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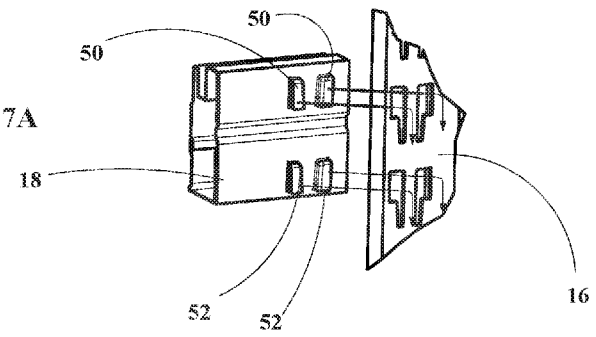
(54) **Title:** METHOD FOR MAKING SHELVES

Fig. 7A



(57) **Abstract:** A rack for shelving consisting of upright posts and horizontal beams, connecting each between two upright posts, wherein said upright posts comprise. The upright posts include each at least one flank demonstrating one column of through gamma perforation doublets. The horizontal beams are either depth forming beams or width forming beams. The width forming beams include each at each of each extremity two rows of one doublet of fasteners adapted to fit with the gamma perforations so that the entire number of individual fasteners in those two rows of said perforations find each a matching perforation. The fasteners of the width forming beam are formed including each a cross recess of the width matching the width of the flank of the upright posts.

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METHOD FOR MAKING SHELVES

CROSS-REFERENCE TO RELATED APPLICATIONS

The present application claims the benefit of priority to US Provisional Patent Application Serial Number 62/480,570, filed April 3, 2017, entitled "METHOD FOR MAKING SHELVES." The aforementioned application is hereby incorporated herein by reference. The present application also claims the benefit of priority to US Provisional Patent Application Serial Number 62/533685, filed July 18, 2017, entitled "METHOD FOR MAKING SHELVES." The aforementioned application is hereby incorporated herein by reference.

TECHNICAL FIELD

The present invention relates to metal shelving. The construction of pallet racks from components and specifically to joining upright posts with the horizontal beams to form a scaffolding unto which shelves are laid.

BACKGROUND ART

The use of pallet racks is common in warehouses and stores. Such appliances are designed to receive product bearing pallets typically from a forklift truck.

Typically such racks are constructed from upright posts into which horizontal beams are connected. See for example European patent application EP 3042865A1.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is an isometric view of a four posted rack in accordance with the present invention.

Fig. 2A illustrates a vertical (upright) post in accordance with the present invention, having a T profile.

Figure 2B illustrates a upright post in accordance with the present invention featuring a double column of doublets of perforations.

Fig. 2C illustrates in detail the two perforations in each doublet.

Figs. 3A-B illustrates features of a horizontal width forming beam

Figs. 3C is an isometric view of a horizontal beam showing placement of the fasteners.

Figure 3D is an enlarged isometric extremity of a horizontal width forming beam .

Fig. 3E is an enlarged extremity of a horizontal width forming beam showing fasteners with relation to profile.

Fig. 4A is an enlarged isometric view of the fastener interaction with the gamma perforation.

Fig. 4B is an enlarged isometric view of the fastener interaction with the gamma perforation showing more detail.

Figs 5A – B are schematic isometric views of the fastener and perforation engaging mechanism in accordance with the oresent invention.

Fig. 6 illustrates a upright non voluminous post in accordance with the present invention having two types of perforations.

Figs. 7A-C. depict , pictorially , the insertion steps of the fasteners into matching perforations.

DESCRIPTION OF EMBODIMENTS

The present invention is implemented in the technical environment of storage racks, such as pallet racks and shelves. This invention relates to structural elements and joining them together in a specific form whereby joining and supporting members of structures such as shelf racks, scaffolding, and the like. It is a particularly important object of the invention to provide new and improved joints for connecting a supporting member and a supported member.

The present invention provides a system along with a method for constructing racks, emphasizing sturdy joining aspects and strong posts and horizontal beams, whereby weight of the components is kept low.
A general view of a simple rack **10** demonstrating some aspects of the invention is presented in **Fig**. **1**. Rack **10** includes four upright posts **16** also referred to simply as "uprights" connected horizontally by two types of beams. Width forming beams **18** forming the width of the rack, and depth forming beams **20** that form the depth of rack **10**.
A prominent aspect of the invention is the width joining system, to explain how this works, first the structural elements involved are described.

The upright posts

The posts shown in the figure are typically configure to form corners, however, there are upright posts configured otherwise.
As can be seen in **Fig.2A,** upright post **16** features, having a T profile, such that two matching rows of vertically arranged columns of perforations as shown enlarged, with reference to **Fig**. **2B**. Upright post **16** has the two flanks, left flank **28** and right flank **30**. Each of the flanks features a column of doublets of through-perforations which will be related to as (gamma) perforations infra. As can be seen in **Fig**. **2C** the two perforations in each doublet are axisymmetrical with respect to each other such that perforation **32** (left) is identical but chirally opposed to perforation **34**. Both perforations are

cutouts in the profile of the flanks **28** and **30** respectively**.** The perforations do not have any voluminous features.

The fasteners that fit in within these perforations do possess voluminous features and are therefore three dimensionally structured. The fasteners which fit in within the perforations are a part of the width forming beams.

Before explaining how the joining works, important structural features of the horizontal beams are described.

The horizontal width forming beams

In **Fig**. **3A** the broad side of horizontal beam **18** is shown, featuring on both extremes fastener group **42** .Looking from the narrow side of beam **18**, at **Fig**. **3B** the two groups of fasteners **42** can be seen extending from the otherwise flat surface of the beam. In **Fig**. **3C** the beam **18** is shown with the fasteners. All the fasteners extend from the same surface as can be seen in **Fig**. **3D** an enlarged view of one group of fasteners at the extremity of horizontal beam. Thus there are two horizontally arranged doublets of fasteners including on the upper side fasteners **50** and on the lower side fasteners **52**. The two doubles are identical and can be simultaneously fit inside two doublets of perforations as described above with reference to **Fig**. **2B**. The positioning of the fasteners with respect to the horizontal beam and the profile from which it is made are described more clearly in the enlarged view demonstrated in **Fig**. **3D**. In **Fig**. **3E** some features of the fasteners are shown and discussed following.

Fasteners, structural aspects thereof , interaction with the upright post and the gamma perforations in particular

As demonstrated in **Fig**. **3E** Fastener **52A** has recess **56** at one side, and a frontal cover **58.** The interaction of the fastener **52** (for the sake of clarity the post is not shown) with upright post **26** is explained with reference to Figs**. 4A – 5B.**

In **Fig**s. **4A** and **B**, upright post **26** features two chirally arranged perforations. **32** and **34**, the rest of the discussion below deals with perforation **34** in more

detail. Fastener **52** points at a matching perforation **34** (arrow **36**) and when poked at the perforation, cross recess **56** gets aligned with the width dimension **68** of upright post **26** this alignment allows fastener **52** to be pushed down while being inserted in the perforation **34**, so that metal projection **70** (shown hatched) is entangled within recess **56**. Thus in order to implement the construction fastening of the invention, several movements are to be executed sequentially, as follows. First fastener **52** is poked into a matching gamma perforation **34**, (in the direction of arrow **36**) then the fastener is lowered (pushed down) in the direction of double headed arrow **76** (lower part) optionally forcefully, this is also the direction of gravity pull. As a result, fastener **52** and post **72** to which it is attached (shown in **Fig**. **4B** only) become engaged with upright post **26**. The tenacity and stability of the link between the width forming post not shown, but the manner by which the fastener is attached prevents swiveling of the fastener **52** in the direction as described by double headed arrow **74** (around axis- arrow **36**) because it is a rectangular box restrained by the sides (broad and narrow) of gamma perforation **34**. Up and down movement as indicated by double headed arrow **76** is restrained by the top and bottom walls of the gamma perforation. The engagement of fastener **52** with metal flap **70** prevents undesirable detachment of the fastener from the upright post **26**. Thus in order to intentionally detach the fastener from post **26** it will have to be lifted up against gravity force (arrow **76**) thereby detaching from flap **70.** This alludes to the fact that gravity is harnessed in this connection to the stabilization of the structure of the connection once established. At this point the fact that the entire discussion of the procedure to achieve the connection of the fastener with the upright post has been conducted in the singular, the actual performance in accordance with the present invention, dictates two connections being executed at once with the two chiral perforations **32** and **34** made simultaneously, thereby providing extra strength to the connection yet allowing for thin profile walls. of both vertical and width forming frame parts to be thinned (typically by the process of rolling). Moreover according to a preferred embodiment of the invention two doublets of fasteners are employed at once,

with each such connection (see **Fig**. **3D** and **Figs 7A-C**), thereby providing additional stability parameters to the connection. Another structural feature of the fastener is explained with reference to **Figs**. **5A-C**. Fastener **52** is shown as it confronts the gamma perforation with which it is engageable explicitly demonstrating the role of leg **86**, the front face **88** of which is shown hatched, recess **90** in leg **86** is optional.

The depth of the recess **90** up the leg **86** can limit the extent to which the fastener **52** can be pushed downwards when inserted inside perforation **34**. As can be seen in **Fig**. **5B** walls **94** of perforation **34** constrain the swivelling of fastener **52** and can guard against undesirable collapse of the entire structure of an erected rack in a direction parallel to post **26**. In addition, inner face **96** of perforation **34** also constrains a potential swiveling of fastener **52** by abutting face **98** of fastener **52**. As regards the length of leg **86**, or in other words the length vertical length **104** (in **fig. 5C)** or the reach of fastener **52** downwards inside perforation **34**, there are several options, in some embodiments, leg **86** does not reach horizontal lowermost surface **102** of the perforation, in which case there is no reason for forming recess **90** at all in which case the fastener **52** would look as described in **Fig**. **4A**. In other embodiments the fastener may just reach the bottom of the perforation when it is pressed downwards, and in yet other embodiments as can be seen in **Fig**. **5C** it is longer and may reach beyond the bottom of the perforation while it is pressed downwards, if recess **90** exists and in such a case recess **90** is functional.

