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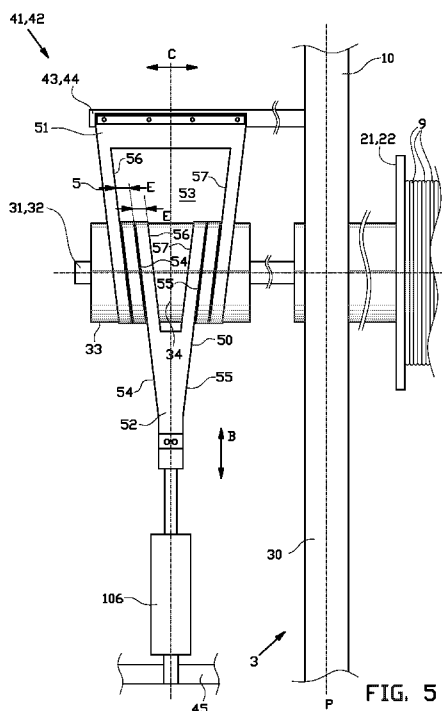
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(54) Title: CREEL BOBBIN BRAKE, CREEL BOBBIN ASSEMBLY, A CREEL AND A CREEL METHOD



(57) Abstract: The invention relates to a first creel bobbin brake (41, 141), a creel bobbin assembly (3, 103), a creel (1, 101) and a creel method. The first creel bobbin brake (41, 141) is arranged for applying a braking torque to a first shaft (31, 131) of a first creel bobbin (21). The first creel bobbin brake (41, 141) comprises a strap (5, 205) that is provided with a first end (51, 251), a second end (52, 252) and a strap body (50, 250) extending in a longitudinal direction between the first end (51, 251) and the second end (52, 252), wherein the strap (5, 205) further comprises an opening (53, 253) in the strap body (50, 250), wherein the strap body (50, 250) and the opening (53, 253) are arranged to taper from the first end (51, 251) towards the second end (52, 252), wherein the strap (5, 205) is arranged to be wound around the first shaft (31, 131) of the first creel bobbin (21) over at least two revolutions, wherein the second end (52, 252) is insertable through the opening (53, 253) with each revolution.

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5 Creel bobbin brake, creel bobbin assembly, a creel and a
creel method

10 BACKGROUND

The invention relates to a creel bobbin brake, a creel bobbin assembly, a creel and a creel method.

With tire designs featuring increasingly wider
15 tires, cord or wire reinforced tire components have grown increasingly wider as well, embedding more and more reinforcement wires. As each reinforcement wire is supplied from an individual creel bobbin, the number of creel bobbins has been steadily increasing. Currently, a creel
20 may contain several hundreds of creel bobbins. Each creel bobbin has to be braked individually to ensure uniform tension in all wires. Consequently the complexity, costs and footprint of a creel have been increasing dramatically. Hence, there is a need to reduce the complexity, the costs
25 and/or the footprint of a creel.

It is an object of the present invention to provide a creel bobbin brake, a creel bobbin assembly, a creel and a creel method, wherein the complexity, costs and/or footprint of the creel can be reduced.

30

SUMMARY OF THE INVENTION

According to a first aspect, the invention
35 provides a first creel bobbin brake for applying a braking torque to a first shaft of a first creel bobbin, wherein the first creel bobbin brake comprises a strap that is

provided with a first end, a second end and a strap body extending in a longitudinal direction between the first end and the second end, wherein the strap further comprises an opening in the strap body, wherein the strap body and the opening are arranged to taper from the first end towards the second end, wherein the strap is arranged to be wound around the first shaft of the first creel bobbin over at least one and a half revolutions, wherein the second end is insertable through the opening with each revolution, wherein the strap comprises a first outer edge and a second outer edge tapering towards each other from the first end towards the second end on opposite sides of the strap body, wherein the strap further comprises a first inner edge and a second inner edge tapering towards each other from the first end towards the second end on opposite sides of the opening, wherein the first outer edge and the second outer edge are arranged to extend on the alongside of the first inner edge and the second inner edge, respectively, with each revolution after the first revolution.

It has been found that winding the strap over at least one and a half revolutions about the shaft can make the brake torque substantially independent or completely independent from the friction between the strap and the shaft. With said at least one and a half revolutions, the brake torque can be made almost solely dependent on tension in the strap and the diameter of the brake surface at the shaft. It is known to wind a strap helically over a single revolution about the shaft. However, said helically wound strap tends to run-off to the side of the shaft. Although it would be possible to wind the strap over multiple revolutions about the shaft, this will only intensify the problem. The strap according to the present invention is arranged to be wound over at least one and a half revolutions while the second end can be inserted repeatedly through the same opening with each revolution. By inserting the second end through the same opening with each revolution, the subsequent windings can take place

symmetrically, e.g. in the same plane parallel to the longitudinal direction of the strap. This reduces the tendency of strap to run off to one side of the shaft. Hence, a less complex, inexpensive yet effective creel
5 bobbin brake can be obtained. Because of the tapering inner and outer edges, with each revolution of the strap about the shaft, the outer edges thereof can fit within the inner edges that define the opening.

In a preferred embodiment the strap is arranged
10 to be wound around the first shaft of the first creel bobbin over at least two revolutions, and preferably at least three revolutions, wherein the second end is insertable through the opening with each revolution. Depending on the friction characteristics of the material
15 that has been chosen for the strap, it may be advantageous to wind the strap around the first shaft over one or more additional revolutions to make the brake torque solely dependent on the tension in the strap.

In an embodiment thereof the opening has a
20 smallest width in a lateral direction perpendicular to the longitudinal direction of the strap body, wherein the strap body at the second end has a smallest width in the lateral direction that is equal to or smaller than the smallest width of the opening. Hence, the second end can be inserted
25 through the opening at each position along said opening.

In an alternative embodiment the opening extends up to and is open at the first end of the strap body in the longitudinal direction. Hence, the opening can divide the strap body into two legs that terminate at the first end
30 and that can be spread apart at an adjustable taper angle to allow for more or less windings of the strap body about the first shaft.

In a further embodiment the strap body and the opening taper linearly from the first end towards the
35 second end. Hence, with each revolution of the strap, the strap body and the opening taper in the same amount.

In a further embodiment the strap body and the

opening taper from the first end towards the second end at a taper angle which is the same for both the strap body and the opening. Thus, the strap body and the opening can thus taper in substantially the same amount.

5 In a further embodiment the strap body is symmetrical or substantially symmetrical in a lateral direction perpendicular to the longitudinal direction of the strap body. Because of the symmetry, the forces and/or tension in the strap body can be divided uniformly and/or
10 evenly over the strap.

 In an embodiment thereof the first inner edge and the second inner edge are parallel or substantially parallel to the first outer edge and the second outer edge, respectively. Consequently, the width of the strap body
15 between said edges can be kept substantially constant.

 In a further embodiment thereof the first outer edge, the second outer edge, the first inner edge and the second inner edge taper inwards in a lateral direction perpendicular to the longitudinal direction over each
20 revolution with a pitch distance, wherein the distance between the first outer edge and the first inner edge and the distance between the second outer edge and the second inner edge in said lateral direction is equal to or smaller than the pitch distance. Said relation between the pitch
25 distance and the distance between the respective outer edge and the inner edge provides that each subsequent winding of the strap body can fit within the opening of the previous winding.

 In a further embodiment the strap body is made
30 from a single piece of material. Hence, the complexity and/or costs of the strap body can be reduced.

 In one embodiment the strap body comprises reinforced synthetic resin or rubber based material. With said material, the strap can be made independent from
35 friction with at least two revolutions and preferably at least three revolutions.

 Alternatively, the strap body comprises leather.

With said alternative material, the strap can be made independent from friction with at least two revolutions.

According to a second aspect, the invention provides a creel bobbin assembly comprising the
5 aforementioned first creel bobbin brake, wherein the creel bobbin assembly further comprises a first shaft for supporting a first creel bobbin and a base member for supporting said first shaft with respect to a creel plane, wherein the first shaft is provided with a brake surface,
10 wherein the strap of the first creel bobbin brake is arranged to be wound around said brake surface over the at least two revolutions. This provides the same advantages as the previously discussed embodiments of the first creel bobbin brake.

15 In an embodiment thereof the brake surface has a circumference, wherein the opening in the strap body has a length in the longitudinal direction of the strap body that is equal to or larger than two times the circumference of the brake surface. Hence, the opening is sufficiently long
20 such that the second end can be inserted there through at least one more time and preferably at least two more times after the first revolution.

In a further embodiment thereof the brake surface is formed by a brake drum that is rotationally fixed to the
25 at least one shaft. Said brake drum can provide an increased diameter with respect to the shaft and/or may be provided with another material to increase the brake torque that can be applied to the first shaft.

According to a third aspect, the invention
30 provides a creel bobbin assembly comprising a first shaft for supporting a first creel bobbin and a base member for supporting said first shaft with respect to a creel plane, wherein the first shaft comprises a second shaft for supporting a second creel bobbin, wherein the base member
35 is arranged for supporting said second shaft with respect to the creel plane. Hence, two creel bobbins can be supported by the same base member.

Preferably, the first shaft and the second shaft are arranged for supporting the first creel bobbin and the second creel bobbin, respectively, on the same side of the creel plane.

5 In a first embodiment the first shaft and the second shaft are mutually parallel yet spaced apart in a direction parallel to the creel plane. By spacing said first shaft and said second shaft apart, the creel bobbins can be supported in an at least partially spaced apart
10 relationship.

In an embodiment thereof the second shaft is longer than the first shaft to support the second creel bobbin at a spacing distance from the creel plane to allow for intermediate placement of the first creel bobbin
15 between the creel plane and the second bobbin. By placing the first creel bobbin between the creel plane and the second bobbin, the first creel bobbin and the second creel bobbin can be placed side-by-side in an axial direction parallel to the rotation axes thereof. Preferably, the
20 first shaft and the second shaft are spaced apart in the direction parallel to the creel plane over a distance such that the first creel bobbin and the second creel bobbin at least partially overlap each other in the direction parallel to the creel plane. Hence, the first shaft and the
25 second shaft can be placed closer together with the first creel bobbin and the second creel bobbin at least partially overlapping each other. Thus, more creel bobbins can be fitted within the same footprint.

In an alternative embodiment the first shaft and
30 the second shaft are coaxial. Preferably, the first shaft is hollow and wherein the second shaft extends concentrically through the first shaft, wherein the second shaft protrudes from the first shaft to support the second creel bobbin in a side-by-side relationship with the first
35 creel bobbin. Hence, two creel bobbins can be placed at the same position on the creel wall, thereby significantly reducing the footprint of the creel.

In a further embodiment the assembly further comprises a first creel bobbin brake and a second creel bobbin brake for applying a braking torque to the first shaft of the first creel bobbin and the second shaft of the second creel bobbin, respectively. Hence, the shafts of both creel bobbins can be braked individually.

In an embodiment thereof each bobbin brake comprises a strap that is provided with a first end and a second end, wherein each creel bobbin brake further comprises a first mounting member for mounting the first end of the strap to the base member and a second mounting member for mounting the second end of the strap to the base member. Hence, the strap can be mounted between the respective mounting members while in between the strap is wound around the first shaft.

In an embodiment thereof the creel bobbin assembly further comprises a tensioner that is arranged between the second mounting member and the base member. When the tensioner is arranged between the second mounting member and the base member, the second mounting member can be pulled, thereby indirectly tensioning the strap that extends between the first mounting member and the second mounting member.

In an alternative embodiment thereof the creel bobbin assembly further comprises a tensioner that is arranged between the second end and the second mounting member. When the tensioner is arranged between the second end and the second mounting member, the second end of the strap can be put under tension directly, thereby directly tensioning the strap that extends between the first mounting member and the second mounting member.

According to a fourth aspect, the invention provides a creel comprising a plurality of creel bobbins, a plurality of guiding tubes located at the lower end of the creel and a plurality of guiding tubes located at the upper end of the creel, wherein each guiding tube is arranged for receiving a wire from an individual creel bobbin, wherein

the lower half of the creel bobbins are arranged to feed their wires to the guiding tubes at the upper end of the creel, while the upper half of the creel bobbins are arranged to feed their wires to the guiding tubes at the lower end of the creel. Hence, the overall height of the creel can be reduced.

According to a fifth aspect, the invention provides a creel comprising a creel bobbin and a guiding tube for receiving a wire from said creel bobbin, wherein the wire in use extends from the creel bobbin towards the guiding tube at a fleet angle with respect to an imaginary center line normal to the axial direction of the creel bobbin, wherein the wire extends at a maximum fleet angle when the wire is unwinding from the extreme left and the extreme right of the creel bobbin, wherein the creel bobbin has a bobbin width and a minimum distance between the circumference of the creel bobbin and the guiding tube, wherein the bobbin width and the minimum distance are chosen such that the maximum fleet angle is less than ten degrees. Hence, the optimal fleet angle can be obtained.

Preferably, the maximum fleet angle is less than five degrees or less than three degrees.

According to a sixth aspect, the invention provides one or more creels and a wire collector for use with said one or more creels, wherein the one or more creels are arranged for supporting a first group of creel bobbins and a second group of creel bobbins relative to a creel plane, wherein the wire collector comprises a first collection section for collecting wires from the creel bobbins of the first group and a second collection section for collecting wires from the creel bobbins of the second group, wherein the collection sections are movable in a switching direction transverse or perpendicular to the creel plane to alternately align the first collection section and the second collection section with a downstream station. Hence, while the first collection section is actively outputting wires from the first group of creel

bobbins, the wires from the second group of creel bobbins can be organized and/or prepared in the second collection section so that the wire collector can quickly switch between groups when creel bobbins of the first group are
5 emptied or depleted.

In one configuration the one or more creels comprises a single creel that is arranged for supporting the first group of creel bobbins at one side of the creel plane and the second group of creel bobbins at the opposite
10 side of the creel plane. Hence, the wire collector can quickly switch between two groups of creel bobbins of the same creel.

In an alternative configuration the one or more creels comprises a first creel that is arranged for supporting the first group of creel bobbins and a second
15 creel that is arranged for supporting the second group of creel bobbins. Hence, the wire collector can quickly switch between different creels.

In a preferred embodiment the collection sections
20 are movable in the switching direction to alternately align the first collection section and the second collection section with a downstream station in an output direction parallel or substantially parallel to the creel plane. Hence, the downstream station can be arranged in parallel
25 with the creel plane.

In another embodiment each collection section comprises collector rollers that are tiltable about a vertical axis to follow or adjust for the movement of the collection sections in the switching direction relative to
30 the one or more creels. Hence, the wires can be accurately guided from the one or more creels to an out-of-line downstream station.

According to a seventh aspect, the invention provides a creel comprising a plurality of the
35 aforementioned creel bobbin assemblies. With the increasingly bigger creels, the advantages of the individual creel bobbin assemblies in terms of costs,

complexity and/or footprint are even more relevant for reducing the costs, complexity and/or footprint of the creel as a whole.

Preferably, the creel comprises a creel wall,
5 wherein the base member is mountable and dismountable with respect to said creel wall. The base members can be easily dismounted, which is particularly advantageous when each base member carries two shafts and/or the associated creel bobbin brakes.

10 According to an eighth aspect, the invention provides a creel method for mounting the aforementioned strap to the aforementioned creel bobbin assembly, wherein the creel method comprises the steps of winding the strap around the first shaft of the first creel bobbin over at
15 least two revolutions and inserting the second end through the opening with each revolution. The method relates to the implementation of the aforementioned strap to a creel bobbin assembly and thus has the same advantageous effects.

In a preferred embodiment the creel method
20 comprises the steps of winding the strap around the first shaft of the first creel bobbin over at least three revolutions and inserting the second end through the opening with each revolution.

