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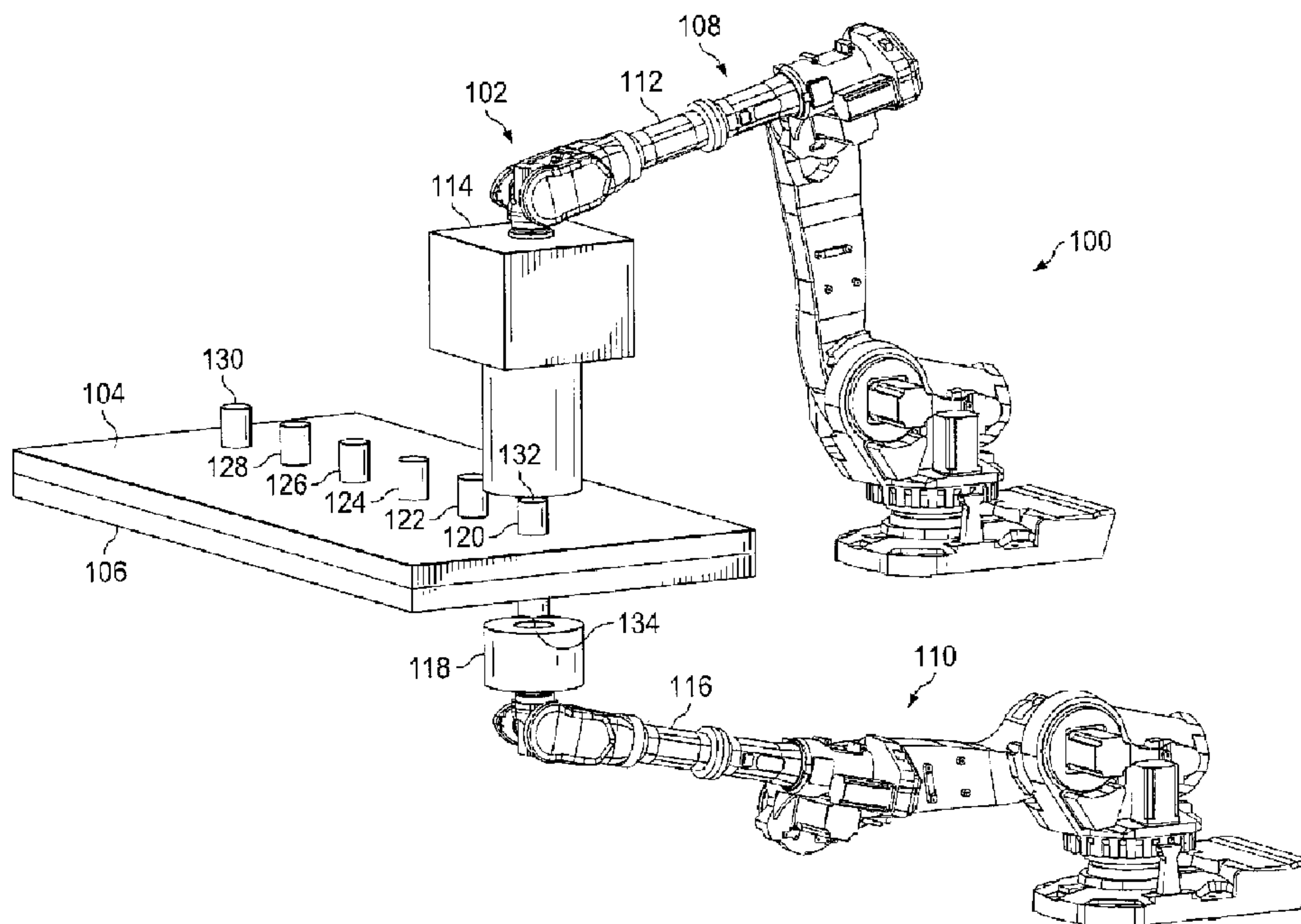
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(54) Titre : CONTROLE DE RETROACTION EN TEMPS REEL POUR L'EXECUTION D'OPERATIONS D'OUTILLAGE
DANS LES PROCEDES D'ASSEMBLAGE

(54) Title: REAL-TIME FEEDBACK CONTROL FOR PERFORMING TOOLING OPERATIONS IN ASSEMBLY
PROCESSES



(57) **Abrégé/Abstract:**

A method and apparatus for controlling a tooling operation to be performed by a tooling system in an assembly process. A current set of parameter values for a set of parameters for the tooling system are modified iteratively, until the current set of parameter values are determined to result in the tooling operation producing an output that meets a set of criteria, to form a final set of parameter values. The tooling operation is performed with the tooling system using the final set of parameter values. A determination is made as to whether the output of the tooling operation meets the set of criteria based on sensor data about the output. A new set of parameter values are identified as the current set of parameter values to be evaluated in response to a determination that the output of the tooling operation does not meet the set of criteria.



