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(54) **POWDER CONVEYING DEVICE AND IMAGE FORMING APPARATUS INCORPORATING SAME**

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(57) **ABSTRACT**

A powder conveying device includes a drop conveyance passage, an intersecting conveyance passage, a conveying screw, and a floating member. Powder entering from an inflow port drops in the drop conveyance passage. The intersecting conveyance passage communicates with a lower end of the drop conveyance passage and extends in an intersecting direction that intersects the drop conveyance passage. The conveying screw is disposed in the intersecting conveyance passage and rotates in a specified direction to convey the powder in the intersecting direction. The floating member is movably installed in the drop conveyance passage and floats in the drop conveyance passage to move by contact with the conveying screw. The inflow port and the floating member interfere with each other to prevent the floating member from coming out of the inflow port of the drop conveyance passage.

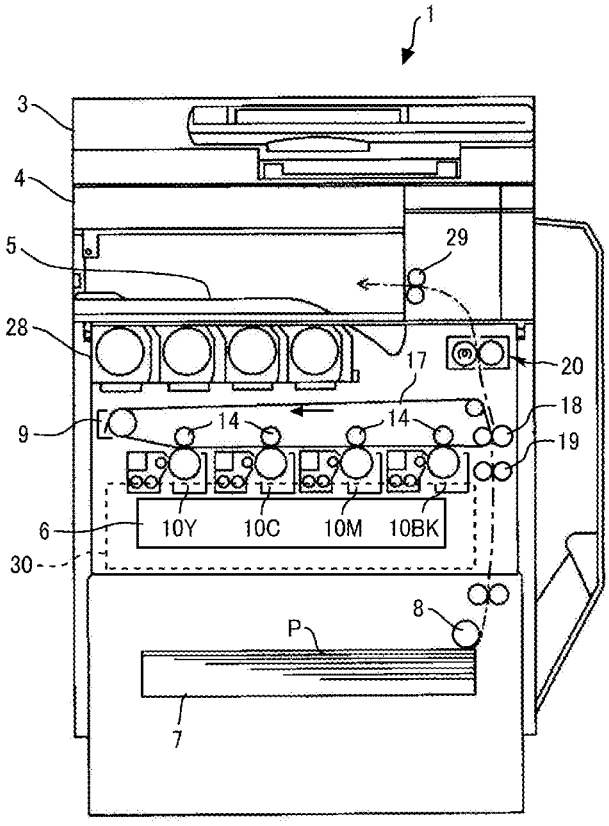


FIG. 1

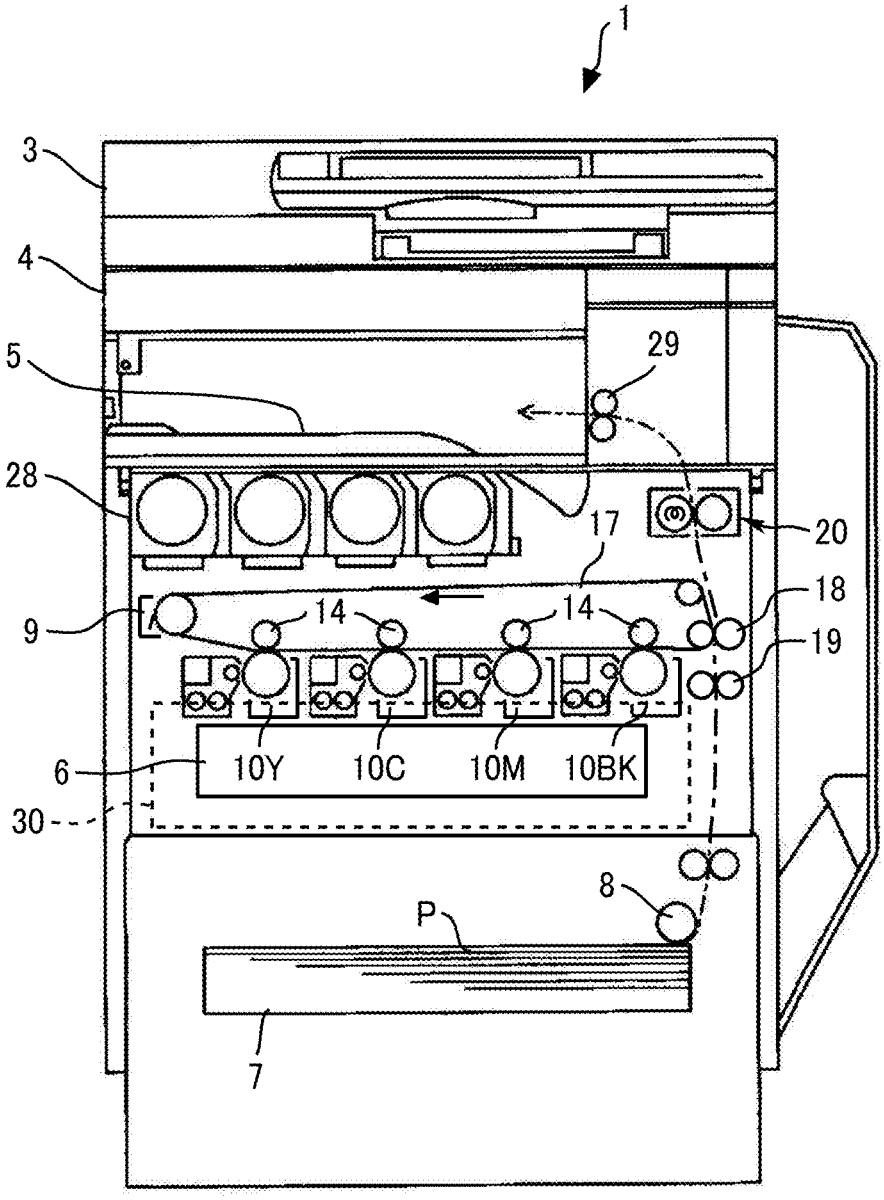


FIG. 2

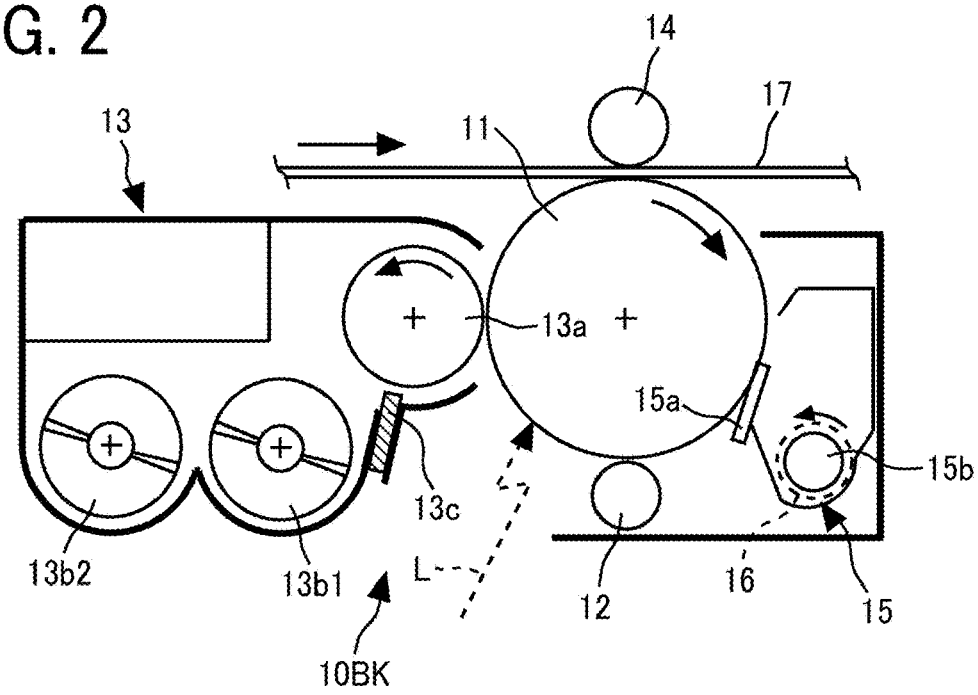

14
17
13
11
13a
15a
15b
13c
13b2
13b1
L
12
16
15
10BK

FIG. 3

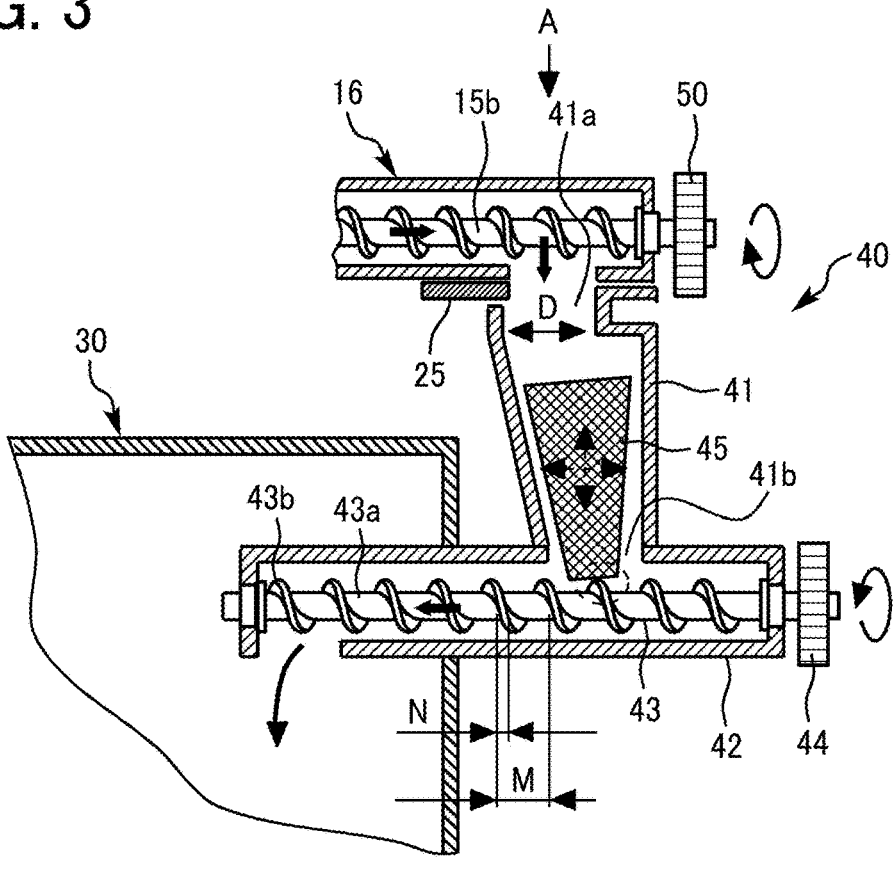

A
16
15b
41a
50
40
D
30
25
41
45
41b
43b
43a
N
43
42
44
M

FIG. 4

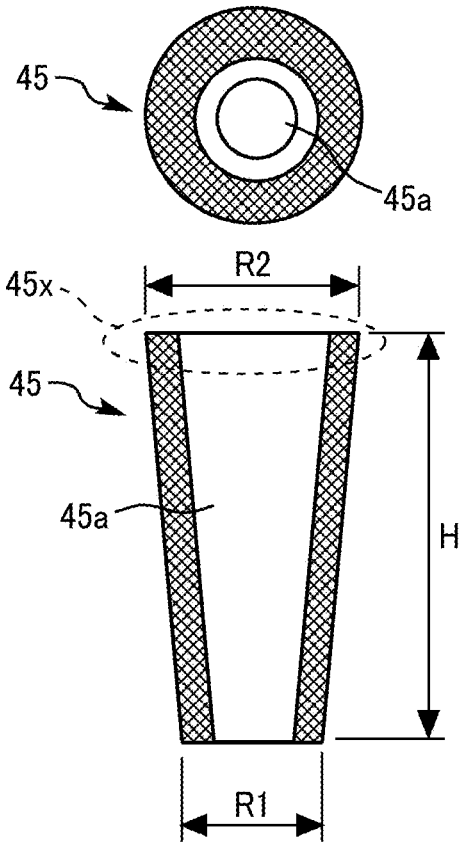


FIG. 5

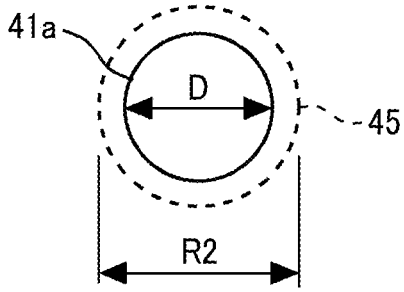


FIG. 6

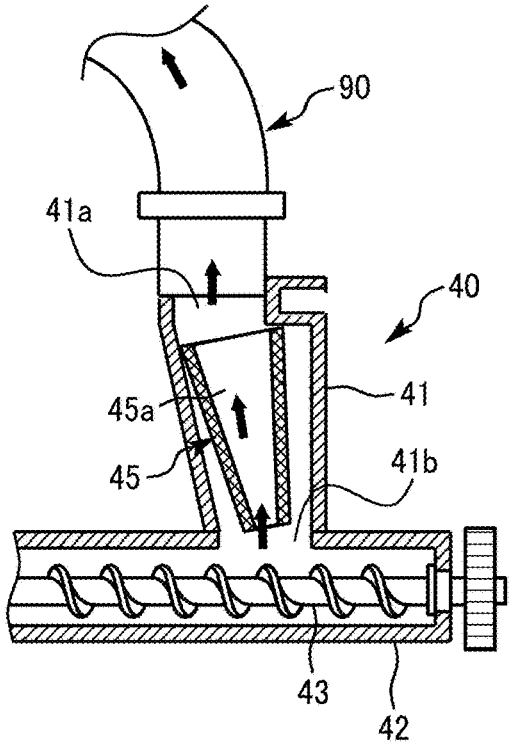


FIG. 7

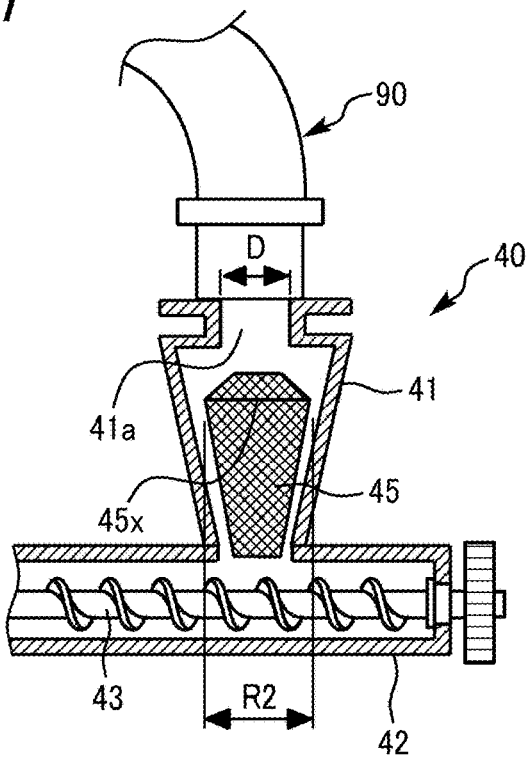


FIG. 8

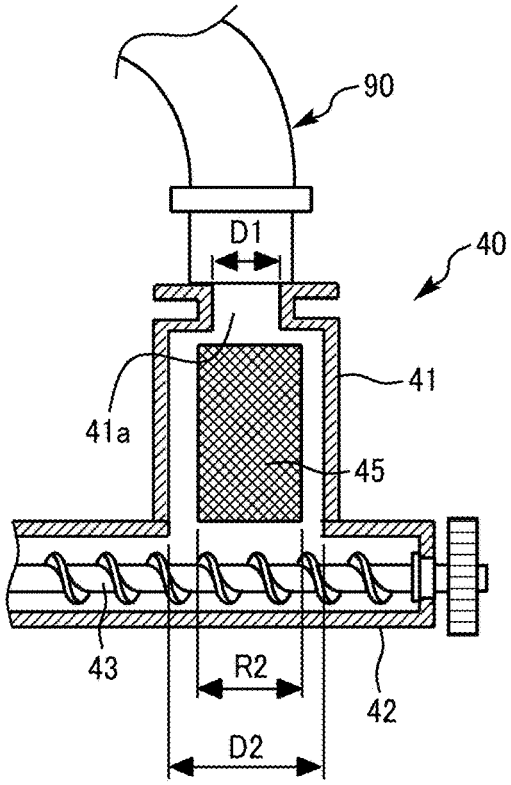


FIG. 9

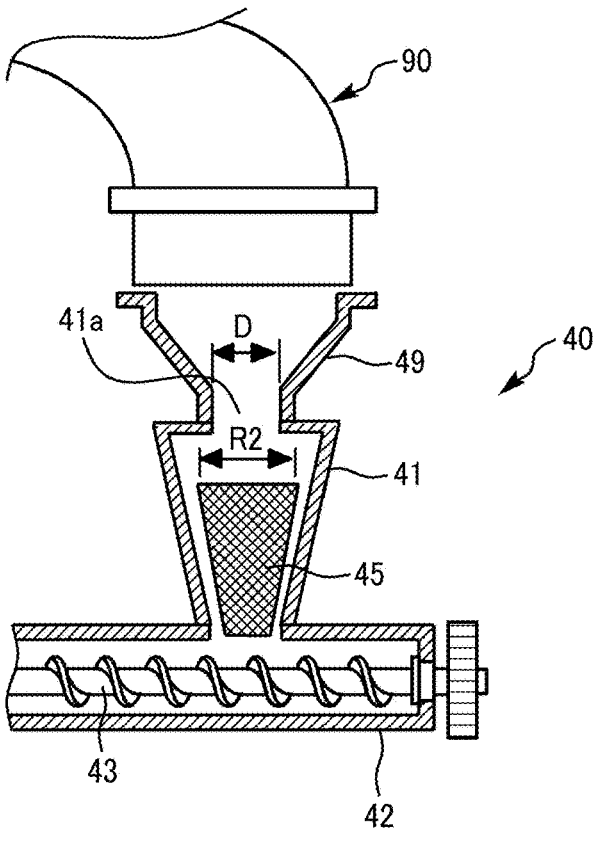


FIG. 10A

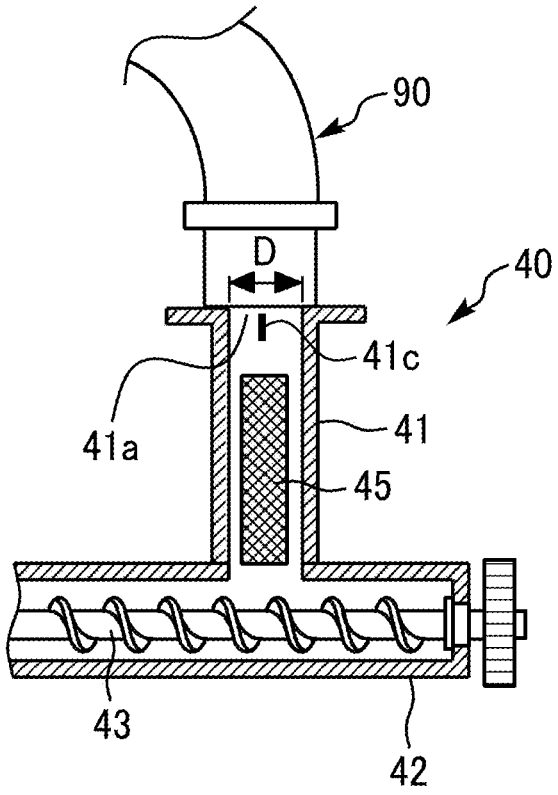


FIG. 10B

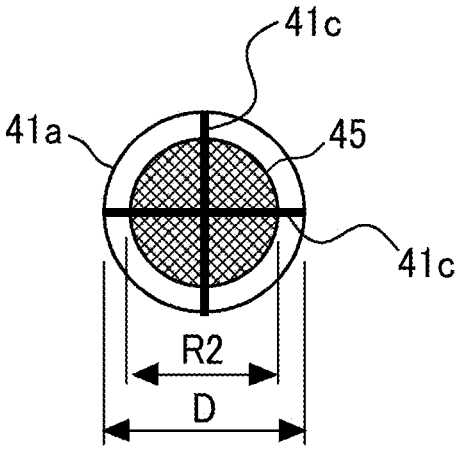
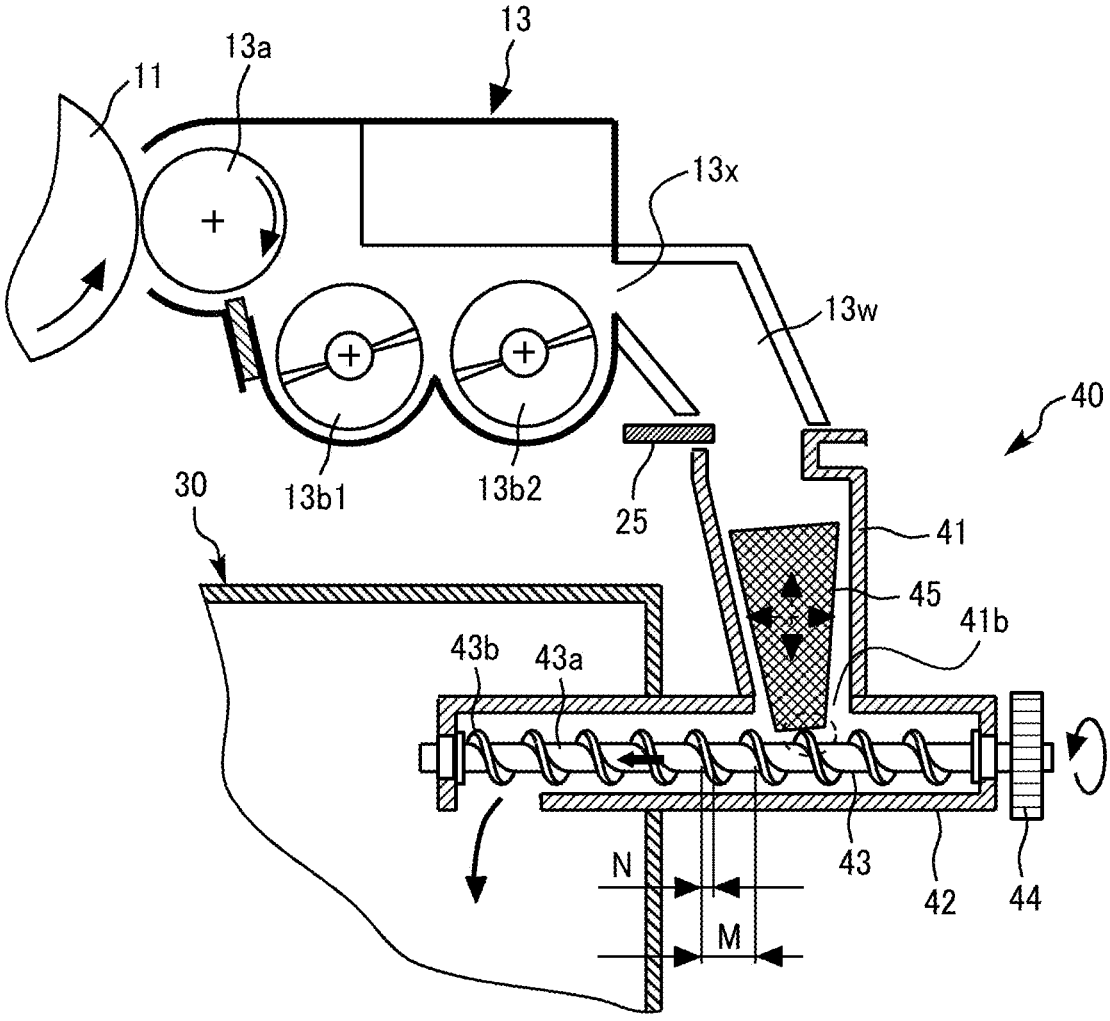


FIG. 11



POWDER CONVEYING DEVICE AND IMAGE FORMING APPARATUS INCORPORATING SAME

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This patent application is based on and claims priority pursuant to 35 U.S.C. § 119(a) to Japanese Patent Application Nos. 2022-084982, filed on May 25, 2022, and 2023-051459, filed on Mar. 28, 2023, in the Japan Patent Office, the entire disclosure of which is hereby incorporated by reference herein.

BACKGROUND

Technical Field

[0002] Embodiments of the present disclosure relate to a powder conveying device to convey powder such as waste toner, and an image forming apparatus, such as a copier, a printer, a facsimile machine, or a multifunction peripheral (MFP) having at least two of such capabilities, incorporating the powder conveying device.

Related Art

[0003] Image forming apparatuses, such as copiers or printers, are known that include a drop conveyance passage and an intersecting conveyance passage as conveyance passages for conveying powder such as waste toner. Powder having flowed in from an inlet port drops by its own weight through the drop conveyance passage. A conveying screw is driven to rotate to convey the powder, which has flowed in from the drop conveyance passage, in an intersecting direction through the intersecting conveyance passage.

SUMMARY

