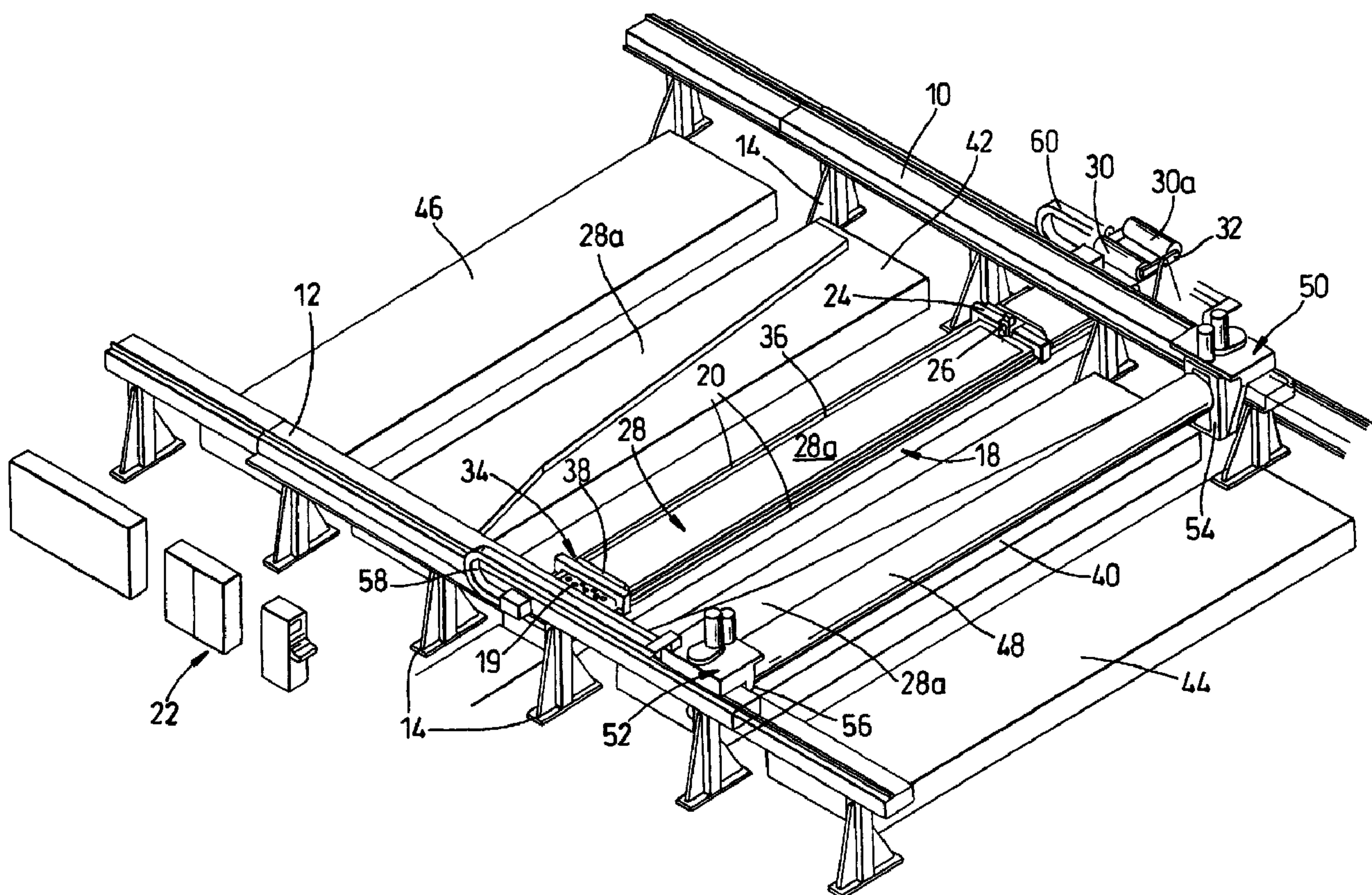




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(54) Titre : MACHINE DE SUPERPOSITION DE TEXTILES DESTINEE A LA PRODUCTION D'UN LAMELLE
(54) Title: A MACHINE FOR LAYING UP FABRIC TO PRODUCE A LAMINATE