The various aspects and features described and
25 shown in the specification can be applied, individually, wherever possible. These individual aspects, in particular the aspects and features described in the attached dependent claims, can be made subject of divisional patent applications.

30 For example, the spaced apart arrangement and the coaxial arrangement of the first shaft and the second shaft in the creel bobbin assembly according to the second aspect of the invention can be applied individually from the first creel bobbin brake and the second creel bobbin brake.

BRIEF DESCRIPTION OF THE DRAWINGS

The invention will be elucidated on the basis of exemplary embodiments shown in the attached schematic drawings, in which:

figure 1 shows a front view of a creel according to a first embodiment of the invention with a plurality of first creel bobbins and a plurality of second creel bobbins;

figure 2 shows a side view of a creel bobbin holder for holding a set of a first creel bobbin and a second creel bobbin, wherein the second creel bobbin is shown partially in cross section;

figure 3 shows the creel bobbin holder with a creel bobbin brake for braking one of the creel bobbins held by said creel bobbin holder;

figures 4 and 5 show in side view the steps of mounting the creel bobbin brake to the creel bobbin holder of figure 2;

figure 6 shows in side view an optional additional step of mounting the creel bobbin brake to the creel bobbin holder of figure 2;

figures 7, 8 and 9 show in side view the steps of mounting an alternative creel bobbin brake according to a second embodiment of the invention to the creel bobbin holder of figure 2;

figures 10 and 11 show details of a guiding tube that is used in the creel of figure 1;

figure 12 shows a detail of an alternative guiding tube that can be used in the creel of figure 1;

figure 13 shows a rear view of the creel bobbin brake or the alternative creel bobbin brake in the mounted state of figure 5 or 9, respectively;

figure 14 shows a side view of an alternative creel bobbin holder according to a third embodiment of the invention;

figure 15 shows a side view of the positioning of

one of the creel bobbins in the creel according to figure 1;

figure 16 shows a front view of the creel according to figure 1 in combination with a wire collector according to a fourth embodiment of the invention for collecting the wires from the plurality of bobbins;

figures 17A and 17B show top views of a single creel in combination with the aforementioned wire collector; and

figure 18A and 18B show top view of a double creel in combination with the aforementioned wire collector.

DETAILED DESCRIPTION OF THE INVENTION

Figure 1 shows a creel 1 according to a first embodiment of the invention. The creel 1 comprises a creel wall 10 that defines a creel plane P and a plurality of first reels or bobbins 21 and second reels or bobbins 22 rotatably mounted to said creel wall 10 at the same side of said creel plane P. Each bobbin 21, 22 holds a plurality of windings of a cord or a wire 9 that is arranged to be unwound from the respective bobbin 21, 22 and guided through the creel 1 via a wire collector (not shown) towards an extruder (not shown) for embedding into rubber to form a reinforced rubber ply (not shown) for use in tire building. The wires 9 are preferably made from metal or fabric in accordance with the desired specifications of the tire component. The wires 9 should be supplied to the extruder at substantially the same tension to prevent deformation in the reinforced rubber ply.

As shown in the partial cross section of figure 2, each creel bobbin 21, 22 comprises a hub 23 that defines central axis of the respective creel bobbin 21, 22 and a set of flanges 24, 25 that contain the wire 9 on the respective creel bobbin 21, 22 in an axial direction

parallel to the central axis. The creel 1 comprises a plurality of creel bobbin assemblies 3 for holding the plurality of creel bobbins 21, 22. One of said creel bobbin assemblies 3 is shown in more detail in figure 2. Each
5 creel bobbin assembly 3 is provided with a first shaft 31 and a second shaft 32 that define a first rotation axis R1 and a second rotation axis R2, respectively. Each of the first creel bobbins 21 and the second creel bobbins 22 is arranged to be placed with its central hub 23 on a
10 respective one of the first shafts 31 and the second shafts 32, respectively, such that its central axis is aligned with the rotation axis R1, R2 defined by said one shaft 31, 32. Each creel bobbin 21, 22 is rotationally fixed with respect to its respective shaft 31, 32 so as to be
15 rotatable together with said shaft 31, 32 about the respective rotation axis R1, R2.

In this exemplary first embodiment, each creel bobbin assembly 3 comprises a set of one of the first shafts 31 and one of the second shafts 32 and a common base
20 member 30 for rotatably supporting the set of shafts 31, 32 with respect to the creel wall 10. The base member 30 is mounted to the creel wall 10 with suitable fasteners, e.g. bolts. Hence, the set of two shafts 31, 32 can be mounted simultaneously by attaching the base member 30 to the creel
25 wall 10. Alternatively, the shafts 31, 32 may be directly supported on and/or mounted to the creel wall 10, in which case the base member is formed by the creel wall 10 itself.

As shown in figure 2, the first shaft 31 and the second shaft 32 of the creel bobbin assembly 3 are mutually
30 parallel yet spaced apart in a direction parallel to the creel plane P. As a result, the first rotation axis R1 and the second rotation axis R2 are offset with respect to each other in the direction parallel to the creel plane P. Furthermore, the second shaft 32 is considerably longer
35 than the first shaft 31 to protrude beyond the first shaft 31 and to support the second creel bobbin 22 at a spacing distance X spaced apart from the creel plane P. Preferably,

said spacing distance X is sufficient to allow for intermediate placement of the first creel bobbin 21 between the second creel bobbin 22 and the creel plane P, such that the first creel bobbin 21 can just rotate freely with respect to the second creel bobbin 22. Hence, the first creel bobbin 21 and the second creel bobbin 22 can be placed side-by-side in an at least partially overlapping arrangement. The first shaft 31 and the second shaft 32 can thus be position closer to each other in a direction parallel to the creel plane P. In particular, the first shaft 31 and the second shaft 32 can be spaced apart in a direction parallel to the creel plane P over a distance of less than two-thirds of the diameter of the creel bobbins 21, 22 such that the creel bobbins 21, 22 overlap each other by at least one-third of said diameter.

As shown in figure 2, the shafts 31, 32 that support the creel bobbins 21, 22 on one side of the creel plane P extend through said creel plane P to the opposite side of the creel plane P. The creel bobbin assembly 3 further comprises a first creel bobbin brake 41 and a second creel bobbin brake 42 which are arranged at said opposite side of the creel plane P for braking the shafts 31, 32 of the creel bobbin 21, 22. The creel bobbin brakes 41, 42 are arranged for applying a braking torque to the shafts 31, 32 of the respective creel bobbins 21, 22 to control the tension in each individual wire 9 as they are being unwound from the respective creel bobbin 21, 22.

The creel bobbin assembly 3 as a whole, together with the creel bobbin brakes 41, 42 that are associated with the shafts 31, 32 of said base member 30, form a replaceable unit that can be easily replaced as a whole by simply dismounting the base member 30 from the creel wall 10.

Figures 3-6 show an exemplary one of the creel bobbin brakes 41, 42 in more detail. Each creel bobbin brake 41, 42 comprises a strap 5 that is arranged to be wound around the shaft 31, 32 of the respective creel

bobbin 21, 22. The strap 5 comprises a first end 51, a second end 52 opposite to the first end 51 and a strap body 50 extending in a longitudinal direction B between the first end 51 and the second end 52. Preferably, the strap body 50 is integrally formed and/or made from a single piece of material. The material of the strap body 50 preferably comprises reinforced synthetic resin or rubber based material. Alternatively, the strap body 50 may comprise leather. The shaft 31, 32 is provided with a brake surface 33 that extends circumferentially about the respective rotation axis R1, R2. In this exemplary embodiment, said brake surface 33 is formed by a brake drum 34 that is arranged on and rotationally fixed to the shaft 31, 32. Alternatively, the shaft 31, 32 itself may form the brake surface 33. As shown in figure 13, the brake surface 33 has a diameter D and a circumference equal to the diameter D multiplied by pi. The strap body 50 is arranged to wound around said brake surface 33.

As shown in figure 3, the strap 5 is provided with a first outer edge 54 and a second outer edge 55 tapering towards each other from the first end 51 towards the second end 52 on opposite sides of the strap body 50. The strap 5 further comprises an opening 53 in the strap body 50. Said opening 53 is defined by a first inner edge 56 and a second inner edge 57 tapering towards each other from the first end 51 towards the second end 52 on opposite sides of the opening 53. Both the strap body 50 and the opening 53 taper in a tapering direction T parallel to the longitudinal direction B from the first end 51 towards the second end 52. The strap body 50 tapers from a largest width W1 at the first end 51 to a smallest width W2 at the second end 52. The opening 53 also tapers from a largest width W3 to a smallest width W4. Preferably, both the strap body 50 and the opening 53 taper linearly at the same taper angle A. Hence, the first outer edge 54 and the first inner edge 56 remain parallel or substantially parallel and the second outer edge 55 and the second inner edge 57 remain

parallel or substantially parallel. In this exemplary embodiment, the smallest width W_2 of the strap body 50 at the second end 52 is equal to or smaller than the smallest width W_4 of the opening 53.

5 As shown in figures 3-6, the strap 5 is arranged to be wound over multiple revolutions, e.g. multiple 360 degree windings, about the shaft 31, 32. In particular, it has been found that winding the strap 5 over at least one and a half revolutions, e.g. at least a 540 degree winding,
10 a winding of at least 720 degrees or at least three 360 degree windings, about the shaft 31, 32 makes the brake torque independent from the friction between the strap 5 and the brake surface 33. With said at least one and a half revolutions, the brake torque can be made solely dependent
15 on tension in the strap 5 and the diameter of the brake surface 33. The strap 5 according to the present invention is arranged to be wound over at least one and a half revolutions while the second end 52 is inserted and/or pulled through the same opening 53 with each revolution. By
20 inserting the second 52 through the same opening 53 with each revolution, the subsequent windings can take place symmetrically, e.g. in the same plane parallel to the longitudinal direction B of the strap 5. This reduces the tendency of strap 5 to run off to one side of the brake
25 surface 33.

 As shown in figure 3, the strap body 50 is symmetrical or substantially in a lateral direction C perpendicular to the longitudinal direction B of the strap body 50. Again, due to said symmetry, the strap body 50 is
30 less likely to run off to a side of the brake surface 33 in said lateral direction C.

 Moreover, as shown in figure 3-6, the first outer edge 54, the second outer edge 55, the first inner edge 56 and the second inner edge 57 taper inwards in the lateral
35 direction C over each revolution with a pitch distance E. The distance between the first outer edge 54 and the first inner edge 56 and the distance between the second outer

edge 55 and the second inner edge 57 in said lateral direction C, i.e. the width of the strap body 50 between said first outer edge 54 and said first inner edge 56 and the width of the strap body 50 between the second outer edge 55 and the second inner edge 57 in said lateral direction C, is chosen to be equal to or smaller than said pitch distance E. Consequently, with each subsequent revolution after the first revolution, the first outer edge 54 and the second outer edge 55 are arranged to extend alongside the first inner edge 56 and the second inner edge 57, respectively. Preferably, the smallest width W2 of the strap body 50 at the second end 52 is equal to or smaller than twice the pitch distance E.

In the step of figure 5 the strap 5 has been wound about the shaft 31, 32 about two revolutions. Depending however on the friction characteristics of the material that has been chosen for the strap 5 it may be advantageous to wind the strap 5 around the shaft 31, 32 over an additional revolution to make the brake torque solely dependent on the tension in the strap 5, e.g. in the case of reinforced synthetic resin or rubber based material. Hence, figure 6 shows the optional step of winding the strap 5 over an additional revolution to arrive at a total of at least three windings about the shaft 31, 32.

As shown in figure 3, the opening 53 has a length L in the longitudinal direction B that is equal to or larger than two times the circumference of the brake surface 33, i.e. two times the diameter D of the brake surface 33 multiplied by pi. This allows for the second end 52 to be wound around the brake surface 33 and to be inserted through the same opening 53 over at least one and a half revolutions, preferably at least two revolutions and optionally at least three revolutions.

As shown in figure 2, each creel bobbin brake 41, 42 further comprises a first mounting member 43, 44 and a second mounting member 45 for mounting the first end 51 and

the second end 52, respectively, to the base member 30 and/or the creel wall 10. In this exemplary embodiment, the first mounting member 43, 44 extends on an opposite side of the respective rotation axis R1, R2 with respect to the
5 second mounting member 45 for mounting the first end 51 and the second end 52 to the base member 30 and/or the creel wall 10 on opposite sides of said respective rotation axis R1, R2. In the steps as shown in figures 3-6, the first end 51 is mounted to the first mounting member 43, 44 first.
10 Subsequently, the second end 52 is inserted and pulled through the opening 53 in the strap body 50 three times. Said second end 52 is then mounted to the second mounting member 45. In this exemplary embodiment, the second ends 52 of the straps 5 of both creel bobbin brakes 41, 42 are
15 directly mounted to the same second mounting member 45. The second mounting member 45 is in turn connected to the base member 30 and/or the creel wall 10 via a tensioner 6 that is arranged to pull on said second mounting member 45 with respect to the base member 30 and/or the creel wall 10.
20 Hence, with the use of a single tensioner 6, both straps 5 can be tensioned simultaneously.

Alternatively, the second mounting member 45 may be stationary with respect to the base member 30 and/or the creel wall 10 and individual tensioners 106 (as shown in
25 figure 5) may be provided between the second end 52 of each strap 5 and the second mounting member 45.

Figures 7, 8 and 9 show an alternative strap 205 according to a second embodiment of the invention for use in the previously discussed creel bobbin brake 41. The
30 alternative strap 205 again has a first end 251, a second end 252 and a strap body 250 extending between the first end 251 and the second end 252 in the longitudinal direction B. Moreover, the strap 205 has an opening 253, a first outer edge 254, a second outer edge 255, a first
35 inner edge 256 and a second inner edge 257 similar to the strap 5 of figures 3-6. The alternative strap 205 differs from the aforementioned strap 5 in that its opening 253

extends up to and opens at the first end 251 in the longitudinal direction B. In other words, the opening 253 extends up to the edge and/or debouches at the first end 251. The opening 253 thus divides the strap body 250 into a first leg 258 and a second leg 259 that terminate at the first end 251. Said legs 258, 259 can be spread apart at the first end 251, as shown in figure 8, to provide a different and/or an adjustable taper angle A. The opening 253 tapers to a smallest width that is chosen in a range zero to the smallest width of the strap body 250. The legs 258, 259 are arranged to be mounted to the first mounting member 43, 44 with the legs 258, 259 spread apart at a certain taper angle A that allows for at least one and a half revolutions of the alternative strap 205 about the shaft 31, 32. The second end 251 of the alternative strap 205 is arranged to be inserted through the opening 253 several times and to be mounted to the second mounting member 245, e.g. with the use of the tensioner 106, in the same manner as the aforementioned strap 5.

The tensioners 6, 106 are arranged for providing a tension in accordance with the type of wire 9 that is used. For fabric wires 9, which are relatively light, the tension is within a range of 1 to 10 Newton, preferably 1.3 to 5 Newton and most preferably approximately 1.5 Newton. For steel wires 9, which are relatively heavy, the tension is within a range of 5 to 15 Newton, preferably 8 to 12 Newton and most preferably approximately 10 Newton. The tensioners 6, 106 preferably comprise low friction pneumatic cylinders which can accurately and/or steplessly set the tension by increasing and/or decreasing the pneumatic pressure. The low friction prevents that a build-up of pneumatic pressure in the pneumatic cylinder that in the prior art cylinders causes sudden or abrupt jolts while setting the tension.

A creel method for mounting the strap 5 in the previously discussed creel bobbin brake 41, 42 will be briefly elucidated below with reference to figures 3-6.

