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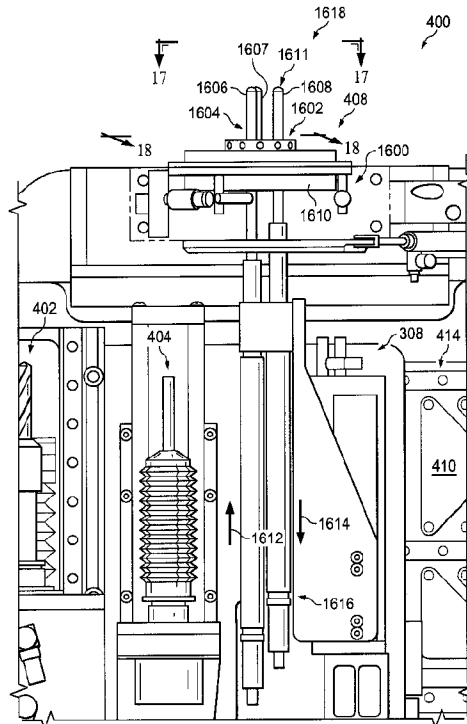
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(54) Titre : SYSTEME ET METHODE DE POSITIONNEMENT D'UN OUTIL AUTOMATISE RELATIVEMENT A UNE
STRUCTURE

(54) Title: SYSTEM AND METHOD FOR POSITIONING AN AUTOMATED ASSEMBLY TOOL RELATIVE TO A
STRUCTURE



(57) Abrégé/Abstract:

A method and apparatus for positioning an end effector relative to a structure. The apparatus may comprise the end effector and a sensor system. The end effector may be configured to perform an operation on the structure. The sensor system may have a plurality of sensors extending outward from the end effector.

ABSTRACT

A method and apparatus for positioning an end effector relative to a structure. The apparatus may comprise the end effector and a sensor system. The end effector may be configured to perform an operation on the structure. The sensor system may have a plurality of sensors extending outward from the end effector.

SYSTEM AND METHOD FOR POSITIONING AN AUTOMATED ASSEMBLY TOOL RELATIVE TO A STRUCTURE

BACKGROUND

1. Field:

The present disclosure relates generally to aircraft and, in particular, to manufacturing aircraft structures. Still more particularly, the present disclosure relates to a system and method for positioning a tool system relative to a structure.

2. Background:

In manufacturing aircraft structures, various operations may be performed to assemble each aircraft structure. These operations may be performed manually by human operators using handheld tools or using automated devices. For example, without limitation, drilling, countersinking, fastening, coupling, sealing, coating, inspecting, or other suitable types of operations may be performed to assemble the aircraft structure.

When performing these operations, precise alignment is needed to avoid rework or discarding of parts. The desire for an increased production rate for aircraft structures has led some manufacturers to use automated drilling and fastening systems in addition to or in place of human operators.

With some existing automated systems, the system must contact the surface of the aircraft structure and press against the surface with a prescribed force. These systems may rely on machine global accuracy and tooling to ensure that the drilling tool is oriented in a desired manner relative to the surface and in contact with the surface. With these systems, however, normality measurements, as well as measurement of clamping forces, may not be as accurate as desired. As a result, holes with poor countersink flushness, as well as fastener misalignment to the surface, may occur.

Other existing solutions may employ an end effector with a pressure-sensing nosepiece. The nosepiece may be the first contact point between the end effector and the airplane skin. With a pressure-sensor integrated into the nosepiece, the nosepiece may provide position feedback as the machine contacts the aircraft structure. This system, however, requires contact with the airplane skin to generate such position information. Consequently, the machine must approach the surface slowly to avoid undesired encounters that could cause undesired inconsistencies to form in the airplane skin, the nosepiece, or both. This slow approach may take more time than desired and reduce the speed at which the aircraft structure is assembled.

These nosepiece systems also give rise to reliability and accuracy concerns. Because the nosepiece also provides clamping force for the automated system, the nosepiece must have a large enough diameter to fit various drills, hole inspection probes, and fastener inserters through the center hole. A large contact surface may reduce countersink depth repeatability due to the differing contours in the surface of the aircraft structure.

Additionally, a nosepiece with a large diameter may contact adjacent fastener heads, skin panel lap joints, and debris on the surface of the skin. As a result, the nosepiece may become misaligned, leading to errors when performing operations. Accordingly, there is a need for a method and apparatus that take into account one or more of the issues discussed above as well as possible other issues.

SUMMARY

According to a first embodiment, there is provided an apparatus including an end effector configured to perform an operation on a structure, and a sensor system having a plurality of sensors extending outward from the end effector.

The apparatus may include a pressure foot connected to the end effector and configured to contact a surface of the structure.

The plurality of sensors may be configured to generate position data about a position of the plurality of sensors relative to the surface of the structure.

The plurality of sensors may be located centrally in the pressure foot and may extend outward substantially perpendicular to a contact surface of the pressure foot.

The plurality of sensors may have an equilateral triangular arrangement.

Each of the plurality of sensors may be located at a corner in the equilateral triangular arrangement, and a channel may run through a center of the equilateral triangular arrangement.

The plurality of sensors may be configured to contact the surface of the structure prior to the pressure foot contacting the surface of the structure.

The plurality of sensors may extend outward from a channel located centrally in the pressure foot.

The apparatus may include a load cell associated with the pressure foot and configured to identify a contact force between the pressure foot and the surface of the structure.

At least one of a speed of the end effector or a distance traveled by the end effector may be modified as the end effector moves toward the surface of the structure based on the contact force identified by the load cell.

The sensor system may be configured to identify whether an object is present on the surface of the structure and to generate a signal configured to stop the end effector before the pressure foot reaches the object.

The apparatus may include a movement system configured to change a position of the end effector relative to a surface of the structure based on position data from the plurality of sensors.

The movement system may be configured to dynamically change the position of the end effector as the end effector moves closer to the surface of the structure.

The movement system may be configured to change an orientation of the end effector to a desired orientation prior to contact with the surface of the structure based on the position data from the plurality of sensors.

The orientation of the end effector may be changed as the end effector moves toward the surface of the structure.

A contact surface of a pressure foot may be substantially parallel to the surface of the structure when the end effector is in the desired orientation.

The movement system may move the end effector at a first speed and may reduce the first speed to a second speed prior to a pressure foot contacting the surface of the structure based on the position data from the plurality of sensors.

A speed of the end effector may be dynamically changed from the first speed to the second speed as the end effector moves toward the surface of the structure.

The apparatus may include a biasing system associated with the plurality of sensors and configured to move the plurality of sensors between an extended position and a retracted position in response to the plurality of sensors contacting a surface of the structure.

The structure may be selected from one of a wing, a fuselage, an aileron, a flap, a slat, a spoiler, a stabilizer, a door, a housing, and a nacelle.

A sensor in the plurality of sensors may be selected from one of a linear variable differential transformer, a capacitive transducer, a contact encoder, a capacitive displacement sensor, an eddy-current sensor, an ultrasonic sensor, an ultrasonic sensor, a laser, and a multi-axis displacement transducer.

The sensor system may be configured to measure a flushness of a fastener inserted into a hole drilled in a surface of the structure.

The end effector may be configured to hold a set of tools comprising at least one of a drilling system, an inspection system, a fastener installer, a sealant applicator, a sprayer, or a cleaning system.

The apparatus may include a number of protective elements positioned on at least one sensor in the plurality of sensors and configured to substantially prevent the at least one sensor from scratching a surface of the structure.

According to a further embodiment, there is provided a method for positioning an end effector relative to a structure, the method involves generating position data about a position of a plurality of sensors in a sensor system relative to a surface of the structure, and changing a position of the end effector relative to the surface of the structure based on the position data generated by the plurality of sensors.

The method may involve changing the position of the end effector as the end effector moves toward the surface of the structure.

The plurality of sensors may extend outward from a pressure foot associated with the end effector.

The plurality of sensors may be located centrally in the pressure foot and may extend outward substantially perpendicular to a contact surface of the pressure foot.

The plurality of sensors may have an equilateral triangular arrangement.

Each of the plurality of sensors may be located at a corner in the equilateral triangular arrangement, and a channel may run through a center of the equilateral triangular arrangement.

The plurality of sensors may be configured to generate the position data about the position of the plurality of sensors relative to the surface of the structure.

The method may involve changing an orientation of the end effector to a desired orientation prior to contact with the surface of the structure based on the position data from the plurality of sensors, wherein the contact surface of the pressure foot is substantially normal to the surface of the structure when the end effector is in the desired orientation.

The method may involve changing the orientation of the end effector as the end effector moves toward the surface of the structure.

The method may involve moving the end effector at a first speed using a movement system, and contacting the surface with at least one sensor in the plurality of sensors as the end effector moves at the first speed.

The method may involve reducing the first speed to a second speed prior to the pressure foot contacting the surface of the structure based on the position data from the plurality of sensors.

The method may involve reducing the first speed to the second speed as the end effector moves toward the surface of the structure.

The method may involve contacting the surface of the structure with the plurality of sensors, and moving the plurality of sensors between an extended position and a retracted position within a housing of the pressure foot as the end effector moves toward the surface of the structure.

The method may involve biasing the plurality of sensors outward from the pressure foot from a channel located centrally in the pressure foot.

The method may involve contacting the surface of the structure using the pressure foot with a desired contact force, and performing an operation on the surface of the structure using a set of tools associated with the end effector.

The method may involve moving the set of tools relative to the surface of the structure using a track system on a shuttle table associated with the end effector to perform the operation.

The method may involve identifying a contact force between the pressure foot and the surface of the structure using a load cell associated with the pressure foot, and modifying at least one of a speed of the end effector or a distance traveled by the end effector based on the contact force identified.

The method may involve modifying at least one of the speed of the end effector or the distance traveled by the end effector as the end effector moves toward the surface of the structure.

The method may involve identifying whether an object is present on the surface of the structure using a sensor in the plurality of sensors, wherein the object protrudes from the surface of the structure, and generating a signal configured to stop the end effector before the pressure foot reaches the object.

The method may involve positioning the plurality of sensors relative to a desired location for a hole to be drilled on the surface of the structure.

The method may involve inspecting a flushness of a fastener inserted into a hole drilled in the surface of the structure using the sensor system.

The method may involve modifying an operation of the end effector based on the flushness of the fastener.

According to a further embodiment, there is provided an assembly system including a mobile platform configured to move to a desired position relative to a location on a surface of a structure, an end effector associated with the mobile platform and configured to perform an operation on the surface of the structure at the location; a pressure foot connected to the end effector and configured to contact the surface of the structure at the location, and a sensor system having a plurality of sensors extending outward from the pressure foot, in which the plurality of sensors is configured to generate position data about a position of the plurality of sensors relative to the location on the surface of the structure.

The system may include a motion platform configured to change an orientation of the end effector to a desired orientation prior to contact with the surface of the structure at the location based on the position data generated from the plurality of sensors.

The motion platform may be configured to change at least one of a position, the orientation, a speed, or a distance traveled by the end effector as the end effector moves toward the location on the surface of the structure.

The motion platform may moves the end effector at a first speed and reduces the first speed to a second speed prior to the pressure foot contacting the location on the surface of the structure based on the position data generated from the plurality of sensors.

The plurality of sensors may be configured to contact the surface of the structure at the location prior to the pressure foot contacting the surface of the structure at the location.

The system may include a biasing system associated with the plurality of sensors and configured to move the plurality of sensors between an extended

position and a retracted position in response to the plurality of sensors contacting the surface of the structure at the location.

The system may include a load cell associated with the pressure foot and configured to identify a contact force between the pressure foot and the surface of the structure, wherein at least one of a speed of the end effector or a distance traveled by the end effector is modified based on an amount of the contact force identified by the load cell.

According to a further embodiment, there is provided a method for drilling a fastener. The method involves moving an end effector toward a surface of a structure at a first speed, in which the end effector is associated with a sensor system having a plurality of sensors extending outward from the end effector, contacting the surface of the structure with at least one of the plurality of sensors, generating position data about a position of the plurality of sensors relative to the surface of the structure, changing a position of the end effector relative to the surface of the structure based on the position data from the plurality of sensors, moving the end effector toward the surface of the structure at a second speed that is slower than the first speed to contact the surface of the structure with the end effector with a desired contact force, and drilling a hole into the surface of the structure using the end effector.

The method involves changing the position of the end effector as the end effector moves toward the surface of the structure.

The end effector may be associated with a pressure foot and the pressure foot may contact the surface of the structure to provide the desired contact force.

The method may involve identifying whether an object is present on the surface of the structure using a sensor in the plurality of sensors, wherein the object protrudes from the surface of the structure, and generating a signal configured to stop the end effector before the pressure foot reaches the object.

The method may involve moving the plurality of sensors between an extended position and a retracted position within a housing of the pressure foot as the end effector moves toward the surface of the structure.

The end effector may be configured to hold a set of tools and further may involve moving the set of tools relative to the surface of the structure using a track system on a shuttle table associated with the end effector to install the fastener.

The method may involve installing the fastener by performing at least one of a drilling operation, a fastening operation, an inspection operation, a measurement operation, a cleaning operation, a sealing operation, or a data collection operation using the set of tools.

According to a further embodiment, there is provided a method for positioning a tool on a surface. The method involves moving the tool relative to the surface to roughly position the tool within a selected region on the surface using a first movement system, and moving the tool relative to the surface with at least one degree of freedom to precisely position the tool at a selected position within the selected region on the surface using a second movement system.

Moving the tool relative to the surface with the at least one degree of freedom to precisely position the tool at the selected position may include moving the tool relative to the surface with the at least one degree of freedom to the selected position using the second movement system, and aligning an element associated with the tool for performing an operation at the selected position relative to the selected position using a third movement system.

According to a further embodiment, there is provided a method for positioning a tool on a surface. The method involves moving the tool relative to the surface to roughly position the tool within a selected region on the surface using a first movement system, moving the tool relative to the surface with at least one degree of freedom to precisely position the tool at a selected position within the selected region on the surface using a second movement system, and aligning an element associated with the tool for performing an operation at the selected position relative to the selected position using a third movement system.

According to a further embodiment, there is provided a method for positioning an assembly system relative to a surface. The method involves moving the assembly system relative to the surface to roughly position the assembly

system within a selected region on the surface using a first movement system, moving a motion platform relative to the surface with at least one degree of freedom to precisely position an end effector on the motion platform at a selected position within the selected region on the surface using a second movement system, and aligning a tool associated with the end effector for performing an operation at the selected position relative to the selected position using the motion platform.

Aligning the tool may involve moving the end effector with the tool toward the surface at a first speed, contacting the surface with at least one sensor in a sensor system, moving the end effector with the tool toward the surface at a second speed, determining a position for the end effector based on position information generated by the sensor, and positioning the end effector such that the tool associated with the end effector is normal to the surface.

In one embodiment there is provided an apparatus including an end effector configured to perform an operation on a structure having a surface and a sensor system having a plurality of sensors on the end effector. Each sensor of the plurality of sensors is extendable and retractable to selectively position a respective contact point of the each sensor relative to the surface independently of a position of the end effector relative to the surface.

In another embodiment there is provided a method for positioning an end effector relative to a structure. The method involves generating position data about a position of a plurality of sensors in a sensor system relative to a surface of the structure. Each sensor of the plurality of sensors is extendable and retractable to selectively position a respective contact point of the each sensor relative to the surface independently of a position of the end effector relative to the surface. The method further involves changing a position of the end effector relative to the surface of the structure based on the position data generated by the plurality of sensors.

In another embodiment there is provided an assembly system including a mobile platform configured to move to a desired position relative to a location on a surface of a structure, an end effector associated with the mobile platform and configured to perform an operation on the surface of the structure at the location, a pressure foot connected to the end effector and configured to contact the surface of the structure at

the location, and a sensor system having a plurality of sensors on the pressure foot. The plurality of sensors are configured to generate position data about a position of the plurality of sensors relative to the location on the surface of the structure. Each sensor of the plurality of sensors is extendable and retractable to selectively position a respective contact point of the each sensor relative to the surface independently of a position of the pressure foot relative to the surface.

In another embodiment there is provided a method for drilling a hole for installing a fastener. The method involves moving an end effector toward a surface of a structure at a first speed. The end effector is associated with a sensor system having a plurality of sensors on the end effector. Each sensor of the plurality of sensors is extendable and retractable to selectively position a respective contact point of the each sensor relative to the surface independently of a position of the end effector relative to the surface. The method further involves contacting the surface of the structure with at least one of the plurality of sensors, generating position data about a position of the plurality of sensors relative to the surface of the structure and changing a position of the end effector relative to the surface of the structure based on the position data from the plurality of sensors. The method further involves moving the end effector toward the surface of the structure at a second speed that is slower than the first speed to contact the surface of the structure with the end effector with a desired contact force and drilling a hole into the surface of the structure using the end effector.

The features and functions can be achieved independently in various embodiments of the present disclosure or may be combined in yet other embodiments in which further details can be seen with reference to the following description and drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

The novel features believed characteristic of the illustrative embodiments are set forth in the appended claims. The illustrative embodiments, however, as well as a preferred mode of use, further objectives and features thereof, will best be understood by reference to the following detailed description of an illustrative embodiment of the present disclosure when read in conjunction with the accompanying drawings, wherein:

Figure 1 is an illustration of a block diagram of a manufacturing environment in accordance with an illustrative embodiment;

Figure 2 is an illustration of a manufacturing environment in accordance with an illustrative embodiment;

Figure 3 is an illustration of an isometric view of an assembly system in accordance with an illustrative embodiment;

Figure 4 is an illustration of an end effector and a set of tools in accordance with an illustrative embodiment;

Figure 5 is an illustration of a top view of an assembly system in accordance with an illustrative embodiment;

Figure 6 is an illustration of an assembly system performing operations in accordance with an illustrative embodiment;

Figure 7 is another illustration of an assembly system performing operations in accordance with an illustrative embodiment;

Figure 8 is yet another illustration of an assembly system performing operations in accordance with an illustrative embodiment;

Figure 9 is still another illustration of an assembly system performing operations in accordance with an illustrative embodiment;

Figure 10 is another illustration of an assembly system performing operations in accordance with an illustrative embodiment;

Figure 11 is yet another illustration of an assembly system performing operations in accordance with an illustrative embodiment;

Figure 12 is still another illustration of an assembly system performing operations in accordance with an illustrative embodiment;

Figure 13 is an illustration of a tool management system in a section in accordance with an illustrative embodiment;

Figure 14 is an illustration of another implementation for an assembly system in accordance with an illustrative embodiment;

Figure 15 is an illustration of a block diagram of an end effector in accordance with an illustrative embodiment;

Figure 16 is an illustration of a side view of a pressure foot on an end effector in accordance with an illustrative embodiment;

Figure 17 is an illustration of a top view of a pressure foot in accordance with an illustrative embodiment;

Figure 18 is an illustration of an end effector moving toward a location on a surface of a panel in accordance with an illustrative embodiment;

Figure 19 is an illustration of a sensor contacting a surface of a panel at a location in accordance with an illustrative embodiment;

Figure 20 is an illustration of an end effector adjusting a position of an end effector in accordance with an illustrative embodiment;

Figure 21 is an illustration of a pressure foot before contacting a surface of a panel in accordance with an illustrative embodiment;

Figure 22 is an illustration of a sensor system inspecting a flushness of a fastener installed in a panel in accordance with an illustrative embodiment;

Figure 23 is an illustration of an end effector approaching an object on a surface of a panel in accordance with an illustrative embodiment;

Figure 24 is an illustration of a sensor contacting an object on a surface of a panel in accordance with an illustrative embodiment;

Figure 25 is an illustration of an end effector approaching a surface of a panel in accordance with an illustrative embodiment;

Figure 26 is an illustration of an end effector with a pressure foot and a sensor system in accordance with an illustrative embodiment;

Figure 27 is an illustration of a flowchart of a process for operating an assembly system to perform an operation on a structure in accordance with an illustrative embodiment;

Figure 28 is an illustration of a flowchart of a process for operating an assembly system to install a fastener in a panel of a structure in accordance with an illustrative embodiment;

Figure 29 is an illustration of a flowchart of a process for positioning an end effector relative to a surface of a structure in accordance with an illustrative embodiment;

Figure 30 is an illustration of a flowchart of a process for positioning an end effector relative to a surface of a structure to perform an operation in accordance with an illustrative embodiment;

Figure 31 is an illustration of a flowchart of a process for applying a desired contact force to a structure to clamp the structure in accordance with an illustrative embodiment;

Figure 32 is an illustration of a flowchart of a process for detecting an object on a surface of a structure using a sensor system in accordance with an illustrative embodiment;

Figure 33 is an illustration of a block diagram of an aircraft manufacturing and service method in accordance with an illustrative embodiment; and

Figure 34 is an illustration of a block diagram of an aircraft is depicted in which an illustrative embodiment may be implemented.

DETAILED DESCRIPTION

The illustrative embodiments recognize and take into account one or more different considerations. For example, without limitation, the illustrative embodiments recognize and take into account that it may be desirable to automate the performance of manufacturing operations on an aircraft structure. In particular, the illustrative embodiments recognize and take into account that it may be desirable to have an automated device capable of performing drilling, measuring, inspecting, fastening, and other suitable operations on an aircraft structure.

The illustrative embodiments also recognize and take into account that it may be desirable to have a device capable of maneuvering under aircraft structures to perform manufacturing operations. For instance, the illustrative embodiments recognize and take into account that some locations on an aircraft structure are difficult for human operators to drill holes in a desired manner.

The illustrative embodiments recognize and take into account that drilling a skin panel of a wing from underneath may provide accuracy and ergonomic challenges. For example, without limitation, inconsistencies, such as incorrectly located holes or delamination, may be formed in holes drilled in the skin panel. As another example, a human operator may experience fatigue when installing

fasteners in the skin panel. These challenges and others may result in the need for rework, discarding the panel or wing, an increase in the cost of manufacturing the wing more than desired, or some combination thereof.

Further, the illustrative embodiments recognize and take into account that it may be desirable to perform manufacturing operations on an aircraft structure without the use of a fixed monument fixture at different locations within the manufacturing facility. In this illustrative example, a “fixed monument fixture” is a structure that is immovably connected to the facility floor, wall, or other portion of the manufacturing facility. In other words, a fixed monument fixture may be a structure that is not configured to be moved in its entirety from one location to another location in the manufacturing facility without unfixing it from the facility floor, walls, or other un-moveable structure. For example, without limitation, a fixed monument fixture may hold a structure in position as operations are performed on the structure. These fixed monument fixtures may include robotic devices bolted to the facility floor, a fixed gantry system, or other structures.

The illustrative embodiments recognize and take into account that fixed monument fixtures reduce flexibility within a manufacturing facility. For instance, disconnecting an assembly from one fixed monument fixture and moving it to the next fixed monument fixture for further assembly may be difficult. This disconnect-move-reconnect time slows production rates and reduces manufacturing flexibility. Further, these fixed monument fixtures may take up more room than desired, allow limited access to the aircraft structures being assembled, or both. Moreover, fixed monument fixtures may be more costly to manufacture, reconfigure, or maintain than desired. Similar problems arise with the use of fixed tool systems.

Thus, the illustrative embodiments provide a method and apparatus for performing operations on a structure. These operations may include installing a fastener in a structure. An assembly system comprises a motion platform and a mobile platform. The motion platform may be configured to be positioned below a surface of a structure to perform an operation on the surface. The mobile platform

may be configured to carry the motion platform across a floor of a manufacturing environment from a first location to a second location.

Turning now to **Figure 1**, an illustration of a block diagram of a manufacturing environment is depicted in accordance with an illustrative embodiment. In this depicted example, manufacturing environment **100** is an environment in which assembly system **102** may be used to install fastener **104** in structure **106**. Manufacturing environment **100** may have floor **107**.

As depicted, manufacturing environment **100** may include structure **106**, autonomous tool system **109**, and system support **108**. In this illustrative example, structure **106** may be an object in aircraft **110**. For example, without limitation, structure **106** may be incorporated in at least one of a wing, a fuselage, a horizontal stabilizer, a door, a housing, an engine, or other suitable structures.

In this illustrative example, structure **106** may take the form of panel **112** of wing **114** in aircraft **110**. Panel **112** may be skin panel **115** in this illustrative example. For instance, panel **112** may be lower skin panel **105** for wing **114**. In other illustrative examples, panel **112** may be a skin panel for a vertical stabilizer in aircraft **110**. In still other illustrative examples, panel **112** may be an upper skin panel for wing **114**, or some other structure, depending on the particular implementation. Other examples for panel **112** may include panels for installation on a fuselage, horizontal stabilizer, flap, spoiler, aileron, door, slat, nacelle or some other aircraft structure. Panel **112** may have surface **116**. Surface **116** may be referred to as a “work surface” in some illustrative examples.

In this depicted example, autonomous tool system **109** may be configured to perform operation **111** on panel **112**. Operation **111** may be referred to as an assembly operation in this illustrative example. For instance, assembly system **102** may be configured to perform at least one of a drilling operation, a fastening operation, an inspection operation, a measurement operation, a cleaning operation, a sealing operation, a data collection operation, or other suitable types of operation **111**.

As used herein, the phrase “at least one of,” when used with a list of items, means different combinations of one or more of the listed items may be used and only one of the items in the list may be needed. The item may be a particular object, thing, or category. In other words, “at least one of” means any combination of items or number of items may be used from the list, but not all of the items in the list may be required.

For example, “at least one of item A, item B, and item C” may mean item A; item A and item B; item B; item A, item B, and item C; or item B and item C. In some cases, “at least one of item A, item B, and item C” may mean, for example, without limitation, two of item A, one of item B, and ten of item C; four of item B and seven of item C; or some other suitable combination.

In this illustrative example, autonomous tool system **109** may take the form of assembly system **102**. In this manner, assembly system **102** may be referred to as an autonomous tool or an automated tool system. Assembly system **102** may be configured to install fastener **104** in surface **116** of panel **112**.

Assembly system **102** may include a number of components. As used herein, a “number of” items may be one or more items. In this illustrative example, a number of components may be one or more components.

One or more components in assembly system **102** may move with at least one degree of freedom up to six degrees of freedom or more. For instance, each component may move with at least one degree of translational freedom or at least one degree of rotational freedom, but can have up to three degrees of translational freedom, up to three degrees of rotational freedom, or both. Each components may move with at least one degree of freedom independently of other components in assembly system **102** in some examples.

Assembly system **102** may be located and positioned based on at least one of global coordinate system **101** and airplane coordinate system **103**, or more particular coordinate systems like wing, flap, spoiler, aileron, door, stabilizer, slat, fuselage, or some other structure or even component systems like spars, ribs,

frames, or some other component. Global coordinate system **101** may be a reference coordinate system for manufacturing environment **100**.

Airplane coordinate system **103** may represent a reference coordinate system in which airplane parts are located in three-dimensional space. Airplane coordinate system **103** may be based on an origin or reference point in aircraft **110**. Using at least one of global coordinate system **101** and airplane coordinate system **103**, assembly system **102** and the components within assembly system **102** may be crudely and precisely positioned relative to structures within manufacturing environment **100**.

As depicted, assembly system **102** may comprise mobile platform **118**, first movement system **119**, end effector **120**, motion platform **122**, second movement system **124**, tool management system **126**, fastener management system **127**, controller **128**, and power supply system **129**. In this illustrative example, mobile platform **118** may be a mechanical device that holds the components within assembly system **102**. For instance, mobile platform **118** may be configured to carry motion platform **122** to perform operation **111**.

In this illustrative example, when an item is “mobile,” the item may be able to move across floor **107** in manufacturing environment **100**. In other words, the item is moveable and not fixed to a particular location in manufacturing environment **100**.

A mobile item also may be drivable. As used herein, an item that is “drivable” may be an item that can drive to different positions by moving or being guided. Driving an item may include moving the item by at least one of translating the item with at least one degree of translational freedom or rotating the item with at least one degree of rotational freedom. Further, driving an item may include moving an entirety of the item and all of the components that make up the item together in unison. A drivable item may be capable of autonomously driving to different locations. In other words, the item may have autonomous or semi-autonomous drive capability to move in its entirety from one location to another location relative to floor **107** in manufacturing environment **100**.

In other cases, a drivable item may be driven by some other system. For example, a controller, a movement system, a human operator, or some other type of device or operator may drive an item. In this manner, a drivable item may be electronically driven, mechanically driven, electromechanically driven, manually driven, or driven in some other manner.

In this illustrative example, mobile platform **118** and the components associated with mobile platform **118** are not fixed in a location. Rather, the entirety of mobile platform **118** may move across floor **107** of manufacturing environment **100**. For example, without limitation, mobile platform **118** may use first movement system **119** to drive from first location **117** to second location **121** on floor **107** of manufacturing environment **100**.

