

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
27 March 2003 (27.03.2003)

PCT

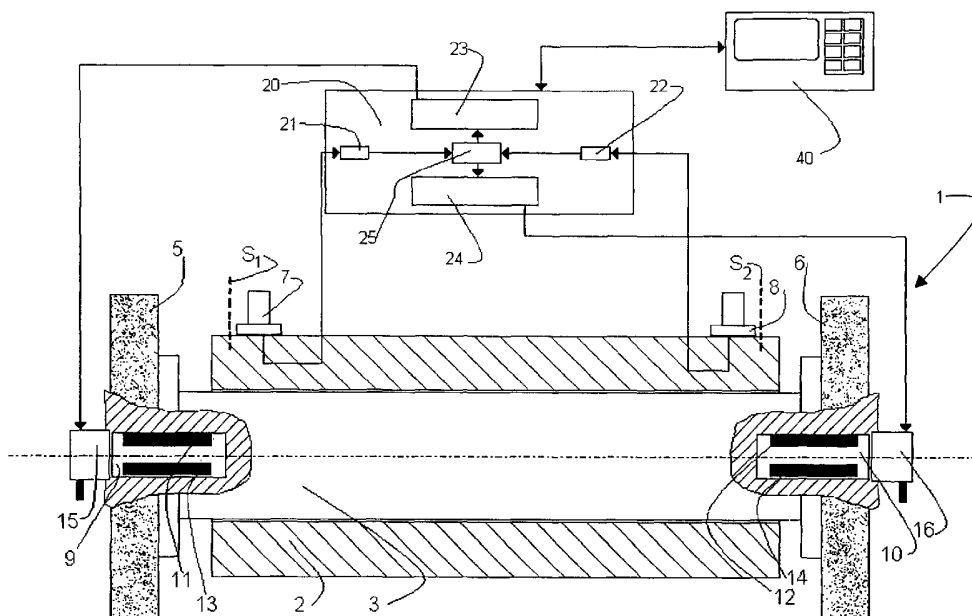
(10) International Publication Number
WO 03/025535 A1

- (51) International Patent Classification⁷: **G01M 1/36**
- (21) International Application Number: PCT/EP02/10282
- (22) International Filing Date:
13 September 2002 (13.09.2002)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data:
BO2001A000560
17 September 2001 (17.09.2001) IT
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- (81) Designated States (national): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.
- (84) Designated States (regional): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:
— with international search report

[Continued on next page]

(54) Title: METHOD AND APPARATUS FOR THE DYNAMIC BALANCING OF A ROTATING STRUCTURE



(57) Abstract: A method and an apparatus for balancing an elongate structure (1) rotating about an axis, like a spindle (3) carrying two grinding wheels (5, 6), wherein two vibration-detecting sensors (7, 8) and associated balancing devices (9, 10) with movable masses (11-14) are arranged at two checking sections (S₁, S₂) spaced out along the axis of rotation. Processing and control means (20) control the balancing devices on the basis of one or more signals (V_C; V_{C1}, V_{C2}) achieved as combination(s) of the vibrations, in module, detected by both the sensors.

WO 03/025535 A1



— before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments

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DESCRIPTION**«METHOD AND APPARATUS FOR THE DYNAMIC BALANCING OF A
ROTATING STRUCTURE»**

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Technical Field

The present invention relates to a method for the dynamic
balancing of a rotatable structure rotating about a
10 longitudinal axis, by means of an apparatus including two
vibration-detecting sensors, two associated balancing
devices, and processing and control means adapted for
processing signals output from the two vibration-detecting
sensors and for controlling the balancing devices, the
15 method including the steps of arranging each vibration-
detecting sensor and its associated balancing device near a
checking section, the two checking sections being spaced
out along the longitudinal axis, and controlling the
operation of the balancing devices on the basis of the
20 signals of the two vibration-detecting sensors.

The invention also relates to an apparatus for implementing
said method.

Background Art

25

The problem of balancing grinding wheels of grinding
machines is known from time.

Undesired vibrations are generally present in a grinding
machine, and generated by out-of-balance conditions of the
30 grinding wheel due to various possible reasons depending on
the grinding wheel itself, like shape and/or constitution
defects (inhomogeneity of the materials, concentricity
errors between the external abrading surface and the
internal centering hole, etc.), inaccurate assembling to
35 the rotating spindle (hence causing the wheel center of
gravity to be spaced apart from the axis of rotation), and,
in general, deteriorations due to wear and/or splinter

- 2 -

occurring during the machining of the workpieces. These vibrations may cause inaccuracies in the features of the machined workpieces - more specifically roundness errors like ovality and/or lobing - and introduce loads and stresses that may damage the machine tool.

Known balancing apparatuses, or balancers, are coupled to the grinding wheel and comprise movable masses, driven by electric motors that adjust the position of the masses, in the course of the wheel rotation, along radial or angular paths in order to compensate the previously mentioned out-of-balance conditions. The driving motors are also part of the apparatus, rotate along with it and the grinding wheel, and are power supplied and controlled by a stationary external power source, by means of an electric connection, including, for example, a brush collector and slip rings, or by means of a contactless connection, for example of the inductive type.

The characteristics (like, for example, the amplitude) of the vibrations generated as a consequence of the out-of-balance are picked up by processing the signals provided by an appropriate sensor and displayed, or processed in a proper unit (that often comprises the previously mentioned power supply source, too) for providing suitable balancing signals and for controlling the motors to drive the movable masses.

