



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification 7 : B29C 47/92, 43/46, 43/58, G01P 3/486	A1	(11) International Publication Number: WO 00/50218 (43) International Publication Date: 31 August 2000 (31.08.00)
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(21) International Application Number: PCT/US00/02444

(22) International Filing Date: 31 January 2000 (31.01.00)

(30) Priority Data:
09/253,709 22 February 1999 (22.02.99) US(71) Applicant: GENERAL ELECTRIC COMPANY [US/US]; 1
River Road, Schenectady, NY 12345 (US).(72) Inventors: REDDY, Suresh, Baddam; 2812 Chablis Drive,
Erie, PA 16506 (US). YORK, John, Arthur; 463 South
Rusto Avenue, Evansville, IN 47714 (IN). VICKERS,
Charles, Ray; 1733 Pleasant Valley Road, Mount Vernon,
IN 47620 (US). SORESENSEN, Donald, Bruce; 5 Droms
Road Extension, Scotia, NY 12302 (US). SARVER, Larry,
David; 7 Hickory Hill Road, New Britain, CT 06052-3740
(US).(74) Agents: SNYDER, Bernard et al.; General Electric Company,
3135 Easton Turnpike W3C, Fairfield, CT 06431 (US).(81) Designated States: JP, SG, European patent (AT, BE, CH, CY,
DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT,
SE).Published
With international search report.

(54) Title: CLOSED LOOP CONTROL OF ROLL SPEEDS IN PLASTIC SHEET EXTRUSION

(57) Abstract

Closed loop control apparatus and methods for reducing ripples in an extruded plastic sheet include, for example, a closed loop speed control system (38) having a roll speed sensor (62), a roll speed controller (64), and a roll drive (66). The roll speed sensor is communicatively coupled to the active extruder roll (20) and configured to determine an actual roll speed of the active extruded roll. The roll speed controller is communicatively coupled to the roll speed sensor and utilizes the actual roll speed and desired roll speed to generate a command signal and transmit such signal to the roll drive. The roll drive is communicatively coupled between the roll speed controller and the active extruder roll, and utilizes the command signal to drive the active.