ABSTRACT

A method and apparatus for controlling a tooling operation to be performed by a tooling system in an assembly process. A current set of parameter values for a set of parameters for the tooling system are modified iteratively, until the current set of parameter values are determined to result in the tooling operation producing an output that meets a set of criteria, to form a final set of parameter values. The tooling operation is performed with the tooling system using the final set of parameter values. A determination is made as to whether the output of the tooling operation meets the set of criteria based on sensor data about the output. A new set of parameter values are identified as the current set of parameter values to be evaluated in response to a determination that the output of the tooling operation does not meet the set of criteria.

REAL-TIME FEEDBACK CONTROL FOR PERFORMING TOOLING OPERATIONS IN ASSEMBLY PROCESSES

BACKGROUND INFORMATION

The production of components for manufactured objects, such as an aircraft, an aircraft engine, or some other type of object, may be a complex, expensive, and time-consuming process. Because of the tolerances required for such components and the stresses placed on these components, extensive testing may typically need to be performed on prototypes of these components. Based on the results of testing, designs of components may need to be adjusted. In some cases, a design of a component may need to be discarded and recreated.

An object such as, for example, without limitation, an aircraft, may be formed from thousands of manufactured components. These components may need to be manufactured and assembled according to certain specifications within strict tolerances. A change order for a single component may require other changes in many other related components. In some cases, a single change order may cause a ripple effect throughout the entire production cycle of the aircraft. Further, changes to a component, even changes that are considered minor may require a full cycle of testing to ensure that these changes are made according to required specifications.

During the assembly of an aircraft, thousands of fastener elements such as, for example, without limitation, rivets, may be used in assembling the various components of the aircraft. Rivets may vary in type, size, and/or material composition.

Prior to using a tool to install a rivet, many iterations of testing may be required to ensure that the rivet that will be formed by the tool will meet the required specifications. Some currently available methods of testing include using trial and error testing. For example, without limitation, test coupons may be used to obtain a set of parameters for the tool that will allow the rivet to be formed according to the required specifications. Several iterations of testing using these test coupons may be needed to identify an optimal set of parameters.

Any changes in the original design for the rivet to be formed or the components to be assembled using the rivet may require that the testing be repeated. Repeating this process may require more time and effort than desired. Further, this type of testing may require more time

and be more expensive than desired. Therefore, it would be desirable to have a method and apparatus that take into account at least some of the issues discussed above, as well as other possible issues.

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SUMMARY

In one illustrative embodiment, a method for controlling a tooling operation to be performed by a tooling system may be provided. A current set of parameter values for a set of parameters for the tooling system are modified iteratively, until the current set of parameter values are determined to result in the tooling operation producing an output that meets a set of
10 criteria, to form a final set of parameter values. The tooling operation with the tooling system is performed using the final set of parameter values. A determination is made as to whether the output of the tooling operation meets the set of criteria based on sensor data about the output of the tooling operation. A new set of parameter values are identified as the current set of
15 parameter values to be evaluated in response to the determination that the output of the tooling operation does not meet the set of criteria.

In another illustrative embodiment, an apparatus comprises a modeler, a quality checker, and a parameter modifier. The modeler is configured to modify, iteratively, a current set of parameter values for a set of parameters for a tooling system, until the current set of parameter values are determined to result in a tooling operation producing an output that meets
20 a set of criteria, to form a final set of parameter values. The quality checker is configured to determine whether the output of the tooling operation meets the set of criteria based on sensor data about the output of the tooling operation. The parameter modifier is configured to identify a new set of parameter values as the current set of parameter values to be evaluated in response to a determination that the output of the tooling operation does not meet the set of criteria.

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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

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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 manufacturing environment in accordance with an illustrative embodiment;

Figure 2 is an illustration of a formed rivet in accordance with an illustrative embodiment;

Figure 3 is an illustration of a manufacturing environment in the form of a block diagram in accordance with an illustrative embodiment;

Figure 4 is an illustration of a set of parameters for a riveting system in the form of a block diagram in accordance with an illustrative embodiment;

Figure 5 is an illustration of a set of properties for a rivet in the form of a block diagram in accordance with an illustrative embodiment;

Figure 6 is an illustration of a process for controlling tooling operations in the form of a flowchart in accordance with an illustrative embodiment;

Figure 7 is an illustration of a process for controlling riveting operations in the form of a flowchart in accordance with an illustrative embodiment; and

Figure 8 is an illustration of a data processing system in the form of a block diagram in accordance with an illustrative embodiment.

DETAILED DESCRIPTION

The illustrative embodiments recognize and take into account different considerations. For example, the illustrative embodiments recognize and take into account that it may be desirable to have a system for adjusting the parameters of a tooling system, such as a riveting system, in substantially real time while tooling operations are being performed. The illustrative embodiments recognize and take into account that this type of system may require using a computer system capable of performing digital modeling at speeds sufficient to generate feedback data for use in adjusting the parameters of the tooling system in real-time.

Thus, the illustrative embodiments provide an apparatus and method for optimizing a set of parameters for a tooling system while performing tooling operations. As used herein,

“optimizing” the set of parameters may mean identifying the set of parameters that allow the tooling operations to be performed according to selected criteria with the least amount of error.

Referring now to the figures and, in particular, with reference to **Figure 1**, an illustration of a manufacturing environment is depicted in accordance with an illustrative embodiment. In this illustrative example, manufacturing environment **100** is an example of an environment in which riveting system **102** may be used to form rivets. In particular, riveting system **102** may be used to form rivets in plate **104** and plate **106** to fasten these plates together.