[0004] In an embodiment of the present disclosure, there is provided a powder conveying device that includes a drop conveyance passage, an intersecting conveyance passage, a conveying screw, and a floating member. Powder entering from an inflow port drops in the drop conveyance passage. The intersecting conveyance passage communicates with a lower end of the drop conveyance passage and extends in an intersecting direction that intersects the drop conveyance passage. The conveying screw is disposed in the intersecting conveyance passage and rotates in a specified direction to convey the powder in the intersecting direction. The floating member is movably installed in the drop conveyance passage and floats in the drop conveyance passage to move by contact with the conveying screw. The inflow port and the floating member interfere with each other to prevent the floating member from coming out of the inflow port of the drop conveyance passage.

[0005] In another embodiment of the present disclosure, there is provided an image forming apparatus that includes the powder conveying device.

BRIEF DESCRIPTION OF THE DRAWINGS

[0006] A more complete appreciation of embodiments of the present disclosure and many of the attendant advantages and features thereof can be readily obtained and understood from the following detailed description with reference to the accompanying drawings, wherein:

[0007] FIG. **1** is a diagram illustrating an overall configuration of an image forming apparatus according to an embodiment of the present disclosure;

[0008] FIG. **2** is a schematic view of an image forming device of the image forming apparatus in FIG. **1**;

[0009] FIG. **3** is a cross-sectional view of a part of a waste-toner conveying device, according to an embodiment of the present disclosure;

[0010] FIG. **4** includes a top view and a cross-sectional side view of a floating member of the waste-toner conveying device in FIG. **3**;

[0011] FIG. **5** is a cross-sectional view of an inflow port of a drop conveyance passage and a swinging member viewed from a direction A in FIG. **3**;

[0012] FIG. **6** is a cross-sectional view of a part of the waste-toner conveying device in which a cleaning device is disposed;

[0013] FIG. **7** is a cross-sectional view of a part of a waste-toner conveying device in which a cleaning device is disposed, according to a first modification;

[0014] FIG. **8** is a cross-sectional view of a part of a waste-toner conveying device in which a cleaning device is disposed, according to a second modification;

[0015] FIG. **9** is a cross-sectional view of a part of a waste-toner conveying device in which a cleaning device is disposed, according to a third modification;

[0016] FIG. **10**A is a cross-sectional view of a part of a waste-toner conveying device in which a cleaning device is disposed, according to a fourth modification;

[0017] FIG. **10**B is a view of a swinging member viewed from a side of an inflow port of a conveyance passage, according to the fourth modification; and

[0018] FIG. **11** is a cross-sectional view of a waste-toner conveying device and a developing device according to a fifth modification.

