - i.e. to be coiled in
30 different directions - to combat any tendency for the resilient unit to become twisted due to the

springs all being coiled in the same direction. Preferably the springs are arranged in alternate handedness.

5 Whilst endeavouring in the foregoing specification to draw attention to those features of the invention believed to be of particular importance, it should be understood that the applicant claims protection
10 in respect of any patentable feature or combination of features referred to herein, and/or shown in the drawings, whether or not particular emphasis has been placed thereon.

CLAIMS

- 5 1. A resilient unit, comprising an array of first springs located in discrete pockets formed between superposed sheets of material joined at least at positions between the springs, wherein inside at least some of the first springs are located second, inner, non-pocketed springs.
- 10 2. A resilient unit according to Claim 1, wherein the springs are held under compression in the pockets.
- 15 3. A resilient unit according to Claim 1 or 2, wherein the second spring is taller/longer than the first spring.
- 20 4. A resilient unit according to Claim 3, wherein the second spring is substantially held in position by the pocket of the first spring.
- 25 5. A resilient unit according to any of the preceding claims, wherein the first spring is wider than it is tall.
6. A resilient unit according to any of the preceding claims, wherein the second spring is taller than it is wide.
- 30 7. A resilient unit according to any of the preceding claims, wherein the first springs are of wire of a

first gauge and the second springs are of wire of as second, different gauge.

5 8. A resilient unit according to Claim 7, wherein the first gauge is greater, ie thicker, than the second gauge.

10 9. Apparatus for making a resilient unit, the apparatus comprising at least first and second resilient element supply stations, and a pocketing station, wherein the first and second resilient element supply stations are arranged to supply respectively at least first and second resilient element types to the pocketing station, which first and second types differ from one another in at least one characteristic, and wherein the pocketing station is arranged in use to insert the resilient elements between superposed sheets of material, and to encapsulate the resilient elements in pockets
15 20 formed by joining the sheets at least at positions between the springs.

25 10. Apparatus according to Claim 9, wherein the supply stations are arranged to supply the resilient elements to the pocketing station in at least one row.

30 11. Apparatus according to Claim 9 or 10, wherein the resilient elements are supplied to the pocketing station in a row in which the first and second types of resilient element are offset with respect to each other.

12. Apparatus according to any of Claims 9 to 11,
wherein the resilient elements are supplied to the
pocketing station in a compressed state, on a
conveyor, which comprises one or more belts, or a
belt and a compression plate.

13. Apparatus according to any of Claims 9 to 12,
wherein the resilient element types differ from one
another according to at least one characteristic, of
a list including but not limited to: material
composition, stiffness or resilience, height, width,
colour, and shape.

14. Apparatus according to any of Claims 9 to 13,
wherein there are three or more resilient element
supply stations, arranged in use to supply
respectively three or more resilient element types,
which may differ from one another according to one
or more characteristic.

15. Apparatus according to any of Claims 9 to 14,
wherein the resilient elements are arranged to be
supplied to the pocketing station in a row
comprising a plurality of discrete resilient element
locations.

16. Apparatus according to Claim 15, wherein the
individual element locations may be occupied by a
resilient element of a first type, or a resilient
element of a second, third or successive type, or
may not be occupied by a resilient element at all.

17. A method of making a resilient unit, the unit comprising an array of resilient elements in pockets formed between superposed sheets of material, the apparatus comprising: supplying at least first and second resilient element types from at least first and second supply stations to a pocketing station, which first and second types differ from one another in at least one characteristic, and inserting the resilient elements between superposed sheets of material at the pocketing station, to encapsulate the resilient elements in pockets formed by joining the sheets at least at positions between the springs.

18. A method according to Claim 17, wherein the method comprises supplying the resilient elements to the pocketing station in at least one row.

19. A method according to Claim 17 or 18, wherein the method comprises arranging resilient elements in the resilient unit such that one or more zones are formed, in which the resilient elements have different characteristics.

20. A method according to any of Claims 17 to 19, wherein the method includes arranging resilient elements in the resilient unit such that a pattern is formed in the resilient unit, which pattern may provide a visual, aesthetic or structural effect.

