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The present invention relates to a transfer system for the transport of objects comprising a guide rail which has a light metal base body and at least one guide element connected to the light metal base body and having a guide surface; a
5 slide for the reception of at least one object; and a bearing which linearly displaceably supports the slide at the guide rail.

A transfer system of the initially named kind is used, for example, in automation technology to transport objects from one location to another location; for example,
10 from one production step to the next. The objects are positioned on slides for this purpose and the slides are traveled along a guide rail.

It is known to manufacture guide rails as compound elements. In such so-called compound linear guides, the body is, for example, produced from light metal, for
15 instance aluminum. Wires or shafts of steel that are introduced into the body, e.g. by insertion or rolling in, serve as guide elements. Such known compound linear guides have in particular proved to be rather unsuitable for applications using ball guides due to their small torsional stiffness and low precision. The low precision in this respect above all relates to the insufficient parallelism of the guide elements.

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It is also known to manufacture guide rails substantially completely from steel. They are as a rule better – as regards machining precision – than known compound linear guides. They do, however, suffer from the disadvantage that they are very difficult and expensive to manufacture.

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A transfer system in accordance with the preamble of claim 1 is known from DE 44 17 136 A1. An electromagnetic clamping device for clamping workpieces is known from DE 27 57 418 A1.

Starting from the prior art, it is the underlying object of the invention to provide a transfer system which can be manufactured comparatively easily and inexpensively and which can be produced and machined with equivalent precision in comparison with known steel guide rails. It is additionally the underlying object
5 of the invention to provide a corresponding machining method.

The object is satisfied by a transfer system for the transport of objects having the features of claim 1 and in particular in that the guide rail has at least one magnetic fixing means which enables a temporary fastening of the guide rail by means of a
10 magnetic clamping apparatus.

The further object of the invention is satisfied by a method of machining a transfer system having the features of claim 10.

15 It is the underlying general idea of the invention to clamp the guide rail in as simple a manner as possible free of tension to be able to machine the guide element in the state embedded into the light metal base body. For this purpose, at least one magnetic fixing means is provided at the guide rail to be able to magnetically clamp the guide rail for machining.

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Advantageous embodiments of the invention can be seen from the dependent claims, from the description and from the drawings.

In accordance with an embodiment, the fixing means is areal. In this context, areal
25 means that the surface of the fixing means which comes into contact with the magnetic clamping apparatus is substantially planar. This has the advantage that a good force transmission can be ensured between the magnetic clamping apparatus and the fixing means.

The fixing means can furthermore be attached to at least one outer side of the guide rail. A direct force transmission is hereby likewise made possible between the magnetic clamping apparatus and the fixing means.

- 5 The fixing means can define a contact plane spaced apart from the outer side of the guide rail. This contact plane can be used for the definition of the position of the guide rail with respect to a reference system of the magnetic clamping apparatus to enable a precise, computer-controlled machining of the guide rail.
- 10 The contact plane – whether spaced apart from the outer side of the guide rail or aligned therewith – is in particular also decisive for the correct positioning of the rail in the final assembled state of the rail.

- In accordance with an embodiment, a respective at least one fixing means is
- 15 provided at two outer sides of the guide rail which are in particular arranged inclined with respect to one another. This has the advantage that – with a suitable configuration of the magnetic clamping apparatus – the guide rail can be reliably fixed in two different dimensions. The fixing means can, for example, be provided at outer sides of the guide rail disposed perpendicular with respect to one another
- 20 for a simple positioning of the guide rail.

To prevent an unwanted movement of the slide transversely to the direction of travel, the guide rail can engage around the slide at least partly from the outside or the slide can engage around the guide rail at least partly from the outside.

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At least one fixing means can be let into a groove which is preferably trapezoidal to establish a reliable connection, in particular a shape-matched connection, between the fixing means and the light metal base body.

To enable a high magnetic force of attraction by the magnetic clamping apparatus, the fixing means can be formed from a ferromagnetic or ferrimagnetic material, preferably steel or iron.