[0019] The accompanying drawings are intended to depict embodiments of the present disclosure and should not be interpreted to limit the scope thereof. The accompanying drawings are not to be considered as drawn to scale unless explicitly noted. Also, identical or similar reference numerals designate identical or similar components throughout the several views.

DETAILED DESCRIPTION

[0020] In describing embodiments illustrated in the drawings, specific terminology is employed for the sake of clarity. However, the disclosure of this specification is not intended to be limited to the specific terminology so selected and it is to be understood that each specific element includes all technical equivalents that have a similar function, operate in a similar manner, and achieve a similar result.

[0021] Referring now to the drawings, embodiments of the present disclosure are described below. As used herein, the singular forms "a," "an," and "the" are intended to include the plural forms as well, unless the context clearly indicates otherwise.

[0022] With reference to the drawings, embodiments of the present disclosure are described in detail below. Identical reference numerals are assigned to identical components or equivalents and descriptions of those components may be simplified or omitted.

[0023] First, with reference to FIG. **1**, a description is given of an overall configuration and operation of an image forming apparatus **1** according to an embodiment of the

present disclosure. In FIG. **1**, the image forming apparatus **1**, which is illustrated as a color copier in the present embodiment, includes a document conveying device **3**, a scanner **4** (document reading device), and a writing device **6** (exposure device). The document conveying device **3** conveys documents to the scanner **4**. The scanner **4** scans the documents to read image data. The writing device **6** emits a laser beam based on input image data. The image forming apparatus **1** also includes a sheet feeder **7**, process cartridges **10**Y, **10**M, **10**C, and **10**BK, an intermediate transfer belt **17** (an image bearer), and a secondary transfer roller **18**. The sheet feeder **7** stores sheets P such as sheets of paper. The process cartridges **10**Y, **10**M, and **10**BK are image forming devices to form toner images of yellow, magenta, cyan, and black, respectively. The toner images of multiple colors are transferred and superimposed one on another onto the intermediate transfer belt **17**. The secondary transfer roller **18** transfers the toner images on the intermediate transfer belt **17** onto the sheet P. The image forming apparatus **1** further includes a fixing device **20**, toner containers **28**, and a waste-toner collection container **30**. The fixing device **20** fixes unfixed toner images on the sheet P. The toner containers **28** contain toners of respective colors to be supplied to developing devices **13** of the corresponding process cartridges **10**Y, **10**M, **10**C, and **10**BK. Waste-toner is collected in the waste-toner collection container **30**.