A balancing apparatus comprising the previously mentioned characteristics is disclosed in U.S. patent US-A-3698263. The automatic balancing of grinding wheels generally takes place in a heuristic way, i.e. on the basis of cycles for displacing the two masses in the balancing device in order to continuously reduce the vibration detected by the sensor until there is obtained its complete elimination or in any case its reduction to acceptable values. For example, it is possible to control, in the course of the rotation, angular displacements of the masses, taken together and/or individually, in a direction and/or in the other, on the basis of the trend of the signal of the vibration-detecting

- 3 -

sensor, until said signal reaches zero or a value very close to zero.

Automatic balancings using deterministic criteria - i.e. balancing procedures including the performing of test
5 cycles allowing to calculate the arrangement (for example the angular arrangement) of the masses that is able to balance the system - are more difficult and expensive to apply to rotors of machine tools, as it is required to continuously check the arrangement (for example the angular
10 arrangement) of the movable masses in the device.

Deterministic procedures are more frequent in the manually-operated balancings, for example for balancing automobile wheels, where balancing weights are added by an operator - at angular positions indicated by visual indicators - for
15 reducing the static out-of-balance. A deterministic procedure of this type is described in patent US-A-4854168. However, should the longitudinal layout dimensions of the grinding wheel be greater than, or even comparable with, its diametral dimensions (as in the case of grinding wheels
20 of centerless grinding machines), or should the machine tool have two grinding wheels coupled to the same shaft, at longitudinally spaced out positions, a single balancing device that operates, in substance, along a transversal plane is not sufficient for achieving the appropriate
25 balancing. In fact, besides the so-called "static" out-of-balance at a specific area, it is not possible to disregard the dynamic couple balancing, caused by the fact that the axis of rotation that does not coincide, in general, with the axis of inertia of the rotating system. In similar
30 cases it is known to utilize two balancing devices, substantially identical to each other and arranged at longitudinally separate positions, for carrying out a dynamic balancing of the grinding wheel, or of the grinding wheels/shaft system.

35 Patent application DE-A-2345664, which the preamble of claims 1 and 8 of the present patent application refers to, describes a method and an associated apparatus for the

- 4 -

dynamic balancing of an elongate grinding wheel for a centerless grinding machine, along two transversal sections relative to the longitudinal axis, by means of two devices each including a vibration-detecting sensor and an associated unit with movable masses, each device being arranged at one of the two sections. Processing, power supply and control units are alternately connected to the two balancing devices, for controlling in sequence displacements of the masses of each of the devices on the basis of the signal received by the associated vibration-detecting sensor.

In general terms the apparatus and the method described in the German patent application do not achieve satisfying results. In fact, it has been realized that although every balancing operation at each of the two sections determines displacements of the associated masses such that the vibrations detected by the associated sensor are reduced to zero or to a minimum, the displacement of the masses at a section modifies, in general, the vibrations detected at the other section, in a way that directly depends on the elasticity of the support structure of the rotating mass, more specifically on the transversal elasticity to rotation. For this reason the apparatus and the method according to patent application DE-A-2345664 provide acceptable results only if applied to structures with very particular features but, in general terms, do not enable to overcome the problem of the correct dynamic balancing of rotating systems.

30 Disclosure of Invention

An object of the present invention is to provide a balancing method and an apparatus for the dynamic balancing of rotating systems, more specifically elongate structures including tools as grinding wheels, that enable to eliminate or reduce to a minimum the unwanted vibrations in

- 5 -

a way that is rapid, safe and substantially does not depend on the structural features of the rotating system.

This and other objects are achieved by a method according to claim 1, and by an apparatus according to claim 9.

5 One of the advantages that a method according to the invention and, consequently, an associated apparatus provide is the application simplicity, that contributes to provide flexibility of use to rotating systems with tools of various shapes and arrangements.

10

Brief Description of the Drawings

The invention is hereinafter described with reference to the annexed drawings, given by way of non-limiting example
15 only, wherein:

figure 1 shows, in simplified form, an apparatus according to the invention, in a specific application,

figure 2 is a diagram with functional blocks of a balancing method according to a first embodiment of the
20 invention,

figure 3a is a graph representing the trend of the signals provided by the vibration-detecting sensors in the course of a known balancing cycle,

figure 3b is a graph representing the trend of the
25 signals provided by the vibration-detecting sensors in the course of a balancing cycle according to the present invention, and

figure 4 is a diagram with functional blocks of a balancing method according to an alternative embodiment of
30 the invention.

Best Mode for Carrying Out the Invention

Figure 1 illustrates, in simplified and partial form, an
35 elongate rotating structure **1** that defines a longitudinal axis and includes a shaft or spindle **3** and two grinding

- 6 -

wheels **5** and **6**, coupled to the ends of the shaft **3** and spaced out along the longitudinal axis.

A grinding machine support **2**, for example the wheel-carrier, defines an axis of rotation and supports the
5 rotating structure **1** in such a way that the longitudinal axis substantially coincides with the axis of rotation, and the spindle **3**, that is driven in a known way not shown in the figure, can rotate about said axis.

Two vibration-detecting sensors **7** and **8**, for example of the piezoelectric type, are fixed to the stationary support **2**
10 near transversal checking sections **S₁** and **S₂**, near the ends of shaft **3**.