The profiles of the posts and beams

In an aspect of the invention, in order to save on weight while maximizing the stability and strength of the connection, the voluminous profiles of the horizontal width forming beams are made with thin walls. Typically, the upright posts are not voluminous, and are referred to hereinafter as NV posts. As can be seen in **Fig**. **6** NV post **26** features two flanks, **28** and **30**, respectively, rib **108**, perpendicular to the plain formed by flanks **28** and **30,** features a columnar string of of perforations **110**, these perforations on rib **108** are

rectangular or even square cutouts in the rib. Thus making the rib engageable with width forming beams. These perforations serve to receive the matching fastener in the extremity of depth forming beams **20** (see **Fig**. **1**, not shown in **Fig**. **6**).

Pictorial demonstration of the width forming beams with the upright posts and matching perforations

In **Fig**s. **7A-C** the insertion of the fasteners is shown in the order of steps executed. Thus**,** in **Fig**. **7A** horizontal beam **18** bears two fasteners **50** (on the upper side and two fasteners **52** on the lower side**.** To make the connection, all the fasteners are poked at once inside the selected perforations in the upright beam **16**, **as** seen in **Fig**. **7B**. Then the horizontal beam **18** is pushed downwards in the direction of arrows **162**. **In Fig**. **7C** the fasteners upper and lower are seen in their respective perforations resting at the bottom most position within the respective perforations.

CLAIMS

1. A rack for shelving consisting of upright posts and horizontal beams, connecting each between two upright posts, wherein said upright posts comprise:
    - said upright posts include each at least one flank demonstrating one column of through gamma perforation doublets;
    - said horizontal beams are depth forming beam and width forming beam;
    - wherein said width forming beam include at each extremity two rows of one doublet of fasteners adapted to fit with said gamma perforations so that the entire number of individual fasteners in said two rows of said fasteners cab matched each with a matching perforation;
    - wherein said fasteners of said width forming beam are formed including each a cross recess of the width matching the width of the flank of said upright posts;
2. A rack for shelving as in claim 1 wherein at least one upright post includes two flanks each of which demonstrating one column of through gamma perforation doublets.
3. A rack for shelving as in claim 1 wherein Non voluminous
4. A rack for shelving as in claim 1 wherein said upright post includes one or two flanks each demonstrating columnar through - gamma perforation doublets and one rib demonstrating a column of rectangular cutout through - perforations.
5. A rack as in claim 4 wherein said depth forming beams are engageble with said ribs by matching fastener in each of its extremities.