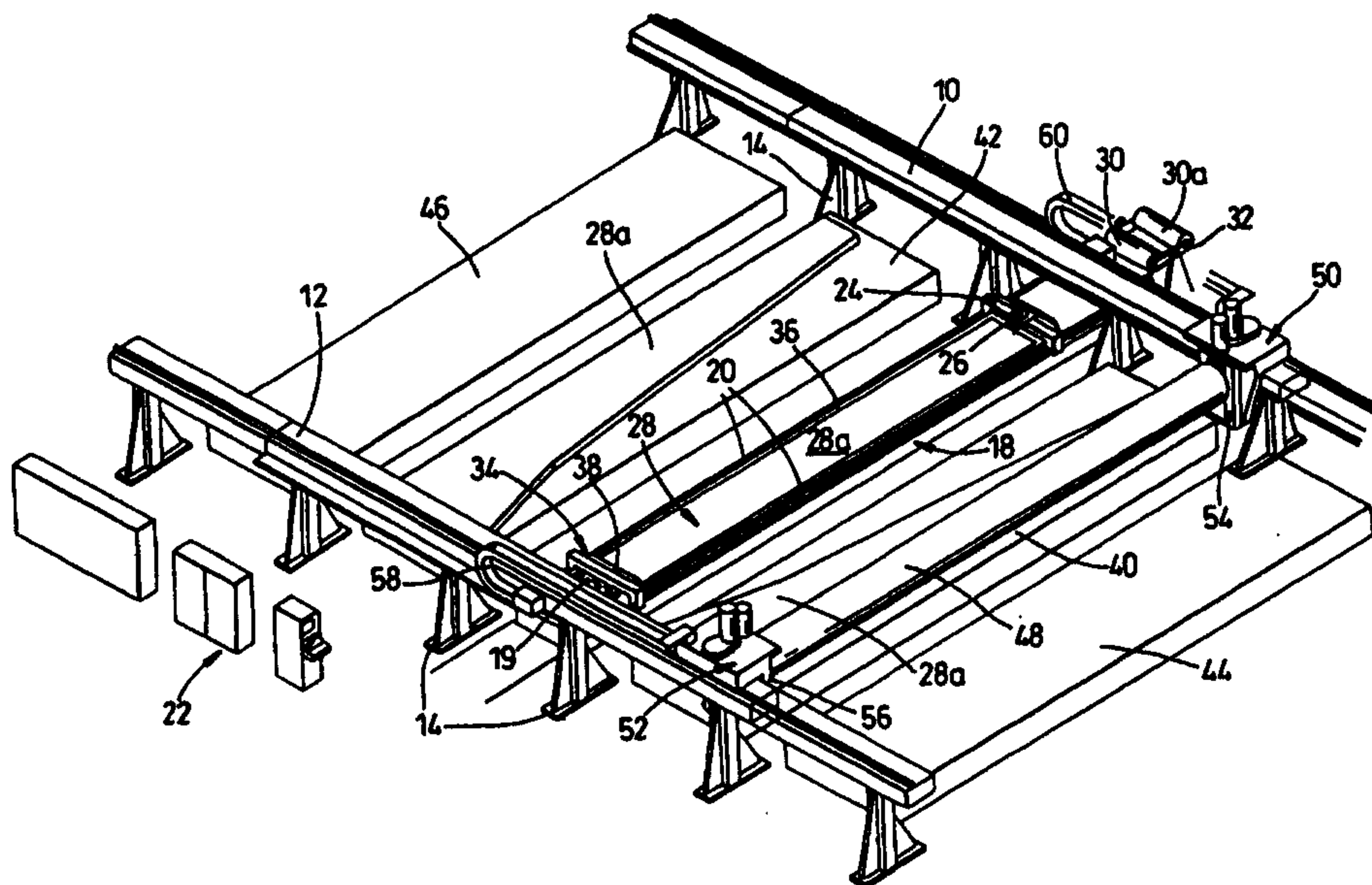
(57) Abrégé/Abstract:

The machine comprises a forming station (18) for receiving a piece of fabric (28) which is shaped at the forming station by a cutter (26). A plurality of lay-up stations (40, 42) is provided and a roller (48) is used to carry the shaped fabric (28a) from the forming station (18) to one or other of the lay-up stations (40, 42). The roller (48) lays the shaped fabric in position at the lay-up station to form part of a laminate at that station. The process is repeated to produce a laminate at the remaining lay-up station. A pick-up device (34) is provided for picking up scrap material left as a peripheral band (36) around the shaped fabric (28a).

