

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
20 February 2003 (20.02.2003)

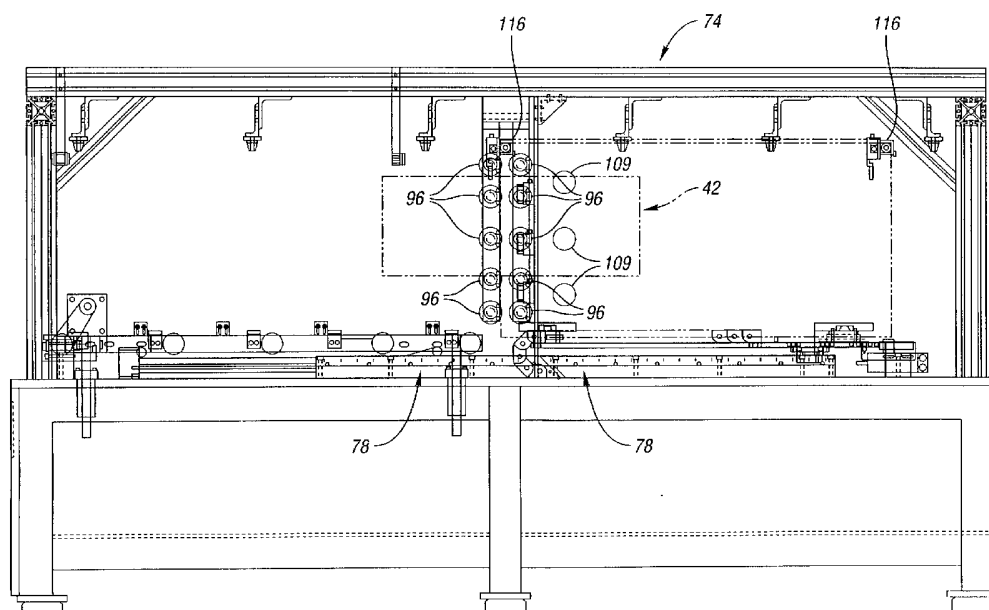
PCT

(10) International Publication Number
WO 03/013778 A1

- (51) International Patent Classification⁷: **B23K 26/00**, 26/14, 26/16, 26/18 (72) Inventor: **HARJU, Ricky, S.** (deceased).
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- (22) International Filing Date: 7 August 2002 (07.08.2002)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data:
09/928,203 10 August 2001 (10.08.2001) US (74) Agent: **FOX, Harold, H.**; Fish & Richardson P.C., 11th Floor, 1425 K Street, NW, Washington, DC 20005-3500 (US).
- (63) Related by continuation (CON) or continuation-in-part (CIP) to earlier application:
US 09/928,203 (CON)
Filed on 10 August 2001 (10.08.2001)
- (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.
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[Continued on next page]

(54) Title: METHOD AND APPARATUS FOR LASER SCRIBING GLASS SHEET SUBSTRATE COATINGS



(57) Abstract: A method and apparatus (42) for laser scribing coatings on glass sheet substrates by conveying the substrate adjacent a laser source (83) that provides a pulsed laser beam (84) with a wavelength at a near-infrared fundamental frequency and having a frequency of at least 50 kilohertz and a pulse duration of at least 8 nanoseconds, and by reflecting the beam by an XYZ galvanometer controlled mirror system (90) toward an uncoated surface of the substrate for passage therethrough to the coating on the other surface to provide overlapping ablations through the coating and scribing at a speed of at least 1000 millimeters per second.



(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).

— *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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Published:

— *with international search report*

METHOD AND APPARATUS FOR LASER SCRIBING GLASS SHEET SUBSTRATE COATINGS

TECHNICAL FIELD

This invention relates to a method and an apparatus for laser scribing of coated
5 layers on glass sheet substrates.

BACKGROUND

Laser scribing of coated layers on glass sheet substrates has been done for
many years as disclosed by United States Patent 4,292,092 Hanak. To a large extent,
the laser scribing is performed by a laser beam that is directed from the coated side of
10 the substrate; however, the scribing has also been performed by directing the laser
beam through the glass sheet substrate to the coated layers to be scribed such as
disclosed by United States Patent 4,568,409 Caplan, 4,854,974 Carlson et al.,
4,892,592 Dickson et al., 5,296,674 Praschek et al., and 5,593,901 Oswald et al.

Traditional laser processing systems are of two types. One type includes a
15 fixed laser head mounted over a movable XY table (two axis) on which the coated
glass sheet is supported for the scribing, while the other type includes a single axis
movable laser scanning head mounted over a single axis movable table. The major
drawback of the first type is the speed limitation of large XY tables, which is
generally in the range of about 300 to 500 millimeters per second. Thus, in order to
20 achieve commercially practical output, it is necessary to use multiple lasers or split
beams to feed several laser nozzles. In addition to being expensive, such systems
require maintaining optical alignment which is difficult and also require that the
power to each nozzle be independently controlled. In addition, it is imperative to
have real time spacing and adjustment between nozzles to facilitate the spacing
25 between scribes. The other system also has the same problems since it is difficult to
move the laser head faster than about 700 to 800 millimeters per second.

Other laser scribing patents noted during an investigation conducted in
connection with the present application include United States Patents 4,603,470
Yamazaki, 4,689,874 Nishiura, and 5,956,572 Kidoguchi et al.

SUMMARY

An object of the present invention is to provide an improved method for laser scribing glass sheet substrate coatings at a relatively high speed so as to thereby provide a cost effective product.

5 In carrying out the above object, the method for laser scribing is performed with a glass sheet substrate having oppositely facing surfaces one of which is uncoated and the other of which is coated. The coated substrate is conveyed along a direction of conveyance adjacent a laser source that provides a pulsed laser beam with a wavelength at a near-infrared fundamental frequency and having a pulse frequency
10 in the range of 50 to 100 kilohertz and a pulse duration in the range of 8 to 70 nanoseconds. The pulsed laser beam is reflected from the laser source by an XYZ galvanometer controlled mirror system toward the uncoated surface of the glass sheet substrate for passage therethrough to the coating on the other surface to provide overlapping ablations through the coating and scribing thereof at a speed of at least
15 1000 millimeters per second.

The glass sheet substrate is conveyed in a vertical orientation and is positioned laterally with respect to the direction of conveyance by gas pressure and vacuum positioners located upstream and downstream along the direction of conveyance from the location at which the pulsed laser beam passes through the substrate such that the
20 positioners control the planarity of the substrate. The gas pressure and vacuum positioners position the glass sheet substrate at its uncoated surface so there is no degradation of the coated surface.