Figure 3 shows the situation in which the strap 5 is initially mounted only with its first end 51 to the first mounting member 43, 44. The second end 52 is unmounted and/or freely movable. There is no tension in the 5 strap body 50.

Figure 4 shows the second end 52 being wound around the brake surface 33 of the brake drum 34 over a single revolution, i.e. 360 degrees. The second end 52 is inserted and/or pulled through the opening 53 in the strap 10 body 50. Note that the outer edges 54, 56 now extend alongside and on the inside of the inner edges 55, 57 of the first winding.

Figure 5 shows the second winding of the strap 5 around the brake surface 33 of the brake drum 34. The strap 15 5 has now been wound over a total of 720 degrees about the brake surface 33. The second end 52 is again inserted and/or pulled through the opening 53 in the strap body 53. And again, the outer edges 54, 56 of the second winding extend alongside and on the inside of the inner edges 55, 20 57 of the first winding.

Figure 6 shows the third and optional winding of the strap 5 around the brake surface 33 of the brake drum 34. The strap 5 has now been wound over a total of 1080 degrees about the brake surface 33. The second end 52 is 25 again inserted and/or pulled through the opening 53 of the strap body 50. And again the outer edges 54, 56 of the third winding extend alongside and on the inside of the inner edges 55, 57 of the second winding. The second end 52 now extends from the brake surface 33 towards the second 30 mounting member 45. In this exemplary embodiment, the second end 52 is mounted to the second mounting member 45 with a tensioner 106. As mentioned before, the second end 52 may also be mounted directly to the second mounting member 45, as shown in figure 2, provided that the second 35 mounting member 45 itself is connected via a tensioner 6 to the base member 30.

Figure 14 shows an alternative creel 101

according to a third embodiment of the invention. The alternative creel 101 comprises a creel bobbin assembly 103 that has a first shaft 131 and a second shaft 132 which are placed coaxially. In particular, the first shaft 131 is
5 hollow and the second shaft 132 is placed concentrically within the first shaft 131. The first shaft 131 and the second shaft 132 are independently rotatable. Hence, the first rotation axis R1 and the second rotation axis R2 coincide and/or are collinear. The first creel bobbin 21 is
10 arranged to be supported on the first shaft 131 nearest to the creel plane P. The second shaft 132 protrudes from the first shaft 131 in an axial direction parallel to the first rotation axis R1 away from the creel plane P to support the second creel bobbin 22 coaxially at a side of the first
15 creel bobbin 21 facing away from the creel plane P. Hence, the first creel bobbin 21 and the second creel bobbin 22 can be supported coaxially side-by-side in the axial direction parallel to the first rotation axis R1 and/or the second rotation axis R2. Again, the creel bobbins 21, 22
20 are both supported at the same side of the creel plane P.

As shown in figure 14, the first shaft 131 and the second shaft 132 extend through the creel plane P to the opposite side of said creel plane P. At said opposite sides, the alternative creel 101 is again provided with
25 creel bobbin brakes 141, 142 that essentially operate in the same way as the previously discussed creel bobbin brakes 41, 42. However, like the creel bobbins 21, 22 and their shafts 131, 132, the creel bobbin brakes 141, 142 are also arranged coaxially. In particular, the first shaft 131
30 is hollow and accommodates the concentrically placed second shaft 132 which protrudes from said first shaft 131 at the opposite side of the creel plane P. The creel bobbin brakes 141, 142 are arranged side-by-side in an axial direction parallel to the first rotation axis R1 and/or the second
35 rotation axis R2 so that their respective straps 5 may be wound around the shafts 131, 132 over at least three revolutions in the same way as previously described.

The side-by-side coaxial arrangement also allows the creel bobbin brakes 141, 142 to be mounted between a common first mounting member 143 and a common second mounting member 145, thus simplifying the construction of
5 the creel bobbin assembly 103.

As shown in figure 1, the creel 1 further comprises a plurality of guiding tubes 8 for guiding and/or leading the wires 9 towards a wire collector or an extruder (not shown) at the front of the creel 1. Each guiding tube
10 8 is arranged for receiving a wire 9 from an individual creel bobbin 21, 22. As shown in detail in figure 10, each guiding tube 8 comprises a main channel 81 and an air channel 82 that merges oblique with the main channel 81 in a direction of guidance G. The air channels 82 are
15 connected in fluid communication to a source of pressurized air. The pressurized air enters the air channels 82 and is arranged for blowing the wires 9 through the respective main channels 81 towards the wire collector or the extruder in the direction of guidance G. Preferably, the source of
20 pressurized air can be individually switched on and off for each guiding tube 8 by a plurality of valves (not shown). Said valves are preferably manually operated. The pressurized air can be switched on when a new creel bobbin 21, 22 is mounted to the creel 1 and the wire 9 thereof is
25 not yet engaged by the wire collector or the extruder.

As shown in more detail in figure 11, the main channel 81 of the guiding tube 8 is preferably provided with one or more air leak stops 83 arranged in the area upstream of the position where the air channel 82 merges
30 with the main channel 81. Each air leak stop 83 comprises a disruption surface 84 for that faces in the direction of guidance G to disrupt air flow leaking upstream in the direction of guidance G. This can improve the suction of the wire 9 into the main channel 81. Hence, the wire 9 can
35 be sucked into the main channel 81 more easily. More in particular, the wire 9 does not have to be stuck as far into the main channel 81 before being sucked in when

comparing it with the prior art guiding tubes.

Figure 12 shows an alternative guiding tube 108 that is provided with a main channel 181 and an air channel 182 that merges oblique with the main channel 181 in the direction of guidance G. The alternative guiding tube 108 further comprises a wire inlet 183 that has a significantly smaller diameter than the main channel 181. The smaller diameter can prevent that air from the air channel 182 leaks back into the wire inlet 183. At a position spaced apart from the wire inlet 183 in the direction of guidance G, the main channel 181 is provided with one or more air pressure outlets 184 to reduce the pressure build-up in the main channel 183. Preferably, the air pressure outlets 184 are angled back with respect to the direction of guidance G to prevent that the wire 9 accidentally exits the main channel 181 through one of the one or more air pressure outlets 184. The reduced air pressure downstream of the one or more air pressure outlets 184 can prevent that the pressure build-up counteracts the feeding of the wire 9 in the direction of guidance G.

As further shown in figure 1, the creel 1 preferably has to meet certain ergonomic requirements. In particular, it is important that the lowest creel bobbins 21, 22 in the creel 1 are at a certain minimum height H1 to prevent that an operator has to reach too low to replace said lowest creel bobbins 21, 22. Similarly, the highest creel bobbins 21, 22 in the creel 1 should not be placed higher than a maximum height H2 to prevent that the operator has to reach too high to replace said highest creel bobbins 21, 22. However, at the same time, the creel bobbins 21, 22 should be spaced apart from their respective guiding tubes 8 sufficiently. In particular, with reference to figure 15, it is noted that the wire 9 makes a so-called fleet angle F between the wire 9 unwinding from the extreme left and the extreme right of the creel bobbin 21, 22 and an imaginary center line M normal to the axial direction of the creel bobbin 21, 22. Said fleet angle F should be less

than 10 degrees, preferably less than five degrees and most preferably less than three degrees. Hence, for a given bobbin width Y , the minimum distance Z between the circumference of the creel bobbin 21, 22 and the respective
5 guiding tube 8 can be calculated.

Based on the minimum height $H1$ of the lowest creel bobbins 21, 22, the maximum height $H2$ of the highest creel bobbins 21, 22 and the minimum distance Z between the creel bobbins 21, 22 and their respective guiding tubes 8,
10 the configuration of the creel 1 according to figure 1 was conceived. In this configuration, the lower half of the creel bobbins 21, 22 are arranged to feed their wires 9 to the guiding tubes 8 at the upper end of the creel 1, while the higher or upper half of the creel bobbins 21, 22 are
15 arranged to feed their wires 9 to the guiding tubes 8 at the lower end of the creel 1. Hence, the creel height can be reduced significantly while meeting both the requirements for the minimum height $H1$, the maximum height $H2$ as well as the minimum distance Z .

As the previously discussed embodiments of the invention allow for an increased number of creel bobbins 21, 22 within the creel 1, 101, the number of wires 9 also increases significantly. Figure 16 shows a wire collector 7 for use with the creel 1 according to figure 1. Said wire
25 collector 7 is used for collecting the wires 9 originating from the individual creel bobbins 21, 22 and directing the collected wires 9 towards a downstream station 300, e.g. an extruder head where the wires 9 are embedded in elastomeric material, in an output direction K . In this exemplary
30 embodiment, the output direction K is parallel or substantially parallel to the creel plane P . In figures 17A and 17B, the downstream station 300 is arranged in or in-line with the creel plane P . In figures 18A and 18B, the downstream station 300 is out-of-line with and in the
35 center between both creel planes P .

In figure 16, only the first creel bobbins 21 are shown for simplicity. The wire collector 7 may however also

be used for collecting the wires 9 from the second creel bobbins 22, as schematically shown in figures 17A and 17B. As shown in figures 17A, 17B, the creel 1 has a plurality of creel bobbins 21, 22 on either side of the creel plane P. In figures 17A and 17B, the wire collector 7 is used in combination with a single creel 1. In figures 18A and 18B, the wire collector 7 is used in combination with a double-creel configuration, i.e. in combination with a first creel 11 and a second creel 12, each being similar or identical to the creel 1 of figure 1.

The wire collector 7 comprises a first collection section 71 for collecting the wires 9 from a first group of creel bobbins 21, 22 and a second collection section 72 for collecting the wires 9 from a second group of creel bobbins 21, 22. In figures 17A and 17B, the first group comprises the creel bobbins 21, 22 at one side of the creel plane P and the second group comprises the creel bobbins 21, 22 at the opposite side of the creel plane P. In figures 18A and 18B, the first group comprises the creel bobbins 21, 22 from the first creel 11 and the second group comprises the creel bobbins 21, 22 from the second creel 12.

In both embodiments, the first collection section 71 and the second collection section 72 are individually movable in a switching direction S transverse or perpendicular to the creel plane P. In particular, the first collection section 71 and the second collection section 72 are arranged to be alternately moved into a position into alignment with the downstream station 300 in the output direction K. Hence, when the first collection section 71 is actively outputting its collected wires 9 to the downstream station 300, as shown in figures 17A and 18A, the wires 9 in the second collection section 72 can be organized and/or prepared so that when the creel bobbins 21, 22 of the group associated with the active first collection section 71 are empty, the wire collector 7 can easily switch from the creel bobbins 21, 22 of the empty group to the creel bobbins 21, 22 of the group associated

with the second collection section 72, as shown in figures 17B and 18B. In this exemplary embodiment, the collection sections 71, 72 are arranged on one or more rails 73 extending in the switching direction S. Alternatively, the
5 collection sections 71, 72 may be arranged on carriages that run over the factory floor.

As best seen in figure 16, each collection section 71, 72 comprises a set of upper rollers 74 located at or near the respective creel 1 for receiving the wires 9
10 from the guide tubes 8 at the top of the creel 1 and a set of lower rollers 75 for receiving the wires 9 from the guide tubes 8 at the bottom of the creel 1. The wire collector 7 further comprises a first set of collector rollers 76 and a second set of collector rollers 77 for
15 receiving the wires 9 from the upper rollers 74 and the lower rollers 75, respectively. The orientation of said collector rollers 76, 77 can be tilted about a vertical axis, as schematically shown in figures 17A, 17B, 18A and 18B, to follow or adjust for the movement of the collection
20 sections 71, 72 in the switching direction S relative to the rollers 74, 75 at the creel 1, 11, 12. Each collection section 71, 72 further comprises a set of output wheels 78, 79 for bringing the wires 9 from the respective collector rollers 76, 77 together and for outputting said wires 9 in
25 the output direction K towards the downstream station 300.

It is to be understood that the above description is included to illustrate the operation of the preferred embodiments and is not meant to limit the scope of the invention. From the above discussion, many variations will
30 be apparent to one skilled in the art that would yet be encompassed by the scope of the present invention.

C L A I M S

1. First creel bobbin brake for applying a braking torque to a first shaft of a first creel bobbin, wherein the first creel bobbin brake comprises a strap that is provided with a first end, a second end and a strap body
5 extending in a longitudinal direction between the first end and the second end, wherein the strap further comprises an opening in the strap body, wherein the strap body and the opening are arranged to taper from the first end towards the second end, wherein the strap is arranged to be wound
10 around the first shaft of the first creel bobbin over at least one and a half revolutions, wherein the second end is insertable through the opening with each revolution, wherein the strap comprises a first outer edge and a second outer edge tapering towards each other from the first end
15 towards the second end on opposite sides of the strap body, wherein the strap further comprises a first inner edge and a second inner edge tapering towards each other from the first end towards the second end on opposite sides of the opening, wherein the first outer edge and the second outer
20 edge are arranged to extend on the alongside of the first inner edge and the second inner edge, respectively, with each revolution after the first revolution.

2. First creel bobbin brake according to claim 1, wherein the strap is arranged to be wound around the
25 first shaft of the first creel bobbin over at least two revolutions, wherein the second end is insertable through the opening with each revolution.

3. First creel bobbin brake according to claim 1 or 2, wherein the strap is arranged to be wound around the
30 first shaft of the first creel bobbin over at least three revolutions, wherein the second end is insertable through the opening with each revolution.

4. First creel bobbin brake according to claim

1, 2 or 3, wherein the opening has a smallest width in a lateral direction perpendicular to the longitudinal direction of the strap body, wherein the strap body at the second end has a smallest width in the lateral direction that is equal to or smaller than the smallest width of the opening.

5 5. First creel bobbin brake according to claim 1, 2 or 3, wherein the opening extends up to and is open at the first end of the strap body in the longitudinal direction.

6. First creel bobbin brake according to any one of the preceding claims, wherein the strap body and the opening taper linearly from the first end towards the second end.

15 7. First creel bobbin brake according to any one of the preceding claims, wherein the strap body and the opening taper from the first end towards the second end at a taper angle which is the same for both the strap body and the opening.

20 8. First creel bobbin brake according to any one of the preceding claims, wherein the strap body is symmetrical or substantially symmetrical in a lateral direction perpendicular to the longitudinal direction of the strap body.

25 9. First creel bobbin brake according to any one of the preceding claims, wherein the first inner edge and the second inner edge are parallel or substantially parallel to the first outer edge and the second outer edge, respectively.

30 10. First creel bobbin brake according to any one of the preceding claims, wherein the first outer edge, the second outer edge, the first inner edge and the second inner edge taper inwards in a lateral direction perpendicular to the longitudinal direction over each revolution with a pitch distance, wherein the distance between the first outer edge and the first inner edge and the distance between the second outer edge and the second

35

inner edge in said lateral direction is equal to or smaller than the pitch distance.

11. First creel bobbin brake according to any one of the preceding claims, wherein the strap body is made
5 from a single piece of material.

12. First creel bobbin brake according to any one of the preceding claims, wherein the strap body comprises reinforced synthetic resin or rubber based material.

13. First creel bobbin brake according to any one
10 of claims 1-11, wherein the strap body comprises leather.

14. Creel bobbin assembly comprising the first creel bobbin brake according to any one of the preceding claims, wherein the creel bobbin assembly further comprises a first shaft for supporting a first creel bobbin and a
15 base member for supporting said first shaft with respect to a creel plane, wherein the first shaft is provided with a brake surface, wherein the strap of the first creel bobbin brake is arranged to be wound around said brake surface over the at least two revolutions.

20 15. Creel bobbin assembly according to claim 14, wherein the brake surface has a circumference, wherein the opening in the strap body has a length in the longitudinal direction of the strap body that is equal to or larger than two times the circumference of the brake surface.