[0024] Each of the process cartridges **10**Y, **10**M, **10**C, and **10**BK (serving as image forming devices) includes a photoconductor drum **11** (serving as an image bearer), a charging device **12**, the developing device **13**, and a cleaning device **15**, which are integrated as a single unit as illustrated in FIG. **2**. Each of the process cartridges **10**Y, **10**M, **10**C, and **10**BK, which is expendable, is replaced with a new one when depleted. Yellow, magenta, cyan, and black toner images are formed on the respective photoconductor drums **11** (serving as image bearers) in the process cartridges **10**Y, **10**M, **10**C, and **10**BK.

[0025] A description is given below of operations of the image forming apparatus **1** to form a normal color toner image. A conveyance roller of the document conveying device **3** conveys a document on a document table onto an exposure glass of the scanner **4**. The scanner **4** optically scans the document on the exposure glass to read image data. The yellow, magenta, cyan, and black image data are transmitted to the writing device **6**. The writing device **6** irradiates the photoconductor drums **11** of the corresponding process cartridges **10**Y, **10**M, **10**C, and **10**BK with laser beams L (exposure light) based on the yellow, magenta, cyan, and black image data, respectively.

[0026] Meanwhile, the four photoconductor drums **11** rotate clockwise as illustrated in FIGS. **1** and **2**. With reference to FIG. **2**, the charging device **12** (charging roller) uniformly charges a surface of the photoconductor drum **11** at a position opposite the photoconductor drum **11** (charging process). Thus, the surface of the photoconductor drum **11** is charged to a certain potential. Subsequently, the surface of the photoconductor drum **11** thus charged reaches a position where the surface of the photoconductor drum **11** is irradiated with the laser beam L. The writing device **6** emits the laser beams L for respective colors from a light source according to the image data. The laser beams L are reflected by a polygon mirror and transmitted through multiple lenses. The laser beams L transmitted through the multiple lenses passes through different optical paths for the different color components of yellow, magenta, cyan, and black (exposure process).

[0027] The laser beam L corresponding to the yellow image data is emitted to the surface of the photoconductor drum **11** in the process cartridge **10**Y, which is the first from the left in FIG. **1** among the four process cartridges **10**Y, **10**M, **10**C, and **10**BK. Thus, an electrostatic latent image for yellow is formed on the photoconductor drum **11** charged by the charging device **12** (charging roller). Similarly, the laser beam L corresponding to the cyan image data is emitted to the surface of the photoconductor drum **11** in the second process cartridge from the left in FIG. **1**, thus forming an electrostatic latent image corresponding to the cyan image data on the surface of the photoconductor drum **11**. The laser beam L corresponding to the magenta image data is emitted to the surface of the photoconductor drum **11** in the third process cartridge **10**M from the left in FIG. **1**, thus forming an electrostatic latent image corresponding to the magenta image data on the surface of the photoconductor drum **11**. The laser beam L corresponding to black image data is emitted to the surface of the photoconductor drum **11** in the fourth process cartridge **10**BK from the left in FIG. **1**, thus forming an electrostatic latent image corresponding to the black image data on the surface of the photoconductor drum **11**.

[0028] Then, the surface of the photoconductor drum **11** having the electrostatic latent image reaches a position opposite the developing device **13** (see FIG. **2**). The developing device **13** supplies toner of each color onto the surface of the photoconductor drum **11** and develops the electrostatic latent image on the photoconductor drum **11** into a toner image (development process). Subsequently, the surface of the photoconductor drum **11** after the development process reaches a position opposite the intermediate transfer belt **17** (intermediate transferor) as image bearer. Each of primary transfer rollers **14** is disposed at the position where the surface of the photoconductor drum **11** faces the intermediate transfer belt **17** such that the primary transfer roller **14** contacts an inner circumferential surface of the intermediate transfer belt **17**. At the positions of the primary transfer rollers **14**, the toner images on the photoconductor drums **11** are sequentially transferred to and superimposed on the intermediate transfer belt **17**, forming a multicolor toner image thereon (primary transfer process).

[0029] After the primary transfer process, the surface of the photoconductor drum **11** reaches a position opposite the cleaning device **15** (see FIG. **2**). The cleaning device **15** collects untransferred toner remaining on the photoconductor drum **11** (cleaning process). Then, the surface of the photoconductor drum **11** passes through a discharging device to complete a series of image forming processes performed on the photoconductor drum **11**.

[0030] Meanwhile, the surface of the intermediate transfer belt **17**, onto which the single-color toner images on the photoconductor drums **11** are transferred and superimposed, moves in a direction indicated by an arrow in FIG. **1** and reaches a position opposite a secondary transfer roller **18**. The secondary transfer roller **18** secondarily transfers the multicolor toner image on the intermediate transfer belt **17** onto the sheet P (secondary transfer process). After the secondary transfer process, the surface of the intermediate transfer belt **17** reaches a position opposite an intermediate transfer belt cleaner **9** (cleaning device). The intermediate

transfer belt cleaner **9** collects the untransferred toner on the intermediate transfer belt **17** to complete a series of transfer processes on the intermediate transfer belt **17**.

[0031] The sheet P is conveyed from the sheet feeder **7** to the position of the secondary transfer roller **18**, via a sheet conveyance guide, a registration roller pair **19**, or the like. More specifically, a feed roller **8** feeds the sheet P from the sheet feeder **7** that stores a stack of sheets P, and the sheet P is then guided by the sheet conveyance guide to the registration roller pair **19**. The sheet P that has reached the registration roller pair **19** is conveyed toward the position of the secondary transfer roller **18** so that the sheet P coincides with the arrival of the multicolor toner image on the intermediate transfer belt **17**.

[0032] Subsequently, the sheet P, onto which the multicolor image is transferred, is conveyed to the fixing device **20**. The fixing device **20** includes a fixing roller and a pressure roller pressing against each other. In a nip between the fixing roller and the pressure roller, the multicolor toner image is fixed on the sheet P. After the fixing process, an output roller pair **29** ejects the sheet P as an output image to the exterior of a body of the image forming apparatus **1**, and the ejected sheets P are stacked on an output tray **5** to complete a series of image forming processes.

[0033] Next, with reference to FIG. **2**, image forming devices of the image forming apparatus **1**, according to an embodiment of the present disclosure, are described in detail below. FIG. **2** is a schematic view of the process cartridge **10**BK for black. The other three process cartridges **10**Y, **10**M, and **10**C have a similar configuration as the process cartridge for black except for the color of toner used in the image forming process, and thus drawings and descriptions thereof are omitted to avoid redundancy.

[0034] As illustrated in FIG. **2**, the process cartridge **10**BK is a single unit that includes the photoconductor drum **11** as the image bearer, the charging device **12** to charge the photoconductor drum **11**, the developing device **13** to develop the electrostatic latent image on the photoconductor drum **11**, and the cleaning device **15** to remove the untransferred toner from the photoconductor drum **11** in a casing of the process cartridge **10**BK.

[0035] The photoconductor drum **11** is an organic photoconductor designed to be charged with a negative polarity and includes a photosensitive layer formed on a drum-shaped conductive support. The charging device **12** is a charging roller including a conductive core and an elastic layer of moderate resistivity overlaid on the conductive core. A power supply applies a specified voltage to the charging device **12** (charging roller). Thus, the charging device **12** uniformly charges the surface of the photoconductor drum **11** facing the charging device **12**.

[0036] The developing device **13** includes a developing roller **13***a* disposed opposite the photoconductor drum **11**, a first conveying screw **13***b***1** disposed opposite the developing roller **13***a*, a second conveying screw **13***b***2** disposed opposite the first conveying screw **13***b***1** via a partition, and a doctor blade **13***c* disposed opposite the developing roller **13***a*. The developing roller **13***a* includes multiple magnets and a sleeve that rotates around the magnets. The magnets are stationary and generate magnetic poles around the circumferential surface of the developing roller **13***a*. The magnets generate a plurality of magnetic poles on the developing roller **13***a* (sleeve) to bear developer on the developing roller **13***a*. The developing device **13** stores two-component developer including carrier and toner.

[0037] The cleaning device **15** is provided with a cleaning blade **15***a* that contacts the photoconductor drum **11** and a conveying screw **15***b* (a conveyance tube **16**) that conveys the untransferred toner collected in the cleaning device **15** toward the waste-toner collection container **30** (see FIG. **3**) as waste toner. For example, the cleaning blade **15***a* is made of rubber, such as urethane rubber, and contacts the surface of the photoconductor drum **11** at a specified angle with a specified pressure. With this configuration, substances such as the untransferred toner adhering to the photoconductor drum **11** are mechanically scraped off and collected in the cleaning device **15**. The untransferred toner collected in the cleaning device **15** is conveyed to the waste-toner collection container **30** via the conveyance tube **16** (in which the conveying screw **15***b* is disposed) by a waste-toner conveying device **40** as the powder conveying device (see FIG. **3**). The conveyed untransferred toner is collected in the waste-toner collection container **30** as the waste toner (powder). The conveying screw **15***b* is driven by a drive motor via a gear **50** (see FIG. **3**) to rotate in a direction indicated by an arrow in FIGS. **2** and **3**. Similarly, with reference to FIG. **1**, the intermediate transfer belt cleaner **9** as a cleaning device is also provided with a cleaning blade and a conveying screw. The cleaning blade contacts the intermediate transfer belt **17**. The conveying screw (conveyance tube **16**) conveys the untransferred toner collected in the intermediate transfer belt cleaner **9** toward the waste-toner collection container **30** (see FIG. **3**) as waste toner. The untransferred toner collected in the intermediate transfer belt cleaner **9** is conveyed to the waste-toner collection container **30** via the conveyance tube **16** (in which a conveying screw is disposed) by the waste-toner conveying device **40** and is collected in the waste-toner collection container **30** as waste toner (powder). A description is given of the waste-toner conveying device **40** in further detail below. In addition to the untransferred toner, substances adhering to the photoconductor drum **11** or the intermediate transfer belt **17** include paper dust resulting from the sheet P, discharge products generated on the photoconductor drum **11** during discharge by the charging device **12**, additives to the toner, and the like. In the present specification, such substances are collectively referred to as the "untransferred toner".