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(21) International Application Number: PCT/GB99/03903 (22) International Filing Date: 24 November 1999 (24.11.99) (30) Priority Data: 9825999.7 28 November 1998 (28.11.98) GB (71) Applicant (for all designated States except US): BRITISH AEROSPACE PUBLIC LIMITED COMPANY [GB/GB]; Warwick House, Farnborough Aerospace Centre, P.O. Box 87, Farnborough, Hampshire GU14 6YU (GB). (72) Inventors; and (75) Inventors/Applicants (for US only): KAYE, Allan [GB/GB]; British Aerospace Airbus Limited, New Filton House, Filton, Bristol, Avon BS99 7AR (GB). MARLOW, Ian [GB/GB]; 28 North Street, Oundle, Peterborough, Cambridgeshire PE8 4AL (GB). MILLS, Andrew [GB/GB]; Cranfield University, Aerospace Centre, Building 42A, Cranfield, Bedfordshire MK43 0AL (GB). BACKHOUSE, Robert [GB/GB]; Cranfield University, Aerospace Centre, Building 42A, Cranfield, Bedfordshire MK43 0AL (GB).		(74) Agents: EDIS, Ronald, Malcolm et al.; British Aerospace Public Limited Company, Group IP Department, Lancaster House, Farnborough Aerospace Centre, P.O. Box 87, Farnborough, Hampshire GU14 6YU (GB). (81) Designated States: AE, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, US, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG). Published <i>With international search report.</i>

(54) Title: A MACHINE FOR LAYING UP FABRIC TO PRODUCE A LAMINATE**(57) Abstract**

The machine comprises a forming station (18) for receiving a piece of fabric (28) which is shaped at the forming station by a cutter (26). A plurality of lay-up stations (40, 42) is provided and a roller (48) is used to carry the shaped fabric (28a) from the forming station (18) to one or other of the lay-up stations (40, 42). The roller (48) lays the shaped fabric in position at the lay-up station to form part of a laminate at that station. The process is repeated to produce a laminate at the remaining lay-up station. A pick-up device (34) is provided for picking up scrap material left as a peripheral band (36) around the shaped fabric (28a).

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A MACHINE FOR LAYING UP FABRIC TO PRODUCE A LAMINATE

The invention relates to a machine for laying up fabric to produce a laminate and is primarily concerned with the laying up of fabric to produce skins for aerofoils such as top and bottom skins for aircraft wings.

- 5 Fibre reinforced plastics materials, for example glass or carbon fibre composite materials, can be laid one upon the other in an uncured form to produce a laminate which is then cured to form the final article. Such a material can be produced by laying up tapes side by side as described in UK No 0 118 266 on a single tool and it will be appreciated that manufacture of large wing skins by such a method is a lengthy process.
- 10 The present invention is concerned with the production of laminates from pieces of fabric which will enable the laminates to be produced more quickly than hitherto.

- According to the invention there is provided a machine for laying up fabric to produce laminates, comprising a forming station for receiving a piece of fabric, profiling means at the forming station for shaping the fabric, a plurality of lay-up stations and carrier means
- 15 wherein the carrier means is adapted to carry out the following steps in a single operation:
- i) picking up the shaped fabric from the forming station,
 - ii) transferring the shaped fabric from the forming station to the lay-up stations, and
 - iii) laying the shaped fabric accurately in position at a selected lay-up station,
- to form part of a laminate at that station, the process being repeated to produce a laminate
- 20 at one or more of the remaining lay-up stations.

Such a machine enables several laminates such as top and bottom wing skins to be produced on a single machine and is of considerable advantage in that respect.

The shaped fabric may be accurately positioned at the selected lay-up station by accurately positioning the carrier means over a fixed table of the selected lay-up station.

- 25 In order to ensure that the fabric is laid up accurately, position sensing means may be provided for the carrier means so that the position of the carrier means relative to a set datum can be determined. In that way, the position of the formed fabric on the carrier means can be determined relative to the datum and, in that way, accurate placement of the fabric at the selected lay-up station can be ensured. The or a further position sensing

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means may be provided for sensing the position of the profiling means relative to the same or another datum.

The carrier means may comprise an elongate roller. The shaped formed fabric may also be elongate and may be picked up by the roller so as to lie around the periphery of the roller and extend longitudinally thereof. The roller can then take the elongate section of fabric from the forming station and deposit the fabric at the selected lay-up station. The roller then returns to the forming station to pick up the next piece of formed fabric for delivery to the previous or a further lay-up station. The roller may be divided into axial segments which can be subjected to air pressure, e.g. vacuum. The roller can be applied to the cut fabric at the forming station and vacuum applied to the roller thereby causing the cut fabric to adhere to the surface of the roller. Once the roller has taken the fabric to a lay-up station, positive pressure can then be applied in order to ensure that the fabric detaches from the surface of the roller for placement at the lay-up station.