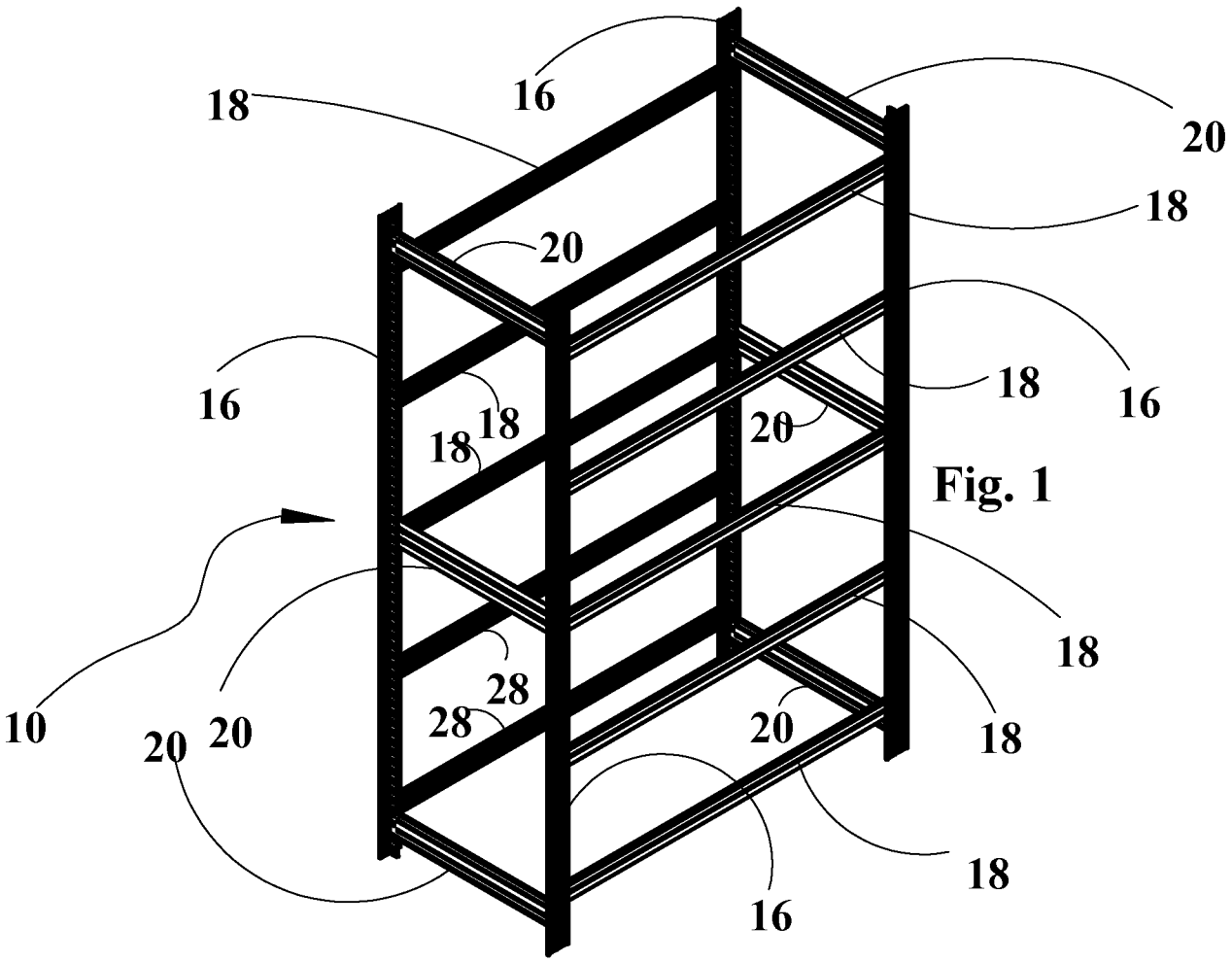


Fig. 1

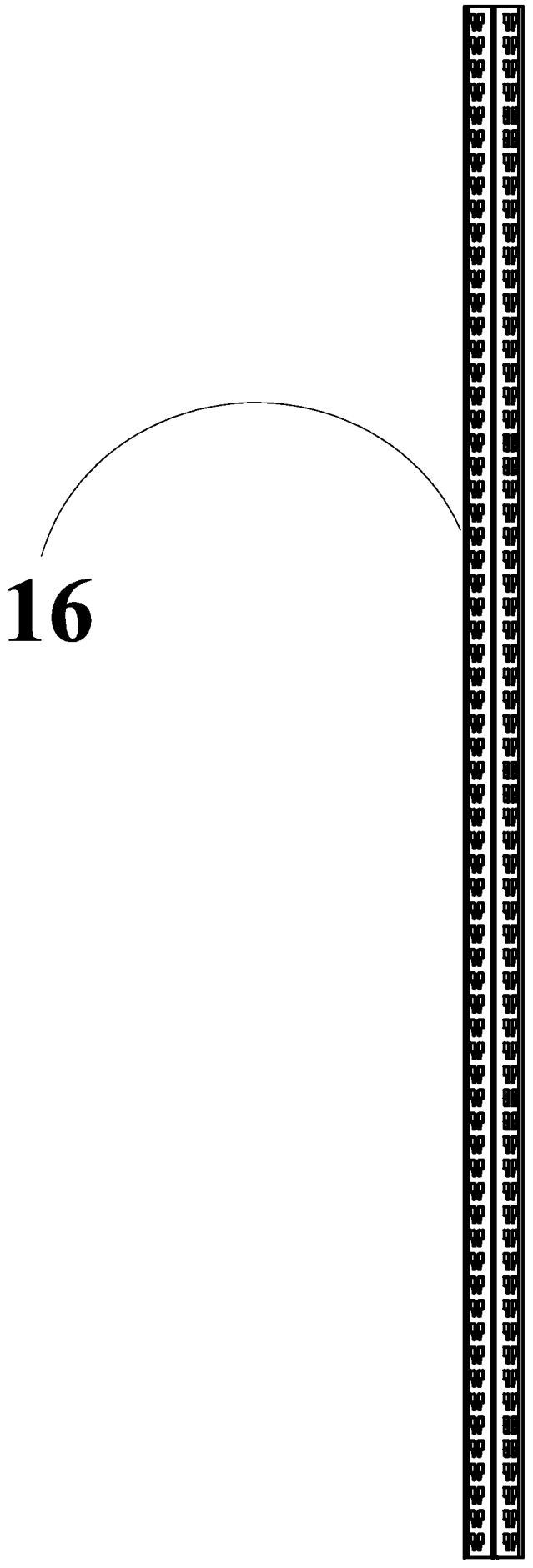


Fig.2A

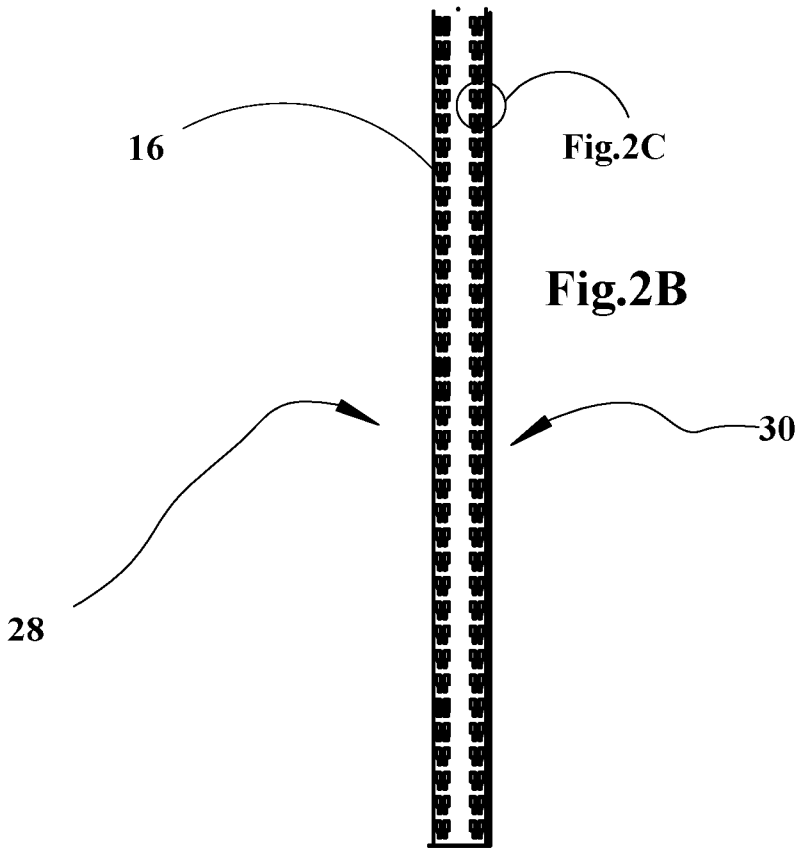


Fig.2B

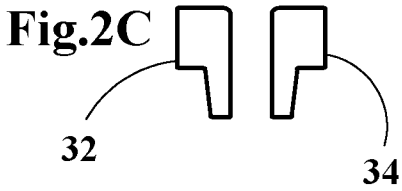


Fig.2C

Fig. 3A

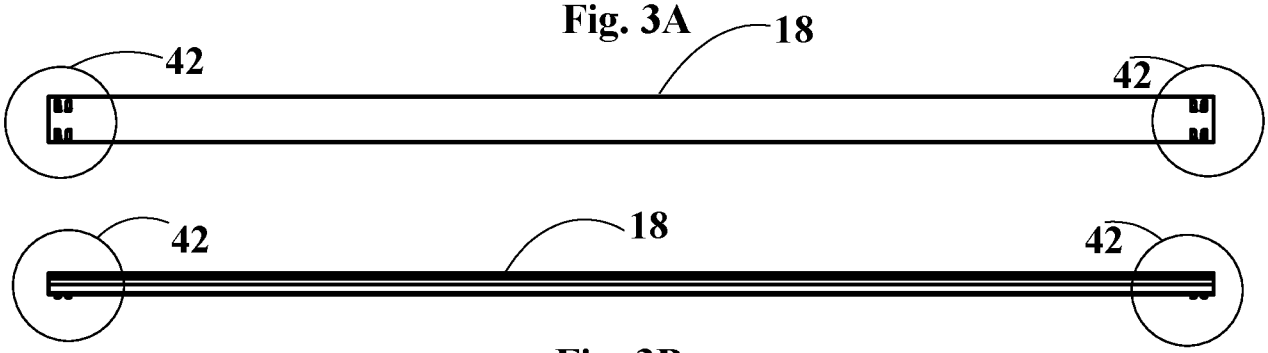


Fig. 3B

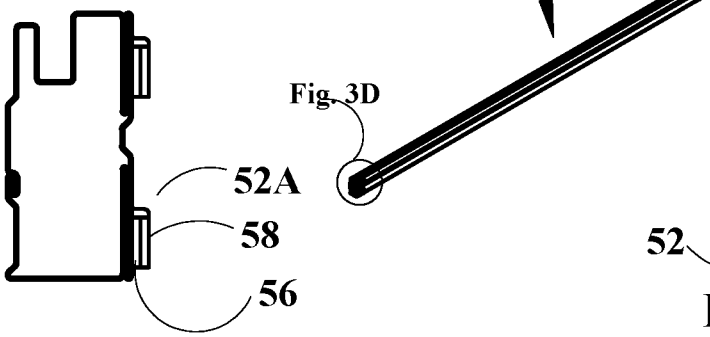


Fig. 3C

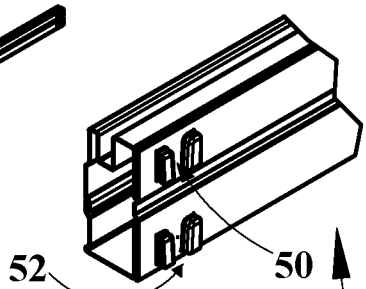


Fig. 3D

Fig. 3E

18

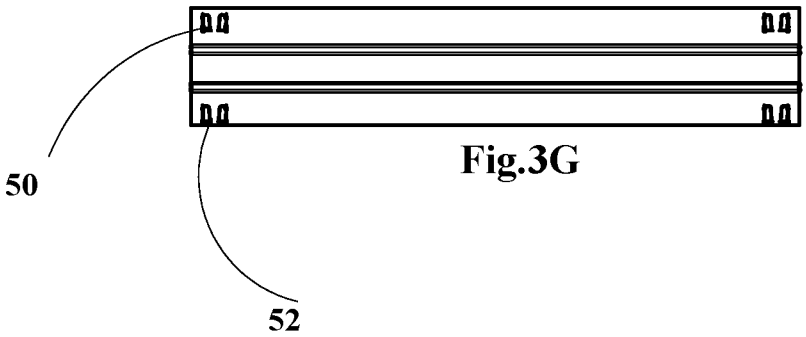


Fig.3G

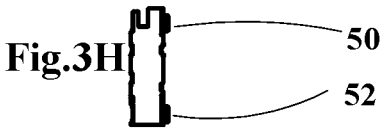
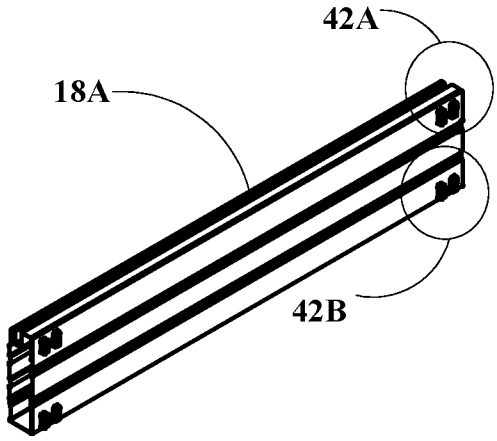


Fig.3H



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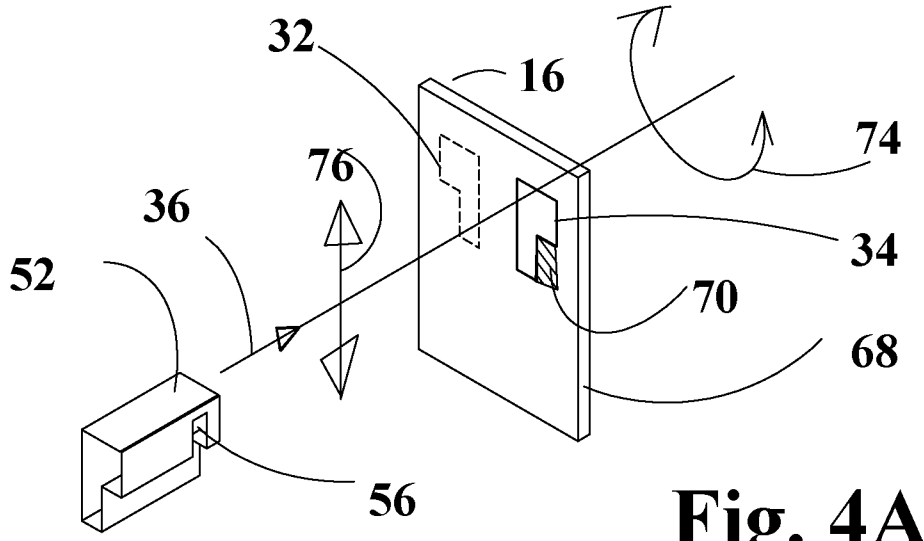


