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(72) Inventor: **Grogan, Peter Alexander**
Bucklands Beach, Auckland (NZ)

(74) Representative: **Brown, John David**
FORRESTER & BOEHMERT
Pettenkoferstrasse 20-22
80336 München (DE)

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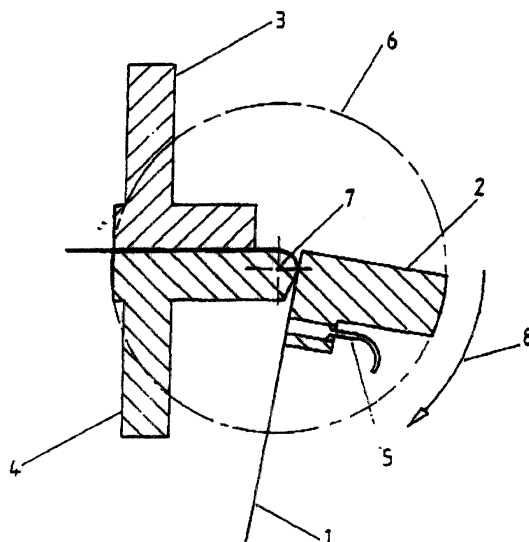
(71) Applicant: **FISHER & PAYKEL LIMITED**
Auckland (NZ)

(54) **Sheet metal folder, controller and method**

(57) A sheet metal folder includes a movable fold bar, an actuator to move the movable fold bar and a sheet position monitor which monitors the position of the folded portion of a sheet being folded. During folding, a controller moves the fold bar to a first fold position and retreats the fold bar to a position in which the sheet is no longer contacted by the fold bar. The current position of the sheet is then registered. A second fold position is

calculated using the difference between the first fold position of the fold bar and the registered position. The fold bar is then moved to the second fold position. The sheet position monitor may involve a detector detecting the presence of a folded part of the sheet against the fold bar, with the current position of the sheet after the fold bar is retreated being registered by registering the position of the fold bar immediately the sheet no longer resides against the fold bar.

FIG. 2



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EUROPEAN SEARCH REPORT

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The present search report has been drawn up for all claims			
Place of search MUNICH		Date of completion of the search 11 September 2001	Examiner Ash, R
CATEGORY OF CITED DOCUMENTS 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 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 & : member of the same patent family, corresponding document			

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**ANNEX TO THE EUROPEAN SEARCH REPORT
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