25 16. Creel bobbin assembly according to claim 14 or 15, wherein the brake surface is formed by a brake drum that is rotationally fixed to the at least one shaft.

17. Creel bobbin assembly comprising a first shaft for supporting a first creel bobbin and a base member
30 for supporting said first shaft with respect to a creel plane, wherein the first shaft, wherein the creel bobbin assembly comprises a second shaft for supporting a second creel bobbin, wherein the base member is arranged for supporting said second shaft with respect to the creel
35 plane, wherein the first shaft and the second shaft are arranged for supporting the first creel bobbin and the second creel bobbin, respectively, on the same side of the

creel plane.

18. Creel bobbin assembly according to claim 17,
wherein the first shaft and the second shaft are mutually
parallel yet spaced apart in a direction parallel to the
5 creel plane.

19. Creel bobbin assembly according to claim 18,
wherein the second shaft is longer than the first shaft to
support the second creel bobbin at a spacing distance from
the creel plane to allow for intermediate placement of the
10 first creel bobbin between the creel plane and the second
creel bobbin.

20. Creel bobbin assembly according to claim 19,
wherein the first shaft and the second shaft are spaced
apart in the direction parallel to the creel plane over a
15 distance such that the first creel bobbin and the second
creel bobbin at least partially overlap each other in the
direction parallel to the creel plane.

21. Creel bobbin assembly according to claim 17,
wherein the first shaft and the second shaft are coaxial.

22. Creel bobbin assembly according to claim 21,
wherein the first shaft is hollow and wherein the second
shaft extends concentrically through the first shaft,
wherein the second shaft protrudes from the first shaft to
support the second creel bobbin in a side-by-side
25 relationship with the first creel bobbin.

23. Creel bobbin assembly according to any one of
claims 17-22, wherein the creel bobbin assembly further
comprises a first creel bobbin brake and a second creel
bobbin brake for applying a braking torque to the first
30 shaft of the first creel bobbin and the second shaft of the
second creel bobbin, respectively.

24. Creel bobbin assembly according to claim 23,
wherein each bobbin brake comprises a strap that is
provided with a first end and a second end, wherein each
35 creel bobbin brake further comprises a first mounting
member for mounting the first end of the strap to the base
member and a second mounting member for mounting the second

end of the strap to the base member.

25. Creel bobbin assembly according to claim 24, wherein the creel bobbin assembly further comprises a tensioner that is arranged between the second mounting
5 member and the base member.

26. Creel bobbin assembly according to claim 24, wherein the creel bobbin assembly further comprises a tensioner that is arranged between the second end and the second mounting member.

10 27. Creel comprising a plurality of creel bobbin assemblies according to any one of claims 14-26.

28. Creel according to claim 27, wherein the creel comprises a creel wall, wherein the base member is mountable and dismountable with respect to said creel wall.

15 29. Creel comprising a plurality of creel bobbins, a plurality of guiding tubes located at the lower end of the creel and a plurality of guiding tubes located at the upper end of the creel, wherein each guiding tube is arranged for receiving a wire from an individual creel
20 bobbin, wherein the lower half of the creel bobbins are arranged to feed their wires to the guiding tubes at the upper end of the creel, while the upper half of the creel bobbins are arranged to feed their wires to the guiding tubes at the lower end of the creel.

25 30. Creel comprising a creel bobbin and a guiding tube for receiving a wire from said creel bobbin, wherein the wire in use extends from the creel bobbin towards the guiding tube at a fleet angle with respect to an imaginary center line normal to the axial direction of the creel
30 bobbin, wherein the wire extends at a maximum fleet angle when the wire is unwinding from the extreme left and the extreme right of the creel bobbin, wherein the creel bobbin has a bobbin width and a minimum distance between the circumference of the creel bobbin and the guiding tube,
35 wherein the bobbin width and the minimum distance are chosen such that the maximum fleet angle is less than ten degrees.

31. Creel according to claim 30, wherein the maximum fleet angle is less than five degrees or less than three degrees.

32. One or more creels and a wire collector for
5 use with said one or more creels, wherein the one or more creels are arranged for supporting a first group of creel bobbins and a second group of creel bobbins relative to a creel plane, wherein the wire collector comprises a first
10 collection section for collecting wires from the creel bobbins of the first group and a second collection section for collecting wires from the creel bobbins of the second group, wherein the collection sections are movable in a
switching direction transverse or perpendicular to the
15 creel plane to alternately align the first collection section and the second collection section with a downstream station.

33. One or more creels and the wire collector according to claim 32, wherein one or more creels comprises a single creel that is arranged for supporting the first
20 group of creel bobbins at one side of the creel plane and the second group of creel bobbins at the opposite side of the creel plane.

34. One or more creels and the wire collector according to claim 32, wherein the one or more creel
25 comprises a first creel that is arranged for supporting the first group of creel bobbins and a second creel that is arranged for supporting the second group of creel bobbins.

35. One or more creels and a wire collector according to any one of claims 32-34, wherein the
30 collection sections are movable in the switching direction to alternately align the first collection section and the second collection section with a downstream station in an output direction parallel or substantially parallel to the creel plane.

36. One or more creels and a wire collector according to any one of claims 32-35, wherein each
35 collection section comprises collector rollers that are

tiltable about a vertical axis to follow or adjust for the movement of the collection sections in the switching direction relative to the one or more creels.

37. Creel method for mounting the strap according
5 to any one of claims 1-13 to a creel bobbin assembly according to any one of claims 14-27, wherein the creel method comprises the steps of winding the strap around the first shaft of the first creel bobbin over at least one and a half revolutions and inserting the second end through the
10 opening with each revolution.

38. Creel method according to claim 37, wherein the creel method comprises the steps of winding the strap around the first shaft of the first creel bobbin over at least two revolutions and inserting the second end through
15 the opening with each revolution.

39. Creel method according to claim 37 or 38, wherein the creel method comprises the steps of winding the strap around the first shaft of the first creel bobbin over at least three revolutions and inserting the second end
20 through the opening with each revolution.

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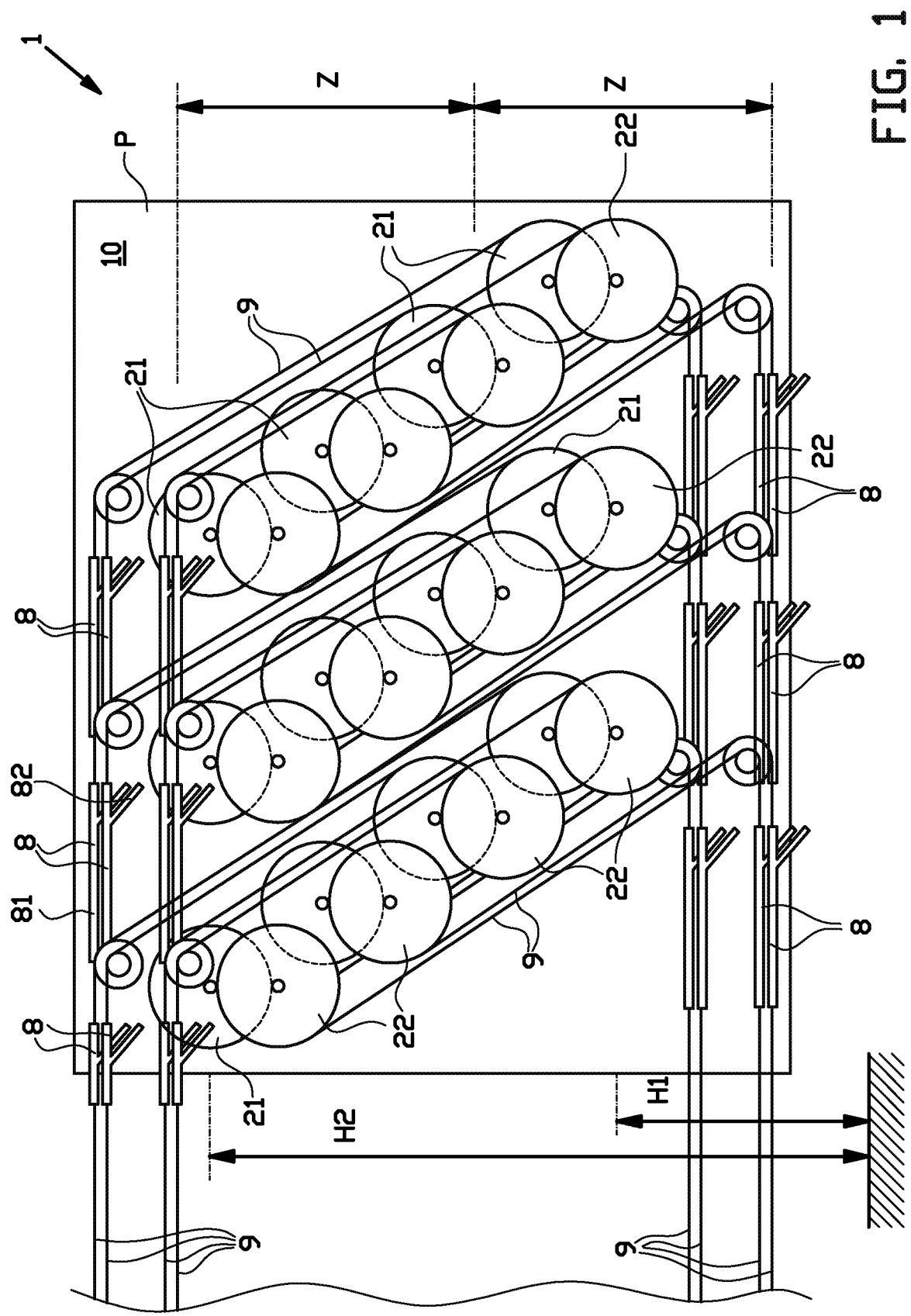
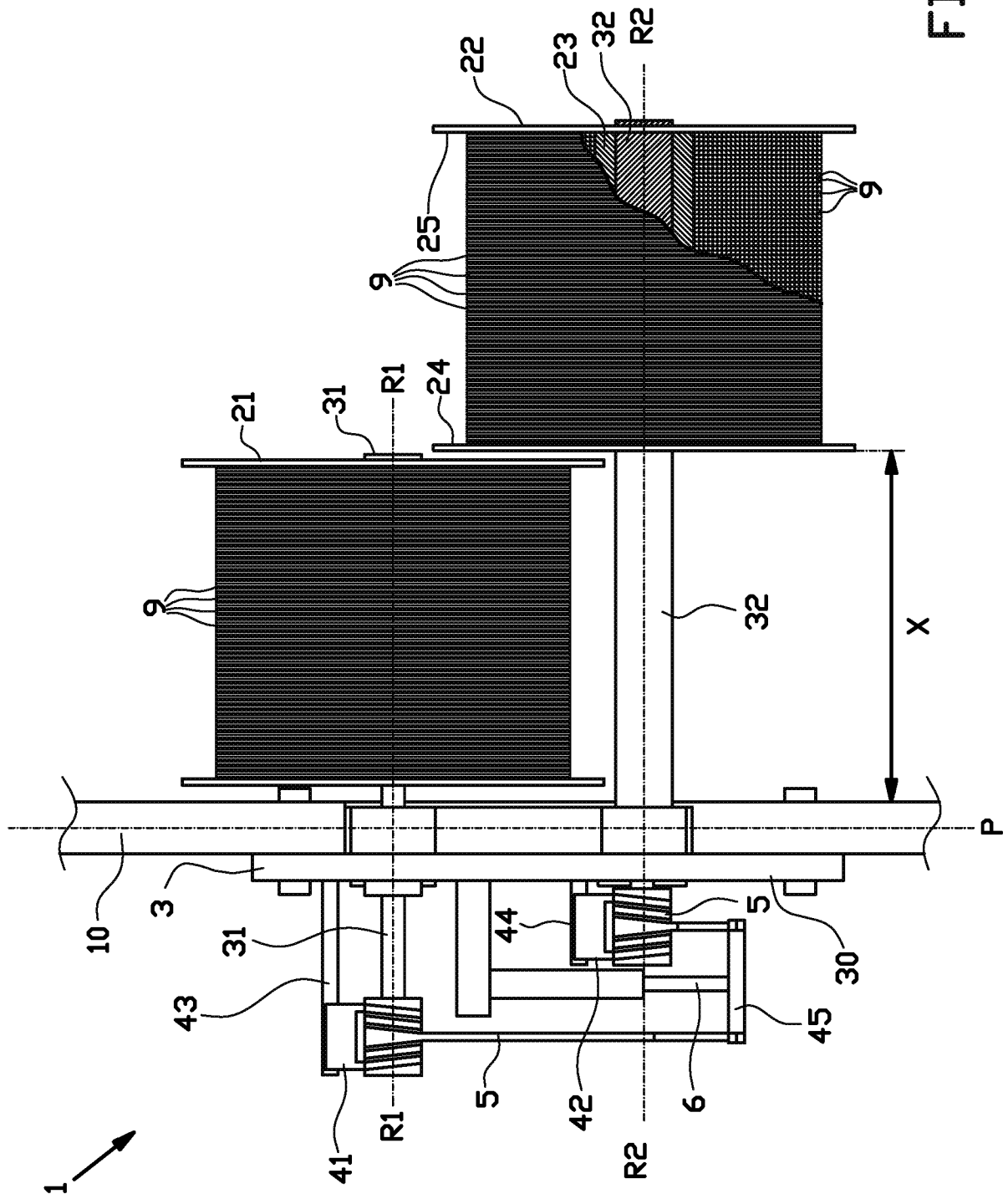
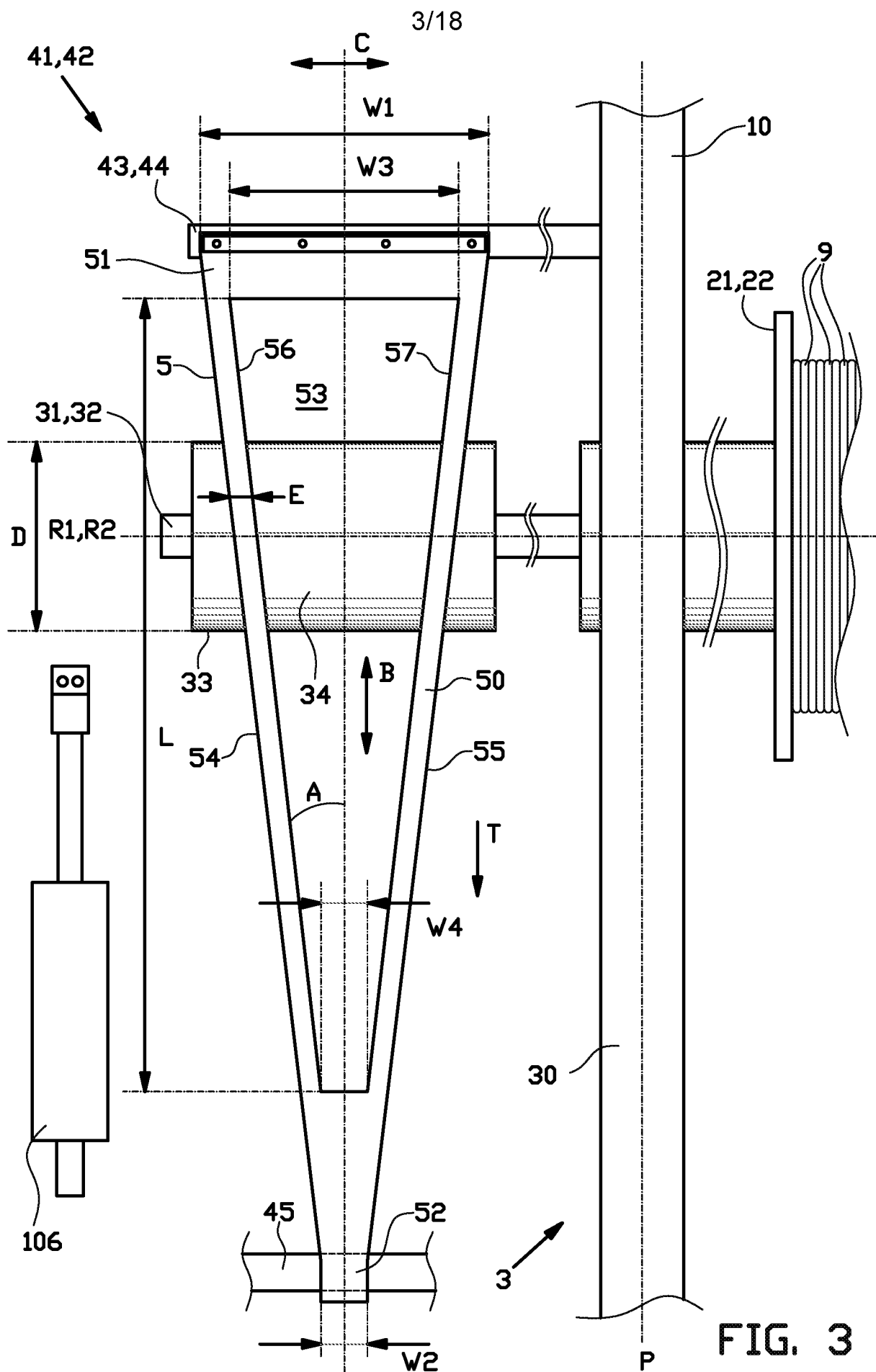
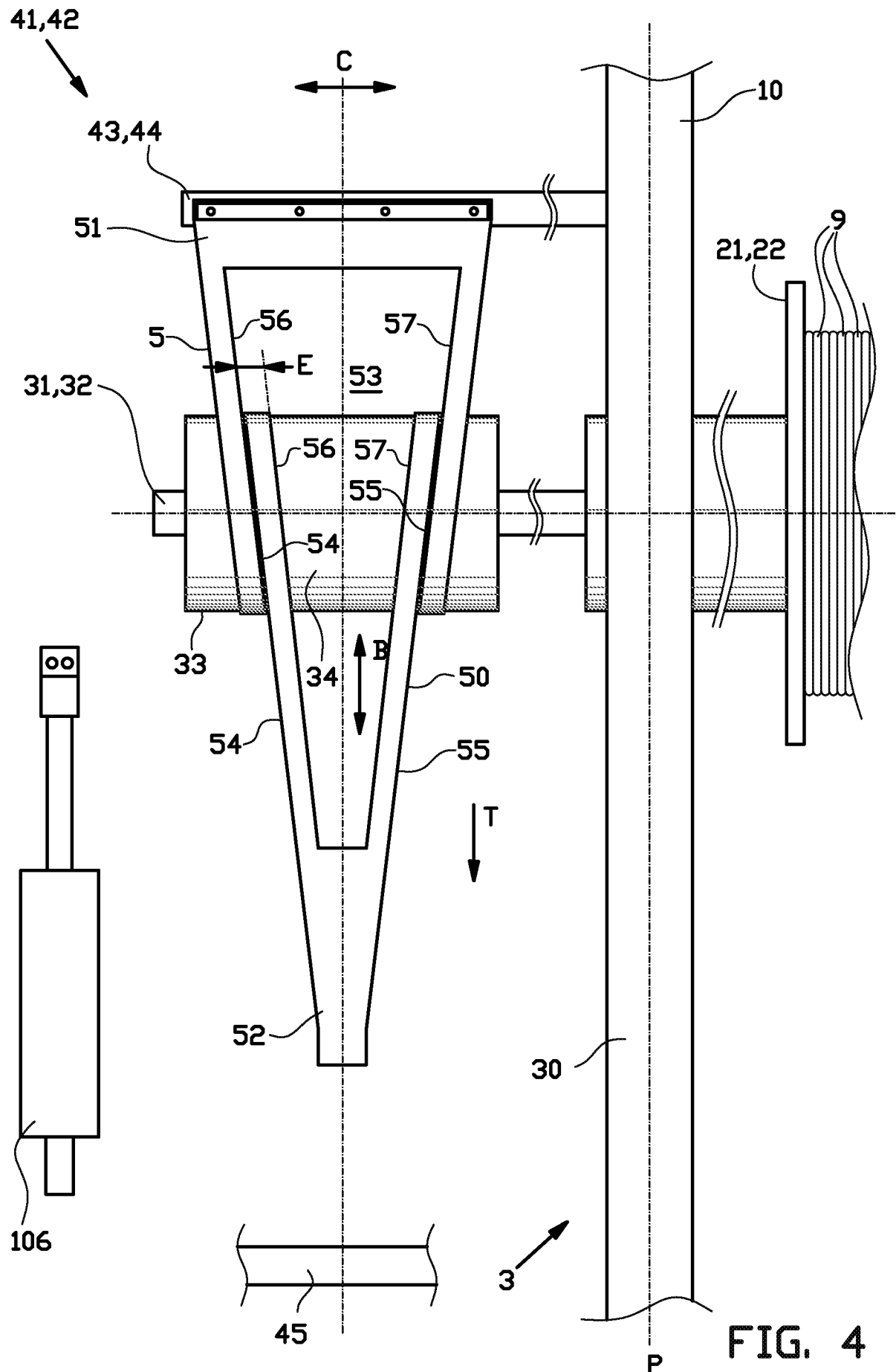


