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**(71) Applicant(s):**

NIPPON ELECTRIC GLASS CO., LTD. [JP/JP]; 7-1, Seiran 2-chome, Otsu-shi, Shiga 5208639 (JP) *(for all designated states)*

**(72) Inventor(s):**

AKIYAMA Shuji; c/o NIPPON ELECTRIC GLASS CO., LTD., 7-1, Seiran 2-chome, Otsu-shi, Shiga 5208639 (JP)

MITSUGI Kaoru; c/o NIPPON ELECTRIC GLASS CO., LTD., 7-1, Seiran 2-chome, Otsu-shi, Shiga 5208639 (JP)

NISHIJIMA Koji; c/o NIPPON ELECTRIC GLASS CO., LTD., 7-1, Seiran 2-chome, Otsu-shi, Shiga 5208639 (JP)

**(74) Agent(s):**

SHIROMURA Kunihiko; Ehara Patent Office, 15-26, Edobori 1-chome, Nishi-ku, Osaka-shi, Osaka 5500002 (JP)

**(54) Title (EN):** WORKPIECE CONVEYANCE METHOD AND WORKPIECE CONVEYANCE DEVICE

**(54) Title (FR):** PROCEDE DE TRANSPORT DE PIECE A USINER ET DISPOSITIF DE TRANSPORT DE PIECE A USINER

**(54) Title (JA):** ワークの搬送方法、及びワークの搬送装置

**(57) Abstract:**

**(EN):** This workpiece conveyance method is for imparting a conveyance force (F) on a workpiece (1) to convey the workpiece (1) in a predetermined direction while supporting the workpiece (1) by means of free rollers (11), and is characterized by imparting a rotary supplemental force (f) on the free rollers (11) in the direction of rotation during conveyance of the workpiece (1) by means of imparting a fluid flow.

**(FR):** La présente invention concerne un procédé de transport pour impartir une force de transport (F) sur une pièce à usiner (1) pour le transport de la pièce (1) dans une direction prédéterminée tout en assurant le support de la pièce (1) au moyen de rouleaux libres (11), et caractérisé en ce qu'il impartit une force de rotation supplémentaire (f) sur les rouleaux libres (11) dans la direction de rotation lors du transport de la pièce (1) par la fourniture d'un débit de fluide.

**(JA):** 本発明に係るワークの搬送方法は、ワーク(1)に搬送力(F)を付与して、ワーク(1)をフリーローラ(11)で支持しながら所定の方向に搬送するための方法であって、流体の流れを与えることにより、フリーローラ(11)に、ワーク(1)の搬送時に回転する向きに回転補助力(f)を付与することを特徴とする。

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