Fig. 4A

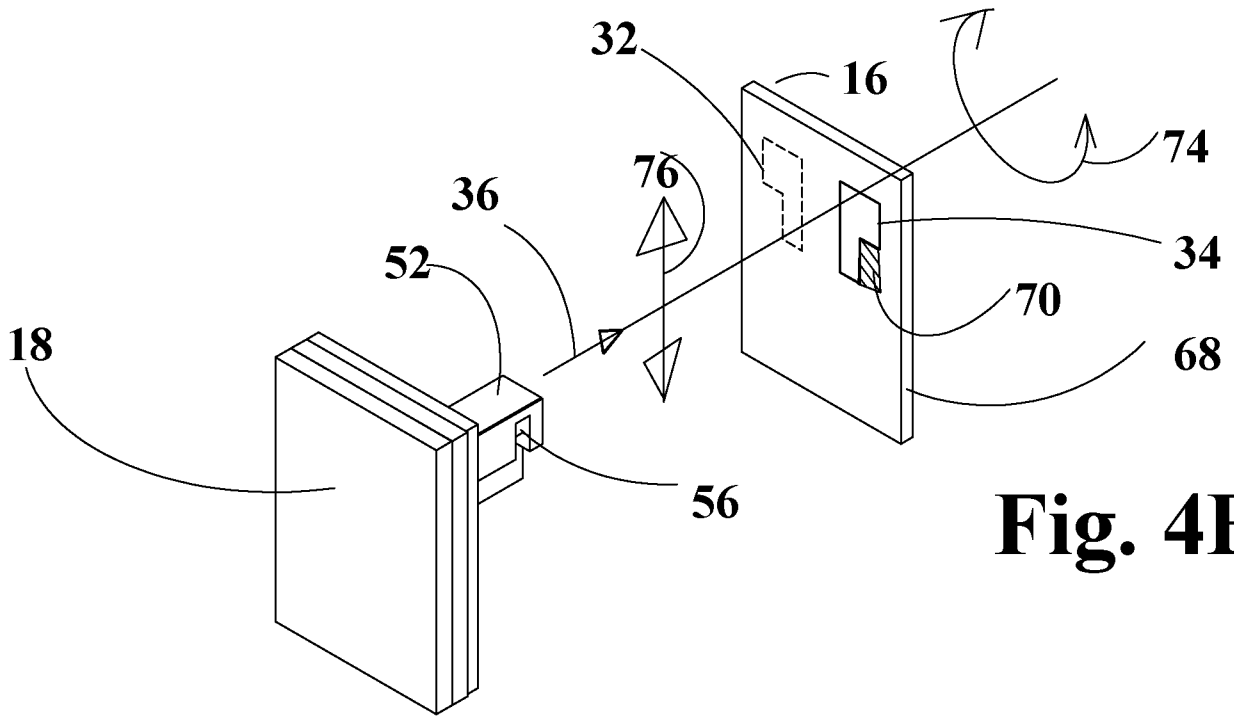


Fig. 4B

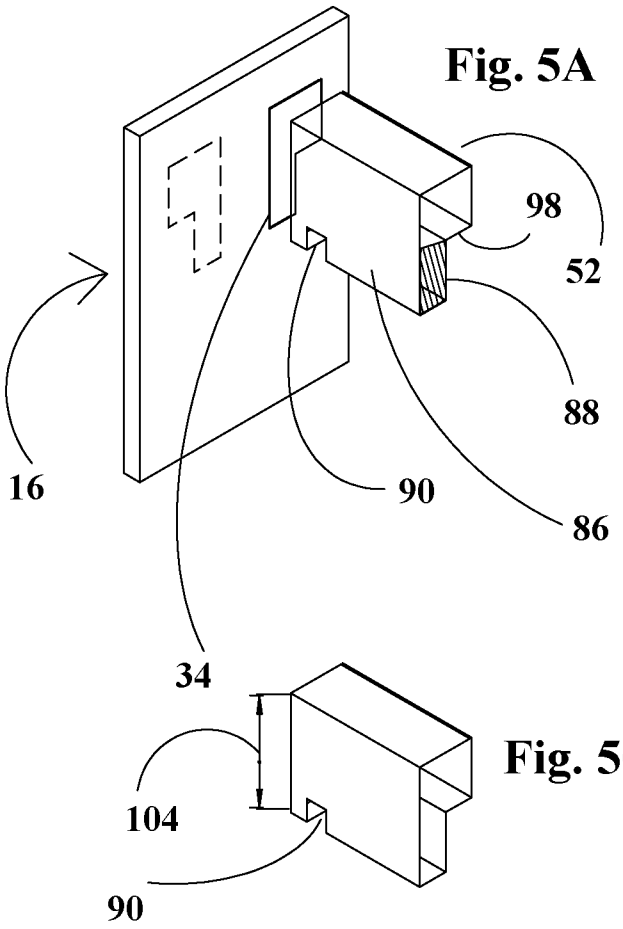


Fig. 5A

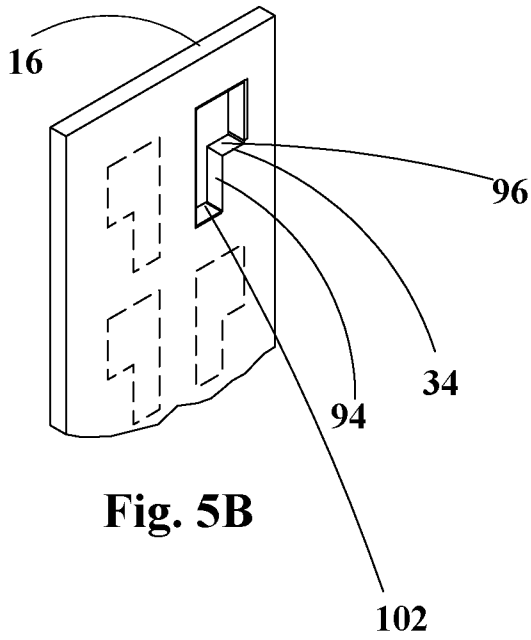


Fig. 5B

Fig. 5C

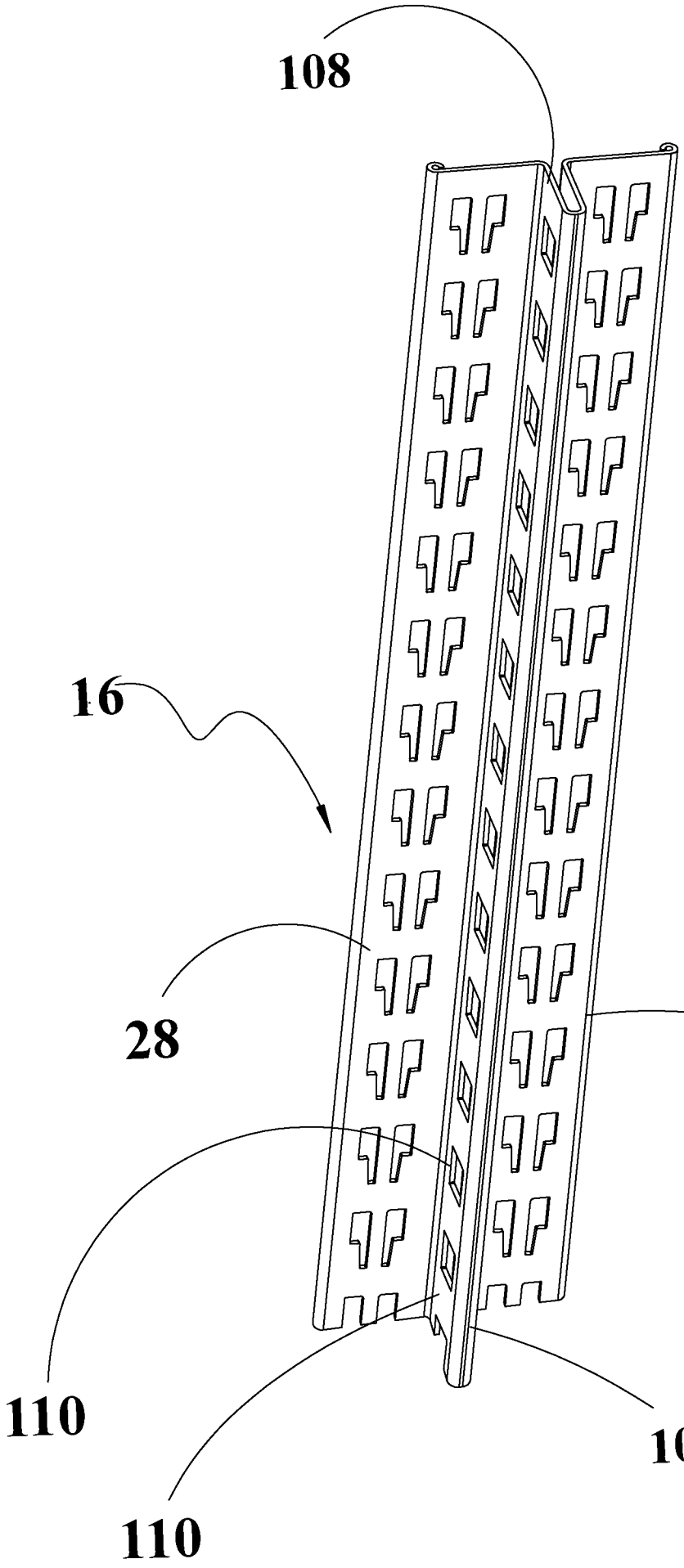


Fig. 6

Fig. 7A

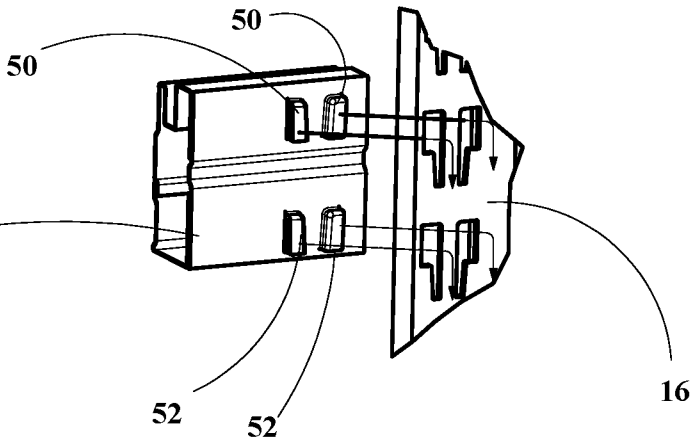


Fig. 7C

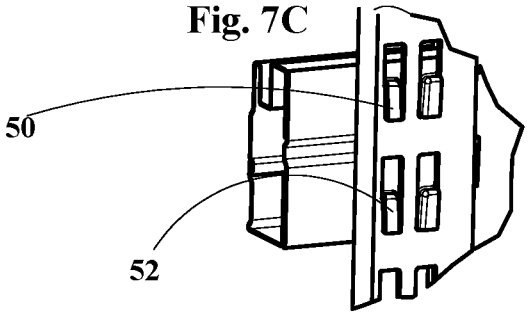
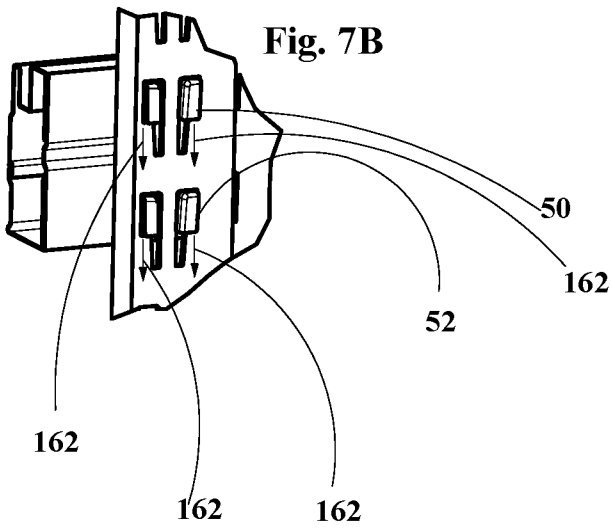