Laser detectors detect the exact position of the coated substrate so the scribing laser beam can be properly focused.

25 In one practice of the method, the conveyance of the coated glass sheet substrate is provided by indexing thereof with the substrate being held stationary during the laser scribing.

In another practice of the method, the laser scribing is performed as the coated glass sheet substrate is conveyed.

In performing the laser scribing method, the coated glass sheet substrate is disclosed as having a plurality of different coated layers and a plurality of the laser scribes are made at different power levels so the scribes extend through different layers. More specifically, in the most rapid performance of the laser scribing method, a plurality of laser sources and associated XYZ galvanometer controlled mirror systems respectively provide the pulsed laser scribing of the different scribes at different power levels, each with a wavelength at a near-infrared fundamental frequency and with pulse frequencies in the range of 50 to 100 kilohertz and pulse durations in the range of 8 to 70 nanoseconds and at scribing speeds of at least 1000 millimeters per second.

Another object of the present invention is to provide improved apparatus for laser scribing a coating on a glass sheet substrate.

In carrying out the immediately preceding object, the apparatus of the invention includes a conveyor for conveying a glass sheet substrate along a direction of conveyance with the substrate having oppositely facing surfaces one of which is uncoated and the other of which has a coating. A laser source provides a pulsed laser beam with a wavelength at a near-infrared fundamental frequency and having a pulse frequency in the range of 50 to 100 kilohertz and a pulse duration in the range of 8 to 70 nanoseconds. An XYZ galvanometer controlled mirror system reflects the pulsed laser beam from the laser source toward the uncoated surface of the glass sheet substrate for passage therethrough to the coating on the other surface to provide overlapping ablations through the coating and scribing thereof at a speed of at least 1000 millimeters per second.

The apparatus supports the substrate in a vertical orientation and includes gas pressure and vacuum positioners located upstream and downstream along the direction of conveyance from the location at which the pulsed laser beam passes through the substrate such that the positioners control the planarity of the substrate during the laser scribing.

The apparatus includes laser detectors that detect the exact position of the coated substrate so the scribing laser beam can be properly focused.

The apparatus disclosed includes a plurality of the pulsed laser sources that operate at different power levels, each with a wavelength at a near-infrared fundamental frequency and with a pulse frequency in the range of 50 to 100 kilohertz and a pulse duration in the range of 8 to 70 nanoseconds, and a plurality of XYZ
5 galvanometer controlled laser mirror systems of the apparatus respectively reflect the pulsed laser beams from the laser sources to provide scribing at speeds of at least 1000 millimeters per second.

The details of one or more embodiments of the invention are set forth in the accompanying drawings and the description below. Other features, objects, and
10 advantages of the invention will be apparent from the description and drawings, and from the claims.

DESCRIPTION OF DRAWINGS

FIGURE 1 is a schematic view of various stations of a photovoltaic panel manufacturing system that includes laser scribing apparatus constructed in accordance
15 with the present invention to perform the method of the invention.

FIGURE 2 is a plan view of a photovoltaic panel that has been scribed to provide separate cells.

FIGURE 3 is a sectional view taken through a glass sheet substrate which has coated layers thereon to be scribed to provide the photovoltaic panel.

20 FIGURE 4 is a sectional view similar to Figure 3 illustrating the panel after first and second scribes have been made.

FIGURE 5 is a sectional view similar to Figure 4 illustrating the panel at a later stage after a third scribe has been made.

FIGURE 6 is a schematic view that illustrates the manner in which the
25 scribing is performed.

FIGURE 7 is a view taken in the direction of line 7-7 in Figure 6 to illustrate the construction of positioners utilized to locate the glass sheet substrate during the scribing.

FIGURE 8 is a side elevational view illustrating the laser scribing stations, each of which has a right loading end, a center laser scribing module, and a left unloading end.

FIGURE 9 is a top plan view taken at an enlarged scale along the direction of line 9-9 in Figure 8 to illustrate the laser scribing module.

FIGURE 10 is a side elevational view taken along the direction of line 10-10 in Figure 9 to illustrate the laser scribing module at an enlarged scale from that shown in Figure 8.

FIGURE 11 is a schematic view illustrating the manner in which overlapping ablations through a coating on the substrate perform laser scribing.

FIGURE 12 is a view illustrating one way in which the laser scribing proceeds by conveying indexes with the laser scribing performed as the coated glass sheet substrate is held stationary.

FIGURE 13 is a view of another way in which the laser scribing proceeds by continuously moving the coated glass sheet substrate and moving the laser beam angularly along the direction of conveyance.

DETAILED DESCRIPTION

With reference to Figures 1, 2 and 3 of the drawings, a system 20 includes certain illustrated stations utilized in manufacturing of a photovoltaic panel 22. The panel 22 is manufactured using a glass sheet substrate 24 which is shown in Figure 3 as having one surface coated with a tin oxide layer 26. After washing and cleaning of the tin oxide coated glass substrate 24, a cadmium sulfide layer 28 about 3000 angstroms thick is deposited at a first station 30. The manufacturing proceeds as the glass sheet substrate is conveyed along a direction of conveyance illustrated by arrow C to a second station 32 where a cadmium telluride layer 34 about 3 microns thick is deposited prior to movement through treating stations 36 and 38. After subsequent conveyance of the substrate to a first scribing station 40, pulsed laser scribing apparatus 42_a provides scribing of a first set of scribes 44, in a manner performed in accordance with the present invention as is hereinafter more fully described, through

the tin oxide layer 26, the cadmium sulfide layer 28 and the cadmium telluride layer 34. After scribing the first set of scribes 44, the substrate is then conveyed to a station 46 where the first set of scribes 44 are filled with a dielectric material 48, whereupon the substrate is conveyed to a second scribing station 50 where pulsed laser scribing apparatus 42_b constructed in accordance with the invention operates at a lower power level than the first scribing station to provide scribing of a second set of scribes 52 through the cadmium sulfide layer 28 and the cadmium telluride layer 34 without scribing the tin oxide layer 26. The substrate is then conveyed to a coating station 54 where an electrically conductive back contact layer 56 (Figure 5) is applied prior to movement to a treatment station 58. The substrate is then conveyed to a third scribing station 60 where scribing apparatus 42_c constructed in accordance with this invention operates at a lower power level than the second scribing station to provide a third set of scribes 62 through the back contact layer 56 in order to provide separate cells 64 that are electrically connected to each other in series. Electrical connectors 65 shown in Figure 2 provide electrical connection of the panel for use.