Means may be provided for positioning the piece of fabric, which may be in the form of a sheet, at the forming station. The forming station may comprise a table on which the piece of fabric is placed and the table may include retention means and/or release means for the fabric. Conveniently, retention means may include the provision for applying vacuum to the surface of the fabric lying on the table to suck the fabric into firm contact with the table. To release the fabric, the vacuum may be released and a positive pressure applied to the said surface of the fabric. Where the fabric is an uncured fibre reinforced plastics, it may have a sticky surface which will tend to adhere to the table and the application of positive air pressure is useful in ensuring that it will be fully released when required.

The roller may also be divided circumferentially into a plurality of sectors and the sectors may house a foam or foam like material which provides a flexible periphery for the roller. Peripheral surfaces of the foam may be protected by a layer of film which may be perforated.

The roller may be mounted on adjustable mountings which will permit the outer tube of the roller to be varied, e.g. for pitch, yaw and/or axial movement.

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The profiling means may comprise a beam of laser light or other suitable cutter which preferably cuts the fabric so as to leave a peripheral length of waste. A single length of waste may be formed such as a ring of waste material around a predetermined cut shape. A suitable removal means may be provided for removing the waste and may take the form of a rotary member such as a wheel or roll. Conveniently, vacuum may be applied to retain the cut piece of fabric in place while the scrap is being removed. The aforesaid removal means may serve a dual purpose. In that respect, it may be used to draw the piece of fabric on to the forming station as well as being used to remove the scrap after the fabric has been cut.

Four lay-up stations may be provided which are adapted to receive shaped fabrics for laying up the respective upper and lower skins for port and starboard aerofoils such as the wings of an aircraft. The profiling means may be programmed to cut left and right hand shapes for the various wing skins.

The skins may be formed by laying a plurality of elongate skin sections edge-to-edge to form a further layer and by laying additional elongate skin sections edge-to-edge to form one or more further layers upon the first layer. In such a case, the edges of the skin sections of one layer are preferably staggered in relation to the edges of the skin sections of an adjacent layer of the laminate.

A machine in accordance with the invention will now be described by way of example with reference to the accompanying drawings in which:

Figure 1 is a perspective view of a preferred form of machine in accordance with the invention;

Figure 2 is a diagrammatic perspective view of part of a roller for the machine shown in Figure 1;

Figure 3 is a perspective view to a larger scale showing part of the roller of Figure 2;

Figure 3A is a perspective view of a roller formed with cut-outs;

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Figure 4 is a plan view showing the way in which individual lengths of fabric are laid up edge-to-edge to form a desired shape; and

Figure 5 is a diagrammatic plan view of forming and lay-up stations of the machine showing the way in which different shapes can be cut from single pieces of material and delivered to the various lay-up stations to produce upper and lower wing skins for port and starboard aircraft wings.

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Looking at Figure 1, two parallel rails 10,12 are carried by floor mount supports 14. A floor mounted table 18 of rectangular shape extends between the rails 10, 12. The table 18 has a perforated upper surface 19 which extends across a multiplicity of honeycomb cells which can be selectively evacuated or pressurised. The table 18 has two parallel rails 20, arranged one each side thereof which slideably support a cross beam 24 on which a laser cutter 26 is slideably mounted. The cross beam 24 is driveable along the rail 22 by a motor-driven rack and pinion (not shown). Likewise, the laser cutter 26 is driveable along the cross beam 24 by a motor-driven rack and pinion (not shown). The table 18 may be somewhat like the table described in EP-A-0 118 266 to which the reader is directed for details. The motors for driving the cross member 24 and the laser cutter 26 are programmed by suitable software at a control station 22 to enable the correct shape to be cut from a sheet of fibre reinforced fabric 28 which is drawn on to the table 18 from a roll of fabric 30. The roll of fabric 30 forms part of a two-roll carousel 32 which may carry either a second roll of fabric 30a or a roll of alternative fabric. The carousel 32 may include more than two-rolls if desired. In order to draw a length of fabric 28 onto the table 18, a pick-up device 34 is provided. The pick-up device 34 is also mounted on the rails 20 and is driveable on the rails by a suitable motor-driven rack and pinion (not shown). The pick-up device moves towards the carousel 32 and the cross beam 24 is also moved slightly toward the carousel 32 so that the pick-up device 34 can pick up the fabric 28 and then move back towards the figure 1 position drawing the fabric 28 from the roll 30 beneath the cross beam 24 and over the length of the table 18. Once the fabric 28 has been laid in position, vacuum is applied to hold the fabric in place and the laser cutter 26 cuts the fabric 28 to the desired shape. It will be noted that a peripheral band of waste material 36 is formed by the laser cutter 26 around the desired cut shape of material. Vacuum is released from the cells overlaid by the band of waste 36 and the pick-up device 34 travels over the fabric 28 picking up the band of waste on a roll 38. The roll may comprise a series of paddles or spokes or a disposable cardboard roll which picks up the band 36 as the device 24 moves towards the carousel 32. Once it reaches that end, the cut fabric remaining on the table 18 is ready to be carried to one of two lay-up sections 40,42. If desired the machine can be extended as shown in ghost outline in Figure 1 to define two or more further lay-up stations 44, 46. Basically, each of the lay-up stations comprises a floor-mounted table.