Fig. 7B



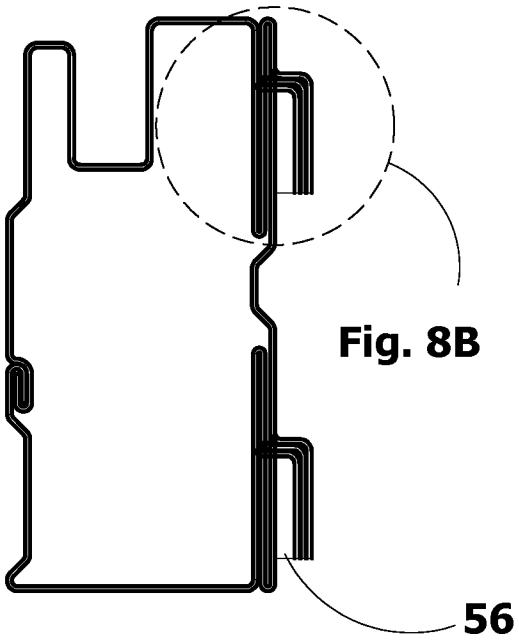


Fig. 8A

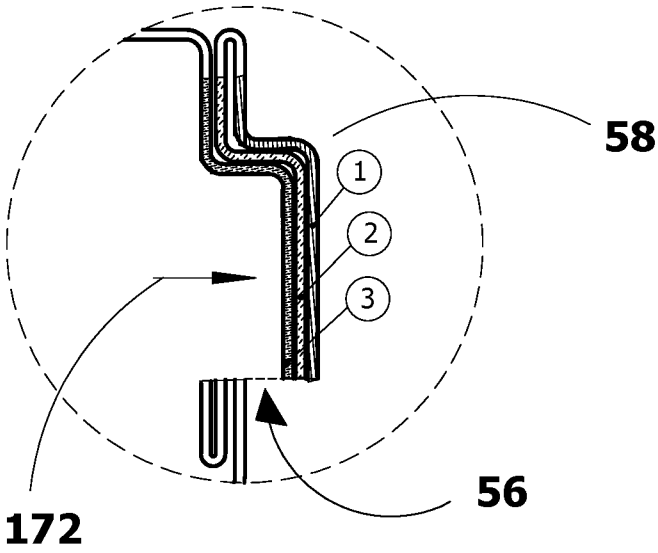


Fig. 8B

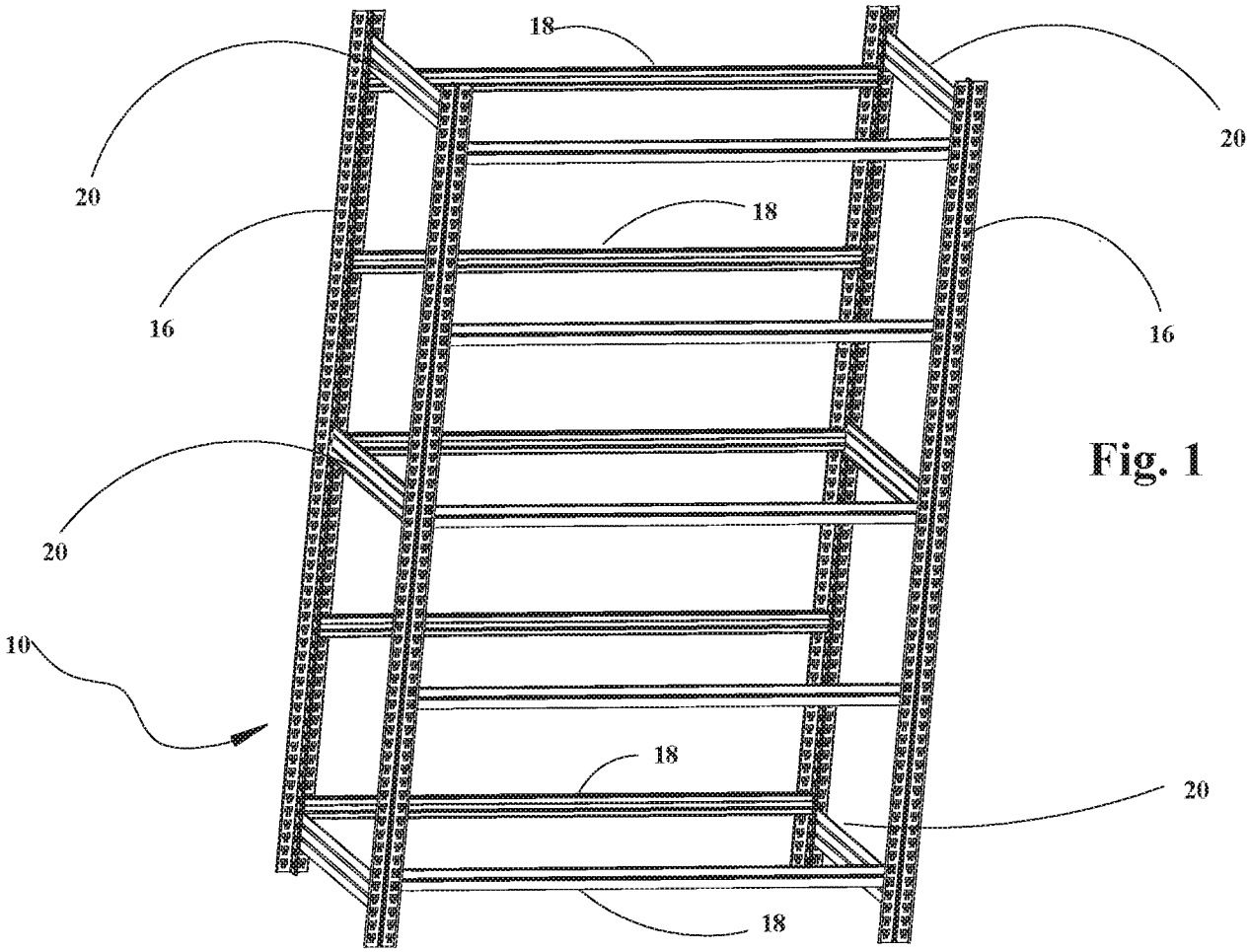


Fig. 1

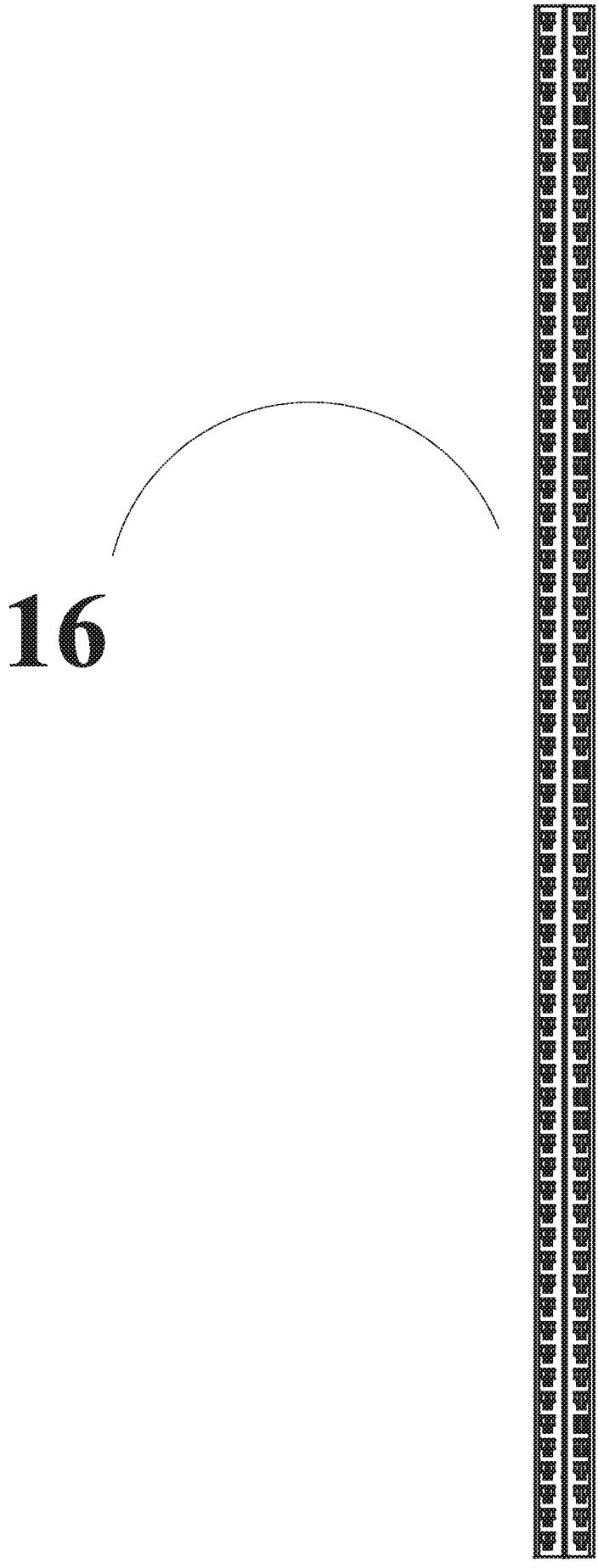


Fig.2A

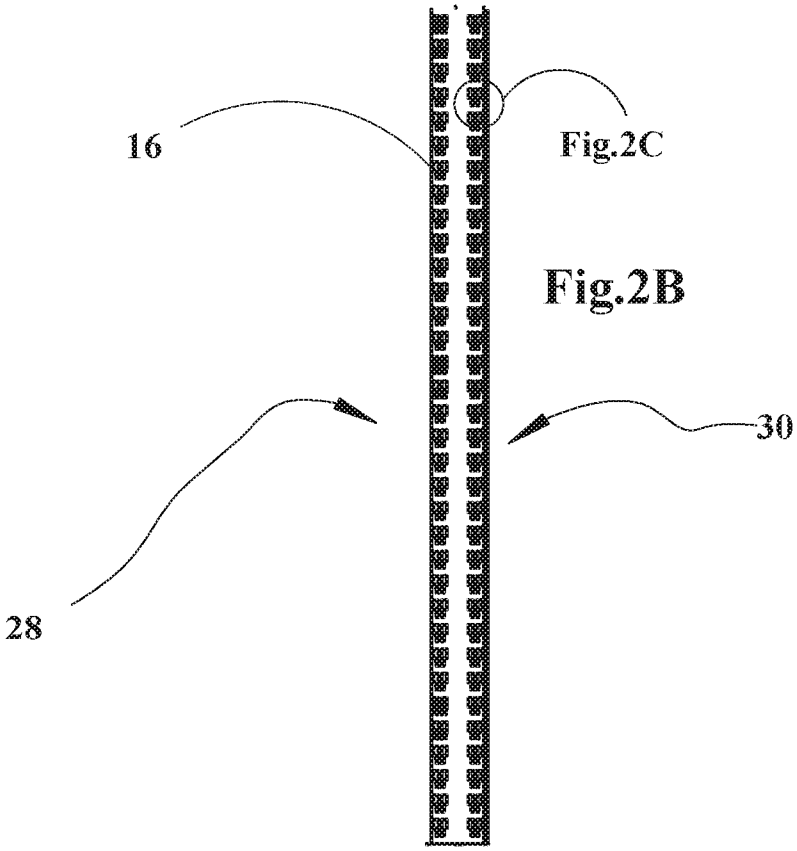


Fig.2B

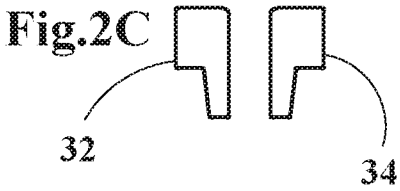


Fig.2C

Fig. 3A

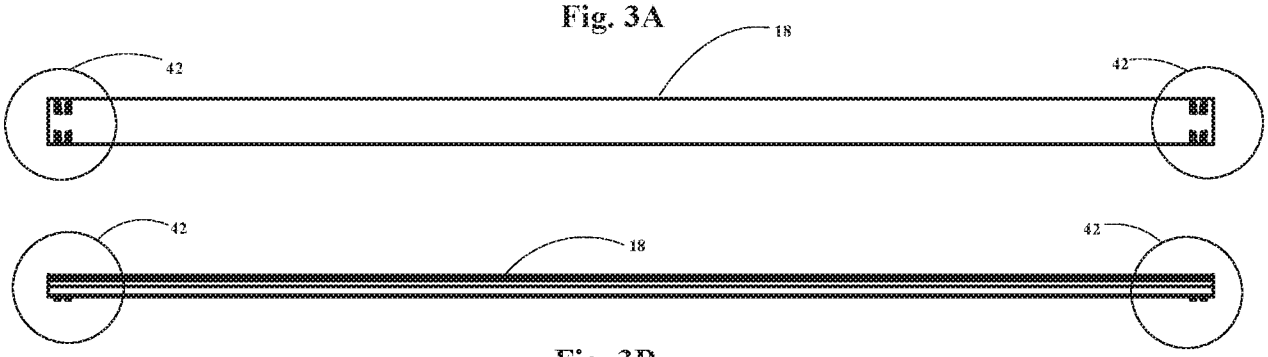


Fig. 3B

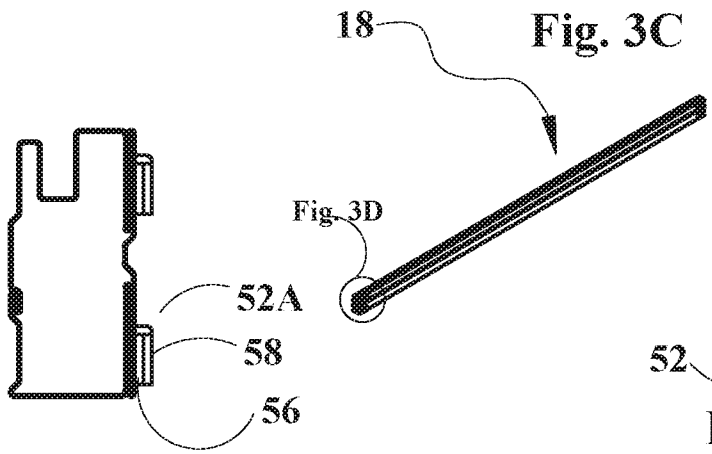


Fig. 3C

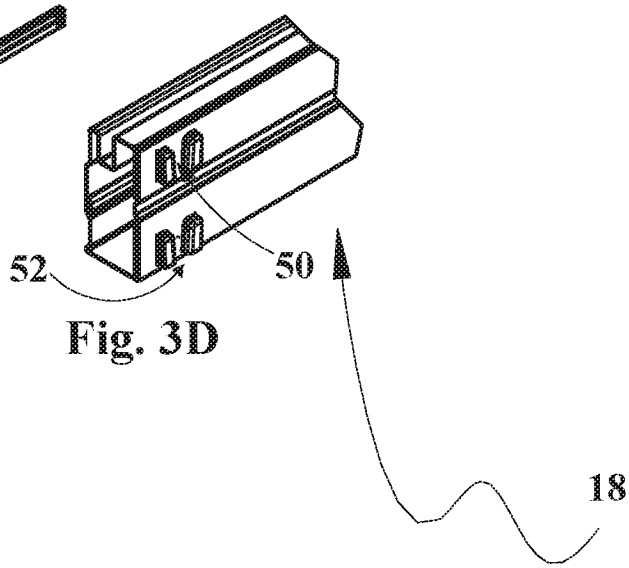


Fig. 3D

Fig. 3E

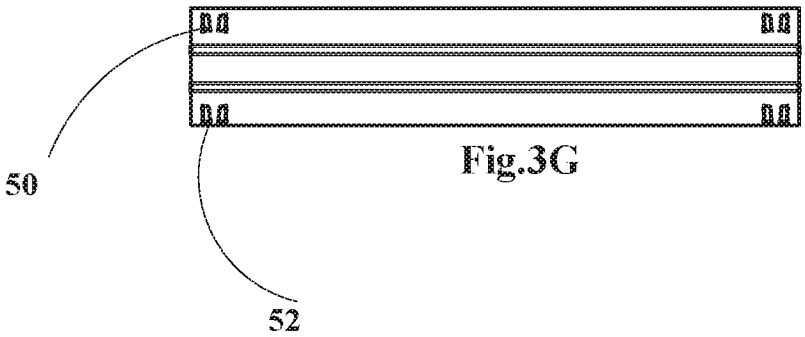


Fig.3G

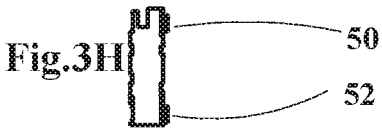


Fig.3H

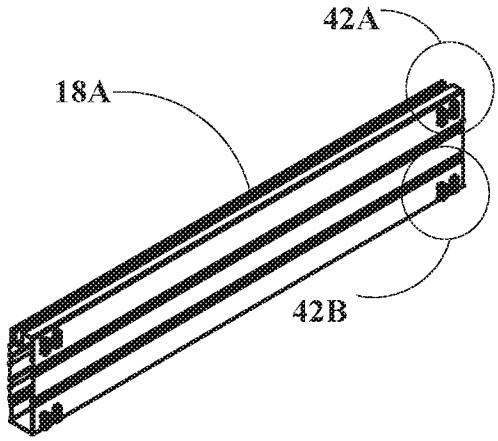


Fig.3F

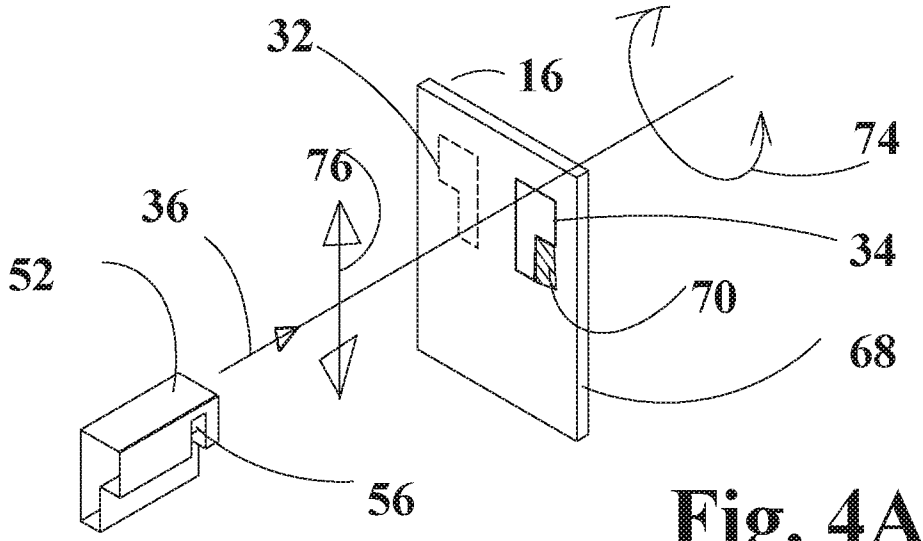


Fig. 4A

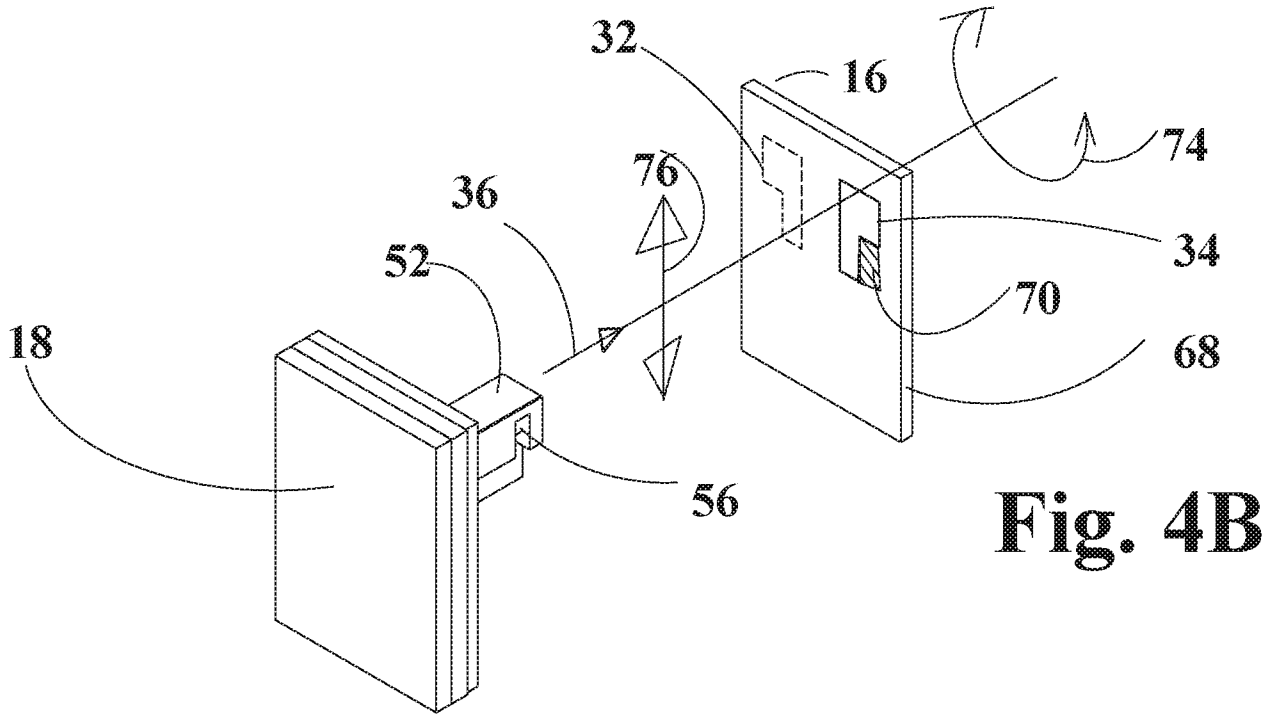


Fig. 4B

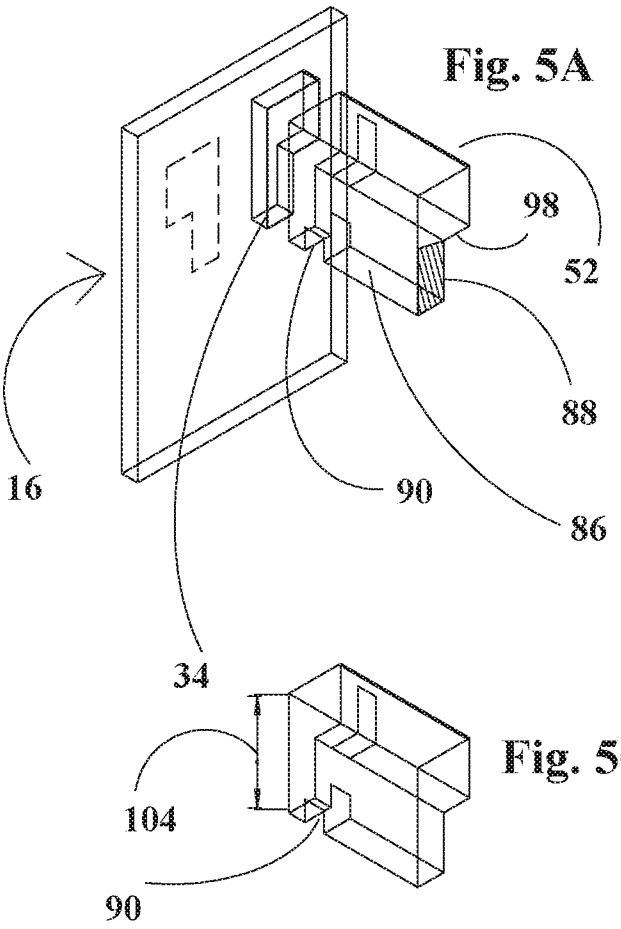


Fig. 5A

