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**Shefet et al.**

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(45) **Date of Patent:** **Mar. 22, 2005**

(54) **REPETITIVE HIGH-DENSITY PACKING MECHANISMS FOR ARRANGING SUSPENDED LENGTHS OF ELONGATED ITEMS IN A DESIRED ORIENTATION AND ASSOCIATED METHODS**

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(51) **Int. Cl.<sup>7</sup>** ..... **A22C 11/02**

(52) **U.S. Cl.** ..... **452/183**

(58) **Field of Search** ..... 452/31, 32, 51, 452/35, 47, 187, 185, 183

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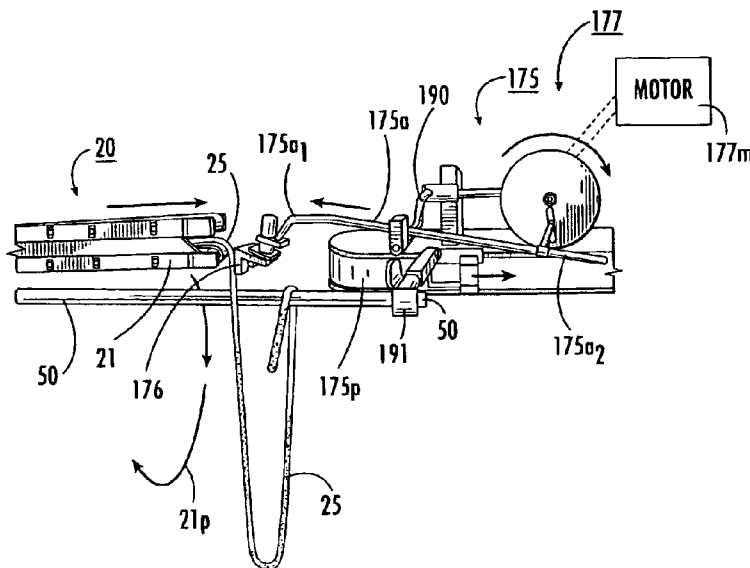
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**ABSTRACT**

Methods and devices for loading carrier members with suspended elongated product include straddling suspended elongated product over a carrier member having a width so that portions of the elongated product are serially draped over the carrier member along a desired length thereof and wiping, pushing, or pulling adjacent segments closer together to increase the amount or density of the product on the carrier member. The straddling is carried out so that the draped elongated product defines suspension regions that contact the carrier member intermediate lengths of the elongated product that hang from opposing sides of the carrier member. At least one of the suspended regions on the carrier member is moved in a predetermined direction at a first time then another one of the at least one of the suspended regions on the carrier member is moved in the predetermined direction at a second time. The straddled elongated product is thus arranged so that serially consecutive suspension regions are more closely positioned together on the carrier member based on the first and second moving steps.

**35 Claims, 20 Drawing Sheets**



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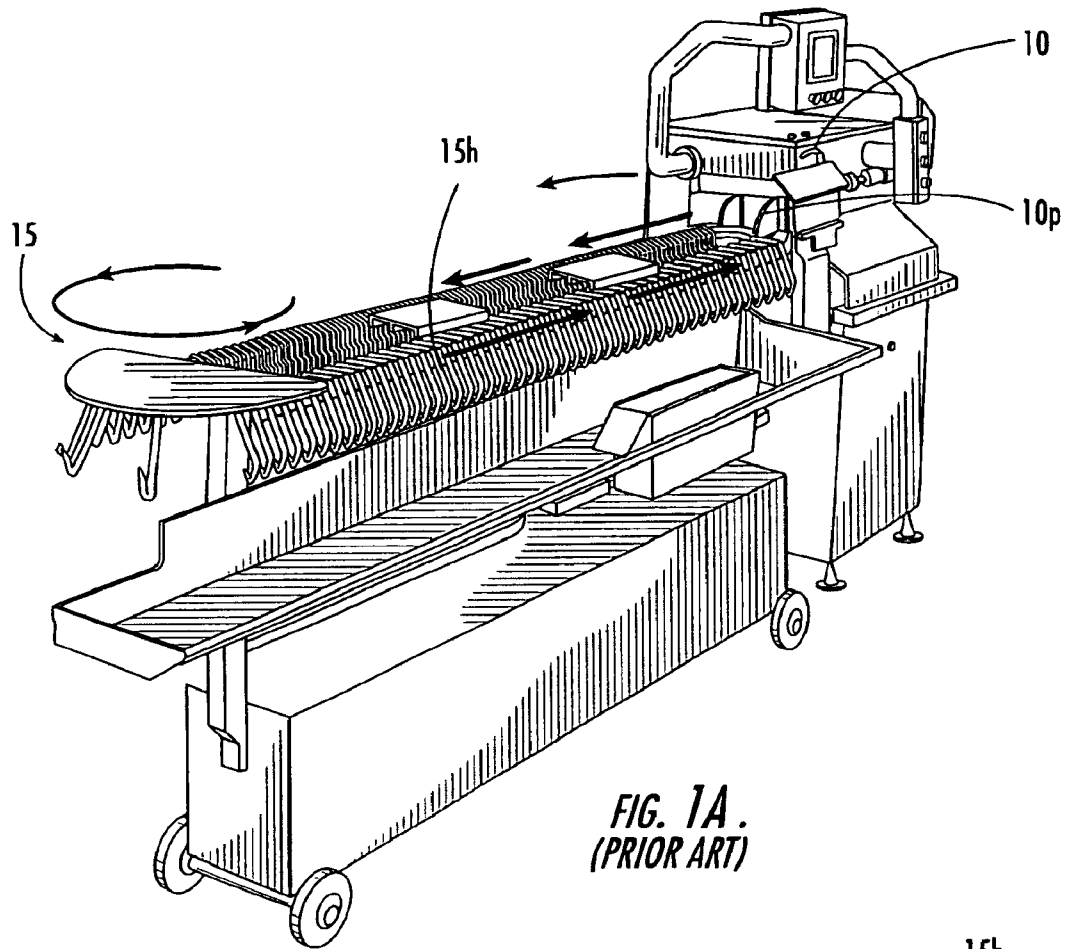
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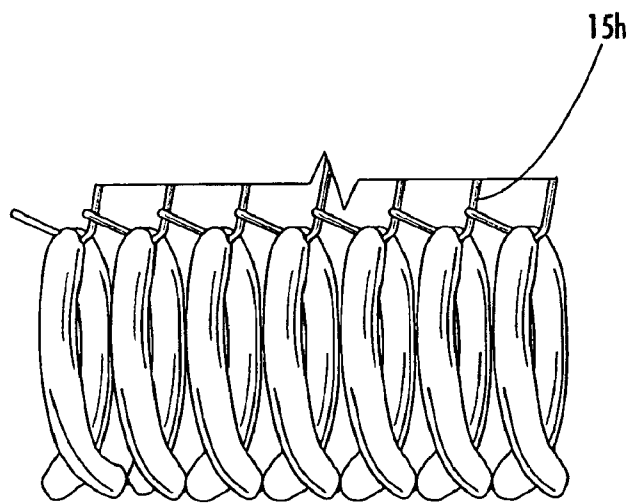
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Pictures of the inside of a conventional prior art oven from Alkar.

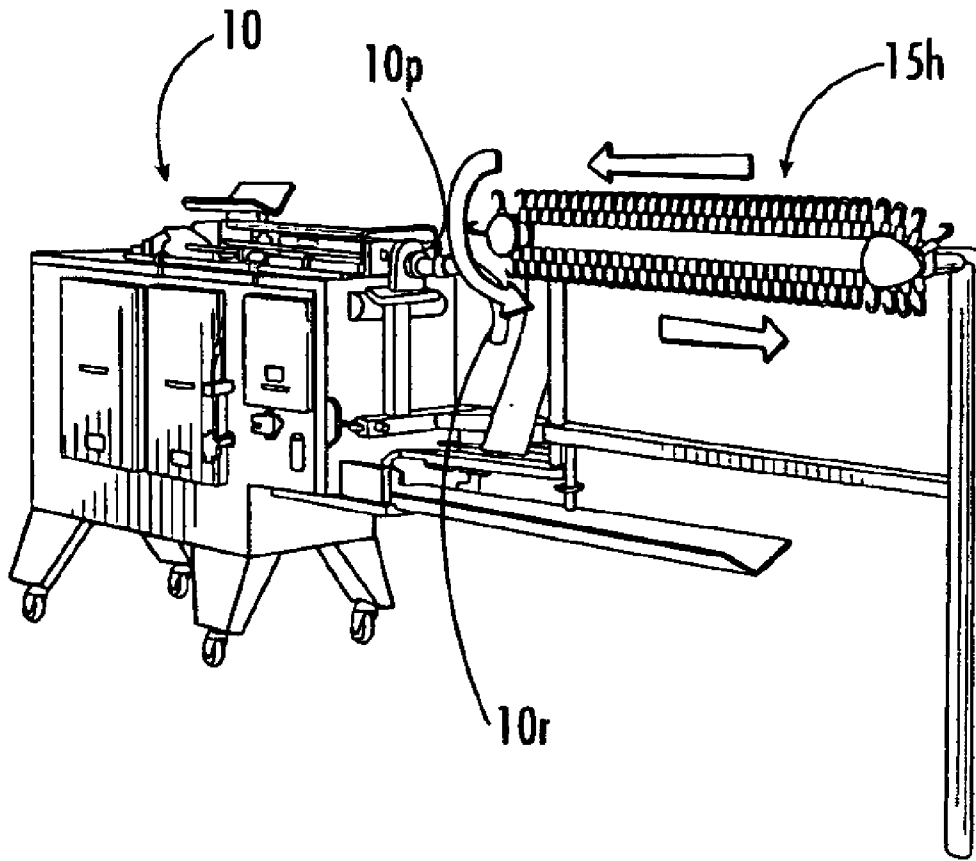
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**FIG. 1A.**  
**(PRIOR ART)**



**FIG. 1B.**  
**(PRIOR ART)**



**FIG. 1C.**  
**(PRIOR ART)**

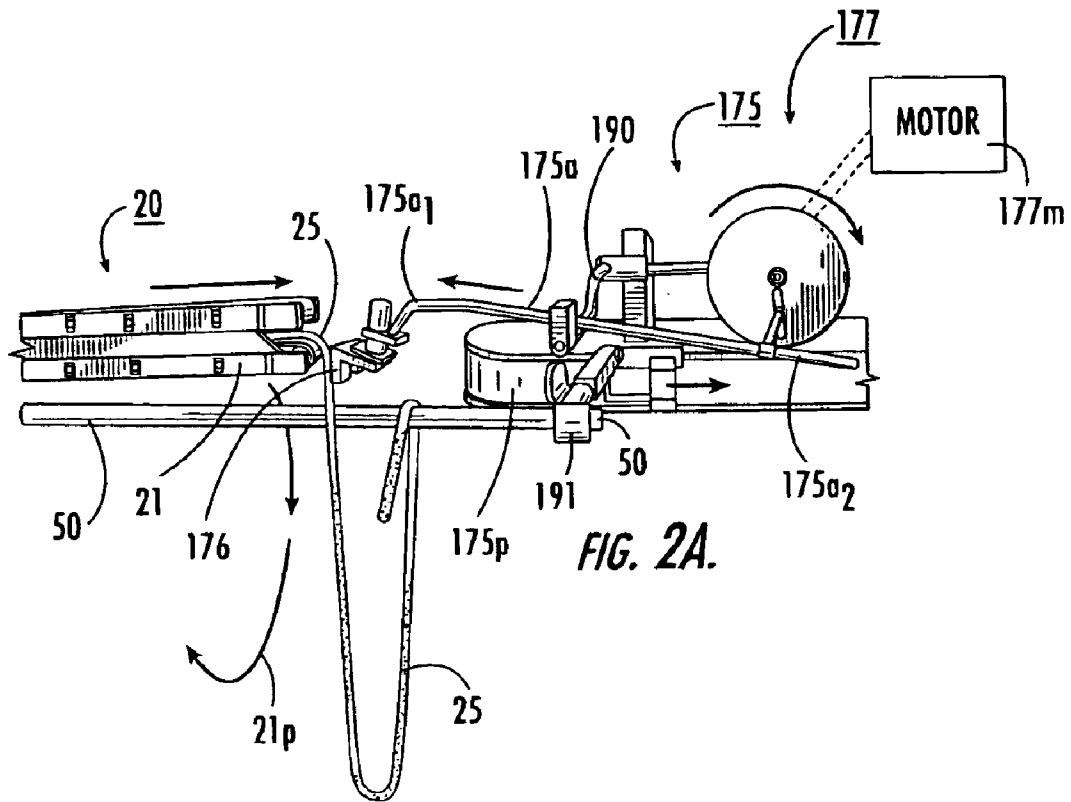


FIG. 2A.

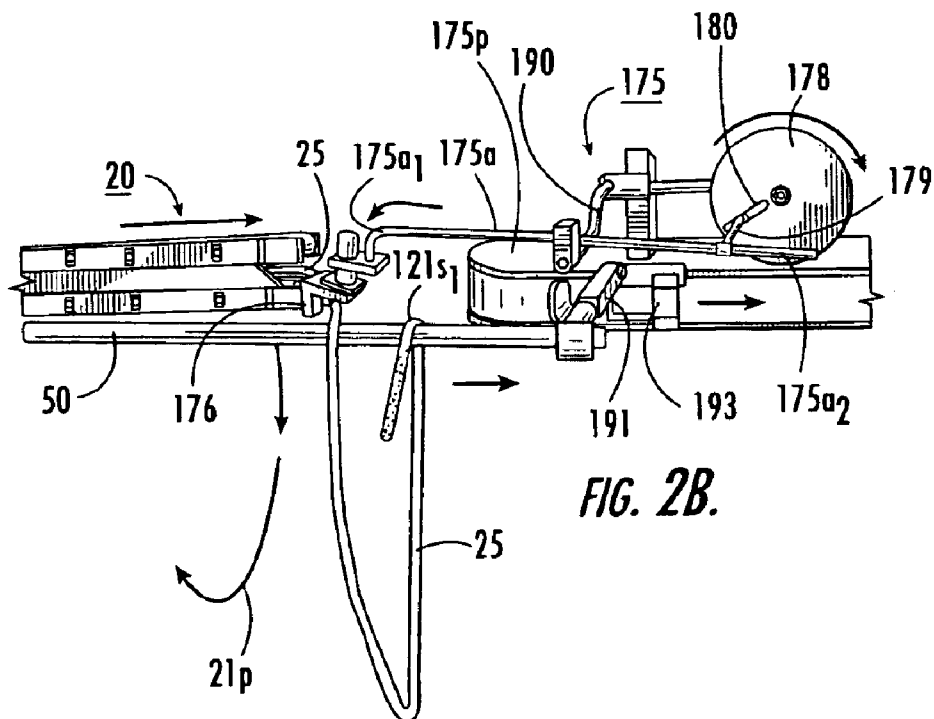
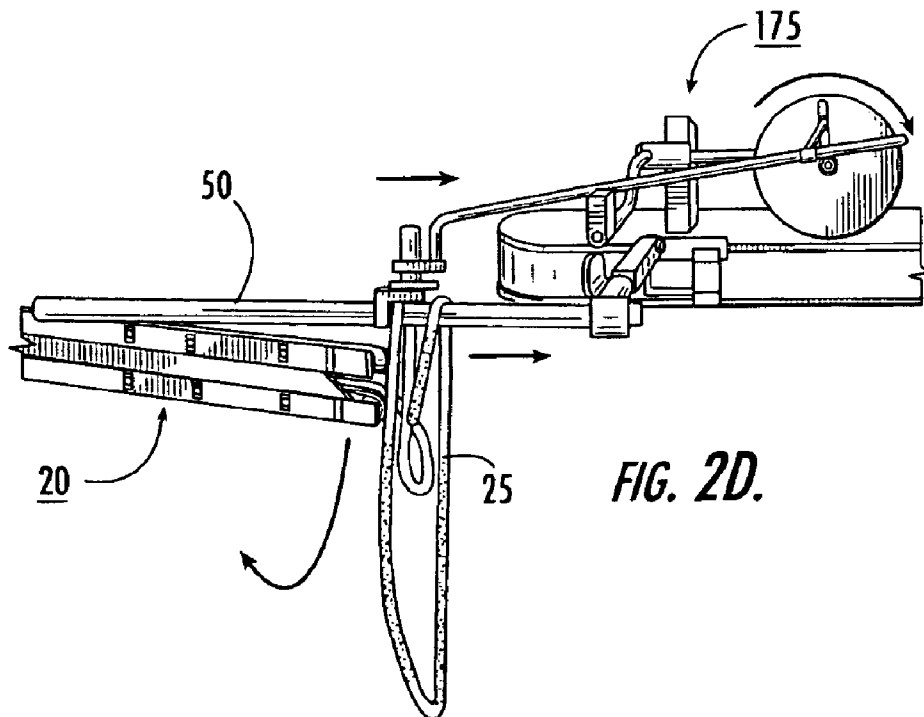
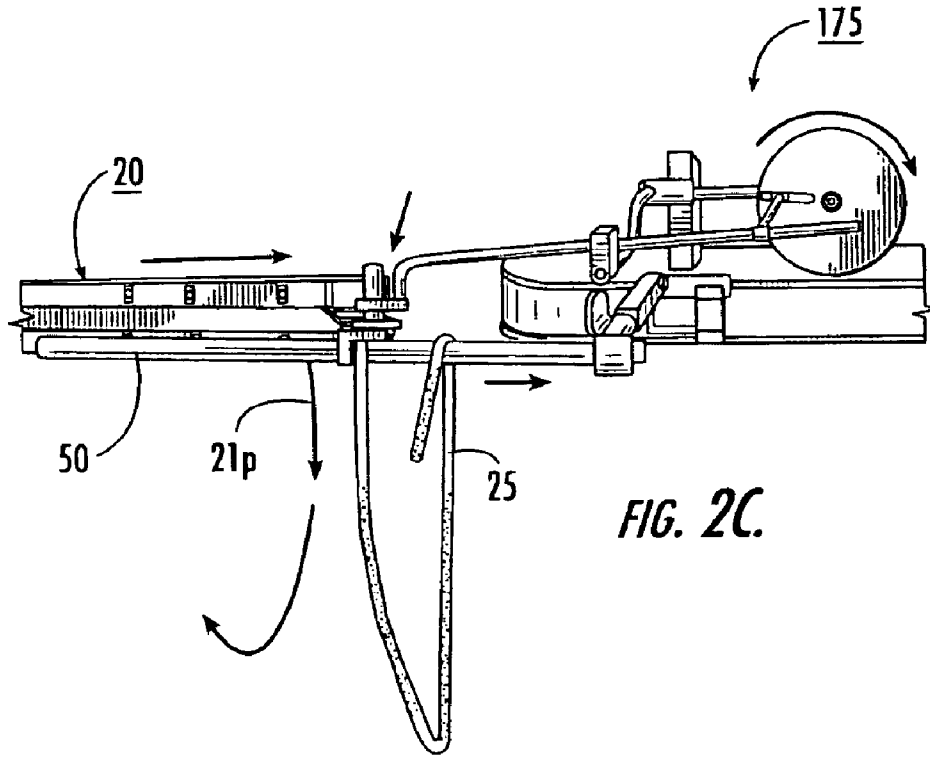


FIG. 2B.