FIG. 1

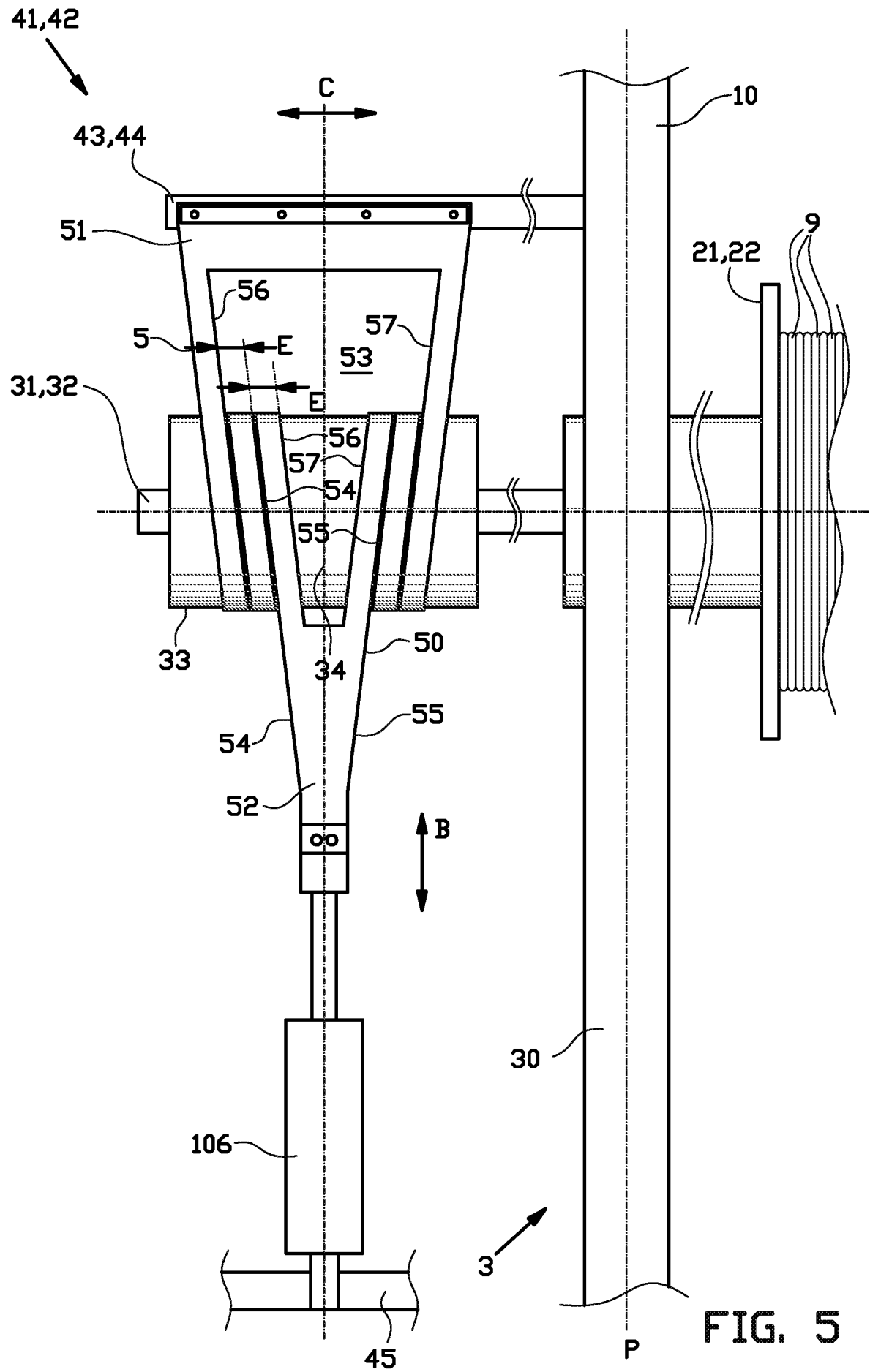


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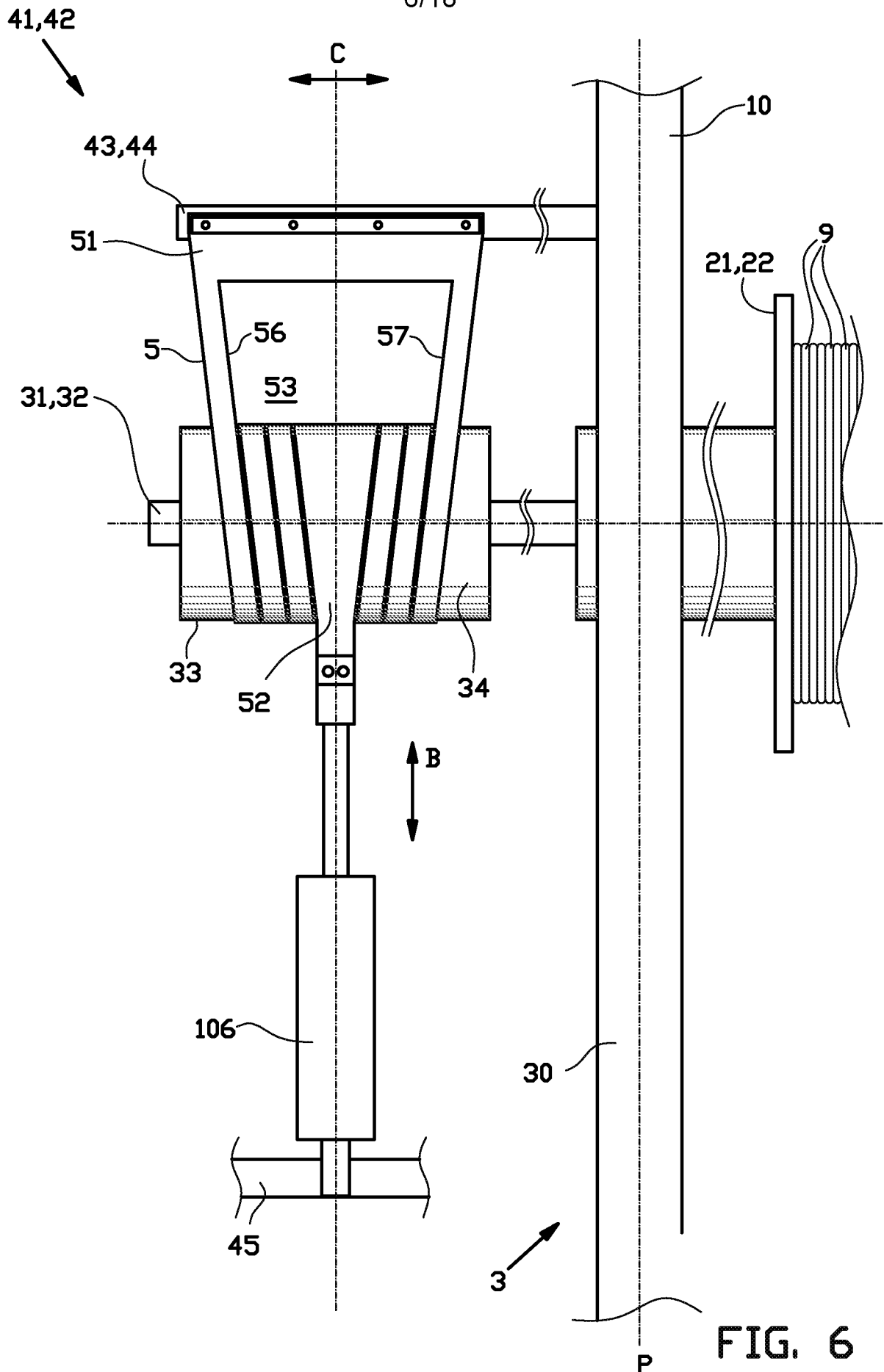