An elongate roller 48 is mounted on carriages 50,52 which slide on the rails 10,12 respectively. The carriages 50,52 include mountings 54,56 in which the respective ends of the roller 48 are adjustably mounted. Reference should be made to EP-A-0 118 266 for details of the way in which the ends of a roller 48 can be mounted for adjustment. In the present case, the ends of the roller 48 may be moved up and down relative to each other and fore and aft to provide adjustment in pitch and yaw. The mountings 54,56 also enable the axial position of the roller 48 to be adjusted relative to the carriages 50, 52. A drive motor (not shown) is provided on one of the carriages 50,52 for rotating the roller 48 and power for the motor and for motors which adjust the roller 48 is supplied via flexible cable mountings 58,60.

Looking at Figures 2 and 3, the roller 48 is divided axially into a plurality of segments 62 each of which is circumferentially divided by plates 63 into a plurality of sectors 64, 66. In the present case, each segment 62 is divided into 13 sectors 64, ten of which subtend an angle A and three of which 66 subtend a larger angle B. Vacuum/pressure pipes 68 pass axially along the roller 42 to enable each of the sectors 64 to be evacuated or pressurised through apertures 69. As shown in Figure 3, two such pipes 68 may pass through each sector 64 from one end of the roller 48. Each sector 64 is occupied by a wedge-shaped piece of open-cell foam material 70. The foam material 70 is sealed at its edges where it contacts circular dividers 72 between the segments 62 and has its cylindrical periphery covered by a perforated sheet of film 74 shown broken away in Figure 3. The foam inserts 70 form a flexible periphery for that section of the roller defined by the sectors 64. The larger sectors 66 may be used for other purposes, for example, the carrying of individual components to be placed on the laminate produced during the lay-up procedure. Also, the dividers 72 or plates 63 which define the sectors may be formed with cut outs which, in the finished laminate will create recesses or projections to cooperate with components such as ribs or stringers of an aircraft wing. Figure 3A illustrates a roller profile where cut-outs or recesses 73 are formed in the dividers 72 and aligned cut-outs or recesses 73a are formed in the foam inserts 70 for receiving such components. If desired the dividers 72 and foam inserts 70 associated with selected segments 62 may be formed with the cut-outs or recesses 73, 73a.

The position of the roller 48 relative to a datum is known by providing a position sensor (not shown) for the roller 48. The position of the lay-up stations 40, 42 and the position of the shaped fabric 28a on the table 18 are also known accurately in relation to the datum. The angular position of the roller 48 is also accurately determined. The positioning may be effected by known CNC (Computer Numerical Control) methods or by known laser positioning techniques.

Once the roll 38 of the pick-up device 34 has collected the band of scrap 36 as described above, both the cross beam 24 and the pick-up device 34 are moved to the end of the table 18 adjacent the carousel 32. The roller 48 is then moved along the rails 10,12 into a position over the shaped fabric indicated at 28a. The roller 48 is rotated so as to position the film covered periphery correctly in relation to the shaped fabric 28a and the roller is then lowered into contact with the fabric. The cells of the table 18 are pressurised and the sectors 64 of the roller are evacuated. The roller 48 is then moved over the table 18 so that the length of shaped fabric 28a is sucked onto the periphery of the roller so as to extend longitudinally thereof. The roller carriages 50,52 are then driven along the rails 10,12 towards either the lay-up station 40 or the lay-up station 42. In the present case, it is assumed that the roller is moving towards the lay-up station 42. The aforesaid position sensor accurately senses the position of the roller 48 in relation to the lay-up station 42 and when the correct position is reached, pressure is applied to the sectors 64 as the roller 48 rotates and deposits the shaped material 28 on the table of the lay-up station 42. As the roller 48 is doing that, the pick-up device 34 will be drawing a fresh length of fabric 28 from the roll 30 which will then be cut by the laser cutter 26 as before into the appropriate shape dictated by the software. The roller 48 then returns to pick up the next piece of shaped fabric 28a and takes it to the appropriate lay-up station 40 or 42.

