

TITLE: "An industrial plant and method for the production of an industrial product, in particular an aeronautical component or system"

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DESCRIPTION

Technical field

The present invention is relative to an industrial plant and to a method for the production of an industrial product, in particular an aeronautical component or system.

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More specifically, the present invention is relative to an industrial plant and to a method according to the preamble of the appended independent claims.

Technological background

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The use of industrial methods and plants for the production of an industrial product, in particular an aeronautical component or system, is widely known.

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These methods and plants typically involve a plurality of operating stations, each of which is suited to perform, on an aeronautical component or system, a production activity, which can be a step to process, transform or assemble the component or system.

Though, said industrial methods and plants according to the prior art have some drawbacks.

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One drawback consists in the fact that, especially in the aeronautical field, the operating stations and the production activities associated therewith are generally numerous and complex to be managed, in terms of handling, during a working process. As a matter of fact, the articles to be subject to processing are bulky and therefore difficult to move and deal with during their transportation through the operating stations of a production line. Generally, this aspect requires the operating stations to

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be arranged at a single level or working surface and the industrial products to be moved through the different operating stations by means of overhead cranes and/or slings.

5 Therefore, in order to perform the production method, in particular in the aeronautical field, there has to be a processing area that requires a free space extending, as a whole, in a horizontal direction; this condition leads to the drawback of necessarily having at one's disposal large
10 industrial areas for the installation of the plants.

Secondly, the use of overhead cranes and slings often leads to difficulties in securing the plant. This drawback, in particular, is relative to the safety of those operators that manually handle the industrial products when they have
15 to be fixed on the overhead cranes or slings.

According to the prior art, JP 62 063053 A describes a crane, which supports a vertically mobile lifting surface and it is suited to receive a semifinished product, a robotized apparatus being activated by a human operator
20 standing on the lifting surface itself. The semifinished product is delivered to a numerical control tool machine by means of the robotized apparatus, so that said semifinished product is subject to processing. Subsequently, at the end of the processing step, the semifinished product is removed
25 from the numerical control tool machine by means of the robotized apparatus. In this way, the operations are performed in a sequential manner and, therefore, the finished product is obtained at the end of the production cycle.

30 Nevertheless, the technical solution suggested by JP 62 063053 A requires the presence of a human operator on the lifting surface in order to act on the robotized

apparatus, thus requiring a manual command or activation for the movement of the moving system associated with the semifinished product itself.

Summary of the invention

5 The object of the present invention is to provide a method and a plant that are able to solve these and other drawbacks of the prior art and that, at the same time, can be produced in a simple and economic manner.

10 According to the present invention, this and other objects are reached by means of a plant and of a method having the features set forth in the appended independent claims.

15 The appended claims are an integral part of the technical teachings provided in the description with reference to the present invention.

Brief description of the drawings

20 Further features and advantages of the present invention will be best understood upon perusal of the following detailed description, which is provided by way of example and is not limiting, with reference to the accompanying drawings, which specifically show what follows:

25 - figure 1 is a prospective top view showing an industrial plant according to a first embodiment of the present invention;

 - figure 2 is a partial lateral prospective view of the plant shown in figure 1;

30 - figure 3 is a schematic lateral view of a moving system of the industrial plant shown in the previous figures;

 - figure 4 is a section view of the moving system shown in figure 3 obtained through the section line IV-IV; and

- figure 5 is a flowchart representing the functional connections of the industrial plant shown in the previous figures.

Detailed description of the invention

5 With reference to figure 1, number 10 indicates, as a whole, an industrial plant according to an embodiment of the present invention. Plant 10 is suited to manufacture an industrial product, advantageously but not necessarily an aeronautical component or system, for example including a
10 wing of an aircraft.

 In particular, in the case of the wing of an aircraft, the industrial product comprises a semifinished product, which, at the end of the production cycle, will make up the finished wing and also includes a so-called jig, which
15 consists of a substantially framework-like support element, for example shaped as a frame or as a tray, on which the semifinished product is fixed and supported during the transportation through the different operating stations (these details are not shown). In the aeronautical field,
20 in particular, the use of the jig is advantageous, since it also provides a univocal reference system for the processing and assembling steps to which the semifinished product is subsequently subject in order to build the finished wing. Therefore, preferably, the industrial
25 product always remains coupled to the relative jig until the end of the working process to which it is subject.

