



EUROPEAN PATENT APPLICATION

Application number: 83307981.7

Int. Cl. 4: **B 65 H 67/04**

Date of filing: 23.12.83

Priority: 29.12.82 US 454364

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Date of publication of application: 03.10.84
Bulletin 84/40

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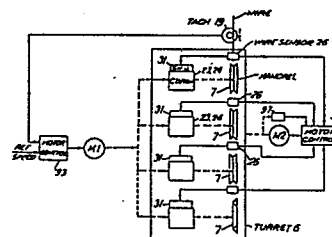
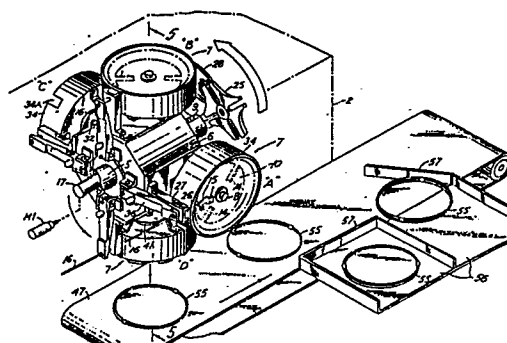
Designated Contracting States: **DE FR GB IT SE**

Date of deferred publication of search
report: 16.04.86 Bulletin 86/16

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Wire coil production system.

A wire coil production system for winding, tying and distributing coils fabricated from pre-cut wire segments. Four controllably driven mandrels or reels (7) are mounted in relative quadrature on a rotatable turret (6) which cycles each mandrel through stations (A to D) for (1) receiving the wire (16) and initiating the winding operation, (2) completing the winding operation, (3) tying the formed coil and (4) discharging the coil to a conveyer/distributor system. Each mandrel includes a wire sensor (26, 27) and automatic wire clamping and coil load/unload mechanisms. A control system (93, 95) coordinates all operations so they are synchronized with the wire feed system and with each other.



EP 0 120 168 A3



DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. ³)
Y	GB-A- 958 612 (O.H. ÄSTRÖM) * Page 1, line 88 - page 2, line 18; page 2, lines 16-34, 42-47, 98, 112; figure 4; page 3, lines 29-45 *	1, 4, 6	B 65 H 67/04
Y	FR-A-2 165 606 (DART INDUSTRIES INC., USA) * Page 1, lines 9-11; page 16, line 32 - page 17, line 23 *	1, 4-6	
A	-----	2, 3, 5	
			TECHNICAL FIELDS SEARCHED (Int. Cl. ³)
			B 65 H
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 20-01-1986	Examiner HOEFER W.D.
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on or after the filing date D : document cited in the application L : document cited for other reasons</p> <p>& : member of the same patent family, corresponding document</p>			