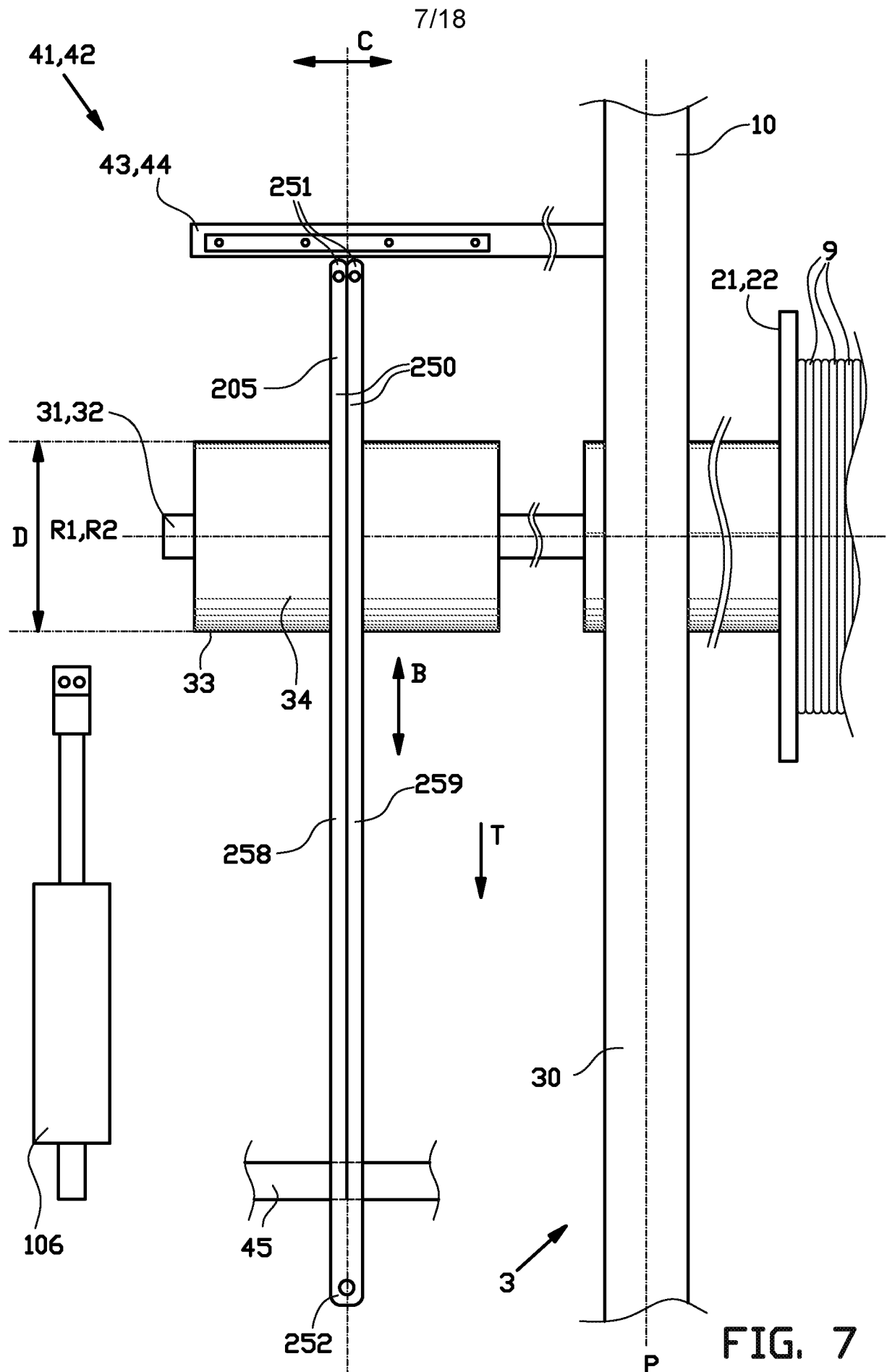


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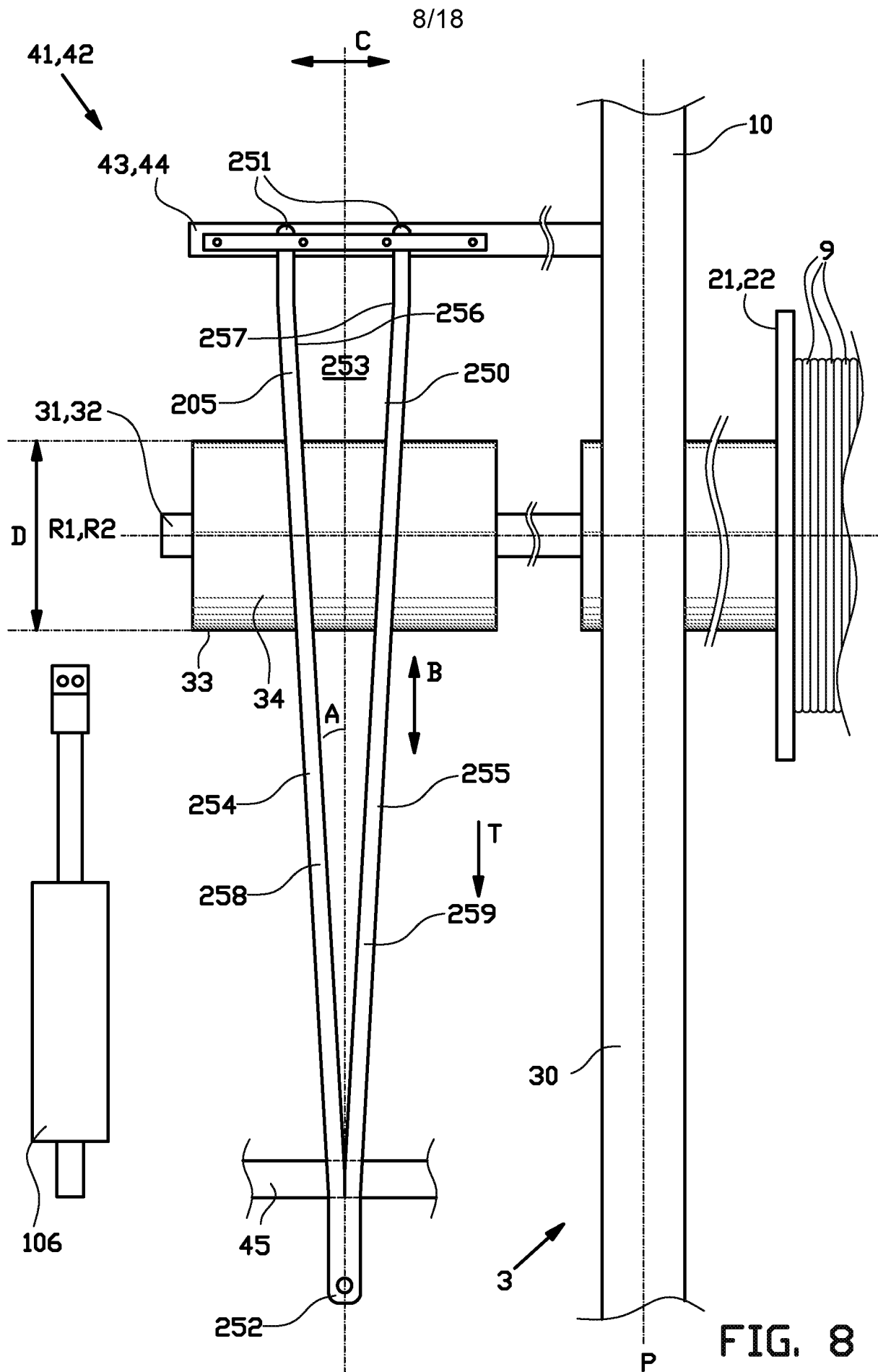
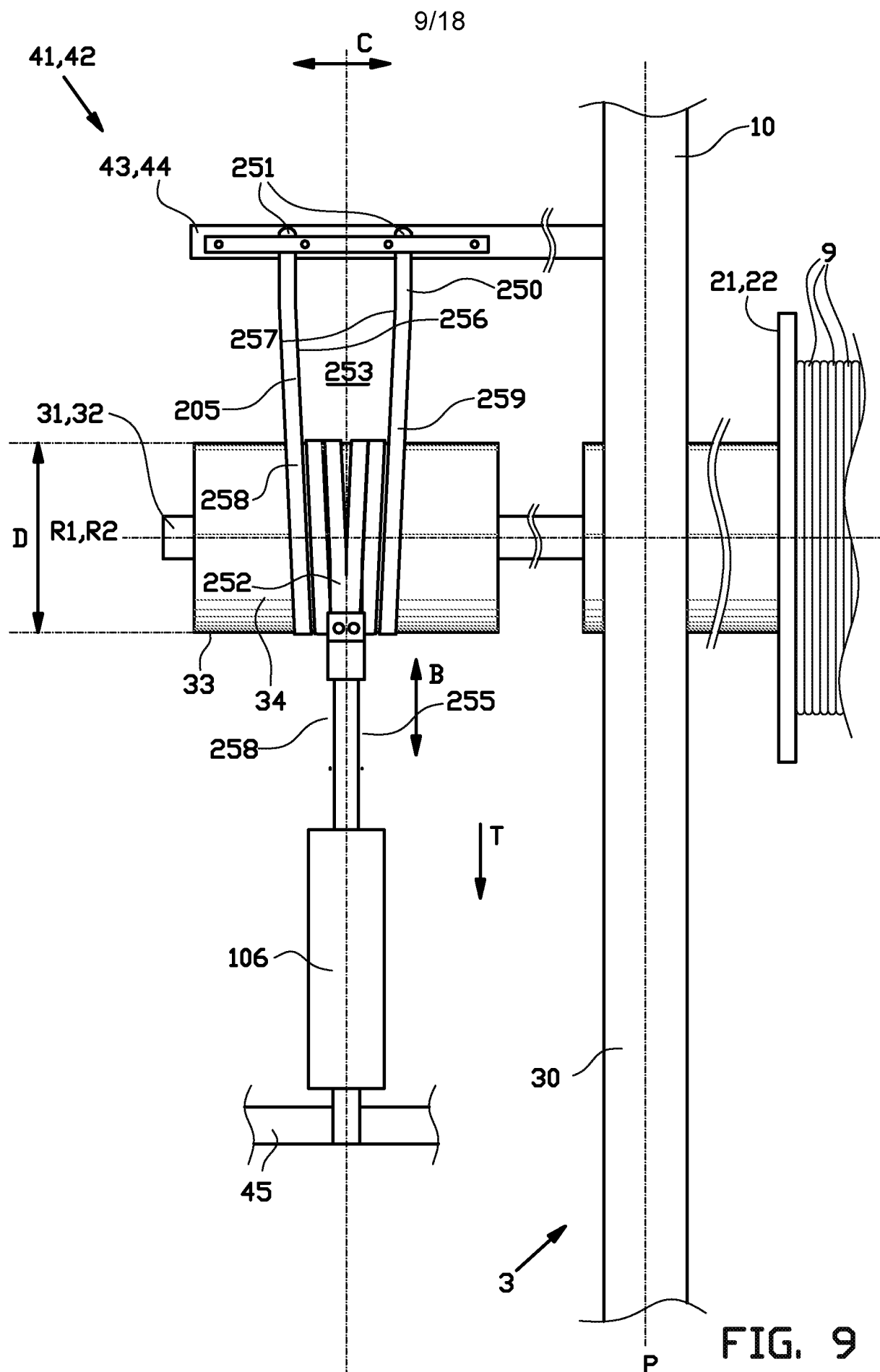