As illustrated, first movement system **119** may be physically associated with mobile platform **118**. A first component, such as first movement system **119**, may be considered to be physically associated with a second component, such as mobile platform **118**, by being secured to the second component, bonded to the second component, mounted to the second component, welded to the second component, fastened to the second component, connected to the second component in some other suitable manner, or a combination thereof. The first component also may be connected to the second component using a third component. Further, the first component may be considered to be associated with the second component by being formed as part of the second component, as an extension of the second component, or a combination thereof.

In this depicted example, first movement system **119** may comprise a number of components configured to drive mobile platform **118** from first location **117** to second location **121**. For instance, first movement system **119** may include wheels, a track system, pulleys, or other suitable movement devices. In this manner, first movement system **119** provides crude positioning for mobile platform **118**.

In an illustrative example, first movement system **119** may include retractable wheels **131**. Retractable wheels **131** may be retracted to lower mobile platform **118**

to floor **107** of manufacturing environment **100**. Lowering mobile platform **118** to floor **107** of manufacturing environment **100** may temporarily plant assembly system **102** in place during installation of fastener **104**. After the installation of fastener **104** is completed, retractable wheels **131** may be extended to lift mobile platform **118** from floor **107** and move mobile platform **118** from first location **117** to second location **121** on floor **107** of manufacturing environment **100**.

In this depicted example, first movement system **119** may include mecanum wheels **133**. Mecanum wheels **133** allow mobile platform **118** to achieve omnidirectional movement. In other words, mecanum wheels **133** may move mobile platform **118** forward and backward, as well as side to side.

In some illustrative examples, mecanum wheels **133** also may be retractable or may lock to substantially prevent undesired movement of mobile platform **118**. In other illustrative examples, first movement system **119** may include holonomic wheels, another type of omni-wheels, casters, other suitable movement devices, or a combination thereof. These types of wheels may or may not be retractable in an illustrative example.

As depicted, end effector **120** may be a device to which set of tools **132** are attached. In particular, end effector **120** may be configured to hold set of tools **132**. Set of tools **132** may be used to install fastener **104** in panel **112**.

As used herein, a “set” of items may be one or more items. In this illustrative example, set of tools **132** may be one or more tools. When two or more tools are present in set of tools **132**, the tools also may be referred to a group of tools, a plurality of tools, simply “tools,” or the like.

In this illustrative example, motion platform **122** may be a device configured to position end effector **120** in desired position **130** relative to surface **116**. In this illustrative example, desired position **130** may include at least one of a location or an orientation for end effector **120** in three-dimensional space relative to panel **112** of structure **106**.

Motion platform **122** may move set of tools **132** on end effector **120** to desired position **130** relative to location **135** on surface **116** of panel **112** to install

fastener **104**. Specifically, motion platform **122** may be configured to position set of tools **132** on end effector **120** relative to surface **116** of panel **112** at location **135**. For example, without limitation, motion platform **122** may position set of tools **132** perpendicular to location **135**, parallel to location **135**, co-linear to a central axis of location **135** for fastener **104**, or in some other manner.

Motion platform **122** provides fine positioning for end effector **120** relative to location **135**. Location **135** may be a desired location for drilling hole **134** for fastener **104**.

When set of tools **132** are positioned relative to location **135** on surface **116** of panel **112**, fastener **104** may be installed in a desired manner. For instance, positioning set of tools **132** perpendicular to surface **116** at location **135** may allow set of tools **132** to drill hole **134** in surface **116** along axis **137**. Axis **137** may run perpendicular to surface **116** at location **135** in some cases. Drilling hole **134** in this manner may provide a desired alignment for fastener **104** when inserted into hole **134**. In another illustrative example, positioning set of tools **132** perpendicular to surface **116** may allow set of tools **132** to drill hole **134** without forming a crack, delamination, or other out of tolerance inconsistencies in panel **112**. In other examples, axis **137** may be at an angle.

In this depicted example, motion platform **122** may take various forms. Motion platform **122** takes the form of hexapod **141** in this illustrative example. In other illustrative examples, without limitation, motion platform **122** may take the form of a Stewart platform or other suitable types of motion platforms.

Motion platform **122** may provide degrees of freedom **139** of movement for end effector **120** in this illustrative example. Degrees of freedom **139** may refer to the movement of end effector **120** in three-dimensional space. For instance, motion platform **122** may be configured to provide seven degrees of freedom **139** for end effector **120**.

As illustrated, second movement system **124** may be physically associated with motion platform **122**. Second movement system **124** may comprise a number of components configured to move motion platform **122** along vertical axis **136**

toward surface **116** of panel **112**. For example, second movement system **124** may include an elevator, a panel, or some other type of structure used to support motion platform **122** as motion platform **122** moves along vertical axis **136**.

Vertical axis **136** may be an axis substantially perpendicular to surface **116** at location **135** in this illustrative example. Set of tools **132** on end effector **120** may move along vertical axis **136** as motion platform **122** moves.

In this illustrative example, set of tools **132** may comprise a number of different types of tools. Set of tools **132** may include sensor system **138**, drilling system **140**, inspection system **142**, and fastener installer **144** in this illustrative example.

In an illustrative example, set of tools **132** may be positioned on shuttle table **146** on end effector **120**. Shuttle table **146** may hold set of tools **132** and move set of tools **132**.

Shuttle table **146** may be configured to move set of tools **132** relative to surface **116** of panel **112** along track system **147**. As an example, shuttle table **146** may move set of tools **132** back and forth along an axis parallel to surface **116** of panel **112** using track system **147**.

As illustrated, sensor system **138** may comprise various sensing devices configured to identify at least one of panel **112**, position **148** of end effector **120** relative to location **135** on surface **116** of panel **112**, or location **135** on surface **116** of panel **112** to drill hole **134** for fastener **104**. For example, without limitation, sensor system **138** may include a camera, a proximity sensor, a magnetic through-skin sensor, or some other suitable type of sensor.

After using at least one of first movement system **119** and second movement system **124**, position **148** of end effector **120** may be verified using sensor system **138** in set of tools **132**. In this illustrative example, position **148** may include a current location, an orientation, or both for end effector **120** relative to surface **116** of panel **112**. Position **148** may be compared to desired position **130** and adjustments may be made.

In some illustrative examples, sensor system **138** may be configured to identify position **148** of end effector **120** relative to location **135** on surface **116** based on index features **150** of surface **116**. Index features **150** may be pre-determined reference points on surface **116**. These index features **150** may take the form of at least one of a magnet, a sensor, a graphical indicator, a radio-frequency identification tag, a target, or some other suitable type of index feature. End effector **120** may be moved along surface **116** based on the position of index features **150**. Index features **150** also may be used to identify where to drill hole **134** in surface **116**.

In some other illustrative examples, sensor system **138** may communicate with metrology system **152** in system support **108** to identify position **148** of end effector **120**. Metrology system **152** may be one or more measurement devices in this illustrative example.

System support **108** with metrology system **152** may be configured to support operation of assembly system **102**. Specifically, system support **108** may provide navigation, utilities, position information, task assignment, and other suitable types of resources.

As an example, system support **108** may provide navigation for assembly system **102**. As another example, metrology system **152** may be configured to make measurements about the position of structure **106** in some illustrative examples. In some cases, system support **108** may provide electricity, air, hydraulic fluid, water, vacuum, or other utilities to assembly system **102**. System support **108** may be configured to provide these resources to various other devices located in manufacturing environment **100** as well.

In this illustrative example, pressure foot **151** may be connected to end effector **120**. Pressure foot **151** may be a pressure-sensing device in this illustrative example. Pressure foot **151** may be the first portion of end effector **120** to contact surface **116** of panel **112**.

In this illustrative example, pressure foot **151** may be configured to identify contact force **153** between pressure foot **151** and surface **116** of panel **112**.

Contact force **153** may be an amount of force exerted on surface **116** by end effector **120**.

Pressure foot **151** may sense contact force **153** using a load cell or some other type of load sensor. An indication of contact force **153** may be desirable to reduce the risk of damage to at least one of surface **116**, end effector **120**, or both.

Pressure foot **151** may be manually or automatically removed and replaced to optimize the area of contact with to panel **112**. For instance, pressure foot **151** may be interchanged with a pressure foot having a different diameter, shape, or other feature. In some illustrative examples, pressure foot **151** may be designed to safely break away in the event of an undesired encounter with panel **112** to avoid damage of panel **112**, components within assembly system **102**, or both.

A desired contact force **153** may be needed in this illustrative example. For instance, contact force **153** may be used to clamp panel **112** to the substructure for panel **112** before installing fastener **104**. As an example, panel **112** may need to be pressed against a rib, spar, or load bearing fitting for proper installation of fastener **104**. Thus, a desired contact force **153** may be needed to achieve these results.

Once end effector **120** and set of tools **132** are in position, assembly system **102** may drill hole **134** in location **135** on surface **116** of panel **112**. Assembly system **102** may drill hole **134** in location **135** on surface **116** using drilling system **140** in this illustrative example.

Drilling system **140** may be configured to drill different types of holes in location **135** on surface **116**. For example, without limitation, hole **134** may take the form of a cylindrical hole, a conical hole, a countersunk hole, a counterbored hole, a spot face, a blind hole, or some other type of hole in this illustrative example.

Drilling system **140** may include spindle **154** and feed axis **156**. In this illustrative example, spindle **154** may comprise a number of mechanical parts configured to rotate to drill hole **134**. As an example, spindle **154** may include a drill bit on an end of spindle **154**. Spindle **154** may rotate the drill bit to drill hole **134** with depth **155** and diameter **158** in a desired manner. In another example, spindle

154 may rotate a milling cutter. Spindle **154** may be operated using hydraulic power, pneumatic power, electricity, or some other energy source.

In some cases, the mechanical parts in spindle **154** may be changed based on the requirements for hole **134**. For instance, the drill bit on spindle **154** may be changed to change at least one of depth **155** and diameter **158** of hole **134**. For example, a thinner bit may be used to decrease diameter **158** of hole **134**. In other illustrative examples, a longer cutter may be used to increase depth **155** of hole **134**.

As depicted, feed axis **156** may be perpendicular to surface **116** at location **135**. In other examples, depending on the particular implementation, feed axis **156** may not be perpendicular to surface **116**.

Feed axis **156** may include various mechanical parts configured to move spindle **154** relative to surface **116** at location **135** to drill hole **134**. For example, without limitation, feed axis **156** may include a platform, a track system, a load cell, a roller bearing, and other mechanical parts. Feed axis **156** may move spindle **154** toward location **135** on surface **116** to drill hole **134**. When hole **134** is completed, feed axis **156** may move spindle **154** in the opposite direction.

After drilling hole **134**, assembly system **102** may inspect hole **134**. Assembly system **102** may use inspection system **142** to inspect hole **134**. Inspection system **142** may inspect at least one of depth **155** and diameter **158** of hole **134**. Inspection system **142** may inspect diameter **158** of hole **134** using hole probe **160**.

In this illustrative example, hole probe **160** may be an elongate device configured to measure diameter **158** of hole **134**. In some illustrative examples, hole probe **160** may be inserted into hole **134** to determine if hole **134** has a desired diameter. Depending on the type of hole **134** formed, inspection system **142** may be used to inspect other parameters for hole **134**. For example, without limitation, inspection system **142** may be used to inspect at least one of a countersink depth, countersink angle, countersink normality to location **135**, the normality of hole **134**

to location **135**, a countersink diameter, a grip length, or some other parameter for hole **134**.

Hole probe **160** may be removed to place a different probe into inspection system **142**. Different probes may be placed into inspection system **142** to inspect different diameters. In some illustrative examples, hole probe **160** may be replaced with a thinner probe to inspect hole **134** having a smaller diameter. In other illustrative examples, hole probe **160** may be replaced with a thicker probe to inspect hole **134** having a larger diameter.

After inspecting hole **134**, assembly system **102** may place fastener **104** into hole **134**. Fastener **104** may join panel **112** to a part positioned against panel **112**. For example, without limitation, fastener **104** may join panel **112** to a rib, a spar, or some other structural member in wing **114**. In another illustrative example, fastener **104** may join a skin panel to panel **112**.

In this depicted example, fastener **104** may take the form of one of a rivet, a lockbolt, a bolt, a hexdrive, and other suitable types of fasteners. Fastener **104** may be placed in hole **134** using fastener installer **144**. In this illustrative example, fastener installer **144** may be a mechanical device configured to apply a force to fastener **104** to insert fastener **104** in hole **134**. In some illustrative examples, fastener installer **144** may accommodate several diameters of fasteners.

Fastener management system **127** may hold fasteners **162** and other parts for fastener installer **144**. Fastener management system **127** may be configured to hold several different diameters and grip lengths of fasteners **162**. Fastener management system **127** may also perform other functions. For example, fastener management system **127** may perform at least one of washing fasteners **162** to remove any residue, applying sealant **164** to fasteners **162**, inspecting fastener and sealant application, supplying one of fasteners **162** having sealant **164** to fastener installer **144**, or other desirable actions.

In this illustrative example, sealant **164** may take the form of a polymeric material, a dielectric material, paint, or some other type of coating material. Sealant

164 may be configured to provide electromagnetic effect protection for fasteners **162**, seal hole **134**, or perform various other functions.

In this depicted example, fastener **104** may have flushness **171** with surface **116** of panel **112**. Flushness **171** may represent the position of fastener **104** relative to surface **116** when installed in panel **112**. For example, without limitation, flushness **171** may represent whether fastener **104** is recessed, proud, or substantially planar to surface **116** of panel **112** within selected tolerances. An indication of flushness **171** of fastener **104** may be desirable to ensure installation of fastener **104** meets at least one of certification requirements, internal manufacturing standards, or other suitable requirements.

As illustrated, tool management system **126** may include a number of parts configured to exchange tool **170** between storage rack **172** and end effector **120**. Tool **170** may be one of set of tools **132** configured for use on end effector **120**. In this illustrative example, storage rack **172** may be a structure used to hold tool **170** and other tools when not used by end effector **120**.

Tool management system **126** may place tool **170** on end effector **120** when tool **170** is needed. In a similar fashion, tool management system **126** may take a tool that is no longer needed off end effector **120** and place it in storage rack **172**.

In this illustrative example, controller **128** may be a device configured to control operation of assembly system **102**. Controller **128** may be in communication with the various components in assembly system **102**, as well as system controller **166** and metrology system **152** in system support **108**.

When one component is "in communication" with another component, the two components may be configured to send signals back and forth over a communications medium. For example, without limitation, controller **128** may communicate with system controller **166** wirelessly over a network. In another illustrative example, controller **128** may communicate with motion platform **122** via a wired or wireless connection.

Controller **128** may be further configured to prevent undesired encounters with human operators **188**, autonomous tool systems **190**, or both in manufacturing

environment **100**. In this illustrative example, autonomous tool systems **190** may be other devices configured to work on panel **112**. In some examples, autonomous tool systems **190** may be referred to as automated tools.

Controller **128** may use system support **108** to determine the location of human operators **188** and maneuver assembly system **102** around human operators **188**. Controller **128** also may be configured to shut down assembly system **102** if human operators **188** are too close to assembly system **102**. In still another illustrative example, controller **128** may use system support **108** to determine the location of autonomous tool systems **190** within manufacturing environment **100** to avoid undesired encounters between assembly system **102** and autonomous tool systems **190**.

In this illustrative example, at least one of controller **128** and system controller **166** may be implemented in software, hardware, firmware, or a combination thereof. When software is used, the operations performed by the controller may be implemented using, for example, without limitation, program code configured to run on a processor unit. When firmware is used, the operations performed by the controller may be implemented using, for example, without limitation, program code and data and stored in persistent memory to run on a processor unit.

When hardware is employed, the hardware may include one or more circuits that operate to perform the operations in the controller. Depending on the implementation, the hardware may take the form of a circuit system, an integrated circuit, an application specific integrated circuit (ASIC), a programmable logic device, or some other suitable type of hardware device configured to perform any number of operations.

With a programmable logic device, the device may be configured to perform the number of operations. The device may be reconfigured at a later time or may be permanently configured to perform the number of operations. Examples of programmable logic devices include, for example, a programmable logic array, a programmable array logic, a field programmable logic array, a field programmable

gate array, and other suitable hardware devices. Additionally, the processes may be implemented in organic components integrated with inorganic components and may be comprised entirely of organic components excluding a human being. For example, the processes may be implemented as circuits in organic semiconductors.

In some illustrative examples, the operations, processes, or both performed by controller **128** and system controller **166** may be performed using organic components integrated with inorganic components. In some cases, the operations, processes, or both may be performed entirely by organic components, excluding a human being. As one illustrative example, circuits in organic semiconductors may be used to perform these operations, processes, or both.

As illustrated, assembly system **102** also may have power supply system **129**. Power supply system **129** may include a power source configured to provide power **168** to assembly system **102**. This power source may take the form of a battery, a solar cell, a pressurized air generator, a fuel cell, a combustion engine, a cable to an external power source, or some other suitable device. Power supply system **129** may be configured to supply power **168** to assembly system **102** such that utility cables or other connections may not be needed to move assembly system **102** relative to surface **116** of panel **112**.

In this illustrative example, steering direction **199** may be provided for assembly system **102**. As an example, steering direction **199** may be provided for mobile platform **118** as mobile platform **118** moves from location to location in through manufacturing environment **100**. Steering direction **199** may take the form of commands, instructions, path generation, physically changing the direction of movement of mobile platform **118**, and other methods of guidance for mobile platform **118**. In this illustrative example, steering direction **199** may dynamically change as conditions within manufacturing environment **100** change.

Steering direction **199** may be provided by at least one of controller **128**, system controller **166**, human operators **188**, or some other suitable device. In other illustrative examples, mobile platform **118** may steer itself, not under the direction of a controller. As an example, system controller **166** may send

commands to steer mobile platform **118** from first location **117** to second location **121**. In yet another example, one or more of human operators **188** may steer mobile platform **118** between first location **117** to second location by physically changing its direction.

In some cases, object **174** may be present on surface **116** of panel **112**. Object **174** may be, for example, without limitation, a protrusion, foreign object debris, an installed fastener, a seal, a cap, and other suitable types of objects. Contact with object **174** by pressure foot **151** or other portions of end effector **120** may be undesirable because it may affect position **148** of end effector **120** relative to surface **116** of panel **112**.

As an example, contact with object **174** may cause misalignment in pressure foot **151** relative to surface **116**. When misalignment occurs, operation **111** may be performed incorrectly. For example, without limitation, hole **134** may be drilled at an undesired angle. In another illustrative example, fastener **104** may be installed such that flushness **171** is outside selected tolerances.

The illustration of manufacturing environment **100** in **Figure 1** is not meant to imply physical or architectural limitations to the manner in which an illustrative embodiment may be implemented. Other components in addition to or in place of the ones illustrated may be used. Some components may be unnecessary. Also, the blocks are presented to illustrate some functional components. One or more of these blocks may be combined, divided, or combined and divided into different blocks when implemented in an illustrative embodiment.

For example, in some cases, first movement system **119** may include at least one of an air system, retractable tracks, or other devices in addition to or in place of retractable wheels **131**, mecanum wheels **133**, or other types of omni-wheels or omni-directional wheels, or some combination thereof. The air system may include, for example, without limitation, air bearings that may be used to form air cushions that can be used to move mobile platform **118**. In some illustrative examples, a locking mechanism also may be included. In another illustrative example, gravity may hold mobile platform **118** in place.

In still other illustrative examples, set of tools **132** may include tools in addition to or in place of the ones shown in **Figure 1**. In still other illustrative examples, an additional sealant applicator, a cleaning system, a sprayer, a cooling system, or other device also may be positioned on end effector **120**.

Turning next to **Figure 2**, an illustration of a manufacturing environment is depicted in accordance with an illustrative embodiment. Manufacturing environment **200** may be an example of a physical implementation for manufacturing environment **100** in **Figure 1**.

In this depicted example, manufacturing environment **200** may include wing assembly **202**. Wing assembly **202** may be an example of a physical implementation for wing **114** shown in block form in **Figure 1** as wing **114** is being assembled.

As depicted, assembly system **204** may be positioned below wing assembly **202**. In this illustrative example, assembly system **204** may be positioned below surface **206** of panel **208** of wing assembly **202**. For instance, panel **208** may be a lower skin panel for wing assembly **202**. Surface **206** and panel **208** may be examples of physical implementations for surface **116** and panel **112**, respectively, shown in **Figure 1**.

In **Figure 3**, an illustration of an isometric view of assembly system **204**, shown in the direction of lines **3-3** in **Figure 2**, is depicted in accordance with an illustrative embodiment. In this depicted example, an enlarged view of assembly system **204** is shown such that components within assembly system **204** may be seen in greater detail.

As depicted, assembly system **204** may include mobile platform **300**, end effector **302**, and motion platform **304**. Mobile platform **300**, end effector **302**, and motion platform **304** may be examples of physical implementations for mobile platform **118**, end effector **120**, and motion platform **122**, respectively, shown in block form in **Figure 1**.

In this illustrative example, mobile platform **300** may move relative to wing assembly **202** shown in **Figure 2** using first movement system **306**. First

movement system **306** may take the form of retractable wheels **307** in this illustrative example. Retractable wheels **307** retract to temporarily plant assembly system **102** in place while installing a fastener (not shown in this view) in surface **206** of panel **208** in **Figure 2**. First movement system **306** with retractable wheels **307** may be an example of a physical implementation for first movement system **119** with retractable wheels **131** shown in block form in **Figure 1**.

As illustrated, end effector **302** may be connected to motion platform **304**. Motion platform **304** may move end effector **302** relative to surface **206** of panel **208**. End effector **302** may hold set of tools **308**. Set of tools **308** may be used to install the fastener in panel **208**. Set of tools **308** may be an example of a physical implementation for set of tools **132** in **Figure 1**.

In this illustrative example, second movement system **310** may move motion platform **304** and end effector **302** along vertical axis **312**. Second movement system **310** may include platform **314** in this illustrative example. Platform **314** may move motion platform **304** back and forth along vertical axis **312**. Second movement system **310** and vertical axis **312** may be examples of physical implementations for second movement system **124** and vertical axis **136**, respectively, shown in **Figure 1**.

As depicted, assembly system **204** also may include fastener management system **316**, tool management system **318**, and controller **320**. Fastener management system **316**, tool management system **318**, and controller **320** may be examples of physical implementations for fastener management system **127**, tool management system **126**, and controller **128**, respectively, shown in block form in **Figure 1**.

In this illustrative example, fastener management system **316** and tool management system **318** may be configured to assist set of tools **308** in installing the fastener. For example, without limitation, fastener management system **316** may supply the fastener to set of tools **308** for installation. In another illustrative example, tool management system **318** may supply a drill bit with a desired

diameter to set of tools **308** for use. Tool management system **318** is shown in section **311**.

In this depicted example, controller **320** may be configured to control the operation of each of the components in assembly system **204**. For instance, controller **320** may be configured to retract and extend retractable wheels **307**. As another example, controller **320** may send commands to move platform **314** along vertical axis **312** in a desired manner. In another illustrative example, controller **320** may communicate with tool management system **318** to provide a desired tool for use on end effector **302**.

In some cases, controller **320** may receive commands from a system controller (not shown in this view) to navigate assembly system **204** through manufacturing environment **200**. Alternatively, controller **320** may autonomously drive assembly system **204**. In still another illustrative example, assembly system **204** may be non-autonomously driven from one location to another location. Steering direction may be provided as assembly system **204** moves through manufacturing environment **200**. Steering direction may be provided by at least one of controller **320**, the system controller, a human operator, or some other suitable device. In other illustrative examples, mobile platform **300** may steer itself, not under the direction of a controller.

With reference now to **Figure 4**, an illustration of end effector **302** and set of tools **308** shown in the direction of view lines **4-4** in **Figure 3** is depicted in accordance with an illustrative embodiment. In this view, an enlarged view of end effector **302** is shown such that the components within set of tools **308** and end effector **302** are seen in greater detail.

As depicted, set of tools **308** may include sensor system **400**, drilling system **402**, inspection system **404**, and fastener installer **406**. Sensor system **400**, drilling system **402**, inspection system **404**, and fastener installer **406** may be examples of physical implementations for sensor system **138**, drilling system **140**, inspection system **142**, and fastener installer **144**, respectively, shown in block form in **Figure 1**.

Pressure foot **408** may also be seen in this view. Pressure foot **408** may be part of sensor system **400** in this illustrative example. In an illustrative example, pressure foot **408** may be the first contact point with surface **206** of panel **208** in **Figure 2**. Pressure foot **408** may be an example of a physical implementation for pressure foot **151** in **Figure 1**.

In this depicted example, pressure foot **408** may include channel **409**. Channel **409** may be an opening in pressure foot **408**. Each tool in set of tools **308** may be extended and retracted through channel **409** to perform operations on panel **208**.

A tool in set of tools **308** may move to align with channel **409** of pressure foot **408** before being extended. As operations are performed on panel **208**, pressure foot **408** may remain in contact with surface **206** of panel **208** to provide a desired clamping force and alignment.

As illustrated, end effector **302** may include shuttle table **410** and connector **412**. Shuttle table **410** may provide structural support for set of tools **308**. Shuttle table **410** also may move set of tools **308** along track system **414**.

In this illustrative example, shuttle table **410** may move set of tools **308** back and forth in the direction of arrow **416** using track system **414**. Shuttle table **410** and track system **414** may be examples of a physical implementations for shuttle table **146** and track system **147** shown in **Figure 1**. Connector **412** may be an umbilical cable configured to connect set of tools **308** with various utilities in this illustrative example.

In **Figure 5**, an illustration of a top view of assembly system **204** shown in the direction of lines **5-5** in **Figure 3** is depicted in accordance with an illustrative embodiment. In this illustrative example, motion platform **304** may include linear actuators **500** and disc actuator **502**. Disc actuator **502** is connected to end effector **302** in this illustrative example. The motion of linear actuators **500** or disc actuator **502** may result in movement of end effector **302** in this illustrative example.

Linear actuators **500** may be configured to extend and retract individually to move disc actuator **502** with six degrees of freedom in this illustrative example.

Specifically, linear actuators **500** may be configured to translate disc actuator **502** in x-axis **504**, y-axis **505**, and z-axis **506** and rotate disc actuator **502** about x-axis **504**, y-axis **505**, and z-axis **506**.

In this illustrative example, disc actuator **502** may be configured to rotate in the direction of arrow **508** to move end effector **302** about the circumference of disc actuator **502**. In this manner, motion platform **304** provides an additional degree of freedom of movement for end effector **302**. In other words, linear actuators **500** with disc actuator **502** may provide a total of seven degrees of freedom of movement for end effector **302**. Linear actuators **500**, disc actuator **502**, or both may move individually or simultaneously to place end effector **302** in a desired position relative to surface **206** of panel **208** shown in **Figure 2**.

Figures 6-12 show illustrations of assembly system **204** performing operations in accordance with an illustrative embodiment. Specifically, **Figures 6-12** show assembly system **204** installing a fastener in surface **206** of panel **208** in the direction of lines **6-6** in **Figure 2**.

Turning to **Figure 6**, mobile platform **300** has been placed in a desired position relative to location **601** on surface **206** of panel **208** using first movement system **306**. Location **601** may be a location for a hole (not shown in this view) and is an example of a physical implementation for location **135** on surface **116** in **Figure 1**. Second movement system **310** may move motion platform **304** in the direction of arrow **600** along vertical axis **312** toward surface **206**.

In **Figure 7**, motion platform **304** has moved in the direction of arrow **600** in **Figure 6**. Sensor system **400** may be used to determine a location for a hole to be drilled (not shown in this view). Motion platform **304** may then be used to position end effector **302** with set of tools **308** perpendicular to location **601** on surface **206** of panel **208** in this illustrative example.

In this illustrative example, a portion of linear actuators **500** may be extended to position end effector **302**. In addition, disc actuator **502** may rotate end effector **302** in the direction of arrow **508**.

Turing next to **Figure 8**, pressure foot **408** may contact surface **206** of panel **208**. Pressure foot **408** may identify a contact force between pressure foot **408** and surface **206** of panel **208**. Movement of end effector **302** may be slowed in response to the contact until end effector **302** is in a desired position against surface **206**.

In this illustrative example, sensor system **400** may then be used to confirm a desired position for end effector **302** relative to surface **206**. Sensor system **400** may confirm that end effector **302** and set of tools **308** are positioned perpendicular to surface **206** at location **601**. Set of tools **308** is shown in section **800** in this illustrative example. Set of tools **308** may be moved in the direction of arrow **802** on track system **414** to move drilling system **402** into a position to drill the hole.

In **Figure 9**, drilling system **402** may be used to drill hole **900** in surface **206** of panel **208** at location **601**. In particular, spindle **902** with drill bit **903** may extend in the direction of arrow **600** along feed axis **904**. Spindle **902** and feed axis **904** may be examples of spindle **154** and feed axis **156**, respectively, in drilling system **140** shown in **Figure 1**.