Balancing devices **9** and **10** are housed, for example, in suitable recesses at the ends of the spindle **3** near the
15 transversal sections **S₁** and **S₂** and each includes a pair of eccentric balancing masses - shown in simplified form and identified by reference numbers **11**, **13** and **12**, **14**, respectively - angularly movable about the longitudinal axis by means of associated motors, not shown in the
20 figure. Transmission units **15** and **16** transmit the power supply for the motors and the information relating to the required angular displacements of the masses to the balancing devices **9** and **10**, by means of contactless couplings for example of the inductive type - per se known
25 and not shown in the figure.

Processing and control means **20** are connected to the machine logic **40**. Figure 1 shows, in simplified form, some circuits and units of the processing and control means **20**, and more specifically filtering and detection circuits **21**
30 and **22** connected to the vibration-detecting sensors **7** and **8**, respectively, two processing and control units **23** and **24** connected to the balancing devices **9** and **10**, respectively, and combining circuits **25**. The outputs of each of the filtering and detection circuits **21** and **22** are connected to
35 the combining circuits **25**, in turn connected to both the processing units **23** and **24**.

- 7 -

In figure 2 the functional blocks of the diagram indicate the steps of a balancing method according to the present invention and more specifically:

Block **30**: start of the dynamic balancing cycle;

5 Block **31**: filtering and detection of the signal of the vibration-detecting sensor **7** for achieving the module of the vibration detected at section **S₁**;

Block **32**: filtering and detection of the signal of the vibration-detecting sensor **8**, for achieving the module of
10 the vibration detected at section **S₂**;

Block **33**: combination of the achieved modules;

Block **34**: comparison between the calculated combination and a pre-determined threshold value;

Block **35**: control for driving the masses **11** and **13** of the
15 balancing device **9**;

Block **36**: control for driving the masses **12** and **14** of the balancing device **10**;

Block **37**: end of the balancing cycle.

The operation of the apparatus shown in figure 1 according
20 to the method indicated in figure 2 is as follows.

In the course of the grinding operations, a balancing cycle has to be carried out, for example, as a consequence of the substitution, or the dressing, of the grinding wheels **5** and/or **6**. In any case, the decision as to whether carry out
25 the balancing cycle is taken by an operator, or, in the example shown in figure 1, by the machine logic **40** that controls the start (block **30**) of this cycle.

In the course of the rotation of the spindle **3**, that carries the grinding wheels **5** and **6**, the sensors **7** and **8**
30 detect the vibrations at sections **S₁** and **S₂**, respectively, and send associated signals to the processing and control means **20**. More specifically, the signals of the sensors **7** and **8** are sent to the circuits **21** and **22**, respectively, where, according to a known process (blocks **31** and **32**),
35 they are filtered and detected for obtaining, for example, direct voltages **V₀₁** and **V₀₂** indicative of the modules of the two detected vibrations.

The signals output from circuits **21** and **22** are sent to combining circuits **25** (block **33**), that in turn send to both units **23** and **24** a combined signal V_C that is indicative of a combination of the modules of the vibrations detected by sensors **7** and **8**. The combination can be the plain sum of the signals output from circuits **21** and **22**:

$$V_C = V_{01} + V_{02} \quad (1)$$

or, there can be foreseen other types of combinations, as hereinafter described.

The combined signal V_C is compared with a pre-determined threshold value V_T (block **34**), indicative of the whole vibration considered as acceptable for the rotating system (ideally $V_T = 0$). When the value of the combined signal V_C is lower than the threshold value V_T , the balancing cycle ends (block **37**).

If $V_C > V_T$, the units **23** and **24** control, by means of their associated transmission units **15** and **16**, displacements of the masses **11**, **13** and **12**, **14** of the balancing devices **9** and **10** (blocks **35** and **36**). The operation of the balancing devices **9** and **10** is controlled by the associated units **23** and **24**, that control displacements of the masses **11**, **13** and **12**, **14** till the value of the combined signal V_C - that varies as the vibrations vary at sections S_1 and S_2 as a consequence of the various positions taken by the masses **11-14** - reaches or becomes lower than the threshold value V_T .

According to an embodiment of the present invention, the method foresees that the balancing devices **9** and **10** be controlled in parallel by their associated units **23** and **24**. In other words, each of the units **23** and **24** controls, in a simultaneous and independent way with respect to the other, displacements of the masses of the associated balancing devices **9** and **10**, both with the aim of minimizing the value of the combined signal V_C .

Another embodiment of the present invention foresees a method according to which the displacements of the masses

11, 13 and 12, 14, respectively, are controlled in an alternative and sequential way by their associated units 23 and 24, till the value of the same combined signal V_c reaches the threshold value V_T .

5 Figure 3b is a graph representing a possible trend in time of the modules V_{01} and V_{02} of the vibrations detected by sensors 7 and 8, and of the combined signal V_c (in this case the sum of the modules V_{01} and V_{02}) in a typical balancing cycle according to the method disclosed in the present invention in an application as the one shown in
10 figure 1.

Figure 3a shows, instead, the possible trend of the same values of the modules of the vibrations at the sections S_1 and S_2 (identified as V_{01}' and V_{02}') in an identical
15 application, in which the applied method is substantially similar to the one described in the patent application DE-A-2345664, in other words each balancing device 9 (10) is controlled by its associated processing and control unit 23 (24) in a sequential way and on the basis of the signal of
20 just sensor 7 (8) applied at the associated section S_1 (S_2).