 The industrial product is associated with a processing cycle or process, which includes a plurality of predetermined production activities. Please note that, by
30 way of non limiting example, in figure 1 said jig is shown in a schematic manner and, in particular, forms a frame that is adapted to surround the industrial product while

the working process is carried out, said jig being associated with reference number 11.

As shown in figures 1 and 2, plant 10 comprises a plurality of first operating stations 12, which are placed
5 at a first level or height H1, and a plurality of second operating stations 14, which are placed at least at a second level or height H2, which is higher than said first level H1. Each one of said operating stations 12 and 14 is suited to carry out at least one of said production
10 activities on said industrial product. In the embodiment shown, the first level H1 is substantially arranged at the height of the ground.

In the description and in the appended claims, the term "production activities" substantially indicates any
15 kind of manufacturing, processing, forming, transforming, assembling and storing activities to which the industrial product can be subject during its working process. These activities can include, for example, a mechanical operation, a thermal treatment, the application of a
20 coating, a chemical process, an assembly step, a temporary storage or the like. Preferably, operating stations 12 and 14 are suited to perform production activities for complex industrial products, for example production activities for a wing of an aircraft that is constrained on the jig and
25 has to be moved through the different operating stations.

Furthermore, the term "production activity" can also indifferently refer to

- completely automatized activities, and/or
- activities that, in order to be performed, require the
30 presence of one or more operators on the machines or tools that are suited to act on the industrial product during the working process, and/or

- "mixed-type" activities comprising the two types of activities mentioned above.

Even though the working process can comprise one (or more) storing activities, according to the present invention at least one of the above-mentioned production activities is a manufacturing, processing, forming, transforming and assembling activity of the industrial product.

Therefore, the industrial product is adapted to move through different operating stations 12, 14 of plant 10 and remain there based on a predetermined order that is established as a function of the sequence of production activities defined by the working process to which said industrial product has to be subject.

Plant 10 comprises a moving system 16, which is configured to transport said industrial product, by lifting and/or lowering it, from at least one operating station 12 to at least one second operating station 14. Clearly, the first operating station 12 and the second operating station 14 can indifferently play the role of "departure" station, in which at least one previous production activity is performed, and the role of "arrival" station, in which at least one following production activity is performed. In other words, moving system 16 is built so as to equally transport the industrial product from a first station 12 to a second station 14 or from a second station 14 to a first station 12. Thanks to these features, plant 10 can also extend in a vertical direction with two or more working surfaces and, therefore, has a multi-level structure that takes up a reduced space in a horizontal direction.

Preferably, the first operating stations 12 are supported by a base working surface, for example a base

platform 18, whereas the second operating stations 14 are supported by at least one higher working surface, for example a higher platform 20. In the embodiment shown, base platform 18 and higher platform 20 are separate and spaced
5 apart by a plurality of support columns 22 (only some of them are numbered), which are vertically interposed between platforms 18, 20 themselves.

Optionally but advantageously, higher platform 20 and - if necessary - base platform 18 are provided with
10 peripheral rails (not numbered), which are arranged in correspondence to at least one portion of the respective periphery.

Preferably, moving system 16 substantially operates in a manner similar to that of a stacker crane.

15 In the embodiment shown, the first operating station 12 are arranged in a pair of first rows (not numbered), between which moving system 16 is able to slide. Preferably, the second stations 14 are also arranged in a pair of second rows (not numbered), which are arranged in a
20 corresponding manner above said first rows and between which moving system 16 is able to slide. In particular, the sliding movement of moving system 16 between the first and the second rows of operating stations 12, 14 substantially consists in a translation, which, for example, follows a
25 straight line.

Preferably, close to the second operating stations 14, higher working surface 20 has a passage or longitudinal corridor 24, through which said moving system 16 is able to pass close to said second operating stations 14. In the
30 embodiment shown, passage 24 is arranged between the second rows of the second operating stations, spacing them apart, and moving system 16 can slide therein in a guided manner.

In the embodiment shown, passage 24 has the shape of a slot or slit obtained on higher platform 20 and extending only along a portion of the latter. In other embodiments, the passage can be continuous and extends in a continuous manner through the higher working surface, thus creating a pair of lateral platforms, which are separate from one another and extend along opposite sides of the passage. If necessary, the lateral platforms can be arranged at different working heights.