FIG. 8



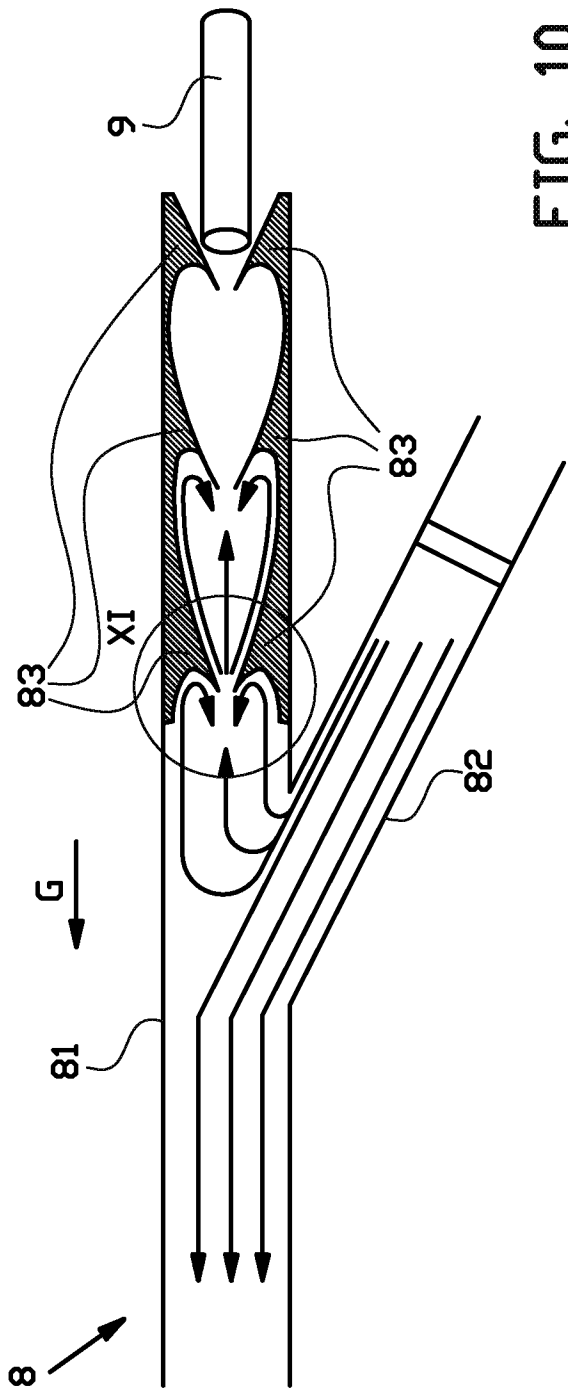


FIG. 10

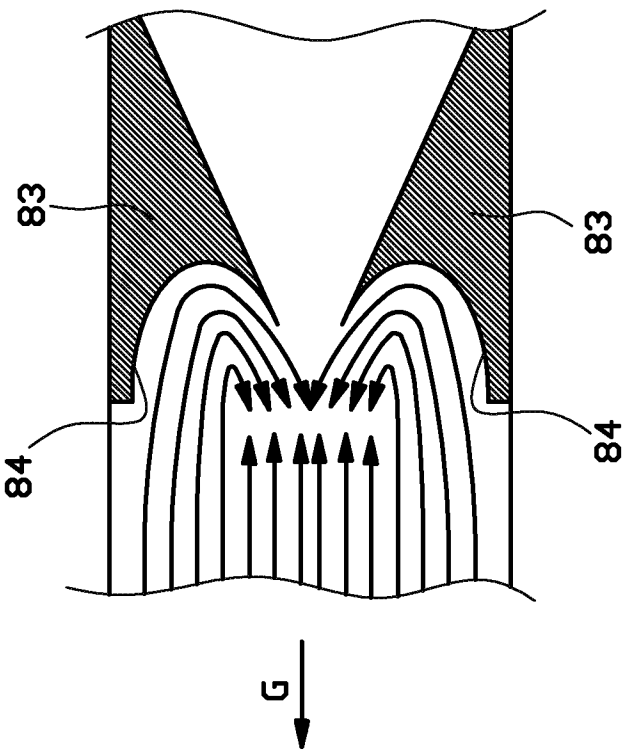


FIG. 11

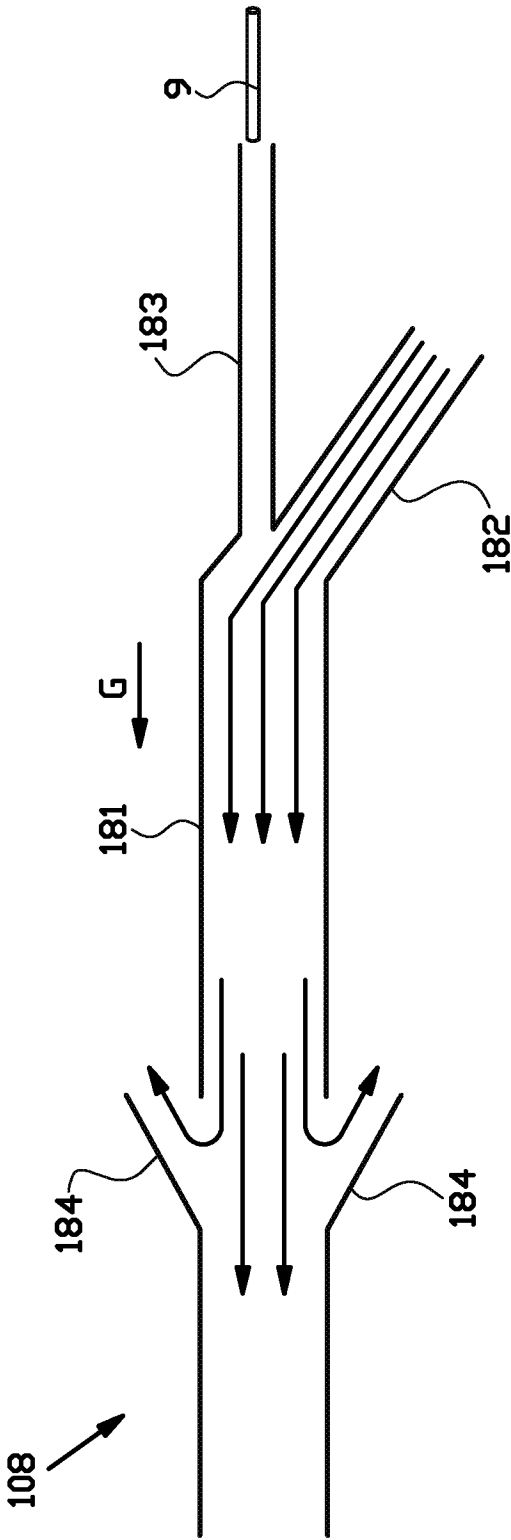


FIG. 12

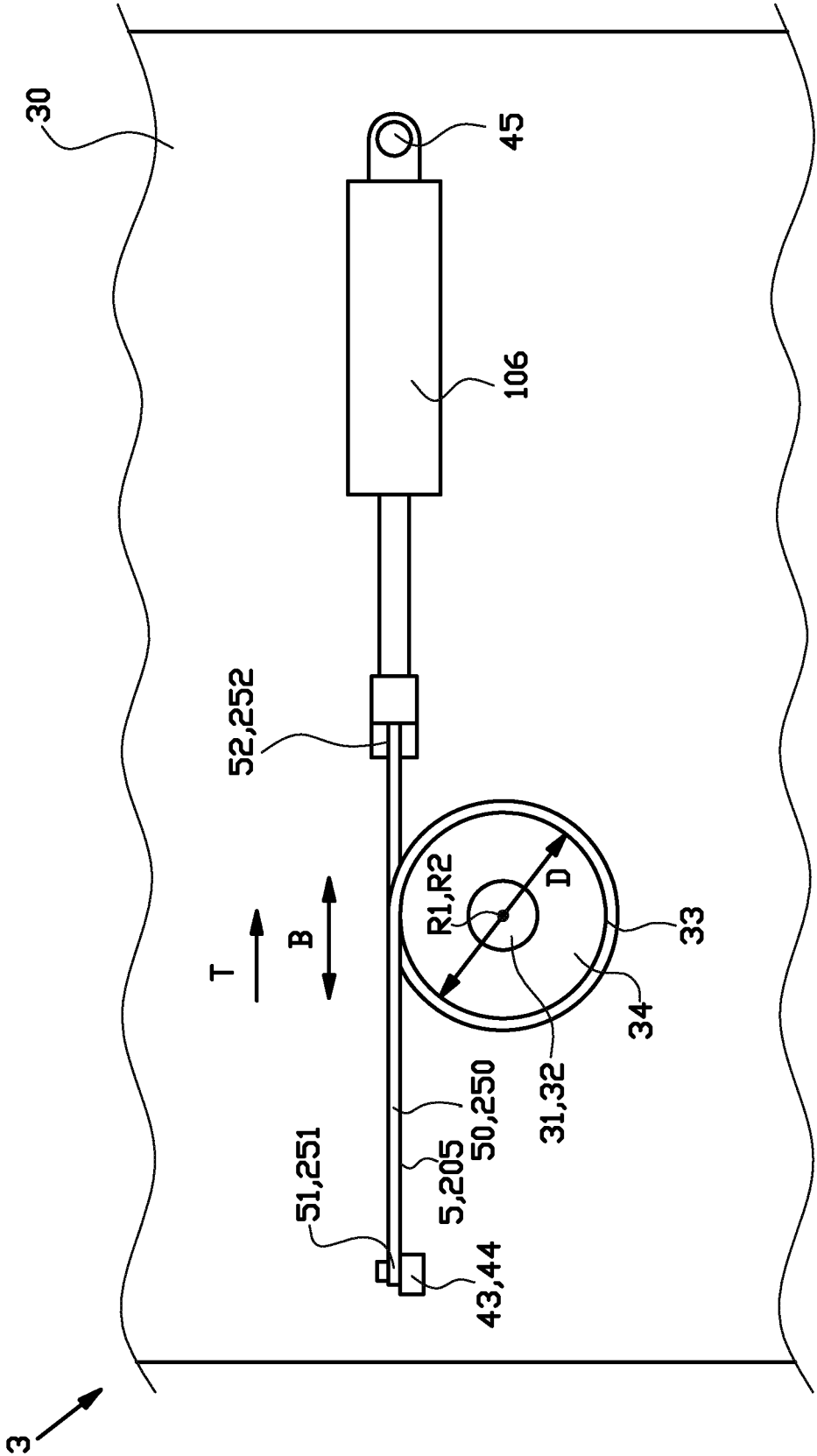
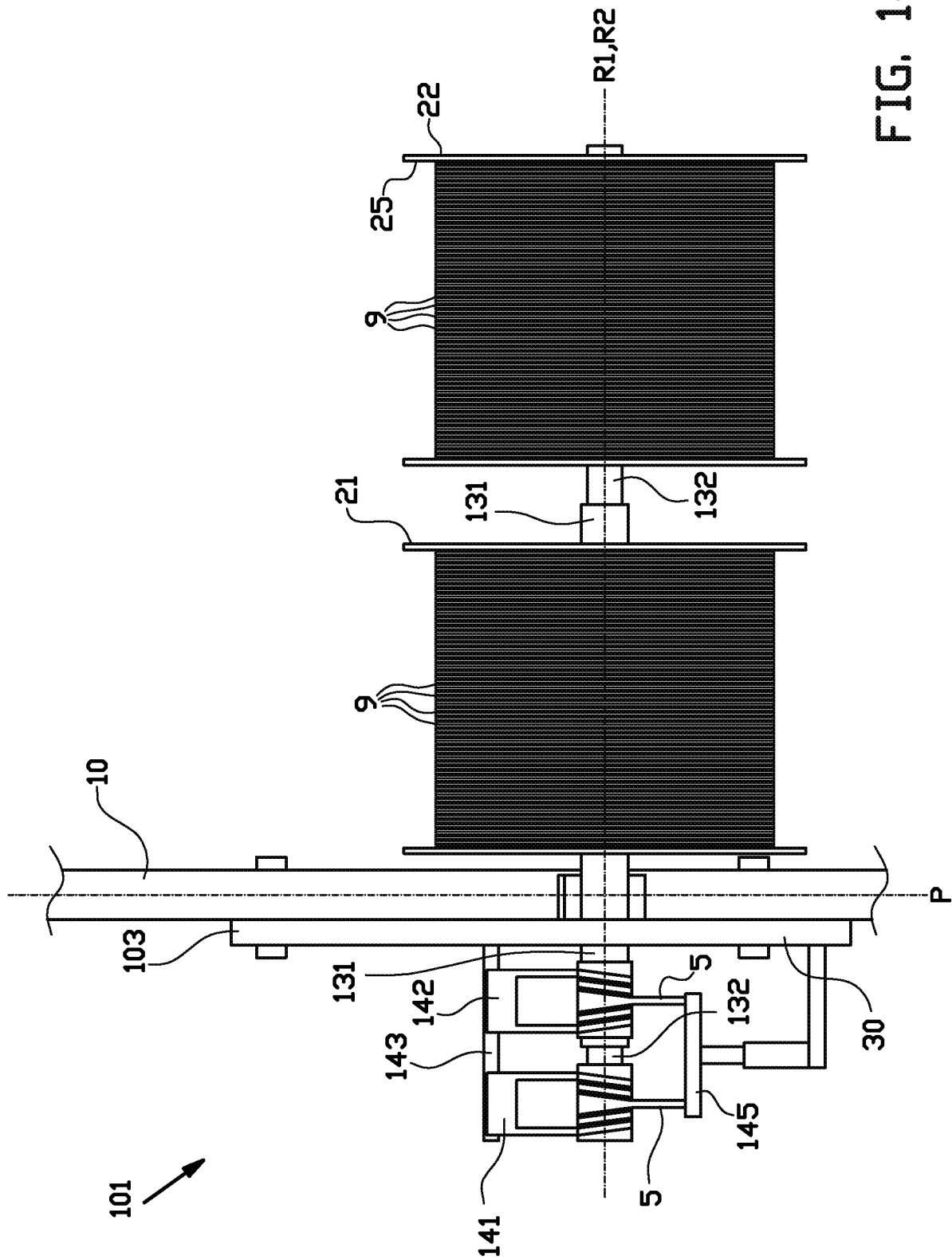
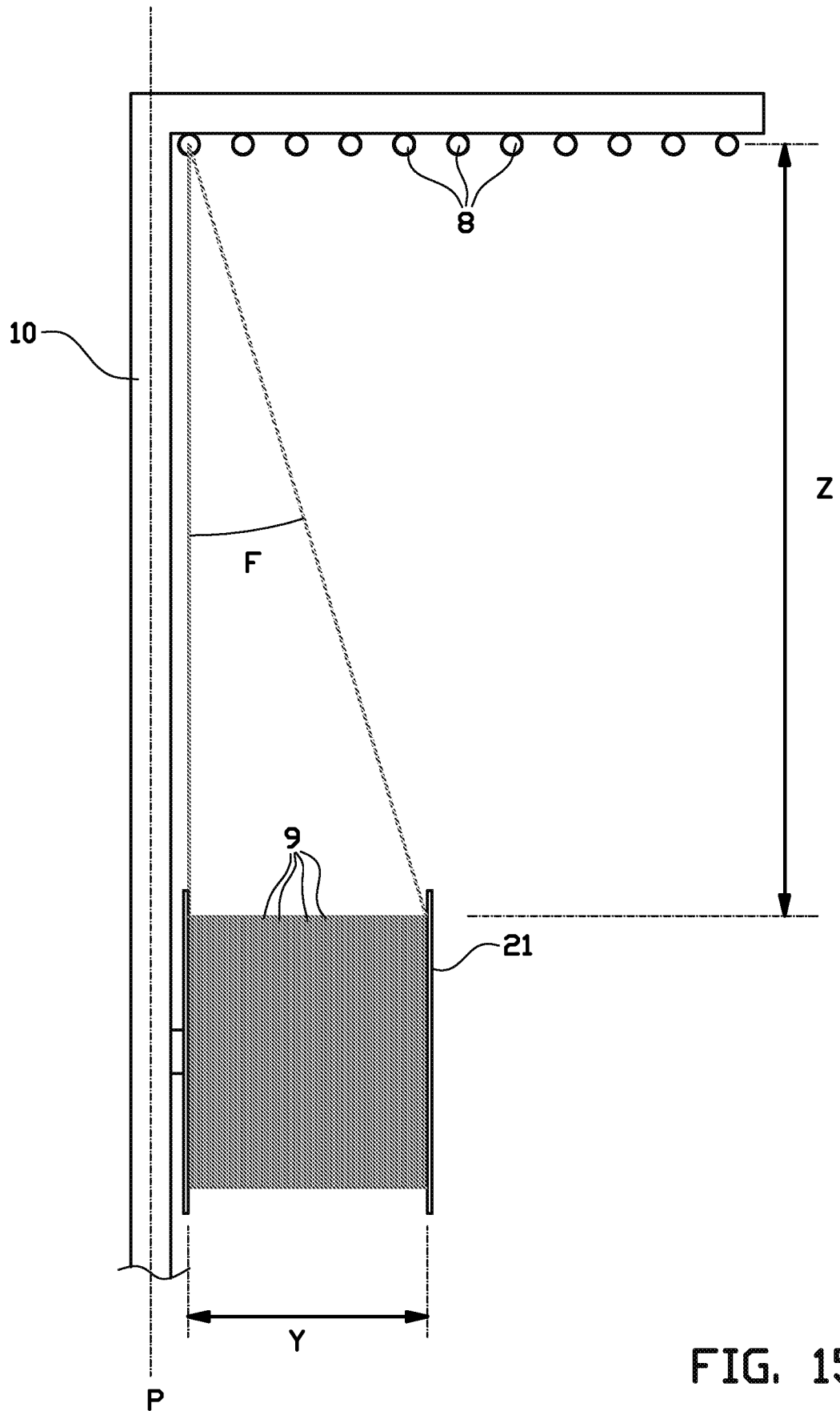
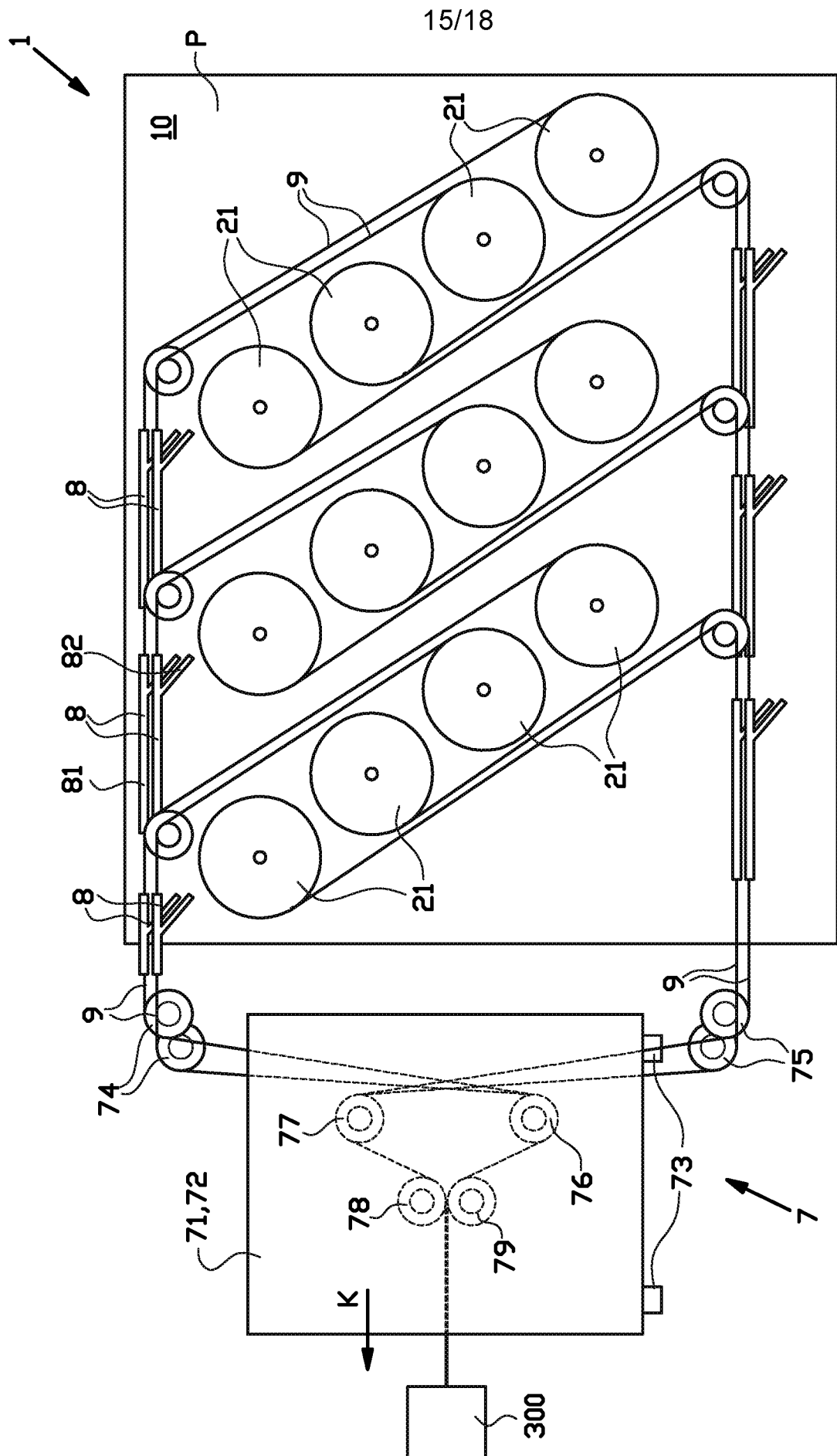