- 5 If the fixing means is arranged such that it at least partly forms a contact surface or assembly surface in a final assembled state, the use of steel is accompanied by the advantage of a robust, precise and reliable connectability of the rail to the components bearing it.
- 10 The bearing can comprise at least one roller element bearing, in particular in the manner of a ball guide, which cooperates with the guide surface of the guide element for the elimination of friction between the guide rail and the slide.

- The slide can have at least one guide part which is disposed opposite the guide element of a corresponding guide rail for a more precise guidance of the slide.
- 15 Such a guide part can be introduced into a groove, in particular a trapezoidal groove, of the slide by rolling in or by adhesive bonding. The guide element can be integrated into the guide rail in a similar manner. The guide part can, however, alternatively also be formed integrally at the slide. The integral manner of
- 20 construction has the advantage that no additional machining step is necessary to introduce the guide part into the groove of the slide. The same applies analogously to the guide element which can be formed in one piece with the light metal base body of the guide rail.

- 25 The invention also relates, as described above, to a method of machining a transfer system for the transport of objects. The method in accordance with the invention comprises the steps:
- providing a guide rail which comprises a light metal body and a magnetic fixing means which enables a temporary fastening of the guide rail by means of a
- 30 magnetic clamping apparatus; fixing the guide rail in or at a machining apparatus

by means of the magnetic clamping apparatus; machining the guide rail, in particular a guide element provided for supporting a slide at the guide rail; and releasing the guide rail. This method has the advantage that a simple, tension-free clamping of the guide rail and thus a precise machining of the guide rail in a well-defined state is possible. After machining, the rail can also be released fast, whereby the process time which is required for machining the guide element can be reduced.

The machining can in this respect comprise grinding a guide surface of the guide element. Other machining or processing steps are, however, also possible such as drilling of holes, thread cutting, milling a groove, welding on or casting on a part, coating a surface or similar machining or processing steps.

The machining can alternatively or additionally comprise an introduction of the guide element. The guide element can, for example, be introduced into the light metal base body by rolling in or by adhesive bonding.

The fixing of the guide rail can be carried out by means of one or more electromagnets of the magnetic clamping apparatus. This has the advantage that the magnetic clamping apparatus can be switched on and off in a simple manner. Alternatively or additionally, the fixing of the guide rail can be carried out by means of a permanent magnet, whereby a connection to the grid is no longer necessary on the sole use of permanent magnets.

The invention will be described in the following using purely exemplary embodiments and with reference to the enclosed drawings. There are shown:

Fig. 1 a sectional view of a first embodiment of the transfer system in accordance with the invention;

- Fig. 2 a sectional view of a guide rail in accordance with a second embodiment;
- Fig. 3 a sectional view of a guide rail in accordance with a third embodiment;
- Fig. 4 a sectional view of a guide rail in accordance with a fourth embodiment; and
- Fig. 5 a flowchart of an embodiment of the method in accordance with the invention for machining a transfer system.

Figures 1 to 4 show different embodiments of a guide rail 10 that are equipped with a fixing means 12 for fixing the guide rail 10 to a magnetic clamping apparatus, not shown. The guide rails 10 are furthermore each equipped with two guide elements 14 which each have a guide surface 16. Each fixing means 12 and each guide element 14 is attached to a light metal base body 18 which is not magnetic.

Fig. 1 shows an embodiment in which the guide rail 10 has a U shape and engages around a slide 20 partly from the outside. The slide 20 on which the object to be transported is arranged is linearly displaceably supported at the guide rail 10 by means of a bearing 22. The bearing 22 comprises a plurality of roller elements 24 which are arranged between the guide element 14 at the guide rail side and a guide part 26 at the slide side and which are in contact with the guide surface 16. The guide element 14, the guide part 26 and the fixing means 12 are let into trapezoidal grooves, which are shaped in the light metal base body 18 or in the slide 20, and are thus fixed in a shape-matched manner.

The fixing means 12 have a height H that is greater than the depth T of the respective groove. The fixing means 12 thereby project out of the guide rail 10. If a plurality of fixing means 12 are attached to a surface, their exposed surfaces lie in one plane. As can be seen in Fig. 1, an additional fixing means 12 can be attached
5 at the side to ensure a more precise positioning of the guide rail 10 on a magnetic clamping apparatus, not shown.