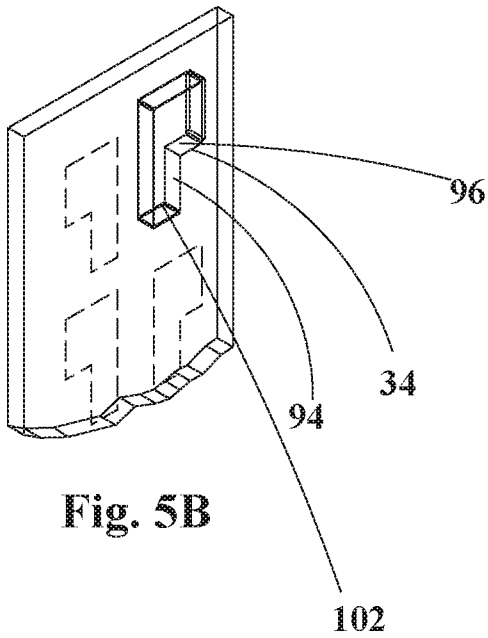


Fig. 5B

Fig. 5C

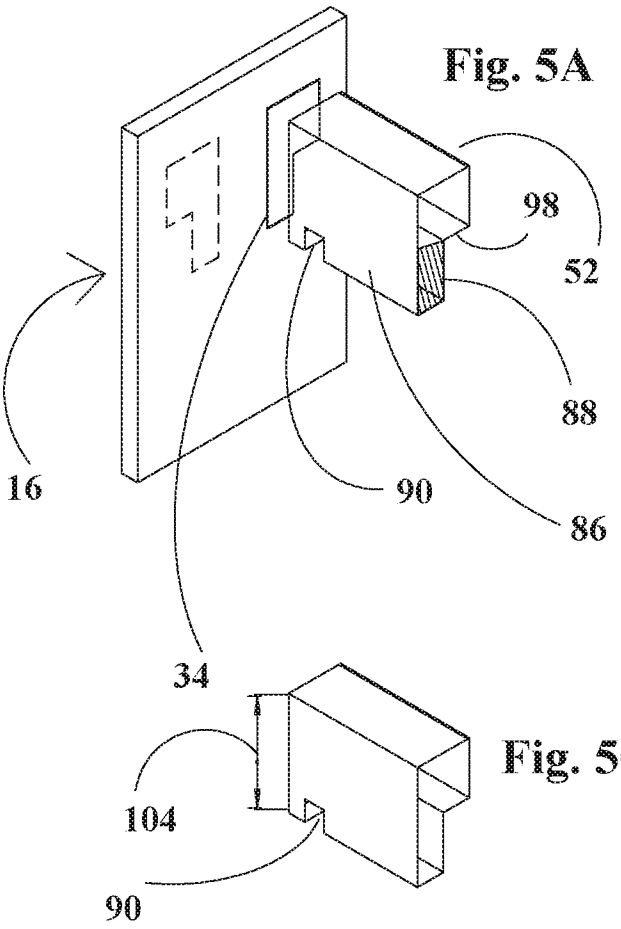


Fig. 5A

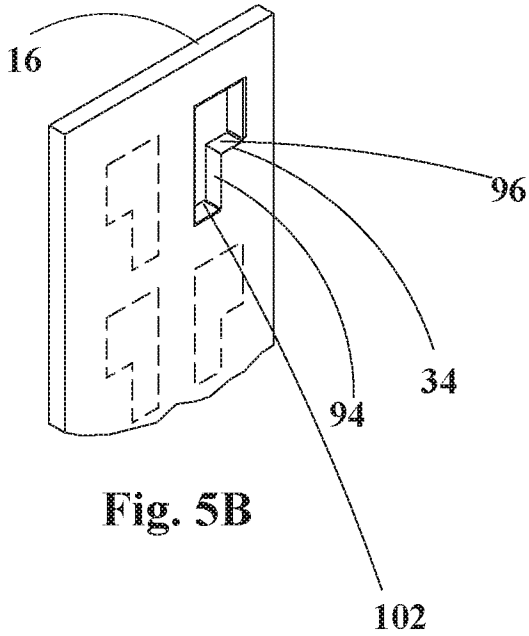


Fig. 5B

Fig. 5C

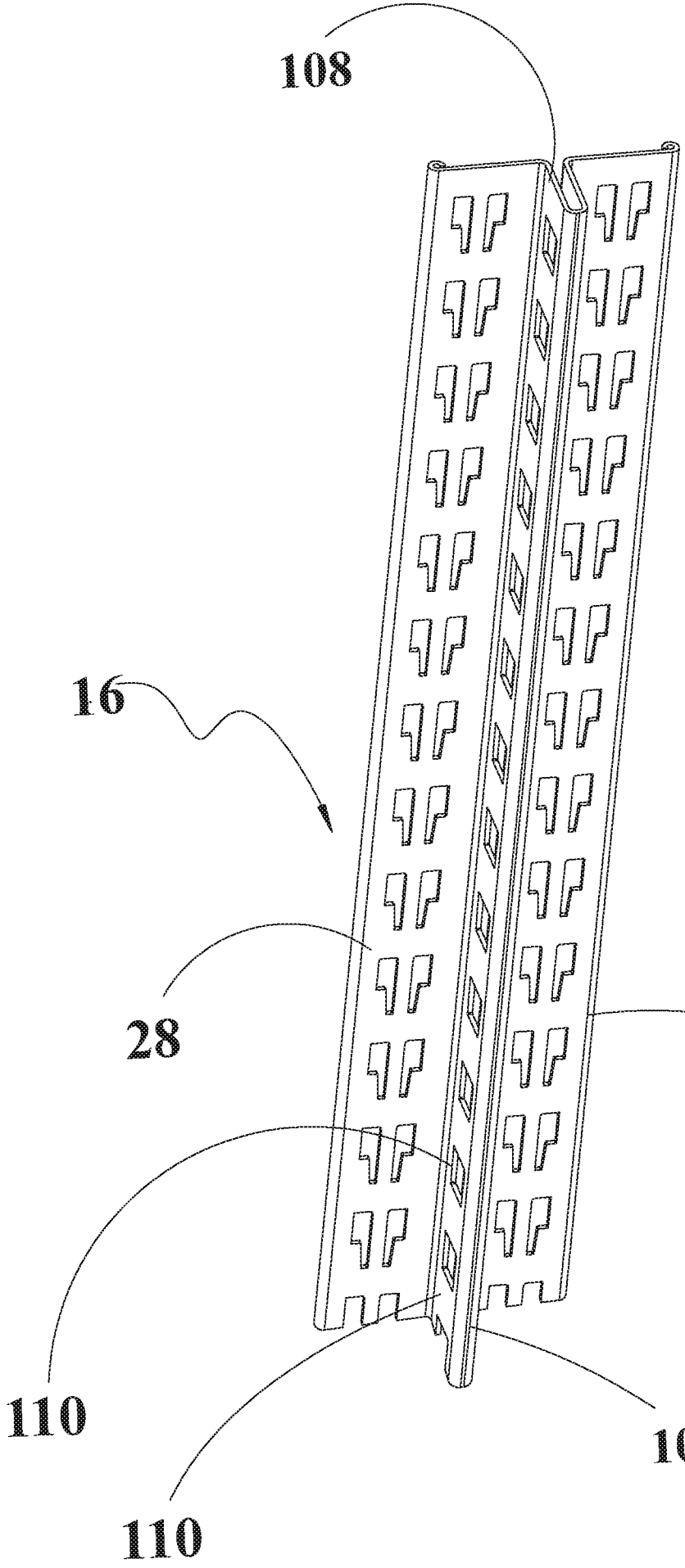


Fig. 6

Fig. 7A

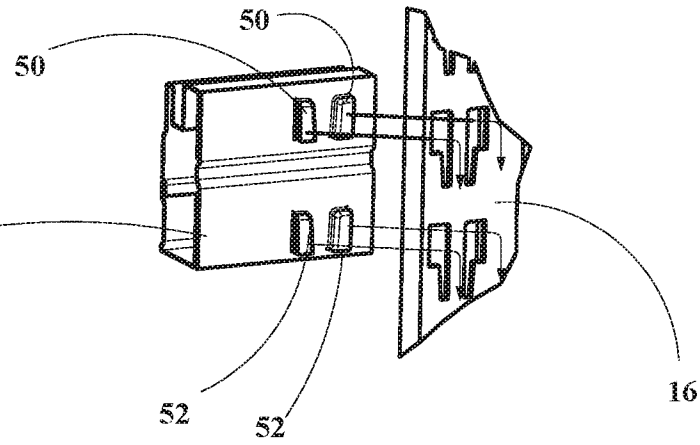


Fig. 7C

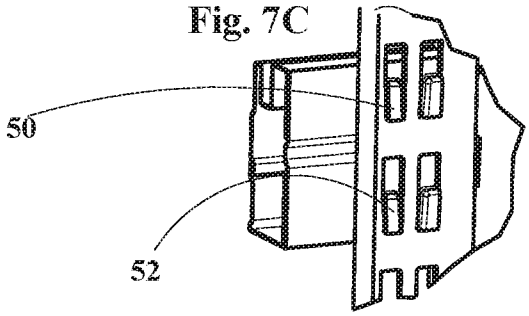
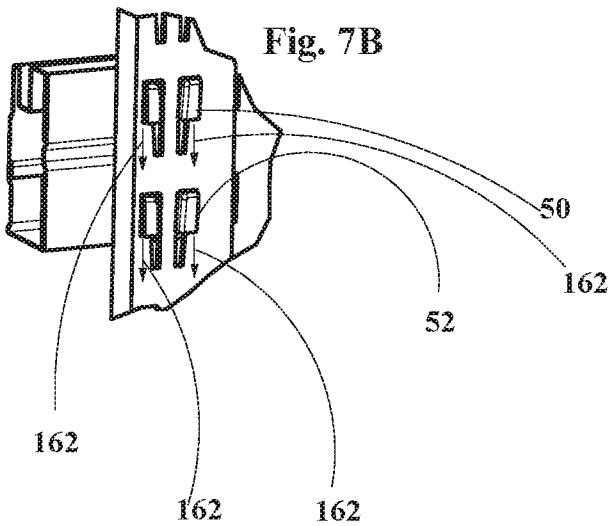


Fig. 7B



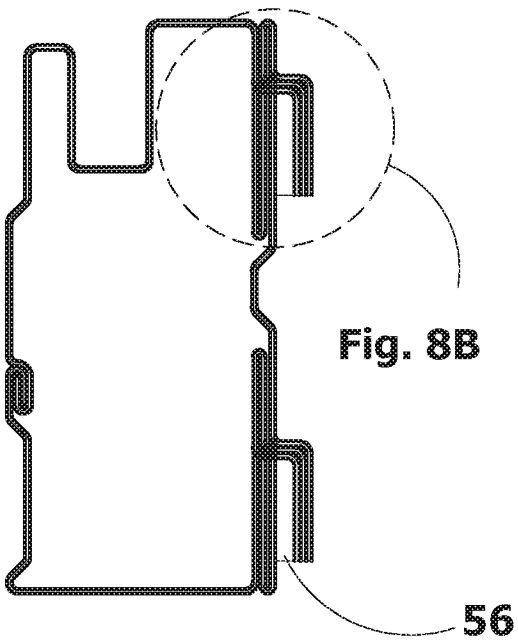


Fig. 8A

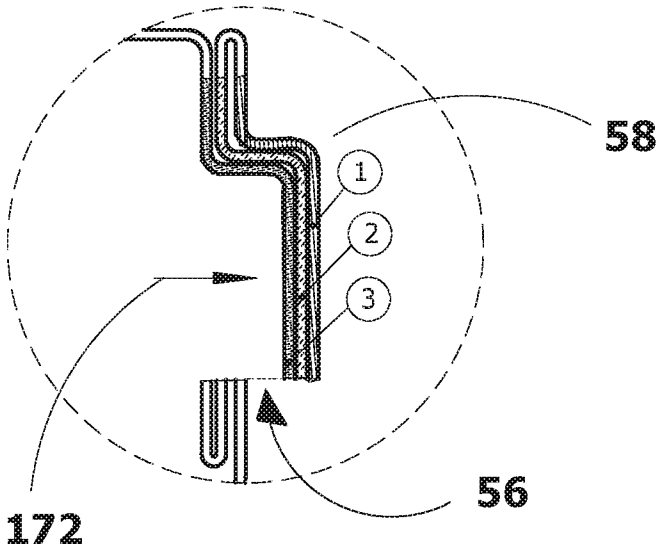


Fig. 8B

INTERNATIONAL SEARCH REPORT

International application No.
PCT/IL2018/050379

A. CLASSIFICATION OF SUBJECT MATTER
IPC (2018.01) A47B 57/40

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC (2018.01) A47B 57/40, A47F

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)
Databases consulted: THOMSON INNOVATION, Google Patents, DWPI