The attitude of the roller 48 can be controlled very accurately so that the shaped fabric 28a is laid precisely as required. In that way, several pieces of fabric 28a can be laid edge-to-edge as shown in figure 4 to produce a single layer at a particular lay-up station. Further layers can be formed in the same way to produce the laminate, the edge-to-edge joints J in one layer being staggered with respect to the edge-to-edge joints in adjacent layers. The process can be continued automatically until the required laminates have been produced at the lay-up stations 40,42.

By using four lay-up stations 40, 42, 44 and 46, upper and lower skins for port and starboard aircraft wings can be laid up on a single machine. Figure 5 shows the way in which two shaped pieces of fabric 28a,28b can be cut from a single sheet of fabric 28 to produce upper and lower skins 28a,28b for a starboard wing of an aircraft. The pieces of fabric 28a are carried by the roller 48 to lay-up station 42 and the pieces of fabric 28b are carried by the roller 48 to the lay-up station 40. Sufficient layers of fabric 28a,28b are laid up at those stations to produce laminates of the required thickness. Further pieces of material 28c,28d are also cut from a single piece of material 28 as shown in broken lines and those pieces are carried by the roller 48 to the lay-up stations 44,46 respectively and the procedure is continued so that laminates are produced to form upper and lower wing skins for the port wing of the aircraft. If necessary each piece 28a to 28d may be butted edge-to-edge with other pieces to form a layer of desired form as described above.

If desired, additional components may be placed manually on the laminate being formed at the lay-up stations 40 to 46 during the lay-up process, for example, small pieces of fabric may be used manually as stiffening rims around an access holes formed in the fabric 28 by the laser cutter 26. The roller 48 could be arranged to pick up other components during its journey from the table 18 to the selected lay-up station for deposit at the lay-up station at some point in the lay-up process.

The roller 48a may be tapered or include tapered sectors 62 to vary the way in which the lay-up of the fabric is effected. Normally, however, the roller 48 will be substantially cylindrical throughout its entire length.

Once the lay-up is complete at the lay-up stations 40, 42, the laminate then needs to be prepared for curing in an autoclave. Normally an uncured laminate on its lay-up table is sealingly covered by what is known as a "bagging film". The bagging film is an impervious layer and once in position on the laminate vacuum is applied beneath the bagging film so as to draw it into firm contact with the uncured laminate. The assembly is then placed in an autoclave under pressure, the resultant force from the combined vacuum and pressure consolidating the laid up fabrics during the curing process. Once cured, the laminate is then removed from the autoclave and taken off the lay-up table for use. Conveniently, the machine may be arranged to lay the bagging film onto the laminate after

the lay-up procedure is complete. In that respect, the alternative roll 30a on the carousel 32 may comprise a roll of bagging film which is drawn onto the table 18 by the pick up device 34. Once in position, it is picked up by the roller 48 and carried to the appropriate lay-up station 40,42 where it is deposited on the laid-up fabric. Once in position, the bagging film
5 is sealed around the laminate manually prior to the vacuum being applied.

If desired, the carousel 32 may carry several different rolls of material. For example, one roll may comprise material made by a tape-laying machine where the tape has been laid in one direction. Another roll may have similar material where the tape is rolled in a different direction and several rolls of that type may be used. Commonly used directions for wing
10 skin manufacture are 0° (spanwise for the wing) $+45^\circ$, -45° and 90° (substantially chordwise). The various rolls of material at the carousel may accommodate each of those directions to produce a lay-up of a multi-axial type. If desired, any one of the rollers at the carousel could carry a fabric which is already in the form of a multi-axial lay-up of materials rather than being a material which is produced as a lay-up of tapes in a single
15 direction. The thickness of the fabrics to be used may be in the range of 0.25 mm to 1.5 mm.

The materials for which the fabric is produced may be of a dry fibre type for subsequent impregnation with a suitable matrix or binder, a ready impregnated material or a fabric containing a pre-forming binder. Pre-forming binders are used to help shape dry fibre
20 material which is subsequently impregnated with resin by RTM (Resin Transfer Moulding) or RFI (Resin Film Infusion). The dry fibre has a very small coating of resin to aid handling and cutting due to the fibres being held together better than when uncoated.

Whilst specific reference has been made to the case of a laser cutter 26, the cutter 26 may be an ultrasonic cutter or a reciprocal knife.