[0038] The image forming processes, described above, are described in further detail below with reference to FIG. **2**. The developing roller **13***a* rotates in a direction (counterclockwise) indicated by an arrow in FIG. **2**. In the developing device **13**, as the first conveying screw **13***b***1** and the second conveying screw **13***b***2** arranged via the partition rotate, the developer is circulated in the longitudinal direction of the developing device **13**, while being stirred and mixed with toner supplied from the toner container **28** by a toner supply device. The longitudinal direction of the developing device **13** is perpendicular to the plane on which FIG. **2** is illustrated.

[0039] Thus, the toner is triboelectrically charged and attracted to the carrier. The toner is borne on the developing roller **13***a* together with the carrier. The developer borne on the developing roller **13***a* reaches a position opposite the doctor blade **13***c*. After having been adjusted to an appropriate amount at the position of the doctor blade **13***c*, the developer on the developing roller **13***a* then comes to an opposing position to the photoconductor drum **11** (i.e., a

development area). In the development area, the toner in the developer adheres to the electrostatic latent image formed on the surface of the photoconductor drum **11**. The toner adheres to the electrostatic latent image (i.e., the toner image is formed) by a development electric field formed by a potential difference (i.e., a developing potential) between a latent image potential (i.e., an exposure potential) of an image area irradiated with the laser beam L and a developing bias applied to the developing roller **13***a*. Subsequently, most of the toner attached to the photoconductor drum **11** in the developing process is transferred onto the intermediate transfer belt **17**. The untransferred toner remained on the surface of the photoconductor drum **11** is collected in the cleaning device **15** by the cleaning blade **15***a*.

[0040] A description is given of the waste-toner conveying device **40** as a powder conveying device disposed in the image forming apparatus **1** according to the present embodiment. With reference to FIG. **3**, the waste-toner conveying device **40** as a powder conveying device conveys waste toner, which is powder collected by the cleaning device **15** and the intermediate transfer belt cleaner **9** and conveyed via the conveyance tube **16**, toward the waste-toner collection container **30** in a direction indicated by a black arrow in FIG. **3**. The waste-toner collection container **30** is detachably (replaceably) attached in the body of the image forming apparatus **1**. When the waste-toner collection container **30** is attached to the body of the image forming apparatus **1**, the waste-toner collection container **30** is communicatively coupled with the waste-toner conveying device **40** (an intersecting conveyance passage **42**). The waste toner that has conveyed by the waste-toner conveying device **40** is collected in the waste-toner collection container **30**.

[0041] As illustrated in FIG. **3**, the waste-toner conveying device **40** (powder conveying device) includes, for example, a drop conveyance passage **41**, the intersecting conveyance passage **42**, a conveying screw **43**, and a floating member **45**. The drop conveyance passage **41** is a conveyance passage along which toner (waste toner) as powder that has flowed into from an inflow port **41***a* drops by its weight, and is formed to extend in a substantially vertical direction in the present embodiment. The drop conveyance passage **41** according to the present embodiment is substantially circular in cross section (which is a horizontal cross section). The inflow port **41***a* of the drop conveyance passage **41** is connected to a discharge port formed downstream from the conveyance tube **16**. The intersecting conveyance passage **42** is a conveyance passage that extends in an intersecting direction that intersects the drop conveyance passage **41**. An upper portion of the intersecting conveyance passage **42** communicates with a lower end (an outflow port **41***b*) of the drop conveyance passage **41**. In the present embodiment, the intersecting conveyance passage **42** extends straight in a substantially horizontal direction and is a circular shape in cross section slightly larger than a screw diameter of the conveying screw **43** to be described below. The conveying screw **43** is disposed in the intersecting conveyance passage **42** and rotates in a specified direction (a direction indicated by an arrow in FIG. **3**) to convey toner in the intersecting direction. The conveying screw **43** includes a shaft portion **43***a* and a screw portion **43***b* wound around the shaft portion **43***a*. The conveying screw **43** is driven by a drive motor via a gear **44** and rotates in the direction indicated by an arrow in FIG. **3**. Both ends of the conveying screw **43** in an axial direction of the conveying screw **43** are rotatably supported by a housing of the waste-toner conveying device **40**. In the present embodiment, both of the shaft portion **43***a* and the screw portion **43***b* of the conveying screw **43** are made of a metal material such as stainless steel having high mechanical strength.

[0042] In the present embodiment, the drop conveyance passage **41** extends in the substantially vertical direction. Alternatively, a drop conveyance passage can be used that has any shape allowing waste toner to fall by its own weight. For example, a drop conveyance passage can be used that allows toner to slide down on an inclined surface inclined relative to the vertical direction to fall by its own weight. Further, in the present embodiment, the intersecting conveyance passage **42** extends in the substantially horizontal direction. The intersecting conveyance passage **42** with any shape in which waste toner is conveyed in the intersecting direction by the conveying screw **43** can be used. Thus, for example, a shape with an inclined surface inclined relative to the horizontal direction, or with a partly or entirely curved portion, is also feasible.

[0043] In the waste-toner conveying device **40** according to the present embodiment, the floating member **45** is movably disposed in the drop conveyance passage **41**. The floating member **45** floats in the drop conveyance passage **41** and randomly contacts an inner wall of the drop conveyance passage **41** due to contact with the conveying screw **43** rotating in a specified direction (the direction indicated by an arrow in FIG. **3**) while maintaining a vertical posture to some extent without changing a vertical relationship such as falling in a horizontal direction. Specifically, the floating member **45** is a column-shaped member extending in substantially the same direction as a direction in which the drop conveyance passage **41** extends (in a vertical direction), and is placed on the conveying screw **43** in a free state in the drop conveyance passage **41** without being supported by any member. A cross-sectional diameter R**1** (see FIG. **4**) of a lower end of the floating member **45** is set to be larger than a clearance between the conveying screw **43** and the intersecting conveyance passage **42** so that the floating member **45** floats above the rotating conveying screw **43** without entering the clearance between the conveying screw **43** and the intersecting conveyance passage **42**.

[0044] The floating member **45** moves to the left in FIG. **3** along with the rotation of the conveying screw **43** to contact the left inner wall of the drop conveyance passage **41** or contacts an inner wall other than the left inner wall due to reaction or imbalance of an upper part of the floating member **45**. Thus, the floating member **45** randomly swings in a free posture and in a free direction to almost uniformly contact the inner wall of the drop conveyance passage **41**. As a result, the floating member **45** contacts the inner wall of the drop conveyance passage **41** over substantially the entire circumferential surface with a relatively wide range (as an operating range) extending upward from the lower end of the drop conveyance passage **41** (which is a communicating portion with the intersecting conveyance passage **42**). Thus, a failure that waste toner adheres to the inner wall of the drop conveyance passage **41** can be reduced. Even if waste toner adheres to the inner wall of the drop conveyance passage **41**, the contact of the floating member **45** can remove the adhered toner. Accordingly, a failure that the drop conveyance passage **41** is blocked by the adhered toner is also reduced. In particular, toner adhesion to the inner wall of the drop conveyance passage **41** is not likely to occur on the

upper end of the drop conveyance passage **41** and is likely to occur in a range from the lower end to the central portion. Thus, it is useful to set the length H (see FIG. **4**) of the floating member **45** such that the floating member **45** can contact the inner wall of the drop conveyance passage **41** in such a range. Since the waste toner is likely to adhere to the inner wall of the drop conveyance passage **41** as compared to new toner (fresh toner), it is useful to install the floating member **45** in the drop conveyance passage **41** for waste toner.

[0045] In the present embodiment, the floating member **45** has a hardness smaller than the hardness of the conveying screw **43**. Specifically, in the present embodiment, the floating member **45** is made of a material such as a rubber material or a resin material and has a hardness smaller than the hardness of the conveying screw **43** made of a metal material. Thus, the hardness of the floating member **45** is smaller than the hardness of the conveying screw **43**, so that a failure can be reduced that the conveying screw **43** is worn out due to repeated contact with the floating member **45**. Accordingly, the good performance of conveying toner by the conveying screw **43** is maintained over time. Note that the hardness of the floating member **45** may be smaller than the hardness of the conveying screw **43** as a whole or only at the surface of the floating member **45**. That is, the hardness of at least the surface (outer surface) of the floating member **45** may be smaller than the hardness of the conveying screw **43**.

[0046] Although the floating member **45** wears due to repeated contact with the conveying screw **43**, the worn portion is limited to a bottom portion that contacts the conveying screw **43**, and a portion contacting the inner wall of the drop conveyance passage **41** hardly wears. The length H (see FIG. **4**) of the contacting portion is set to be sufficiently long, so that the function of preventing toner adhesion to the inner wall of the drop conveyance passage **41** is stably maintained over time. Even if the bottom of the floating member **45** wears, using the column-shaped floating member **45** can prevent the floating member **45** from being caught in the screw portion **43***b* of the conveying screw **43** and causing a failure such as malfunction or breakage of the conveying screw **43** as compared with a case of using a spherical member.

[0047] In the present embodiment, the hardness of the floating member **45** is smaller than the hardness of the inner wall of the drop conveyance passage **41** (which is formed of a resin material having a relatively high strength). Accordingly, a failure that the drop conveyance passage **41** wears due to repeated contact with the floating member **45** can be reduced. Note that the hardness of the floating member **45** may be smaller than the hardness of the inner wall of the drop conveyance passage **41** as a whole or only at the surface of the floating member **45**. In other words, the hardness of at least the surface (outer surface) of the floating member **45** may be smaller than the hardness of the inner wall of the drop conveyance passage **41**.

[0048] In the present embodiment, the floating member **45** is preferably elastic and made of an elastic material such as rubber. Accordingly, the hardness of the floating member **45** can be significantly lower than the hardness of the conveying screw **43** made of a metal material, so that the effect of reducing wear of the conveying screw **43** is more likely to be achieved. Since the floating member **45** is an elastic member, a reaction force generated when the floating member **45** contacts the conveying screw **43** or the inner wall of the drop conveyance passage **41** increases by an elastic force. As a result, the floating member **45** greatly moves, and, the effect of preventing the toner from adhering to the inner wall is easily achieved.