Countersinks 28 are furthermore present in the guide rail 10 to screw the guide rail 10, for example, tightly to a rack, not shown, on site.

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The embodiments of the guide rail 10 shown in Figures 2 to 4 are engaged around from the outside by a slide, not shown. The guide elements 14 for this purpose lie on oppositely disposed outer surfaces of the guide rail 10. These embodiments essentially differ from one another by the cross-sectional shape of the guide
15 elements 14. Whereas the guide element 14 shown in Fig. 2 has a trapezoidal base shape having a cut-out for the reception of roller elements 24, the guide elements 14 of the embodiments shown in Figs. 3 and 4 have a substantially circular base shape. Chamfers (Fig. 3) or notches (Fig. 4) can be shaped at the substantially circular profile for the guiding of roller elements 24.

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Fig. 5 shows a flowchart for a method of machining a transfer system for the transport of objects. In a first step, a guide rail 10 is provided. The guide rail 10 comprises a light metal base body 18 and a magnetic fixing means 12. The fixing means 12 makes it possible to temporarily fasten, i.e. to fix, the guide rail 10 by
25 means of a magnetic clamping apparatus, not shown. In a second step, the guide rail 10 is fixed in or at a machining apparatus by means of the magnetic clamping apparatus. A magnetic field is generated for this purpose, for example by one or more magnets, in particular electromagnets, which cooperates with the magnetic fixing means 12 and provides a firm, force-transmitting connection between a
30 machining apparatus and the guide rail 10.

The guide rail 10 is subsequently machined in a third step. This step can comprise the introduction of a guide element 14, the grinding of a guide surface 16 of the guide element 14 as well as additional and/or alternative machining steps. On completion of the machining, the guide rail 10 is released from the machining apparatus again by a deactivation of the magnetic clamping apparatus, for example by switching off the electromagnet(s). Another section of the guide rail 10 or another component can now be machined.

- 10 It is possible by the method described above to machine the guide rail 10 without it being tensioned or even deformed by spot loads such as occur with compound linear guides clamped in a known manner. If the guide rail 10 is subsequently installed in a transfer system, it is ensured that it is aligned exactly as it was during the machining. This is in particular of importance if the step of machining
- 15 comprises the machining of the guide element 14, in particular of the guide surface 16. The exactly fitting installation of the guide rail 10 is therefore ultimately substantially simplified. A readjustment of the rail 10 is as a rule no longer necessary on the assembly.
- 20 Whereas the machining of a guide rail 10 and a subsequent attachment of the guide rail 10 to a transfer system is described here, it is also conceivable to machine a total module, comprising a plurality of guide rails 10 connected to one another, with the aid of the described method.
- 25 It can therefore be stated in summary that it is inter alia ensured by the tension-free or twist-free temporary fastening of the guide rail 10, which is made possible by the at least one magnetic fixing means 12, that the at least one guide surface 16 is in the same position or at least in a well-defined position with respect to a reference surface or a reference system in both a machining state and a state of

use. The machining of the guide rail 10 is thereby substantially simplified and the precision of the components decisive for the guiding of the slide 20 is increased.

Reference numeral list

	10	guide rail
	12	fixing means
5	14	guide element
	16	guide surface
	18	light metal base body
	20	slide
	22	bearing
10	24	roller element
	26	guide part
	28	countersink

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Krav**1. Transfersystem til transport af objekter, omfattende:**

en føringsskinne (10) med et letmetalbasislegeme (18) og mindst et
føringselement (14), som har en føringsflade (16) og er forbundet med
5 letmetalbasislegemet (18),

en slæde (20) til optagelse af mindst et objekt, og
et leje (22), der arbejder sammen med føringselementet (14) og lejrer
slæden (20) lineært forskydeligt på føringsskinnen (10),

kendetegnet ved, at

10 føringsskinnen (10) desuden har mindst en magnetisk holdemekanisme
(12), som muliggør en midlertidig fastgørelse af føringsskinnen (10) ved
hjælp af en magnetspændeanordning, navnlig til bearbejdning af
føringsfladen (16).