Search terms used: rack, shelves, posts, perforations, stiles, beams, fixation, uprights, pallet, columns, hook, clamp, structure.

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 5452812 A (SYCAMORE SYSTEMS INC.) 26 Sep 1995 (1995/09/26) Figs. 2, 5	1-5
Y	EP 0890330 A1 (GUILLAUMOND SA.) 13 Jan 1999 (1999/01/13) Fig. 2	1-5
Y	EP 0486895 A1 (SCHAEFER GMBH FRITZ) 27 May 1992 (1992/05/27) Figs. 1, 10	4,5
Y	US 4064996 A (SHILLUM ROBERT L.) 27 Dec 1977 (1977/12/27) Fig. 2	4,5
A	FR 2889654 A1 (DUWIC SOC PAR ACTIONS SIMPLIFI) 16 Feb 2007 (2007/02/16) Whole document	1-5

[X] Further documents are listed in the continuation of Box C. [X] See patent family annex.

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"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	Date of mailing of the international search report
19 Jul 2018	22 Jul 2018
Name and mailing address of the ISA: Israel Patent Office Technology Park, Bldg.5, Malcha, Jerusalem, 9695101, Israel Facsimile No. 972-2-5651616	Authorized officer AGMAIL Waleed Ibrahim Ramadan Telephone No. 972-2-5651626

INTERNATIONAL SEARCH REPORT

International application No.
PCT/IL2018/050379

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

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A	US 3565264 A (REPUBLIC STEEL CORP.) 23 Feb 1971 (1971/02/23) Whole document	1-5
A	US D683983 S (TROYNER ANTHONY J. et. al.) 11 Jun 2013 (2013/06/11) Whole document	1-5

INTERNATIONAL SEARCH REPORT
Information on patent family members

International application No.
PCT/IL2018/050379

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