[0049] As illustrated in FIGS. **3** and **4**, in the present embodiment, the floating member **45** is formed in a substantially conical shape (columnar shape) to have a circular cross section. In a case where the floating member **45** is formed to have a polygonal cross section, the corners of the floating member **45** contact the inner wall of the drop conveyance passage **41** and wear out. Consequently, the condition of contact with the inner wall changes over time. As a result, the effect of preventing toner from adhering to the inner wall of the drop conveyance passage **41** may change over time. On the other hand, the floating member **45** having a columnar cross section can reduce such a failure.

[0050] As illustrated in FIG. **4**, the floating member **45** according to the present embodiment has a through-hole **45***a* formed therein. The floating member **45** has the through-hole **45***a* in this manner to reduce the weight of the floating member **45**. The wear of the conveying screw **43** and the inner wall of the drop conveyance passage **41** due to contact of the floating member **45** can be further reduced. Since the weight reduction of the floating member **45** increases reaction when the floating member **45** contacts the conveying screw **43** or the inner wall of the drop conveyance passage **41**, the floating member **45** greatly moves. Thus, the effect of preventing toner from adhering to the inner wall is easily achieved. The through-hole **45***a* of the floating member **45** causes a part of the waste toner that falls by its weight in the drop conveyance passage **41** to fall by its weight via the through-hole **45***a*. Thus, the fluidity (transportability) of the waste toner in the drop conveyance passage **41** can be enhanced as compared with a case where the floating member **45** has no through-hole **45***a*.

[0051] With reference to FIGS. **3** and **4**, in the present embodiment, a relationship of R**1**>M−N is established, where R**1** represents a diameter (a cross-sectional diameter) of an inscribed circle of a bottom surface (a lower end) of the floating member **45**, M represents a screw pitch of the conveying screw **43**, and N represents a plate thickness of the screw portion **43***b* of the conveying screw **43**. In a case where the above-described relationship is not established, the floating member **45** may fit in or enter between the screw portions **43***b* of the conveying screw **43**. Thus, a failure may occur that the movement of the floating member **45** due to contact with the rotating conveying screw **43** is restricted or that the floating member **45** is broken. On the other hand, in the present embodiment, the dimensions of the related components are defined such that the floating member **45** does not fit in or enter between the screw sections **43***b* of the conveying screw **43**. Thus, the occurrence of such a failure can be reduced.

[0052] With reference to FIGS. **3** and **4**, in the present embodiment, a relationship of H>Dmax is established, where H represents the length of the floating member **45**, and Dmax represents the cross-sectional diameter (of the largest portion) of the inside of the drop conveyance passage **41**. In a case where the above-described relationship is not established, a failure may occur that the floating member **45** falls to be greatly inclined with respect to the vertical direction and is fitted onto the inner wall of the drop conveyance passage **41**. In such a case, the floating member

45 does not move, and the function of preventing toner adhesion is not achieved. On the other hand, in the present embodiment, since the length H of the floating member **45** is set to be sufficiently larger than the cross-sectional diameter Dmax of the drop conveyance passage **41**, the occurrence of such a failure can be reduced. Note that, in the present embodiment, the internal cross section of the drop conveyance passage **41** is circular. In a case where the internal cross section of the drop conveyance passage **41** is rectangular, the length of the diagonal line of the cross section is defined as the cross-sectional diameter D.

[0053] In the present embodiment, the specific gravity of the floating member **45** is greater than the specific gravity of waste toner (powder). Accordingly, a failure is reduced that a large amount of waste toner is interposed between the conveying screw **43** and the floating member **45** to greatly float up the floating member **45** above the conveying screw **43**. In other words, even in a case where a large amount of waste toner is in the intersecting conveyance passage **42**, the floating member **45** contacts the conveying screw **43** in a manner such that the floating member **45** intrudes into the waste toner due to a difference in the specific gravity between the floating member **45** and the waste toner. As a result, the floating member **45** contacts and moves relative to the conveying screw **43**, the effect of reducing toner adhesion to the inner wall of the drop conveyance passage **41** is maintained.

[0054] With reference to FIG. **3**, the waste-toner conveying device **40** according to the present embodiment is detachably attached to the conveyance tube **16** in a state of being installed in the body of the image forming apparatus **1**. The conveyance tube **16** is detachably attached to the waste-toner conveying device **40** in a state of being installed in the body of the image forming apparatus **1**. The waste-toner conveying device **40** is formed such that a cleaning device **90** (see FIG. **6**) is detachably attached to the inflow port **41***a* of the drop conveyance passage **41**. With such a configuration, for the waste-toner conveying device **40** removed from the image forming apparatus **1** or the waste-toner conveying device **40** from which the conveyance tube **16** has been removed in the image forming apparatus **1**, a suction port of the cleaning device **90** is connected to the inflow port **41***a* of the drop conveyance passage **41**, so that the waste-toner conveying device **40** can be cleaned. Specifically, the cleaning device **90** is operated in a state where the cleaning device **90** is set at the inflow port **41***a*. Thus, the waste toner remaining in the waste-toner conveying device **40** is sucked (removed) by the cleaning device **90**. Note that, as illustrated in FIG. **3**, the conveyance tube **16** is provided with a shutter **25** that opens and closes the discharge port (which is an opening communicating with the inflow port **41***a*) in conjunction with the relative attaching and detaching operations of the waste-toner conveying device **40** to and from the conveyance tube **16**. As a result, even when the waste-toner conveying device **40** is removed, a failure that waste toner leaks from the discharge port of the conveyance tube **16** is reduced.

[0055] A description is given of the waste-toner conveying device **40** as the powder conveying device according to the present embodiment in detail below. With reference to FIGS. **3** to **6**, the waste-toner conveying device **40** according to the present embodiment is formed such that the inflow port **41***a* of the drop conveyance passage **41** and the floating member **45** can interfere with each other to prevent the floating member **45** from coming out from the inflow port **41***a* of the drop conveyance passage **41**. In other words, even if a service person tries to remove the floating member **45** in the drop conveyance passage **41** from the inflow port **41***a* of the drop conveyance passage **41**, the inflow port **41***a* and the floating member **45** interfere with each other and the floating member **45** cannot be removed. Note that the inflow port **41***a* of the drop conveyance passage **41** functions as an opening connected to the suction port of the cleaning device **90** during suction and cleaning by the cleaning device **90** described above.

[0056] Specifically, as illustrated in FIG. **5**, the opening area of the inflow port **41***a* (the area of a portion surrounded by a solid line in FIG. **5**) is smaller than the projected area of the floating member **45** when viewed from the inflow port **41***a* (the projected area as viewed from the direction A in FIG. **3** and the area of a portion surrounded by a broken line in FIG. **5**). Specifically, in the present embodiment, a hole diameter D of the inflow port **41***a* is smaller than an outer diameter R**2** of a large-diameter portion **45***x* (see FIG. **4**) of the floating member **45** (D<R**2**). More specifically, as described above with reference to FIG. **3**, the waste-toner conveying device **40** according to the present embodiment is formed such that the vertical relationship of the floating member **45** does not change in the drop conveyance passage **41**. As illustrated in FIG. **6**, the floating member **45** has a columnar shape, and the large-diameter portion **45***x* that can interfere with the inflow port **41***a* is formed at least in a part of the floating member **45**. Thus, as illustrated in FIG. **7**, even if a service person tries to remove the floating member **45** in the drop conveyance passage **41** from the inflow port **41***a* of the drop conveyance passage **41**, at least the large-diameter portion **45***x* is caught by the inflow port **41***a*, and the floating member **45** cannot be removed. Note that, as described above, the floating member **45** is not oriented horizontally in the drop conveyance passage **41**. Thus, the lateral face (the portion of the height H) of the floating member **45** does not interfere with the inflow port **41***a* (does not function as an interfering portion). Accordingly, it is useful to provide the large-diameter portion **45***x* having a large cross-sectional diameter R**2** in a part of the column-shaped floating member **45**. In a case where the hole shape of the inflow port **41***a* is a rectangle rather than a circle, the hole diameter D thereof corresponds to a length of a diagonal line of a corner portion.

[0057] Thus, in the present embodiment, since the inflow port **41***a* and the floating member **45** are formed to be able to interfere with each other, a failure that the floating member **45** comes out from the inflow port **41***a* of the drop conveyance passage **41** is not likely to occur. Specifically, as illustrated in FIG. **6**, even when the cleaning device **90** suctions and cleans the waste toner in the drop conveyance passage **41** (waste-toner conveying device **40**) in the direction indicated by a black arrow indicated in FIG. **6** from the inflow port **41***a* during maintenance of the waste-toner conveying device **40**, a failure that the floating member **45** comes out from the inflow port **41***a* by suction is not likely to occur. Accordingly, a failure that the floating member **45** is sucked into the cleaning device **90** and is lost or broken is less likely to occur.

[0058] In the floating member **45** according to the present embodiment, as described above, the large-diameter portion **45***x* is formed to be larger than the inflow port **41***a*. The large-diameter portion **45***x* is also formed to be larger than

the outflow port **41***b*. Accordingly, the floating member **45** cannot be set in the drop conveyance passage **41** as it is during the manufacturing process. On the other hand, the floating member **45** is made of an elastic material such as a rubber material so that the floating member **45** can be set in the drop conveyance passage **41** in a state where the floating member **45** is elastically deformed during the manufacturing process. The drop conveyance passage **41** itself may be formed to be dividable (e.g., to be dividable into two semi-conical members) so that the floating member **45** can also be set before the divided drop conveyance passages **41** are assembled during the manufacturing process. In a case where the large-diameter portion **45***x* is formed to be smaller than the outflow port **41***b*, the drop conveyance passage **41** and the intersecting conveyance passage **42** may be formed to be separable. In such a case, the floating member **45** is set from the outflow port **41***b* into the drop conveyance passage **41** in a state of being separated with respect to the intersecting conveyance passage **42** during the manufacturing process. Thereafter, the intersecting conveyance passage **42** is connected to the drop conveyance passage **41** such that the floating member **45** is also set in the drop conveyance passage **41**.