As depicted, riveting system **102** may include first device **108** and second device **110**. First device **108** may include first robotic arm **112** and first tool **114**. Second device **110** may include second robotic arm **116** and second tool **118**. In one illustrative example, first tool **114** may be referred to as an anvil, while second tool **118** may be referred to as a die. In another illustrative example, both first tool **114** and second tool **118** may be referred to as dies.

First tool **114** and second tool **118** may be configured for use in forming rivets. For example, first robotic arm **112** and second robotic arm **116** may be configured to position and move first tool **114** and second tool **118** relative to plate **104** and plate **106** to form rivets.

As depicted, members **120**, **122**, **124**, **126**, **128**, and **130** have been inserted through corresponding openings through plate **104** and plate **106**. These members may be used to form rivets. First robotic arm **112** may be configured to use first tool **114** to apply a force to a member, such as member **120**, to change a shape of first end **132** of member **120**. Further, second robotic arm **116** may be configured to use second tool **118** to apply a force to member **120** to change a shape of second end **134** of member **120**. More specifically, first tool **114** and second tool **118** may be used to deform first end **132** and second end **134** of member **120** such that member **120** becomes permanently installed through plate **104** and plate **106**. Once first end **132** and second end **134** of member **120** have been deformed using first tool **114** and second tool **118**, member **120** may be referred to as a rivet.

With reference now to **Figure 2**, an illustration of a formed rivet is depicted in accordance with an illustrative embodiment. In this illustrative example, rivet **200** may be the rivet formed when first tool **114** and second tool **118** change the shapes of first end **132** and second end **134** of member **120** in **Figure 1**. As depicted, rivet **200** may have first shape **202** at first end **132** of rivet **200** and second shape **204** at second end **134** of rivet **200**.

A feedback control system may be used to generate feedback data based on rivet **200** and to determine whether rivet **200** meets a set of criteria based on the feedback data. When the feedback data indicates that the rivet has not been formed according to the set of criteria, a new set of parameters may be identified for riveting system **102** using digital modeling. This
 5 new set of parameters may then be used by riveting system **102** for the next rivet to be formed.

With reference now to **Figure 3**, an illustration of a manufacturing environment is depicted in the form of a block diagram in accordance with an illustrative embodiment. In this illustrative example, manufacturing environment **300** may be an example of an environment in which tooling system **302** may be used. In this illustrative example, tooling system **302** may
 10 be used to perform number of operations **304** on number of structures **306**. As used herein, a “number of” items may be one or more items. In this manner, number of operations **304** may be one or more operations. An operation in number of operations **304** may be referred to as a tooling operation. The tooling operation may be selected from at least one of a riveting operation, a drilling operation, a fastening operation, a nailing operation, a rotating operation,
 15 or some other type of operation.

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
 20 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
 25 combination.

In one illustrative example, tooling system **302** may take the form of riveting system **308**. Riveting system **102** in **Figure 1** may be an example of one implementation for riveting system **308**. Riveting system **308** may be used to form rivets that are used to fasten structures in number of structures **306**, such as first plate **310** and second plate **312**, to each other. In this
 30 manner, riveting system **308** may be used to perform riveting operations **314**. Plate **104** and

plate **106** in **Figure 1** may be an example of one implementation for first plate **310** and second plate **312**.

As depicted, riveting system **308** may be configured to operate with set of parameters **316**. Set of parameters **316** may determine the properties of the rivets formed using riveting system **308**. For example, riveting system **308** may be used to form rivet **318** having set of properties **320**. When set of parameters **316** are changed, set of properties **320** may change.

In this illustrative example, calibration system **322** may be used to identify an initial set of values for set of parameters **316** to be used by riveting system **308**. Further, calibration system **322** may be configured to monitor the set of properties of each rivet formed using riveting system **308** to determine whether adjustments need to be made to these values. Calibration system **322** may include computer system **324** and sensor system **326**.

Computer system **324** may be comprised of one or more computers depending on the implementation. When more than one computer is present in computer system **324**, these computers may be in communication with each other. In this illustrative example, computer system **324** may be implemented in the form of supercomputer **328**. Supercomputer **328** may be comprised of any number of computers, processor units, integrated circuits, microprocessors, and/or other computer hardware and/or software components configured to collectively provide significant processing power.

In this illustrative example, sensor system **326** may include number of sensor devices **330**. In one illustrative example, number of sensor devices **330** may include laser sensor device **332**, backscatter x-ray sensor device **334**, and/or some other type of sensor device.

Prior to number of operations **304** being performed, computer system **324** may be configured to identify initial set of parameter values **336** for set of parameters **316**. In some cases, computer system **324** may receive initial set of parameter values **336** in the form of user input. Of course, in other illustrative examples, computer system **324** may randomly select initial set of parameter values **336**. In still other examples, computer system **324** may select initial set of parameter values **336** from a database of parameter values.

Modeler **338** in computer system **324** may be configured to receive initial set of parameter values **336**. Modeler **338** may be a digital modeler. Modeler **338** may use initial set of parameter values **336** to run number of tests **340**, generate number of models **341**, and/or run

number of simulations **342** to determine whether initial set of parameter values **336** will result in a rivet being formed according to desired specifications.