The deposition of the cadmium sulfide at station 30 illustrated in Figure 1 and the deposition of the cadmium telluride at station 32 may be performed in accordance with the disclosures of United States Patents 5,248,349 Foote et al., 5,372,646 Foote et al., 5,470,397 Foote et al., 5,536,333 Foote et al., 5,934,163 Powell et al., and 6,037,241 Powell et al., the entire disclosures of which are hereby incorporated by reference.

The photovoltaic panel 22 shown in Figure 2 has an elongated shape with a width of about 60 centimeters (600 millimeters) between its opposite sides 66 and a length of about 120 centimeters between its opposite ends 68. Furthermore, the scribing described above provides 115 of the cells 64 such that the available space for each cell including the associated scribes is just slightly more than one centimeter. Each set of scribes for providing the 115 cells of the panel thus has a total length of about 69,000 millimeters. In order to perform economical manufacturing where the panels can be made in about a minute or so, the laser apparatus must have a scribing speed of about 1000 millimeters per second or greater. In actuality, the scribing

apparatus of the invention as is hereinafter more fully described has a scribe speed of 2000 to 3000 millimeters per second to allow for transfer time between stations.

While it is possible to utilize a single laser apparatus to do each set of scribes, provision of the laser scribing apparatus 42_a, 42_b, and 42_c at each of the three scribing stations as illustrated in Figure 1 provides a higher rate of operation and a consequently more cost efficient product.

The method for laser scribing coated glass sheet substrates will be described in connection with the laser scribing apparatus 42 in an integrated manner to facilitate an understanding of all aspects of the invention. This laser scribing apparatus 42 is illustrated in Figures 6-10 and as specifically illustrated in Figure 8 includes a right loading end 70, a left unloading end 72, and a central laser scribing module 74. The coated glass sheet substrate to be scribed is conveyed in a vertically extending orientation toward the left from the loading end 70 to the laser scribing module 74 for the laser scribing and is subsequently conveyed toward the left to the unloading end 72 in preparation for delivery to the next station. The conveyance from the loading end 70 is provided on a loading cart 76 and the glass sheet is received by a laser scribing conveyor 78 best shown in Figure 10 for accurately controlled conveyance during the laser scribing operation. After the laser scribing as is hereinafter more fully described, the scribed glass sheet substrate is delivered from the laser scribing conveyor 78 to an unloading cart 80 of the unloading station 72 shown in Figure 8. The conveyor 78 conveys the glass sheet substrate 24 which as illustrated in Figure 6 has an uncoated surface 81 and a coated surface 82 on which the tin oxide, cadmium sulfide and cadmium telluride layers are located such that this would correspond to scribing at the first scribing station 40 illustrated in Figure 1 prior to application of the back contact layer previously described. The scribing is performed by directing a laser beam through the glass sheet substrate 24 from its uncoated surface 81 to its coated surface 82 and through to the different layers for the scribing, with the layers scribed being controlled by the power level of the laser for each of the scribes.

As best illustrated in Figure 9, the laser scribing apparatus 42 includes a laser source 83 that provides the pulsed laser beam 84 with a wavelength at a near-infrared

fundamental frequency and having a pulse frequency in the range of 50 to 100 kilohertz and a pulse duration in the range of 8 to 70 nanoseconds. The specific laser source 83 utilized is a diode-pumped, Q-switched, neodymium-doped, yttrium vanadate laser source providing a pulsed laser beam with a wavelength at its near-
5 infrared fundamental frequency of 1064 nanometers and operating at a pulse frequency in the range of 50 to 100 kilohertz with the pulse duration in the range of 8 to 70 nanoseconds. The pulsed laser beam is reflected by mirrors 86 and 88 to an XYZ galvanometer controlled mirror system collectively indicated by 90 that directs the laser beam to perform the scribing. More specifically, the XYZ galvanometer
10 controlled mirror system 90 includes a galvanometer controlled focuser 92 that moves a lens horizontally to control the focal length of the beam in the Z direction and a galvanometer controlled dual mirror assembly 94 that directs the beam in the XY directions so as to thereby collectively provide XYZ control.

By laser scribing of the scribes from the uncoated surface 81 of the glass sheet substrate 24 shown in Figure 6, there is no gas plume formed by the ablations that
15 provide the scribing such that the plumes cannot prevent the next laser pulses from passing through the coatings to provide each next ablation. More specifically, the scribing as shown in Figure 11 is performed with the ablations 95 overlapping each other. An overlap of 50% provides a generally uniform scribe width and a fast scribe
20 speed. The ablations 95 thus provide a scribe such as the first scribe 44 illustrated in Figure 11, and the second and third scribes are also provided in the same way.

With continuing reference to Figure 6 and additional reference to Figure 10, the laser scribing apparatus 42 includes gas pressure and vacuum positioners 96 that maintain the glass sheet substrate planar at its uncoated surface 81 and position the
25 substrate laterally with respect to the direction of conveyance so the focused pulsed laser beam has its focus in the Z direction at the layer or layers being scribed. These positioners 96 are located in vertically extending sets both upstream and downstream of the location where the laser beam 84 passes through the glass sheet substrate to provide the laser scribing. More specifically as illustrated in Figure 10, there are five
30 of the positioners 96 upstream of the scribing location and five of the positioners

downstream of the scribing location. As illustrated in Figures 6 and 7, each of the positioners 96 has a central location 98 to which a vacuum is applied from a vacuum source 100 through an associated conduit 102. An annular porous member 104 of each positioners 96 extends around the central location 98 and receives pressurized
5 gas from a gas source 106 through an associated conduit 108. The positioners 96 position the uncoated glass sheet surface 81 within about 4-6 microns so as to provide an accurate location for the laser beam focusing and the ablations at the layer or layers being scribed.

As shown in Figures 6, 8 and 10, laser detectors 109 located upstream from
10 the scribing location provide laser detection beams 109_a (Figure 6) that are reflected back from the uncoated glass surface 81 to detect the exact position of the glass substrate and through connection to the focuser of the galvanometer mirror system 90 focuses the pulsed scribing laser beam 84 in response to the position detected
15 throughout the range of movement and scribing of the scribing laser beam. This detection accommodates for any nonplanarity of the glass sheet substrate such as roller waves formed when the glass is manufactured.

Two different ways in which the laser scribing can be performed are respectively illustrated in Figures 12 and 13. In Figure 12, the laser scribing station conveyor provides a conveying index 110 between each laser scribe 112 during which
20 the coated substrate is held stationary such that the laser beam moves vertically to perform the scribing, after first having been adjusted horizontally to provide the proper spacing between the previously formed adjacent scribe. As illustrated in Figure 13, it is also possible for the coated glass sheet substrate to be continuously conveyed along the direction of conveyance C and the path of the laser scribes 114 is
25 then angular both along the direction of conveyance and with respect to a true vertical direction, and after the completion of each scribe, there is a reset motion 115 of the galvanometer controlled mirror system such that the complete pass as illustrated has a generally bow tie configuration.