After drilling hole **900**, spindle **902** may retract downward to its previous position. Set of tools **308** may then move in the direction of arrow **906** along track system **414** into a position to inspect hole **900**.

With reference to **Figure 10**, inspection system **404** may be extended in the direction of arrow **600** to inspect hole **900**. In this illustrative example, hole probe **1000** may be used to measure a diameter of hole **900**. Hole probe **1000** may be an example of hole probe **160** shown in block form in **Figure 1**.

After inspection of hole **900**, hole probe **1000** retracts downward to its previous position. A fastener (not shown in this view) may then be installed in hole **900**. End effector **302** and set of tools **308** may move to position fastener installer **406** relative to hole **900**.

In **Figure 11**, fastener installer **406** may insert fastener **1100** into hole **900**. Fastener installer **406** may move from side to side using track system **414** and then extend vertically to insert fastener **1100** in hole **900**.

Referring now to **Figure 12**, fastener installer **406** has installed fastener **1100** into hole **900**. End effector **302** may now be repositioned relative to a next location to drill a hole.

In this illustrative example, assembly system **204** may be configured to provide “one-up assembly” of fasteners in panel **208**. In this illustrative example, “one-up” assembly may refer to the process of drilling and fastening joints without having to drill holes, to disassemble parts for cleaning and/or deburring before reassembling to install fasteners. This one-up assembly may increase the rate at which fasteners may be installed in panel **208** and also may increase wing assembly rates.

In other illustrative examples, assembly system **204** may not install fastener **1100**. Instead, assembly system **204** may only drill and measure holes in panel **208**. Various fasteners may be subsequently installed by assembly system **204**, a human operator, some other type of device, or a combination thereof.

In another illustrative example, assembly system **204** may be used in a non-one-up assembly situation. For instance, assembly system **204** may drill first drill hole **900** and inspect the diameter of hole **900**, before being moved away from panel **208**. Panel **208** may then be lowered, cleaned, deburred, and reinstalled. Assembly system **204** then may be brought back into place for fastener insertion.

With reference next to **Figure 13**, an illustration of tool management system **318** in section **311** from **Figure 3** is depicted in accordance with an illustrative embodiment. In this example, tool management system **318** is shown without other components in assembly system **204** to better show features of tool management system **318**.

In this depicted example, tool management system **318** may include a number of components. As depicted, tool management system **318** may include robot arm **1300**, storage rack **1302**, and tools **1304**.

As depicted, robot arm **1300** may have end effector **1306**. End effector **1306** is configured to hold a portion of tools **1304** to exchange tools **1304** with end effector **302** shown in **Figure 3**. For instance, end effector **1306** may exchange a

probe, a drill bit, a removable pressure foot, or other tools with end effector **302**, depending on the operations being performed by end effector **302**.

In this illustrative example, storage rack **1302** also may hold a portion of tools **1304**. Robot arm **1300** may use end effector **1306** to drop off a tool in storage rack **1302**. In a similar fashion, robot arm **1300** may use end effector **1306** to pick up a tool stored in storage rack **1302**. In this manner, tool management system **318** may provide various tools **1304** for use on panel **208** shown in **Figure 2**.

In **Figure 14**, an illustration of another implementation for an assembly system is depicted in accordance with an illustrative embodiment. In this depicted example, assembly system **1400** may be an example of a physical implementation for assembly system **102** shown in block form in **Figure 1**.

As depicted, assembly system **1400** may include the same or different components from assembly system **204** shown in **Figure 2**. In this illustrative example, assembly system **1400** may include mobile platform **1402**, movement system **1403**, end effector **1404**, motion platform **1406**, controller **1408**, tool management system **1410**, and fastener management system **1412**. Mobile platform **1402**, movement system **1403**, end effector **1404**, motion platform **1406**, controller **1408**, tool management system **1410**, and fastener management system **1412** may be examples of physical implementations for mobile platform **118**, first movement system **119**, end effector **120**, motion platform **122**, controller **128**, tool management system **126**, and fastener management system **127**, respectively, shown in block form in **Figure 1**.

In this depicted example, movement system **1403** may include mecanum wheels **1414** attached to mobile platform **1402**. Mecanum wheels **1414** are used to move mobile platform **1402**. Mecanum wheels **1414** may be an example of a physical implementation for mecanum wheels **133** shown in block form in **Figure 1**, or other types of omni-wheels or omni-directional wheels used in an illustrative embodiment.

A second movement system (not shown in this view) may move motion platform **1406** along vertical axis **1416**. Motion platform **1406** may move end

effector **1404** relative to a surface of a structure (not shown in this view). This movement may include rotation in the direction of arrow **1418**.

As illustrated, end effector **1404** may hold set of tools **1420** that perform operations on the structure. Set of tools **1420** may perform these operations under the control of controller **1408**. Fastener management system **1412** and tool management system **1410** supply components to set of tools **1420** in this illustrative example.

The illustrations of assembly system **204** in **Figures 2-13** and assembly system **1400** in **Figure 14** are not meant to imply physical or architectural limitations to the manner in which an illustrative embodiment may be implemented. Other components in addition to or in place of the ones illustrated may be used. Some components may be optional.

The different components shown in **Figures 2-14** may be illustrative examples of how components shown in block form in **Figure 1** can be implemented as physical structures. Additionally, some of the components in **Figures 2-14** may be combined with components in **Figure 1**, used with components in **Figure 1**, or a combination of the two.

Although the illustrative embodiments are shown and described with reference to panel **208** of a wing, assembly system **204** is not so limited. Assembly system **204** may be used for performing operations in lower sections of fuselage panels, lower wing to body joint, and other types of structures.

The illustrative embodiments may be used with various configurations of structures that hold wing assembly **202**. For example, without limitation, assembly system **204** may be used with immobile or semi-mobile fixtures where there is access from below. Alternatively, assembly system **204** may be arranged below drivable supports configured to hold wing assembly **202**. These drivable supports may take the form of automated guided vehicles. In this manner, assembly system **204** is versatile in its use within manufacturing environment **200**.

The illustrative embodiments further recognize and take into account one or more different considerations with respect to positioning end effector **120** with

pressure foot **151** relative to surface **116** of structure **106**. For example, without limitation, the illustrative embodiments recognize and take into account that it may be desirable to determine position **148** of end effector **120** prior to end effector **120** contacting surface **116** of structure **106**. As an example, it may be desirable to modify a speed, an orientation, or both, of end effector **120** before contacting surface **116** of structure **106**. These parameters may be modified such that pressure foot **151** contacts surface **116** with a desired contact force to clamp structure **106** with its substructure, to reduce the risk of inconsistencies forming in structure **106**, to reduce the risk of damages to pressure foot **151**, or a combination thereof.

The illustrative embodiments also recognize and take into account that it may be desirable to provide more accurate position data for end effector **120** as end effector **120** moves toward surface **116**. For example, without limitation, it may be desirable to avoid objects protruding from surface **116** as pressure foot **151** contacts surface **116**. These undesired objects may cause inaccurate position data to be collected by sensor system **138**. With inaccurate position data, operation **111** may be performed in an undesired manner. In addition, it may be desirable to position the sensors in sensor system **138** around location **135** for hole **134** such that more accurate position data is generated for end effector **120** with respect to location **135**.

The illustrative embodiments further recognize and take into account that it may be desirable to increase the speed at which end effector **120** approaches surface **116**. An increase in approach speed may lead to drilling and fastening operations being performed more quickly than with some currently used systems. As a result, the time needed to manufacture structure **106** may be reduced.

Thus, the illustrative embodiments provide a method and apparatus for positioning end effector **120** relative to structure **106**. An apparatus may comprise end effector **120** and sensor system **138**. End effector **120** may be configured to perform an operation on structure **106**. Sensor system **138** may have a plurality of sensors extending outward from end effector **120**.

Turning to **Figure 15**, an illustration of a block diagram of end effector **120** from **Figure 1** is depicted in accordance with an illustrative embodiment. In this depicted example, examples of components that may be used to implement end effector **120** are shown in this figure.

As depicted, pressure foot **151** may be connected to end effector **120**. Pressure foot **151** may be configured to contact surface **116** of structure **106** at location **135** shown in **Figure 1**.

In this illustrative example, pressure foot **151** may have housing **1500**, contact surface **1502**, and channel **1504**. Housing **1500** may be a structure surrounding components within pressure foot **151**. Housing **1500** of pressure foot **151** may be connected to end effector **120** in this illustrative example.

As shown, contact surface **1502** may be a portion of pressure foot **151** that is oriented toward surface **116** of panel **112** in **Figure 1**. In some illustrative examples, contact surface **1502** may be positioned on end effector **120** such that contact surface **1502** protrudes slightly from end effector **120**. In other words, contact surface **1502** may extend outward from end effector **120**. In this manner, contact surface **1502** of pressure foot **151** is the portion of end effector **120** that contacts surface **116** of structure **106**.

Pressure foot **151** may be configured to contact surface **116** at location **135** with desired contact force **1506**. Desired contact force **1506** may be an amount of force needed for set of tools **132** to perform operation **111** in **Figure 1** in a desired manner. In this illustrative example, desired contact force **1506** may be an amount of force sufficient to push structure **106** against a substructure to clamp the components in place.

Structure **106** may be clamped before performing operation **111**. As an example, panel **112** may need to be clamped to a rib or spar with desired contact force **1506** to install fastener **104** shown in **Figure 1**. Desired contact force **1506** may be zero when it is not desirable for pressure foot **151** to contact surface **116**.

In this illustrative example, pressure foot **151** may remain in contact with surface **116** of structure **106** at location **135** throughout the performance of

operation **111** on structure **106**. In particular, contact surface **1502** may remain in contact with surface **116** as set of tools **132** move along track system **147** in shuttle table **146** to install fastener **104**. Pressure foot **151** may exert desired contact force **1506** as fastener **104** is being installed.

In this illustrative example, channel **1504** may be located centrally in pressure foot **151**. Channel **1504** may be a space within housing **1500** of pressure foot **151** through which set of tools **132** may pass. Channel **1504** may extend centrally through substantially all of housing **1500** in this illustrative example. Channel **409** in pressure foot **408** in **Figure 4** may be an example of a physical implementation for channel **1504** shown in this figure.

In this depicted example, channel **1504** of pressure foot **151** may provide access for set of tools **132** to location **135** on surface **116** of structure **106**. For instance, inspection system **142** may move along track system **147** in shuttle table **146** to align with channel **1504** of pressure foot **151**. Inspection system **142** then may be extended through channel **1504** in pressure foot **151** to inspect location **135** on surface **116** of structure **106**.

As another illustrative example, fastener installer **144** may move along track system **147** to align with channel **1504**. Fastener installer **144** may then extend through channel **1504** to install fastener **104** in hole **134**. Pressure foot **151** may maintain desired contact force **1506** to push surface **116** of structure **106** at location **135** against its substructure during these operations.

As depicted, load cell **1508** may be associated with pressure foot **151**. Load cell **1508** may be connected to contact surface **1502** of pressure foot **151**.

In this depicted example, load cell **1508** may be a device configured to identify contact force **153** between pressure foot **151** and surface **116** of structure **106**. In particular, load cell **1508** may be configured to identify contact force **153** between contact surface **1502** of pressure foot **151** and surface **116** at location **135**.

In this illustrative example, as contact surface **1502** of pressure foot **151** touches surface **116** at location **135**, load cell **1508** may identify contact force **153**. At least one of speed **1510** of end effector **120** or distance **1512** traveled by end

effector **120** may be modified based on contact force **153** identified by load cell **1508**. For example, without limitation, end effector **120** may be steered as it moves toward work surface **116** using feedback provided by at least one of load cell **1508**, a metrology system **152** in **Figure 1**, and sensor system **138**. In other words, steering may occur “on the fly” using feedback from various systems.

In this illustrative example, speed **1510** may be a rate of movement of end effector **120**. Speed **1510** also may represent the rate of movement of pressure foot **151**. Distance **1512** may be an amount of space between contact surface **1502** of pressure foot **151** and surface **116**.

Based on contact force **153** identified using load cell **1508**, end effector **120** may slow down, speed up, change orientation, or be modified in some other manner. As an example, if contact force **153** is greater than desired contact force **1506**, speed **1510** may be reduced such that contact force **153** from pressure foot **151** reduces the formation of inconsistencies, avoids the formation of inconsistencies, or both, in surface **116** of structure **106**.

Speed **1510** may be altered based on pre-programmed instructions in some illustrative examples. For instance, when contact force **153** is determined, end effector **120** may automatically adjust its speed. In other illustrative examples, speed **1510** is measured dynamically using a measurement device. In still another illustrative example, speed **1510** of end effector **120** is calculated by various applications in communication with controller **128** in **Figure 1**. In this case, speed **1510** may be calculated from position information generated by metrology system **152**, sensor system **138**, or both as shown in **Figure 1**.

As another example, if contact force **153** is less than desired contact force **1506**, end effector **120** may be moved closer to surface **116** to provide desired contact force **1506**. As yet another example, if contact force **153** is substantially equal to desired contact force **1506**, end effector **120** may be stopped and operation **111** may be started on surface **116** of structure **106**. These changes may occur under the direction of controller **128**, system controller **166** in **Figure 1**, or both.

In this illustrative example, sensor system **138** may be used to position pressure foot **151** and end effector **120** relative to location **135** on surface **116** prior to contacting surface **116**. In an illustrative example, sensor system **138** may move along track system **147** in shuttle table **146** to align with channel **1504** in pressure foot **151**. Sensor system **138** may be extended through channel **1504** toward surface **116**.

In this illustrative example, sensor system **138** may have plurality of sensors **1514** and biasing system **1515**. Plurality of sensors **1514** may be devices configured to generate position data **1516** about position **1517** of plurality of sensors **1514** relative to surface **116** of structure **106** at location **135**.

In this depicted example, position **1517** may include an orientation for each of plurality of sensors **1514** relative to surface **116**, a location of each of plurality of sensors **1514** in three-dimensional space, a distance from surface **116** for each of plurality of sensors **1514**, or a combination thereof. In this illustrative example, position data **1516** may be information about position **1517** including, for example, without limitation, coordinates, values, or other types of information used to identify position **1517** with respect to at least one of global coordinate system **101** or airplane coordinate system **103** shown in **Figure 1**.

Sensor **1518** may be one of plurality of sensors **1514** in this illustrative example. Sensor **1518** may take a number of different forms. For example, without limitation, sensor **1518** may be selected from one of a linear variable differential transformer, a capacitive transducer, a laser distance sensor, a contact encoder, a capacitive displacement sensor, an eddy-current sensor, an ultrasonic sensor, a multi-axis displacement transducer, and other suitable types of sensors.

As depicted, plurality of sensors **1514** may extend outward from pressure foot **151**. Specifically, plurality of sensors **1514** may extend outward substantially perpendicular to contact surface **1502** of pressure foot **151**. In this manner, plurality of sensors **1514** may be configured to contact surface **116** of structure **106** at location **135** prior to pressure foot **151** contacting surface **116** of structure **106**.

In this illustrative example, each of plurality of sensors **1514** may have a different position **1517** relative to location **135** on surface **116** of structure **106**. As a result, each of plurality of sensors **1514** may generate different position data **1516**.

For example, without limitation, if plurality of sensors **1514** includes three sensors, position **1517** of each sensor relative to location **135** on surface **116** may be different. For instance, each sensor may have a different orientation relative to location **135** on surface **116**. As another example, each sensor may have a different distance between the sensor and surface **116**. In this manner, different position data **1516** may be generated by each of the three sensors in this illustrative example.

From position data **1516** generated by each of plurality of sensors **1514**, the manner in which end effector **120** approaches location **135** on surface **116** of structure **106** may be adjusted. End effector **120** may be adjusted using movement system **1520**.

As illustrated, movement system **1520** may be associated with end effector **120**. In this illustrative example, movement system **1520** may comprise a number of components configured to move end effector **120**.

Motion platform **122**, as shown in **Figure 1**, may be an example of movement system **1520** in some cases. In other illustrative examples, movement system **1520** may be used in addition to or in place of motion platform **122** to move end effector **120**. Movement system **1520** may include wheels, a track system, pulleys, or other suitable movement devices in this illustrative example.

As depicted, movement system **1520** may be configured to change position **148** of end effector **120**. For instance, movement system **1520** may change orientation **1524** of end effector **120** to desired orientation **1526** prior to contact with surface **116** of structure **106** at location **135**.

In this illustrative example, orientation **1524** may be the direction that end effector **120** currently faces about a number of axes. Desired orientation **1526** may be the direction that end effector **120** faces when contact surface **1502** is substantially parallel to surface **116** of structure **106** at location **135**.

Orientation **1524** and desired orientation **1526** also may represent the direction that contact surface **1502** of pressure foot **151** faces, since pressure foot **151** moves with end effector **120**. Movement system **1520** may change orientation **1524** to desired orientation **1526** based on position data **1516** from each of plurality of sensors **1514**.

As illustrated, movement system **1520** may change speed **1510** of end effector **120** as pressure foot **151** approaches surface **116**. Initially, movement system **1520** may move end effector **120** at first speed **1522** toward surface **116**.

Movement system **1520** may then reduce speed **1510** to second speed **1523** prior to pressure foot **151** contacting surface **116** of structure **106**. Speed **1510** may be reduced to second speed **1523** based on position data **1516** from plurality of sensors **1514**. As an example, if position data **1516** indicates that pressure foot **151** is about to contact surface **116**, movement system **1520** may reduce speed **1510** to second speed **1523** such that pressure foot **151** does not contact surface **116** with an undesired amount of contact force **153**.

Movement system **1520** may increase speed **1510** in some illustrative examples. For example, without limitation, speed **1510** may be increased from second speed **1523** to first speed **1522** to decrease the time needed for end effector **120** to approach location **135** on surface **116**.

In this illustrative example, movement system **1520** may be configured to change position **148** of end effector **120** as end effector **120** moves toward surface **116** of structure **106**. For instance, movement system **1520** may dynamically change orientation **1524** without stopping end effector **120**. In a similar fashion, movement system **1520** may change speed **1510**, distance **1512** traveled by end effector **120**, or both as end effector **120** moves toward location **135** on surface **116** of structure **106**.

As illustrated, biasing system **1515** may be associated with plurality of sensors **1514**. Biasing system **1515** may comprise a number of components configured to bias plurality of sensors **1514** between extended position **1528** and

retracted position **1530** in response to contacting surface **116** of structure **106** at location **135**.

In this illustrative example, extended position **1528** may be a configuration for plurality of sensors **1514** in which plurality of sensors **1514** protrude outwardly from contact surface **1502** of pressure foot **151** in the direction of location **135** on surface **116**. Retracted position **1530** may be a configuration for plurality of sensors **1514** in which plurality of sensors **1514** are positioned within housing **1500** of pressure foot **151**.

In this illustrative example, each of plurality of sensors **1514** may extend and retract individually, or may extend and retract in combination. The extension and retraction may be active or passive, depending on the particular implementation. When active, controller **128** may extend one or more of plurality of sensors **1514** to contact surface **116**.

Biasing system **1515** may take various forms in this illustrative example. For instance, biasing system **1515** may include at least one of a number of springs, coils, mechanical devices, or other suitable structures.

As plurality of sensors **1514** contact surface **116** of structure **106** and end effector **120** continues to move toward surface **116** at location **135**, surface **116** exerts force **1534** on plurality of sensors **1514**. In response, plurality of sensors **1514** are biased from extended position **1528** to retracted position **1530**. In other words, plurality of sensors **1514** may move into housing **1500** in response to force **1534**.

For instance, when biasing system **1515** includes a spring, plurality of sensors **1514** may compress the spring. In this manner, plurality of sensors **1514** are “spring-loaded” such that force **1534** may not damage plurality of sensors **1514**. In addition, plurality of sensors **1514** also may not cause inconsistencies to form on surface **116**. When end effector **120** moves away from location **135** on surface **116**, the spring may force plurality of sensors **1514** outward.

In some instances, plurality of sensors **1514** may include a number of protective elements **1527** positioned on at least one sensor in plurality of sensors

1514. Protective elements **1527** are configured to prevent components in plurality of sensors **1514** from scratching or marring surface **116** at location **135**. For example, without limitation, a pad, a coating, or some other suitable protective element may be positioned on at least one of plurality of sensors **1514**.

After end effector **120** is positioned relative to location **135** on surface **116** in a desired manner, sensor system **138** may be repositioned on shuttle table **146** such that other tools in set of tools **132** may perform additional operations. In this illustrative example, sensor system **138** may be moved along track system **147** in shuttle table **146** out of alignment from channel **1504**.

For example, without limitation, drilling system **140** may then be moved along track system **147** to align with channel **1504** of pressure foot **151**. Drilling system **140** may then be extended to drill hole **134** in surface **116** of structure **106** at location **135**. Subsequently, fastener **104** may be inserted in hole **134**.

In this illustrative example, sensor system **138** may be configured to measure flushness **171** of fastener **104** inserted into hole **134** drilled in location **135** on surface **116** of structure **106** shown in **Figure 1**. After fastener **104** is inserted in hole **134**, sensor system **138** may then be moved to align with channel **1504** of pressure foot **151**. Plurality of sensors **1514** then may be used to measure flushness **171** of fastener **104**. Based on flushness **171**, operation **111** performed by set of tools **132** on end effector **120** may be modified.

For instance, if flushness **171** indicates fastener **104** is recessed from surface **116** of structure **106** more than desired, at least one of drilling system **140** or fastener installer **144** may be reconfigured. In one illustrative example, fastener installer **144** may be reconfigured to use less force when installing fastener **104**. In another example, drilling system **140** may be reconfigured to adjust the countersink, depth, angle, or some other parameter. If flushness **171** indicates that fastener **104** is substantially planar to surface **116** of panel **112** within selected tolerances, end effector **120** with set of tools **132** may duplicate its operations on subsequent fastener installations.

In some illustrative examples, sensor system **138** also may be configured to identify object **174** on surface **116** of structure **106** at location **135**. Sensor system **138** may be configured to generate signal **1538** when object **174** is identified. Signal **1538** may be configured to stop end effector **120** before pressure foot **151** reaches object **174**.

For example, without limitation, when sensor **1518** comes in contact with object **174**, sensor **1518** may send signal **1538** to controller **128** shown in **Figure 1**. From signal **1538**, controller **128** may command movement system **1520** to stop end effector **120** and reposition end effector **120** to avoid object **174**. Signal **1538** may be an electrical signal in this illustrative example.

The illustration of end effector **120**, pressure foot **151**, and sensor system **138** in **Figure 15** is not meant to imply physical or architectural limitations to the manner in which an illustrative embodiment may be implemented. Other components in addition to or in place of the ones illustrated may be used. Some components may be unnecessary. Also, the blocks are presented to illustrate some functional components. One or more of these blocks may be combined, divided, or combined and divided into different blocks when implemented in an illustrative embodiment.

For example, sensor system **138** with plurality of sensors **1514** may be used on other types of structures other than panel **112**. As an example, end effector **120** with sensor system **138** may be oriented toward an upper panel, a panel in a vertical configuration, or an object in another type of configuration. In other words, the movement of plurality of sensors **1514**, end effector **120**, and pressure foot **151** is not limited to an upward movement relative to a lower panel of a structure. Each component works in a similar fashion when approaching structures with varying configurations.

As another illustrative example, movement system **1520** may not move end effector **120** such that plurality of sensors **1514** are substantially perpendicular to surface **116** at location **135**. Instead, in some examples, hole **134** may be drilled along an axis that is not normal to surface **116** at location **135**. In this case, end

effector **120** may be oriented at an angle. Another device, other than pressure foot **151**, may be needed to clamp structure **106** to its substructure. In still another illustrative example, plurality of sensors **1514** may extend outward from contact surface **1502** of pressure foot **151** at a different angle other than about ninety degrees, depending on the particular implementation.

With reference next to **Figure 16**, an illustration of a side view of pressure foot **408** on end effector **302** from **Figure 4** is depicted in accordance with an illustrative embodiment. In this depicted example, an enlarged view of pressure foot **408** is shown in the direction of lines **16-16** in **Figure 4**.

As illustrated, pressure foot **408** may include contact surface **1600** and housing **1602**. A channel (not shown in this view) extends centrally through housing **1602**. Contact surface **1600** and housing **1602** may be examples of physical implementations for contact surface **1502** and housing **1500**, respectively, of pressure foot **151** shown in block form in **Figure 15**.

In this depicted example, sensor system **400** may include plurality of sensors **1604**. Plurality of sensors **1604** may include sensor **1606**, sensor **1607**, and sensor **1608** in this illustrative example. Plurality of sensors **1604** may be an example of a physical implementation for plurality of sensors **1514** shown in block form in **Figure 15**.

In this illustrative example, sensor **1606**, sensor **1607** (partially obscured in this view) and sensor **1608** may be linear variable differential transformers. Linear variable differential transformers may be contact-type sensors in this illustrative example. A “contact-type sensor” may be a sensor that generates position data when in contact with an object. Sensor **1606**, sensor **1607**, and sensor **1608** may individually generate position data for use in adjusting a direction of travel for end effector **302**. Protective elements **1611** may be placed on the protruding ends of sensor **1606**, sensor **1607**, and sensor **1608** to prevent scratching or marring the surface of the structure.

Plurality of sensors **1604** extend outward from pressure foot **408** in this illustrative example. In particular, plurality of sensors **1604** may extend centrally

though the channel in pressure foot **408**. Plurality of sensors **1604** may extend outward substantially perpendicular to contact surface **1600** of pressure foot **408** in this illustrative example.

Plurality of sensors **1604** may be configured to move in the direction of arrow **1612** to extend beyond pressure foot **408**. In a similar fashion, plurality of sensors **1604** may be configured to move in the direction of arrow **1614**. Biasing system **1616** may be configured to bias plurality of sensors **1604** as they move back and forth in the directions of arrow **1612** and arrow **1614**.

In this illustrative example, plurality of sensors **1604** is in extended position **1618**. Extended position **1618** of plurality of sensors **1604** may be an example of an implementation for extended position **1528** of plurality of sensors **1514** in **Figure 15**.

In some cases, sensor **1606**, sensor **1607**, and sensor **1608** may be configured to extend different distances from pressure foot **408**. For instance, at least one of sensor **1606**, sensor **1607**, and sensor **1608** may be configured to extend further than the other.

As depicted, load cell **1610** may be connected to pressure foot **408**. Load cell **1610** may be an example of an implementation for load cell **1508** shown in block form in **Figure 15**.

In this illustrative example, load cell **1610** may be connected to contact surface **1600** of pressure foot **408**. Load cell **1610** may measure a contact force between pressure foot **408** and the surface of the structure.

In **Figure 17**, an illustration of a top view of pressure foot **408** in **Figure 16** is depicted in accordance with an illustrative embodiment. A top view of pressure foot **408** is shown in the direction of lines **17-17** in **Figure 16**. This view is taken normal to axis **1702** shown in this figure.

Channel **1700** in pressure foot **408** may be seen in this view. Channel **1700** may have axis **1702**. Axis **1702** may extend centrally through channel **1700**.

As shown, plurality of sensors **1604** may have configuration **1704**. Configuration **1704** may be an arrangement of plurality of sensors **1604** where each

sensor is positioned substantially equidistant from the other sensors about axis **1702**. In this illustrative example, sensor **1606**, sensor **1607**, and sensor **1608** are positioned substantially equidistant from one another about axis **1702**. Configuration **1704** for plurality of sensors **1604** may generate position data about a desired location for hole **900** in **Figure 9**.

In this illustrative example, operations may be performed by set of tools **308**, shown in **Figures 3-12**, along axis **1702**. For example, without limitation, hole **900** may be drilled along axis **1702**. As another illustrative example, fastener **1100** from **Figure 11** may be installed along axis **1702**. When properly aligned, axis **1702** of channel **1700** may correspond to axis **137** for hole **134** shown in **Figure 1**.

Because plurality of sensors **1604** are positioned about axis **1702** in this manner, position data may be generated for a location for hole **900** with a smaller margin of error than with some currently used systems. In other words, since plurality of sensors **1604** are so closely positioned relative to a desired location for hole **900**, more accurate position data may be generated, due to the possibly compound curvature of the structure surface. As a result, a greater likelihood of accurate performance drilling and fastening operations may be achieved.

Figures 18-21 are illustrations of an enlarged view of end effector **302** with pressure foot **408** as end effector **302** moves relative to location **601** on surface **206** of panel **208** from **Figure 6**. The movement of end effector **302** is adjusted based on position data generated by plurality of sensors **1604** from **Figure 16**. In **Figure 18-21**, end effector **302** is shown in the direction of lines **18-18** in **Figure 16**.

Referring to **Figure 18**, an illustration of end effector **302** moving toward location **601** on surface **206** of panel **208** is depicted in accordance with an illustrative embodiment. In this depicted example, end effector **302** may move toward location **601** on surface **206** of panel **208** in the direction of arrow **1800**.