Furthermore, moving system 16 comprises a support structure 26, which can slide in a guided manner on a guide rail (not numbered) of the mechanical or inductive type, which extends along operating stations 12. By way of example, the guide rail can extend between said first rows, thus laterally spacing them apart. The sliding movement of the support structure on the guide rail advantageously takes place by means of driving organs, for example of the electric type. In the embodiment shown, the guide rail extends on base platform 18 in a position corresponding to longitudinal passage 24, whereas support structure 26 extends - and can be moved, if necessary, in a guided manner - along said longitudinal passage 24.

Preferably, support structure 26 is configured as a framework or "skeleton" comprising, for example, a plurality of columns or uprights 27, which are connected to one another by a corresponding plurality of crosspieces 29.

Furthermore, moving system 16 comprises a transport assembly 28, which is indicated with number 28 and can vertically slide (for example by being lifted and lowered in a direction that is substantially orthogonal to platforms 16, 18) in a guided manner on support structure 26, so as to reach the different levels or working heights

H1, H2. In the embodiment shown, the transport assembly 28 is mounted so as to slide in a guided manner on uprights 27, for example in a controlled manner by means of driving organs of the known type, which, for the sake of simplicity, are not shown. transport assembly 28, therefore, is suited to pick up, by being lowered and lifted, the industrial product and move it from at least one of said first operating stations 12 to at least one of said second operating stations 14.

10 In the embodiment shown, transport assembly 28 comprises a support element or board 30, which is suited to vertically move in a guided manner on support structure 26, and a pick-and-place assembly 32, which can be transversely moved in a guided manner on support element 30, for example
15 by means of driving organs of the known type, which, for the sake of simplicity, are not shown.

Preferably, pick-and-place assembly 32 is able to extend on opposite sides of support element 30, thus sliding from one side to the other of the latter, so as to
20 be able to pick up and deliver an industrial product in correspondence to operating stations 12, 14 that can also be arranged on opposite sides of support structure 26 itself.

In more simple embodiments, pick-and-place assembly 32
25 can be configured so as to extend and operate on one single side of support element 30. For example, this can occur when the first operating stations 12 are arranged in a single first row and the second operating stations 14 are arranged in a single second row placed above said first
30 row; in this way, pick-and-place assembly 32 can be arranged on the side of support element 30 that simultaneously faces the first and the second row of

operating stations 12, 14.

In the embodiment shown, pick-and-place assembly 32 fulfills the task of picking up and delivering the industrial product, so as to move it from a first operating station 12 to a second operating station 14, which are arranged on base platform 18 and on higher platform 20 respectively.

According to further embodiments, pick-and-place assembly 32 can be configured so as to be mobile, in a guided manner, in any direction on a plane defined by support element 30, so as to be able to extend beyond the latter in the desired position, thus allowing a great flexibility and freedom in the movements performed to pick up and deliver the industrial product between different operating stations 12, 14.

For example, the pick-and-place assembly comprises a plurality of retractable forks 32, which are configured to transversely extend beyond support element 30, so as to be arranged under the industrial product to be supported during the movement. In the embodiment shown, each fork 32 comprises a plurality of segments 32a, 32b with an oblong shape, which can be extended in a controlled manner by means of driving means (not shown for the sake of simplicity) in a transverse direction with respect to the vertical direction of transport assembly 28. By way of example, segments 32a, 32b can have a tubular shape and can slide one on top of the other. In other embodiments, these segments can be configured in a telescopic manner. In the embodiment shown, segments 32a, 32b are two; though, retractable forks 32 can be used, which are provided with three or more segments. In particular, the first segment indicated with 32a is a base segment, which is mounted so

as to transversely slide, in a guided manner, directly on support element 30, whereas the second segment indicated with 32b is an end segment 32b, which is mounted so as to transversely slide, in a guided manner, directly on base segment 32a. As shown in the figures, the sliding direction of the first and of the second segment 32a, 32b conveniently is the same.

Preferably, retractable forks 32 are of the bidirectional type or of the duel-inlet type, which means that they can be moved, in a guided manner, from one side to the other of support element 30, so that they are able to indifferently pick up and deliver the industrial product on one side or the other of the support structure 26. In figures 3 and 4, retractable forks 32 are positioned in correspondence to a first side, arranged on the left, of support element 30 and can be moved so as to slide towards the opposite side, arranged on the right, in order to assume a configuration that is substantially symmetrical to the one shown.