With reference to Figure 10, prior to conveyance to the first scribing station,
30 the two upper corners of the coated glass sheet substrate are laser marked with

respective fiducials which are detected by a pair of cameras 116 so as to provide a signal for accurate location of the panel and the spacing between the fiducials so that the scribing can be accurately located. This allows adjustment as necessary for thermal expansion or contraction and for different spacings between the fiducials on
5 different substrates.

In addition, each substrate can be provided with a bar code that is sensed by a bar code reader 118 shown in Figure 9 so as to provide identification of each particular substrate being scribed. In addition, the apparatus includes an exhaust hood 120 that receives the exhaust from the coated side of the substrate being scribed. To
10 insure that the scribing is performed at the proper power level, the galvanometer controlled mirror 90 can periodically reflect the laser beam as shown at 84_a to a power meter 122 whose sensed power can then be utilized to provide any necessary adjustment of the power level from the pulsed laser source 83.

In order to provide the first, second and third sets of scribes 44, 52 and 62
15 through the different layers as described above, the average power levels of the lasers are respectively about 20 watts, 8 to 9 watts, and 4 to 5 watts.

While the best mode for carrying out the invention has been described in detail, those familiar with the art to which this invention relates will recognize various alternatives for practicing the invention as defined by the following claims.

WHAT IS CLAIMED IS:

1. A method for laser scribing comprising:
providing a glass sheet substrate having oppositely facing surfaces one of which is uncoated and the other of which has a coating;
5 conveying the coated glass sheet substrate along a direction of conveyance adjacent a laser source that provides a pulsed laser beam with a wavelength at a near-infrared fundamental frequency and having a pulse frequency of at least 50 kilohertz and a pulse duration of at least 8 nanoseconds; and
reflecting the pulsed laser beam from the laser source by an XYZ
10 galvanometer controlled mirror system toward the uncoated surface of the glass sheet substrate for passage therethrough to the coating on the other surface to provide overlapping ablations through the coating and scribing thereof at a speed of at least about 1000 millimeters per second.
2. A method for laser scribing as in claim 1 wherein the glass sheet
15 substrate is conveyed in a vertical orientation and is positioned laterally with respect to the direction of conveyance by gas pressure and vacuum positioners located upstream and downstream along the direction of conveyance from the location at which the pulsed laser beam passes through the substrate such that the positioners control the planarity of the substrate during the laser scribing.
- 20 3. A method for laser scribing as in claim 2 wherein the gas pressure and vacuum positioners position the glass sheet substrate at its uncoated surface so there is no degradation of the coated surface.
4. A method for laser scribing as in claim 2 wherein the position of the
glass sheet substrate is detected adjacent the positioners by a laser detection beam,
25 and the pulsed laser beam being focused in response to the position detected.
5. A method for laser scribing as in claim 1 wherein the conveyance of the glass sheet substrate provides indexing thereof and the substrate is held stationary during the laser scribing.

6. A method for laser scribing as in claim 1 wherein the laser scribing is performed as the glass sheet substrate is conveyed.

7. A method for laser scribing as in claim 1 wherein the glass sheet substrate has a plurality of different coated layers and a plurality of the laser scribes
5 are made at different power levels so the scribes extend through different layers.

8. A method for laser scribing as in claim 7 wherein a plurality of laser sources and associated XYZ galvanometer controlled mirrors respectively provide the pulsed laser scribing of the different scribes at different power levels, each with a wavelength at a near-infrared fundamental frequency and with pulse frequencies in
10 the range of 50 to 100 kilohertz and pulse durations in the range of 8 to 70 nanoseconds and at speeds of at least 1000 millimeters per second.

9. A method for laser scribing comprising:
providing a glass sheet substrate having oppositely facing surfaces one of which is uncoated and the other of which has a coating with different layers;
15 conveying the coated glass sheet substrate in a vertical orientation along a direction of conveyance adjacent a vanadate laser source that provides a pulsed laser beam of a selected power with a wavelength at its near-infrared fundamental frequency and having a pulse frequency of at least 50 kilohertz and a pulse duration of at least 8 nanoseconds;
20 positioning the vertically oriented substrate by gas pressure and vacuum positioners; and

reflecting the pulsed laser beam from the vanadate laser source by an XYZ galvanometer controlled mirror system toward the uncoated surface of the glass sheet substrate for passage therethrough to the coating on the other surface to provide
25 overlapping ablations through certain layers of the coating and scribing thereof at a speed of at least about 1000 millimeters per second.

10. Apparatus for laser scribing comprising:
a conveyor for conveying a glass sheet substrate along a direction of conveyance with the substrate having oppositely facing surfaces one of which is
30 uncoated and the other of which has a coating;

a laser source positioned along the direction of conveyance to provide a pulsed laser beam with a wavelength at a near-infrared fundamental frequency and having a pulse frequency of at least 50 kilohertz and a pulse duration of at least 8 nanoseconds; and

5 an XYZ galvanometer controlled mirror system for reflecting the pulsed laser beam toward the uncoated surface of the glass sheet substrate for passage therethrough to the coating on the other surface to provide overlapping ablations through the coating and scribing thereof at a speed of at least about 1000 millimeters per second.

10 11. Apparatus for laser scribing glass sheet substrates as in claim 9 further including gas pressure and vacuum positioners located upstream and downstream along the direction of conveyance from the location at which the pulsed laser beam passes through the substrate such that the positioners control the planarity and position of the substrate during the laser scribing.

15 12. Apparatus as in claim 11 further including laser detectors for determining the position of the substrate adjacent the positioners to focus the pulsed laser beam.

13. Apparatus for laser scribing glass sheet substrates as in claim 10 which includes a plurality of the pulsed laser sources that operate at different power
20 levels, each with a wavelength at a near infrared fundamental frequency and having a pulse frequency in the range of 50 to 100 kilohertz and a pulse duration in the range of 8 to 70 nanoseconds, and a plurality of XYZ galvanometer controlled laser mirror systems that respectively reflect pulsed laser beams from the laser sources to provide scribing at speeds of at least 1000 millimeters per second.