In this illustrative example, it may be desirable for axis **1702** to be perpendicular to location **601** on surface **206** to perform operations at location **601** in a desired manner. As a result, end effector **302** may need to be repositioned relative to location **601** on surface **206**.

End effector **302** may move in the direction of arrow **1800** until one of plurality of sensors **1604** contacts surface **206** at location **601**. That sensor may then generate position data about its position relative to surface **206** at location **601**. From this position data, controller **320** (not shown in this view) may send signals to reposition end effector **302**. End effector **302** may be repositioned using a movement system (not shown in this view). For instance, end effector **302** may be repositioned using motion platform **304** shown in **Figure 3**.

In some illustrative examples, when plurality of sensors **1604** comprise a non-contact type sensor, each of plurality of sensors **1604** may generate position data continuously as end effector **302** moves toward location **601** on surface **206**. In this illustrative example, a “non-contact type” sensor is a sensor that provides position data without contact with a structure.

In this illustrative example, end effector **302** may move in the direction of arrow **1800** at a first speed. As end effector **302** gets closer to location **601** on surface **206**, the movement system may reduce the speed of end effector **302** to a second speed. The second speed may be a speed at which the risk of undesired encounters between pressure foot **408** and surface **206** at location **601** are reduced.

In this manner, end effector **302** may approach location **601** on surface **206** in at least two stages. In the first stage, end effector **302** moves at a more rapid pace than in the second stage. Because plurality of sensors **1604** extend outward from pressure foot **408** and provide position data, end effector **302** may be adjusted to be normal to location **601** on surface **206** before pressure foot **408** touches surface **206**. This action allows for more rapid approach and dynamic adjustment of end effector **302**, resulting in less time needed to position end effector **302** as desired.

Due to the compound curvature of surface **206**, plurality of sensors **1604** may be positioned relative to one another in an equilateral triangular arrangement at a plane on, and parallel to, contact surface **1600**. Channel **1700** runs through the center of the equilateral triangular arrangement. Axis **1702** is located at the

centroid of the equilateral triangular arrangement. Each of plurality of sensors **1604** is located at a corner in the equilateral triangular arrangement. Other triangular sensor arrangements are also possible in other illustrative examples.

In **Figure 19**, an illustration of sensor **1607** contacting surface **206** of panel **208** at location **601** is depicted in accordance with an illustrative embodiment. In this illustrative example, end effector **302** has moved in the direction of arrow **1800**.

End effector **302** has orientation **1900** relative to location **601** on surface **206** in this illustrative example. Orientation **1900** may be an example of an implementation for orientation **1524** shown in block form in **Figure 15**.

As depicted, sensor **1607** has made contact with surface **206** of panel **208** at location **601**. In response to this contact, sensor **1607** begins to move in the direction of arrow **1614**.

In this depicted example, the movement of sensor **1607** causes sensor **1607** to generate position data. This position data may be used by the movement system to change the position of end effector **302** as shown in **Figure 20**. For example, the movement system may change orientation **1900** of end effector **302** to orientation **2000** as shown in **Figure 20** as end effector **302** moves closer to surface **206**.

Since neither sensor **1606** nor sensor **1608** have contacted surface **206**, sensor **1606** and sensor **1608** may not generate position data in this illustrative example. The movement system may be commanded by controller **320** to reposition end effector **120** until sensor **1606** and sensor **1608** generate position data equivalent to sensor **1607** as pressure foot **408** closes in on location **135** at the second speed.

Turning now to **Figure 20**, an illustration of end effector **302** adjusting a position of end effector **302** is depicted in accordance with an illustrative embodiment. In this illustrative example, axis **1702** is substantially normal to the plane formed by contact point **2001** for sensor **1606**, contact point **2003** for sensor **1607**, and contact point **2005** for sensor **1608** at location **601** on surface **206**.

End effector **302** now has orientation **2000**. In this illustrative example, orientation **2000** may be a desired orientation. In this illustrative example,

orientation **2000** is an orientation for end effector **302** in which contact surface **1600** of pressure foot **408** is substantially normal to surface **206** at location **601**. Orientation **2000** may be an example of an implementation for desired orientation **1526** shown in block form in **Figure 15**.

End effector **302** may move toward surface **206** in the direction of arrow **2002**. Movement in the direction of arrow **2002** may still occur at the first speed.

All of plurality of sensors **1604** may contact surface **206** in this illustrative example at the corresponding contact points. Each sensor in plurality of sensors **1604** may move in the direction of arrow **1614**. As plurality of sensors **1604** move, each sensor generates position data that may be used to make additional adjustments to the orientation of end effector **302**.

Next, in **Figure 21**, an illustration of pressure foot **408** before contacting surface **206** of panel **208** at location **601** is depicted in accordance with an illustrative embodiment. In this depicted example, end effector **302** has moved in the direction of arrow **2002**. Contact surface **1600** of pressure foot **408** is about to touch surface **206** of panel **208** at location **601**.

In this depicted example, the movement system has reduced the speed of end effector **302** in response to signals sent by controller **320**. End effector **302** continues to move in the direction of arrow **2002** until contact surface **1600** contacts surface **206** of panel **208** in a desired manner.

On contact, load cell **1610** measures the contact force between the two objects. If the contact force is substantially equal to a desired contact force for clamping, set of tools **308** may begin to perform operations on surface **206** at location **601**, as shown and described with reference to **Figures 6-12**, above. If not, end effector **302** may be moved further toward location **601** on surface **206** at the second speed until a desired contact force is reached.

In this illustrative example, plurality of sensors **1604** may be in retracted position **2100**. In retracted position **2100**, plurality of sensors **1604** may not extend outward from pressure foot **408**. Retracted position **2100** may be an example of an

implementation for retracted position **1530** for plurality of sensors **1514** shown in block form in **Figure 15**.

With reference now to **Figure 22**, an illustration of sensor system **400** inspecting a flushness of fastener **1100** installed in panel **208** as shown in **Figure 12** is depicted in accordance with an illustrative embodiment. In this depicted example, contact surface **1600** of pressure foot **408** is interfaced with surface **206** at location **601**.

Sensor **1607** may be extended centrally through channel **1700**, shown in **Figures 17-21**, in pressure foot **408** to contact fastener **1100**. Sensor **1608** and sensor **1606** remain retracted in this illustrative example.

Sensor **1607** may then measure fastener **1100**. This measurement may then be compared to the original reading from the three sensors on initial contact with surface **206** at location **601**. The original three contact points **2001**, **2003**, and **2005** allow calculation of a plane in which the current reading is proximally the center of the three sensors. A difference in height between fastener **1100** and surface **206** at location **601** around fastener **1100** may then be determined.

Turning to **Figure 23**, an illustration of end effector **302** approaching an object on surface **206** of panel **208** at location **601** is depicted in accordance with an illustrative embodiment. In this depicted example, object **2300** may be present on surface **206**.

Object **2300** may be debris, a crowned fastener, or some other type of object in this illustrative example. Object **2300** may be an example of a physical implementation for object **174** shown in block form in **Figure 1**.

It may be desirable for pressure foot **408** to avoid an encounter with object **2300**. For example, without limitation, an encounter between pressure foot **408** and object **2300** may result in rework required for pressure foot **408**. In another example, applying undesirable pressure to object **2300** using pressure foot **408** may damage surface **206** in some manner.

In this illustrative example, end effector **302** moves in the direction of arrow **2002** toward surface **206** at location **601**. Plurality of sensors **1604** may be used to

sense the presence of object **2300**, as well as location **2304** of object **2300** on surface **206** at location **601**, before pressure foot **408** comes in contact with object **2300**.

In **Figure 24**, an illustration of sensor **1607** contacting object **2300** on surface **206** of panel **208** at location **601** shown in **Figure 23** is depicted in accordance with an illustrative embodiment. In this depicted example, sensor **1607** has contacted object **2300** and may begin to move in the direction of arrow **1614**. At the same time, sensor **1607** generates position data indicating the presence of object **2300**.

The movement system may be configured to stop movement of end effector **302** such that pressure foot **408** does not touch object **2300**. Object **2300** may be removed from surface **206**, end effector **302** may be repositioned to avoid contact with object **2300**, or both.

Turning to **Figure 25**, an illustration of end effector **302** approaching surface **206** of panel **208** is depicted in accordance with an illustrative embodiment. In this depicted example, portion **2500** of surface **206** may have a different contour than portion **2502** of surface **206**. For instance, portion **2502** and portion **2500** may be a location for a lap joint on surface **206**.

As shown, without plurality of sensors **1604** extending beyond contact surface **1600** of pressure foot **408**, position data would be generated on contact by pressure foot **408**. However, this position data can be inaccurate. Portion **2504** of contact surface **1600** of pressure foot **408** may contact portion **2502** first, instead of providing accurate position data about the normality of pressure foot **408** to portion **2500** of surface **206**.

The use of plurality of sensors **1604** extending beyond contact surface **1600** ensures accurate position data to adjust end effector **302** in a desired manner. Data is generated relative to the precise location for the hole, thus improving accuracy and decreasing the potential for misalignment of end effector **302**.

Referring next to **Figure 26**, an illustration of end effector **302** with pressure foot **408** and sensor system **138** is depicted in accordance with an illustrative

embodiment. In this depicted example, sensor system **138** may include plurality of sensors **2600**.

Plurality of sensors **2600** have replaced plurality of sensors **1604** as shown in **Figure 16**. Plurality of sensors **2600** may be an example of another physical implementation for plurality of sensors **1514** shown in block form in **Figure 15**.

In this illustrative example, plurality of sensors **2600** may be arranged within channel **1700** of pressure foot **408**. For instance, plurality of sensors **2600** may be arranged about axis **1702** within channel **1700**.

As depicted, plurality of sensors **2600** may not extend outward from pressure foot **408**. Instead, plurality of sensors **2600** may be non-contact type sensors.

In this instance, plurality of sensors **2600** may generate position data continuously as end effector **302** approaches surface **206** of panel **208**. In this manner, end effector **302** may be repositioned such that axis **1702** is substantially perpendicular to surface **206** prior to pressure foot **408** contacting surface **206**.

The illustrations of pressure foot **408** and sensor system **138** in **Figures 16-26** are not meant to imply physical or architectural limitations to the manner in which an illustrative embodiment may be implemented. Other components in addition to or in place of the ones illustrated may be used. Some components may be optional.

The different components shown in **Figures 16-26** may be illustrative examples of how components shown in block form in **Figure 15** can be implemented as physical structures. Additionally, some of the components in **Figures 16-26** may be combined with components in **Figure 16**, used with components in **Figure 16**, or a combination of the two.

As an example, although three sensors are shown in plurality of sensors **1604** in **Figures 16-25**, other numbers of sensors may be used. For example, without limitation, two sensors, four sensors, six sensors, ten sensors, or some other suitable number of sensors may be present in plurality of sensors **1604**.

In addition, other configurations for plurality of sensors **1604** may be used other than configuration **1704**. As an example, plurality of sensors **1604** may be

arranged along a diameter of channel **1700**. In another illustrative example, plurality of sensors **1604** may be arranged along a circumference of channel **1700**.

In still other illustrative examples, plurality of sensors **1604** may contact surface **206** at location **601** from above. In this case, end effector **302** may be oriented above panel **208** and move downward toward location **601** on surface **206**. In still other illustrative examples, plurality of sensors **1604** may contact surface **206** from the side, at an angle, or in some other manner, depending on the particular implementation.

Although the illustrative examples are described with respect to panel **208** for an aircraft, an illustrative embodiment may be applied to other types of platforms. The platform may be, for example, without limitation, a mobile platform, a stationary platform, a land-based structure, an aquatic-based structure, and a space-based structure.

More specifically, the platform may be a surface ship, a tank, a personnel carrier, a train, a spacecraft, a space station, a satellite, a submarine, an automobile, a power plant, a bridge, a dam, a house, a manufacturing facility, a building, and other suitable platforms. In addition, plurality of sensors **1604** may be used to generate position data relative to other structures within each of these platforms.

With reference now to **Figure 27**, an illustration of a flowchart of a process for operating assembly system **102** to perform operation **111** on structure **106** from **Figure 1** is depicted in accordance with an illustrative embodiment. In particular, the process illustrated in **Figure 27** may be implemented to install fastener **104** in panel **112**. Control of the different operations may be performed by controller **128** in assembly system **102**.

The process may begin by carrying motion platform **122** across floor **107** of manufacturing environment **100** from first location **117** to second location **121** using mobile platform **118** (operation **2700**). Next, the process may roughly position motion platform **122** below surface **116** of structure **106** (operation **2702**).

Thereafter, the process precisely positions end effector **120** relative to location **135** on surface **116** using motion platform **122** (operation **2704**). End effector **120** may hold set of tools **132** to perform operation **111** on structure **106**. The process then may perform operation **111** on surface **116** at location **135** using set of tools **132** on end effector **120** (operation **2706**), with the process terminating thereafter.

Turning next to **Figure 28**, an illustration of a flowchart of a process for operating assembly system **102** to install fastener **104** in panel **112** of structure **106** from **Figure 1** is depicted in accordance with an illustrative embodiment. The process illustrated in this figure also may be implemented after mobile platform **118** has reached second location **121**.

The process may begin by moving motion platform **122** along vertical axis **136** toward surface **116** using second movement system **124** (operation **2800**). The process may position end effector **120** perpendicular to surface **116** of location **135** using motion platform **122** (operation **2802**). In some illustrative examples, end effector **120** is not positioned perpendicular to location **135**, as described with reference to **Figure 1**, above.

In operation **2802**, sensor system **138** may identify position **148** of end effector **120** and compare that position to desired position **130** for end effector **120**. End effector **120** may then be moved using a combination of components in motion platform **122**.

Next, the process may move end effector **120** along vertical axis **136** to contact surface **116** at location **135** (operation **2804**). The process identifies contact force **153** between pressure foot **151** on end effector **120** and surface **116** (operation **2806**).

In this illustrative example, contact force **153** may be identified using a load cell or other load-sensing device. Contact force **153** may be identified to reduce undesired encounters between end effector **120** and surface **116**, to determine whether desired contact force **153** has been reached, or both.

A determination may be made as to whether desired contact force **153** has been reached (operation **2808**). The desired contact force **153** provides clamping force for panel **112** and its substructure. In some cases, no clamping force is necessary.

Controller **128** may compare contact force **153** identified by the load cell to a pre-determined contact force. If desired contact force **153** has been reached, the process drills hole **134** in surface **116** of panel **112** using drilling system **140** in set of tools **132** (operation **2810**).

Thereafter, the process may inspect at least one of depth **155** or diameter **158** of hole **134** using inspection system **142** in set of tools **132** (operation **2812**). For instance, hole probe **160** may be inserted into hole **134** to inspect hole **134**. In other illustrative examples, inspection system **142** may inspect countersink depth, countersink angle, countersink normality to location **135**, the normality of hole **134** to location **135**, countersink diameter, grip length, or some other parameter for hole **134** as well.

The process then may insert fastener **104** into hole **134** using fastener installer **144** in set of tools **132** (operation **2814**). In operation **2814**, fastener management system **127** may assist fastener installer **144** by applying sealant **164** to fastener **104** and supplying fastener installer **144** with fastener **104** for insertion. The process may inspect fastener **104** (operation **2816**), with the process terminating thereafter.

Returning to operation **2808**, if desired contact force **153** has not been reached between surface **116** and end effector **120**, the process returns to operation **2804** as described above. In this illustrative example, as set of tools **132** perform these operations, set of tools **132** may be moved along track system **147** in shuttle table **146** on end effector **120** to position each tool relative to hole **134**. If additional adjustment is needed, at least one of second movement system **124** and motion platform **122** may be used. Further, tool management system **126** may exchange tools in set of tools **132** as needed.

Referring now to **Figure 29**, an illustration of a flowchart of a process for positioning end effector **120** relative to surface **116** of structure **106** from **Figure 1** is depicted in accordance with an illustrative embodiment. The process illustrated in **Figure 29** may be implemented using sensor system **138** with plurality of sensors **1514** as shown in **Figure 15**. Control of the different operations may be performed by controller **128** in assembly system **102** shown in **Figure 1**.

The process may begin by generating position data **1516** about position **1517** of plurality of sensors **1514** in sensor system **138** relative to surface **116** of structure **106** (operation **2900**). Position data **1516** may be generated before, during, or after at least one of plurality of sensors **1514** has contacted surface **116**.

The process then may change position **148** of end effector **120** relative to surface **116** of structure **106** based on position data **1516** generated by plurality of sensors **1514** (operation **2902**), with the process terminating thereafter. For example, movement system **1520** may change orientation **1524** of end effector **120** to desired orientation **1526** such that pressure foot **151** is substantially parallel to surface **116** of structure **106**.

In **Figure 30**, an illustration of a flowchart of a process for positioning end effector **120** relative to surface **116** of structure **106** to perform operation **111** in **Figure 1** is depicted in accordance with an illustrative embodiment. The process illustrated in **Figure 30** may be implemented using sensor system **138** with plurality of sensors **1514** as shown in **Figure 15**. The different operations may be controlled by controller **128** in assembly system **102** shown in **Figure 1**.

The process may begin by moving end effector **120** toward surface **116** of structure **106** at first speed **1522** (operation **3000**). The process then may contact surface **116** of structure **106** with at least one of plurality of sensors **1514** (operation **3002**).

Next, position data **1516** may be generated about position **148** of plurality of sensors **1514** relative to surface **116** of structure **106** (operation **3004**). Position **148** of end effector **120** may be changed relative to surface **116** of structure **106** based on position data **1516** from plurality of sensors **1514** (operation **3006**).

Position **148** of end effector **120** relative to surface **116** at location **135** may be changed while end effector **120** travels toward surface **116** at first speed **1522**, second speed **1523**, or both.

Thereafter, end effector **120** may be moved toward surface **116** of structure **106** at second speed **1523** that is slower than first speed **1522** to contact surface **116** of structure **106** with pressure foot **151** with desired contact force **1506** (operation **3008**).

The process then performs operation **111** on structure **106** (operation **3010**), with the process terminating thereafter. In particular, fastener **104** may be installed on surface **116** of structure **106** using set of tools **132** on end effector **120**.

With reference next to **Figure 31**, an illustration of a flowchart of a process for applying desired contact force **1506** to structure **106** to clamp structure **106** from **Figure 1** is depicted in accordance with an illustrative embodiment. The process illustrated in **Figure 31** may be implemented using load cell **1508** shown in **Figure 15**. Controller **128** in assembly system **102** shown in **Figure 1** may control the different operations.

The process may begin by moving end effector **120** toward surface **116** of structure **106** (operation **3100**). Next, the process may contact surface **116** of structure **106** with contact surface **1600** of pressure foot **151** on end effector **120** (operation **3102**).

Thereafter, the process may identify contact force **153** between contact surface **1600** of pressure foot **151** and surface **116** of structure **106** using load cell **1508** (operation **3104**). The process then may determine whether contact force **153** substantially corresponds to desired contact force **1506** within selected tolerances (operation **3106**).

If contact force **153** corresponds to desired contact force **1506**, the process terminates. Otherwise, the process modifies at least one of speed **1510** of end effector **120** or distance **1512** traveled by end effector **120** based on contact force **153** identified by load cell **1508** (operation **3108**), with the process returning to operation **3104** as described above.

In **Figure 32**, an illustration of a flowchart of a process for detecting object **174** on surface **116** of structure **106** using sensor system **138** in **Figure 1** is depicted in accordance with an illustrative embodiment. The process illustrated in **Figure 32** may be implemented using sensor system **138** with plurality of sensors **1514** as shown in **Figure 15**. The different operations may be controlled using controller **128** in assembly system **102** shown in **Figure 1**.

The process may begin by identifying whether object **174** is present on surface **116** of structure **106** using plurality of sensors **1514** (operation **3200**). Next, a determination may be made as to whether an encounter with object **174** is desired (operation **3202**).

If an encounter with object **174** is undesired, signal **1538** may be generated to stop end effector **120** before pressure foot **151** reaches object **174** (operation **3204**), with the process terminating thereafter. For example, signal **1538** may be generated to stop end effector **120** before reaching debris on surface **116**.

If an encounter with object **174** is desired, end effector **120** may continue to move toward object **174** on surface **116** (operation **3206**). The process may generate position data **1516** about position **1517** of plurality of sensors **1514** relative to object **174** (operation **3208**) with the process terminating thereafter.

For instance, object **174** may be fastener **104** installed in structure **106**. Plurality of sensors **1514** may generate position data **1516** to determine flushness **171** for fastener **104** relative to surface **116** of structure **106** in this illustrative example.

The flowcharts and block diagrams in the different depicted embodiments illustrate the architecture, functionality, and operation of some possible implementations of apparatuses and methods in an illustrative embodiment. In this regard, each block in the flowcharts or block diagrams may represent at least one of module, a segment, a function, or a portion a combination thereof of an operation or step.

In some alternative implementations of an illustrative embodiment, the function or functions noted in the blocks may occur out of the order noted in the

figures. For example, in some cases, two blocks shown in succession may be executed substantially concurrently, or the blocks may sometimes be performed in the reverse order, depending upon the functionality involved. Also, other blocks may be added in addition to the illustrated blocks in a flowchart or block diagram.

Illustrative embodiments of the disclosure may be described in the context of aircraft manufacturing and service method **3300** as shown in **Figure 33** and aircraft **3400** as shown in **Figure 34**. Turning first to **Figure 33**, an illustration of a block diagram of an aircraft manufacturing and service method is depicted in accordance with an illustrative embodiment. During pre-production, aircraft manufacturing and service method **3300** may include specification and design **3302** of aircraft **3400** in **Figure 34** and material procurement **3304**.

During production, component and subassembly manufacturing **3306** and system integration **3308** of aircraft **3400** in **Figure 34** takes place. Thereafter, aircraft **3400** in **Figure 34** may go through certification and delivery **3310** in order to be placed in service **3312**. While in service **3312** by a customer, aircraft **3400** in **Figure 34** is scheduled for routine maintenance and service **3314**, which may include modification, reconfiguration, refurbishment, and other maintenance or service.

Each of the processes of aircraft manufacturing and service method **3300** may be performed or carried out by a system integrator, a third party, an operator, or a combination thereof. In these examples, the operator may be a customer. For the purposes of this description, a system integrator may include, without limitation, any number of aircraft manufacturers and major-system subcontractors; a third party may include, without limitation, any number of vendors, subcontractors, and suppliers; and an operator may be an airline, a leasing company, a military entity, a service organization, and so on.

With reference now to **Figure 34**, an illustration of a block diagram of an aircraft is depicted in which an illustrative embodiment may be implemented. In this example, aircraft **3400** is produced by aircraft manufacturing and service method **3300** in **Figure 33** and may include airframe **3402** with plurality of systems **3404**

and interior **3406**. Examples of systems **3404** include one or more of propulsion system **3408**, electrical system **3410**, hydraulic system **3412**, and environmental system **3414**. Any number of other systems may be included. Although an aerospace example is shown, different illustrative embodiments may be applied to other industries, such as the automotive industry.

Apparatuses and methods embodied herein may be employed during at least one of the stages of aircraft manufacturing and service method **3300** in **Figure 33**. In particular, assembly system **102** from **Figure 1** may be used during various stages of aircraft manufacturing and service method **3300**. For example, without limitation, assembly system **102** may be used to perform operation **111** in a lower panel of aircraft **3400** during component and subassembly manufacturing **3306**. Specifically, during component and subassembly manufacturing **3306**, sensor system **138** may be used to position pressure foot **151** relative to a surface of aircraft **3400** such that operation **111** may be performed in a desired manner.

In another illustrative example, assembly system **102** may be used to perform inspection operations on aircraft **3400** during routine maintenance and service **3314** or some other stage of aircraft manufacturing and service method **3300**. In this case, sensor system **138** may position pressure foot **151** relative to a surface of aircraft **3400** prior to performing inspection operations.

In one illustrative example, components or subassemblies produced in component and subassembly manufacturing **3206** in **Figure 32** may be fabricated or manufactured in a manner similar to components or subassemblies produced while aircraft **3400** is in service **3212** in **Figure 32**. As yet another example, one or more apparatus embodiments, method embodiments, or a combination thereof may be utilized during production stages, such as component and subassembly manufacturing **3206** and system integration **3208** in **Figure 32**. One or more apparatus embodiments, method embodiments, or a combination thereof may be utilized while aircraft **3400** is in service **3212**, during maintenance and service **3214** in **Figure 32**, or a combination thereof. The use of a number of

the different illustrative embodiments may substantially expedite the assembly, reduce the cost of aircraft **3400**, or both.

Thus, the illustrative embodiments may provide a method and apparatus for performing operation **111** on structure **106**. In particular, operation **111** may include installing fastener **104**. Structure **106** may take the form of panel **112** of wing **114** for aircraft **110** in this illustrative example. Assembly system **102** may comprise mobile platform **118**, first movement system **119** associated with mobile platform **118**, end effector **120**, and motion platform **122**. First movement system **119** may be configured to move mobile platform **118** to desired position **130** relative to panel **112** for structure **106**. End effector **120** may be configured to hold set of tools **132** and install fastener **104** in panel **112** using set of tools **132**. Motion platform **122** may be configured to position set of tools **132** on end effector **120** relative to surface **116** of panel **112** to install fastener **104**.

The illustrative embodiments also provide a method and apparatus for positioning end effector **120** relative to structure **106**. An apparatus may comprise end effector **120**, pressure foot **151** connected to end effector **120**, and sensor system **138**. End effector **120** may be configured to perform an operation on structure **106**. Pressure foot **151** may be configured to contact surface **116** of structure **106** at location **135**. Sensor system **138** may have a plurality of sensors extending outward from pressure foot **151**. The plurality of sensors may be configured to generate position data about a position of the plurality of sensors relative to location **135** on surface **116** of structure **106**.

With the use of assembly system **102**, operations may be performed on panel **112** without the need for manual drilling by human operators. The illustrative embodiments provide an autonomous, self-powered system that is capable of navigating under panel **112** without human intervention. In this manner, performing operations on panel **112** may be done more efficiently and in less time than with some currently used systems. As a result, the time, cost, or both time and cost needed to manufacture aircraft **110** may be reduced.

The illustrative embodiments also provide an assembly system with alignment and positioning accuracy. Once under panel **112**, end effector **120** with set of tools **132** may move with seven degrees of freedom to move set of tools **132** to desired position **130** perpendicular to surface **116**. Sensor system **138** may continuously monitor the position of end effector **120**. As a result, normality to surface **116** may be achieved, increasing the consistency and alignment of holes drilled in surface **116**.

In addition, sensor system **138**, inspection system **142**, or both may be used to evaluate performance of assembly system **102**. For example, without limitation, sensor system **138** may measure the flushness of a fastener installed in panel **112**. Subsequent installations may be modified based on this information to more accurately install fasteners. As another example, inspection system **142** may be used to ensure consistency between holes drilled in panel **112**. As a result, less rework may be needed, which further reduces manufacturing time for wing **114**.

Illustrative embodiments also allow operations to be performed on panel **112** without the need for fixed monument structures in manufacturing environment **100**. Instead, assembly system **102** moves about manufacturing environment **100** using retractable wheels **131**. In this manner, manufacturing environment **100** may be reconfigured as needed. Moreover, fewer steps may be needed to set up manufacturing environment **100**. Concrete work and monument builds may be reduced or eliminated when no fixed monument structures are used. Accordingly, cost savings may be realized.

Further, plurality of sensors **1514** may be used to change position **148** of end effector **120** prior to pressure foot **151** contacting surface **116** of structure **106** such that pressure foot **151** contacts surface **116** with desired contact force **1506** to clamp structure **106** with its substructure, to reduce the risk of inconsistencies forming in structure **106**, to reduce the risk of damage to pressure foot **151**, or a combination thereof. In this manner, less rework may be needed on surface **116**. Moreover, the life of pressure foot **151** and other components in end effector **120** may be increased. As a result, the production rate of structure **106** may be

increased while decreasing the cost of maintenance of the equipment used to manufacture structure **106**.

With the use of an illustrative embodiment, speed **1510** at which end effector **120** approaches surface **116** may be increased. Because plurality of sensors **1514** contact surface **116** prior to pressure foot **151**, plurality of sensors **1514** allow end effector **120** to change position and continue to move at an increased speed **1510** toward surface **116**. Instead of moving slowly through its entire approach to avoid undesired encounters between pressure foot **151** and surface **116**, end effector **120** may move rapidly and decelerate right before contact surface **1600** of pressure foot **151** touches surface **116** of structure **106**. This increase in speed **1510** may lead to faster cycle times when performing operations using set of tools **132** on end effector **120**. As a result, the production rate for structure **106** may be increased.

The illustrative embodiments also provide more accurate position data **1516** as end effector **120** moves toward surface **116**. Plurality of sensors **1514** may be used to identify a presence of object **174** protruding from surface **116** of structure **106** and avoid undesired encounters with object **174**, inaccurate position data **1516**, or both.