For example, modeler **338** may use finite-element assisted modeling to form number of models **341** of the rivet that would be formed by riveting system **308** based on initial set of parameter values **336**. Modeler **338** may then use number of models **341** to run number of tests **340** and/or number of simulations **342** to determine whether the rivet that would be formed would meet a set of criteria specified by engineering guidelines, manufacturing guidelines, and/or design requirements.

If modeler **338** determines that initial set of parameter values **336** will result in a rivet being formed according to desired specifications, modeler **338** outputs these values as final set of parameter values **346**. If modeler **338** determines that initial set of parameter values **336** will not result in a rivet being formed according to desired specifications, modeler **338** sends a message to parameter modifier **345** indicating that a new set of parameter values are needed. Parameter modifier **345** may identify and send new set of parameter values **344** to modeler **338**.

This process may be iteratively performed until the current set of parameter values being evaluated have been determined to result in a rivet being formed that meets the desired specifications. These desired specifications may be, for example, set of criteria **358**.

Controller **348** may be configured to receive final set of parameter values **346**. Controller **348** may be configured to control riveting system **308**. In one illustrative example, controller **348** may be considered part of riveting system **308**. In other illustrative examples, controller **348** may be considered separate from riveting system **308**.

Controller **348** may control riveting system **308** to use final set of parameter values **346** for set of parameters **316**. For example, controller **348** may send one or more commands to drive system **350** of riveting system **308** to operate drive system **350** based on final set of parameter values **346**. Riveting system **308** may then use final set of parameter values **346** to form a rivet, such as rivet **318**.

Once rivet **318** has been formed, sensor system **326** may be used to generate sensor data **354**. In particular, number of sensor devices **330** may be used to generate sensor data **354**. Sensor data **354** may include, for example, without limitation, imaging data, x-ray data, laser

imaging data, infrared data, and/or other types of data. Sensor data **354** may be sent to quality checker **356** in computer system **324** for processing.

Quality checker **356** may use sensor data **354** to determine whether rivet **318** has been formed according to set of criteria **358**. More specifically, quality checker **356** may use sensor data **354** to identify set of properties **320** for rivet **318** and to determine whether set of properties **320** meet set of criteria **358**.

If quality checker **356** determines that set of properties **320** meet set of criteria **358**, quality checker **356** sends a message to controller **348** indicating that the current set of parameter values being used for set of parameters **316** may continue being used. However, if quality checker **356** determines that set of properties **320** does not meet set of criteria **358**, quality checker **356** may send a message to parameter modifier **345** indicating that a new set of parameter values are needed.

Parameter modifier **345** may then select new set of parameter values **344** and send new set of parameter values **344** to modeler **338** for processing. Modeler **338** may be configured to use new set of parameter values **344** to run number of tests **340**, generate number of models **341**, and/or run number of simulations **342** to determine whether new set of parameter values **344** may result in a rivet being formed according to desired specifications.

As depicted, riveting system **308** may also include position tracker **352**. Position tracker **352** may be configured to track a position of riveting system **308** relative to number of structures **306** on which number of operations **304** are being performed. Position tracker **352** may be configured to send position data to controller **348** and controller **348** may be configured to reposition riveting system **308** when necessary.

If modeler **338** determines that new set of parameter values **344** will result in a rivet being formed according to desired specifications, modeler **338** outputs these values as final set of parameter values **346** to controller **348**. However, if modeler **338** determines that new set of parameter values **344** will not result in a rivet being formed according to desired specifications, modeler **338** sends a message to parameter modifier **345** that a different set of parameter values are needed. The process described above may be iteratively performed until new set of parameter values **344** that will result in a rivet being formed according to desired specifications has been identified.

The processes performed by quality checker **356**, parameter modifier **345**, and modeler **338** may be performed so quickly, using supercomputer **328**, that the set of parameter values for set of parameters **316** may be adjusted while performing number of operations **304** without requiring significant delays. In this manner, calibration system **322** may provide a feedback
 5 control system for riveting system **308** that allows a set of parameter values for set of parameters **316** for riveting system **308** to be optimized while performing number of operations **304**.

With reference now to **Figure 4**, an illustration of set of parameters **316** for riveting system **308** in **Figure 3** is depicted in the form of a block diagram in accordance with an
 10 illustrative embodiment. As depicted, set of parameters **316** may include speed **400**, interfacial friction conditions **402**, loads **404**, and geometries **406**.

Speed **400** may be the speed at which riveting system **308** is operated. Interfacial friction conditions **402** may identify, for example, without limitation, whether the interfaces between a first tool, such as first tool **114** in **Figure 1**, and a first end of a rivet, such as first
 15 end **132** in **Figure 1**, and between a second tool, such as second tool **118** in **Figure 1**, and a second end of a rivet, such as second end **134** in **Figure 1**, are dry and/or lubricated.

Loads **404** may include the loads applied to the tools used in riveting system **308**. Geometries **406** may include the geometry specifications of the tools used in riveting system **308**.