25 14. Apparatus for laser scribing comprising:
a conveyor for conveying a glass sheet substrate along a direction of conveyance with the substrate having oppositely facing surfaces one of which is uncoated and the other of which has a coating including a plurality of layers;
a plurality of vanadate laser sources spaced from each other along the
30 direction of conveyance, each vanadate laser source providing a pulsed laser beam of

a selected power with a wavelength at its near-infrared fundamental frequency and having a pulse frequency of at least 50 kilohertz and a pulse duration of at least 8 nanoseconds;

a plurality of XYZ galvanometer controlled mirror systems for
5 respectively reflecting the pulsed laser beams toward the uncoated surface of the glass sheet substrate for passage therethrough to the coating on the other surface to provide overlapping ablations through one or more layers of the coating and scribing thereof at a speed of at least about 1000 millimeters per second.

15 15. The method of claim 1, wherein the pulse frequency is in the range of 50 to 100 kilohertz and the pulse duration is in the range of 8 to 70 nanoseconds.

16. The method of claim 9, wherein the pulse frequency is in the range of 50 to 100 kilohertz and the pulse duration is in the range of 8 to 70 nanoseconds.

17. The apparatus of claim 10, wherein the pulse frequency is in the range of 50 to 100 kilohertz and the pulse duration is in the range of 8 to 70 nanoseconds.

15 18. The apparatus of claim 14, wherein the pulse frequency is in the range of 50 to 100 kilohertz and the pulse duration is in the range of 8 to 70 nanoseconds.