Preferably, the pick-and-place assembly is provided with at least one abutment element 34, which is suited to be coupled to a respective engagement organ obtained in the industrial product, so as to allow its correct positioning during pick-up and transport operations. More preferably, abutment element 34 is supported by at least one retractable fork 32. Even more preferably, abutment element 34 is supported by at least one end segment 32b. In the embodiment shown, at least one end segment 32b is provided with a plurality of abutment elements 34, which are used to correctly position or center the industrial product on retractable forks 32. For example, in case of an industrial product including a jig and an aeronautical semifinished

product, abutment elements 34 can be coupled to corresponding engagement organs supported by the jig itself.

Preferably, the abutment elements comprise a plurality
5 of projections or truncated cone-shaped pins 34 and the engagement organs comprise a plurality of seats (not shown), which are adapted to receive said projections 34.

Preferably, transport assembly 28 comprises a proximity sensor apparatus 36, which is suited to provide a
10 signal indicating the presence of obstacles in the direction in which said transport assembly 28 is able to pick up and/or deliver said industrial product. More preferably, pick-and-place assembly 32 is provided with said proximity sensor apparatus 36, which, therefore, is
15 suited to provide a signal indicating the presence of obstacles in the transverse movement and transportation direction of pick-and-place assembly 32. Based on said signal, the moving system allows or inhibits the movement of transport assembly 28 and, in particular, of pick-and-
20 place assembly 32 according to predetermined operating modes. For example, if proximity sensor apparatus 36 detects the presence of objects or people located in the transverse movement and transportation direction of pick-and-place assembly 32, moving system 16 inhibits its
25 activation.

In particular, at least one of forks 32 supports proximity sensor apparatus 36, which is suited to provide a signal indicating the presence of obstacles in the extension direction of fork 32; in the embodiment shown,
30 the proximity sensor apparatus comprises at least one pair of sensors 36, which are arranged on longitudinally opposite sides of fork 32. Advantageously but not

necessarily, sensors 36 are arranged on longitudinally opposite sides of segment 32b.

In the embodiment shown, when pick-and-place assembly 32 holds or supports the industrial product in order to
5 move it between one of the first operating stations 12 and one of the second operating stations 14, said pick-and-place assembly 32 is adapted to move along passage 24 during the transportation between working surfaces or platforms 18 and 20. In this way, the handling of the
10 industrial product is performed with minimal and optimized movements, so that bulky and heavy industrial products, such as the industrial products of the aeronautical field, can be easily handled.

With reference in particular to figure 2, each
15 operating station 12, 14 is associated with a safety barrier 38, which is suited to assume an active condition or position and an inactive condition or position. In the active condition or position, safety barrier 38 prevents moving system 16 from accessing respective operating
20 station 12, 14, for example by separating respective operating station 12, 14 from transport assembly 28 and, in particular, from pick-and-place assembly 32. On the other hand, in the inactive condition or position, safety barrier 38 allows said moving system 16 to access respective
25 operating station 12, 14, for example by allowing pick-and-place assembly 32 to move towards respective operating station 12, 14.

In the embodiment shown, safety barrier 38 comprises an obstacle of the physical type, which is adapted to be
30 interposed in the space arranged between moving system 16, especially pick-and-place assembly 32, and respective operating station 12, 14, when said safety barrier 38 is in

the active position, and, respectively, to free the space arranged between moving system 16, especially pick-and-place assembly 32, and respective operating station 12, 14, when said safety barrier 38 is in the inactive position.

5 Alternatively, the safety barrier can be conceived as a "virtual" barrier, such as an electronic safety barrier (typically of the optoelectronic type). According to this embodiment, said virtual safety barrier is able to interact with moving system 16, in particular with pick-and-place
10 assembly 32, without physical interposition, but - for example - by means of automatic control logics and/or with the use of sensors. According to a possible embodiment, said "virtual" safety barrier can be programmed to:

- prevent moving system 16 (in particular pick-and-place
15 assembly 32) from accessing respective operating station 12, 14, when said barrier is in the active condition; and
- allow moving system 16 (in particular pick-and-place assembly 32) to access respective operating station 12, 14, when said barrier is in the inactive condition.