The shape of the graph of figure 3a (known prior art) shows how, while the value of signal V_{01}' of a first vibration-detecting sensor decreases to a minimum, thanks to the
25 action of its associated balancing device in time t_1 , the value of the signal V_{02}' of the second sensor is simultaneously changed and in general increases. In a symmetric way the subsequent actuation of the other balancing device makes the vibrations detected by the
30 second sensor (V_{02}') decrease, but causes increasing of the value of the first signal (V_{01}') increase in the time interval from t_1 to t_2 . For this reason, as a consequence of the alternative operation of the two balancing devices, even if it is repeatedly performed (and not just once, as
35 described in DE-A-2345664), the signals of the two vibration-detecting sensors in general do not converge

- 10 -

towards zero, or at least towards a minimum value that corresponds to the requested specifications.

The graph of figure 3b shows how, instead, by applying a method according to the present invention, the balancing
5 action of both the devices **9** and **10** that tend to minimize the value of the combined signal V_C leads to a convergence of the signals V_{01} and V_{02} of the individual sensors **7** and **8** towards the minimum requested value.

As far as the combined signal V_C and the processing carried
10 out in the combining circuits **25** are concerned, as previously mentioned there can be foreseen alternatives to the plain sum of the signals output from the filtering and detection circuits **21** and **22**. More specifically, there can be foreseen linear combinations of the signals in which
15 there is given different weight to the vibrations detected by the two sensors **7** and **8**, by means of coefficients that, for instance, give more importance to the highest vibration value - and consequently to the greatest out-of-balance condition - of the two detected at sections S_1 and S_2 :

20

$$V_C = aV_{01} + bV_{02} \quad (2)$$

It is also possible to make the coefficients vary in the course of the balancing operation, for instance for progressively increasing the importance of the lowest vibration.

25 Another possible combination achieved by means of the circuits **25** is represented by the square root of the sum of the squares of the values of the two signals:

$$V_C = \sqrt{V_{01}^2 + V_{02}^2} \quad (3)$$

According to a further solution two different, combined
30 signals V_{C1} and V_{C2} are sent to the units **23** and **24**, for example two linear combinations as in formula (2), with different coefficients. A possible alternative balancing method, represented in figure 4, is now shortly described. After the cycle is started (block **50**), and signals V_{01} and

- 11 -

V_{02} are dynamically obtained (blocks **51** and **52** of figure 4, corresponding to blocks **31** and **32** of figure 2) they are processed to get combined signals V_{C1} (block **53**) and V_{C2} (block **54**), where

$$V_{C1} = V_{01} + kV_{02} \quad (4)$$

$$V_{C2} = k'V_{01} + V_{02} \quad (5)$$

5 It may be, for instance, $k = k' = 1/2$

The combined signals V_{C1} and V_{C2} are compared with respective threshold values V_{T1} and V_{T2} (block **56**) and when

$$(V_{C1} < V_{T1}) \text{ AND } (V_{C2} < V_{T2}) \quad (6)$$

the balancing cycle ends (block **61**).

If the value of at least one of the combined signals V_{C1} ,
 10 V_{C2} is not lower than the respective threshold V_{T1} , V_{T2} , the units **23** and **24** control, by means of their associated transmission units **15** and **16**, displacements of the masses **11**, **13** and **12**, **14** of the balancing devices **9** and **10**. In the example according to figure 4 there is a sequential
 15 procedure wherein each balancing device (e.g. **9**) is controlled (block **57**) in a known way until (block **59**) a minimum value of the relevant combined signal V_{C1} is reached, and then - if the balancing procedure needs to go on (blocks **55**) - the other balancing device **10** is similarly
 20 controlled (blocks **58** and **60**). Block **56** represents a test for establishing which of the two balancing devices **9**, **10** must be controlled in the above-mentioned sequence.

In any case, the combinations V_{C1} and V_{C2} are both achieved on the basis of both the signals provided by the vibration-
 25 detecting sensors **7** and **8**.

The described methods and apparatus enable to achieve the required dynamic balancing in two planes or sections in a simple and efficient way, and can be applied to elongate rotating structures of various types, including, for
 30 example, two grinding wheels coupled to an identical spindle (as shown in the example in figure 1), or a single elongate grinding wheel (as the one, for centerless

- 12 -

grinding machines, shown in the previously mentioned patent application DE-A-2345664), or a single grinding wheel coupled near an end of a rotating spindle, or rotating tools of other shapes and arrangements.

5 The processing and control means **20** can be achieved in a different way with respect to what is shown in simplified form in figure 1. For example, the filtering and the detection of the signals of the sensors **7** and **8** can be carried out by circuits included in the processing and
10 control units **23** and **24** and the latter can be mutually connected for each achieving the combination of the two obtained signals, without the need of the combining circuits **25**.

Even the balancing devices - one or both - can have
15 different shape and structure with respect to those (**9** and **10**) shown in figure 1, and can be, for example, coupled externally to their associated grinding wheel **5** and/or **6** instead of at the interior of the spindle **3**, or include masses translating in transversal directions instead of
20 rotating, or have other per se known characteristics.

