

ABSTRACT

To provide a conveyor system and a conveying method that allow a transport target article to be selectively turned over for conveyance regardless of the size and thickness of the transport target article.

According to the present embodiment, a conveyor system includes a suction device, a moving device, and a control device. The suction device includes a plurality of suction units, each suction unit having an opening and configured to suction a flat transport target article elongated in one direction by negative pressure through the opening. The moving device configured to move the suction device. The moving device includes a turning-over section configured to rotate the suction device about an axis in an approximately horizontal direction. The control device configured to control the suction device and the moving device. When the control device determines that a front side and back side of the transport target article needs to be turned over, the control device controls the moving device and the suction device to suction the transport target article so that an approximate center of the opening of at least one suction unit among the plurality of suction units is located on a first imaginary line, and remaining suction unit is located on one end side in a longitudinal direction of the transport target article with respect to the first imaginary line, the first imaginary line being an imaginary line running through an approximate center between both

ends in a longitudinal direction of an upper surface of the transport target article and approximately parallel to a shorter direction of the upper surface of the transport target article; controls the turning-over section to be in
5 a front-back reversing orientation in which: the remaining suction unit is positioned above the first imaginary line along a gravity direction; another end opposite to one end side of the transport target article in the longitudinal direction suctioned by the remaining suction units is
10 located below the first imaginary line along the gravity direction; and the transport target article is inclined with respect to the gravity direction, and performs control so that suction of the transport target article by the suction units is released after the suction device is in
15 the front-back reversing orientation.