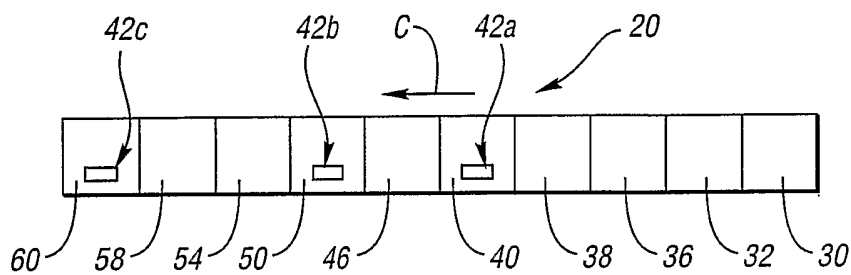


Fig. 1

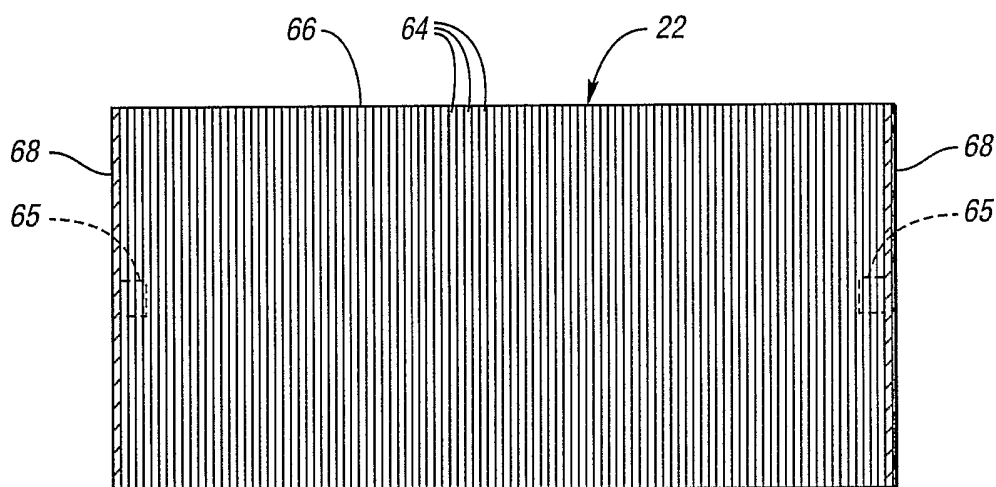


Fig. 2

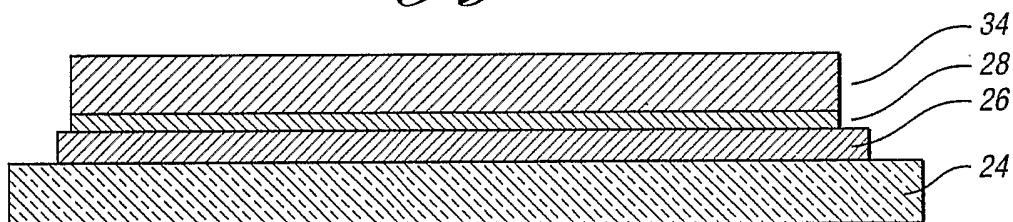


Fig. 3

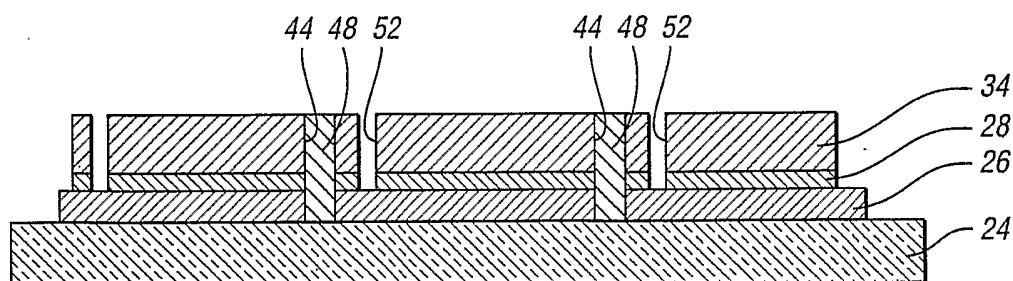


Fig. 4

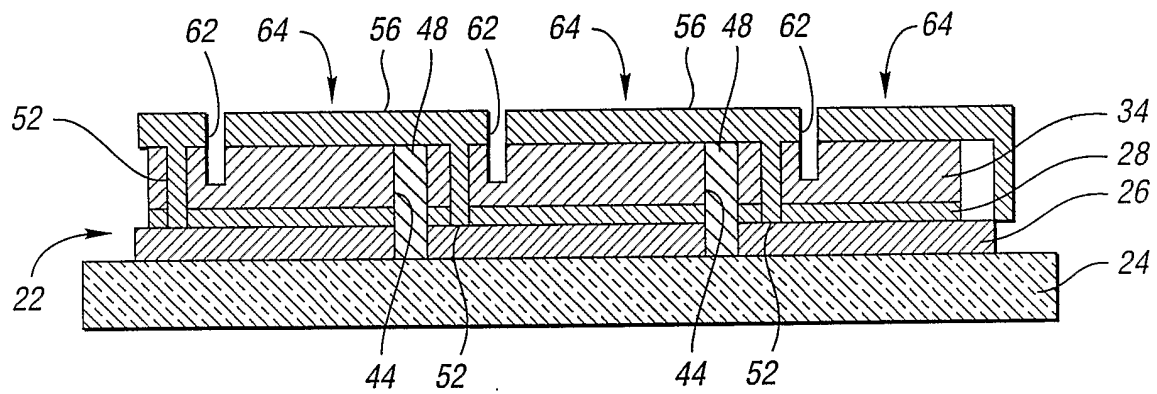


Fig. 5

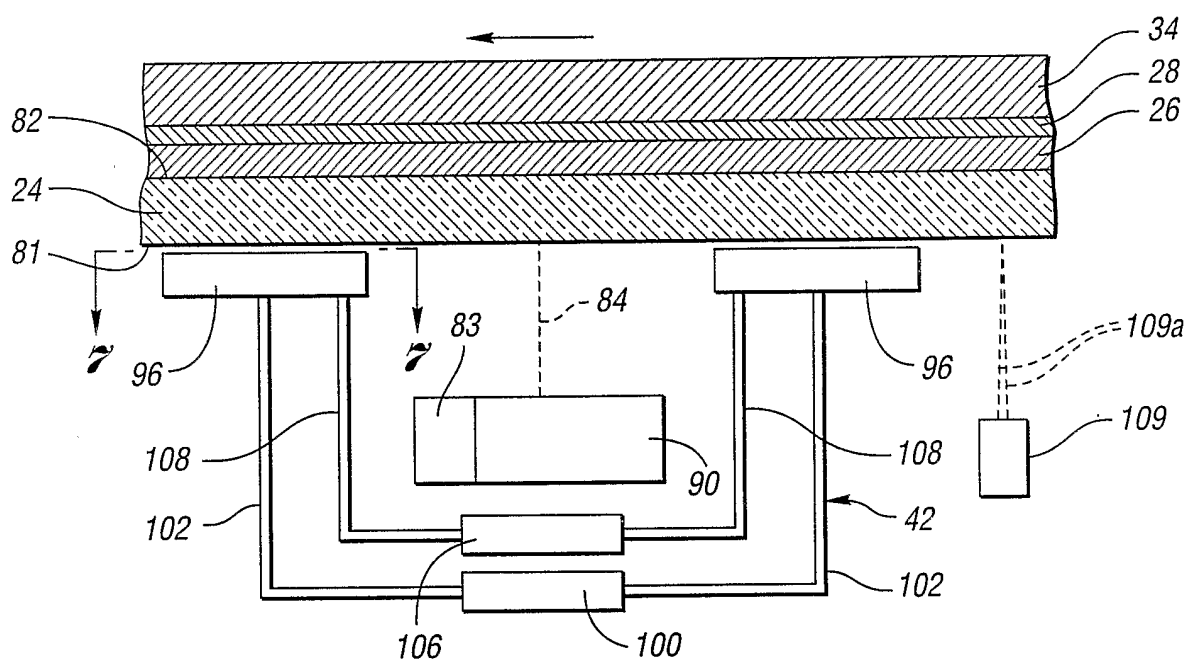


Fig. 6

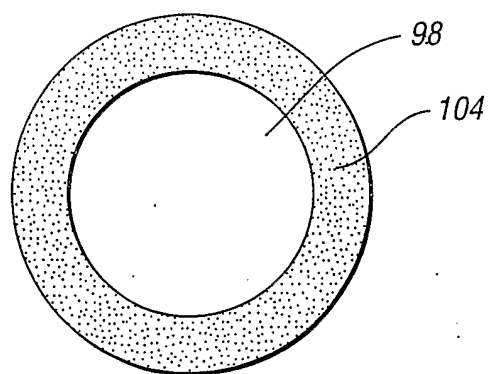


Fig. 7

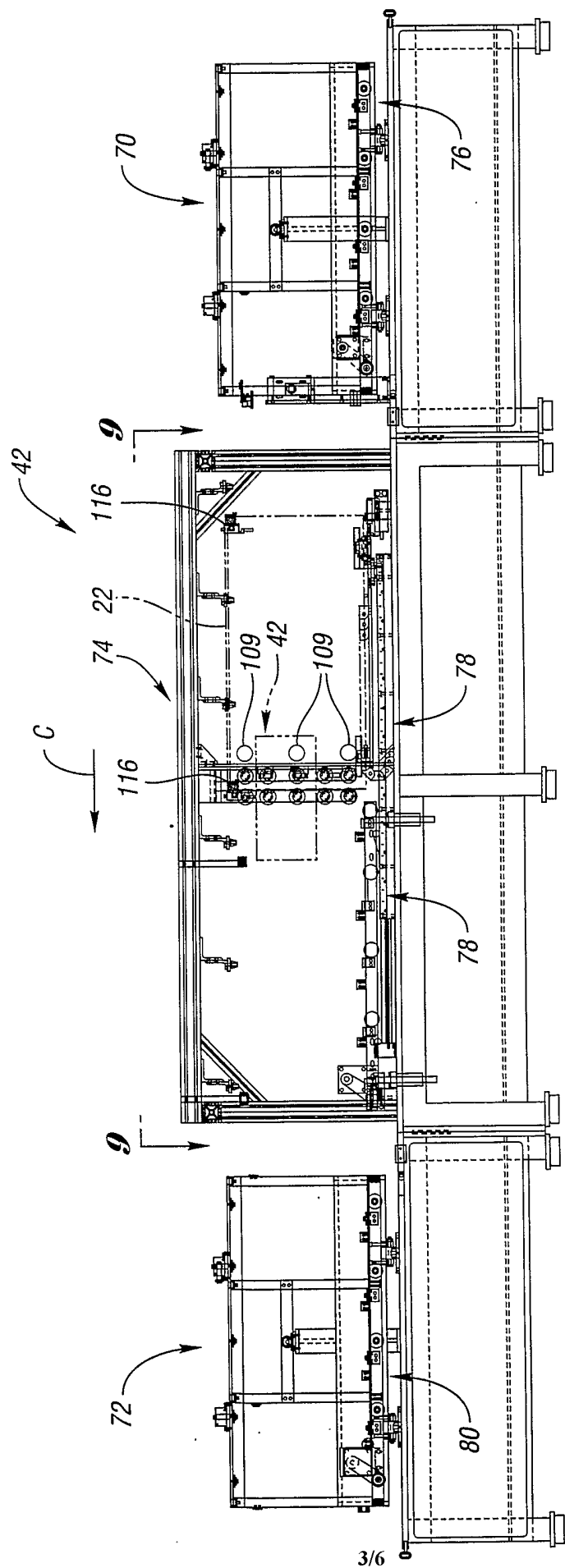


Fig. 8

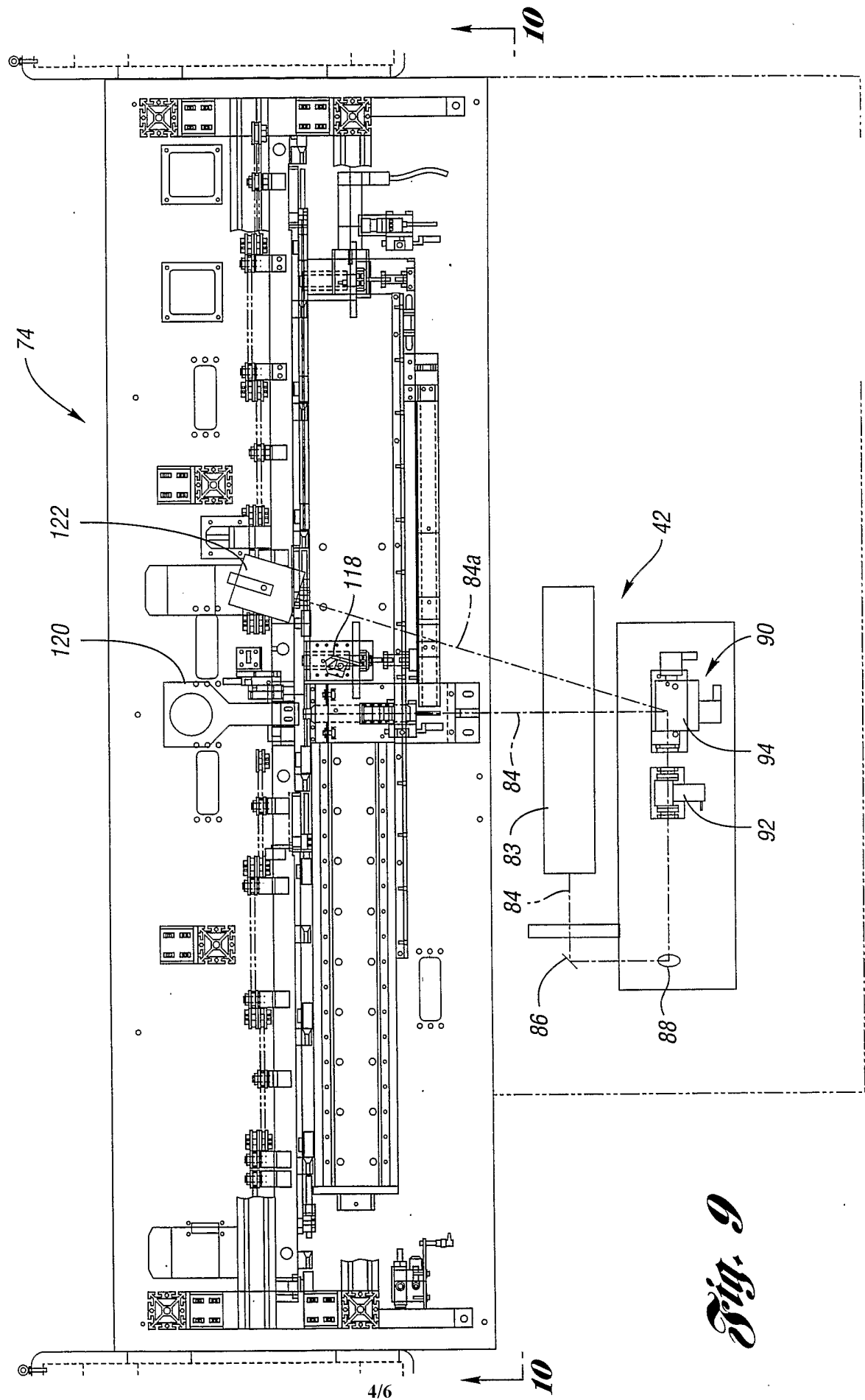


Fig. 9

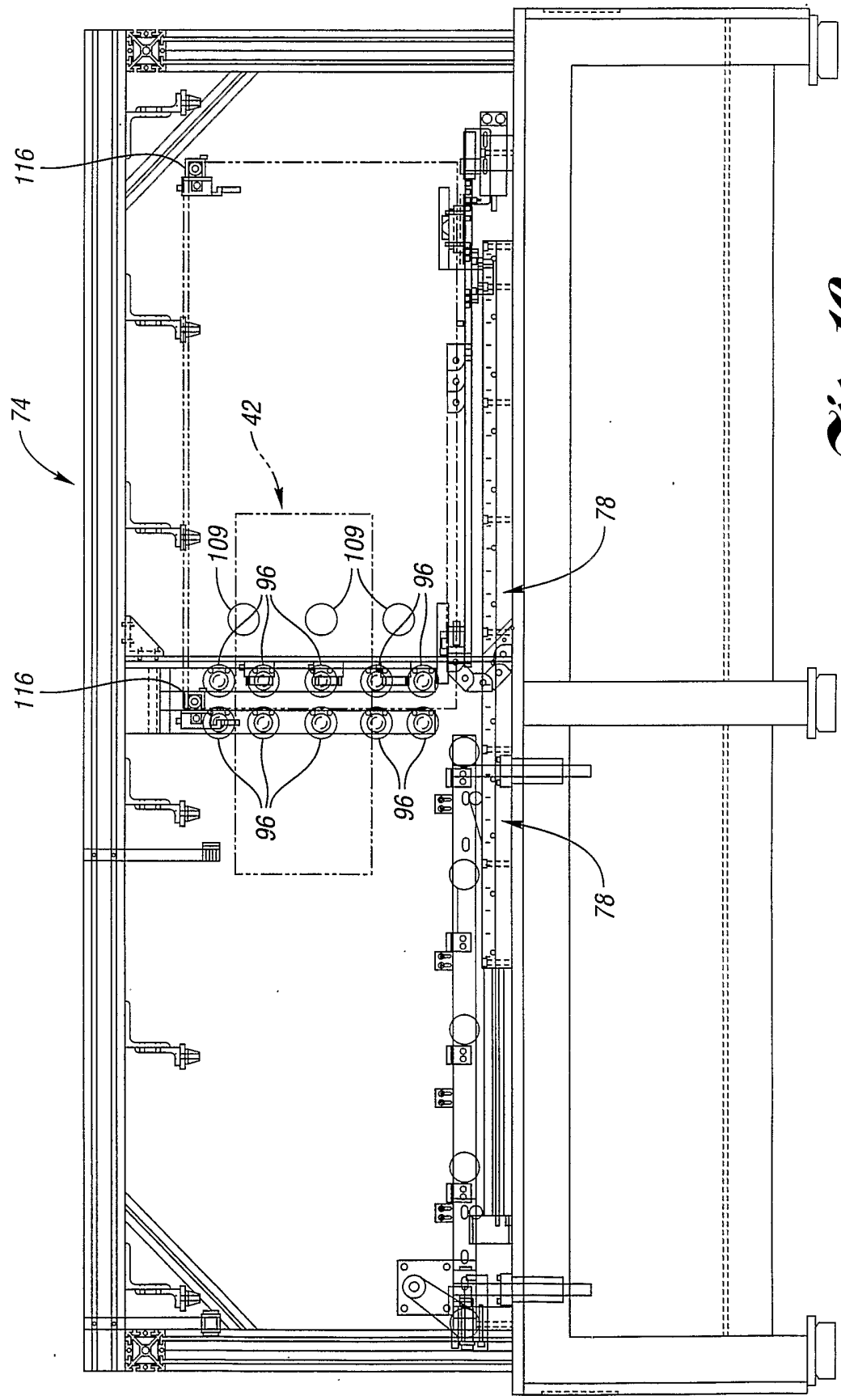


Fig. 10

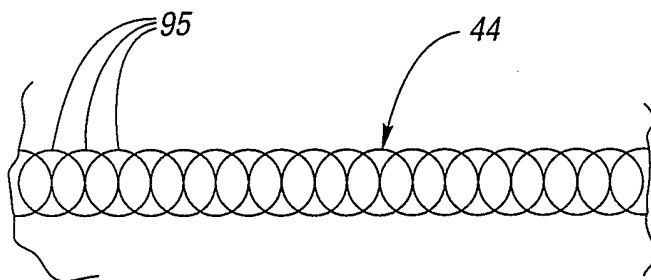


Fig. 11

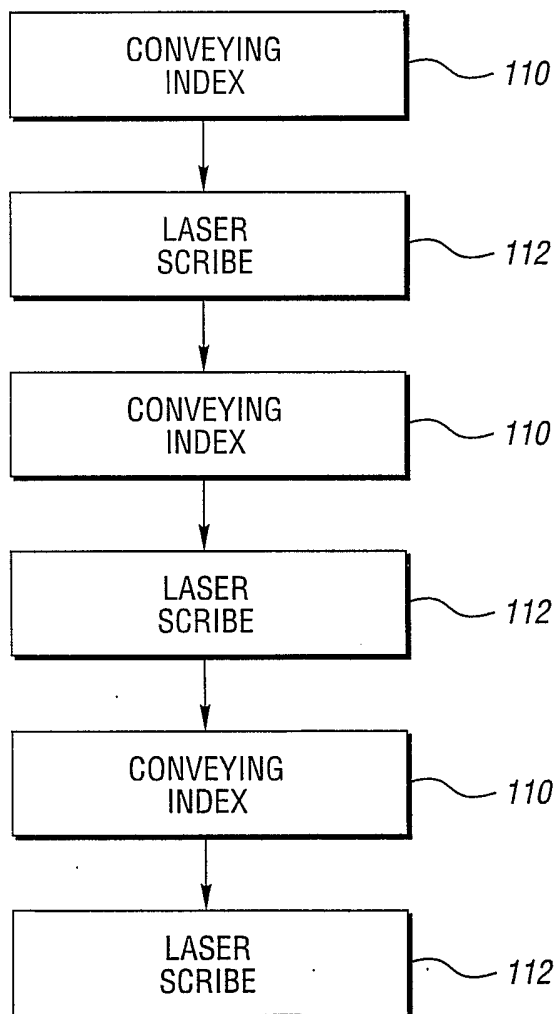


Fig. 12

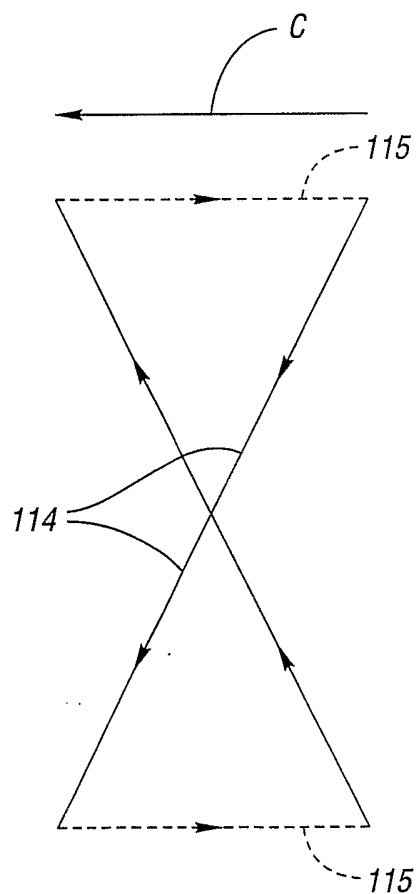


Fig. 13

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US02/24925**A. CLASSIFICATION OF SUBJECT MATTER**

IPC(7) : B23K 26/00, 26/14, 26/16, 26/18

US CL : 219/121.69

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)

U.S. : 219/121.69