20 Preferably, the safety barrier comprises a shutter 38, which is arranged between respective operating station 12, 14 and the area to which transport assembly 28, especially by pick-and-place assembly 32, is able to approach. In the active position shutter 38 is lowered, whereas in the
25 inactive position it is lifted. The movement between the active position and the inactive position of safety barrier 38 can be motorized, for example it can be manually controlled by the operators assigned to respective operating station 12, 14 or automatically controlled
30 according to predetermined modes. In the embodiment shown, each shutter 38 is supported by base platform 18 or by higher platform 20, based on whether it protects one of the

first operating stations 12 or one of the second operating stations 14. By way of example, shutter 38 can be supported by a structure substantially having the shape of a portal and delimited by a pair of lateral uprights 40 projecting from platform 18 or 20, between which a winding organ (not numbered) extends, around which shutter 38 can be wound when it is lifted towards the inactive position and unwound when it is lowered towards the active position.

Preferably, with reference in particular to figure 3, plant 10 comprises a central control system 42, which is suited to control operating stations 12 and 14 and/or moving system 16.

In particular, control system 42 is configured to control at least moving system 16 by automatically moving the industrial product between the operating stations as a function of a predetermined principle and based on the state of occupancy of the operating stations 12, 14. For example, control system 42 can be configured so as to control moving system 16 in such a way that it automatically transports (without the need for a human operator to intervene giving manual commands to moving system 16) the industrial product from a departure operating station 12, 14 to an arrival operating station 12, 14 as a function of a so-called predetermined production "takt time" corresponding to the respective production activity that departure operating station 12, 14 is suited to perform.

As a person skilled in the art can clearly understand, the term "takt time" generally identifies the industrial product production time that is sufficient to cover the demand for the industrial product requested. In other words, the takt time substantially is "the productive speed

or rate" with which the industrial product has to be manufactured in order to satisfy the demand for the industrial product within the desired amount of time. In this case, once a takt time associated with the working
5 process for the industrial product has been determined, a respective takt time is established for each production activity.

In particular, at the end of the takt time of a production or assembling activity, moving system 16
10 automatically moves the industrial product from departure operating station 12, 14 (associated with the production activity) to arrival operating station 14 (associated with the production activity that has to be performed next in the processing sequence).

In the embodiment shown, plant 10 comprises, furthermore, a memory system 44 (preferably a remote one), which is connected to central control system 42 and is suited to store data representing the production activities being carried out or carried out on the industrial product
20 by operating stations 12 and 14 or by moving system 16 or by both. Thanks to these features, all the production activities involved in the manufacturing process of the industrial product can be tracked down.

In the embodiment shown, central control system 42 is
25 provided with a dedicated data processing (sub)network, which is connected to operating stations 12 and 14 and/or to moving system 16 and, furthermore, communicates with a LAN network so as to store (perform a back-up of) all the representing items of information mentioned above.

30 For example, central control system 42 can be suited to control the movement of transport assembly 28 of moving system 16 based on the signals provided by sensor apparatus

36. In particular, central control system 34 is able to inhibit and enable an undesired extension of forks 32, when sensors 36 detects that safety barrier 38 respectively is in the active position, thus providing an inhibition
5 signal, and in the inactive position, thus providing an enabling signal. In the embodiment shown, the movement of forks 32 is inhibited and enabled when shutter 38 is respectively lowered and lifted.

Now we will describe a method to produce an industrial
10 product according to an explanatory embodiment of the present invention. By way of example, the method will be described with reference to plant 10 shown in the figures. Though, as a person skilled in the art can clearly understand, this method can also be used in different
15 plants.

The method comprises a plurality of production activities, which are performed on the industrial product in operating stations 12 and 14. During this method, the industrial product is transported between operating
20 stations 12 and 14, which are arranged at different levels or heights H1, H2, by means of a moving system, for example by means of moving system 16.

During this method, the moving system slides in a guided manner between operating stations 12 and 14. In the
25 embodiment described, moving system 16 slides between the first rows of operating stations 12 and the second rows of the operating stations 14, for example through the guide rail.

Let's consider the case in which a first "departure"
30 operating station 12 has ended a previous production activity to be performed on the industrial product and the latter has to be subject to a following production activity

that has to be performed by a second "destination" operating station 14, which is arranged in a higher position with respect to the first operating station 12.

During a first step, moving system 16 is moved, in a guided manner, between the first operating stations 12, until it is in correspondence to the first "departure" operating station 12. In case moving system 16 already is in correspondence to the first "departure" operating station 12, this step can clearly be left out.

In the embodiment described, the moving system is moved between said pair of rows of first operating stations 12. Preferably, in this first step, the movement of moving system 16 is performed by causing its support structure 26 to slide on the guide rail. In the embodiment described, the top part of support structure 26 also slides within passage 24 arranged between the second pair of rows of the second operating stations 14.