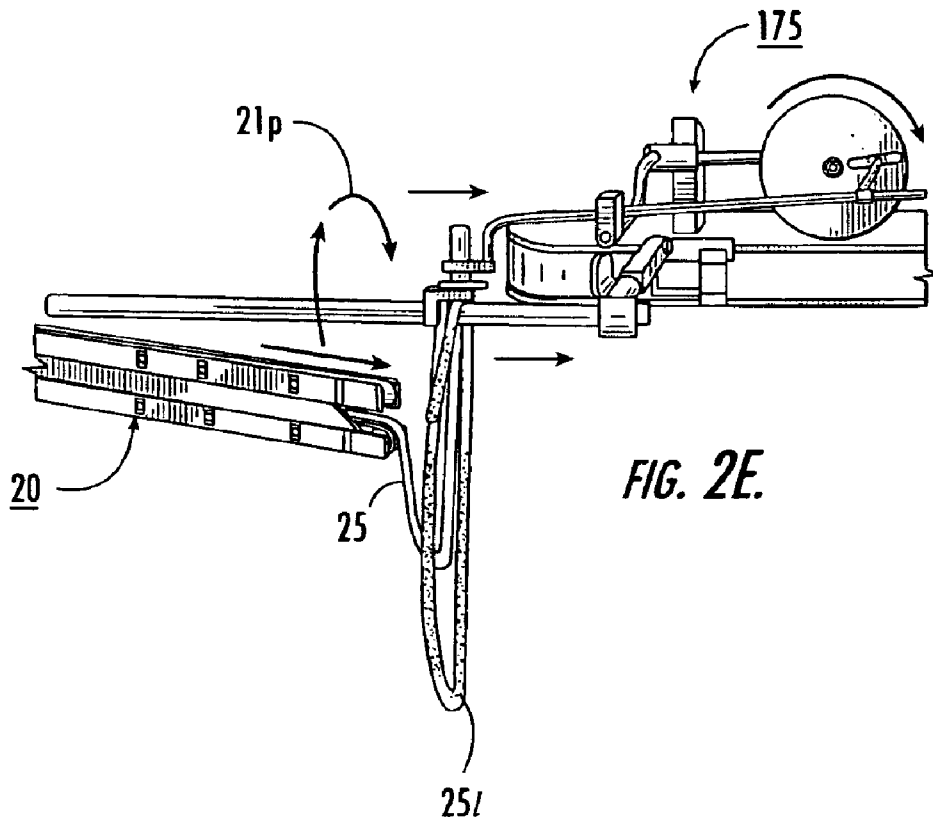


FIG. 2E.

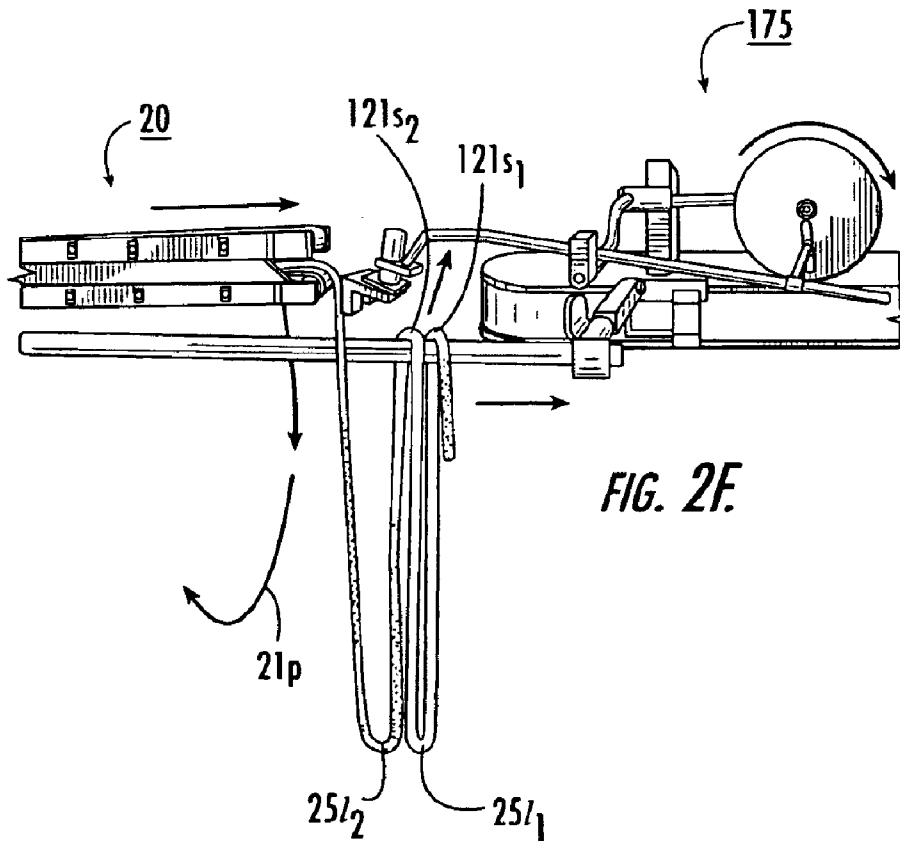


FIG. 2F.

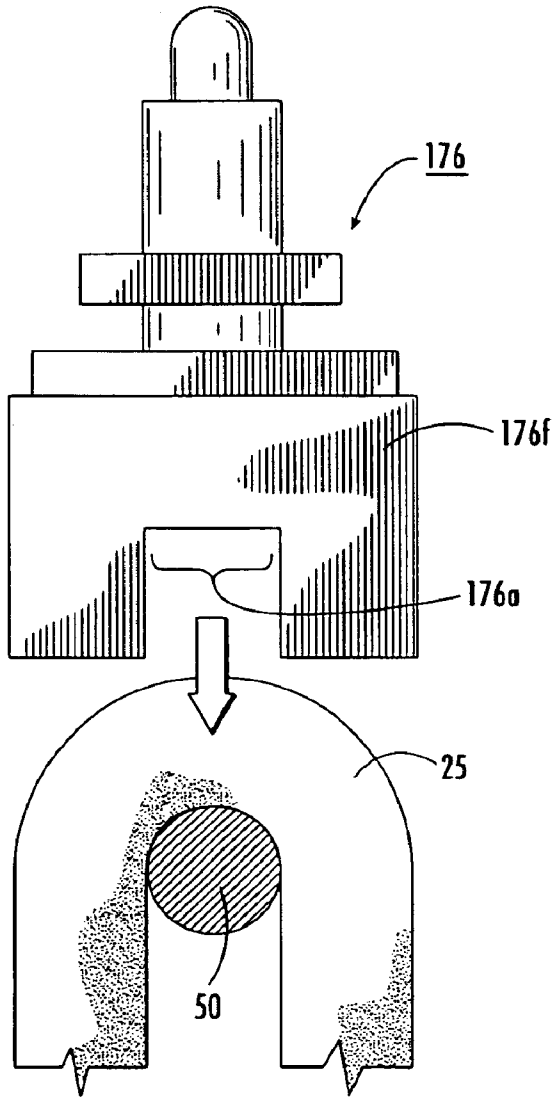


FIG. 3A.

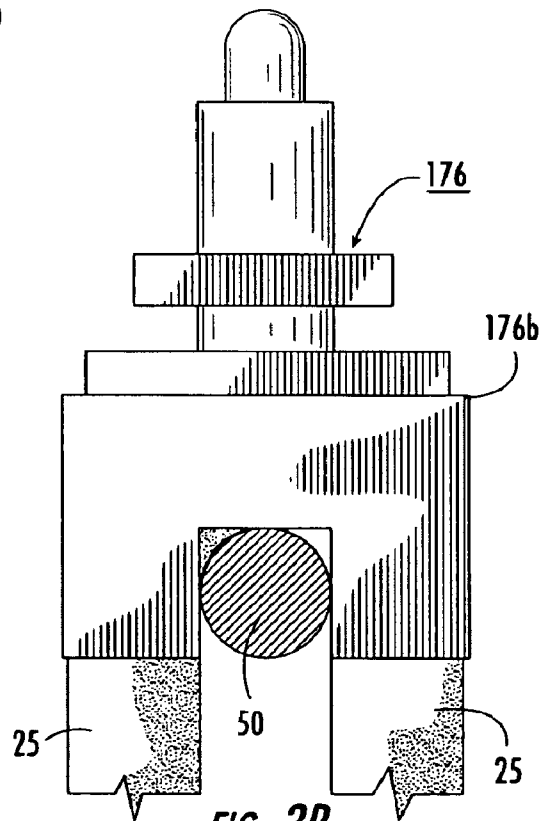
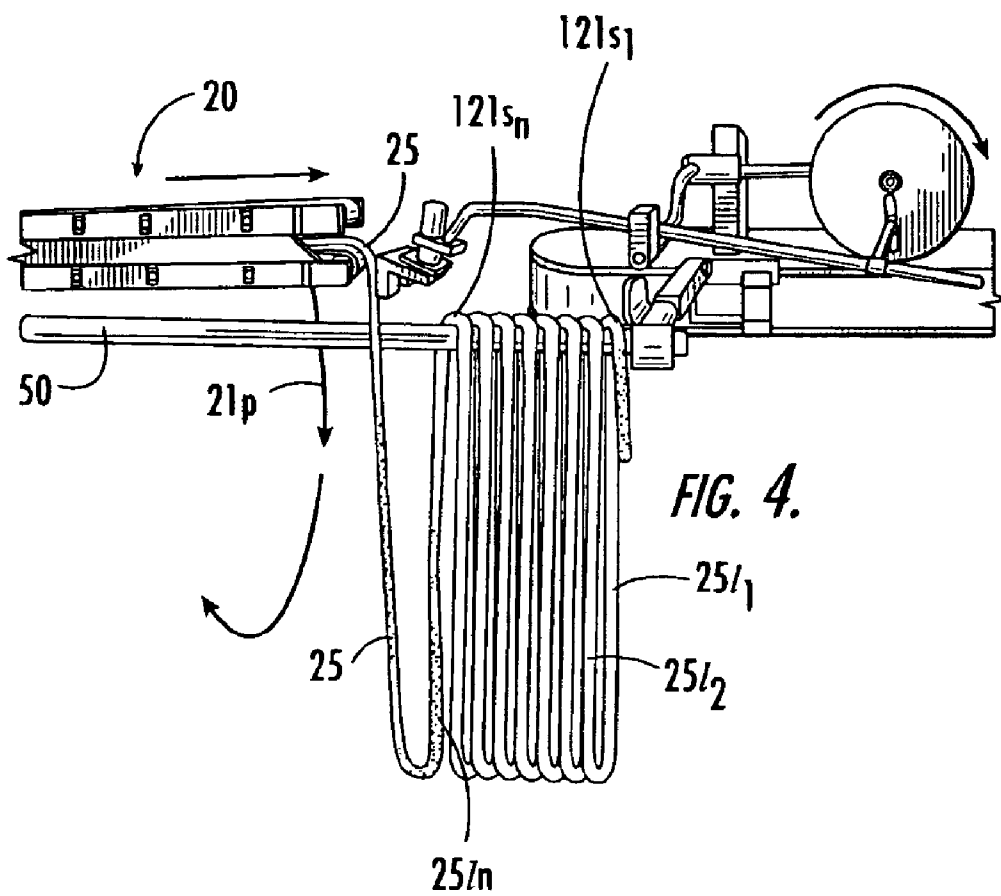


FIG. 3B.





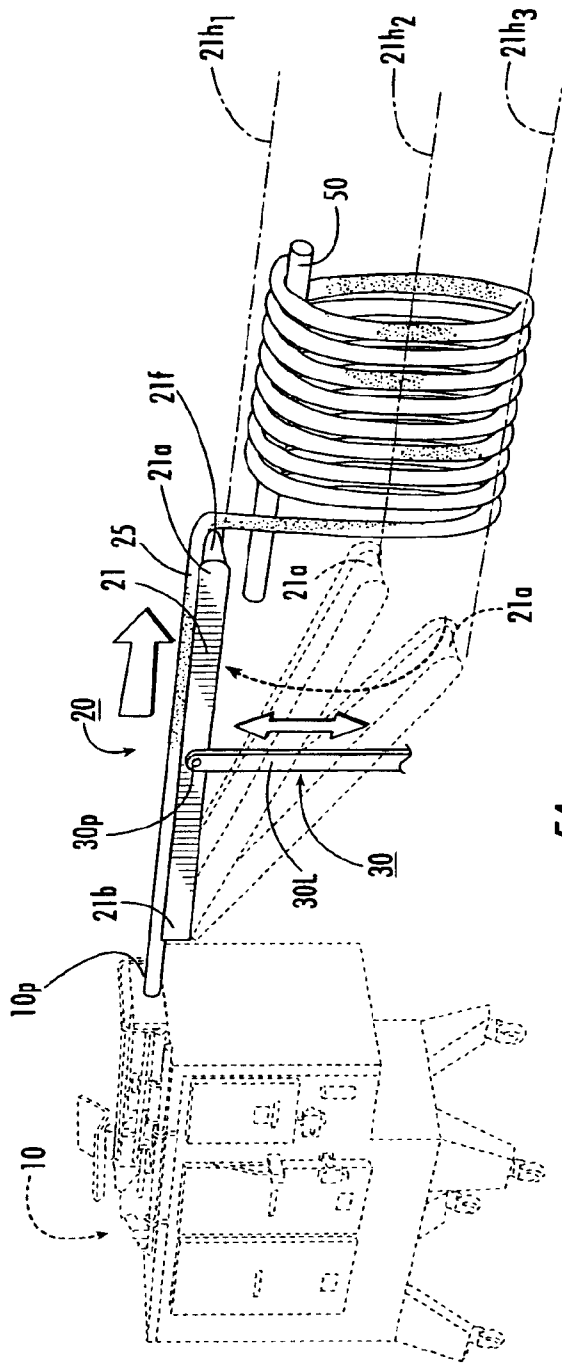


FIG. 5A.

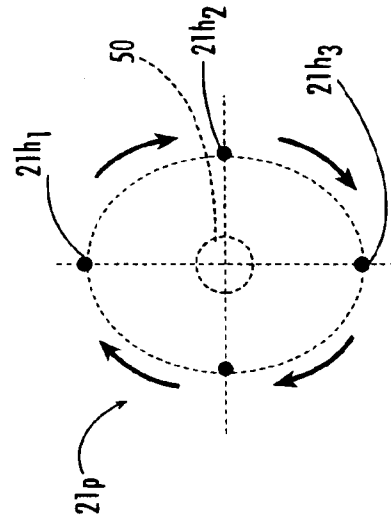
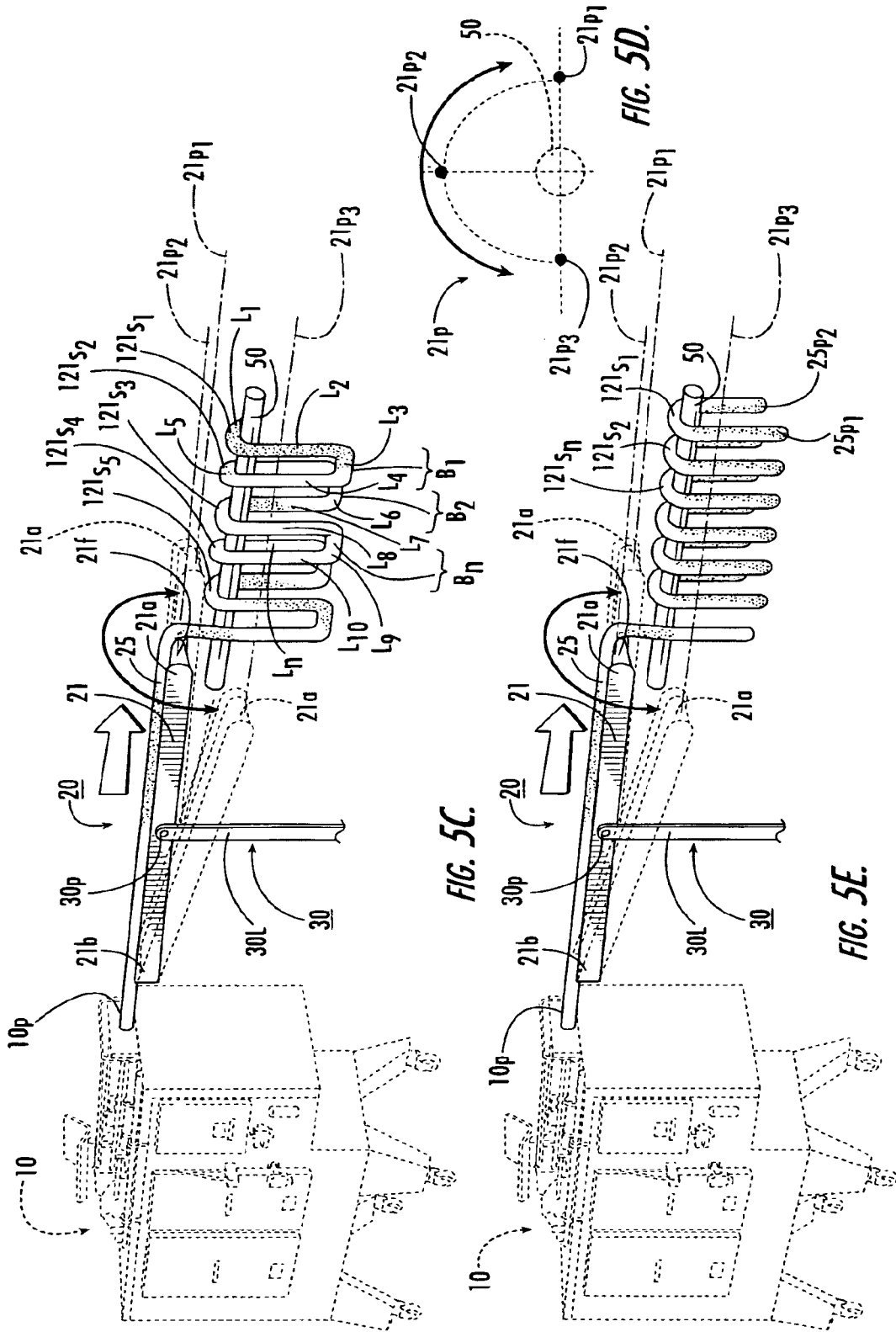


FIG. 5B.