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2. Transfersystem ifølge krav 1,**kendetegnet ved, at**

holdemekanismen (12) er udført som en flade.

20 3. Transfersystem ifølge krav 1 eller 2,**kendetegnet ved, at**

holdemekanismen (12) er anbragt på i det mindste en yderside af føringsskinnen
(10).

25 4. Transfersystem ifølge krav 2,**kendetegnet ved, at**

holdemekanismen (12) definerer et anlægsplan med afstand til ydersiden af
føringsskinnen (10).

5. Transfersystem ifølge i det mindste et af de foregående krav,

kendetegnet ved, at

der mindst er tilvejebragt en holdemekanisme (12) på hver af to ydersider af

5

føringsskinnen (10), som navnlig er anbragt på hældende mod hinanden.

6. Transfersystem ifølge i det mindste et af de foregående krav,

10 **kendetegnet ved, at**

føringsskinnen (10) omslutter slæden (20) i det mindste delvist udefra, eller at slæden (20) omslutter føringsskinnen (10) i det mindste delvist udefra.

7. Transfersystem ifølge i det mindste et af de foregående krav,

15 **kendetegnet ved, at**

mindst en holdemekanisme (12) er forsænket i en not, som fortrinsvis er trapezformet.

8. Transfersystem ifølge i det mindste et af de foregående krav,

20 **kendetegnet ved, at**

holdemekanismen (12) er udført i et ferromagnetisk eller ferrimagnetisk materiale, fortrinsvis stål eller jern.

9. Transfersystem ifølge i det mindste et af de foregående krav,

25 **kendetegnet ved, at**

lejet (22) omfatter mindst et rulleleje, navnlig udført som en kugleføring.

10. Fremgangsmåde til bearbejdning af et transfersystem til transport af objekter, ifølge i det mindste et af de foregående krav, omfattende:

tilvejebringelse af en føringsskinne (10), som omfatter et
letmetalbasislegeme (18) og en magnetisk holdemekanisme (12), som
muliggør en midlertidig fastgørelse af føringsskinnen (10) ved hjælp af en
magnetspændeanordning,

- 5 fastholdelse af føringsskinnen (10) i eller på en bearbejdningsindretning ved
hjælp af magnetspændeanordningen,
bearbejdning af føringsskinnen (10), navnlig af et føringselement (14) til
lejring af en slæde (20) på føringsskinnen (10), og
løsning af føringsskinnen (10).

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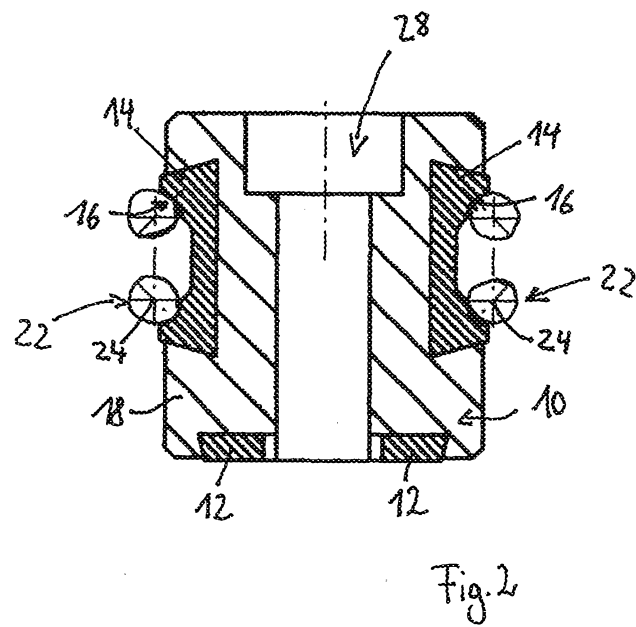
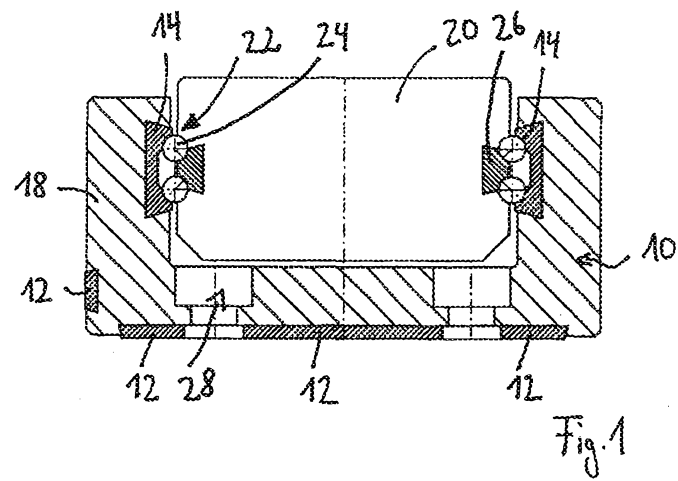
11. Fremgangsmåde ifølge krav 10,
hvor bearbejdningen omfatter slibning af en føringsflade (16) på føringselementet
(14).