Simultaneously with the movement described above, moving system 16 places itself so as to cause transport assembly 28 to be arranged in correspondence to height H1 of the first "departure" operating station 12. In the embodiment described, transport assembly 28 is moved in a guided manner through passage 24, for example on the uprights 27, so as to reach height H1 of the first "departure" operating station 12. If transport assembly 28 already is at height H1 of the first "departure" operating station 12, this step can clearly be left out.

Therefore, in this first step, there advantageously is a sliding translation of support structure 26 on the guide rail and, simultaneously, a vertical translation of support assembly 27 on support structure 26.

In a second step, moving system 16 picks up, from the

first "departure" operating station 12, the industrial product to be transported to the second "destination" operating station 14. Preferably, if sensor apparatus 36 does not detect obstacles and safety barrier 38 associated with the first "departure" operating station 12 is in the inactive position, pick-and-place assembly 32 shifts from a retracted position, in which it does not transversely project beyond support element 30 (hence, beyond support structure 26), to an extended condition, in which it transversely projects with respect to support element 30 (hence, with respect to support structure 26) and is adapted to pick up the industrial product. In this last case, pick-and-place assembly 32 is arranged under the industrial product to be lifted and supported during transportation. Preferably, abutment elements 34 are housed in corresponding recesses created in the bottom of the industrial product (for example in the bottom of the jig). After the industrial product has been successfully picked up, pick-and-place assembly 32 goes back to the retracted position, dragging the industrial product inside support structure 26.

During a third step, moving system 16 is moved, in a guided manner, between the second operating stations 14, until it is in correspondence to the second "destination" operating station 14.

In the embodiment described, moving system 16 is moved between said pair of rows of second operating stations 14. Preferably, in this third step, the movement of moving system 16 is performed again by causing support structure 26 to slide on the guide rail. In the embodiment described, support structure 26 also slides within passage 24 arranged between the pair of rows of the second operating stations

14. If the top part of support structure 26 already is in correspondence to the second "destination" operating station 14, this step can clearly be left out.

Simultaneously with the movement described above,
5 transport assembly 28 places itself so as to be arranged in correspondence to height H2 of the second "destination" operating station 14 In the embodiment described, transport assembly 28 is moved in a guided manner, for example on uprights 27, so as to reach height H2 of the second
10 "destination" operating station 14.

Therefore, in this third step, similarly to the first step, there advantageously is a sliding translation of support structure 26 on the guide rail and, simultaneously, a vertical translation of transport assembly 28 on support
15 structure 26.

In a fourth step, moving system 16 delivers the industrial product to the second "destination" operating station 14. Preferably, if sensor apparatus 36 does not detect obstacles and safety barrier 38 associated with the
20 second "destination" operating station 14 is in the inactive position, pick-and-place assembly 32 shifts from the retracted position to the extended condition, thus bringing the industrial product beyond the support structure 26. When the industrial product is decoupled from
25 pick-and-place assembly 32, for example by removing it from abutment elements 34, it is delivered to the second "destination" operating station 14. Subsequently, pick-and-place assembly 32 goes back to the retracted position.

Now the second "destination" operating station 14 is
30 able to perform the following production activity, for which it is suited, on the industrial product.

For the sake of brevity, we have only described the

movement of an industrial product from a first "departure" operating station 12, which is arranged in a lower position, to a second "destination" operating station 14, which is arranged in a higher position. Though, as a person skilled in the art can clearly understand, the roles of operating stations 12 and 14 can be switched; in this case, one can apply the same steps of the method described above, but they have to be performed in a reverse manner (for example by lifting instead of lowering and vice versa).

According to the present invention, the manufacturing method can be more flexible and, therefore, it can be adjusted to possible variations of the production volumes.

As a matter of fact, the production activities to which the industrial product is suited to be subject can be planned and updated in real time while the method is being performed, for example by central control system 34, based on a scheduling determined as a function of the occupation of operating stations 12, 14. In this way, moving system 36 is able to move the industrial product to an operating station 12, 14 suited to perform a production activity according to a predetermined control logic or algorithm, which is conceived so as to optimize the overall time needed by the industrial products to move through plant 10.