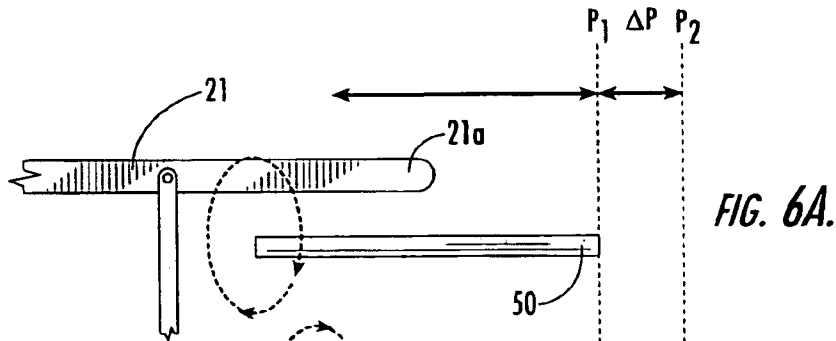


FIG. 6A.

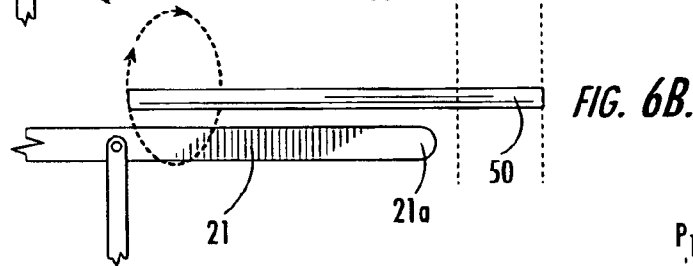


FIG. 6B.

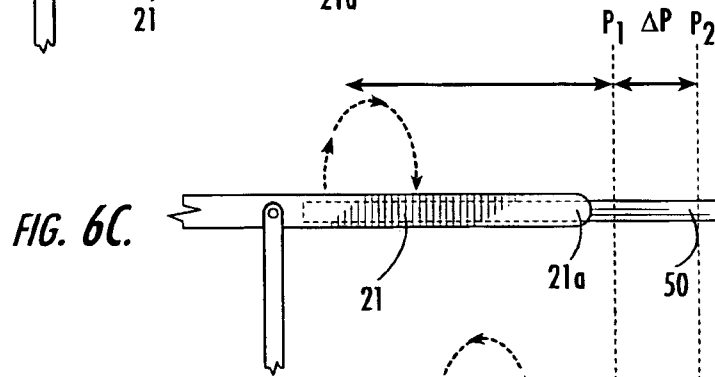


FIG. 6C.

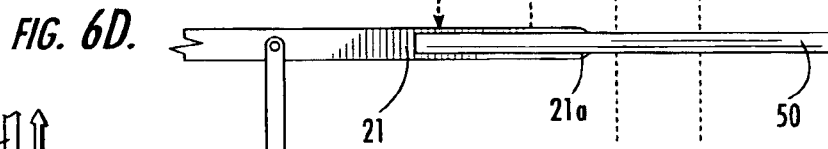


FIG. 6D.

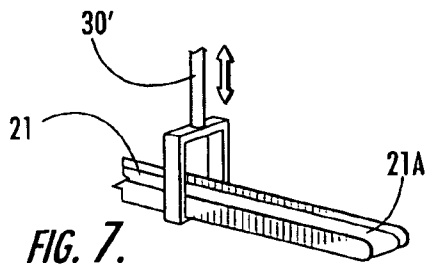


FIG. 7.

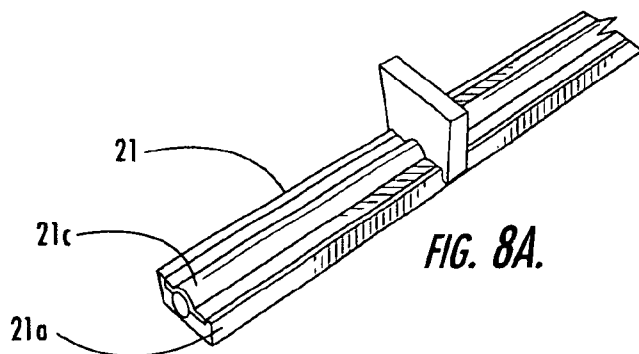


FIG. 8A.

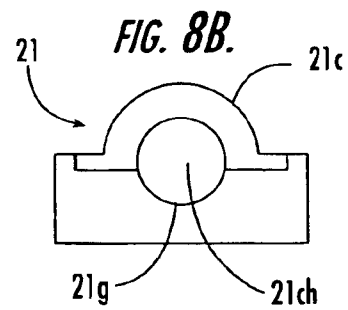


FIG. 8B.

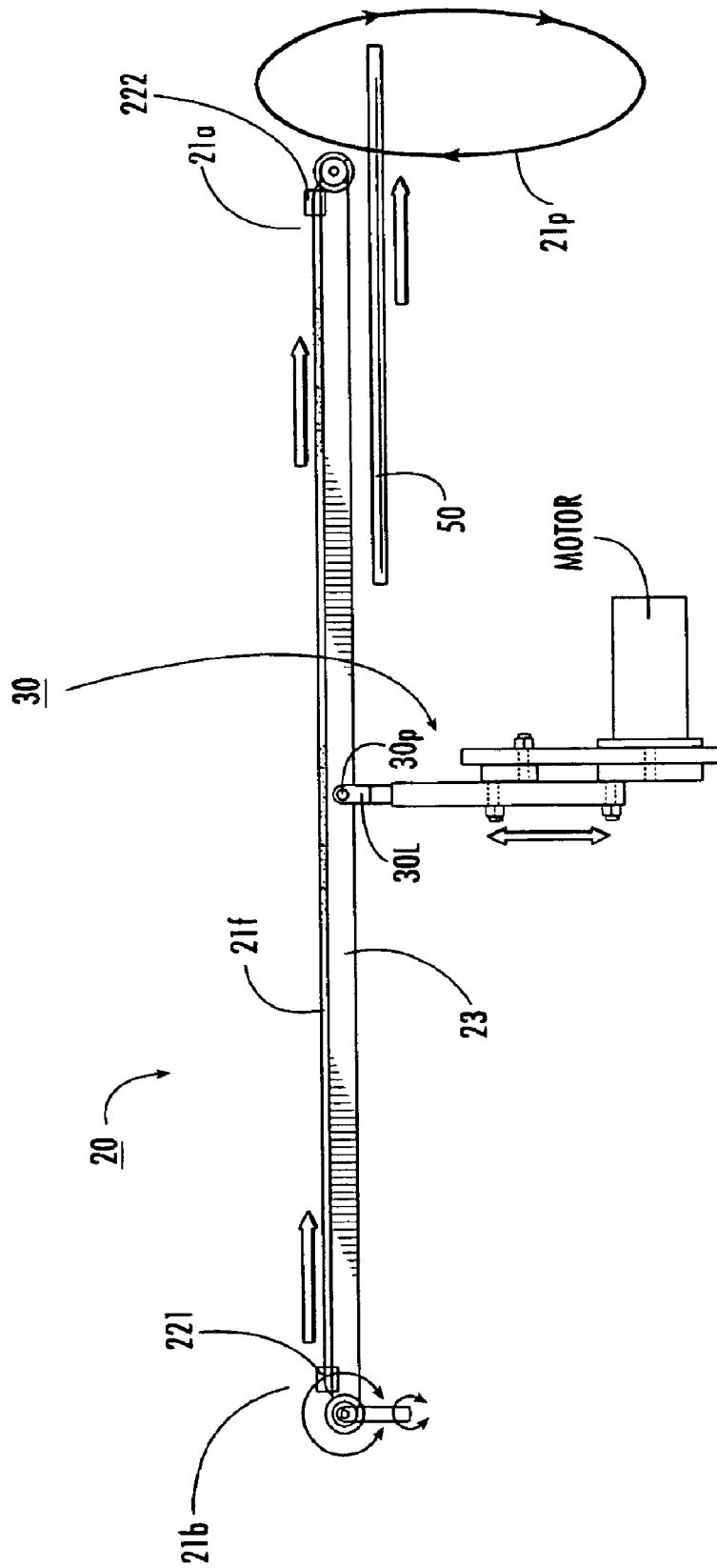
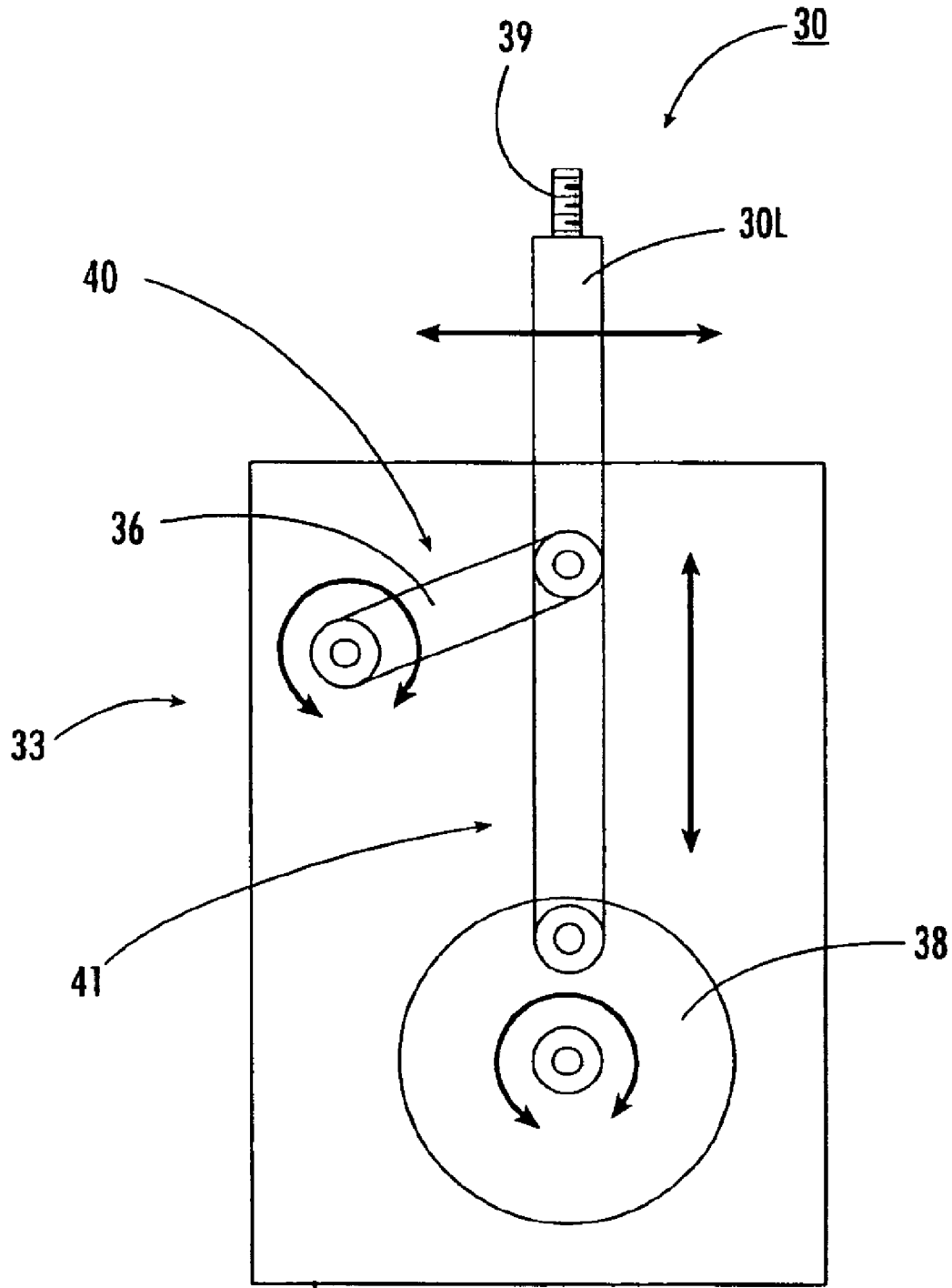
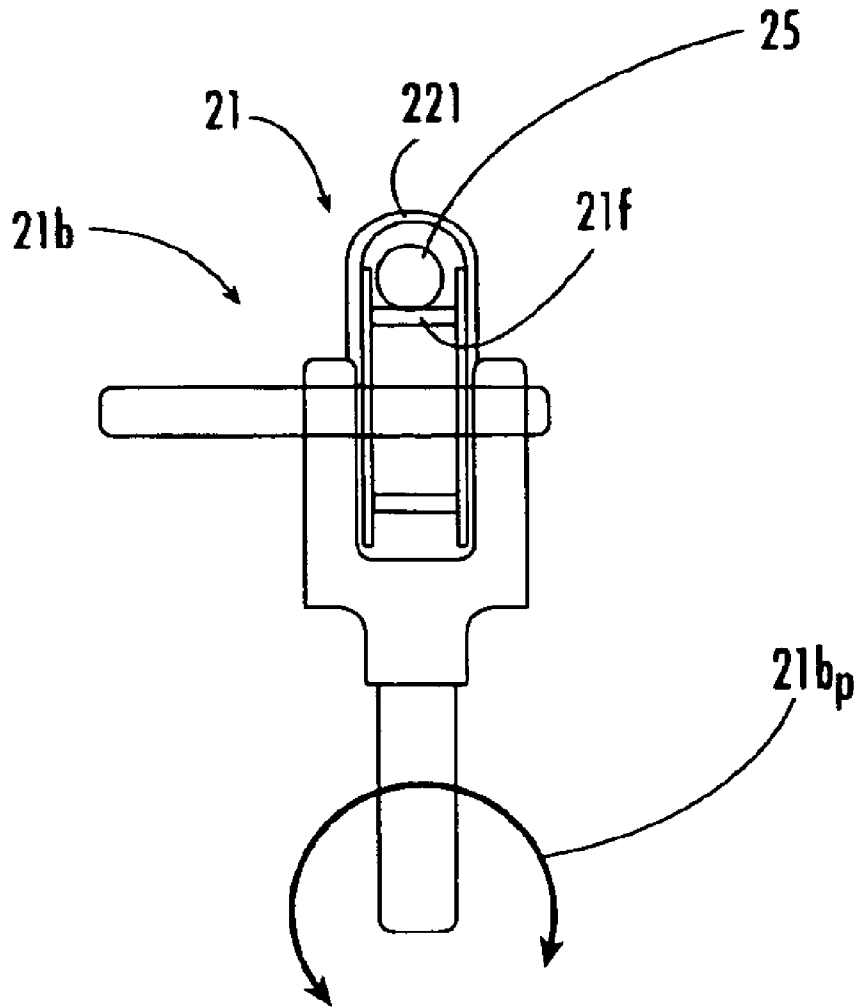


FIG. 9.



34 **FIG. 10.**



**FIG. 11.**

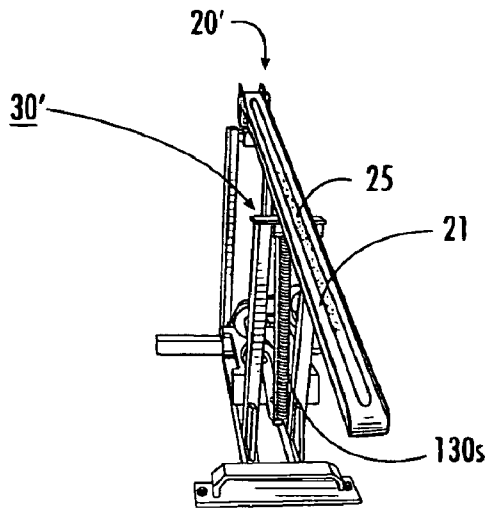


FIG. 12A.