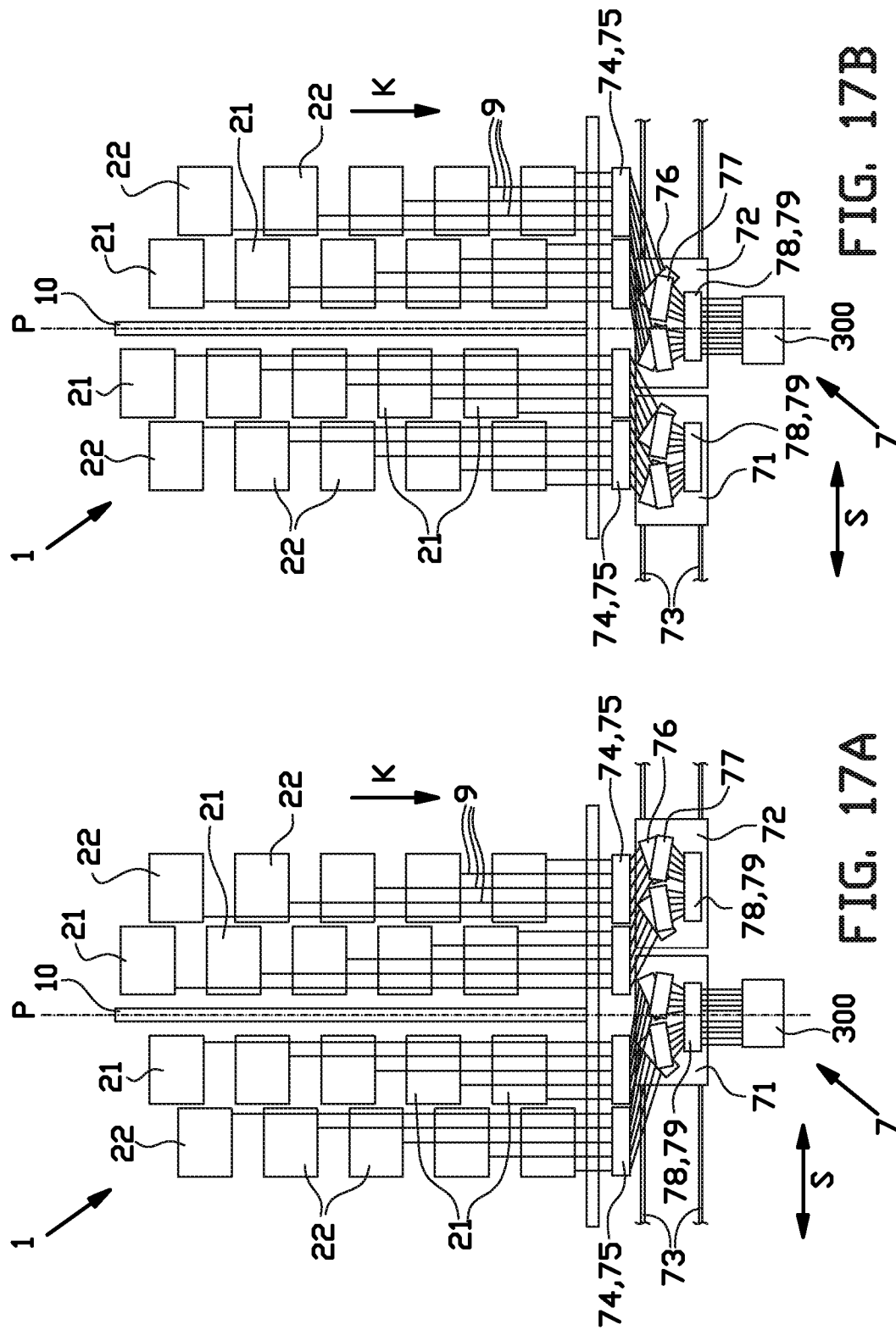
FIG. 13







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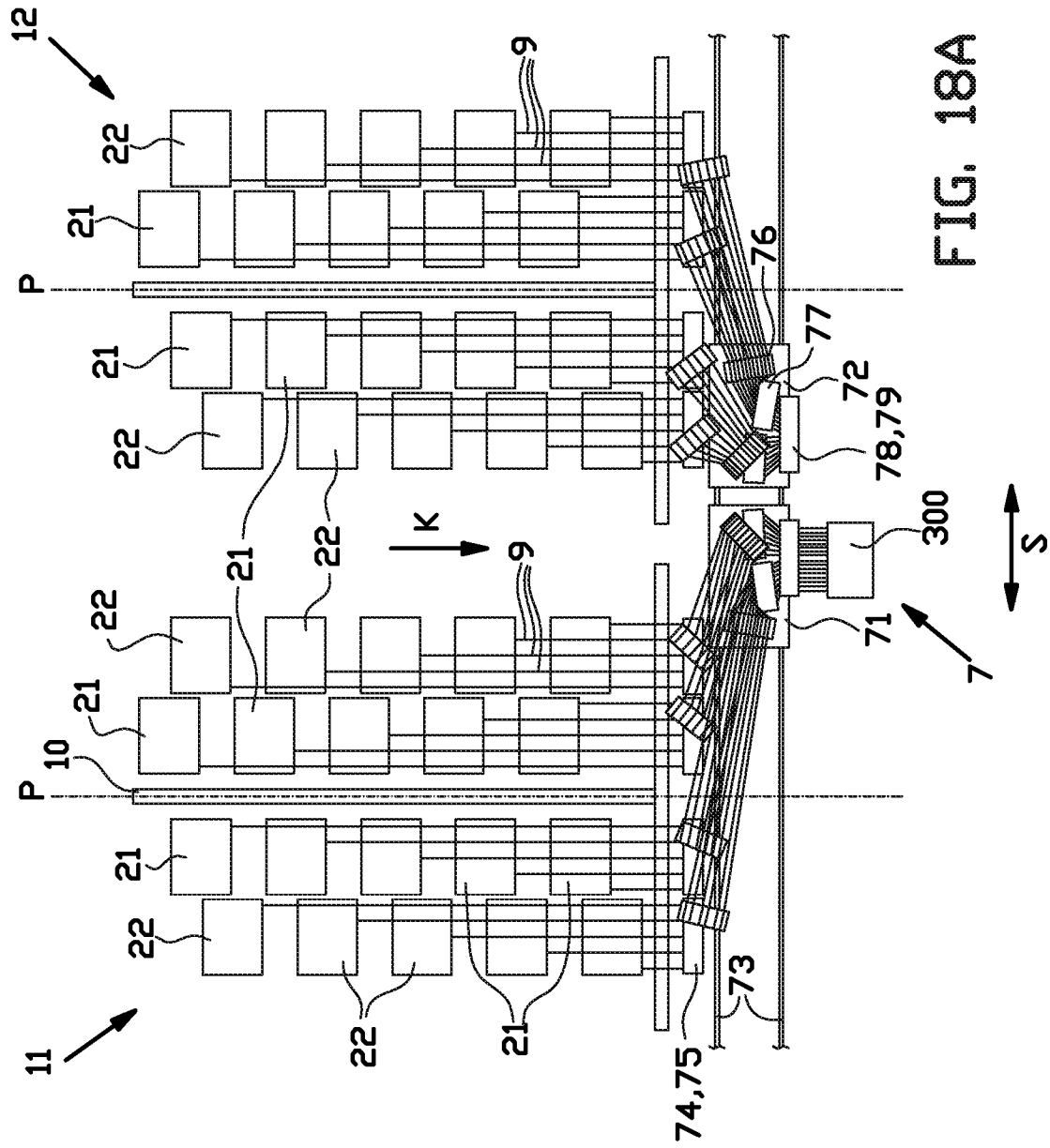
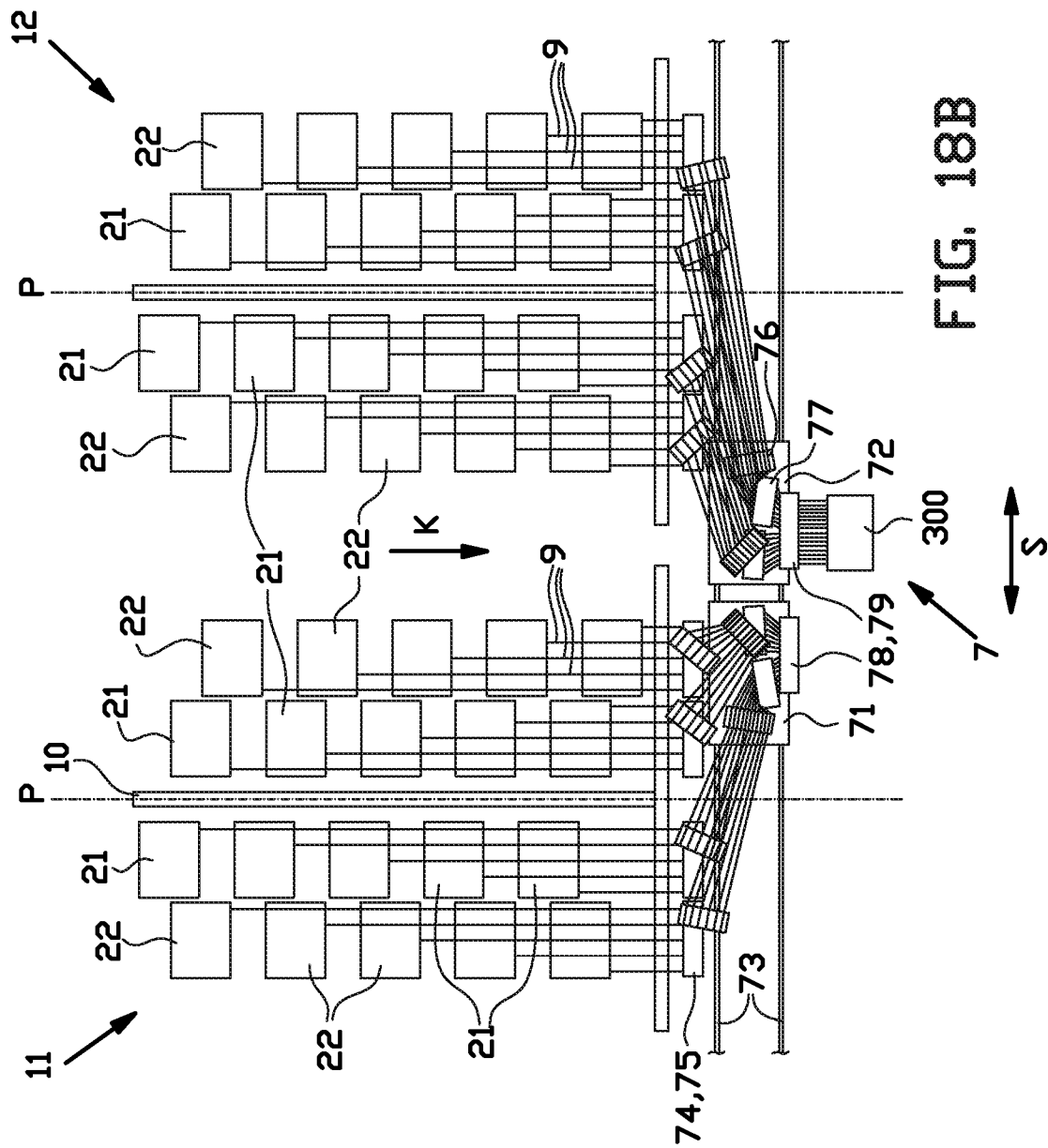


FIG. 18A



INTERNATIONAL SEARCH REPORT

International application No
PCT/NL2018/050190

A. CLASSIFICATION OF SUBJECT MATTER

INV. B65H49/32 B65H59/04 F16D49/08 B65H57/12 B65H67/02
B65H51/16

ADD.

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)

B65H D01H F16D D04B

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)

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	GB 2 528 885 A (TEXKIMP LTD [GB]) 10 February 2016 (2016-02-10) page 2, lines 15-16 page 5, line 10 - page 7, line 18 page 9, lines 10-18; figures -----	1-16,27, 28,37-39
A	US 1 580 270 A (STANLEY WILLIAMS) 13 April 1926 (1926-04-13) page 1, lines 26-43,96-106; figures -----	1-16,27, 28,37-39
A	US 3 531 849 A (BISHOP GARY E ET AL) 6 October 1970 (1970-10-06) column 2, lines 41-66 column 3, lines 51-65; figures -----	1-16,27, 28,37-39
A	DE 50 840 C (BAUTAIN) 17 February 1890 (1890-02-17) the whole document -----	1-16,27, 28,37-39
	-/--	



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

13 August 2018

Date of mailing of the international search report

22/08/2018

Name and mailing address of the ISA/

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Authorized officer

Lemmen, René

INTERNATIONAL SEARCH REPORT

International application No
PCT/NL2018/050190

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	GB 166 902 A (L PH HEMMER GMBH) 5 January 1922 (1922-01-05) the whole document -----	1-16,27, 28,37-39
A	FR 2 359 319 A1 (DAIMLER BENZ AG [DE]) 17 February 1978 (1978-02-17) the whole document -----	1-16,27, 28,37-39
A	ANONYMOUS: "Creel tension device", RESEARCH DISCLOSURE, KENNETH MASON PUBLICATIONS, HAMPSHIRE, UK, GB, vol. 275, no. 24, 1 March 1987 (1987-03-01), XP007111393, ISSN: 0374-4353 the whole document -----	1-16,27, 28,37-39
A	WO 2008/105656 A2 (VMI EPE HOLLAND [NL]; GRASHUIS JAN KORNELIS [NL]; JANSZEN CORNELIS WOU) 4 September 2008 (2008-09-04) page 5, lines 5-21; figures -----	1-16, 27-29, 37-39
A	WO 00/27532 A1 (INTERFACE INC [US]; INGRAM WILLIAM O III [US]) 18 May 2000 (2000-05-18) page 5, line 24 - page 6, line 2; figures -----	29
A	KR 101 556 732 B1 (HO EUN CHONG [KR]; HUR JONG SUK [KR]) 2 October 2015 (2015-10-02) figures -----	29
X	JP 2000 136488 A (BRIDGESTONE CORP) 16 May 2000 (2000-05-16) -----	32-35
A	paragraphs [0022] - [0024], [0032], [0035]; figures -----	36
X	EP 3 124 196 A1 (COMERC INT S R L [IT]) 1 February 2017 (2017-02-01) -----	32-35
A	paragraphs [0003], [0008], [0009], [0033] - [0039], [0043], [0044]; figures -----	36

INTERNATIONAL SEARCH REPORT

International application No.
PCT/NL2018/050190

Box No. II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:
3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box No. III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

see additional sheet

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fees, this Authority did not invite payment of additional fees.
3. ☒ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
1-16, 29, 32-39(completely); 27, 28(partially)
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest and, where applicable, the payment of a protest fee.
- ☐ The additional search fees were accompanied by the applicant's protest but the applicable protest fee was not paid within the time limit specified in the invitation.
- ☒ No protest accompanied the payment of additional search fees.

FURTHER INFORMATION CONTINUED FROM PCT/ISA/ 210

This International Searching Authority found multiple (groups of) inventions in this international application, as follows:

1. claims: 1-16, 37-39(completely); 27, 28(partially)

Creel bobbin brake with a tapering strap having an opening, creel assembly with such a brake, creel with such an assembly and method of mounting such a strap

2. claims: 17-26(completely); 27, 28(partially)

Creel bobbin assembly with a base member supporting a first and a second shaft with respect to a creel plane, creel with such an assembly

3. claim: 29

Creel with bobbins and guiding tubes at the lower end and upper end of the creel

4. claims: 30, 31

Creel with a bobbin and a guiding tube and a maximum fleet angle less than ten degrees

5. claims: 32-36

One or more creels and a wire collector with collection section movable in a switching direction

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/NL2018/050190

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
GB 2528885	A	10-02-2016	NONE
US 1580270	A	13-04-1926	NONE
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KR 101556732	B1	02-10-2015	NONE
JP 2000136488	A	16-05-2000	NONE
EP 3124196	A1	01-02-2017	NONE