

**METHOD AND APPARATUS FOR REDUCING NOISE GENERATED BY THE
ACCUMULATION OF CARRIERS IN A CONVEYOR SYSTEM**

ABSTRACT OF THE DISCLOSURE

An apparatus and method for reducing the noise generated by colliding conveyor carriers is disclosed which comprises urethane bumpers and a method of attaching same to portions of the carriers that do not make contact with other carriers when the carriers are accumulated. The bumpers extend from the carriers a sufficient distance to contact a similar bumper on an adjacent carrier when one carrier rolls up against another. The bumpers do not prevent the normally contacting portions of the carriers from coming into contact, but merely absorb a portion of the kinetic energy of the moving carrier to reduce the noise generated when the contacting portions of the trolleys do meet, and the presence of these bumpers does not adversely affect the spacing of the carriers in the accumulation line.

Figure 3