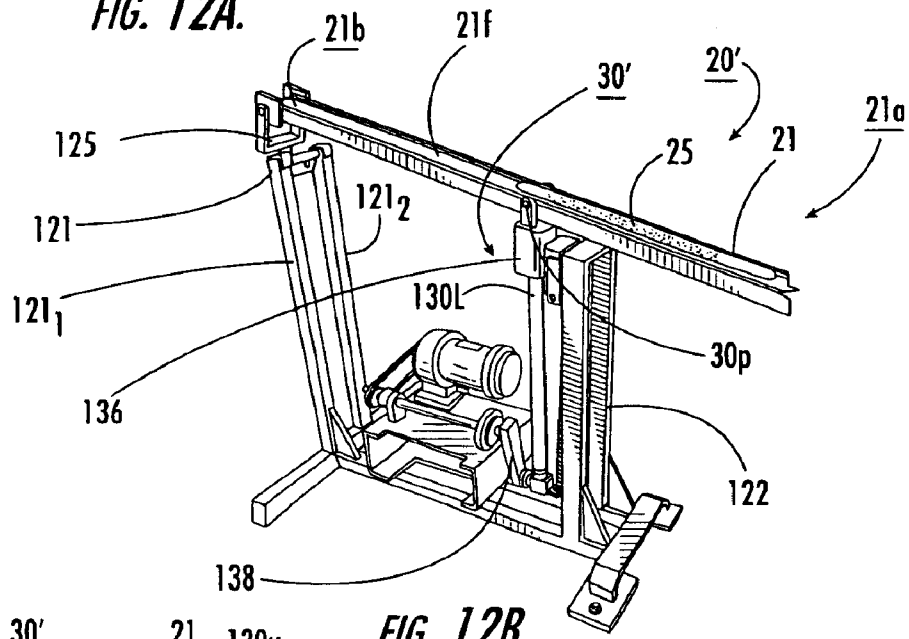


FIG. 12B.

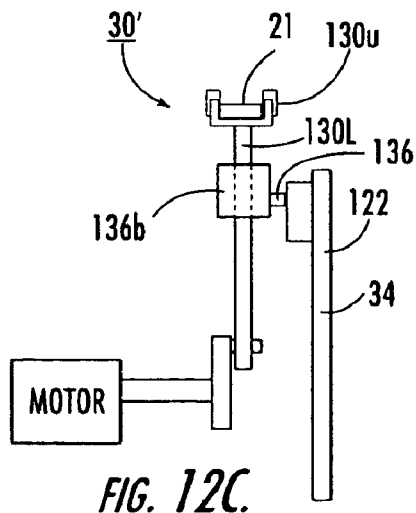


FIG. 12C.



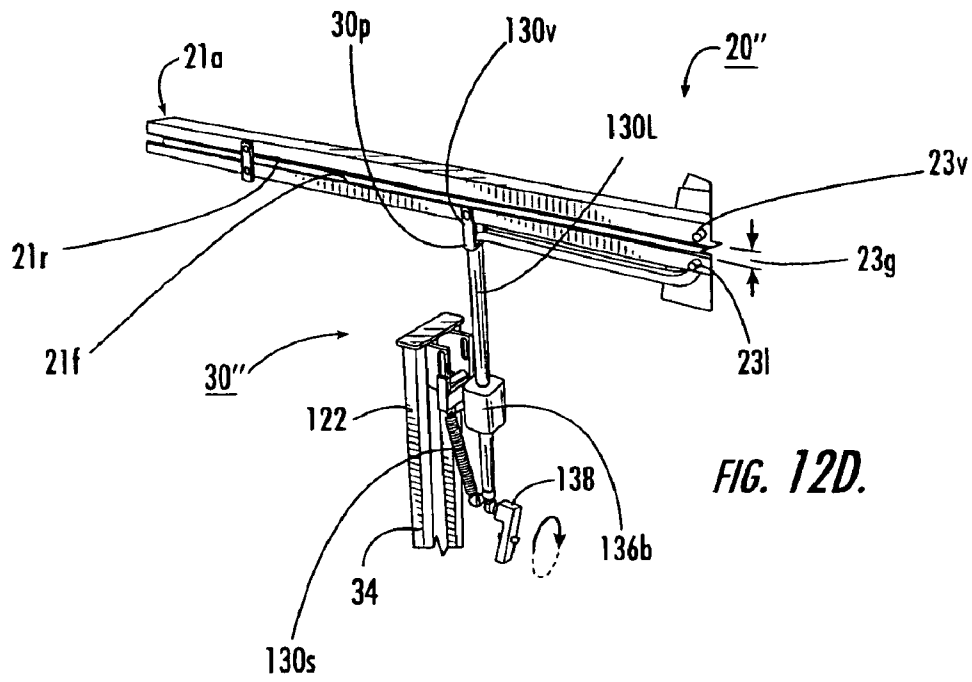


FIG. 12D.

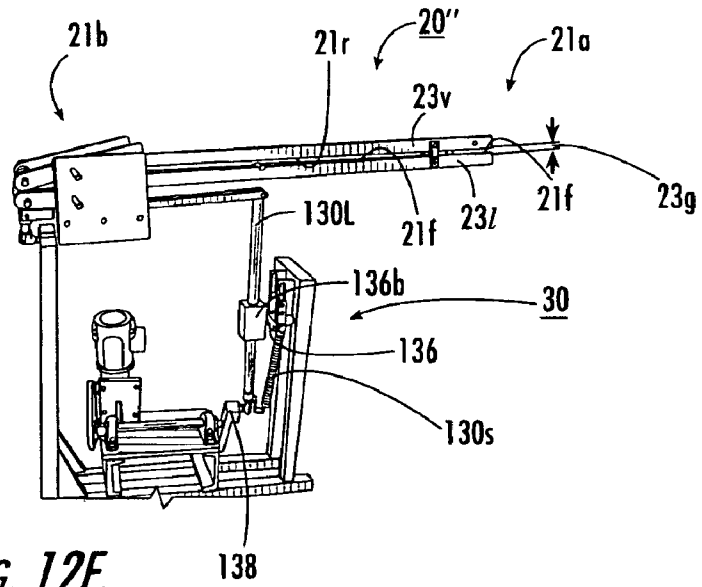
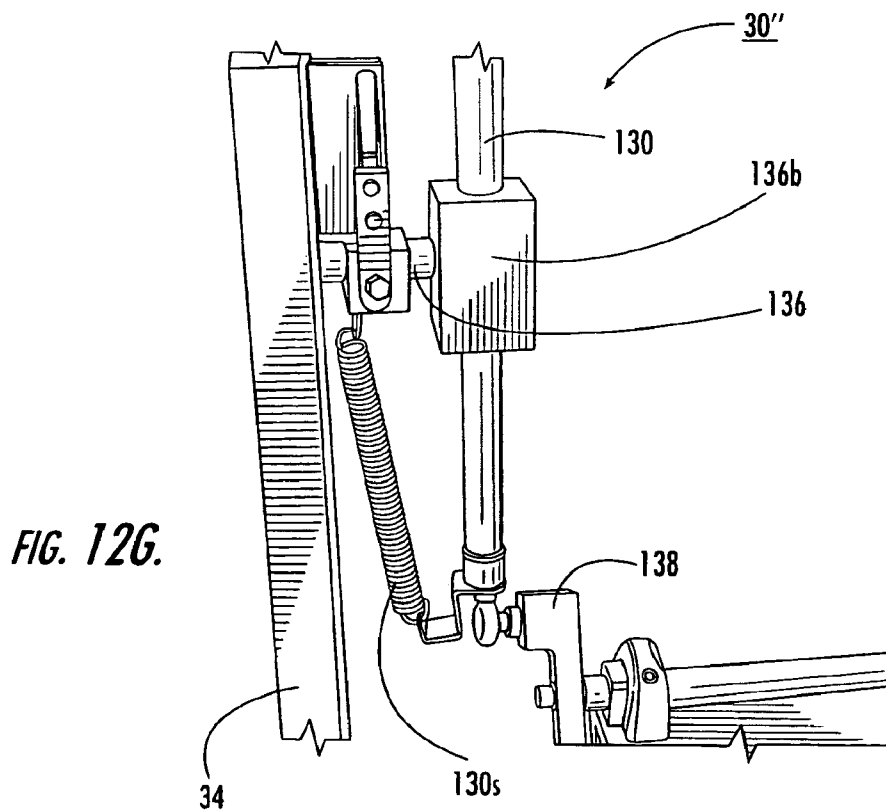
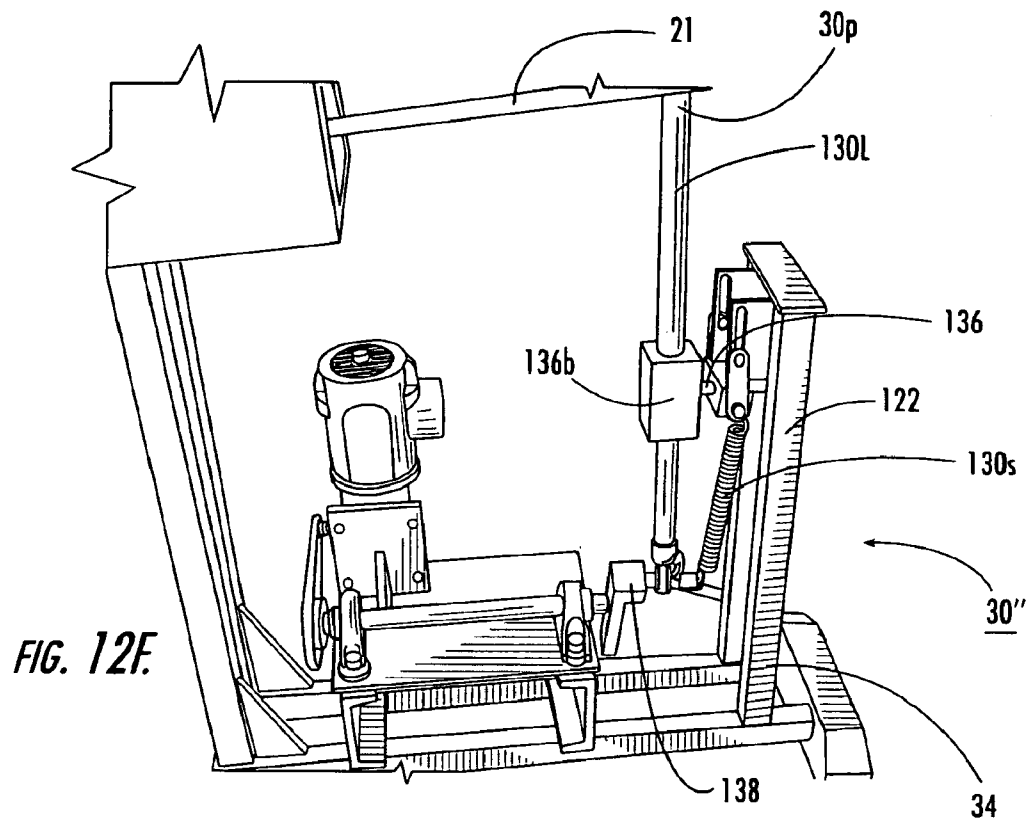


FIG. 12E.



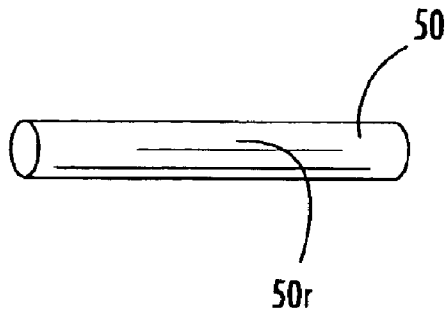


FIG. 13A.

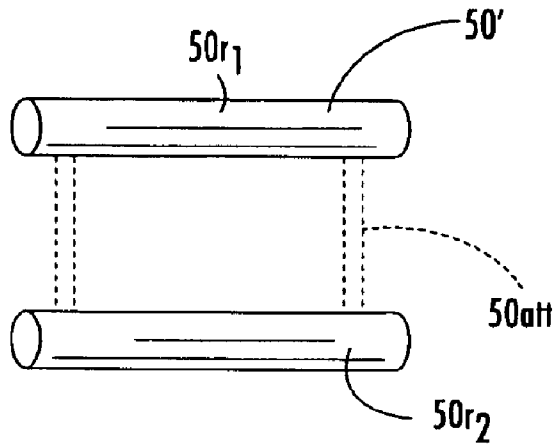


FIG. 13B.

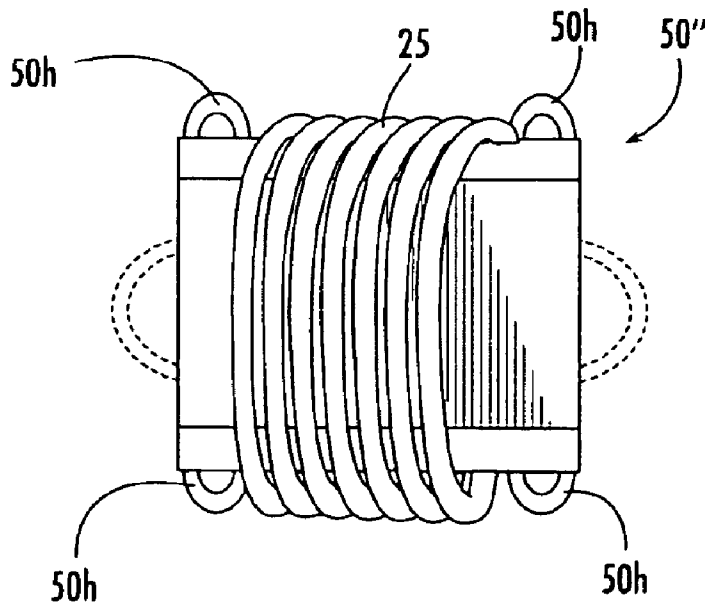
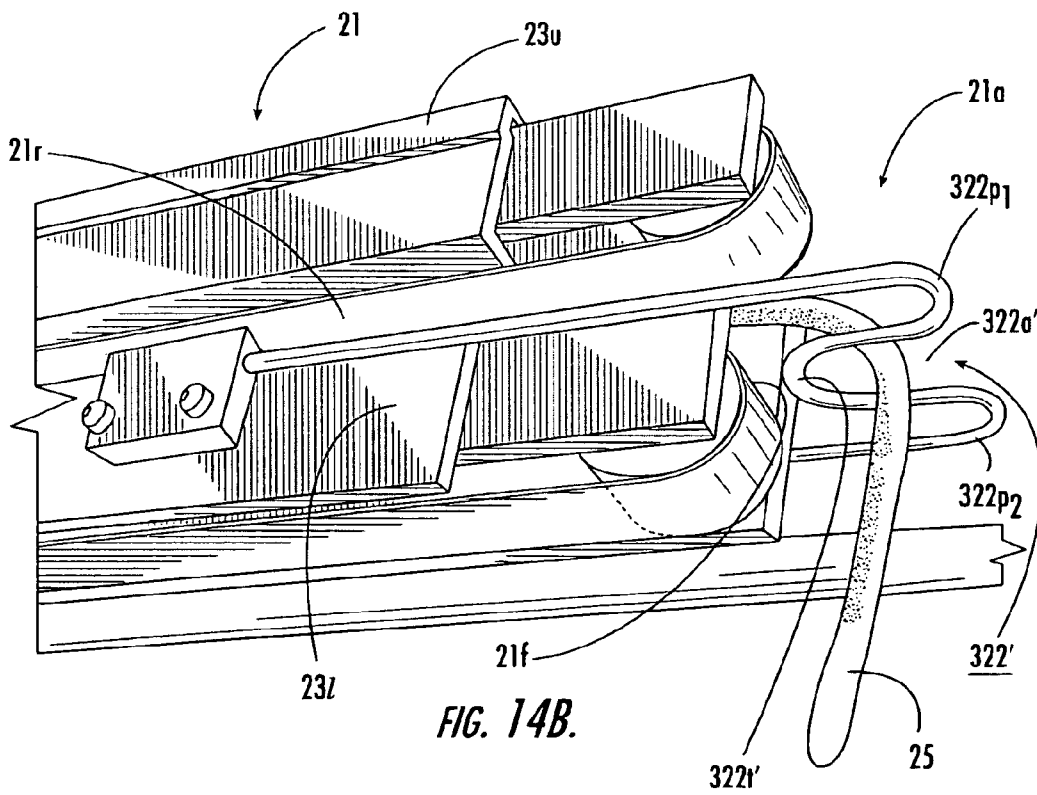
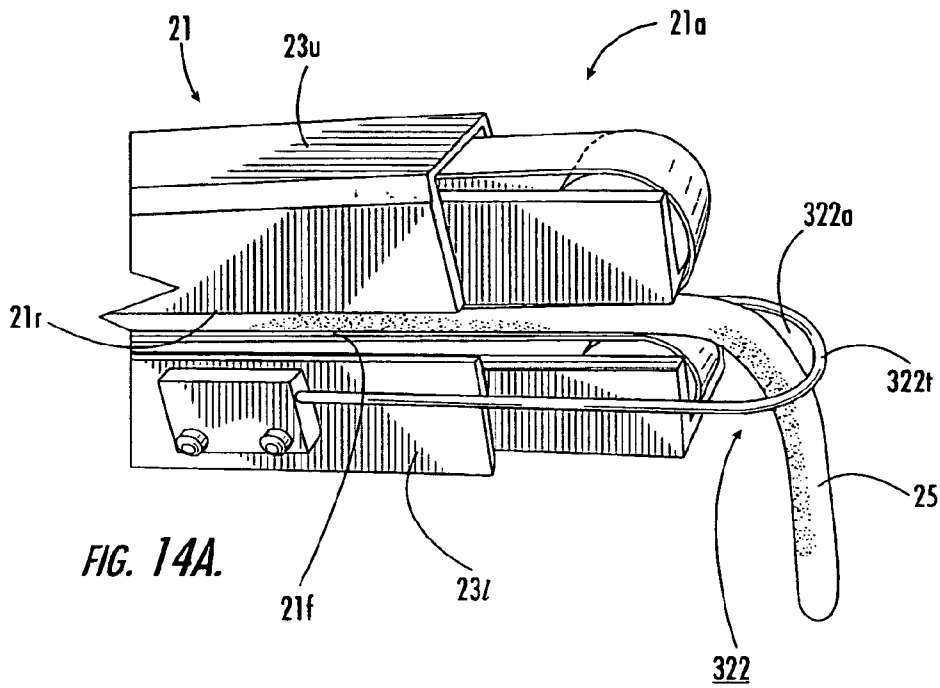
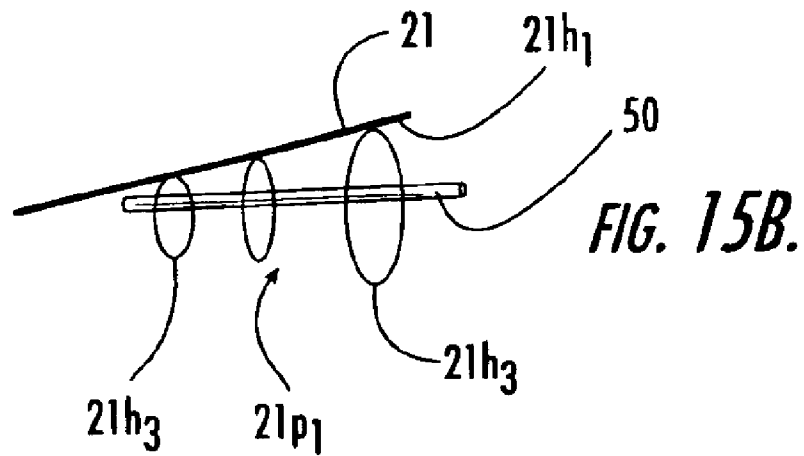
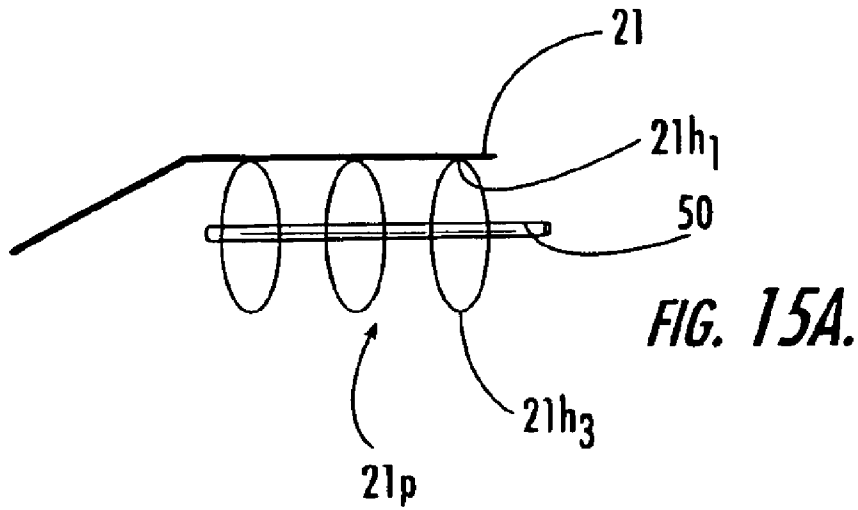