For example, without limitation, loads **404** may include first tool loads **408** and second tool loads **410**. First tool loads **408** may be the loads for a first tool, such as first tool **114** in
 20 **Figure 1**. Second tool loads **410** may be the loads for a second tool, such as second tool **118** in **Figure 1**.

Similarly, geometries **406** may include first tool geometry **412** and second tool geometry **414**. First tool geometry **412** may include the geometry specifications for a first tool, such as first tool **114** in **Figure 1**. Second tool geometry **414** may include the geometry specifications for a second tool, such as second tool **118** in **Figure 1**. The geometry specifications for a tool may include a shape, length, width, and/or depth of the tool.

With reference now to **Figure 5**, an illustration of set of properties **320** for rivet **318** in
 30 **Figure 3** is depicted in the form of a block diagram in accordance with an illustrative

embodiment. As depicted, set of properties **320** may include first end shape **500**, second end shape **502**, and number of interface properties **504**.

First end shape **500** may be the shape of a first end of rivet **318**, such as first shape **202** of first end **132** of rivet **200** in **Figure 2**. Second end shape **502** may be the shape of a second end of rivet **318**, such as second shape **204** of second end **134** of rivet **200** in **Figure 2**. Number of interface properties **504** may include, for example, without limitation, the interference fit formed by the interface between rivet **318**, first plate **310**, and second plate **312**.

With reference now to **Figure 6**, an illustration of a process for controlling tooling operations is depicted in the form of a flowchart in accordance with an illustrative embodiment. The process illustrated in **Figure 6** may be implemented using calibration system **322** in **Figure 3**.

The process may begin by identifying an initial set of parameter values for a set of parameters for a tooling system as a current set of parameter values to be evaluated (operation **600**). Next, the current set of parameter values may be modified iteratively, until the current set of parameter values are determined to result in a tooling operation producing an output that meets a set of criteria, to form a final set of parameter values (operation **602**).

The tooling operation may then be performed using the final set of parameter values (operation **604**). Sensor data may be generated about the output of the tooling operation (operation **606**). Then, a determination may be made as to whether the output of the tooling operation meets the set of criteria (operation **608**).

If the output of the tooling operation meets the set of criteria, the process proceeds to operation **604** as described above. Otherwise, a new set of parameter values may be identified as the current set of parameter values to be evaluated (operation **610**). The process may then return to operation **602** as described above.

With reference now to **Figure 7**, an illustration of a process for controlling riveting operations is depicted in the form of a flowchart in accordance with an illustrative embodiment. The process illustrated in **Figure 7** may be implemented using calibration system **322** in **Figure 3**.

The process may begin by identifying an initial set of parameter values for a set of parameters for a riveting system as a current set of parameter values to be evaluated (operation **700**). Next, a rivet that would be formed by the riveting system based on the current set of

parameter values may be modeled using finite-element assisted modeling (operation 702). A number of tests and/or simulations may be run based on a modeled rivet to generate test data (operation 704). The test data generated in operation 704 may be digital test data. A determination is made as to whether the modeled rivet meets a set of criteria based on the test data (operation 706).

If the modeled rivet meets the set of criteria, the current set of parameter values being evaluated are output as a final set of parameter values to a controller configured to control the riveting system (operation 708). The calibration system then waits until the rivet has been formed by the riveting system using the final set of parameter values (operation 710).

Sensor data is then generated for the rivet formed (operation 712). A determination is made as to whether a set of properties for the rivet meets the set of criteria based on the sensor data (operation 714). If the set of properties for the rivet meet the set of criteria, the process sends an indication to the controller to continue using the current set of parameter values (operation 716), with the process then returning to operation 710 as described above.

Otherwise, the process selects a new set of parameter values for evaluation (operation 718). The process then returns to operation 702 as described above. With reference again to operation 706, if the modeled rivet does not meet the set of criteria based on the test data, the process proceeds to operation 718 as described above.

Turning now to **Figure 8**, an illustration of a data processing system in the form of a block diagram is depicted in accordance with an illustrative embodiment. Data processing system 800 may be used to implement one or more computers in computer system 324, supercomputer 328, modeler 338, parameter modifier 345, quality checker 356, a processor unit in one or more of number of sensor devices 330 in sensor system 326, and/or controller 348 in **Figure 3**.

As depicted, data processing system 800 includes communications framework 802, which provides communications between processor unit 804, storage devices 806, communications unit 808, input/output unit 810, and display 812. In some cases, communications framework 802 may be implemented as a bus system.

Processor unit 804 is configured to execute instructions for software to perform a number of operations. Processor unit 804 may comprise a number of processors, a multi-processor core, and/or some other type of processor, depending on the implementation. In

some cases, processor unit **804** may take the form of a hardware unit, such as a circuit system, an application specific integrated circuit (ASIC), a programmable logic device, or some other suitable type of hardware unit.

Instructions for the operating system, applications, and/or programs run by processor unit **804** may be located in storage devices **806**. Storage devices **806** may be in communication with processor unit **804** through communications framework **802**. As used herein, a storage device, also referred to as a computer readable storage device, is any piece of hardware capable of storing information on a temporary and/or permanent basis. This information may include, but is not limited to, data, program code, and/or other information.