15

12. Fremgangsmåde ifølge krav 10 eller 11,
hvor bearbejdningen omfatter indsættelse af føringselementet (14) i
føringsskinnen (10), navnlig ved indvalsning eller indlimning.

- 20 **13.** Fremgangsmåde ifølge krav 10, 11 eller 12,
hvor fastholdelsen af føringsskinnen (10) sker ved hjælp af en elektromagnet på
magnetspændeanordningen.

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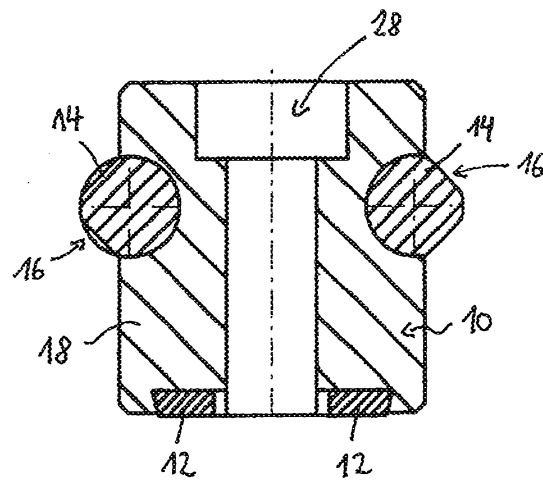


Fig. 3

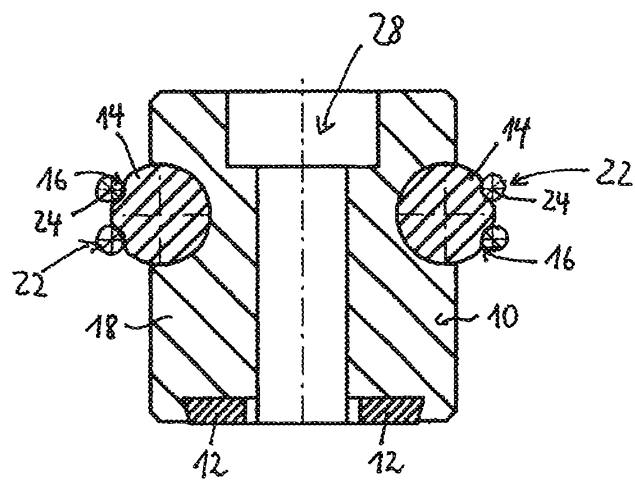


Fig. 4

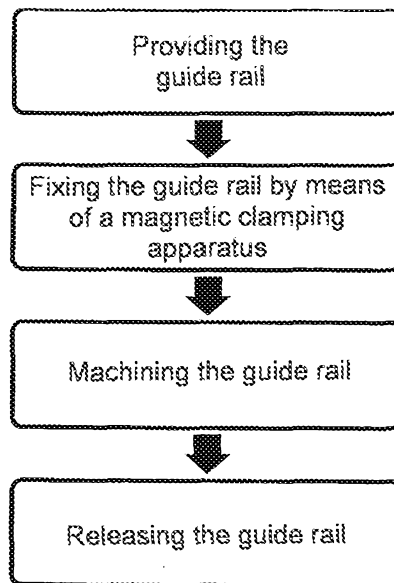


Fig. 5