FIG. 13C.





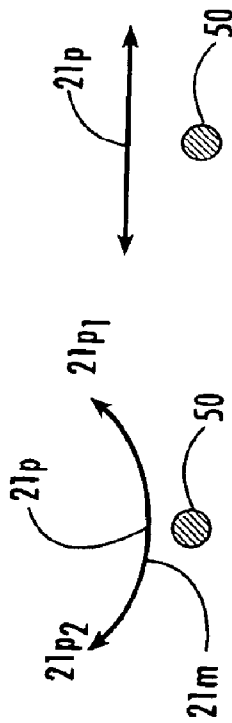


FIG. 16A.

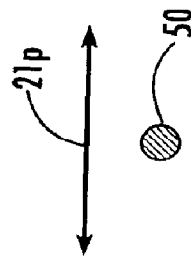


FIG. 16B.

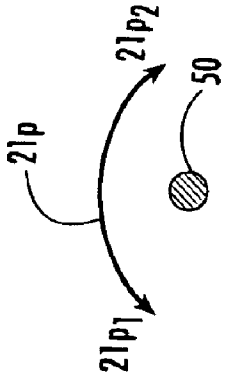


FIG. 16C.

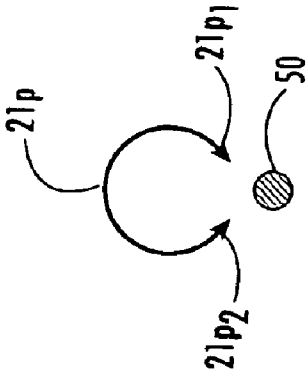


FIG. 16D.

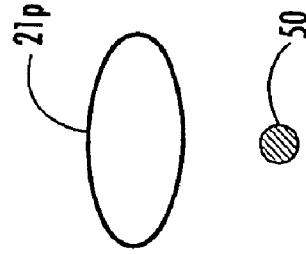


FIG. 16E.

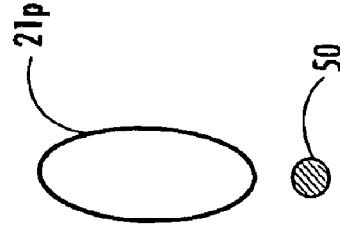


FIG. 16F.

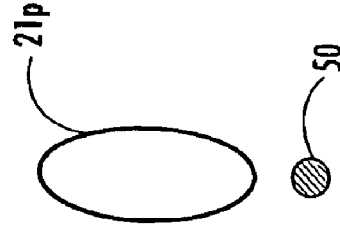


FIG. 16G.

1

**REPETITIVE HIGH-DENSITY PACKING  
MECHANISMS FOR ARRANGING  
SUSPENDED LENGTHS OF ELONGATED  
ITEMS IN A DESIRED ORIENTATION AND  
ASSOCIATED METHODS**

FIELD OF THE INVENTION

The present invention relates to handling of products within processing facilities and is particularly suitable for loading lengths of products such as elongated extruded or stuffed food products on carriers in food preparation and production systems.

BACKGROUND OF THE INVENTION

Conventionally, extruded or stuffed food products such as pasta, dough, and meats such as hot dogs, links, or sausages, can be processed so that the desired food material is extruded or mixed and prepared, then propelled through a "stuffer machine" that includes a stuffing nozzle, extrusion machine, or co-extrusion machine. In operation, in certain food items, as the food moves through the stuffing nozzle or extrusion head, a natural or synthetic casing is disposed about and/or deposited or wrapped around the external surface of the food material to form a continuous length of encased elongated food product. To form certain products (such as hotdogs and sausages), the casing can be twisted, tied, nipped, and/or crimped at certain intervals, forming a chain-like string or strand of encased food product. Extruders and co-extruders are available from various commercial manufacturers including, but not limited to, Townsend Engineering Co., located in Des Moines, Iowa. Stuffers are available from various commercial manufacturers including, but not limited to, HITEC Food Equipment, Inc., located in Elk Grove Village, Ill., Townsend Engineering Co., located in Des Moines, Iowa, Robert Reiser & Co., Inc., located in Canton, Mass., and Handtmann, Inc., located in Buffalo Grove, Ill. Exemplary stuffer and/or linker apparatus are also described in U.S. Pat. Nos. 5,788,563; 5,480,346; 5,049,108; and 4,766,645. The contents of these patents are hereby incorporated by reference as if recited in full herein.

After stuffing or extruding, the encased elongated food product is expelled from the stuffer or extruder via a material discharging exit port. FIG. 1A illustrates a conventional stuffer 10 and stuffer material discharge port 10p. The stuffer discharge port 10p is positioned proximate a "linker" or looping and transferring device 15 (FIG. 1B) that rotates an endless chain of hooks 15h about the discharge port 10p. Generally described, the material discharge port 10p is configured so that, during operation, the product is expelled and directed so that the traveling hooks, which serially travel to be adjacent the discharge port 10p, catch a portion of the length of the product, with the result that the product forms loops on the hooks at certain intervals. More specifically, certain devices are configured so that the hooks 15h travel to the discharge port 10p and the discharge port 10p discharges into a downwardly inclined channel that directs the elongated food downward and, as the hooks turn to face the discharged food, the hooks sequentially individually reach out to grasp the product at certain intervals. Other devices propel the encased product onto hooks that rotate thereabout (typically under) to catch the product at certain intervals to transfer the encased material onto the transfer device. The hooks 15h then suspend the product in a looped configuration (hanging in a vertical orientation) as shown in FIG. 1B, with each hook 15h supporting a single loop of product.

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FIG. 1C illustrates a slightly different prior art stuffer 10 and associated linker 15 with hooks that are oriented to rotate in a different plane from that shown in FIG. 1A (i.e., a vertical plane rather than a horizontal plane). In addition, in this prior art stuffer/linker, the discharge port 10p terminates into a short expanse of tubing that forms a rotating discharge nozzle 10r. The rotating nozzle 10r, again, propels the extruded encased product onto the hooks 15h.

After the product is suspended on the hooks 15h, a rod or stick is typically manually inserted through the suspended looped product above the hooks and below the upper looped portion of the food, and the product is manually lifted up and off the hooks 15h and transferred to a trolley, oven, or other food processing station.

In view of the foregoing, there is a need to provide automated processing systems that can improve the production process to facilitate the loading of food receiving members such as sticks and/or reduce the need for manual labor to load sticks and/or that can more controllably transfer strands of elongated items in an automated manner.

SUMMARY OF THE INVENTION

The present invention provides automated winder systems, methods, and devices that can automate the loading of extruded or stuffed product in a desired increased density packing arrangement onto a carrier or transfer support member such as a stick or rod. The automated winders can be configured to remove the need for a hook-based continuous looping system, and/or manual insertion of rods to lift the looped product onto the rods, from the production process. Indeed, in particular embodiments, the automated winder can load the elongated product in a desired packing density directly onto a stick or desired support transfer or carrier member that can then be used to transfer the product to (and/or through) the next processing station (such as a smoker, oven, curer or the like).

Certain embodiments of the present invention are directed to methods for loading carrier members with suspended elongated product. The methods can be carried out to wipe, push, or pull adjacent segments of the suspended product closer together to increase the amount or density of the product loaded or held on the carrier member.

Certain embodiments are directed to high-density packing mechanisms and methods with a packing arm that extends and retracts repeatedly about a portion of the length of the carrier member thereby sweeping or pushing adjacent segments of suspended product closer together on the carrier member. The carrier member can be moving (forward or rearward) as the packing arm extends and retracts so that the packing arm reaches over different portions of the carrier member at each revolution or cycle of the extend and retract movement. This can allow the packing arm to pack the suspended product in a high-density closely spaced substantially evenly distributed arrangement over a desired length of the carrier member.

and y-axis directional components. The transfer or carrier member may be configured to (linearly) translate as the winder arm translates (moved either forward or backward toward or away from the stuffer discharge port) so that the automated winder can load, straddle-wrap or loop, the released product starting at one end portion of the transfer member and terminating at the opposing end portion so that substantially the entire length (or a desired length) of the transfer member is covered with a continuous length of straddled and/or looped product. As one or more segments of the product is held draped or suspended from the carrier

or transfer member, a packing mechanism having an extending and retracting arm can extend about the carrier member to direct at least one of the draped segments to move in a desired direction on the carrier member to position adjacent segments of the suspended product closer together. The packing mechanism can repeat this motion a plurality of times as the carrier member linearly moves to serially contact spatially separate portions of the carrier member and different draped segments of the product during the packing or loading operation.

The packing mechanism can be automatically or manually operated. For automated versions, the packing arm can be driven by an electric motor that causes the arm to move continuously in a closed path that serially causes the packing arm to extend in an upstream direction above the carrier member, decline or lower to contact the carrier member and push the adjacent food segment in a forward direction, rise to move above the carrier member, and then return to the extended position above the carrier member, et seq., thereby repeating the cycle.

Certain embodiments of the present invention are directed to methods for loading a carrier member with suspended elongated product, including: (a) straddling suspended elongated product over a carrier member having a width so that portions of the elongated product are serially draped over the carrier member along a desired length thereof, the straddling being carried out so that the draped elongated product defines suspension regions that contact the carrier member intermediate lengths of the elongated product that hang from opposing sides of the carrier member; (b) moving at least one of the suspended regions on the carrier member in a predetermined direction at a first time; then (c) moving another one of the at least one of the suspended regions on the carrier member in the predetermined direction at a second time; and (d) arranging the straddled elongated product so that serially consecutive suspension regions are more closely positioned together on the carrier member based on the first and second moving steps.

Other embodiments of the present invention are directed to automated high-density repetitive packing mechanisms for arranging suspended elongated product on a carrier member. The packing mechanism comprises: (a) an elongated packing arm having an associated length and opposing first and second end portions, wherein, in operation, said first end portion is attached to a fork member that is adapted to periodically contact a portion of a suspended elongated item held on a carrier member; and (b) a drive mechanism attached to the second end portion of the packing arm to repeatedly move the packing arm in a predetermined motion so that the fork member serially moves in a cycle that includes moving in a first longitudinal direction, stalling for a desired interval of time, traveling down a desired vertical distance sufficient to cause the fork member to engage with the carrier member, moving in a second longitudinal direction opposite the first longitudinal direction with the fork member substantially horizontal and parallel to the carrier member, then rising a distance to reside above the carrier member.

The system may be arranged so that over a desired time period, the packing mechanism is substantially continuously operated to serially load a plurality of carrier members and/or transfer support members. Further, in certain embodiments, the carrier member or transfer support member is a stick or rod that can be used to support the elongated product at the next active workstation that may be an oven, a smoker, a curer, or other food preparation/processing station.

These and other objects and aspects of the present invention are explained in detail in the specification set forth below.

#### BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1A is a perspective view of a prior art extruded food stuffer and associated linker or transferring and looping device.

FIG. 1B is an enlarged view of the looping hooks of the device shown in FIG. 1A showing an elongated extruded encased food product suspended thereon.

FIG. 1C is a perspective view of another prior art stuffer and linker.

FIGS. 2A–2F are side views of a sequential series of operations used to pack product in close proximity according to embodiments of the present invention.

FIG. 3A is an enlarged front view of the end portion of the packing mechanism shown in FIGS. 2A–2F positioned relative to an underlying carrier member according to embodiments of the present invention.

FIG. 3B is an enlarged front view of the end portion shown in FIG. 3A with the device translated a distance down so as to engage with the carrier member in front of (or behind) a selected region of suspended elongated product according to embodiments of the present invention.

FIG. 4 is a side view of the device shown in FIGS. 2A–2F illustrating a more fully loaded carrier member with a plurality of closely spaced suspended regions held on the carrier member according to embodiments of the present invention.

FIG. 5A is a side view of a portion of an automated winder according to embodiments of the present invention.

FIG. 5B is a schematic illustration of an exemplary motion pattern of the arm of the automated winder of FIG. 5A according to embodiments of the present invention.

FIG. 5C is a side view of a portion of an automated winder similar to that shown in FIG. 5A illustrating a different winding pattern according to embodiments of the present invention.

FIG. 5D is a schematic illustration of an exemplary motion pattern of the arm of the automated winder of FIG. 5C according to embodiments of the present invention.

FIG. 5E is a side view of a portion of an automated winder similar to that shown in FIGS. 5A and 5C illustrating yet another different winding pattern according to embodiments of the present invention.

FIG. 6A is a schematic illustration of a portion of the automated winder illustrated in FIG. 5A showing the winder arm above the loading stick or receiving member.

FIG. 6B is a schematic illustration of a portion of the automated winder illustrated in FIG. 5A showing the winder arm below the loading stick or receiving member.

FIG. 6C is a schematic illustration of a portion of the automated winder illustrated in FIG. 5C showing the winder arm at a first position with respect to the loading stick or receiving member.

FIG. 6D is a schematic illustration of a portion of the automated winder illustrated in FIG. 5C showing the winder arm at a second position with respect to the loading stick or receiving member.

FIG. 7 is a partial perspective view of a portion of the winder arm of the winder of FIG. 5A with the winding mechanism attached above the winder arm according to embodiments of the present invention.



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FIG. 8A is a top perspective view of a portion of a winder arm illustrating an enclosed chute or channel according to embodiments of the present invention.

FIG. 8B is an end view of the winder arm shown in FIG. 8A.

FIG. 9 is a side view of an automated winder system illustrating the winder attached below the winding arm according to embodiments of the present invention.

FIG. 10 is an end view of the winding mechanism shown in FIG. 9.

FIG. 11 is an end view of the winder arm shown in FIG. 9.

FIG. 12A is a perspective view of an alternative embodiment of an automated winder according to the present invention.

FIG. 12B is a side perspective view of the device shown in FIG. 12A.

FIG. 12C is a front schematic view of the device shown in FIG. 12A.

FIG. 12D is a side view of an alternate embodiment of an automated winder according to embodiments of the present invention.

FIG. 12E is a side perspective view of the device shown in FIG. 12D.

FIG. 12F is an enlarged side view of the winder shown in FIG. 12E with the arm partially cutaway.

FIG. 12G is side view of a winding mechanism shown in FIG. 12F.

FIG. 13A is a front view of an example of a stick/rod as employed as a transfer support member suitable for loading with the automated winders of the present invention.

FIG. 13B is a front view of an alternative embodiment of a transfer support member according to the present invention.

FIG. 13C is a front view of yet another alternative embodiment of a transfer support member according to the present invention.

FIG. 14A is a side view of a discharge portion of the arm illustrating an end guide according to certain embodiments of the present invention.