In addition, plurality of sensors **1514** may be positioned about a desired location **135** for hole **134** such that more accurate position data **1516** is generated with respect to location **135**. With more accurate position data **1516**, the consistency and repeatability in performing operations using set of tools **132** may be increased. As a result, less rework may be performed and the cost of manufacturing structure **106** may be reduced.

The description of the different illustrative embodiments has been presented for purposes of illustration and description, and is not intended to be exhaustive or limited to the embodiments in the form disclosed. Many modifications and variations will be apparent to those of ordinary skill in the art. Further, different illustrative embodiments may provide different features as compared to other desirable embodiments. The embodiment or embodiments selected are chosen and described in order to best explain the principles of the embodiments, the

practical application, and to enable others of ordinary skill in the art to understand the disclosure for various embodiments with various modifications as are suited to the particular use contemplated.

EMBODIMENTS IN WHICH AN EXCLUSIVE PROPERTY OR PRIVILEGE IS CLAIMED ARE DEFINED AS FOLLOWS:

1. An apparatus comprising:
 - an end effector configured to perform an operation on a structure having a surface; and
 - a sensor system having a plurality of sensors on the end effector, each sensor of said plurality of sensors being extendable and retractable to selectively position a respective contact point of said each sensor relative to the surface independently of a position of the end effector relative to the surface.
2. The apparatus of claim 1 further comprising:
 - a pressure foot connected to the end effector and configured to contact the surface of the structure.
3. The apparatus of claim 2, wherein the plurality of sensors is located centrally in the pressure foot and extendable outward substantially perpendicular to a contact surface of the pressure foot.
4. The apparatus of any one of claims 2 to 3, wherein the plurality of sensors has an equilateral triangular arrangement.
5. The apparatus of claim 4, wherein each of the plurality of sensors is located at a corner in the equilateral triangular arrangement.

6. The apparatus of any one of claims **2** to **5**, wherein the plurality of sensors is configured to contact the surface of the structure prior to the pressure foot contacting the surface of the structure.
7. The apparatus of any one of claims **2** to **6**, wherein the plurality of sensors extends outward from a channel located centrally in the pressure foot.
8. The apparatus of any one of claims **2** to **7**, wherein the sensor system is configured to identify whether an object is present on the surface of the structure and generate a signal configured to stop the end effector before the pressure foot reaches the object.
9. The apparatus of any one of claims **2** to **8** further comprising:
 - a load cell associated with the pressure foot and configured to identify a contact force between the pressure foot and the surface of the structure.
10. The apparatus of claim **9**, wherein at least one of a speed of the end effector or a distance traveled by the end effector is modified as the end effector moves toward the surface of the structure based on the contact force identified by the load cell.
11. The apparatus of any one of claims **1** to **10**, wherein the plurality of sensors is configured to generate position data about a position of the plurality of sensors relative to the surface of the structure.
12. The apparatus of any one of claims **1** to **11** further comprising:

a movement system configured to change a position of the end effector relative to the surface of the structure based on position data from the plurality of sensors.

- 13.** The apparatus of claim **12**, wherein the movement system is configured to dynamically change the position of the end effector as the end effector moves closer to the surface of the structure.
- 14.** The apparatus of claim **12** or **13**, wherein the movement system is configured to change an orientation of the end effector to a desired orientation prior to contact with the surface of the structure based on the position data from the plurality of sensors.
- 15.** The apparatus of claim **14**, wherein the orientation of the end effector is changed as the end effector moves toward the surface of the structure.
- 16.** The apparatus of claim **14** or **15**, wherein a contact surface of the pressure foot is substantially parallel to the surface of the structure when the end effector is in the desired orientation.
- 17.** The apparatus of any one of claims **12** to **16**, wherein the movement system moves the end effector at a first speed and reduces the first speed to a second speed prior to the pressure foot contacting the surface of the structure based on the position data from the plurality of sensors.
- 18.** The apparatus of claim **17**, wherein a speed of the end effector is dynamically changed from the first speed to the second speed as the end effector moves toward the surface of the structure.

- 19.** The apparatus of any one of claims **1** to **18** further comprising:
- a biasing system associated with the plurality of sensors and configured to move the plurality of sensors between an extended position and a retracted position in response to the plurality of sensors contacting the surface of the structure.
- 20.** The apparatus of any one of claims **1** to **19**, wherein the sensor system is configured to measure a flushness of a fastener inserted into a hole drilled in a surface of the structure.
- 21.** The apparatus of any one of claims **1** to **20**, wherein the end effector is configured to hold a set of tools comprising at least one of a drilling system, an inspection system, a fastener installer, a sealant applicator, a sprayer, or a cleaning system.
- 22.** The apparatus of any one of claims **1** to **21** further comprising:
- a number of protective elements positioned on at least one sensor in the plurality of sensors and configured to substantially prevent the at least one sensor from scratching the surface of the structure.
- 23.** The apparatus of any one of claims **1** to **22**, wherein the structure is selected from one of a wing, a fuselage, an aileron, a flap, a slat, a spoiler, a stabilizer, a door, a housing, and a nacelle.
- 24.** The apparatus of any one of claims **1** to **23**, wherein a sensor in the plurality of sensors is selected from one of a linear variable differential transformer, a capacitive transducer, a contact encoder, a capacitive displacement sensor,

an eddy-current sensor, an ultrasonic sensor, an ultrasonic sensor, a laser, and a multi-axis displacement transducer.

- 25.** A method for positioning an end effector relative to a structure, the method comprising:

generating position data about a position of a plurality of sensors in a sensor system relative to a surface of the structure, wherein each sensor of the plurality of sensors is extendable and retractable to selectively position a respective contact point of said each sensor relative to the surface independently of a position of the end effector relative to the surface; and

changing a position of the end effector relative to the surface of the structure based on the position data generated by the plurality of sensors.

- 26.** The method of claim **25** further comprising:

changing the position of the end effector as the end effector moves toward the surface of the structure.

- 27.** The method of claim **25** or **26**, wherein the plurality of sensors extends outward from a pressure foot associated with the end effector.

- 28.** The method of claim **27** further comprising:

contacting the surface of the structure with the plurality of sensors;
and

moving the plurality of sensors between an extended position and a retracted position through a channel of the pressure foot as the end effector moves toward the surface of the structure.

29. The method of claim **28** further comprising:

biasing the plurality of sensors outward from the pressure foot from the channel located centrally in the pressure foot.

30. The method of any one of claims **27** to **29** further comprising:

contacting the surface of the structure using the pressure foot with a desired contact force; and

performing an operation on the surface of the structure using a set of tools associated with the end effector.

31. The method of any one of claims **27** to **30**, wherein the plurality of sensors is located centrally in the pressure foot and extends outward substantially perpendicular to a contact surface of the pressure foot.

32. The method of any one of claims **27** to **31**, wherein the plurality of sensors has an equilateral triangular arrangement.

33. The method of claim **32**, wherein each of the plurality of sensors is located at a corner in the equilateral triangular arrangement.

34. The method of any one of claims **27** to **33** further comprising:

changing an orientation of the end effector to a desired orientation prior to contact with the surface of the structure based on the position data from the plurality of sensors, wherein the contact surface of the pressure foot is substantially normal to the surface of the structure when the end effector is in the desired orientation.

35. The method of claim **34** further comprising:

changing the orientation of the end effector as the end effector moves toward the surface of the structure.

36. The method of any one of claims **27** to **35** further comprising:

identifying a contact force between the pressure foot and the surface of the structure using a load cell associated with the pressure foot;
and

modifying at least one of a speed of the end effector or a distance traveled by the end effector based on the contact force identified.

37. The method of claim **36** further comprising:

modifying at least one of the speed of the end effector or the distance traveled by the end effector as the end effector moves toward the surface of the structure.

38. The method of any one of claims **27** to **37** further comprising:

identifying whether an object is present on the surface of the structure using a sensor in the plurality of sensors, wherein the object protrudes from the surface of the structure; and

generating a signal configured to stop the end effector before the pressure foot reaches the object.

39. The method of any one of claims **25** to **38** further comprising:

positioning the plurality of sensors relative to a desired location for a hole to be drilled on the surface of the structure.

40. The method of any one of claims **25** to **39** further comprising:

inspecting a flushness of a fastener inserted into a hole drilled in the surface of the structure using the sensor system.

41. The method of claim **40** further comprising:

modifying an operation of the end effector based on the flushness of the fastener.

42. The method of any one of claims **25** to **41**, wherein the plurality of sensors is configured to generate the position data about the position of the plurality of sensors relative to the surface of the structure.

43. The method of any one of claims **25** to **42** further comprising:

moving the end effector at a first speed using a movement system;
and

contacting the surface with at least one sensor in the plurality of
sensors as the end effector moves at the first speed.

44. The method of claim **43** further comprising:

reducing the first speed to a second speed prior to the pressure foot
contacting the surface of the structure based on the position data from
the plurality of sensors.

45. The method of claim **44** further comprising:

reducing the first speed to the second speed as the end effector
moves toward the surface of the structure.

46. The method of any one of claims **25** to **45** further comprising:

moving a set of tools relative to the surface of the structure using a
track system on a shuttle table associated with the end effector to
perform the operation.

47. An assembly system comprising:

a mobile platform configured to move to a desired position relative to a
location on a surface of a structure;

an end effector associated with the mobile platform and configured to perform an operation on the surface of the structure at the location;

a pressure foot connected to the end effector and configured to contact the surface of the structure at the location; and

a sensor system having a plurality of sensors on the pressure foot, wherein the plurality of sensors are configured to generate position data about a position of the plurality of sensors relative to the location on the surface of the structure and wherein each sensor of said plurality of sensors is extendable and retractable to selectively position a respective contact point of said each sensor relative to the surface independently of a position of the pressure foot relative to the surface.

48. The assembly system of claim **47** further comprising:

a motion platform configured to change an orientation of the end effector to a desired orientation prior to contact with the surface of the structure at the location based on the position data generated from the plurality of sensors.

49. The assembly system of claim **48**, wherein the motion platform is configured to change at least one of a position, the orientation, a speed, or a distance traveled by the end effector as the end effector moves toward the location on the surface of the structure.

50. The assembly system of claim **48** or **49**, wherein the motion platform moves the end effector at a first speed and reduces the first speed to a second

speed prior to the pressure foot contacting the location on the surface of the structure based on the position data generated from the plurality of sensors.

51. The assembly system of any one of claims **47** to **50**, wherein the plurality of sensors is configured to contact the surface of the structure at the location prior to the pressure foot contacting the surface of the structure at the location.

52. The assembly system of any one of claims **47** to **51** further comprising:

a biasing system associated with the plurality of sensors and configured to move the plurality of sensors between an extended position and a retracted position in response to the plurality of sensors contacting the surface of the structure at the location.

53. The assembly system of any one of claims **47** to **52** further comprising:

a load cell associated with the pressure foot and configured to identify a contact force between the pressure foot and the surface of the structure, wherein at least one of a speed of the end effector or a distance traveled by the end effector is modified based on an amount of the contact force identified by the load cell.

54. A method for drilling a hole for installing a fastener, the method comprising:

moving an end effector toward a surface of a structure at a first speed, wherein the end effector is associated with a sensor system having a plurality of sensors on the end effector and wherein each sensor of said plurality of sensors is extendable and retractable to selectively

position a respective contact point of said each sensor relative to the surface independently of a position of the end effector relative to the surface;

contacting the surface of the structure with at least one of the plurality of sensors;

generating position data about a position of the plurality of sensors relative to the surface of the structure;

changing a position of the end effector relative to the surface of the structure based on the position data from the plurality of sensors;

moving the end effector toward the surface of the structure at a second speed that is slower than the first speed to contact the surface of the structure with the end effector with a desired contact force; and

drilling a hole into the surface of the structure using the end effector.

- 55.** The method of claim **54** further comprising: changing the position of the end effector as the end effector moves toward the surface of the structure.
- 56.** The method of claim **54** or claim **55**, wherein the end effector is associated with a pressure foot and the pressure foot contacts the surface of the structure to provide the desired contact force.
- 57.** The method of claim **56** further comprising:

identifying whether an object is present on the surface of the structure using a sensor in the plurality of sensors, wherein the object protrudes from the surface of the structure; and

generating a signal configured to stop the end effector before the pressure foot reaches the object.

58. The method of claim **57** further comprising:

moving the plurality of sensors between an extended position and a retracted position within a housing of the pressure foot as the end effector moves toward the surface of the structure.

59. The method of any one of claims **54** to **58**, wherein the end effector is configured to hold a set of tools and further comprising:

moving the set of tools relative to the surface of the structure using a track system on a shuttle table associated with the end effector to install the fastener.

60. The method of any one of claims **54** to **59** further comprising:

installing the fastener by performing at least one of a drilling operation, a fastening operation, an inspection operation, a measurement operation, a cleaning operation, a sealing operation, or a data collection operation using the set of tools.

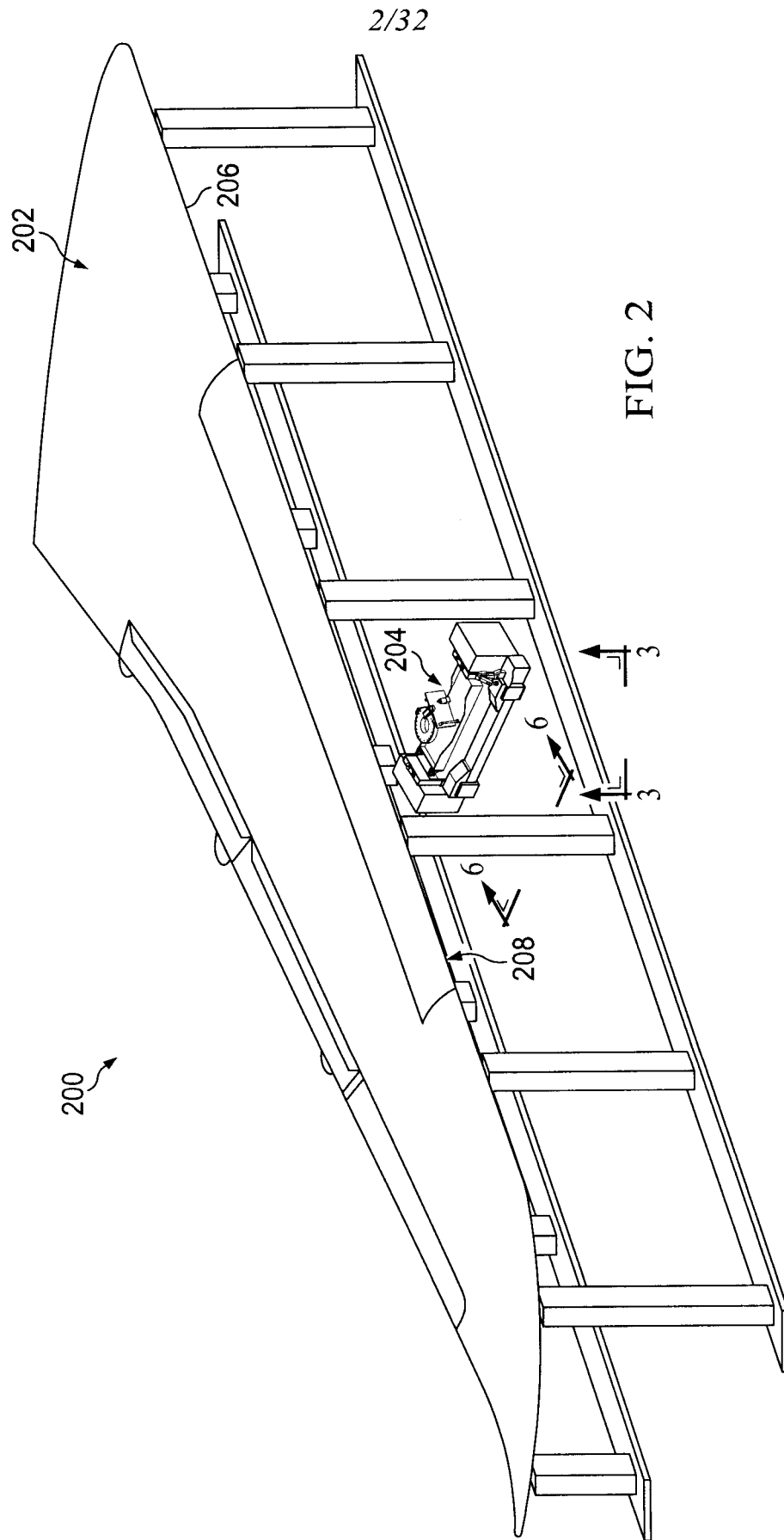
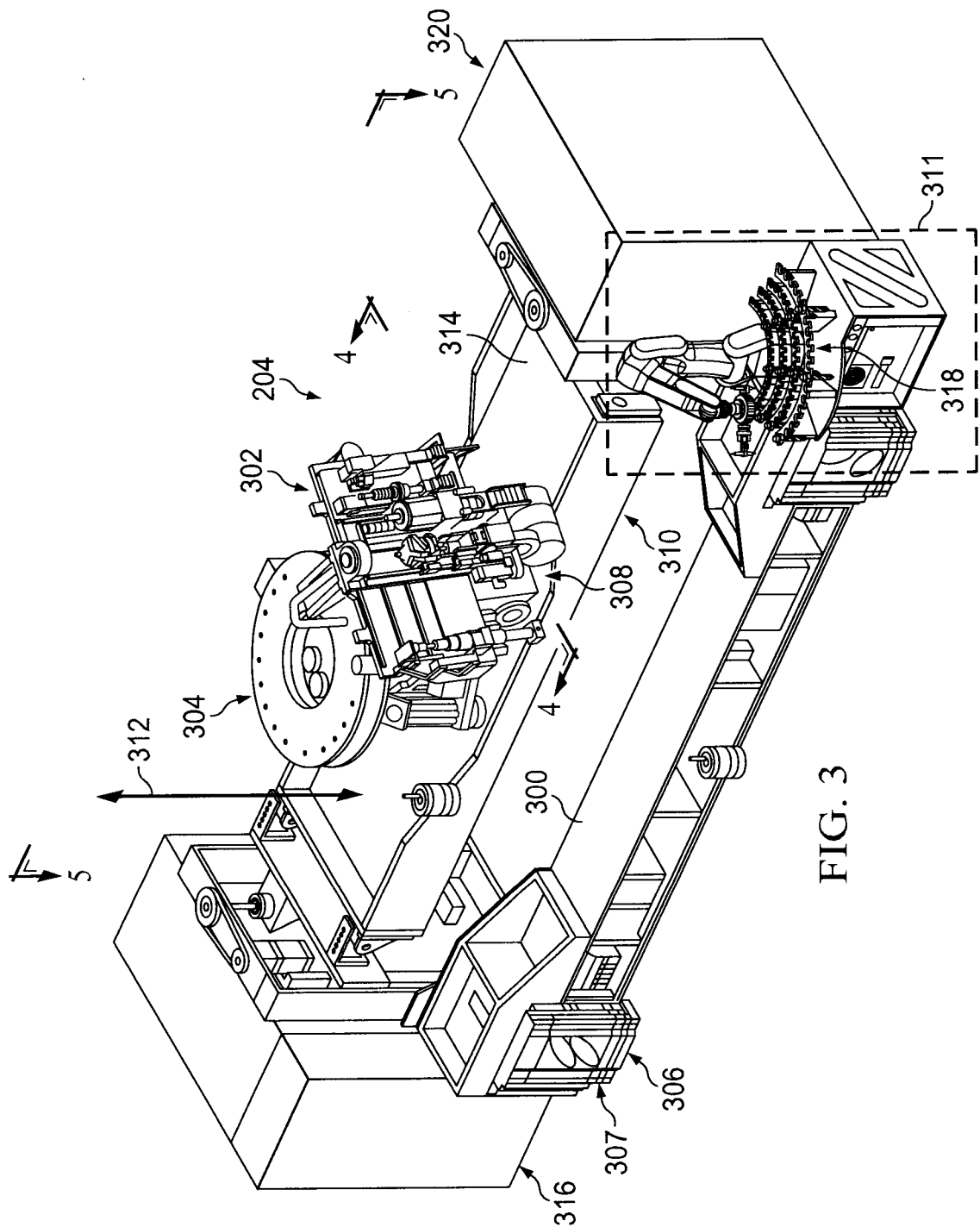


FIG. 2

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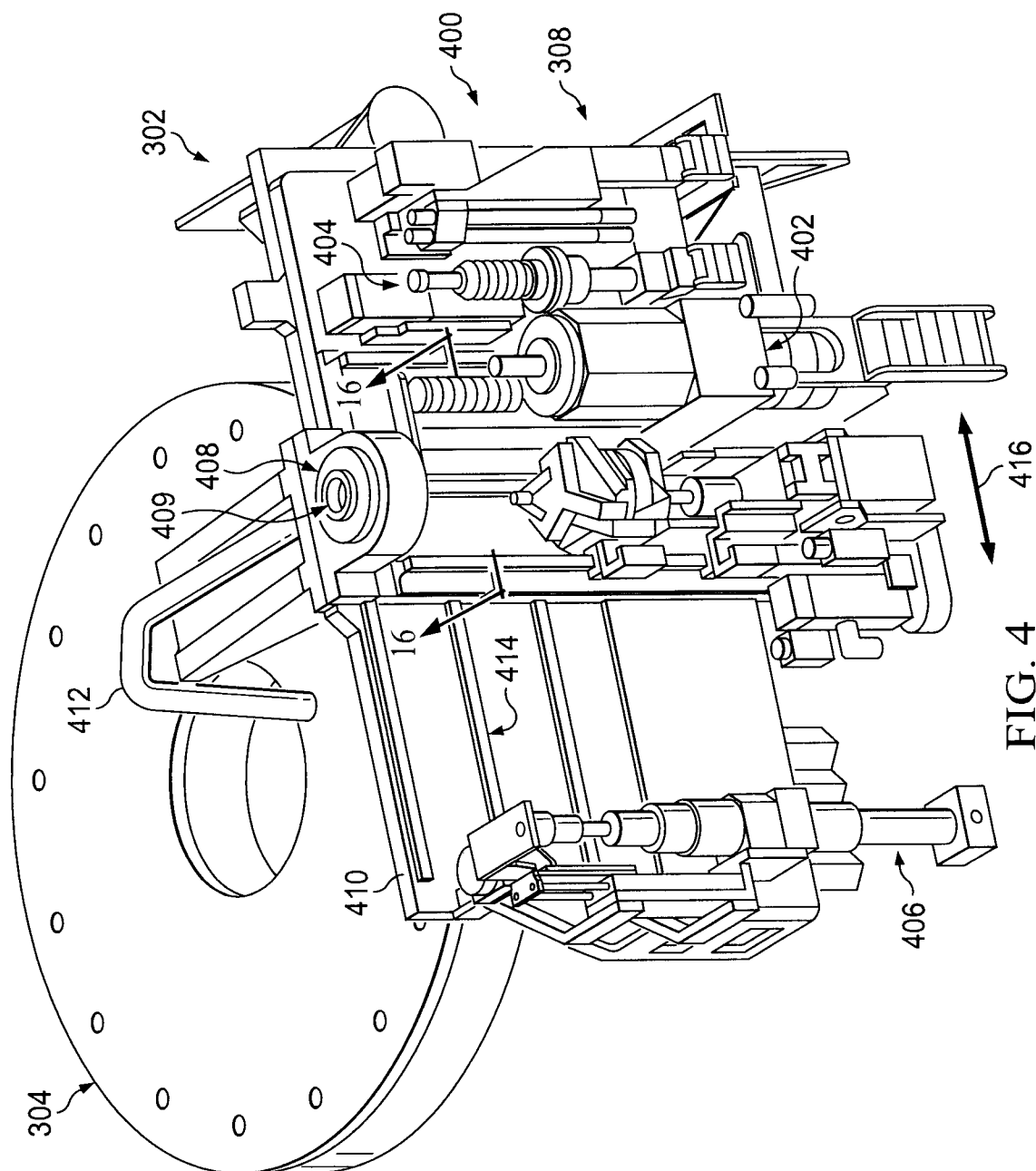
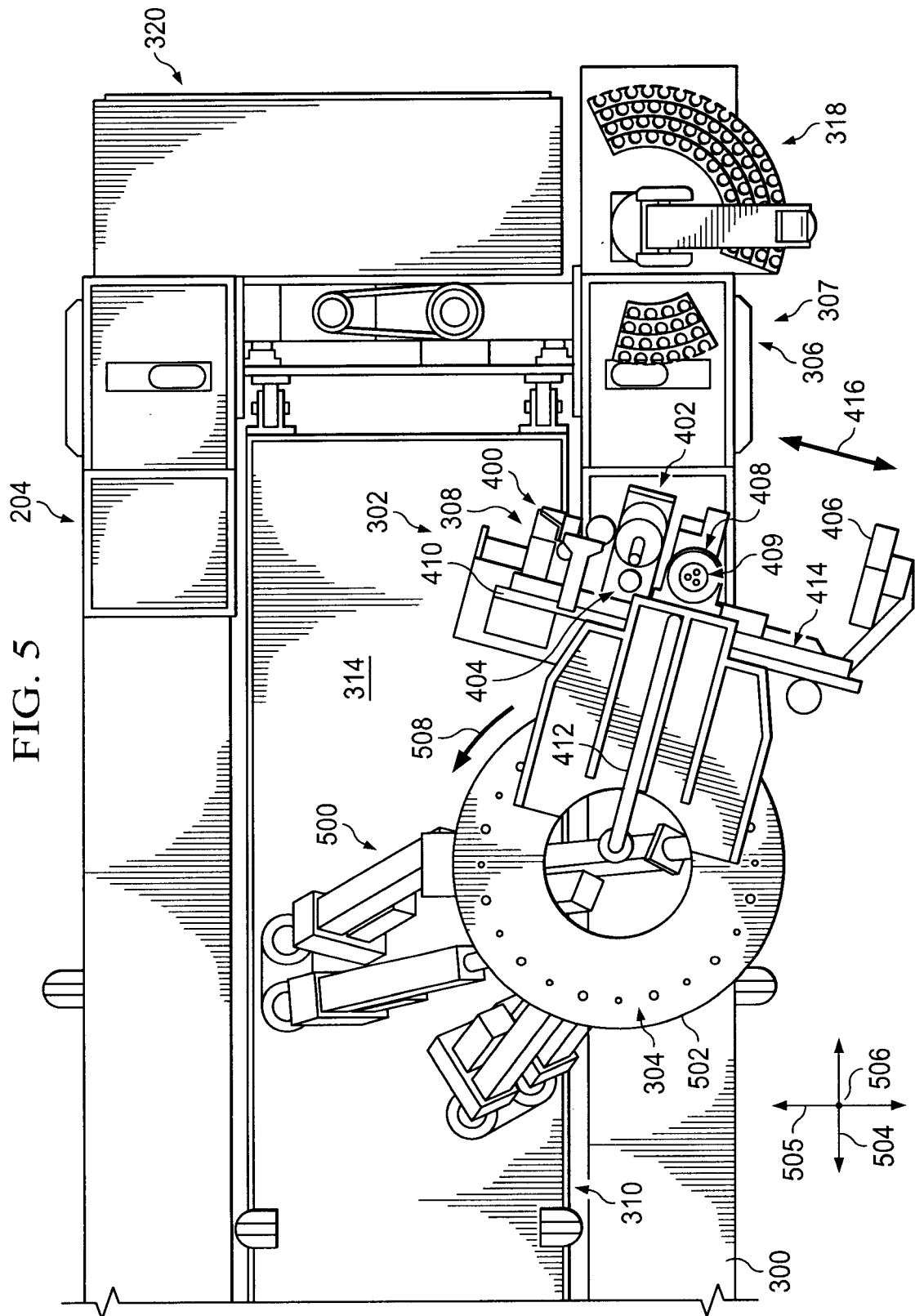


