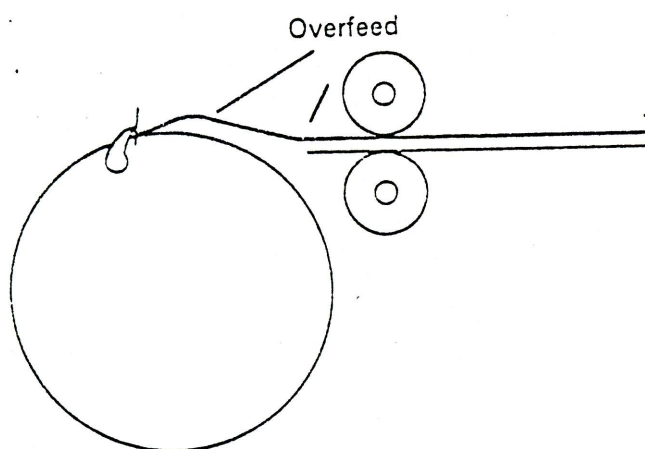


(a) Sheet ready for side lay



(b) Sheet registered against stops (gauge pins) in line with cylinder grippers

*Fig. 142. Operation of roll feed system.*

accurate timing as speeds become greater. Other solutions are directed towards elimination of the reciprocating motion, and it is these which are meeting with considerable success. Rotary gripper in-feed systems are examples of this approach.

One type of rotary gripper in-feed uses a single set of grippers, similar in principle to the swing arm system, built into a skeleton cylinder. The grippers close on the sheet while it is at rest in the register position, then accelerate to cylinder surface speed, transferring the sheet to the impression grippers. The in-feed grippers continue beyond this point, as is the case with the swing arm, but instead of stopping and returning along the same path they complete the full circle to return to the feed plate (*fig. 141*). The feed plate drops a small amount to allow the grippers to pass the register position: they then stop, reverse slightly, and stop to close on the sheet