FIG. 14B is a side perspective view of an alternate configuration of an end guide according to certain embodiments of the present invention.

FIG. 15A is a schematic of a winding pattern according to embodiments of the present invention.

FIG. 15B is a schematic of another winding pattern according to embodiments of the present invention.

FIGS. 16A–16G are schematic front views of illustrations of exemplary winding patterns that may be used to wrap or position product onto a receiving member according to embodiments of the present invention.

#### DESCRIPTION OF EMBODIMENTS OF THE INVENTION

The present invention will now be described more fully hereinafter with reference to the accompanying figures, in which embodiments of the invention are shown. This invention may, however, be embodied in many different forms and should not be construed as limited to the embodiments set forth herein. Like numbers refer to like elements throughout. In the figures, certain layers, components or features may be exaggerated for clarity, and broken lines illustrate optional features or operations unless specified otherwise. In

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addition, the sequence of operations (or steps) is not limited to the order presented in the claims unless specifically indicated otherwise. Where used, the terms “attached”, “connected”, “contacting”, and the like, can mean directly or indirectly, unless stated otherwise.

In the description of the present invention that follows, certain terms are employed to refer to the positional relationship of certain structures relative to other structures. As used herein, the term “forward” and derivatives thereof refer to the general or primary direction that food travels as it moves inside a food processor from a processing point or region to the next processing point or region; this term is intended to be synonymous with the term “downstream,” which is often used in manufacturing environments to indicate that certain material being acted upon is farther along in the manufacturing process than other material. Conversely, the terms “rearward” and “upstream” and derivatives thereof refer to the directions opposite, respectively, the forward and downstream directions.

The devices and methods of the present invention may be particularly suitable to pack and/or load elongated food items onto a support or carrier member that can be used to transport, carry, or move the elongated food items to the next desired work or processing station. Elongated food items include, but are not limited to, elastic or partially elastic food items such as cheese (e.g., mozzarella strands), dough (such as for incubation), meat sticks or strands, pasta, licorice or other strands of candy, and meat products. Of course, the processing system can be configured to wind or transfer other items. For example, other elongated products include candles, ropes, string, cables, chain, wires, hose, tubing, and the like.

In certain embodiments, the present invention is used to process and/or transfer or load a length of an elongated extruded product held in a casing onto a support member. The casing can be any suitable casing (edible or inedible, natural or synthetic) such as, but not limited to, collagen, cellulose, plastic, elastomeric or polymeric casing. The elongated product can be an elongated meat product. Exemplary meat products include, but are not limited to, strands of meat (that may comprise pepperoni, poultry, and/or beef or other desired meat), processed meat products such as strand(s) or continuous lengths of meat sticks (including whole or partial meat mixtures), sausages, hotdogs, and the like. The term “continuous” is used interchangeably with “contiguous” to mean that the product is connected or joined (directly or indirectly) over its length.

The elongated product can be configured as a continuous length of product having a length of at least about 20–25 feet per strand, and typically at least about 50 feet. In other embodiments, the length of the continuous product may be up to about 150–200 feet, or even longer. The elongated product may be segmented or non-segmented, i.e., a length of chain-like linked items, or a strand or multi-stranded length of non-chain linked product. Other embodiments may load the elongated product in a series of non-looped discrete lengths. The discrete lengths may be any desired length or combinations of lengths, such as, but not limited to, lengths between about 1–20 feet.

The elongated food item may be elastic (at least in tension) so as to allow some stretching without unduly altering or deforming its desired shape and/or cross-section during processing. The elongated food item may be an extruded product that is held in a natural or synthetic casing as noted above. Other embodiments contemplate product that have rigid configurations but are movable link to link,

such as chains of material having sufficient rigidity to retain its shape during processing and/or use (such as those objects formed of sufficient thickness or structure to provide a solid, semi-solid, or hollow length of material). The material may be a composite resin, metal, polymer, elastomeric and/or plastic material, combinations of the same, and the like.

In operation, in certain embodiments, the elongated product may have an exterior surface that, during the loading process, exhibits increased friction relative to a finished, cured, or dried configuration. For example, a processed meat mixture that is held in a collagen casing, prior to finishing, can be described as having a relatively gelatinous, sticky external residue that can cause the food to attempt to stick to a support surface.

FIGS. 2A–2F illustrate a sequence of operations that can be carried out to arrange suspended elongated product on a carrier member 50 according to embodiments of the present invention. As used herein, the term “transfer support member” is used interchangeably with the term “carrier member.” As shown in FIG. 2A, a packing mechanism 175 is cooperably aligned with a carrier member 50 that is, in turn, cooperably aligned with an automated winder 20. The automated winder 20 includes a winding arm 21 and has an associated winding or motion pattern 21p that discharges and loads suspended elongated product onto a cooperably aligned carrier member 50 and is discussed in more detail below with reference to FIGS. 5 et seq. The carrier member 50 is loaded with at least one length of elongated product 25. As shown, the product straddles onto the carrier member 50 so that the product defines suspension regions 121S<sub>1</sub>–121S<sub>n</sub>. The straddling can be carried out in different manners to load, suspend, hang, or drape the product 25 onto the carrier member 50. For example, as shown in FIG. 4, the straddling is performed so that the product 25 is arranged in a plurality of loops on the carrier member 50. FIG. 5C illustrates that the straddling configuration can be a continuous length of non-looped bights B<sub>1</sub>, B<sub>2</sub> . . . B<sub>n</sub>, having a series of curves while FIG. 5E shows discrete lengths of products hanging from the carrier member 50.

In any event, the packing mechanism 175 includes an elongated packing arm 175a that moves through a repeating motion cycle illustrated by the arrows proximate the packing arm 175a in FIGS. 2A–2F. The packing arm 175a includes opposing first and second end portions 175a<sub>1</sub>, 175a<sub>2</sub>, respectively. The first end portion 175a<sub>1</sub> can be formed as or include a fork member 176 that, in operation, periodically reaches over and down to contact the outer surface of the carrier member 50 (FIGS. 3A, 3B) and/or a portion of a suspended elongated product 25 held on a carrier member 50 to swipe, move, push, or pull regions of the product 25 in a desired direction on the carrier member 50 to provide a more closely spaced or symmetrical or desired loading/packing arrangement.

As shown in FIGS. 2A–2F, the packing mechanism 175 also includes a drive mechanism 177 attached to the second end portion of the packing arm 175a<sub>2</sub> to repeatedly move the packing arm 175a through a predetermined motion cycle so that the fork member 176 serially moves through its travel cycle. The drive mechanism may be automatically or manually operated. FIG. 2A illustrates that the drive mechanism 177 can be operably associated with an automated drive means such as a motor 177m. As shown by the sequence in FIGS. 2A–2F, the cycle sequence may be such that the fork member 176 moves in a first longitudinal direction (shown in the rearward substantially longitudinal direction in FIG. 2A), travels down a desired vertical distance sufficient to cause the fork member 176 to engage the carrier member 50

(FIGS. 2B, 2C and 3A, 3B), moves in a second longitudinal direction opposite the first longitudinal direction with the fork member substantially horizontal (FIGS. 2D, 2E), then rises a distance to reside above the carrier member 50 (FIG. 2F). The arm 175a and the fork member 176 may be configured to stall for a desired interval of time during a portion of the cycle, typically after they rise (FIG. 2F) and before they descend again (FIG. 2B). The stall or static interval can be timed to define when the fork member 176 will next contact the carrier member 50. The stall interval can depend on the discharge speed of the product 25 from the winder mechanism 20, the speed of the winder 20 as it moves through its winding path 21p and the number of times it is desired for the fork member 176 to contact the carrier member 50 and/or product 25. For example, in certain embodiments, the winding arm 21a may be configured to operate with a pause of about 0.5–2 seconds at one or more locations in its travel path, as the winding arm 21a (FIG. 5A) moves about the carrier member 50. In other embodiments, increased stall times can be used, while in still other embodiments no stall time is used as the amount or speed of drag or movement of the fork member 176 can be timed to continuously move through its operative positions in a variable or constant speed. Combinations of variable speeds, constant speeds, and the use of stall intervals may also be used depending on the application.

For example, the carrier member 50 can be loaded by having the winding arm 21a present the product onto the carrier member 50 so that it is straddled in a desired suspended configuration. The straddling operation has an associated speed that is dependent upon the discharge rate of the product 25 from the winder 20 and the speed of movement of the winder arm 21a about the carrier member 50. Similarly, the packing arm 175a also has an associated speed. The packing arm 175a speed can be adjusted based on the speed of the straddling operation so that it does not disrupt the loading and can move the product 25 at desired intervals during the loading cycle.

In operation, in certain embodiments, the straddling operation is carried out by the winding arm 21a as it travels in a predetermined pattern and discharges food 25 therefrom in a forward direction while the winding arm 21a is traveling through its pattern 21p. The packing arm 175a can be configured to move rearward and forward in a repetitive packing cycle. That is, the repetitive packing cycle can be performed so that the packing arm 175a serially moves in a rearward direction above the carrier member 50 relative to the direction of the discharged food, then stops for a static interval before it declines to contact the carrier member 50 and moves forward thereby pushing the suspended region in back 176b of the packing arm 175a forward, and then rises to complete a packing cycle.

In certain embodiments, the carrier member 50 can be translated forward during the operation of the packing mechanism 175. In this situation, the fork member 176 can sequentially engage different segments of the product and/or different locations of the carrier member 50 to thereby arrange different portions of the product to be closer together. The carrier member 50 is shown as moving forward (horizontal arrows proximate the carrier member 50 in FIGS. 2B–2F) with the packing arm 175a also moving or pushing the suspended product forward on the carrier member 50 itself. However, the movement of the arm of the mechanism 175a and translation of the carrier member 50 can be reversed. In addition, in lieu of moving the carrier member 50, the winding arm 21 of the winder 20 and the packing mechanism 175 can be moved with the packing

mechanism being stationary to distribute elongated product over a desired length of the carrier member 50.

Further, in certain embodiments, instead of positioning the packing mechanism 175 in front of (downstream of) the winding arm 21 as shown, the packing mechanism 175 may be placed to the side or rear of the winding arm 21 and be configured to reach in and periodically push, pull or move the suspended product forward or rearward on the carrier member 50 (not shown).

FIGS. 2A and 2B illustrate that the winding mechanism 177 can be mounted to a platform 175p that holds at least a portion of the mechanism 177 thereon. As shown, the platform 175p includes an upper bracket 190 that holds the packing arm 175a in a manner that allows the packing arm 175a to pivot thereon. The platform 175p can also include a lower bracket 191 that can hold an edge portion of the carrier member 50. The lower bracket 191 may be operably associated with a drive track 193 mounted on the platform 175p that automatically positions the carrier member 50 at the packing station and/or moves the carrier member 50 forward at a desired speed during the packing operation. For additional discussion of suitable take-away and loading systems using drive tracks, see co-pending U.S. Provisional patent application Ser. No. XXXX, filed Apr. 8, 2002, identified by the contents of which are hereby incorporated by reference as if recited in full herein.

As shown in FIGS. 2A and 2B, in certain embodiments, the drive mechanism 177 can be a four-bar linkage mechanism that includes a rotatable wheel 178 that can be mounted to the platform 175p. The wheel 178 can be powered to be automatically driven by a shaft connected to a motor as shown schematically in FIG. 2A. The wheel 178 can be substantially continuously operated so as to repeat the packing cycle(s) a plurality of times for each carrier member 50 presented to the packing arm 175a. The wheel 178 is connected to a linkage 179 that may travel in a restrained slot 180 formed in the wheel 178. The linkage 179 is attached to the arm 175a. In operation, as the wheel 178 rotates, the linkage 179 repeatedly follows a defined path (shown by different locations in FIGS. 2A–2E (FIG. 2F shows the position shown in FIG. 2A), and pulls the arm 175a through a desired motion output.

Of course, any suitable mechanisms and/or components can be employed, including, but not limited to, cam/follower arrangements, pistons (pneumatic or hydraulic), combinations of differently configured linkages with any of the above as well as other electromechanical configurations that can generate the desired repeated motion.

The packing arm 175a may be configured to directly contact each suspended region 121S<sub>1</sub> through 121S<sub>n</sub> (FIG. 4) or only selected ones of the suspended regions. The packing arm 175a may be operated to move groups of suspended regions in a desired direction on the carrier member 50 or a selected suspended region independently of the others. In certain embodiments, the packing arm 175a repeatedly moves to push serially successive spaced-part suspended regions forward along the carrier member 50. In other embodiments, the packing arm 175a pushes non-serially successive spaced-apart suspended regions forward along the carrier member 50.

The product 25 may be arranged in a looped (FIGS. 4, 5A) or non-looped (FIGS. 5C, 5E) configuration on the carrier member 50 as will be discussed further below. FIG. 4 illustrates that a continuous length of elongated product 25 is suspended with substantially even lengths 25l<sub>1</sub>, 25l<sub>2</sub>, 25l<sub>n</sub> of product on opposing sides of the carrier member 50 over

a desired length of the carrier member 50. Other product loading or draping configurations may also be employed.

FIGS. 3A and 3B illustrate an example of the fork member 176 that is attached to the end portion of the arm 175a. The fork member 176 includes a forward or front surface 176f and a rear surface 176b, and may also include an aperture 176a that is sized and configured to correspond to the width of the carrier member 50. The fork member 176 can be sized so as to rest on the carrier member 50 as it pushes, wipes, and/or moves the product on the carrier member 50. The fork member 176 may directly or indirectly contact the product and/or the carrier member 50. For example, as shown the fork member 176 can snugly abut the carrier member 50 and push the food in the desired direction. The fork member 176 may be formed of stainless steel or other material suitable for processing the product (such as food). Lubricating coatings may be employed to inhibit friction between the fork member 176 and the carrier member 50 and/or product 25. In other embodiments, the fork member 176 may be configured to controllably discharge fluid such as air, water, or other pressure applying means, in a desired orientation to move the product along the carrier member 50 (not shown).

Referring again to FIGS. 3A and 3B, in operation, the fork member 176 travels over the carrier member 50 (FIG. 3A) and then travels down a distance to cooperably engage the carrier member 50 (FIG. 3B) so as to move the product along the carrier member 50 in a desired direction to promote efficient side-by-side abutting placement or closely spaced alignment between adjacent suspended regions 121S<sub>1</sub>, 121S<sub>2</sub>, 121S<sub>n</sub>, as shown in FIG. 4.

Turning now to FIG. 5A, one embodiment of an automated winder 20 is shown. The automated winder 20 includes an elongated arm 21 with first and second opposing end portions 21a, 21b, respectively, and a winding mechanism 30. In this view, the winding mechanism 30 is schematically illustrated by a translation linkage 30L that is attached to the arm 21 in a manner that allows it to repetitively move the arm 21 in a desired translating motion or pattern. At the other end of the translation linkage 30L can be any number of suitable translation generation means as will be appreciated by those of skill in the art. As shown, the arm 21 directs the elongated product 25 onto a desired transport support member 50 (shown as a stick or rod). In operation, a plurality of support members 50 are serially placed in aligned cooperating position with the arm 21 of the winder 20 so that each support member 50 can be successively loaded or wound with looped elongated product 25.

In certain embodiments, the winding mechanism 30 is configured to provide a motion for the arm 21 that includes at least a substantially continuous or repeating motion (open or closed path) as indicated by the solid line arrows positioned proximate the translation linkage 30L. Additionally, the winder mechanism 30 may also be configured to translate in a more complex, multi-directional motion (as indicated by the broken-line arrows shown adjacent the solid-line arrows, the motion may also be include movement that is directionally in and out of the paper “the Z axis”). Thus, as shown by the dotted line arrows adjacent the solid line arrows, the translation linkage 30L may drive the arm 21 to move in a direction which is a closed path including two different axis of travel, typically including both X and Y axis directional components. The closed path may be shaped in any desired suitable configuration, including, but not limited to, an oval, teardrop, circular, elliptical, hourglass, square, or rectangle, so as, in operation, it causes the elongate product to wrap to the desired configuration. Further the winding

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mechanism **30** may be programmably configured to alter its winding pattern, winding speed, and the like, depending on certain parameters such as the product being processed and/or the loading configuration desired.

By way of illustration, as shown in FIG. 5B, the arm **21** can have a maxima position at a first vertical height  $21h_1$ , two intermediate positions at a second lesser height  $21h_2$  (shown with the arm **21** in dotted line below the maxima height), and a minima position  $21h_3$  at still a lesser vertical height (shown with arm **21** at yet another lower position at a minima height). The arm **21** is configured to move a sufficient distance above and below the transport member **50** so as to load or loop the elongate product **25** thereon.

FIG. 5B illustrates but one embodiment of a rotational motion pattern  $21p$  for the arm **21** in which the arm **21** successively moves through a closed path pattern. In certain embodiments, as shown in this figure, the pattern  $21p$  may be substantially elliptical or oval. In this pattern, the arm **21** travels through the intermediate positions both as it is moved and/or rotated in the closed path in the downward and upward directions. In position, the transport member **50** is located within the perimeter of the enclosed closed travel path defined by the translating arm **21**. In certain embodiments, the transfer member **50** can be located so that it is centrally located within the boundary of the movement of the arm. In other embodiments, the transfer member is asymmetrically positioned (such as closed to the top, bottom or one side of the arm movement). The direction of travel is shown as clockwise in FIG. 5B, but may be configured to be counterclockwise as well.