FIG. 4



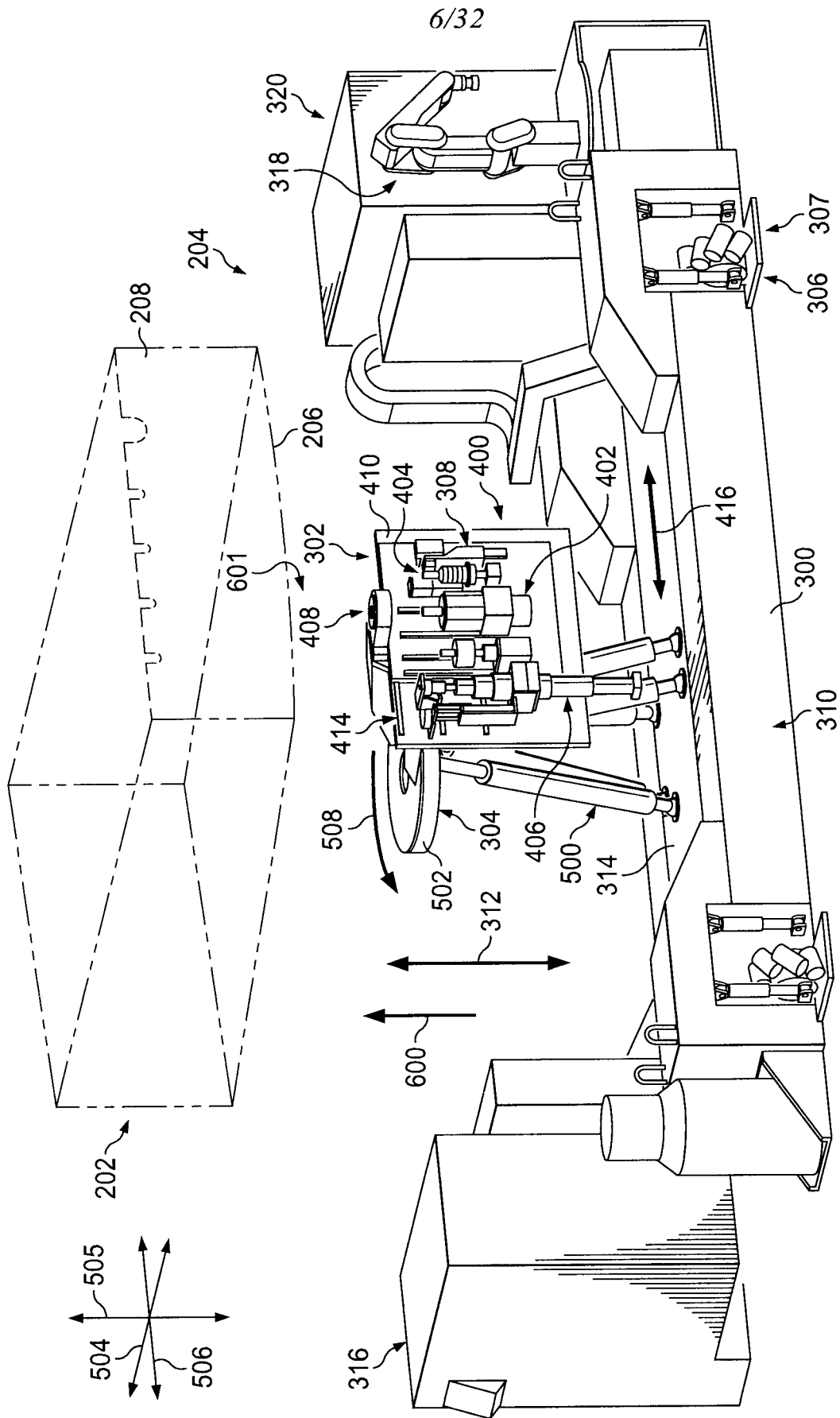


FIG. 6

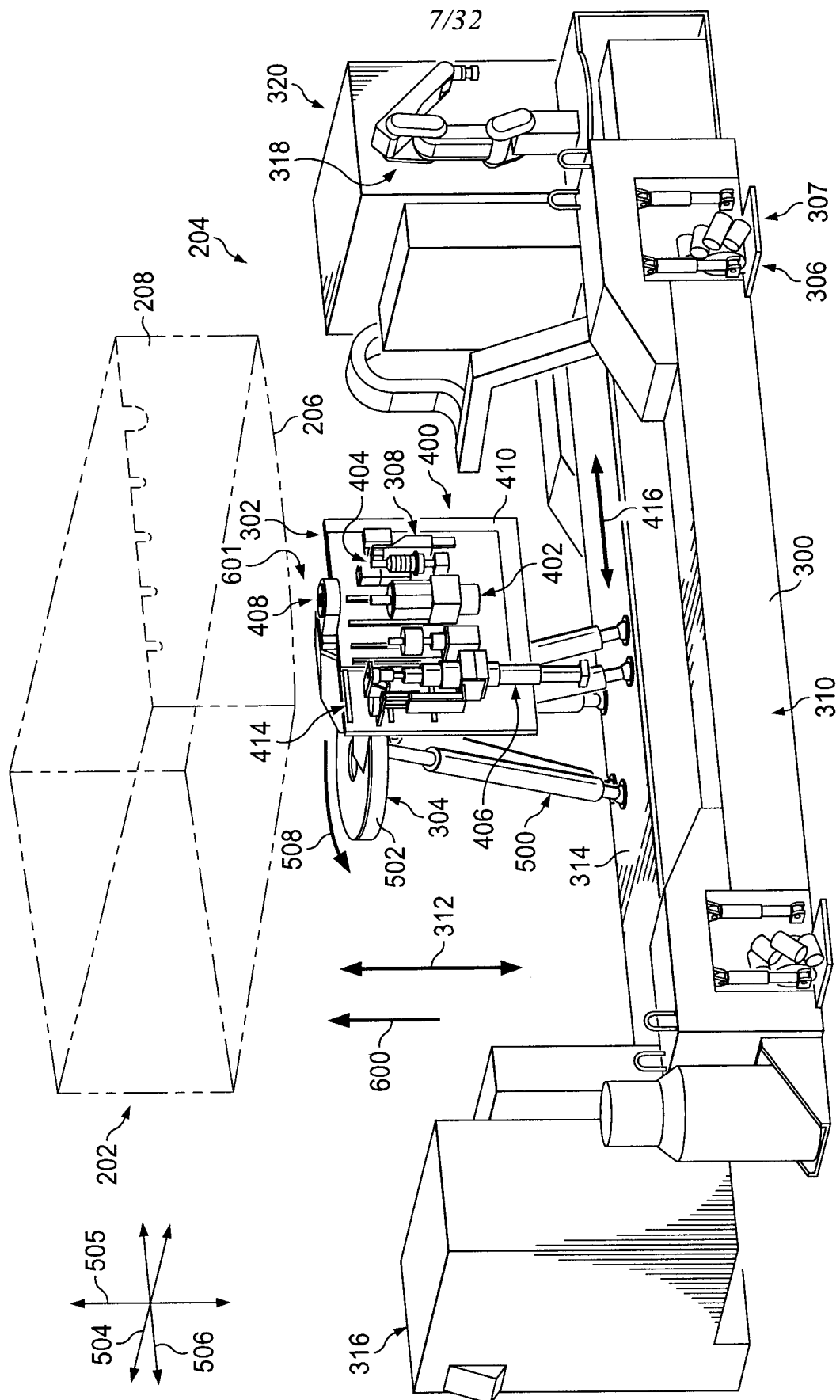


FIG. 7

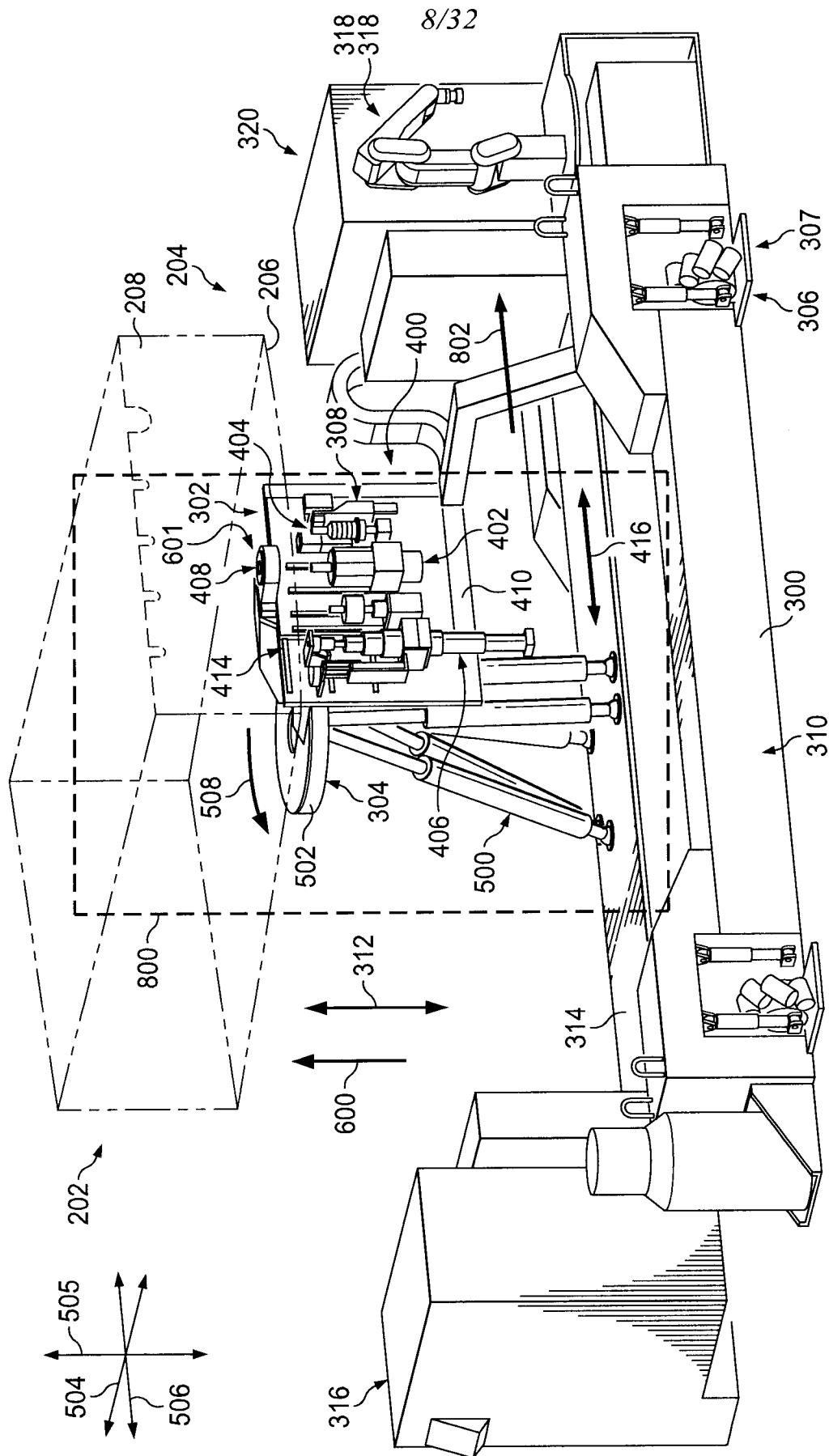
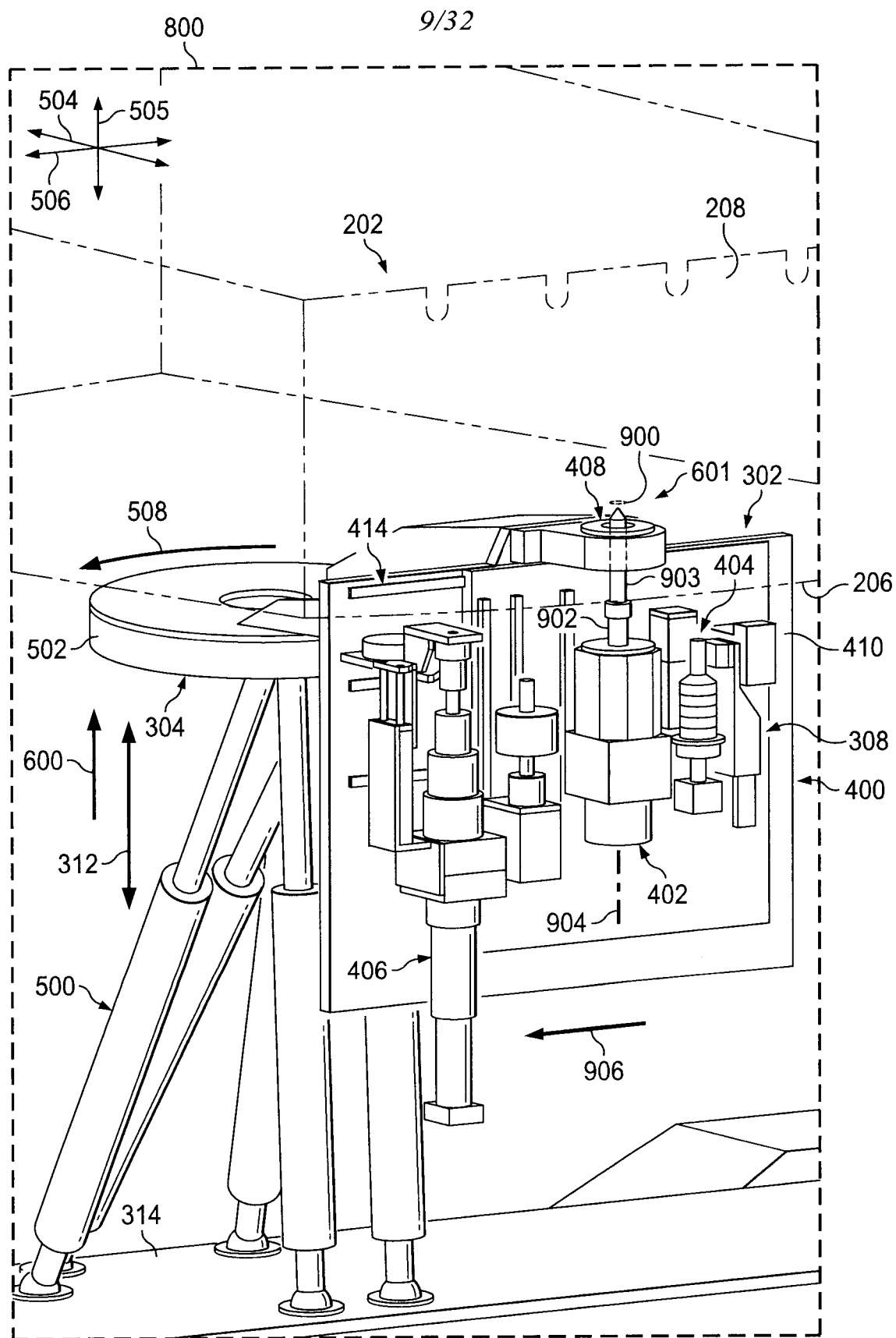


FIG. 8





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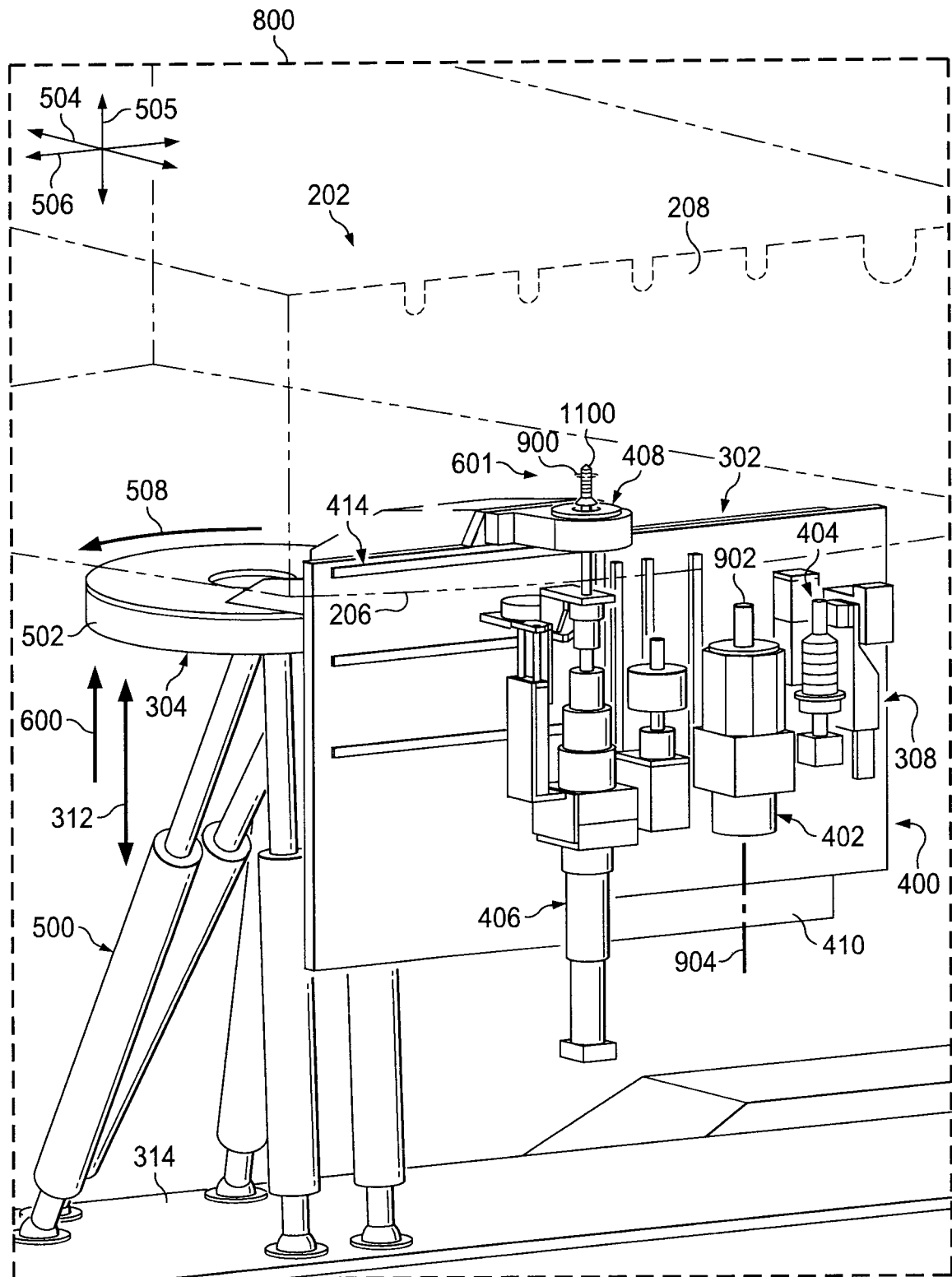
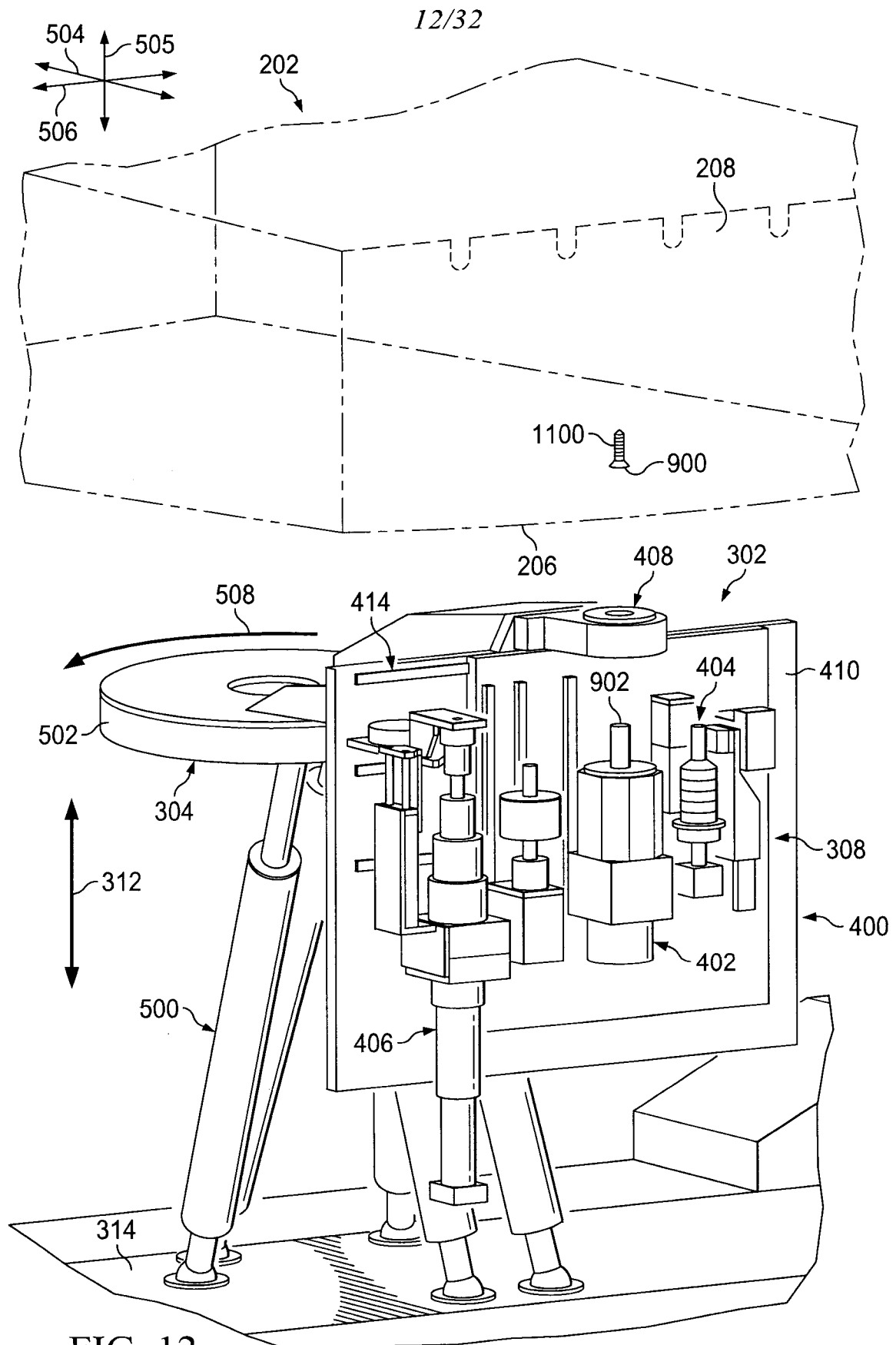


FIG. 11



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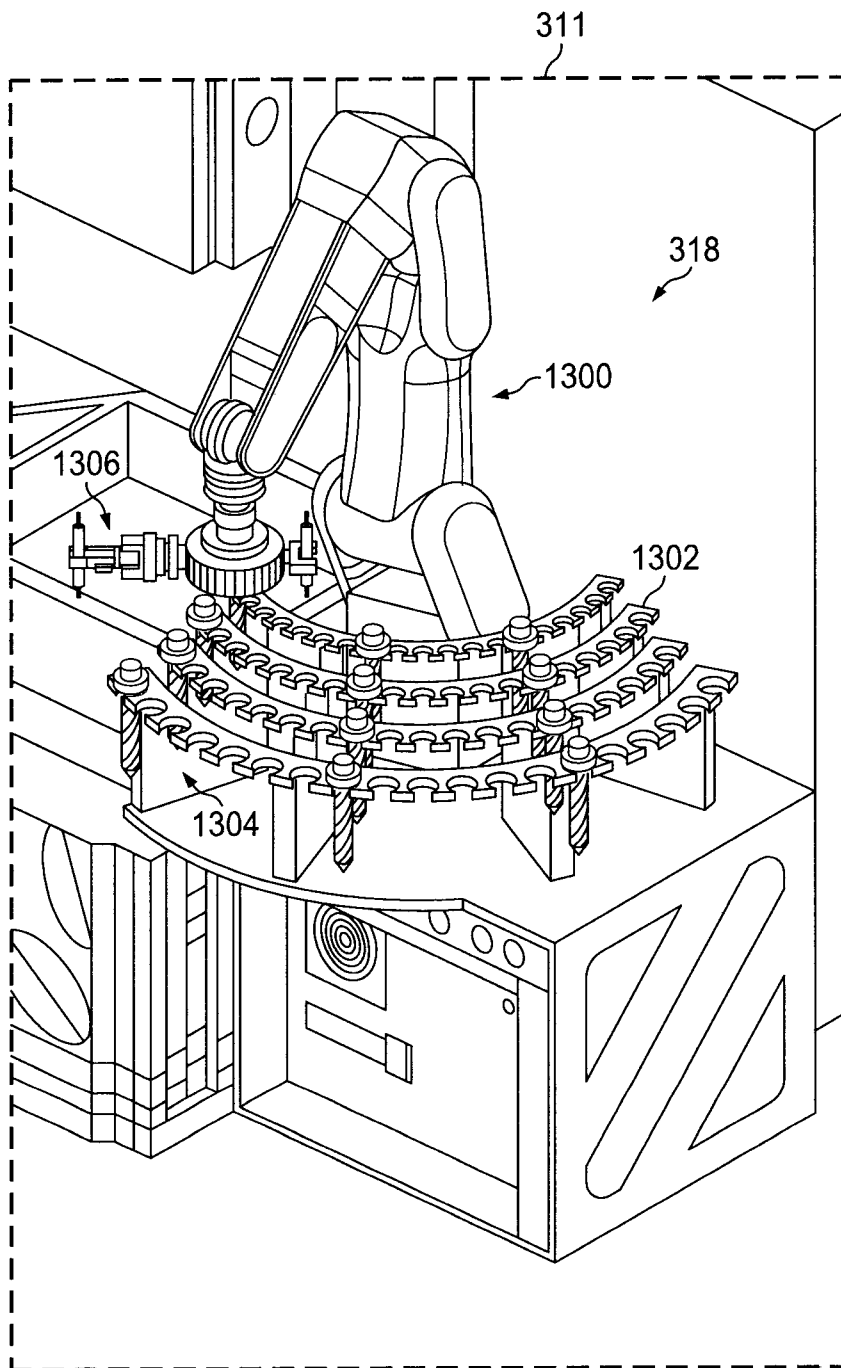
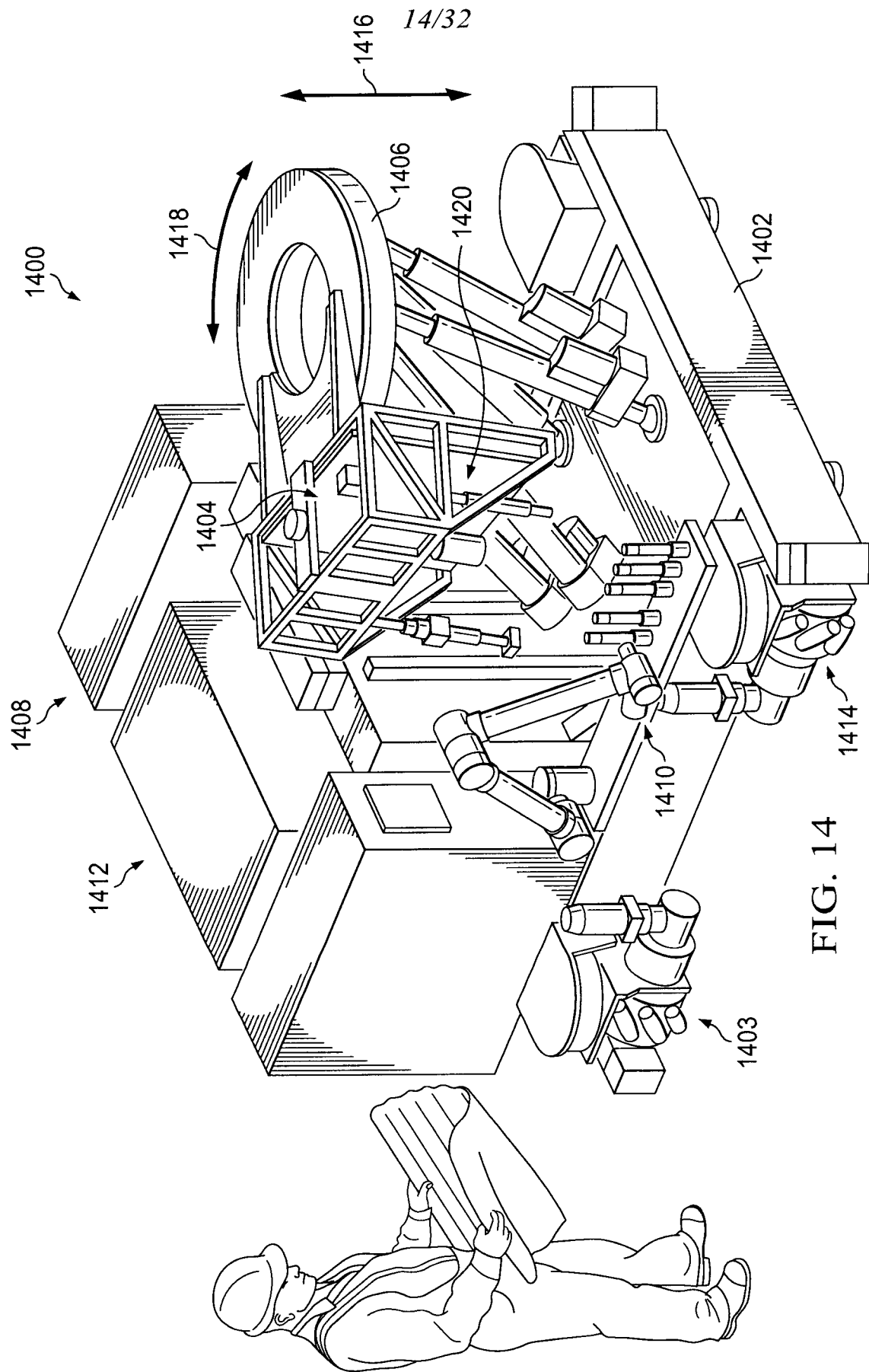
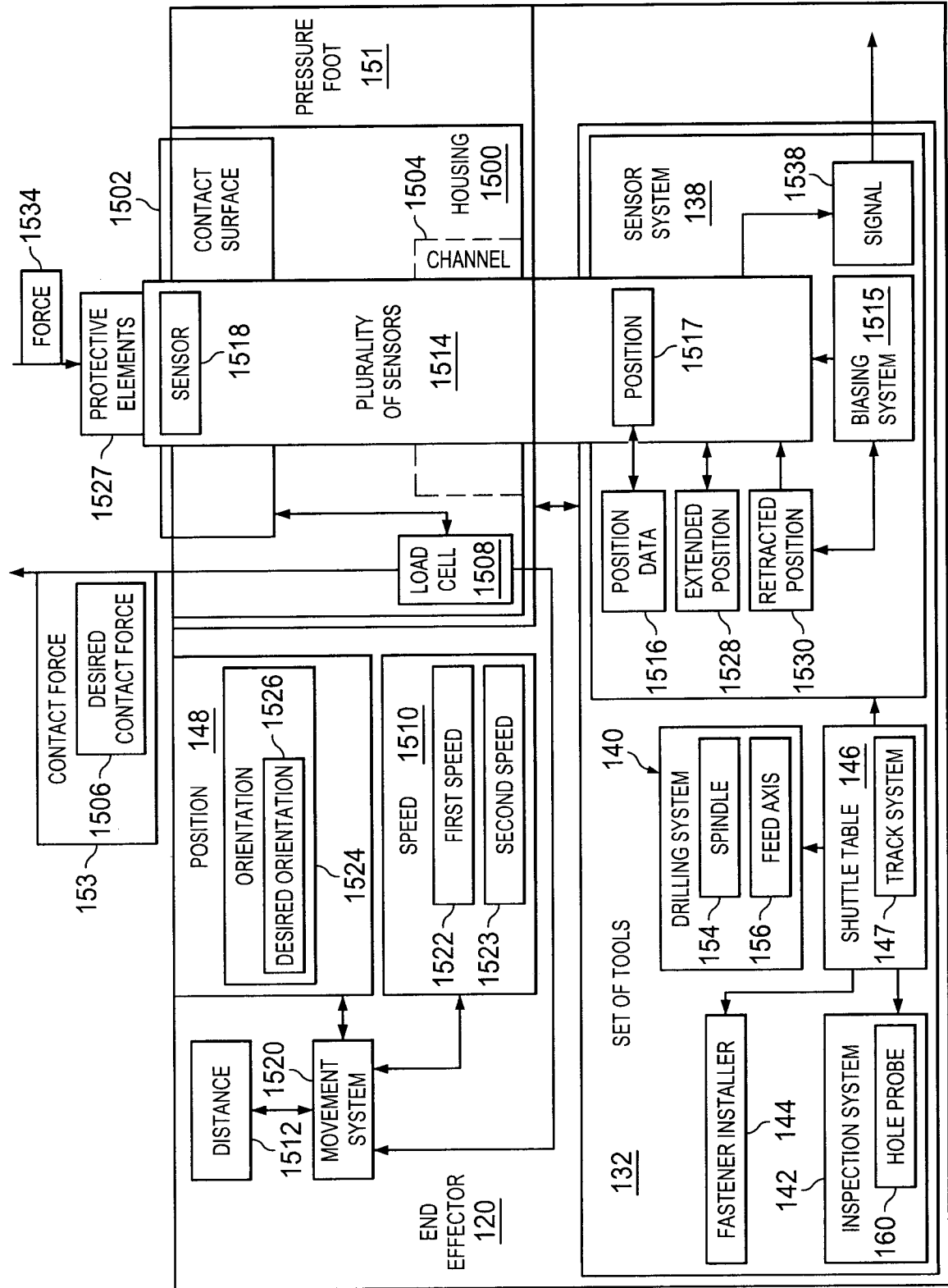