21. A computer programme product on a computer readable medium, comprising instructions that, when executed by a computer, cause the computer to perform a method of making a resilient unit, the unit comprising an array of resilient elements in pockets formed between superposed sheets of material, the apparatus comprising: supplying at least first and second resilient element types from at least first and second supply stations to a pocketing station, which first and second types differ from one another in at least one characteristic, and inserting the resilient elements between superposed sheets of material at the pocketing station, to encapsulate the resilient elements in pockets formed by joining the sheets at least at positions between the springs.

22. A program for causing a device to perform a method of making a resilient unit, the unit comprising an array of resilient elements in pockets formed between superposed sheets of material, the apparatus comprising: supplying at least first and second resilient element types from at least first and second supply stations to a pocketing station, which first and second types differ from one another in at least one characteristic, and inserting the resilient elements between superposed sheets of material at the pocketing station, to encapsulate the resilient elements in pockets formed by joining the sheets at least at positions between the springs.

23. A resilient unit made by apparatus according to any of Claims 9 - 16 or in accordance with a method according to any of Claims 17 to 20.

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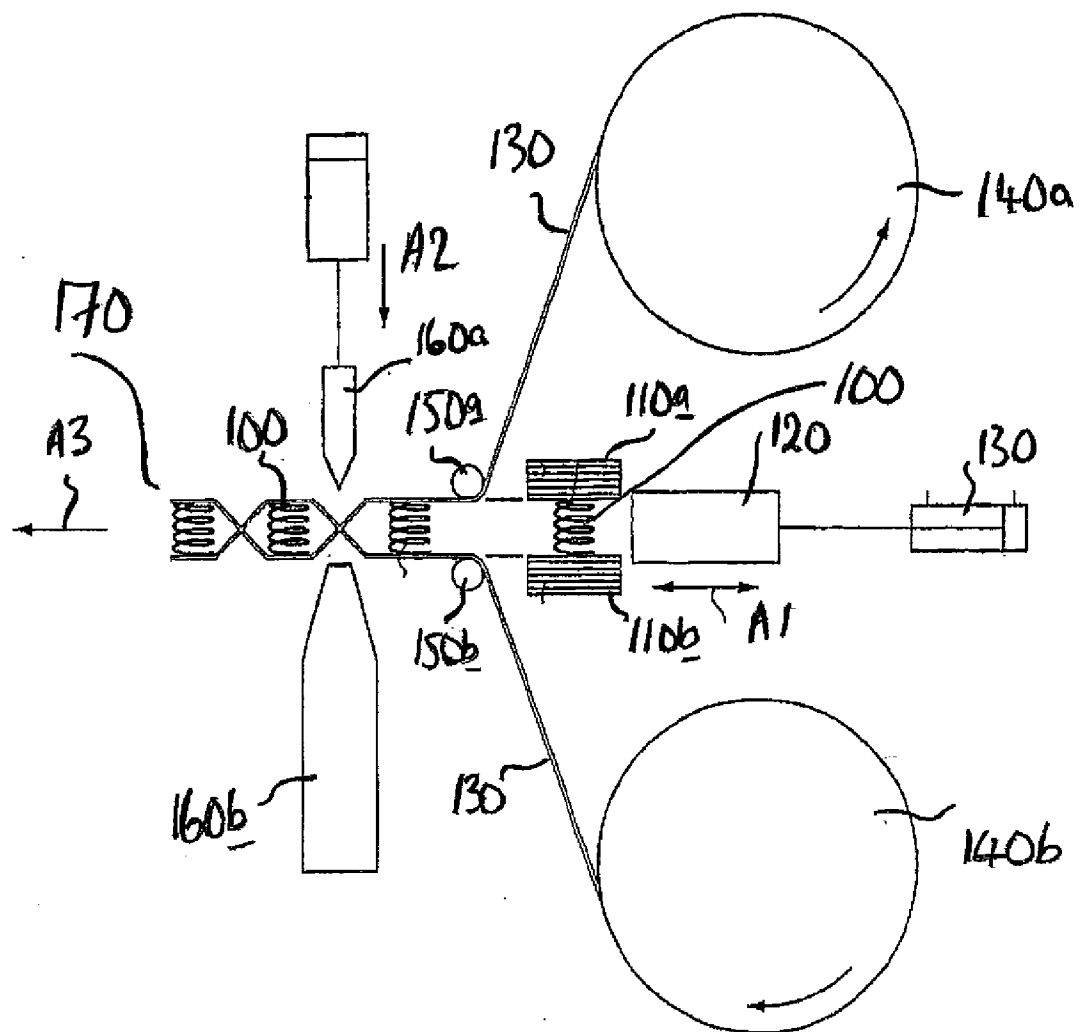
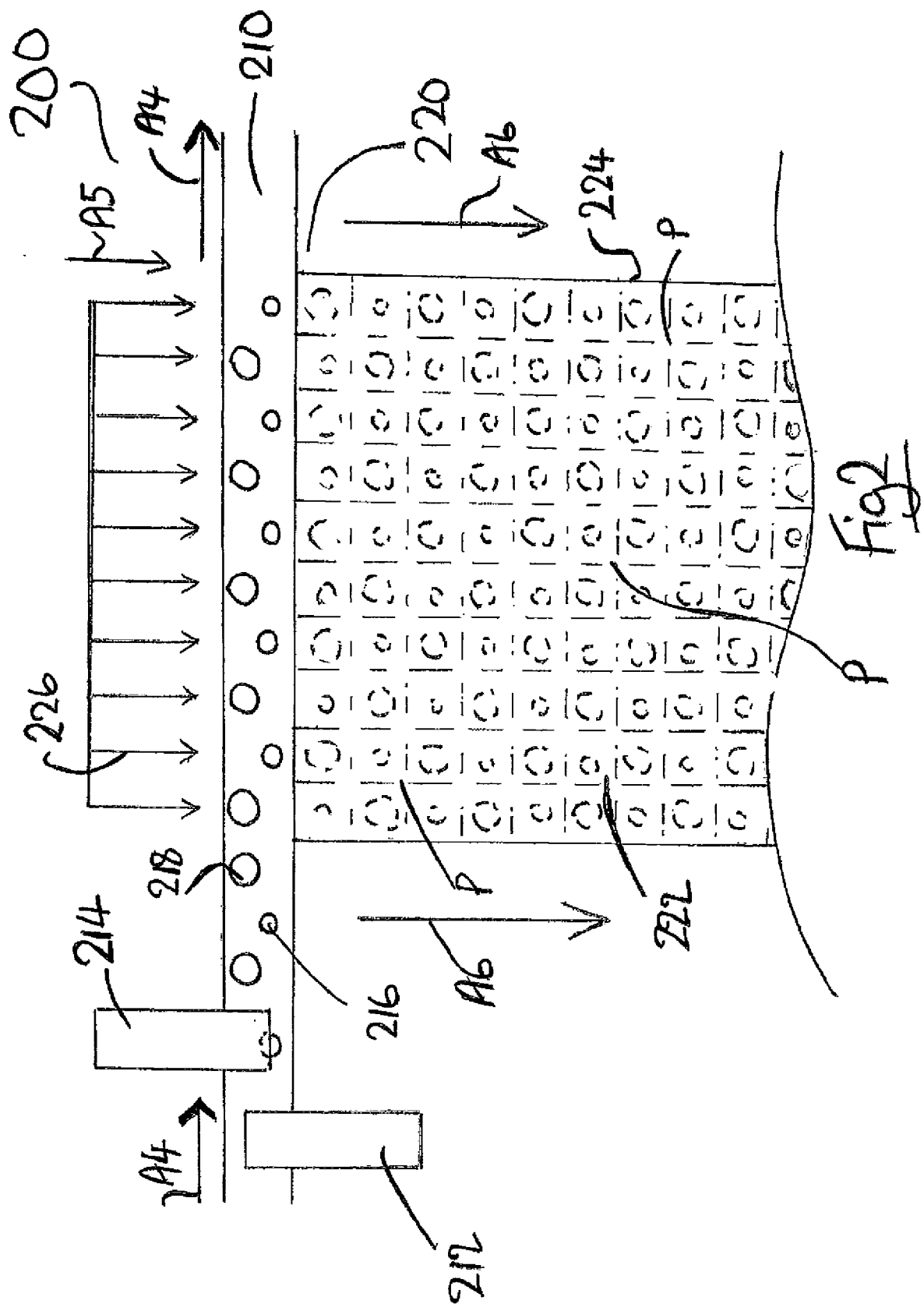
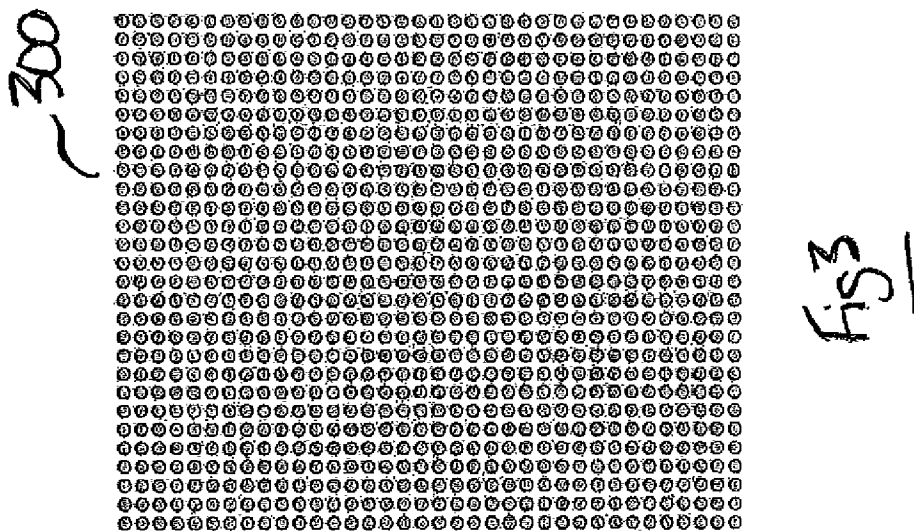
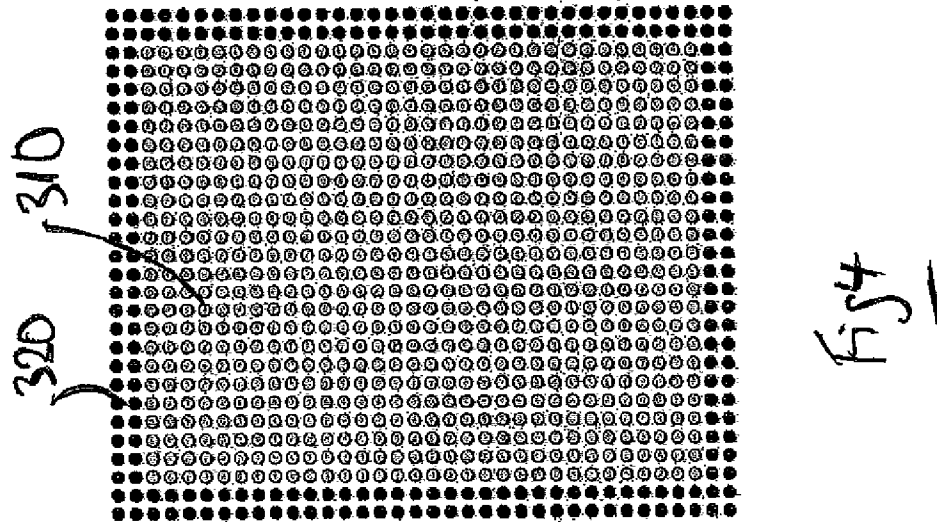
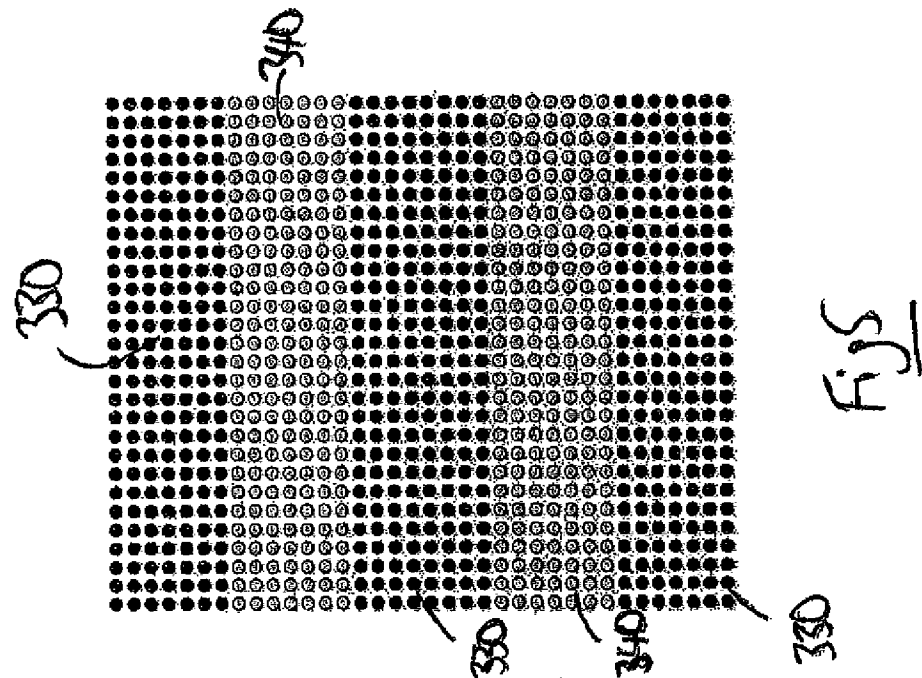