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 practicable, search terms used)

US PAT, US PG, Derwent, JPO, EPO, US OCR

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y,P	US 6,300,593 A (POWELL) 09 October 2001, abstract, col. 4, lines 30-57 & col. 5.	10-14 & 17-18
Y	US 5,658,474 A (GEERKE) 19 August 1997, abstract	10-14 & 17-18
Y, P	US 6,329,229 A (YAMAZKI et al.) 11 December 2001, abstract, col. 1, lines 35-67, col. 2, col. 3 & col. 4, lines 1-43.	10-14 & 17-18
Y, P	US 6,40,675 A (LIZOTTE et al.) 16 July 2002, abstract, col. 1, lines 25-67 & col. 2, lines 1-20.	10-14 & 17-18
Y	US 4,535,218 A (KRAUSE et al.) 13 August 1985, abstract.	10-14 & 17-18



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents:		"T"	later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"A"	document defining the general state of the art which is not considered to be of particular relevance	"X"	document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"E"	earlier document published on or after the international filing date	"Y"	document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
"L"	document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"&"	document member of the same patent family
"O"	document referring to an oral disclosure, use, exhibition or other means		
"P"	document published prior to the international filing date but later than the priority date claimed		

Date of the actual completion of the international search

06 NOVEMBER 2002

Date of mailing of the international search report

14 JAN 2003

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INTERNATIONAL SEARCH REPORT

International application No.
PCT/US02/24925

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 4,645,547 A (KRAUSE et al.) 24 February 1987, abstract	10-14 & 17-18