Memory **814** and persistent storage **816** are examples of storage devices **806**. Memory **814** may take the form of, for example, a random access memory or some type of volatile or non-volatile storage device. Persistent storage **816** may comprise any number of components or devices. For example, persistent storage **816** may comprise a hard drive, a flash memory, a rewritable optical disk, a rewritable magnetic tape, or some combination of the above. The media used by persistent storage **816** may or may not be removable.

Communications unit **808** allows data processing system **800** to communicate with other data processing systems and/or devices. Communications unit **808** may provide communications using physical and/or wireless communications links.

Input/output unit **810** allows input to be received from and output to be sent to other devices connected to data processing system **800**. For example, input/output unit **810** may allow user input to be received through a keyboard, a mouse, and/or some other type of input device. As another example, input/output unit **810** may allow output to be sent to a printer connected to data processing system **800**.

Display **812** is configured to display information to a user. Display **812** may comprise, for example, without limitation, a monitor, a touch screen, a laser display, a holographic display, a virtual display device, and/or some other type of display device.

In this illustrative example, the processes of the different illustrative embodiments may be performed by processor unit **804** using computer-implemented instructions. These instructions may be referred to as program code, computer usable program code, or computer readable program code and may be read and executed by one or more processors in processor unit **804**.

In these examples, program code **818** is located in a functional form on computer readable media **820**, which is selectively removable, and may be loaded onto or transferred to data processing system **800** for execution by processor unit **804**. Program code **818** and computer readable media **820** together form computer program product **822**. In this illustrative
5 example, computer readable media **820** may be computer readable storage media **824** or computer readable signal media **826**.

Computer readable storage media **824** is a physical or tangible storage device used to store program code **818** rather than a medium that propagates or transmits program code **818**. Computer readable storage media **824** may be, for example, without limitation, an optical or
10 magnetic disk or a persistent storage device that is connected to data processing system **800**.

Alternatively, program code **818** may be transferred to data processing system **800** using computer readable signal media **826**. Computer readable signal media **826** may be, for example, a propagated data signal containing program code **818**. This data signal may be an electromagnetic signal, an optical signal, and/or some other type of signal that can be
15 transmitted over physical and/or wireless communications links.

The illustration of data processing system **800** in **Figure 8** is not meant to provide architectural limitations to the manner in which the illustrative embodiments may be implemented. The different illustrative embodiments may be implemented in a data processing system that includes components in addition to or in place of those illustrated for data
20 processing system **800**. Further, components shown in **Figure 8** may be varied from the illustrative examples shown.

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
25 diagrams may represent a module, a segment, a function, and/or a portion 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
30 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.

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
 5 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
 10 understand the disclosure for various embodiments with various modifications as are suited to the particular use contemplated. Further, the disclosure comprises embodiments according to the following clauses:

Clause 4. The method of clause 3, wherein forming the number of models (341) of the output that would be produced by the tooling operation based on the current set of parameter
 15 values comprises:

forming the number of models (341) of the output that would be produced by the tooling operation based on the current set of parameter values using finite-element assisted modeling.

20 Clause 5. The method of clause 3, wherein determining whether the output that would be produced by the tooling operation meets the set of criteria (358) comprises:
 running at least one of a number of tests (340) and a number of simulations (342) based on the number of models (341) to form test data; and

determining whether the output that would be produced by the tooling operation meets
 25 the set of criteria (358) based on the test data.

Clause 14. The apparatus of clause 12, wherein the parameter modifier (345) is configured to identify the new set of parameter values (344) to be evaluated as the current set of parameter values in response to the determination that the output that would be produced by the tooling
 30 operation does not meet the set of criteria (358) and to send the new set of parameter values (344) to the modeler (338) for evaluation.

Clause **19**. The apparatus of clause **18**, wherein the output is a rivet (**318**) and wherein the set of properties (**320**) includes at least one of a first end shape (**500**), a second end shape (**502**), and a number of interface properties (**504**).

5

Clause **20**. The apparatus of clause **9**, wherein the modeler (**338**), the quality checker (**356**), and the parameter modifier (**345**) are implemented in a supercomputer (**328**).

**THE EMBODIMENTS OF THE INVENTION IN WHICH AN EXCLUSIVE
PROPERTY OR PRIVILEGE IS CLAIMED ARE DEFINED AS FOLLOWS:**

- 5 **1.** A method for controlling a tooling operation to be performed by a tooling system, the
method comprising:
- 10 modifying, iteratively, a current set of parameter values for a set of parameters
for the tooling system, until the current set of parameter values are determined
to result in the tooling operation producing an output that meets a set of criteria,
to form a final set of parameter values;
- 15 performing the tooling operation with the tooling system using the final set of
parameter values;
- determining whether the output of the tooling operation meets the set of criteria
based on sensor data about the output of the tooling operation; and
- 20 identifying a new set of parameter values as the current set of parameter values
to be evaluated in response to a determination that the output of the tooling
operation does not meet the set of criteria.
- 2.** The method of claim 1 further comprising:
- 25 repeating modifying, iteratively, the current set of parameter values to form the
final set of parameter values after identifying the new set of parameter values as
the current set of parameter values to be evaluated.
- 3.** The method of claim 1, wherein modifying, iteratively, the current set of parameter
30 values to form the final set of parameter values comprises:

forming a number of models of the output that would be produced by the tooling operation based on the current set of parameter values;

determining whether the output that would be produced by the tooling operation meets the set of criteria; and

identifying the new set of parameter values to be evaluated as the current set of parameter values in response to the determination that the output that would be produced by the tooling operation does not meet the set of criteria.