FIG. 13





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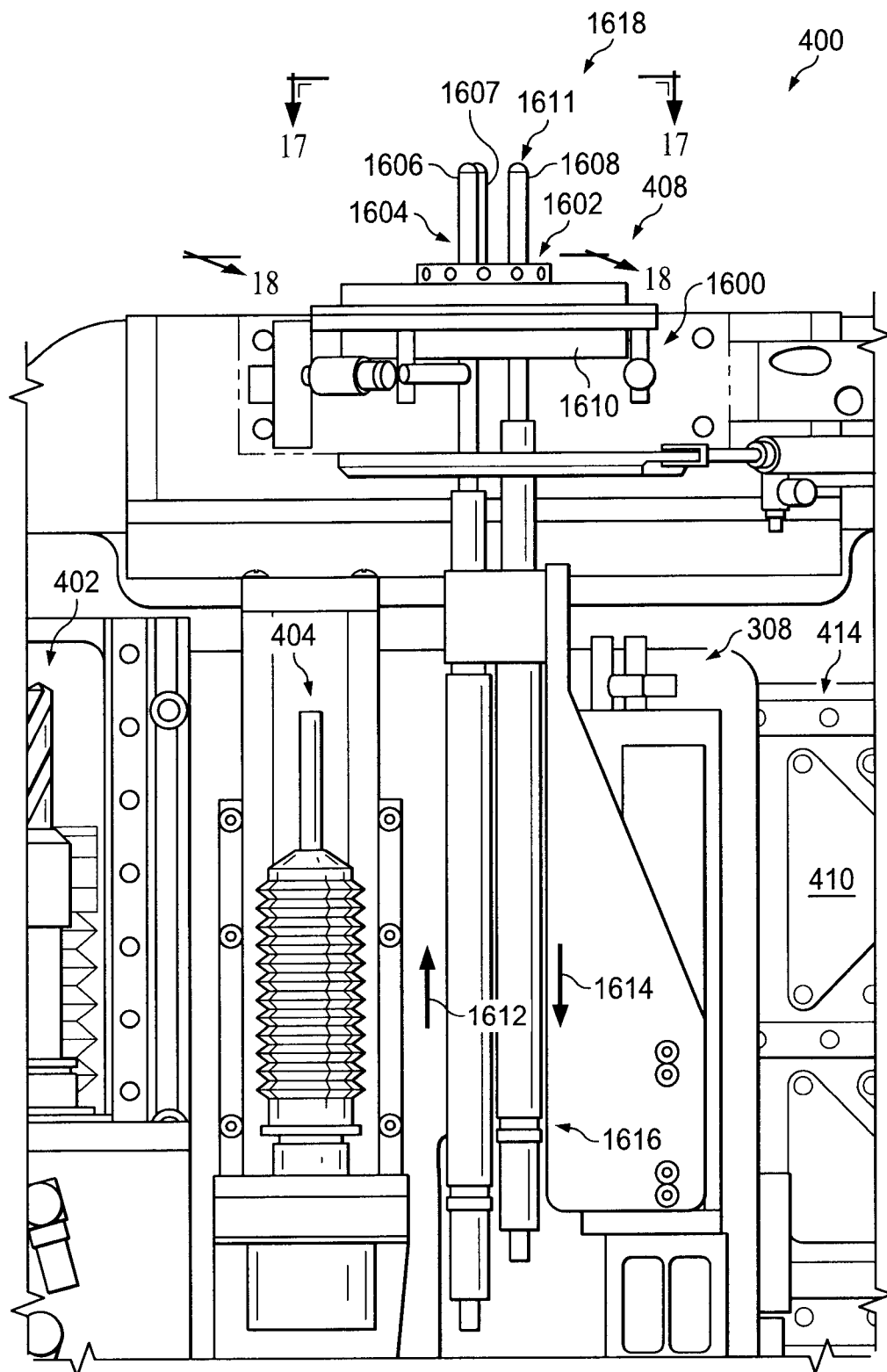


FIG. 16

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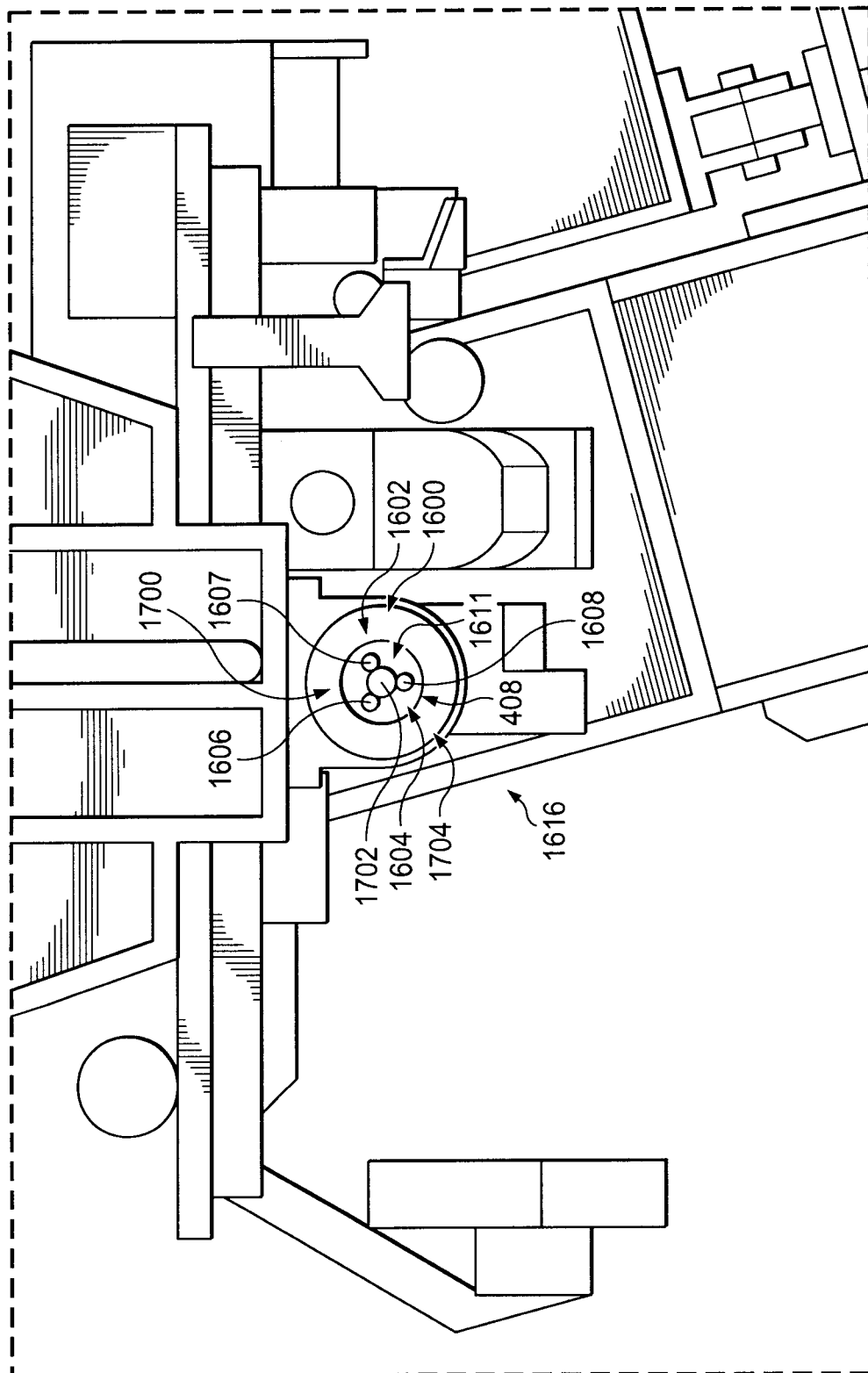


FIG. 17

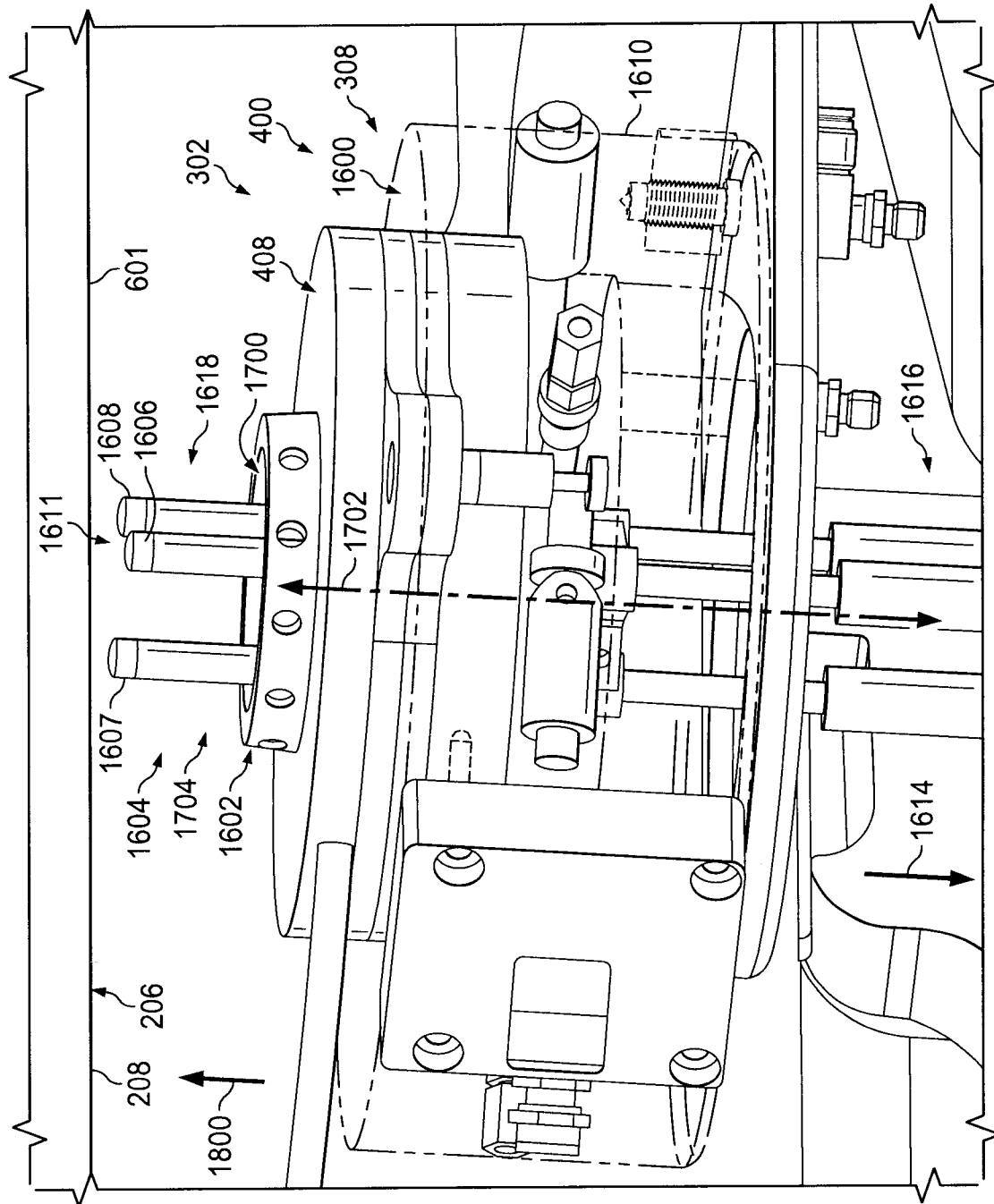


FIG. 18

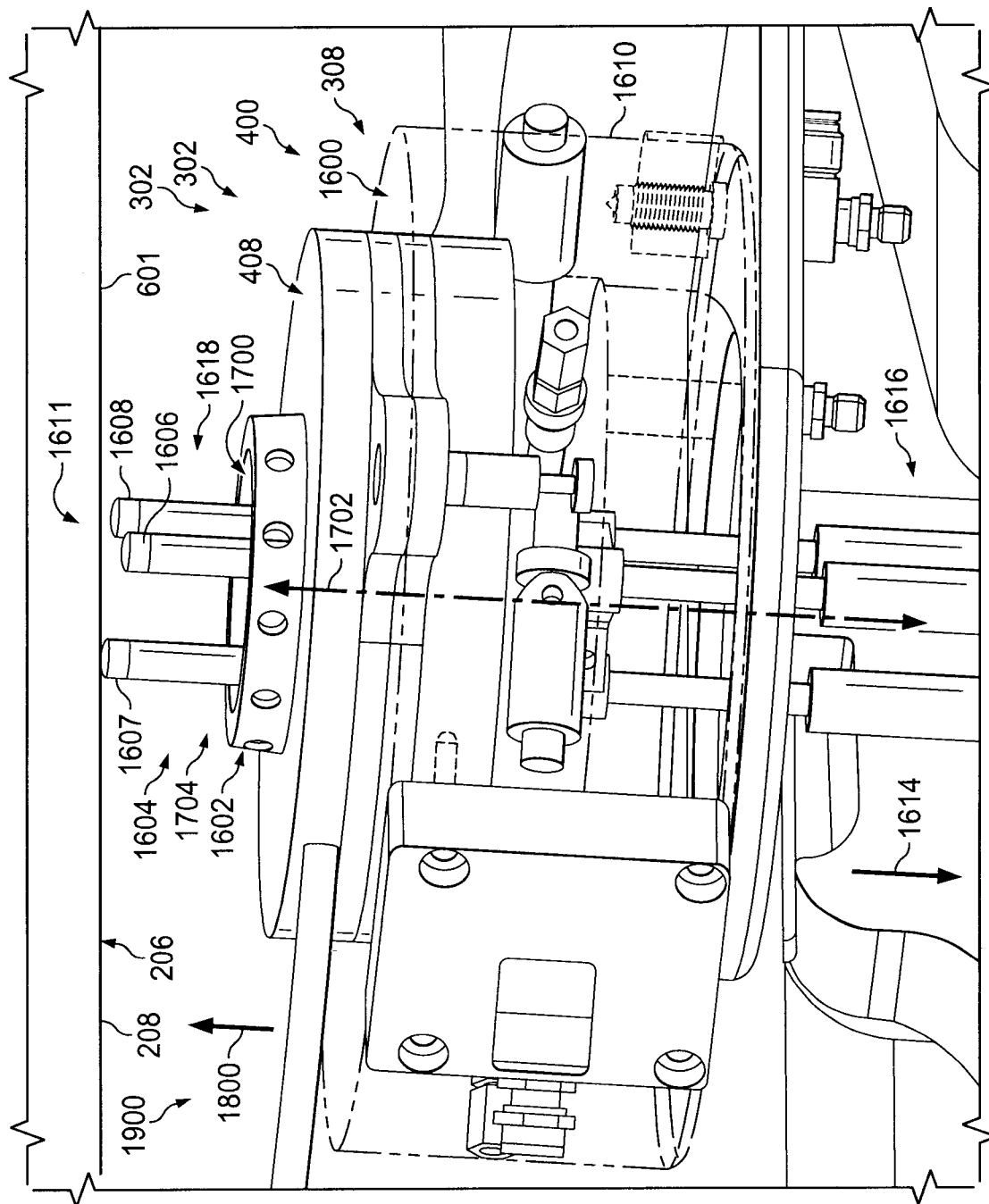


FIG. 19

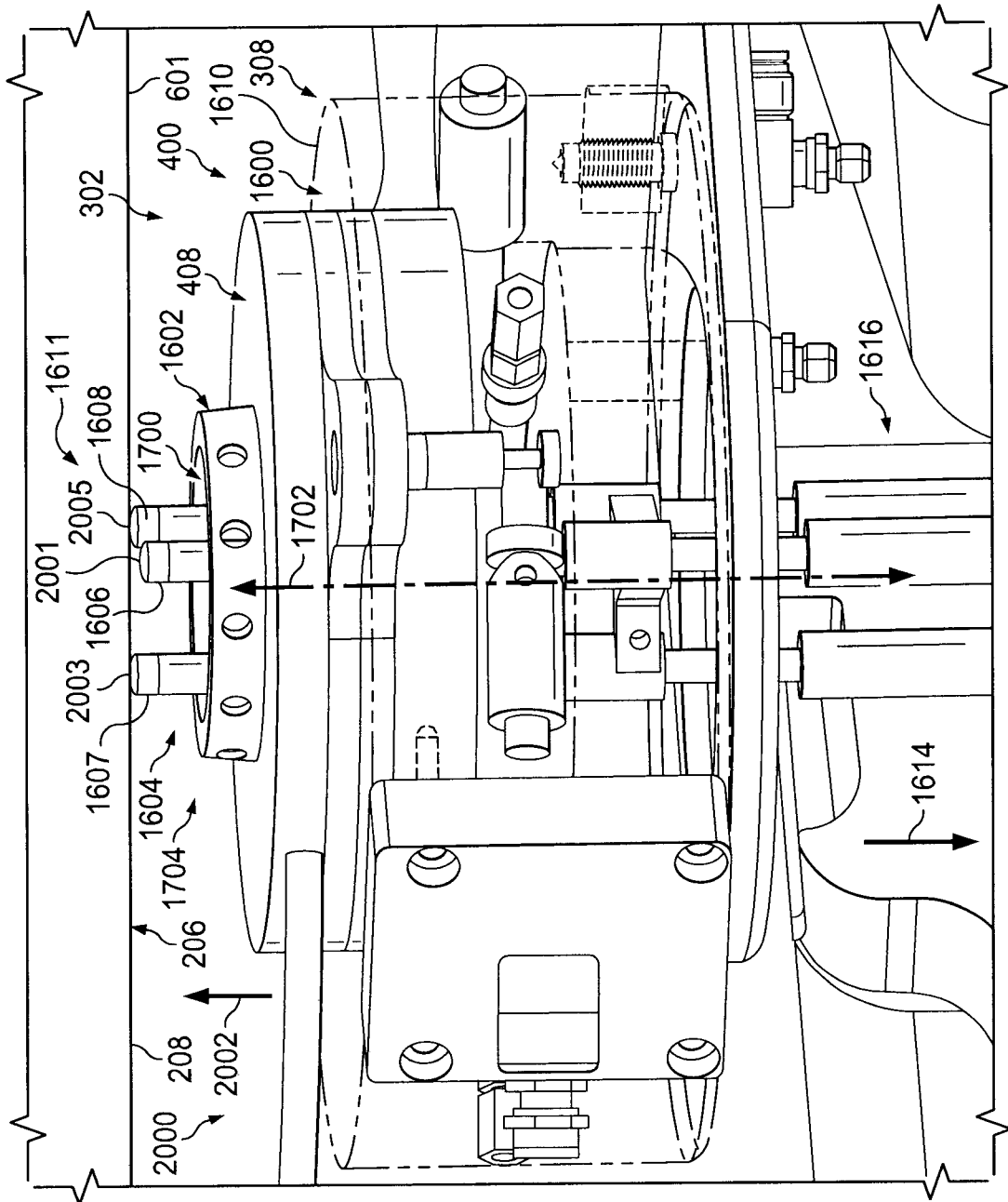


FIG. 20

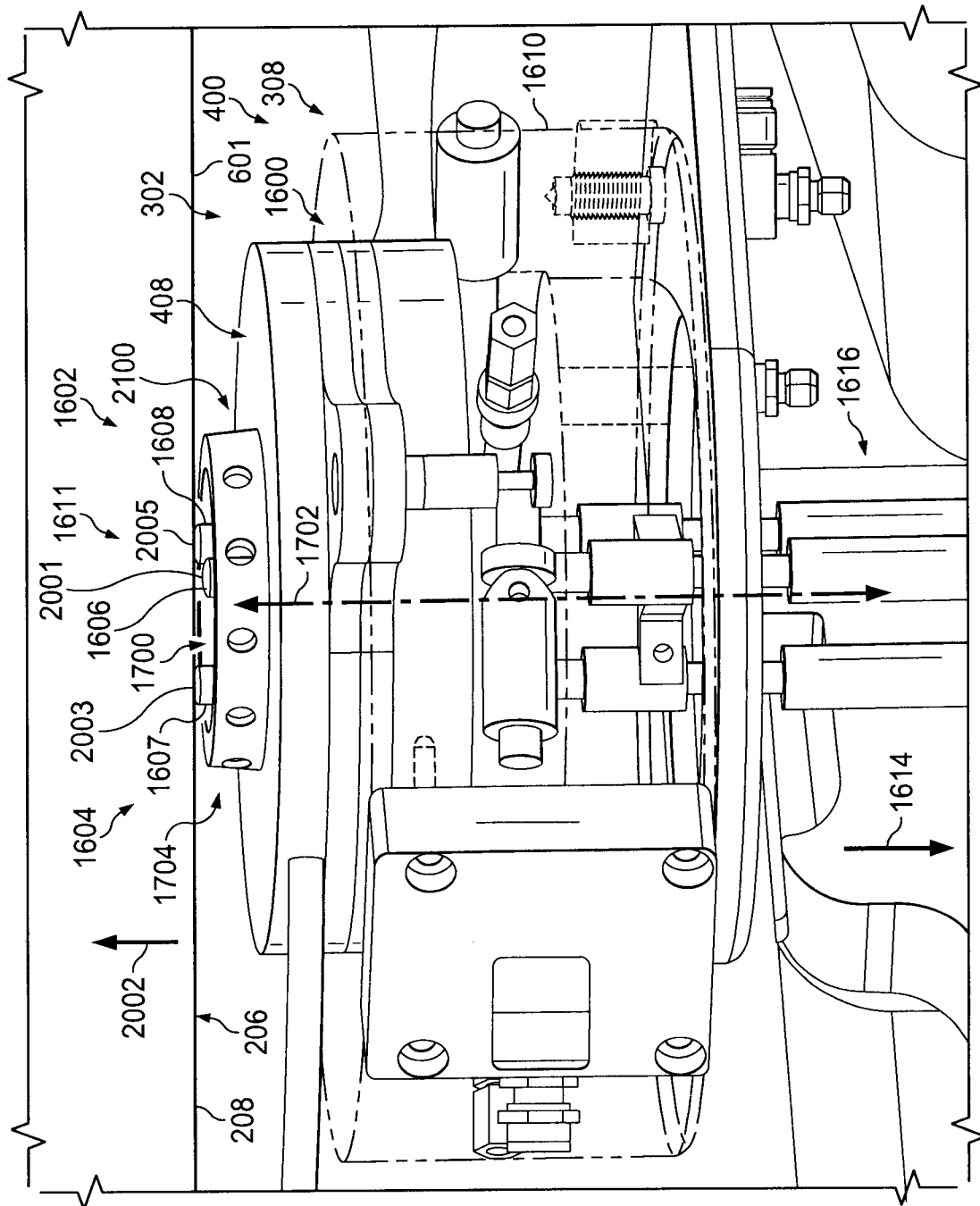


FIG. 21

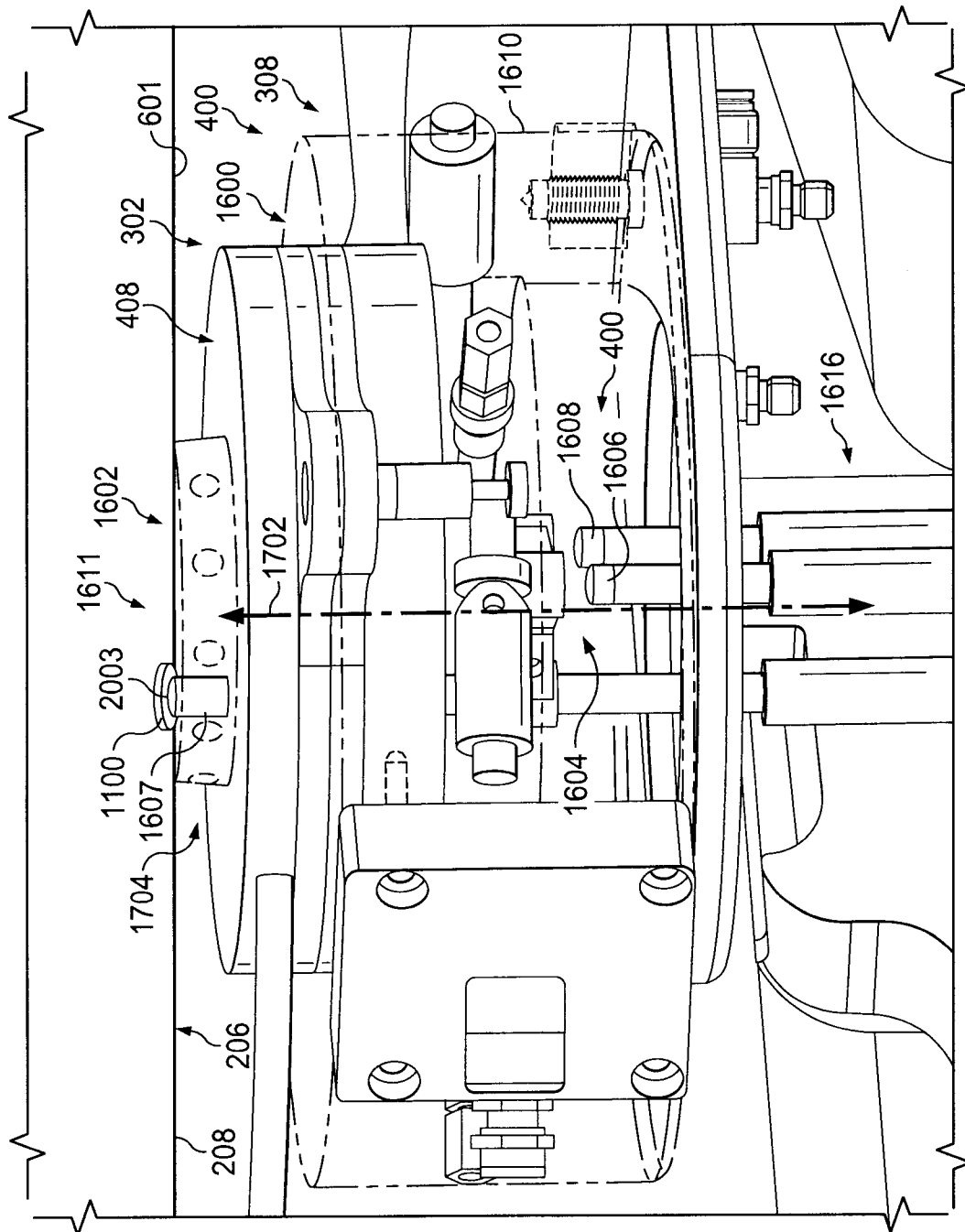
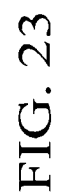