Therefore, one can use a progressive matching principle, in which, during the process, each industrial product is destined to be transported to a free "destination" operating station 12, 14 (namely one that is not occupied by another industrial product being processed) and to be associated with a production activity that still has to be performed on the industrial product itself. In this way, the drawbacks caused by machine standstill can be reduced, since the sequence of the production activities

can be redefined each time in real time according to bonds among the production activities and according to the occupation states of operating stations 12, 14.

Furthermore, the reduced occupation of the spaces
5 guaranteed by the present invention allows users to obtain, in plant 10, further areas for "parking" operating stations, where the industrial product can be left and wait between two consecutive operating activities, for example in order to complete the operations for the polymerization
10 of the industrial product.

Furthermore, the use of moving system 16 is advantageous also because it guarantees high standards or working ergonomics. As a matter of fact, it can be configured so as to facilitate the industrial product pick-
15 up and delivery operations in single operating stations 12, 14. For example, the industrial product can be rotated and lifted/lowered in a controlled and "customized" manner as a function of commands given by the operator when pick-and-place assembly 32 is close to operating station 12, 14
20 involved in the pick-up or delivery operations.

Naturally, the principle of the present invention being set forth, the embodiments and the implementation details can be widely changed with respect to what described above and shown in the drawings as a mere way of
25 non-limiting example, without in this way going beyond the scope of protection provided by the accompanying claims.

Furthermore, the plant can also be built on a larger number of levels defined by platforms 18, 20. Furthermore, plant 10 can comprise more than two rows defined by the
30 first operating stations 12 and by the second operating stations 14; in this case, it is preferable to use a plurality of moving system 16 to handle the industrial

products and, if necessary, a corresponding plurality of passages or corridors 24.

CLAIMS

1. Industrial plant (10) for the production of an industrial product, in particular an aeronautical component or system, which is associated to a working process, which includes a plurality of predetermined production activities; at least one of said production activities being one among a manufacturing, processing, forming, transforming and assembling activity of said industrial product; said plant (10) comprising:

- 10 - a plurality of first operating stations (12) and at least a plurality of second operating stations (14), which are respectively placed at a first level or height (H1) and at least at one second level or height (H2), which is higher than said first level (H1); each one of said operating stations (12, 14) being arranged to carry out at least one production activity on said industrial product; and
- 15 - at least one moving system (16) which is configured to transport said industrial product, by lifting and/or lowering it, between at least one of said first operating stations (12) and at least one of said second operating stations (14);

said plant comprising, furthermore, a central control system (34), for controlling at least said moving system (16) by automatically moving said industrial product between said operating stations (12, 14) as a function of a predetermined principle and based on the state of occupancy of said operating stations (12, 14);

said plant being characterized in that said moving system (16) is a stacker crane comprising:

- 30 - a support structure (26) which is movable between said operating stations (12), and
- a transport assembly (28) which is vertically slidable,

in a guided manner, between said first level (H1) and said second level (H2) on said support structure (26) and is arranged to pick up said industrial product and move it from at least one of said first operating stations (12) to
5 at least one of said second operating stations (14);

said transport assembly (28) comprising:

- a support element (30) which is arranged to move vertically, in a guided manner, on the support structure (26), and

10 - a pick-and-place assembly (32) movable in a guided manner on said support element (30), which is able to extend and project from said support element (30) in a direction substantially transverse to the vertical direction, and is arranged to pick up and move said industrial product;

15 said transport assembly (28) further comprising a proximity sensor apparatus (36) which is brought by said pick-and-place assembly (32) and which is arranged to provide a signal indicating the presence of obstacles in the transverse movement and transportation direction of
20 pick-and-place assembly (32) in which said transport assembly (28) is able to:

- pick up said industrial product from a departure operating station (12, 14) and/or

- deliver said industrial product to an arrival
25 operating station (12, 14);

at least one of said operating stations (12, 14) being associated with a safety barrier (38), which is arranged to assume:

- an active condition or position, in which said barrier (3
30 8) prevents said moving system (16) from accessing the respective operating station (12, 14), and

- an inactive condition or position, in which said barrier

(38) allows said moving system (16) to access the respective operating station (12, 14);

based on said signal, said central control system (34) being arranged for:

5 - allowing a movement of the pick-and-place assembly (32) when said sensor apparatus (36) detects that the associated safety barrier (38) is in the inactive position, providing an enabling signal, and

- inhibiting a movement of the pick-and-place assembly
10 (32) when said sensor apparatus (36) detects that the associated safety barrier (38) is in the active position, providing an inhibition signal.