Fig 1





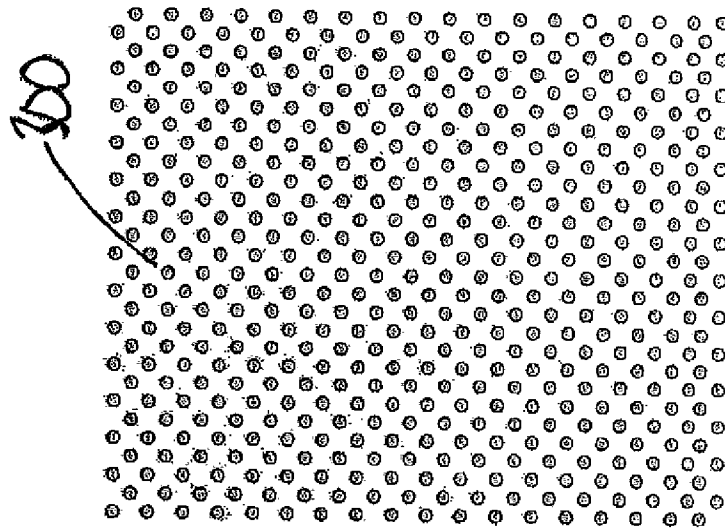


Fig 7

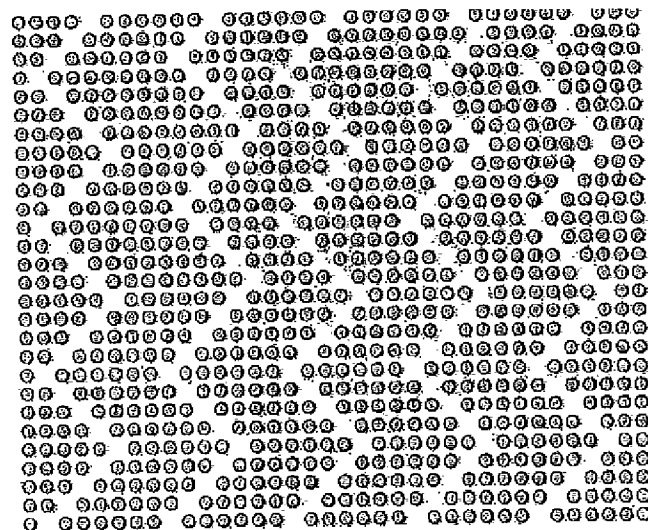


Fig 6