CLAIMS:

1. Method for the dynamic balancing of a rotatable structure **(1)** rotating about a longitudinal axis, by means
5 of an apparatus including two vibration-detecting sensors **(7,8)**, two associated balancing devices **(9,10)**, and processing and control means **(20)** adapted for processing signals output from said two vibration-detecting sensors **(7,8)** and for controlling said balancing devices **(9,10)**,
10 the method including the steps of:
- arranging each vibration-detecting sensor and its associated balancing device near a checking section, the two checking sections **(S₁, S₂)** being spaced out along said longitudinal axis, and
 - 15 ▪ controlling the operation of the balancing devices **(9,10)** on the basis of the signals **(V₀₁, V₀₂)** of the two vibration-detecting sensors **(7,8)**,
- characterized in that the signals **(V₀₁, V₀₂)** of the two vibration-detecting sensors **(7,8)** are processed together
20 **(33;53,54)** for achieving one or more combined signals **(V_c; V_{c1}, V_{c2})**, and the operation **(35,36;57,58)** of said two balancing devices **(9,10)** is controlled **(34;55,59,60)** on the basis of values of said one or more combined signals **(V_c; V_{c1}, V_{c2})**.
25
2. The method according to claim 1, wherein the operation **(35,36)** of the two balancing devices **(9,10)** is controlled in a simultaneous and independent way with respect to each other.
30
3. The method according to claim 1, wherein the operation **(57,58)** of the two balancing devices **(9,10)** is controlled in a sequential way with respect to each other.
- 35 4. The method according to one of the preceding claims, wherein the signals **(V₀₁, V₀₂)** of the two vibration-detecting sensors **(7,8)** are processed together **(33)** for achieving

- 14 -

just one (V_c) of said one or more combined signals ($V_c; V_{c1}, V_{c2}$), and the operation (35,36) of both of said two balancing devices (9,10) is controlled (34) on the basis of values of said just one combined signal (V_c).

5

5. The method according to one of the preceding claims, wherein the signals of the two vibration-detecting sensors (7,8) are processed (33;53,54) for achieving said one or more combined signals ($V_c; V_{c1}, V_{c2}$) as one or more combinations of the modules (V_{01}, V_{02}) of signals indicative of the vibrations at said two checking sections (S_1, S_2).

10

6. The method according to claim 5, wherein at least one (V_c) of said one or more combined signals ($V_c; V_{c1}, V_{c2}$) is obtained as the sum of said modules (V_{01}, V_{02}).

15

7. The method according to claim 5, wherein at least one (V_c) of said one or more combined signals ($V_c; V_{c1}, V_{c2}$) is obtained as the square root of the sum of the squares of said modules (V_{01}, V_{02}).

20

8. The method according to claim 5, wherein said one or more combined signals ($V_c; V_{c1}, V_{c2}$) are obtained as one or more linear combinations of said modules (V_{01}, V_{02}).

25

9. Apparatus for the dynamic balancing of a rotating structure (1) rotating about a longitudinal axis, by means of a method according to claim 1, wherein said processing and control means (20) include two processing and control units (23,24), each processing and control unit being adapted to control one of said balancing devices (9,10).

30

10. The apparatus according to claim 9, wherein each of said balancing devices includes balancing masses (11,13;12,14) movable under the control of the associated processing and control units (23,24).

35

- 15 -

11. The apparatus according to claim 10, wherein each of said balancing devices **(9,10)** includes a pair of said balancing masses **(11,13;12,14)**, the masses being eccentric with respect to the longitudinal axis and angularly movable
5 about it.

12. The apparatus according to one of claims from 9 to 11, including filtering and detection circuits **(21,22)**, adapted for receiving signals sent by the vibration-detecting
10 sensors **(7,8)** and for providing signals **(V₀₁,V₀₂)** indicative of the trend of the associated modules.

13. The apparatus according to one of claims from 9 to 12, for the dynamic balancing of a rotating structure **(1)** of a
15 grinding machine including a spindle **(3)** and two grinding wheels **(5,6)** coupled to the spindle at positions spaced out along the longitudinal axis, wherein said balancing devices **(9,10)** are coupled to the grinding wheels **(5,6)** and are rotatable with them.
20