[0059] As described above with reference to FIG. **4**, in the present embodiment, the floating member **45** has the through-hole **45***a* inside along a direction in which the drop conveyance passage **41** extends (which is the vertical direction). As described above, the floating member **45** is provided with the through-hole **45***a* so that the weight of the floating member **45** is reduced, abrasion of the conveying screw **43** and the inner surface of the drop conveyance passage **41** due to contact of the floating member **45** is reduced, and the floating member **45** greatly moved is likely to prevent toner from adhering to the inner surface of the drop conveyance passage **41**. Furthermore, a part of waste toner that falls by its weight in the drop conveyance passage **41** falls by its weight via the through-hole **45***a*, so that the fluidity (transportability) of the waste toner in the drop conveyance passage **41** is enhanced. In the present embodiment, since the floating member **45** has the through-hole **45***a*, air containing waste toner flows in the through-hole **45***a* when cleaning is performed using the cleaning device **90** (see FIG. **6**). Thus, cleanability is enhanced.

[0060] In particular, as illustrated in FIGS. **4** and **6**, the through-hole **45***a* of the floating member **45** is formed such that the cross-sectional area (hole diameter) of the through-hole **45***a* gradually increases from the lower end to the upper end. As a result, when cleaning is performed with the cleaning device **90** (see FIG. **6**), the floating member **45** (through-hole **45***a*) functions as a tapered nozzle of a cleaner. Thus, waste toner is efficiently suctioned from the lower end (cleanability is further improved).

[0061] As illustrated in FIG. **3**, in the present embodiment, each of the drop conveyance passage **41** and the floating member **45** is formed such that the cross-sectional area gradually increases from the lower end to the upper end. Specifically, both the floating member **45** and the inside of the drop conveyance passage **41** are formed in a substantially conical shape such that a clearance of the floating member **45** relative to the inner wall of the drop conveyance passage **41** is substantially uniform from a lower end to an upper end. With such a configuration, the floating member **45** moves in the drop conveyance passage **41** while contacting in a well-balanced manner. Thus, a failure that the waste toner adheres to the inner wall of the drop conveyance passage **41** is efficiently reduced.

[0062] First Modification

[0063] As illustrated in FIG. **7**, in a waste-toner conveying device **40** (powder conveying device) according to a first modification, a large-diameter portion **45***x* of the floating member **45** is not formed at the upper end as in the floating member **45** illustrated in FIG. **4**, but is formed at a position that is not the upper end (in the example of FIG. **7**, a position adjacent to and lower than the upper end). Even in a case where the floating member **45** is formed as described above, an upper portion of the floating member **45** protrudes upward from the inflow port **41***a* due to suction during cleaning by the cleaning device **90**. However, the large-diameter portion **45***x* is caught by the inflow port **41***a*, so that the floating member **45** does not come out of the inflow port **41***a*. Note that the positions and the number of the large-diameter portions **45***x* formed on the floating member **45** are not limited to those in FIGS. **4** and **7**. Also in the floating member **45** in the first modification, similarly to those illustrated in FIGS. **4** and **6**, a through-hole **45***a* may be formed in the floating member **45** along the direction (which is the vertical direction) in which the drop conveyance passage **41** extends.

[0064] Second Modification

[0065] As illustrated in FIG. **8**, in a waste-toner conveying device **40** (powder conveyance apparatus) according to a second modification, a drop conveyance passage **41** is formed such that an opening area of an inflow port **41***a* (an opening area of a portion having a hole diameter D**1**) is smaller than a cross-sectional area, which is orthogonal to a direction in which the drop conveyance passage **41** extends, of a portion excluding the inflow port **41***a* (a cross-sectional area of an inner-diameter portion having an inner diameter D**2**). In the second modification, a column-shaped (hollow-column-shaped) floating member **45** whose outer diameter is R**2** is used in accordance with the cross-section (inner diameter R**2**) of the drop conveyance passage **41**. The outer diameter R**2** of the floating member **45** is set to be larger than the hole diameter D**1** of the inflow port **41***a* (R**2**>D**1**). Even in the case of such a configuration, the occurrence of a failure that the floating member **45** comes out of the inflow port **41***a* of the drop conveyance passage **41** can be reduced. Note that a through-hole **45***a* may also be formed in the floating member **45** in the second modification along the direction in which the drop conveyance passage **41** extends (which is the vertical direction) in the same manner as the floating member **45** illustrated in FIGS. **4** and **6**.

[0066] Third Modification

[0067] As illustrated in FIG. **9**, a waste-toner conveying device **40** (a powder conveying device) according to a third modification includes an upstream drop conveyance passage **49** along which waste toner (powder) drops by its weight toward the inflow port **41***a* of the drop conveyance passage **41**. Specifically, the upstream drop conveyance passage **49** communicating with the inflow port **41***a* having a hole diameter D smaller than the outer diameter R**2** of the large-diameter portion **45***x* of the floating member **45** is disposed in the waste-toner conveying device **40**. In other words, when the upstream drop conveyance passage **49** and the drop conveyance passage are defined as one integrated drop conveyance passage, the inflow port **41***a* that restricts removal of the floating member **45** is provided in a central portion of the integrated drop conveyance passage. Even in

the case of such a configuration, the occurrence of a failure that the floating member **45** comes out of the inflow port **41***a* of the drop conveyance passage **41** can be reduced. In the third modification, since the upstream drop conveyance passage **49** is formed in a funnel shape, the upstream drop conveyance passage **49** functions as a tapered nozzle of a cleaner during cleaning by the cleaning device **90**. Thus, waste toner can be efficiently suctioned (cleanability is enhanced). Note that a through-hole **45***a* may also be formed in the floating member **45** in the third modification along the direction in which the drop conveyance passage **41** extends (which is the vertical direction) in the same manner as the floating member **45** illustrated in FIGS. **4** and **6**.

[0068] Fourth Modification

[0069] As illustrated in FIGS. **10**A and **10**B, in a waste-toner conveying device **40** (powder conveying device) according to a fourth modification, the inflow port **41***a* of the drop conveyance passage **41** is provided with a restricting member **41***c* as a stopper that restricts the floating member **45** from coming out of the inflow port **41***a*. Specifically, a member in which two rod-shaped members intersect in a cross shape is disposed as the restricting member **41***c* at the inflow port **41***a* (or a position adjacent to the inflow port **41***a*). The restricting member **41***c* is not limited to the configuration illustrated in FIG. **10** and may be any suitable configuration as long as the restricting member **41***c* does not prevent waste toner from flowing into the drop conveyance passage **41** via the inflow port **41***a* from the conveyance tube **16** (see FIG. **3**) and prevents the floating member **45** from coming out of the inflow port **41***a*. In the case of such a configuration, the inflow port **41***a* and the floating member **45** are formed to be able to interfere with each other so that the floating member **45** does not come out of the inflow port **41***a* of the drop conveyance passage **41** without setting any particular dimensional relationship between the inflow port **41***a* and a large-diameter portion of the floating member **45**. In other words, even if a person tries to remove the floating member **45** in the drop conveyance passage **41** from the inflow port **41***a* of the drop conveyance passage **41**, the restricting member **41***c* of the inflow port **41***a* and the floating member **45** interfere with each other. Thus, the floating member **45** cannot be removed. Note that a through-hole **45***a* may also be formed in the floating member **45** in the fourth modification along the direction in which the drop conveyance passage **41** extends (which is the vertical direction) in the same manner as the floating member **45** illustrated in FIGS. **4** and **6**.

[0070] Fifth Modification

[0071] As illustrated in FIG. **11**, a powder conveying device (waste-toner conveying device **40**) according to a fifth modification is a device that conveys waste developer (powder) ejected from the developing device **13** toward a waste-developer collection container (waste-toner collection container **30**). Developer (which is two-component developer composed of toner and carrier) is appropriately supplied from a developer container to the developing device **13** in the fifth modification. When the developer is supplied into the developing device **13**, an excess amount of the developer that exceeds the height position of an outflow port **13***x* formed on a developing case is ejected from the outflow port **13***x* and flows into the drop conveyance passage **41** of the powder conveying device (waste-toner conveying device **40**) via a relay drop passage **13***w*. The developer that has flowed into the drop conveyance passage **41** is collected in the waste-developer collection container (waste-toner collection container **30**) via the intersecting conveyance passage **42**. With such a configuration, the developer contained in the developing device **13** can be appropriately refreshed. The powder conveying device (waste-toner conveying device **40**) according to the fifth modification is also formed such that the inflow port **41***a* and the floating member **45** can interfere with each other to prevent the floating member **45** from coming out of the inflow port **41***a* of the drop conveyance passage **41**. Thus, the occurrence of a failure that the floating member **45** comes out of the inflow port **41***a* of the drop conveyance passage **41** can be reduced. Note that a through-hole **45***a* can also be formed in the floating member **45** according to the fifth modification along the direction in which the drop conveyance passage **41** extends (which is the vertical direction) in the same manner as the floating member **45** illustrated in FIGS. **4** and **6**.

[0072] As described above, the waste-toner conveying device **40** (powder conveying device) according to the above-described embodiments of the present disclosure includes a drop conveyance passage **41**, an intersecting conveyance passage **42**, a conveying screw **43**, and a floating member **45**. Waste toner (powder) that has flowed in from the inflow port **41***a* drops by its weight into the drop conveyance passage **41**. The intersecting conveyance passage **42** communicates with a lower end of the drop conveyance passage **41** and extends in an intersecting direction that intersects the drop conveyance passage **41**. The conveying screw **43** is disposed in the intersecting conveyance passage **42** and rotates in a specified direction to convey the waste toner in the intersecting direction. The floating member **45** is movably installed in the drop conveyance passage **41** to float in the drop conveyance passage **41**. The floating member **45** moves in the drop conveyance passage **41** by contact with the conveying screw **43** that rotates in the specified direction. The inflow port **41***a* and the floating member **45** are formed to be able to interfere with each other to prevent the floating member **45** from coming out of the inflow port **41***a* of the drop conveyance passage **41**. With such a configuration, the occurrence of a failure that the floating member **45** comes out of the inflow port **41***a* of the drop conveyance passage **41** can be reduced.