2. Plant according to claim 1, wherein said control system (34) is configured so as to control said moving
15 system (16) in such a way that it automatically transports said industrial product from a departure operating station (12, 14) to an arrival operating station (12, 14) as a function of a predetermined production takt time corresponding to the respective production activity that
20 the departure operating station (12, 14) is suited to perform.

3. Plant according to claim 1 or 2 and comprising, furthermore, a memory system (44), which is connected to said central control system (34) and is arranged to store
25 data representing the production activities being carried out or carried out on said industrial product by said operating stations (12, 14) and/or by said moving system (16).

4. Plant according to claim 3, comprising a data
30 processing network, which is connected to said operating stations (12, 14) and/or to said moving system (16).

5. Plant according to claim 4, wherein said data

processing network, furthermore, communicates with a LAN network, which is configured to store said representing data in said memory system (44) located in a remote position with respect to the central control system (34).

5 6. Plant according to any of the preceding claims, wherein said safety barrier is a virtual obstacle able to interact with the moving system (16) without physical interposition.

7. Plant according to any of the preceding claims,
10 wherein said safety barrier is a physical obstacle, which is adapted to

be interposed in the space arranged between the moving system (16) and the respective operating station (12, 14), when said safety barrier (38) is in the active position,
15 and, respectively

free the space arranged between the moving system (16) and the respective operating station (12, 14), when said safety barrier (38) is in the inactive position.

8. Plant according to claim 7, wherein said barrier
20 comprises a shutter (38), which is arranged between the respective operating station (12, 14) and the area to which the moving system (16) approaches; said shutter (38) being respectively lowered and lifted in the active and inactive condition.

25 9. Plant according to any of the preceding claims, wherein said central control system (42) is arranged to control the movement of the moving system (16) based on the signals provided by the sensor apparatus (36).

10. Plant according to any of the previous claims, wherein
30 said control system (34) is adapted to calculate and update in real time, by means of scheduling, the production activity sequence with which to perform the production

activities associated with said working process as a function of said predetermined principle and based on the said conditions of said operating stations (12, 14).

11. Plant according to any of the preceding claims, wherein said pick-and-place assembly (32) is extendable in two directions on opposite sides of said support element (30), so as to be able to pick up and/or place said industrial product on one side or on the other side of said support element (30).

12. Plant according to any of the preceding claims, wherein said pick-and-place assembly comprises a plurality of forks (32) which are arranged to extend and project from said support element, so as to pick up and place said industrial product.

13. Plant according to any of the preceding claims, wherein said pick-and-place assembly (32) is provided with at least one abutment element (34), which is arranged to be coupled to a respective seat obtained in a support framework (11) for housing said industrial product, so as to allow its correct positioning during pick-up and transport operations.

14. Plant according to claim 13, wherein said support framework (11) is a jig, for firmly receiving said industrial product during the execution of the working process through said operating stations (12, 14).

15. Plant according to any of the previous claims and comprising, furthermore:

- a base working surface (18) placed at said first level (H1) and supports said first operating stations (12); and

- at least one higher working surface (20) placed at said at least one second level (H2) and supports said second operating stations (14).

16. Plant according to claim 15, wherein a passage (24), through which said moving system (16) is able to pass close to said second operating stations (14), is placed close to said at least one higher working surface (20).

5 17. Plant according to any of the previous claims and comprising, furthermore, at least one support framework, in particular a jig (11), for firmly receiving said industrial product during the execution of the working process and to be picked up by said moving system (16) through said
10 operating stations (12, 14).

18. Method for producing an industrial product, in particular an aeronautical component or system; said method comprising a plurality of production activities, at least one of them being one among a manufacturing, processing,
15 forming, transforming and assembling activity carried out on said industrial product in a plurality of first operating stations (12) and in at least a plurality of second operating stations (14), which are respectively placed at a first level or height (H1) and at at least one
20 second level or height (H2), which is higher than said first level (H1); said industrial product being transported, between consecutive production activities, by lifting and/or lowering it, from at least one of said first operating stations (12) to at least one of said second
25 operating stations (14);

said method comprising the step of automatically moving said industrial product between said operating stations (12, 14) as a function of a predetermined principle and based on the state of occupancy of said
30 operating stations (12, 14);

characterized in that said method is carried out by actuating an industrial plant according to any of the

preceding claims.