4. The method of claim 1 further comprising:

generating the sensor data about the output of the tooling operation using at least one of a laser sensor device and a backscatter x-ray sensor device.

5. The method of claim 1, wherein performing the tooling operation using the final set of parameter values comprises:

performing a riveting operation using the final set of parameter values.

6. The method of claim 1 further comprising:

identifying an initial set of parameter values for the set of parameters for the tooling system as the current set of parameter values to be evaluated based on the tooling operation to be performed, wherein the tooling operation is an operation in an assembly process.

7. An apparatus comprising:

5 a modeler configured to modify, iteratively, a current set of parameter values for a set of parameters for a tooling system to be used to perform a tooling operation, until the current set of parameter values are determined to result in the tooling operation producing an output that meets a set of criteria, to form a final set of parameter values;

10 a quality checker configured to determine whether the output of the tooling operation meets the set of criteria based on sensor data about the output of the tooling operation; and

15 a parameter modifier configured to identify a new set of parameter values as the current set of parameter values to be evaluated in response to a determination that the output of the tooling operation does not meet the set of criteria.

8. The apparatus of claim 7, wherein the modeler is configured to use the parameter modifier to iteratively modify the current set of parameter values to form the final set of
20 parameter values.

9. The apparatus of claim 7, wherein the modeler is configured to form a number of models of the output that would be produced by the tooling operation based on the current set of parameter values and to determine whether the output that would be
25 produced by the tooling operation meets the set of criteria.

10. The apparatus of claim 9, wherein the modeler is configured to run at least one of a number of tests and a number of simulations based on the number of models to form test data.

30

11. The apparatus of claim 9, wherein the modeler is configured to determine whether the output that would be produced by the tooling operation meets the set of criteria based on test data, wherein the test data is digital test data.

5 12. The apparatus of claim 7 further comprising:

a controller configured to receive the final set of parameter values and to control the tooling system based on the final set of parameter values.

10 13. The apparatus of claim 7 further comprising:

a sensor system configured to generate the sensor data about the output of the tooling operation performed using the final set of parameter values.

15 14. The apparatus of claim 7, wherein the set of parameters includes at least one of a speed, interfacial friction conditions, loads, and geometries.

15. The apparatus of claim 7, wherein the set of criteria is for a set of properties of the output produced by the tooling operation.

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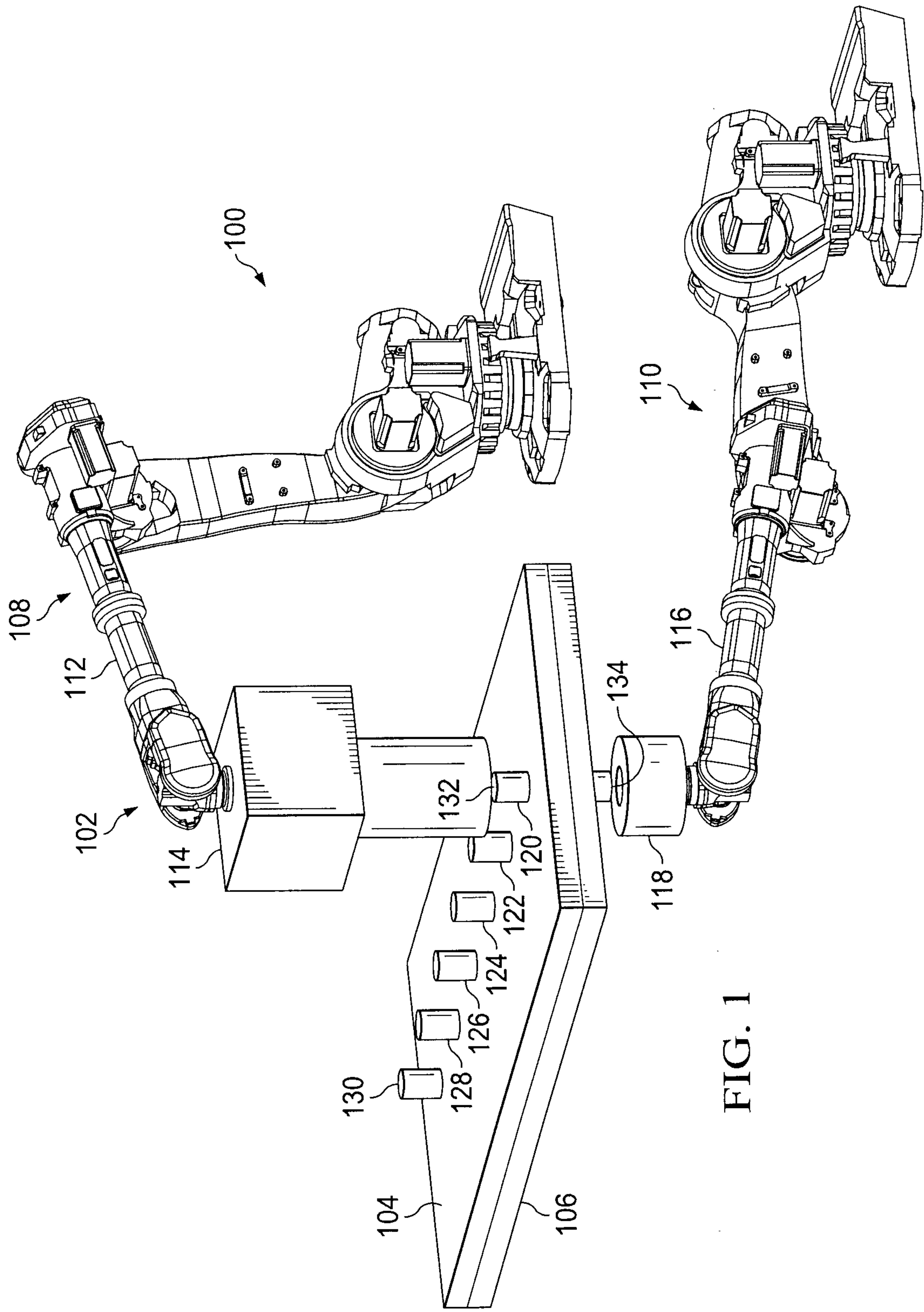