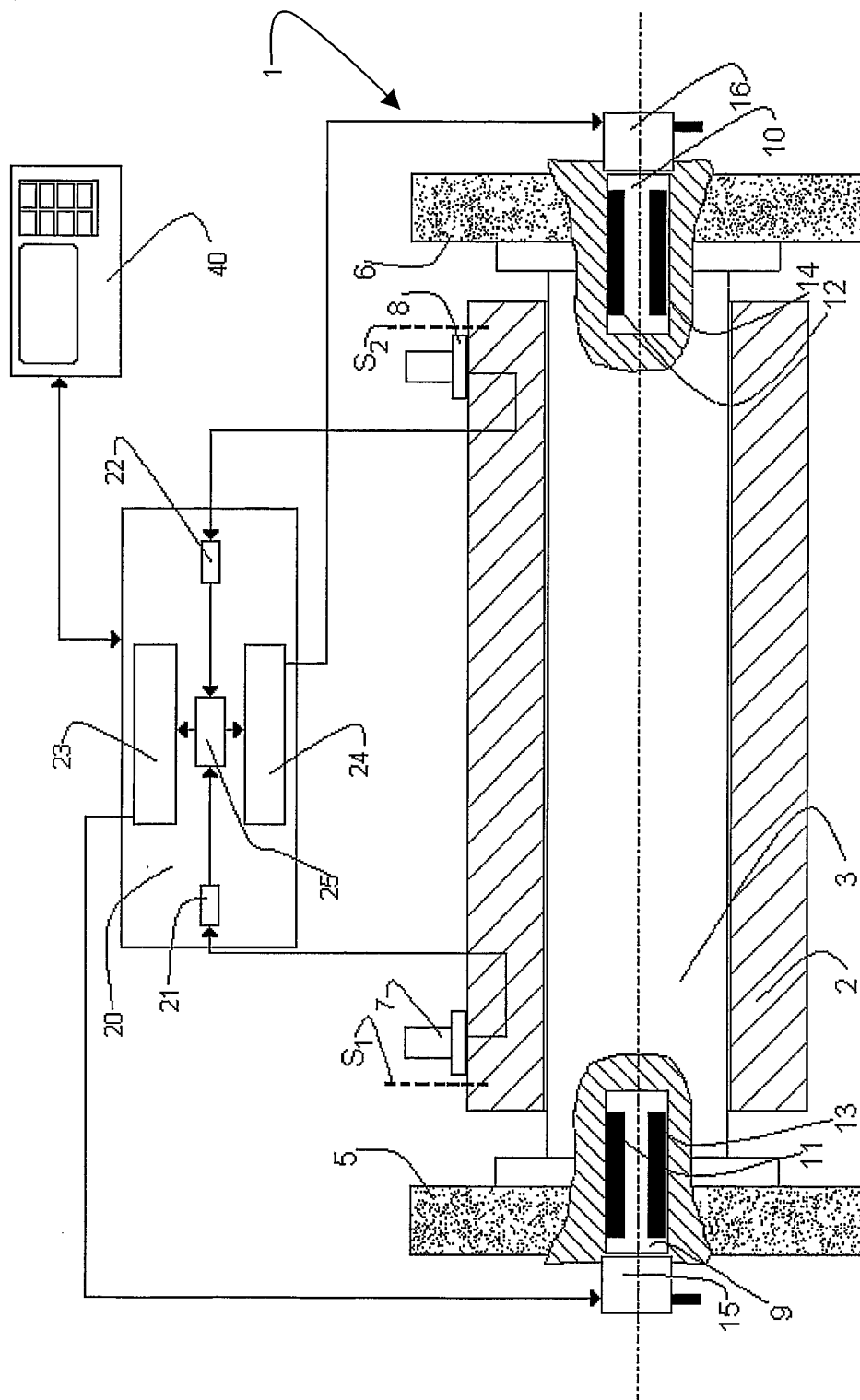


FIG. 1

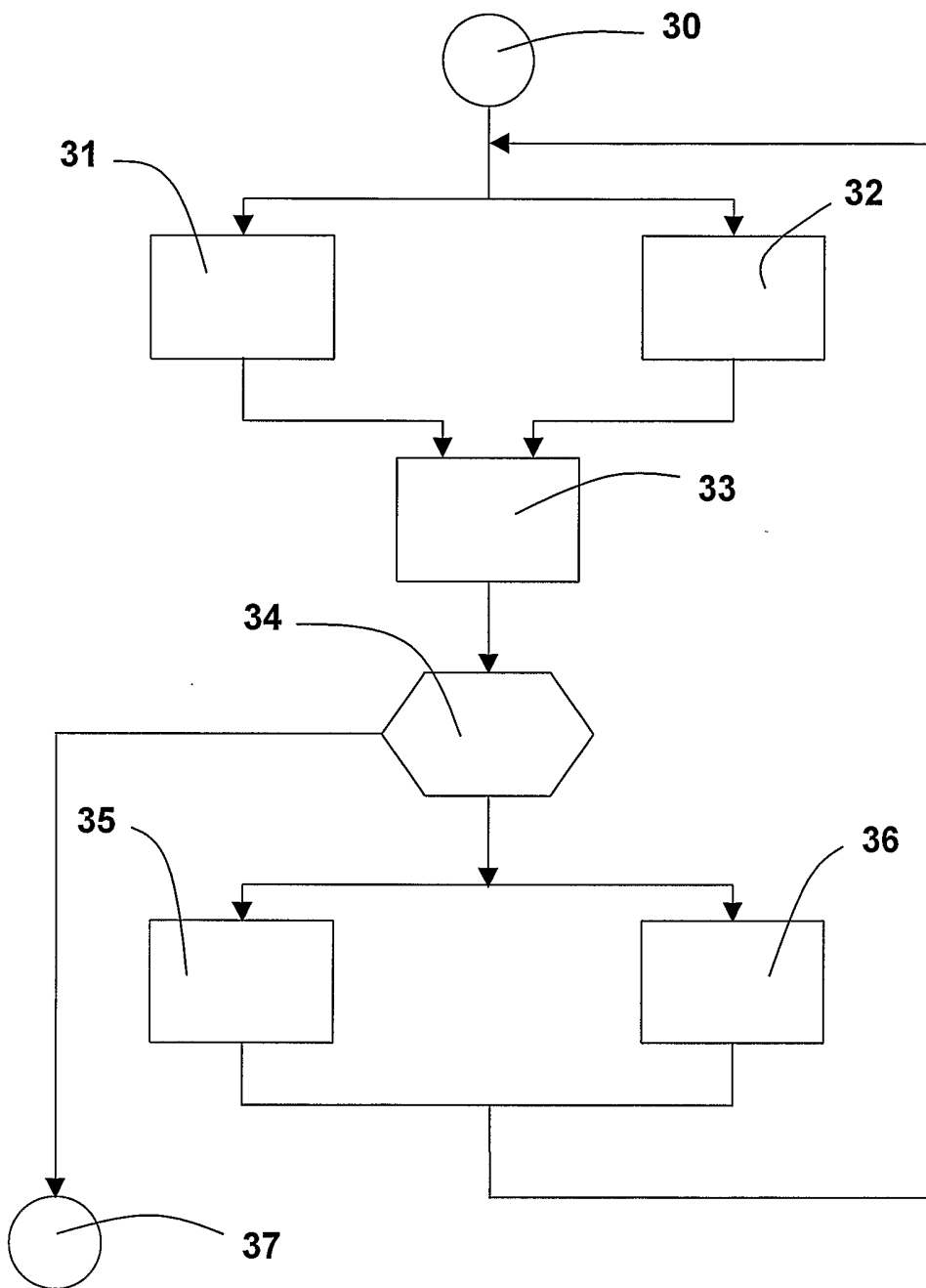


FIG. 2

3 / 4

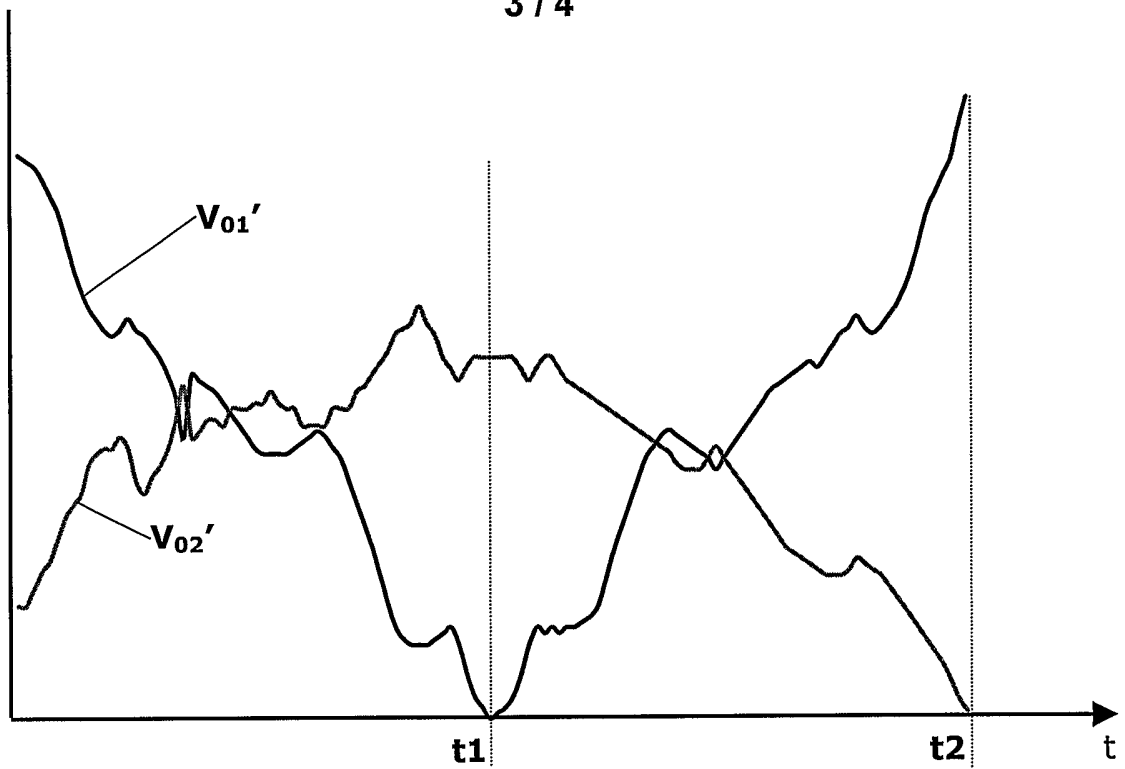


FIG. 3a

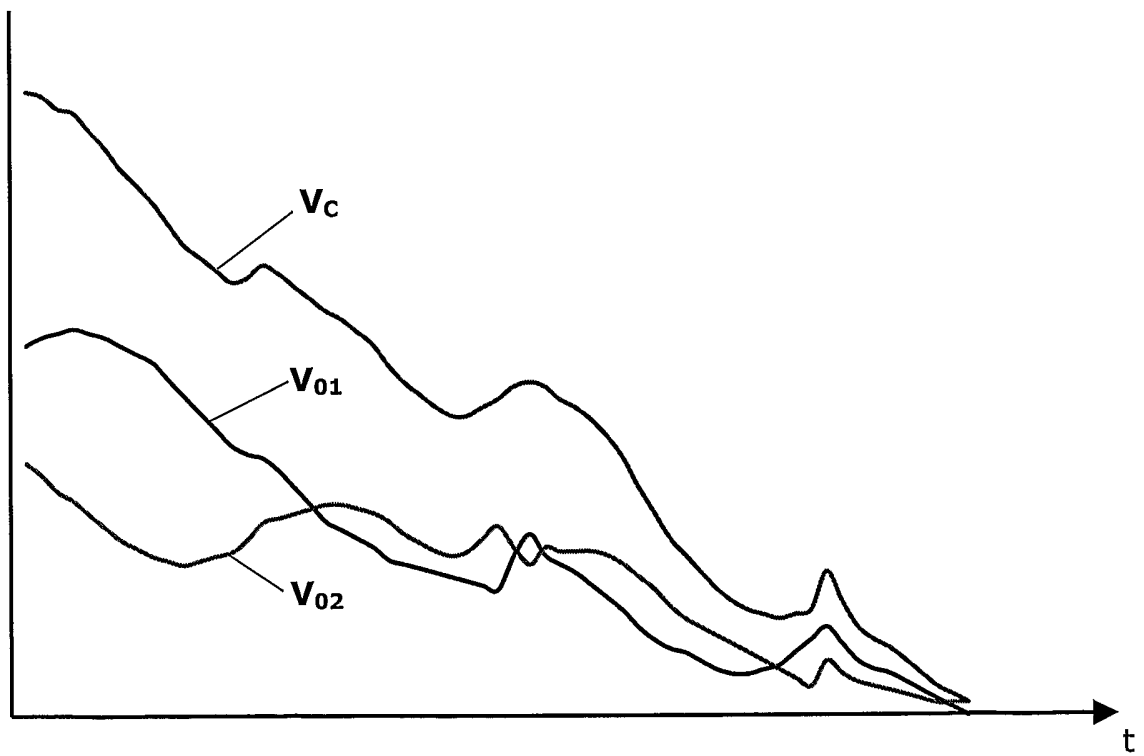


FIG. 3b

4 / 4

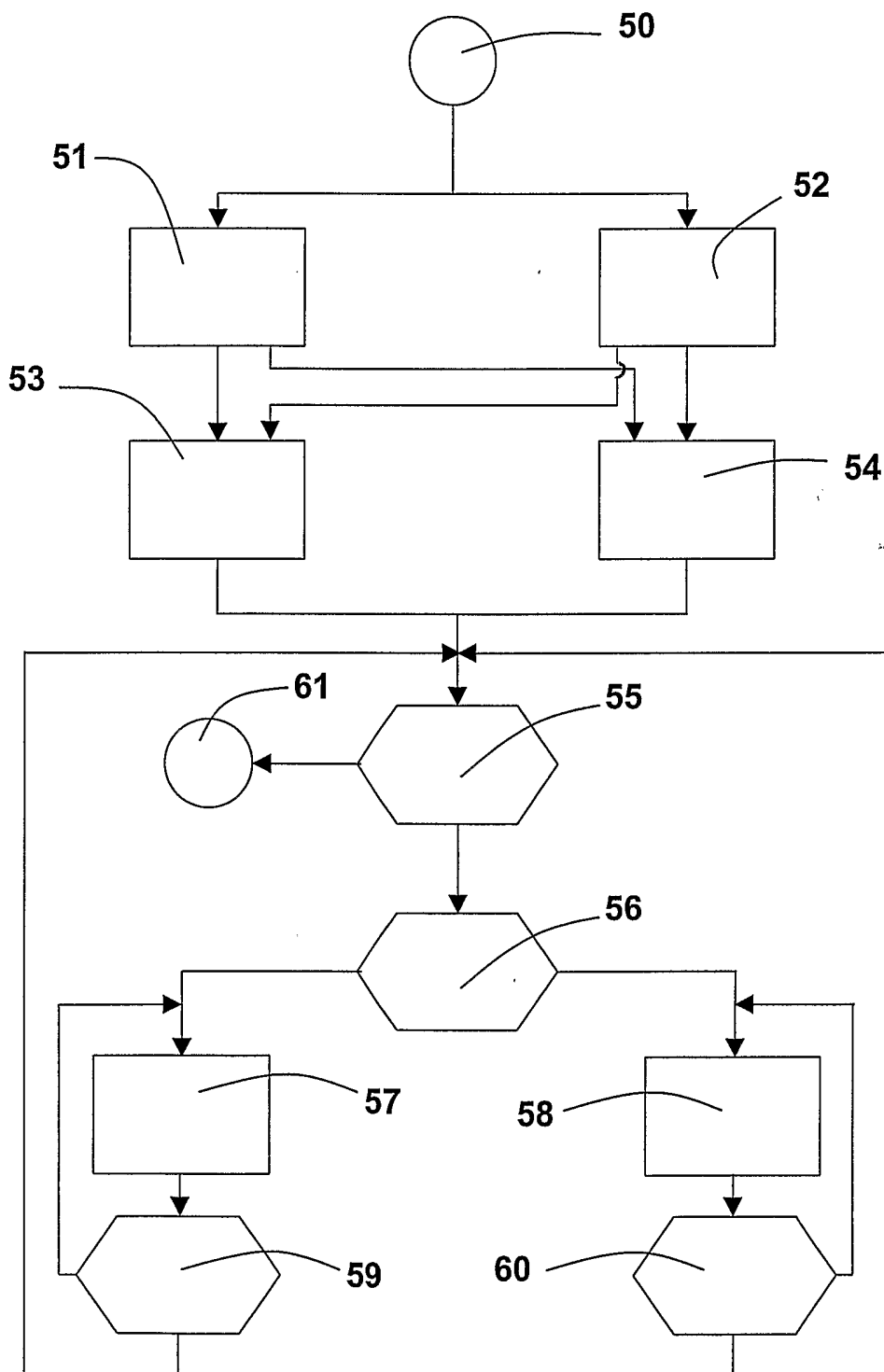


FIG. 4

INTERNATIONAL SEARCH REPORT

Intern application No
PCT/EP 02/10282

A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 G01M1/36

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 7 G01M

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category °	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	DE 29 34 161 A (J.G. ZIVOTOV ET AL.) 26 March 1981 (1981-03-26)	1
A	page 14, line 3 -page 16, last paragraph; figure 3	9
A	US 4 543 463 A (G.B. SCURICINI) 24 September 1985 (1985-09-24) abstract; figure 1	1
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Further documents are listed in the continuation of box C.

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