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CLAIMS:

1. A machine for progressively laying up fabric to produce laminates, comprising a forming station for receiving a piece of fabric, profiling means at the forming station for shaping the fabric, a plurality of lay-up stations and carrier means wherein the carrier means is adapted to carry out the following steps in a single operation:
- 5 i) picking up the shaped fabric from the forming station,
- 10 ii) transferring the shaped fabric from the forming station to the lay-up stations, and
- iii) laying the shaped fabric accurately in position at a selected lay-up station by positioning the carrier means over a fixed table of the selected lay-up station.
- 15 2. A machine according to claim 1 in which position sensing means is provided for the carrier means.
3. A machine according to claim 2 in which the position sensing means senses the position of the carrier means relative to a set datum so that the position of the shaped fabric on the carrier means is known relative to the datum and the fabric will be deposited in predetermined position at the selected lay-up station.
- 20 4. A machine according to claim 2 or 3 in which a or a further position sensing means is provided for sensing the position of the profiling means relative to the or another datum.
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5. A machine according to any one of claims 1 to 4 in which the carrier means comprises an elongate roller.

6. A machine according to claim 5 in which the shaped fabric is elongate and is picked up by the roller so as to
5 lie around the periphery of the roller and to extend longitudinally thereof.

7. A machine according to claim 5 or 6 in which the roller comprises a plurality of axial segments.

8. A machine according to claim 7 in which each of
10 said axial segments can be subjected to a change in air pressure such as vacuum.

9. A machine according to claim 7 or 8 in which one or more of said axial segments includes means such as recesses for receiving elements to be included in the lay up
15 of fabric.

10. A machine according to claim 7, 8 or 9 in which one or more of said axial segments is tapered axially of the drum.

11. A machine according to any one of claims 7 to 10
20 in which the roller is divided circumferentially into a plurality of sectors.

12. A machine according to claim 11 in which each of said axial segments is divided into sectors.

13. A machine according to claim 9 or 10 in which the
25 angles subtended by some of the sectors are different from those subtended by others.

14. A machine according to claim 11, 12 or 13 in which each sector can be subject to changes in air pressure such as vacuum.

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15. A machine according to any one of claims 11 to 14 in which at least some of the sectors house an open cell foam or open cell foam like material.

16. A machine according to claim 15 in which the foam
5 in each sector has a periphery which lies substantially in the same plane as the periphery of the roller.

17. A machine according to claim 15 or 16 in which foam at each segment intersection is sealed.

18. A machine according to claim 15, 16 or 17 in which
10 the periphery of the foam is protected by a film layer which may be perforated.

19. A machine according to any one of claims 5 to 18 in which the attitude of the roller relative to the lay-up stations and/or the forming stations can be varied.

15 20. A machine according to claim 19 in which the roller is mounted to enable pitch, yaw and/or axial movement thereof to be varied.

21. A machine according to any one of claims 1 to 20 in which means is provided for positioning the piece of
20 fabric at the forming station.

22. A machine according to claim 21 in which the table includes retention means and/or release means for the piece of fabric.

23. A machine according to claim 22 in which the table
25 includes retention means for applying vacuum to the underside of the fabric lying on the table and/or release means which includes provision for applying a positive pressure to the said underside of the fabric.

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24. A machine according to any one of claims 1 to 23 in which a the profiling means forms the fabric to leave a single peripheral piece of waste.

25. A machine according to claim 24 in having removal means for removing the waste comprising a rotary member such as a wheel or a roll.

26. A machine according to claim 24 or 25 in which the removal means includes a disposable element which can be disposed of along with the scrap removed thereby.

27. A machine according to claim 24, 25 or 26 including retention means to retain the remainder of the fabric in place while the scrap is removed.

28. A machine according to any one of claims 25 to 27 in which the removal means is arranged also to position the piece of fabric at the forming station.

29. A machine according to any one of claims 1 to 28 in which the profiling means at the forming station is arranged to shape a further piece of fabric between the time that the carrier means has carried away the first piece of shaped fabric to the selected lay-up station and the time it returns to collect the further piece of shaped fabric.

30. A machine according to any one of claims 1 to 29 adapted to lay up fabric to produce upper and lower skins for an aerofoil such as port and/or starboard wings of an aircraft.

31. A machine according to claim 30 in which four lay-up stations are provided and receive fabrics for laying up the respective upper and lower skins for port and starboard aerofoils.