[0073] In the above-described embodiments, the present disclosure is applied to the waste-toner conveying device **40** (powder conveying device) in which the untransferred toner collected by the cleaning device **15** or the intermediate transfer belt cleaner **9** is conveyed as waste toner toward the waste-toner collection container **30**. However, the present disclosure is not limited to the above-described embodiments, and can readily be applied to, for example, a waste-toner conveying device **40** in which only untransferred toner collected in a cleaning device for a photoconductor drum is conveyed as waste toner toward the waste-toner collection container **30**. In the above-described embodiments, the present disclosure is applied to the waste-toner conveying device **40** (powder conveying device) in which waste toner as powder is conveyed. However, the present disclosure is not limited to the above-described embodiments, and can readily be applied to, for example, a powder conveying device in which the untransferred toner (powder) collected by the cleaning device **15** is conveyed as recycle toner toward the developing device **13**, a powder conveying device (see FIG. **11**) in which waste developer (powder) ejected from a developing device is conveyed toward a

waste-developer collection container, or a powder conveying device in which fresh toner (powder) or two-component developer (powder) is conveyed toward a developing device. Such cases also provide substantially the same effects as the effects described above.

[0074] Note that embodiments of the present disclosure are not limited to the above-described embodiments and it is apparent that the above-described embodiments can be appropriately modified within the scope of the technical idea of the present disclosure in addition to what is suggested in the above-described embodiments. Further, the number, position, shape, and so forth of components are not limited to those of the present embodiment and variations, and may be the number, position, shape, and so forth that are suitable for implementing the present disclosure.

[0075] Note that, in the description of the present application, the term "columnar shape" is defined to include not only a cylindrical shape and a polygonal column shape in which a cross-sectional area is constant in a direction in which the column extends but also a shape in which a cross-sectional area is not constant in the direction in which the column extends, for example, a conical shape, a polygonal pyramid shape, and a drum shape. Furthermore, in the description of the present application, the "large-diameter portion" of the floating member is defined as a portion having the largest cross-sectional area regardless of whether the cross section of the floating member (the cross section orthogonal to the direction in which the floating member extends in a columnar shape) is circular or the cross section of the floating member is polygonal.

[0076] Note that aspects of the present disclosure may be, for example, combinations of first to tenth aspects as follows.

[0077] First Aspect

[0078] In a first aspect, a powder conveying device (e.g., the waste-toner conveying device **40**) includes a drop conveyance passage (e.g., the drop conveyance passage **41**), an intersecting conveyance passage (e.g., the intersecting conveyance passage **42**), a conveying screw (e.g., the conveying screw **43**), and a floating member (e.g., the floating member **45**). Powder that has flowed into the drop conveyance passage (e.g., the drop conveyance passage **41**) from an inflow port (e.g., the inflow port **41***a*) drops by its weight in the drop conveyance passage (e.g., the drop conveyance passage **41**). The intersecting conveyance passage (e.g., the intersecting conveyance passage **42**) communicates with a lower end of the drop conveyance passage (e.g., the drop conveyance passage **41**) and extends in an intersecting direction that intersects the drop conveyance passage (e.g., the drop conveyance passage **41**). The conveying screw (e.g., the conveying screw **43**) is disposed in the intersecting conveyance passage (e.g., the intersecting conveyance passage **42**) and rotates in a specified direction to convey the powder in the intersecting direction. The floating member (e.g., the floating member **45**) is movably installed in the drop conveyance passage (e.g., the drop conveyance passage **41**) and floats in the drop conveyance passage (e.g., the drop conveyance passage **41**) to move by contact with the conveying screw (e.g., the conveying screw **43**) that rotates in the specified direction. The inflow port (e.g., the inflow port **41***a*) and the floating member (e.g., the floating member **45**) are configured to be able to interfere with each other to prevent the floating member (e.g., the floating member **45**) from coming out of the inflow port (e.g., the inflow port **41***a*) of the drop conveyance passage (e.g., the drop conveyance passage **41**).

[0079] Second Aspect

[0080] In a second aspect, in the powder conveying device (e.g., the waste-toner conveying device **40**) according to the first aspect, an opening area of the inflow port (e.g., the inflow port **41***a*) is smaller than a projected area of the floating member (e.g., the floating member **45**) when viewed from the inflow port (e.g., the inflow port **41***a*).

[0081] Third Aspect

[0082] In a third aspect, in the powder conveying device (e.g., the waste-toner conveying device **40**) according to the first or second aspect, a vertical relationship of the floating member (e.g., the floating member **45**) does not change in the drop conveyance passage (e.g., the drop conveyance passage **41**). The floating member (e.g., the floating member **45**) has a columnar shape and a large-diameter portion (e.g., the large-diameter portion **45***x*) that can interfere with the inflow port (e.g., the inflow port **41***a*) at least in a part of the floating member (e.g., the floating member **45**).

[0083] Fourth Aspect

[0084] In a fourth aspect, in the powder conveying device (e.g., the waste-toner conveying device **40**) according to any one of the first to third aspects, the floating member (e.g., the floating member **45**) has a through-hole (e.g., the through-hole **45***a*) inside along a direction in which the drop conveyance passage (e.g., the drop conveyance passage **41**) extends.

[0085] Fifth Aspect

[0086] In a fifth aspect, in the powder conveying device (e.g., the waste-toner conveying device **40**) according to the fourth aspect, a cross-sectional area of the through-hole (e.g., the through-hole **45***a*) of the floating member (e.g., the floating member **45**) is formed to gradually increase from a lower end to an upper end of the floating member (e.g., the floating member **45**).

[0087] Sixth Aspect

[0088] In a sixth aspect, in the powder conveying device (e.g., the waste-toner conveying device **40**) according to any one of the first to fifth aspects, each of the drop conveyance passage (e.g., the drop conveyance passage **41**) and the floating member (e.g., the floating member **45**) is formed such that a cross-sectional area of each of the drop conveyance passage (e.g., the drop conveyance passage **41**) and the floating member (e.g., the floating member **45**) gradually increases from a lower end to an upper end of each of the drop conveyance passage (e.g., the drop conveyance passage **41**) and the floating member (e.g., the floating member **45**).

[0089] Seventh Aspect

[0090] In a seventh aspect, in the powder conveying device (e.g., the waste-toner conveying device **40**) according to any one of the first to sixth aspects, the drop conveyance passage (e.g., the drop conveyance passage **41**) is formed such that an opening area of the inflow port (e.g., the inflow port **41***a*) is smaller than a cross-sectional area, which is orthogonal to a direction in which the drop conveyance passage (e.g., the drop conveyance passage **41**) extends, of a portion excluding the inflow port (e.g., the inflow port **41***a*).

[0091] Eighth Aspect

[0092] In an eighth aspect, the powder conveying device (e.g., the waste-toner conveying device **40**) according to any one of the first to seventh aspects further includes an

upstream drop conveyance passage (e.g., the upstream drop conveyance passage **49**) along which powder drops by its weight toward the inflow port (e.g., the inflow port **41***a*) of the drop conveyance passage (e.g., the drop conveyance passage **41**).

[0093] Ninth Aspect

[0094] In a ninth aspect, in the powder conveying device (e.g., the waste-toner conveying device **40**) according to any one of the first to eighth aspects, the inflow port (e.g., the inflow port **41***a*) of the drop conveyance passage (e.g., the drop conveyance passage **41**) is provided with a restricting member (e.g., the restricting member **41***c*) serving as a stopper that restricts the floating member (e.g., the floating member **45**) from coming out of the inflow port (e.g., the inflow port **41***a*).

[0095] Tenth Aspect

[0096] In a tenth aspect, an image forming apparatus (e.g., the image forming apparatus **1**) includes the powder conveying device (e.g., the waste-toner conveying device **40**) according to any one of the first to ninth aspects.

[0097] The above-described embodiments are illustrative and do not limit the present invention. Thus, numerous additional modifications and variations are possible in light of the above teachings. For example, elements and/or features of different illustrative embodiments may be combined with each other and/or substituted for each other within the scope of the present invention.

1. A powder conveying device, comprising:

a drop conveyance passage in which powder entering from an inflow port is to drop;

an intersecting conveyance passage communicating with a lower end of the drop conveyance passage and extending in an intersecting direction that intersects the drop conveyance passage;

a conveying screw disposed in the intersecting conveyance passage, the conveying screw configured to rotate in a specified direction to convey the powder in the intersecting direction; and

a floating member movably installed in the drop conveyance passage, the floating member configured to float in the drop conveyance passage to move by contact with the conveying screw,

wherein the inflow port and the floating member are configured to interfere with each other to prevent the floating member from coming out of the inflow port of the drop conveyance passage.

2. The powder conveying device according to claim **1**,

wherein an opening area of the inflow port is smaller than a projected area of the floating member when viewed from the inflow port.

3. The powder conveying device according to claim **1**,

wherein a vertical relationship of the floating member does not change in the drop conveyance passage, and

wherein the floating member has a columnar shape and includes a portion to interfere with the inflow port at least in a part of the floating member.

4. The powder conveying device according to claim **1**,

wherein the floating member has a through-hole inside along a direction in which the drop conveyance passage extends.

5. The powder conveying device according to claim **4**,

wherein a cross-sectional area of the through-hole gradually increases from a lower end of the floating member to an upper end of the floating member.

6. The powder conveying device according to claim **1**,

wherein a cross-sectional area of the drop conveyance passage gradually increases from the lower end of the drop conveyance passage to an upper end of the drop conveyance passage, and

wherein a cross-sectional area of the floating member gradually increases from a lower end of the floating member to an upper end of the floating member.

7. The powder conveying device according to claim **1**,

wherein an opening area of the inflow port is smaller than a cross-sectional area of a portion of the drop conveyance passage excluding the inflow port, the cross-sectional area being orthogonal to a direction in which the drop conveyance passage extends.

8. The powder conveying device according to claim **1**, further comprising an upstream drop conveyance passage upstream from the drop conveyance passage in a direction of flow of the powder, and

wherein the powder is to drop toward the inflow port of the drop conveyance passage through the upstream drop conveyance passage.

9. The powder conveying device according to claim **1**,

wherein the inflow port of the drop conveyance passage is provided with a stopper that restricts the floating member from coming out of the inflow port.

10. An image forming apparatus, comprising the powder conveying device according to claim **1**.

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