FIG. 22



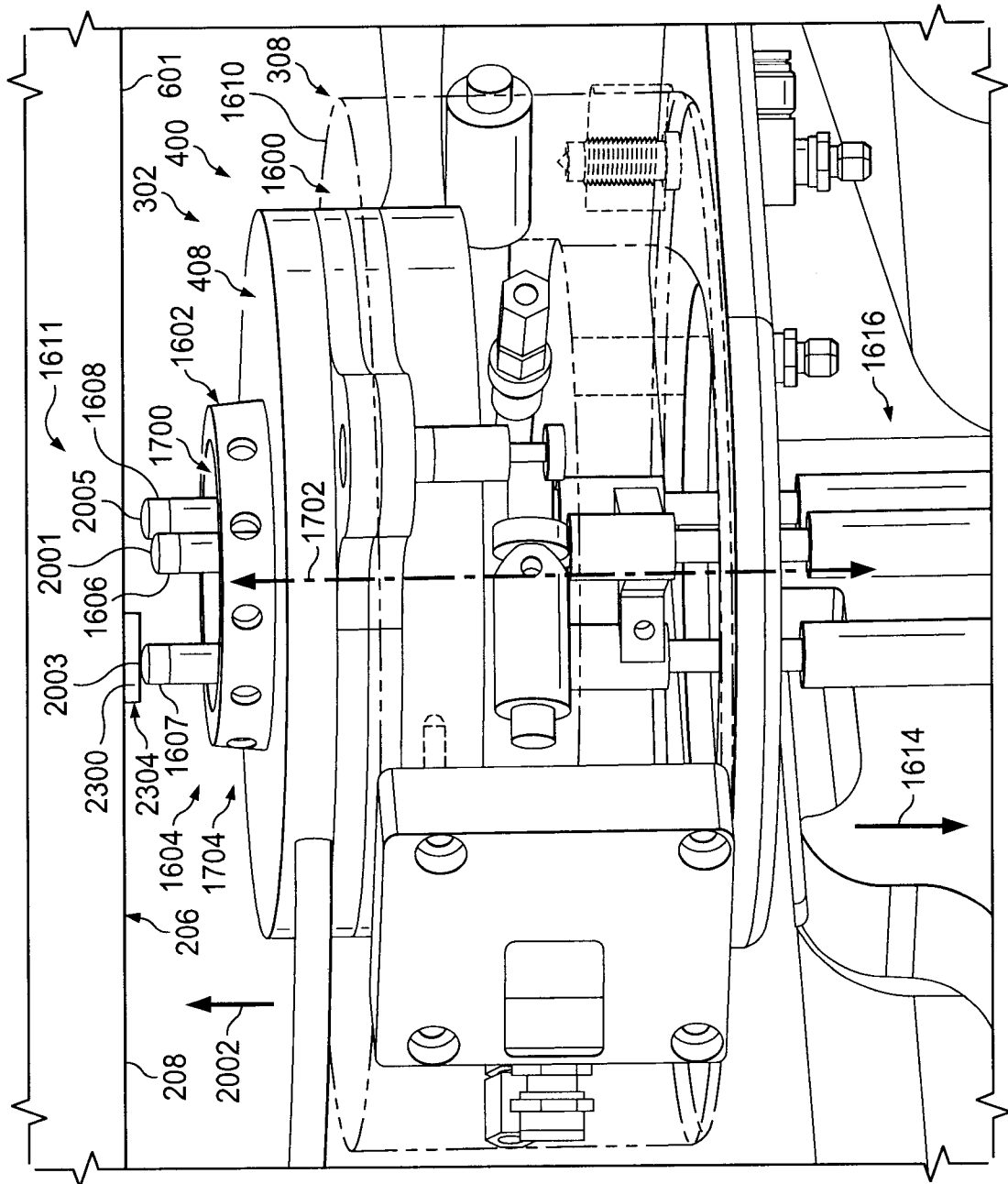


FIG. 24

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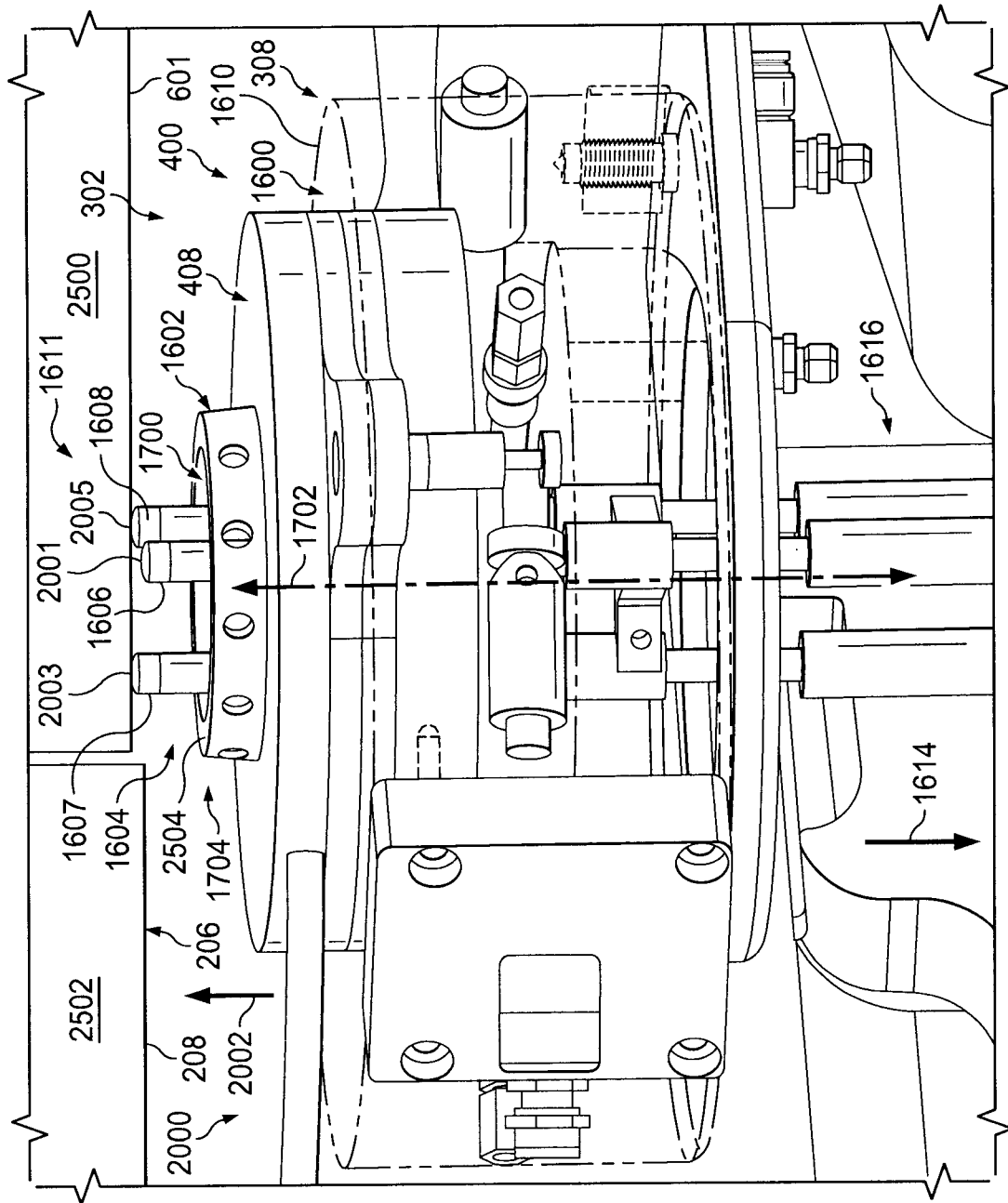


FIG. 25

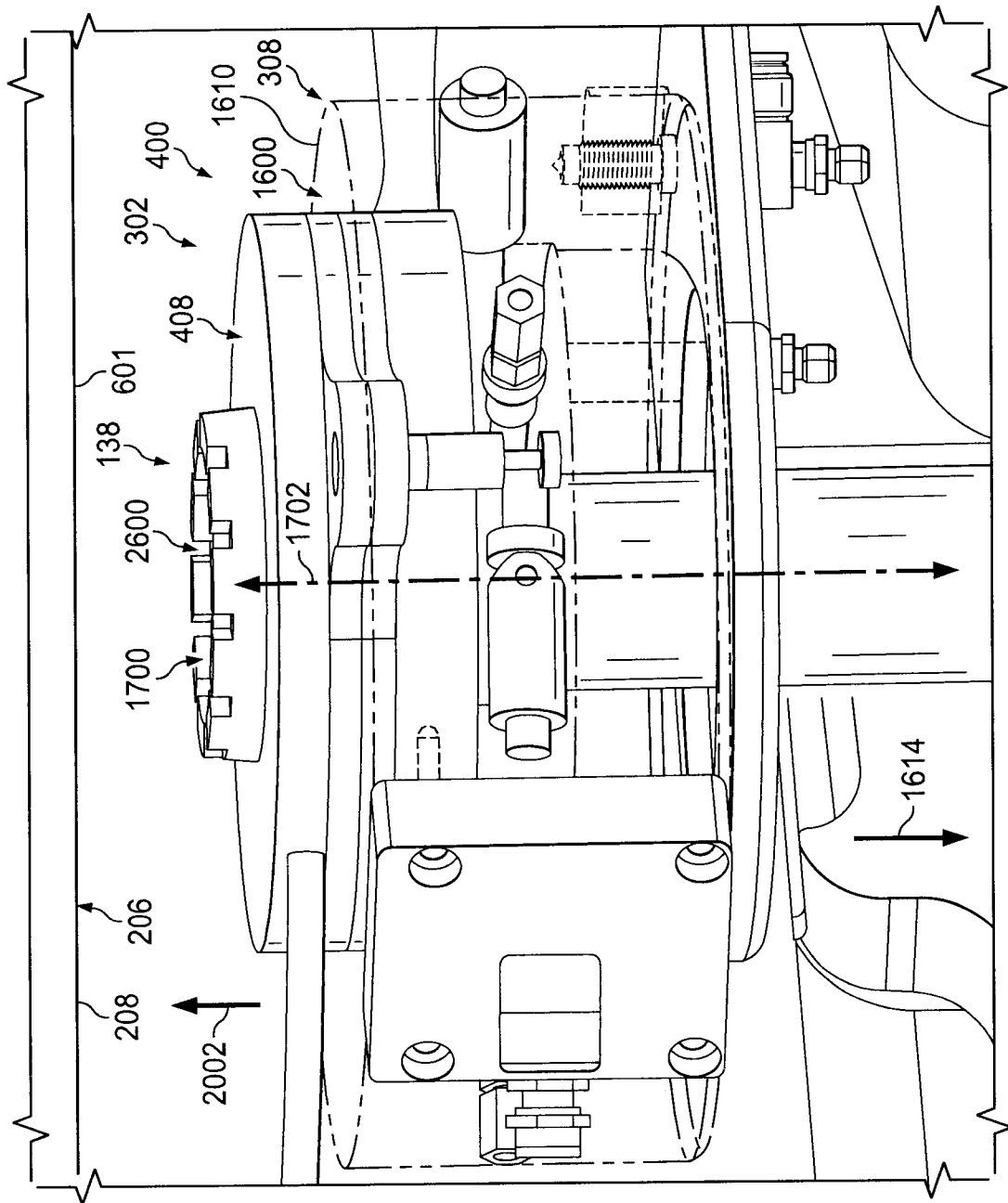


FIG. 26

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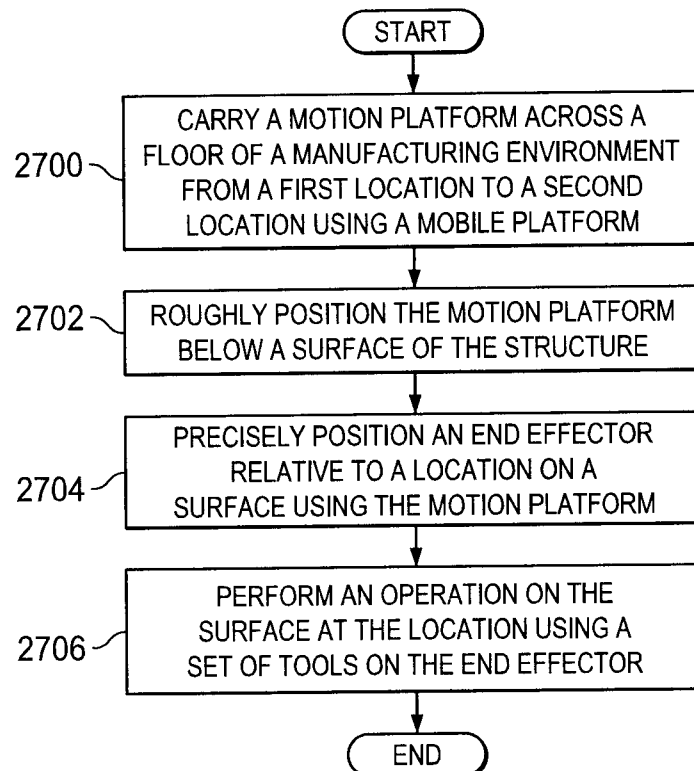


FIG. 27

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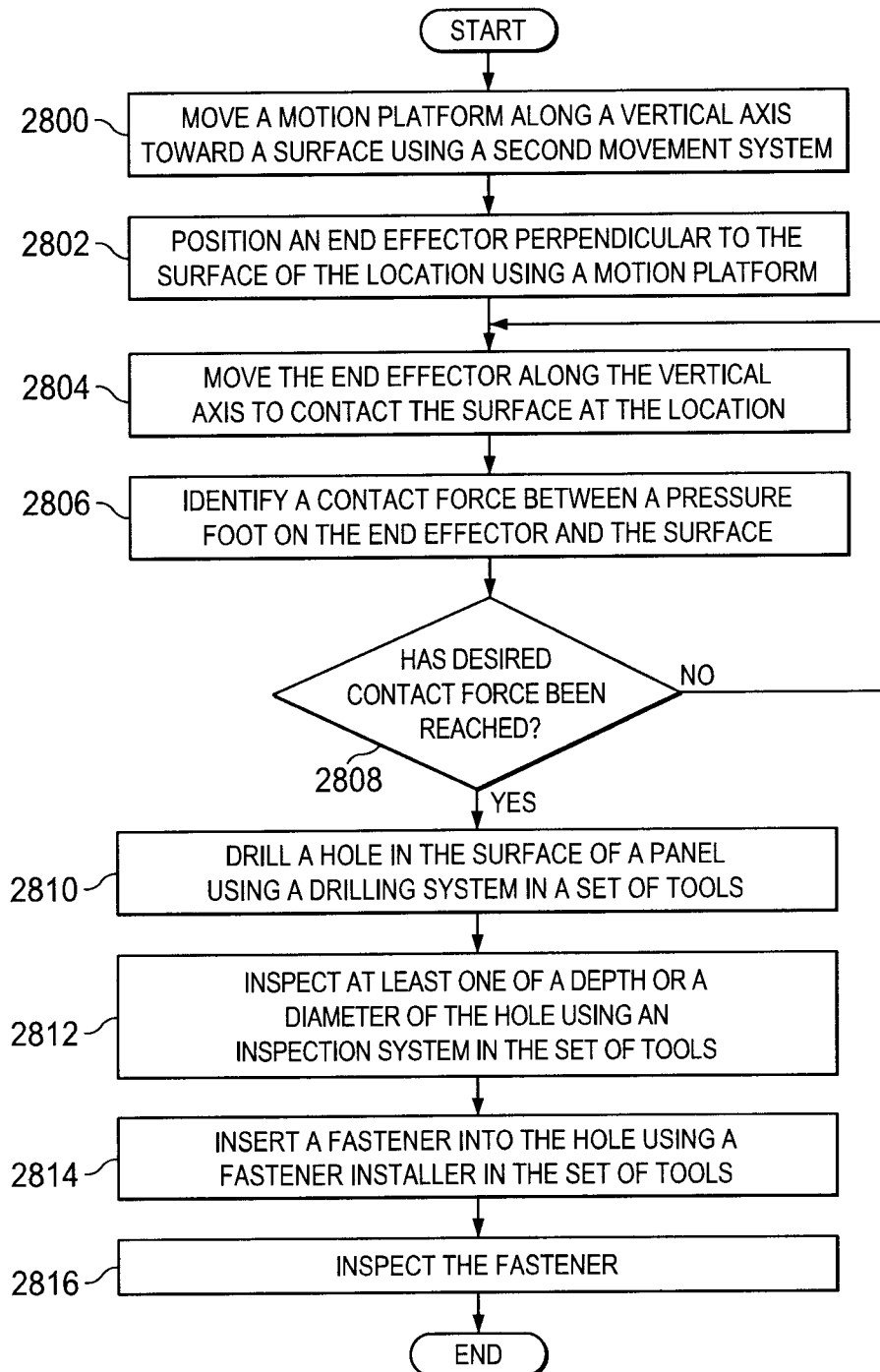


FIG. 28

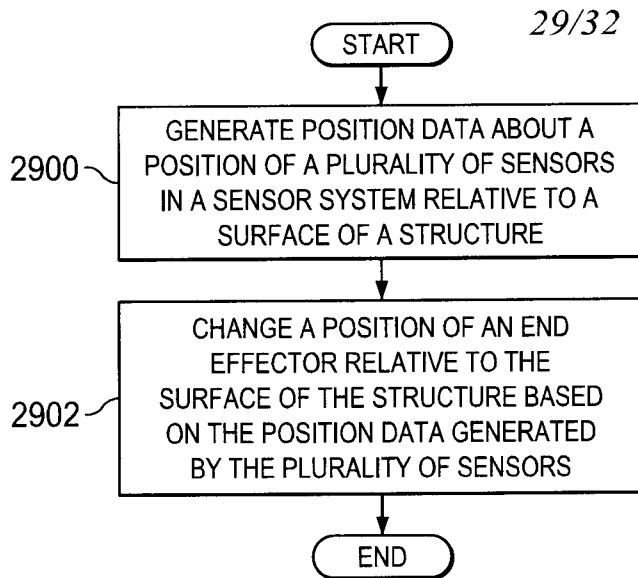


FIG. 29

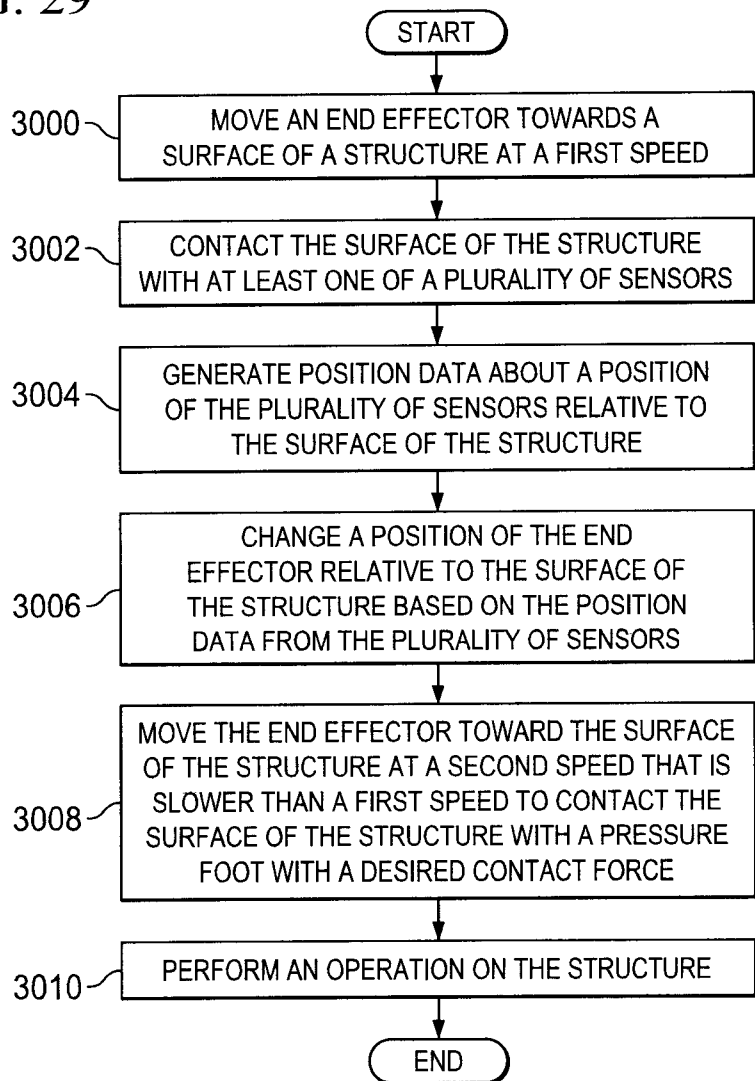


FIG. 30

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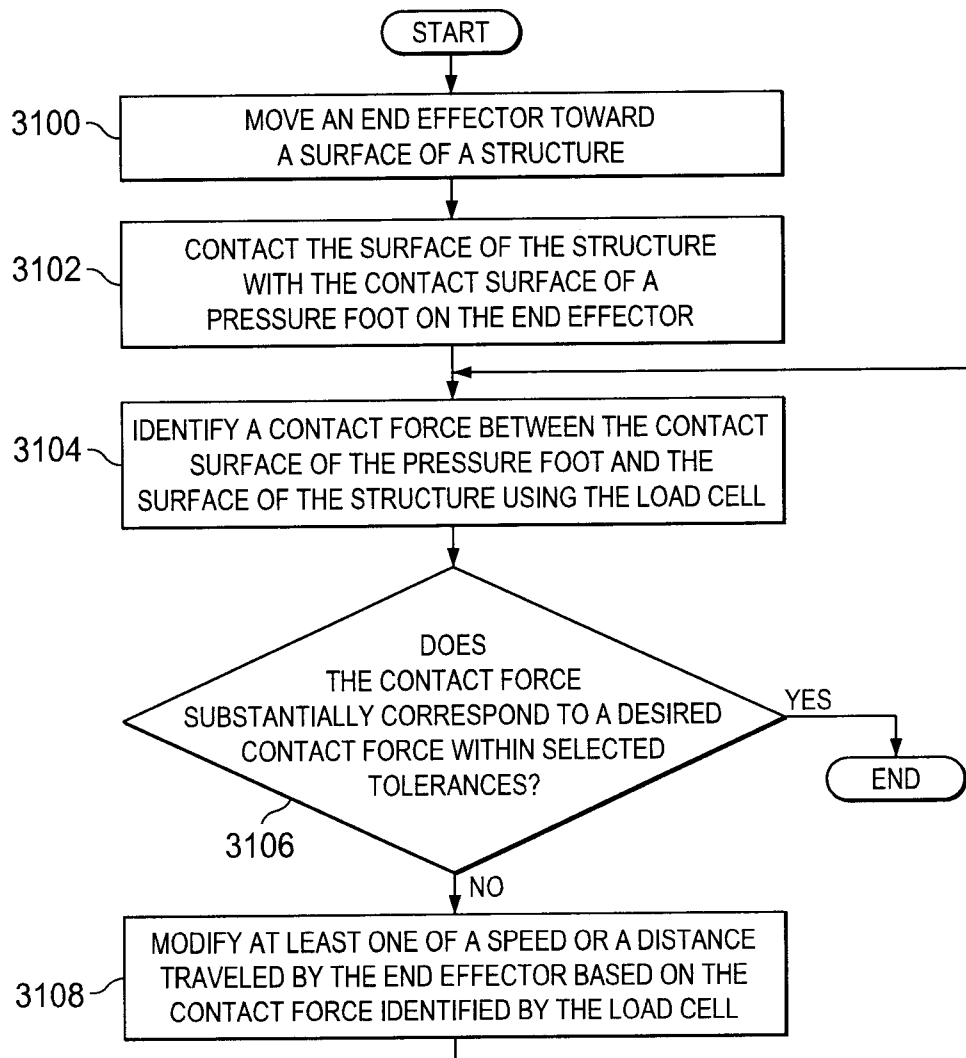


FIG. 31

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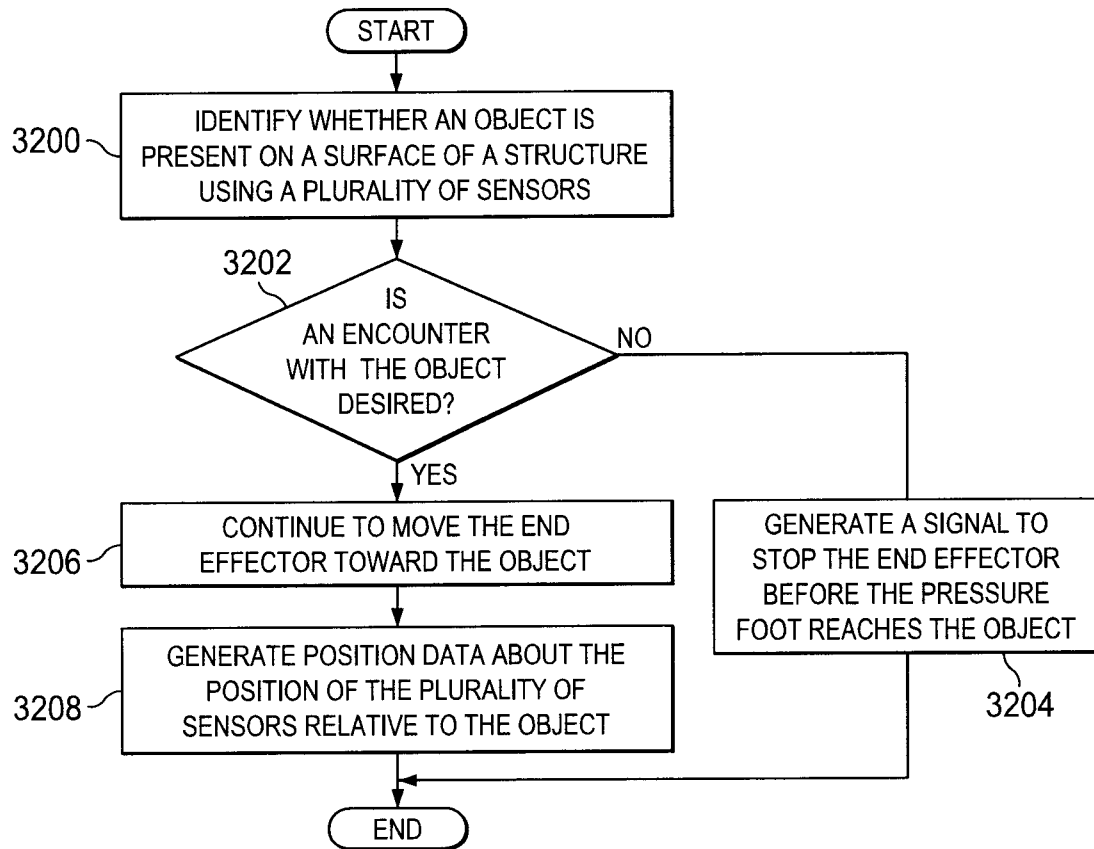


FIG. 32

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