FIG. 5A shows that the first end portion  $21a$  of the arm is positioned a length away from the discharge port  $10p$  of the upstream processing station. As shown, the upstream processing station can be the extruder **10** (such as the conventional extruders shown in FIGS. 1A–1C) and the second end portion  $21b$  of the arm is positioned proximate to, and in cooperating alignment with, a discharge port  $10p$  of the extruder (or stuffer) **10** or intermediately positioned member such as a chute. That is, the second end portion of the arm  $21b$  is positioned so as to receive the elongated product **25** from the upstream device and the opposing (first) end portion  $21a$  is configured to release the elongated product **25** after the product **25** has traveled a desired distance over the length of the arm **21**. Typically, the product **25** will travel a major portion of the length of the arm, and more typically, substantially the entire length of the arm **21** before it is released. The product **25** can be released directly from the first end portion  $21a$ , or a discharge nozzle or other discharge port can be attached to the arm **21** and used to dispense the product **25** therefrom.

In operation, the transfer member **50** can be configured to start at a first position that is toward the upstream end  $21b$  of the arm **21** and during loading is gradually retracted or translated to be closer to the downstream end  $21a$  of the arm **21** all at substantially the same vertical height (as shown by the horizontal arrows adjacent the transport member **50** in FIG. 5A). This motion distributes looped product over the desired length of the transport member **50**. FIGS. 6A and 6B illustrate the winding translation of the arm **21** with respect to the transport member **50**. The transport member **50** is located at a first position  $P_1$  and is gradually moved forward to a second position  $P_2$  as the arm **21** winds the product **25** thereon. Thus, the transport member **50** moves a distance  $\Delta P$ .

In certain embodiments, the transport member **50** moves at a substantially constant speed or increments of travel distance that is synchronized and/or responsive to one or

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more of the speed of the winding (speed of the arm), the speed of forward movement of the product **25** as it exits the arm **21**, and the desired looping arrangement/configuration (length of the loops) on the transport member **50**. In certain embodiments, the movement of the transport member **50**, the winding speed of the arm **21**, and/or the speed of the elongate product **25** as it moves off the arm, can vary to provide variable loading density or looping lengths. Thus, the movement distance and speed of movement of the transport member **50** can vary depending on the desired loading of the transport member and winding speed and loop configuration (length, etc.). Typically, the transport member **50** moves a distance that corresponds to a substantial portion of its length (i.e., greater than about 51–75% thereof). Although described as starting from a rearward position and moving forward, the transport member **50** can be configured to move in the reverse direction also.

FIG. 5C illustrates an alternate loading arrangement of the elongated product on the transport or receiving member **50** with an example of an associated winding pattern  $21p$  of the arm **21**. As shown, the arm **21** is configured to load the product in a suspended straddled, non-looped configuration (i.e., the product does not double over or loop to cross or close upon itself). As shown in FIG. 5C, one or more one continuous lengths of released elongated product can be loaded onto the transfer support member **50** in response to the release of the product **25** from the moving arm during the translation thereof so that the elongated product **25** is arranged in a straddled configuration with a plurality of adjacently arranged non-looped vertical lengths, such as  $L_2, L_4$  or  $L_5, L_7$ , hanging on the same side of the transfer support member and a plurality of different adjacent non-looped lengths, such as  $L_1, L_2$  or  $L_4, L_5$ , hanging on the opposing side of the transfer support member so that the elongated product **25** has a plurality of suspension contact points  $121S_n$  spaced apart about a desired length of the transfer support member **50**. As used herein, the term “suspension contact points” means the discrete physical contact spaces, areas, or regions between the product **25** and the transfer support member **50**. The area or size of the contact points may vary depending on the size, weight, and/or width of the product, and/or the size and/or width of the transfer support member **50**.

Still referring to FIG. 5C, as shown, the winding mechanism **30** is configured to configure the suspended straddled arrangement of the elongated product **25** on the transfer support member **50** such that, in serial order, a first continuous length of product is arranged so that a first vertical length  $L_1$  of the elongated product extends about one side of the transfer support member **50**, a second vertical length  $L_2$  extends over the opposing second side of the transfer support member **50** after the first length  $L_1$ , a first suspension portion  $121S_1$  is located intermediate the first and second lengths  $L_1, L_2$ , respectively. A third adjacent length  $L_3$  laterally extends along the second side of the transfer support member **50** after the second length  $L_2$ , a fourth vertical adjacent length  $L_4$  extends along the second side of the transfer support member **50** after the third length  $L_3$ , a fifth vertical adjacent length  $L_5$  extends along the first side of the transfer support member **50** after the fourth length  $L_4$ , a second suspension portion  $121S_2$  is located intermediate the fourth and fifth lengths  $L_4, L_5$ , respectively, and a sixth adjacent length  $L_6$  laterally extends along the first side of the transfer support member **50** after the fifth length  $L_5$ .

In operation the arm **21** can move have lateral directional travel components so as to move back and forth across above the transfer support member **50**. In so doing, the elongated

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product **25** can be discharged to hang or drape from a first side of the transfer support member **50**, cross over the width of the body of the member **50** and hang or drape another vertical segment down the other opposing second side. The arm **21** continues to release the elongated food so that another vertical segment or portion hangs or drapes still on the same second side before it re-crosses over the transfer support member **50** and drapes another vertical length back on the first side of the transfer support member. The non-looped straddled product can be arranged so that the suspended vertical draped lengths are substantially the same, dissimilar, or combinations thereof. The draping motion can be continued so as to substantially fill a major portion or substantially all of the length of the transfer support member with the elongated product **25**. The lateral lengths of product (i.e.,  $L_3$ ,  $L_6$ ) can be disposed so that they are substantially horizontal as shown, or in other desired configurations. The length of the lateral segments can alter and can be controlled by the movement pattern and speed of discharge, the speed of the motion of the arm, and the movement and speed of the transfer support member **50** during the loading process or operation.

FIG. **5E** illustrates that in lieu of a single continuous length of product **25**, a plurality of discrete product lengths can be straddle loaded onto the transfer support member **50**. In operation, the winding mechanism **30** causes the arm **21** to release a plurality of discrete lengths of elongated item **25** so that the items are arranged in a suspended laterally spaced apart straddled configuration, each discrete length having opposing first and second end portions  $25p_1$ ,  $25p_2$  and an intermediate portion  $121S_1$ ,  $121S_2$ , therebetween, respectively. In position, the first and second end portions  $25p_1$ ,  $25p_2$ , respectively, vertically extend to reside adjacent to each other on opposing sides of the transfer support member **50** and the respective intermediate portion  $121S_1$  or  $121S_2$ , defines a respective one suspension contact region that contacts the transfer support member **50**.

Referring to FIG. **5C**, stated differently, certain embodiments of the suspended straddle configuration of elongated product **25** on the transfer support or carrier member **50** is provided so that sections of the elongated product form bights  $B_1$ ,  $B_2$  . . .  $B_n$ , that are draped from the rod, with longitudinally consecutive or serially positioned bights, being formed and/or located on opposing sides of the carrier member. The bights are sections of the elongated product that bend or curve but do not intersect. As such, the elongated product has adjacent or serially consecutive bights, each of which can have a series of bends or curves (i.e., defined by serially consecutive vertical, longitudinal, and vertical segments) that are draped on one side of the carrier member **50** before the next bight starts across the other side of the carrier member **50**. The loaded transfer member **50** can define a loaded carrier member assembly with elongated product thereon. The product can be arranged on the carrier member so that the elongate product is suspended in a straddled configuration, draped from the carrier member, so that sections of the elongated product form bights, with serially consecutive bights being formed on opposite sides of the carrier member. Each or selected bights can have a plurality of bends or curves and the adjacent bights do not intersect or crossover each other.

FIG. **5D** illustrates an exemplary loading motion  $21p$  of the arm **21** that can be used to provide the straddle arrangement shown in either FIG. **5C** or **5E**. As shown, the loading motion is an open path that has a boundary that has lateral components that permits the arm **21** to travel back and forth across the width of the transfer support member **50**. As

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shown, the arm **21** is disposed so that the travel path boundary primarily extends above the underlying transfer support member **50**. FIG. **5D** also shows that the travel motion  $21p$  can be substantially arcuate with the shape defined by lowermost points  $21p_1$ ,  $21p_3$ , and the maxima position  $21p_2$ . In operation, the arm **21** can repetitively travel in the motion pattern shown  $21p$  or in other suitable motion patterns. FIGS. **16A–16G** illustrate exemplary straddle loading motion patterns  $21p$ , some of which are open and some of which are closed travel paths.

FIGS. **16A**, **16C**, **16D**, and **16E** illustrate different open arcuate patterns  $21p$ . FIG. **16A** illustrates that the arcuate pattern  $21p$  can be reversed so that it turns upward with opposing end portions  $21p_1$ ,  $21p_2$ , that are above the transfer support member **50** and a minima location  $21m$  disposed therebetween. FIGS. **16G** and **16F** illustrate closed path motion patterns  $21p$  for the arm **21**. The pattern  $21p$  shown in FIG. **16G** is above the rod and has increased vertical travel distance relative to the amount of lateral travel distance. FIG. **16F** illustrates that the path  $21p$  may have increased horizontal or lateral travel distance relative to the amount of vertical travel distance. FIG. **16F** illustrates that in certain embodiments, no matter whether an open or closed path, and notwithstanding the configuration thereof, the travel motion pattern  $21p$  can be offset, inclined about, and/or not centered on or over the transfer support member **50**.

FIGS. **6C** and **6D** illustrate the translation of the arm **21** with respect to the transport member **50** (each moving during the loading operation) that can be used to straddle load the transport member **50** with product **25** such as shown in FIGS. **6C** and/or **6E**. The transport member **50** is located at a first position  $P_1$  and is gradually moved forward, typically in a unidirectional manner, to a second position  $P_2$  as the arm **21** drapes or hangs the product **25** thereon. Thus, in the portion of the loading cycle illustrated, the transport member **50** moves a distance  $\Delta P$ . The travel path of the transport member can be such that it is generally below and different from that of the arm **21**. In certain embodiments, the arm **21** travels side to side over the transport member with a constant or variable speed while the transport member **50** moves unidirectionally forward at a desired speed.

The length of the arm **21** can vary depending on various factors, such as, but not limited to, the size of the product, the forward speed of the product, the desired winding pattern and the like. In certain embodiments, the length of the arm **21** is sized to be at least the length of the transport member **50**. In other embodiments, the length of the arm **21** is such that the elongate product **25** travels at least about 2–8 feet, and typically at least about 6 feet, before being discharged therefrom onto the support member **50**.

The automated winder **20** may be configured to be self-supporting or free-standing and portable or free-standing and secured to the production floor relative to the related upstream and/or downstream equipment, as desired. In other embodiments, the second end portion  $21b$  of the arm can be attached to the extruder or upstream device **10** so as to be in communication with the discharge port  $10p$ . As such, the second end portion  $21b$  is stationary but can be pivotally attached to the device **10**. In certain embodiments, the second end portion  $21b$  is mounted so as to be able to move bi-directionally; the mounting or attachment can be configured in any suitable manner, such as, but not limited to, a universal joint, ball joint, bearing, elastomeric joint, and the like. FIG. **11** illustrates an end view of one embodiment of the arm **21** with an end portion  $21b$  configured to be mounted to an extruder or other upstream-positioned device. As shown, the end portion  $21b$  is configured to be affixed to

a device **10** so that it is stationary or fixed in place but allowed to translate in a bi-directional manner in response to forces introduced by the movement of the arm **21** as it, in turn moves in response to forces introduced by the winding mechanism **30** (FIG. 9).

The arm **21** can be any desired shape or configuration. The arm **21** includes a floor **21f** that supports the elongate product **25**. The floor **21f** can be stationary or moving, or combinations thereof. For example, the floor **21f** can comprise rollers, low-friction coatings or surfaces, a conveyor belt(s), and the like. In certain embodiments, the floor **21f** is defined by an endless conveyor **23** (FIG. 9) that wraps around the arm **21** to continuously convey the product **25** forward and then return to the starting position by traveling back underneath the floor **21f**. As shown in FIG. 8B, the arm **21** can include a channel or chute **21ch** that is configured with a shape that complements the elongated product **25**. For example, for a substantially circular cross-section product **25**, the floor **21f** may include an arcuate or semicircular channel **21ch** formed into the floor that is configured to receive a portion of the perimeter of the body of the product therein. In certain embodiments, the channel **21ch** may be sized to be slightly larger, i.e., have a sectional height and/or width that is about 0.1–10% greater, than the height and/or width of the product **25**. The channel **21ch** may be formed over all or portions of the length thereof. The elongate product **25** can be held in the channel **21ch** as it travels over the length of the arm **21**.

As shown in FIGS. 8A and 8B, the arm **21** may include a cover member **21c** that covers the floor **21f** and encloses the elongate product **25** therein. In certain embodiments, the channel **21ch** and the cover **21c** may be formed from two or more matable shell members or, alternatively from a housing or a conduit that is positioned on the arm **21** to define an enclosed channel **21ch**. The cover **21c** may be transparent or translucent or include viewing windows along the length thereof so that a machine or operator may view or inspect product flow at desired points (or substantially all or all of the travel path). The cover **21c** may be formed of a solid material. In other embodiments, a permeable or mesh-like cover (not shown) can be used.

Various automated detectors can be placed at desired locations along the arm to verify proper operation and to render an alert when an abnormality is indicated. Examples of such detectors include optical detectors (infrared or otherwise that respond to changes in visual intensity or generated light beams), flow meters, pressure meters, temperature sensors, and the like.

As shown in FIG. 5A, the winding mechanism **30** is configured to approach the arm **21** from the lower or bottom surface. As such, the winding mechanism **30** can be attached, directly or indirectly, to one or more of the bottom side (lower primary surface) and/or one or more sides (minor surfaces) of the arm **21**. FIG. 7 illustrates that the winding mechanism **30'** may alternatively be mounted to approach the arm from the top side. As such, the winding mechanism **30'** can be configured to suspend the arm **21** and may be attached, directly or indirectly, at the upper primary surface and/or one or more sides of the arm **21**. Still other embodiments can be configured so that the winding mechanism **30, 30'** is attached via one or more end portions **21a, 21b**, of the arm (not shown). Combinations of the attachment configurations noted above may also be used.

Referring to FIGS. 5A, 5B, and 9, the winding mechanism **30** may be attached at an intermediate position at one or more attachment locations, the attachment locations being a

distance away from each of the first and second end portions **21a, 21b**. Although the winding mechanism may be attached to the arm **21** at any desired length from the respective end portions **21a, 21b**, in particular embodiments, the winding mechanism **30** is attached at a primary pivot location that is located inward of the ends of the arm, typically at a location that is inward at least about 20% of the length of the arm (away from each of the ends of the arm). The term “primary pivot location” describes the location on the arm **21** at which the winding mechanism drives the repetitive motion of the arm. It can be a single point contact, a plurality of points, or a region or regions, depending on the configuration of the winding mechanism itself. The attachment position/configuration, the length of the arm, and the weight of the arm and product may influence the amount of physical movement needed by the winding mechanism **30** to generate the desired translation at the end portion **21a** of the arm.

FIG. 9 illustrates one embodiment in which the winding mechanism **30** is attached at a primary pivot location **30p** that is approximately centrally located between each of the opposing ends of the arm **21**. That is, it is located to be within about 10% of the middle location of the arm **21**. In certain embodiments, as shown, the arm **21** may also include an initial enclosed entry port **221** (FIG. 11) that is configured to direct the elongated product to travel in its desired substantially linear travel path over the arm **21**. Similarly, the arm **21** may include an exit block member **222** that inhibits through passage of the elongated product **25** thereby facilitating the sideward (discharge) of the elongate product **25**. In other embodiments, the pivot or winding mechanism **30** can be located closer to the discharge port, i.e., proximate to or adjacent the product inlet port **21b**, this position may allow the arm **21** to be shortened (not shown).

Referring to FIG. 10, an exemplary embodiment of a winding mechanism **30** is shown. This figure is a side view of the device shown in FIG. 9. In this embodiment, the winding mechanism **30** comprises a four-bar linkage **33** that is mounted on a stationary mount bracket **34**. The four bar-linkage **33** includes a pivotably mounted rotating link **36**, and a stationary mounted wheel **38**, a center linkage **30L** that is pivotably attached to both the pivotably mounted link **36** and the stationary mounted link **38**. In operation, the link **36** and the center link **30L** define a minor axis of motion control **40** while the wheel link **38** and the center link **30L** define a major axis of motion control **41**. The center linkage **30L** can include upwardly extending threads **39** that can be used to attach the winding mechanism (directly or indirectly) to the arm **21**.

The wheel **38** can be driven by a gear or shaft (not shown) to automatically turn the wheel **38** at a desired speed (constant and/or variable). Generally described, as the wheel **38** turns, the center link **30L** follows the rotation of the wheel **38**, making the center link **30L** move both laterally (indicated by the side-to-side arrows in the upper portion of the linkage) and vertically (indicated by the vertical arrows) all the while limited by the pivotably attached link **36** that limits the lateral motion of the center linkage **30L**. In this way, the winding mechanism **30** causes the arm **21** to travel through a repetitive substantially elliptical pattern **21p** as shown in FIG. 9. Of course any suitable winding mechanism can be employed, including, but not limited to, cam/follower arrangements, pistons (pneumatic or hydraulic), combinations of linkages and any of the above as well as other electromechanical configurations that can generate the desired repeated winding motion.

FIGS. 12A–12C illustrate another embodiment of a winder **20'**. As shown, the arm **21** has two spaced apart floor

support mounting brackets **121**, **122**, a first one **121** positioned proximate the second end portion **21b** of the arm and another second one **122** positioned upstream of the first one **121**. The first mounting bracket **121** has a junction member **125** that is pivotably mounted to two upwardly extending arms **121<sub>1</sub>**, **121<sub>2</sub>**. The junction member **125** supports the arm **21** while cooperating with the winding mechanism **30** so that it allows the arm **21** to move in a multidirectional manner in response to movement of the arm as driven by the winding mechanism **30**.