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32. A machine according to any one of claims 1 to 31 in which the laminate is formed by laying a plurality of elongate shaped fabric pieces edge-to-edge to form a first layer and by laying additional elongate shaped fabric pieces edge-to-edge to form one or more further layers on the first said layer.

33. A machine according to claim 32 in which positions of edges of the shaped fabric pieces of one layer are laid by the machine so as to be staggered in relation to the positions of edges of the shaped fabric pieces of an adjacent layer.

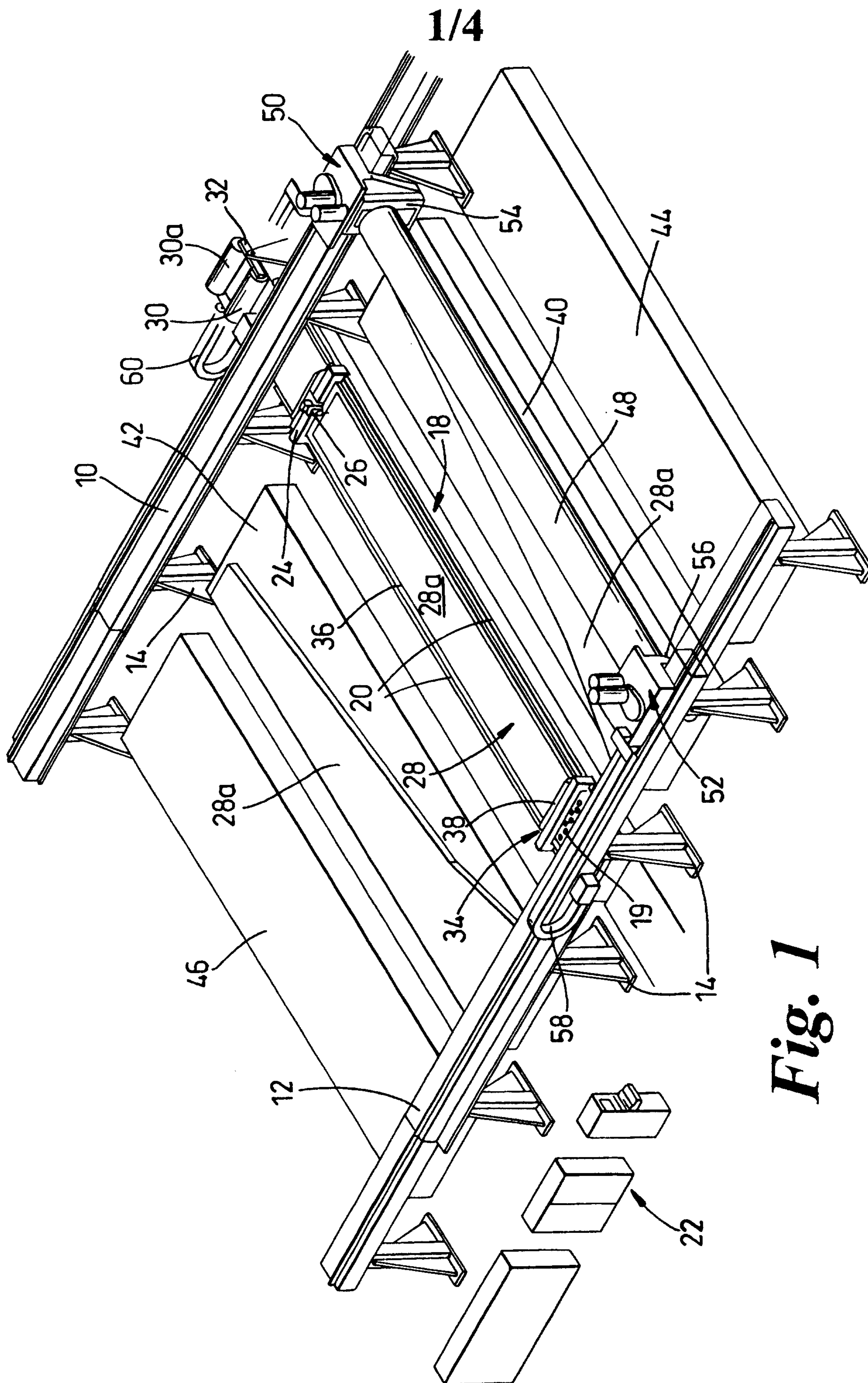
34. A machine according to any one of claims 1 to 33 in which the piece of fabric is drawn from a supply of the fabric such as a roll.

35. A machine according to claim 34 in which a carousel or the like holding different materials such as various types of fabric is provided for use in the machine.

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PATENT AGENTS



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