FIG. **12C** shows that the winding mechanism **30'** is attached to the arm **21** at a primary pivot region **30p** that is upstream of the first floor support mounting bracket **121**. The primary pivot region **30p** is at the attachment position of the winding mechanism linkage **130L** to the arm. As shown in FIG. **12C**, the linkage **130L** includes a fork-like upper portion **130u** that spans the width of the arm **21** and attaches to opposing sides thereof. Similar to the embodiment shown in FIG. **10**, the winding mechanism **30'** shown in FIGS. **12A–12D** causes the arm to move in a substantially elliptical rotational movement pattern. In this embodiment, the winding mechanism **30'** includes a vertically elongate linkage **130L** (such as a piston or rod) that slidably moves through linkage **136** proximate the upper portion of the vertically elongate linkage **130L** and that is connected at the lower portion thereof to a rotational member **138**. As shown by the arrows located adjacent the lower rotational member **138** in FIG. **12D**, in operation, the clockwise rotation of member **138** forces the vertically elongate linkage **130L** to move forward and downward and then rearward and upward relative to the arm **21**. A counterclockwise arrangement may also be used. The movement of the vertically elongate linkage **130L** is further limited or shaped by the movement of the upper linkage **136** that pivots side to side with respect to the arm **21** (indicated by the arcuate arrows proximate the upper link **136**) as the linkage **130L** slides through the block **136b** that cooperates with the upper link **136**. The upper link **136** is pivotably mounted to a block **136b** and is mounted to the platform **122** via stationary mounting bracket **34**. A spring **130s** can be mounted to the platform **122** to help control and/or dampen the movement of the winding mechanism **30'** and/or linkage **130L**. As the linkage **130L** is rotated by the lower linkage **138** it slides upwardly and downwardly through the linkage **136b** that in response pivots in lateral direction relative to the arm **21** to cause the repetitive rotation cycle.

FIGS. **12D–12G** illustrate an additional embodiment of the winding mechanism **20'**. This embodiment illustrates both a different floor or arm configuration (two overlying conveyors with an intermediate food travel path), and a variation on the winding mechanism linkage assembly. Referring to FIG. **12G**, an outer perimeter portion of the rotatable link **138** is shown attached to the lower portion of the link **130L**. As the link **138** rotates, the elongated link **130L** is directed to travel in a multidirectional motion (up and down and sideways). In operation, the rotatable link **138** is substantially constantly rotated or driven by an electric motor. One suitable motor is a ¼ HP 480V three-phase motor having about a 1750 rpm output with a 2.2 ratio.

In addition, as shown in FIGS. **12F** and **12G**, the upper link **136** can be (pivotably) attached to the block **136b** the link **136** can be (pivotably) attached to the platform **122** via a stationary mounting bracket **34**. The spring **130s** can be attached to the lower portion of the linkage **130L** (proximate the connection to the rotatable link **138**) on one end portion and the platform **122** (or bracket **34**) at a location proximate the upper link **136** at the other end portion to help control/

dampen and/or stabilize the motion generated by the winding mechanism **30'**.

FIGS. **12D** and **12E** illustrate an arm configuration that can employ two overlying aligned and vertically spaced apart surfaces that define a roof or ceiling **21r** and a corresponding floor **21f**. In certain embodiments, the roof **21r** and/or floor **21f** may be formed from one or more conveyors (shown as two spaced apart endless conveyors) **23u**, **23l**. The lower conveyor **23l** defines the floor **21f** for food or other item over the arm travel path. The two surfaces **21r**, **21f** that may be defined by conveyors **23u** (roof), **23l** (floor) can be spaced sufficiently apart so as to define a gap therebetween **23g**. The gap **23g** can be sized so as to allow both conveyor primary surfaces (those facing each other) to contact the food in opposing locations in a manner that does not deform the shape of the food as it travels between the two surfaces **21f**, **21r** and/or conveyors **23u**, **23l**, but sufficiently close so as to help guide the food in the travel direction. In other embodiments, the gap **23g** may be such that the roof, ceiling, or upper conveyor resides a distance above the food. The two conveyors **23u**, **23l** may be configured to move at the same speed. In certain embodiments, the speed of the conveyors may be operated between about 2–10 ft/sec, and in particular embodiments, at about 6.5 ft/sec linear movement. The conveyors **23u**, **23l** may be set to vary speed during operation and may be in communication with a variable speed or frequency controller from AC Tech. The drive motor may be configured similar to that described above for the winder mechanism **30**. Although described as two endless conveyors, other configurations can also be used. For example, the floor **21f** and/or roof **21r** can be formed from more than one conveyor. In other embodiments, the roof can be comprised from 2 or more conveyors creating a channel configuration having a triangle or other multi-sided configuration. The floor can also comprise a plurality of conveyors also defining a multi-sided shape (such as a triangle, open square, hexagon, and the like). In addition, portions of the floor and/or ceiling may be configured as stationary components. Combinations of the above may also be used.

In other embodiments, the floor **21f** of the arm **21** can be configured as a “V” or “U” shape (using a conveyor surface formed in that configuration or a plurality of conveyors spaced and oriented to define the desired shape) (not shown) to help hold the food therein as it travels along the arm. Combinations of the above may also be used.

FIGS. **13A–13C** illustrate examples of particular embodiments of transfer support members **50**. As shown in FIG. **13A**, the food transport member **50** may be configured as rod or “stick” **50r**. FIG. **13B** illustrates that the food transport member **50'** may be configured as a pair of separate rods or sticks **50r1**, **50r2**, that are vertically spaced apart and aligned. The two rods **50r1**, **50r2** may be optionally attached as shown by the broken line **50att** feature in FIG. **13B**. In this embodiment, the winder arm **21** can be configured to travel through a winding path that has a sufficient vertical distance so as to encompass or encircle both of the rods **50r1**, **50r2**. FIG. **13C** illustrates that the transport member **50'** can include a contiguous body or a shape or configuration that extends below the upper portion as there is no longer any requirement that the transport member be inserted into hooks to remove the suspended product therefrom. The contiguous body may be solid, perforated, formed, or configured to reduce weight. Similarly, the transport member **50** may include one or more handles **50h** or other externally accessible handling means disposed along the length and/or at selected end portions thereof to promote

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ease of handling to transport the loaded member to another active station. It will be appreciated by those of skill in the art that the present invention now allows a number of different configurations that can act as suitable support members **50**, **50'**, **50''** and the present invention is not limited to the embodiments described herein. In addition, in operation, a plurality of transfer support members, of the same or different configurations, may be sequentially (manually or automated) serially loaded and removed by aligning them with the winder **20**.

FIG. **14A** illustrates that the distal end portion **21a** of the arm **21** can be configured with an end guide **322** that helps to direct the movement of the food as it exits off the arm **21** during the winding operation as the arm moves in its desired winding motion pattern. In operation, the elongated item **25** (shown in broken line) travels through an aperture **322a** defined by the end guide **322**. The guide **322** may have an outer perimeter that is looped and defines a tongue **322t** with an open center. FIG. **14B** illustrates an alternate embodiment of an end guide **322'**. The guide **322'** includes an inwardly oriented tongue **322t'** that defines the aperture **322a'** and spaced apart prongs **322p<sub>1</sub>**, **322p<sub>2</sub>**. In this embodiment, in operation, the food **25** travels outwardly over the perimeter innermost portion of the tongue **322t**. Other configurations of guides **322**, **322'** may also be used. The end guide **322**, **322'** is illustrated with the arm configuration that employs a ceiling or roof and floor **21f**, **21r**; however, the end guide **322**, **322'** is not limited thereto and may be used with any desired arm configuration. In certain embodiments, the end guide **322**, **322'** may be positioned proximate to and substantially vertically aligned with the floor **21f**. In other embodiments, the end guide **322**, **322'** may be configured to extend outwardly at a vertical level that is below the floor **21f**. In yet other embodiments, the end guide **322**, **322'** may be configured to rise above the floor **21f**.

FIGS. **15A** and **15B** illustrate exemplary winding motion patterns **21p**, **21p'** contemplated by certain embodiments of the instant invention. FIG. **15A** illustrates a pattern **21p** that is substantially constant over the winding of the length of the loading member **50** and that the arm **21** can be held substantially planar (horizontal) as it moves through the winding motion. FIG. **15B** illustrates that a variable winding motion pattern **21p'** can be generated. As shown, the winding pattern **21p'** increases or amplifies from left to right to have greater minima and maxima height **21h<sub>1</sub>**, **21h<sub>3</sub>** at various positions along the loading member (or between different loading members or products and/or can increase from left to right). FIG. **15B** also illustrates that the arm **21** may be inclined during the winding operation (the arm can also be declined or operated at various times to be a combination of inclined, declined, or level. In addition, the winding pattern **21p**, **21p'** can vary in other manners (shape or pattern) along the length of winding a particular loading member **50** or vary for each or selected loading members or products.

The foregoing is illustrative of the present invention and is not to be construed as limiting thereof. Although a few exemplary embodiments of this invention have been described, those skilled in the art will readily appreciate that many modifications are possible in the exemplary embodiments without materially departing from the novel teachings and advantages of this invention. Accordingly, all such modifications are intended to be included within the scope of this invention as defined in the claims. In the claims, means-plus-function clauses, where used, are intended to cover the structures described herein as performing the recited function and not only structural equivalents but also equivalent structures. Therefore, it is to be understood that

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the foregoing is illustrative of the present invention and is not to be construed as limited to the specific embodiments disclosed, and that modifications to the disclosed embodiments, as well as other embodiments, are intended to be included within the scope of the appended claims. The invention is defined by the following claims, with equivalents of the claims to be included therein.

That which is claimed is:

**1.** A method for loading a carrier member with suspended elongated product, comprising:

straddling suspended elongated product over a carrier member having a width and length so that portions of the elongated product are serially draped over the carrier member along a desired length thereof, the straddling being carried out so that the draped elongated product defines suspension regions that contact the carrier member between lengths of the elongated product that hang a distance down from opposing sides of the carrier member;

automatically moving at least one of the suspended regions on the carrier member in a predetermined direction at a first time; then

automatically moving another one of the at least one of the suspended regions on the carrier member in the predetermined direction at a second time; and

repeating the first and second moving steps so that serially consecutive suspension regions are more closely positioned together on the carrier member.

**2.** A method according to claim **1**, further comprising automatically unidirectionally translating the carrier member during the straddling and moving steps, the translation direction of the carrier member corresponding to the predetermined direction of the movement of the suspended regions provided by the first and second moving steps.

**3.** A method according to claim **2**, wherein the direction of the first and second moving steps and the translating step is forward.

**4.** A method according to claim **2**, wherein the direction of the first and second moving steps and the translating step is rearward.

**5.** A method according to claim **1**, wherein the first and second moving steps are carried out using a packing arm that automatically moves through a predetermined stroke cycle that includes longitudinal forward and rearward travel, the method further comprising maintaining the carrier member substantially horizontal and at a predetermined height below the packing arm during the first and second moving steps while the packing arm moves through its predetermined stroke cycle.

**6.** A method according to claim **5**, wherein the first and second moving steps are automatically repeated at desired intervals with an automated mechanism operably associated with the packing arm.

**7.** A method according to claim **6**, wherein the automated mechanism is configured and positioned to cooperate with the carrier member to cause a product contact member to automatically travel repeatedly in a travel pattern proximate the carrier member whereby the product contact member serially travels down to contact the product on the carrier member, generally horizontally to push the product in a predetermined direction along the carrier member, and then up above the product while moving in a direction opposing the predetermined direction to return to a starting location of the travel pattern.

**8.** A method according to claim **7**, wherein the product contact member repeatedly automatically travels through the travel pattern during the straddling step.



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9. A method according to claim 1, wherein the first and second moving steps are carried out by automatically longitudinally pushing serially successive spaced apart suspended regions forward along a length direction of the carrier member while the carrier member is moving forward.

10. A method according to claim 1, wherein the first and second moving steps are carried out by automatically longitudinally pushing non-serially successive spaced apart suspended regions forward along a length direction of the carrier member while the carrier member is moving forward.

11. A method according to claim 1, wherein the first and second moving steps are carried out by directly contacting suspended regions with a fork member having downwardly extending spaced apart side members that define a gap space therebetween, the contacting step comprises lowering the fork member so that the side members straddle the carrier member with the carrier member residing in the gap space during the contacting step.

12. A method according to claim 1, wherein the first and second moving steps are carried out by directly contacting a subset of the suspended regions with a fork member having downwardly extending spaced apart side members that define a gap space therebetween, the contacting step comprises lowering the fork member so that the side members straddle the carrier member with the carrier member residing in the gap space during the contacting step.

13. A method according to claim 1, wherein the straddling step has a first associated cadence and the first and second moving steps have a second associated cadence, the method further comprising adjusting the at least one of the first and second cadences.

14. A method according to claim 1, wherein the straddling step is carried out by a winding arm that travels in a predetermined pattern and discharges the food therefrom in a forward direction while the winding arm is traveling through its pattern, wherein the first and second moving steps are carried out by a packing arm that is configured to move rearward and forward in a repetitive packing cycle, and wherein the repetitive packing cycle is performed so that the packing arm serially moves in a rearward direction above the carrier member relative to the direction of the discharged food, then stops for a static interval before it descends to contact the carrier member, moves forward, thereby pushing the suspended region that is located rearward of the packing arm forward, and then rises to complete the packing cycle.

15. A method according to claim 1, wherein the straddling step is carried out so that sections of elongated product form bights having a plurality of non-intersecting bends draped from the carrier member, with serially consecutive bights being draped on opposing sides of the carrier member.

16. A method according to claim 1, wherein the straddling step is carried out so that a plurality of discrete lengths of elongated product are held by the carrier member.

17. A method according to claim 1, wherein the straddling step is carried out so that a continuous length of the elongated product defines a plurality of loops held by the carrier member.

18. A method according to claim 1, wherein the elongated product is an elongated meat product.

19. A method according to claim 1, wherein the first and second moving steps comprise rotating a wheel to cause a linkage to direct a packing arm to travel in a predetermined travel cycle.

20. A method according to claim 19, further comprising stalling the packing arm during the predetermined travel cycle.

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21. A method according to claim 19, wherein the predetermined travel cycle of the first and second moving steps comprises advancing the packing arm to push the product forward along the carrier member, lifting the arm above the product on the carrier member, reversing the direction of travel of the packing arm above the arm is lifted, and stalling the arm for an interval of time while lifted.

22. A method mechanism according to claim 1, wherein the first and second moving steps employ a packing arm that travels in a predetermined travel cycle, wherein, in operation, the carrier member travels automatically in a unidirectional travel path located below the packing arm as the packing mechanism automatically repeatedly travels through its travel cycle.

23. A method according to claim 22, wherein the elongated item is an extruded or stuffed product held in a casing.

24. A method according to claim 22, wherein the elongated item is a meat product.

25. A method according to claim 22, wherein the elongated item is a continuous length of portioned or linked meat.

26. A method according to claim 22, wherein the elongated meat product is a continuous length of non-linked meat.

27. A method packing mechanism according to claim 22, wherein the carrier member is a rod having a length of at least about six feet.

28. A method according to claim 22, wherein, in operation, the packing arm travels a first selected path, the path being two or three dimensional in direction, and the carrier member is cooperably aligned with and below the packing arm, and wherein the carrier member travels in a second open unidirectional path.

29. A method according to claim 22, wherein the carrier member is an elongate rod, the method further comprising: holding a forward edge portion of the carrier member in a first bracket;

automatically advancing the first bracket and carrier member in a generally horizontal orientation during the straddling step; and

providing a second bracket, wherein the second bracket is configured to allow the packing arm to extend there-through so that the packing arm is able to rest against the second bracket and pivot as the packing arm moves through its travel cycle.

30. A method according to claim 1, wherein the first and second moving steps comprise repeatedly moving a packing arm having a fork member in a predetermined motion so that the fork member serially travels in a cycle that includes moving in a first longitudinal direction, descending a desired vertical distance sufficient to cause the fork member to engage a suspended region of product on the carrier member, moving in a second longitudinal direction opposite the first longitudinal direction with the fork member substantially horizontal and parallel to the orientation of the carrier member, then rising a distance to reside above the carrier member.

31. A method according to claim 1, wherein the carrier member is a rod, wherein the packing arm comprises a contact member with horizontally spaced apart downwardly extending first and second fingers, and wherein, in operation, the fingers periodically straddle the carrier member and contact a portion of the suspended product while moving in the predetermined direction to thereby push and/or pull suspended portions of the elongate product closer together on the carrier member.

32. A method of packing a carrier member with at least one suspended product held thereon, comprising

aligning an elongate carrier member comprising at least one suspended elongate product held thereon with a packing arm having an associated length and opposing first and second end portions, the first end portion comprising a contact member;

moving the carrier member generally horizontally; and automatically moving the packing arm so that the contact member pushes the elongate product on the carrier member in a predetermined direction to cause adjacent suspended portions of the at least one elongated item to move closer together on the carrier member.

33. A method according to claim 32, further comprising repeatedly moving the packing arm in a predetermined stroke cycle motion so that the contact member automatically serially moves in a cycle that includes moving in a first longitudinal direction, descending a desired vertical distance sufficient to engage the carrier member, moving in a second longitudinal direction opposite the first longitudinal direction with the contact member substantially horizontal and

parallel to the orientation of the carrier member, then rising a distance to reside above the carrier member.

34. A method according to claim 33, wherein the contact member comprises two spaced apart fingers with a gap space therebetween, the automatically moving the packing arm so that the contact member pushes the elongate product on the carrier member comprises lowering the fingers a distance sufficient to allow the carrier member to enter the gap space and then moving the contact fingers in the predetermined direction to thereby push adjacent suspended portions of at least one elongate product in the predetermined direction on the carrier member.

35. A method according to claim 33, wherein the carrier member has a length direction that is aligned with the predetermined pushing direction of the packing arm, and wherein the packing arm has a longitudinal stroke that longitudinally pushes the product closer together on the carrier member.

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