FIG. 1

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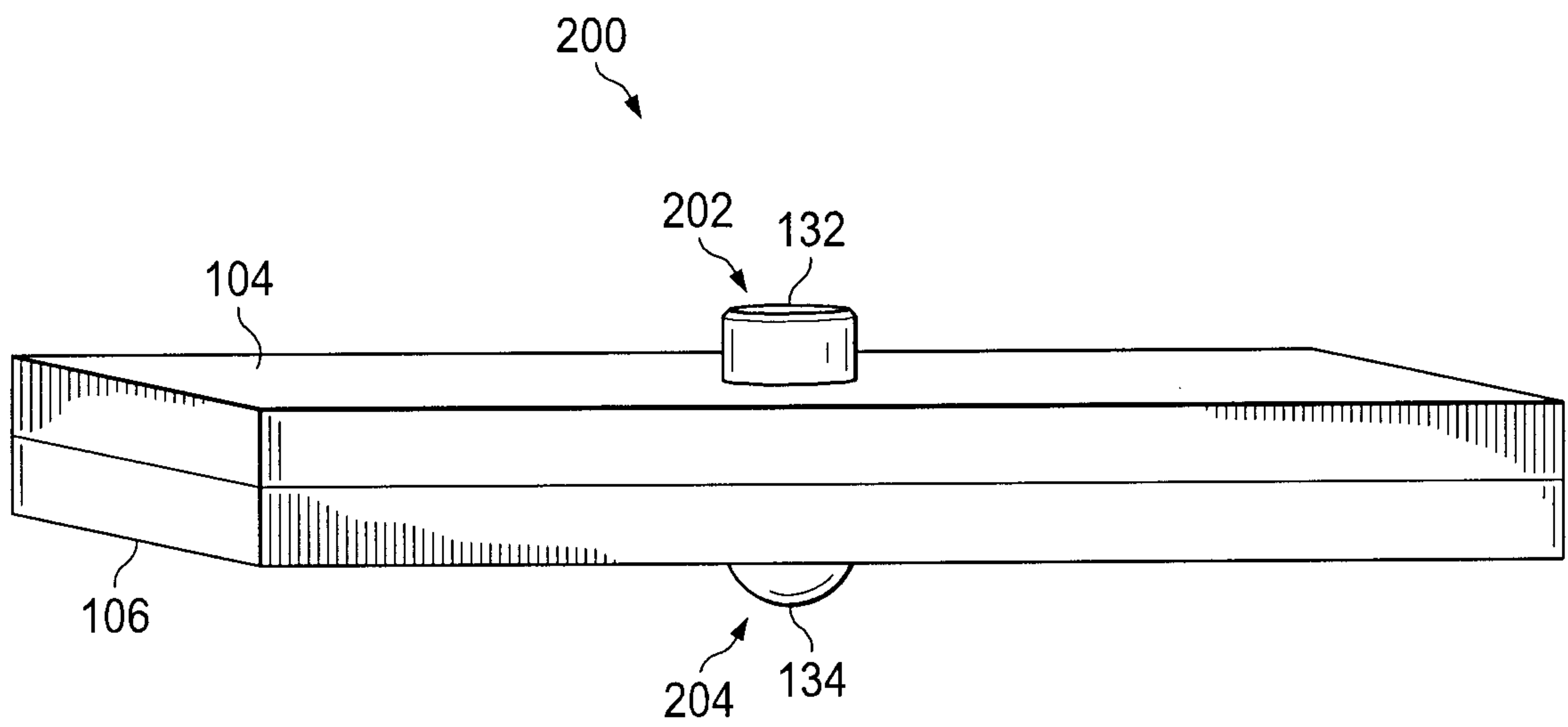


FIG. 2

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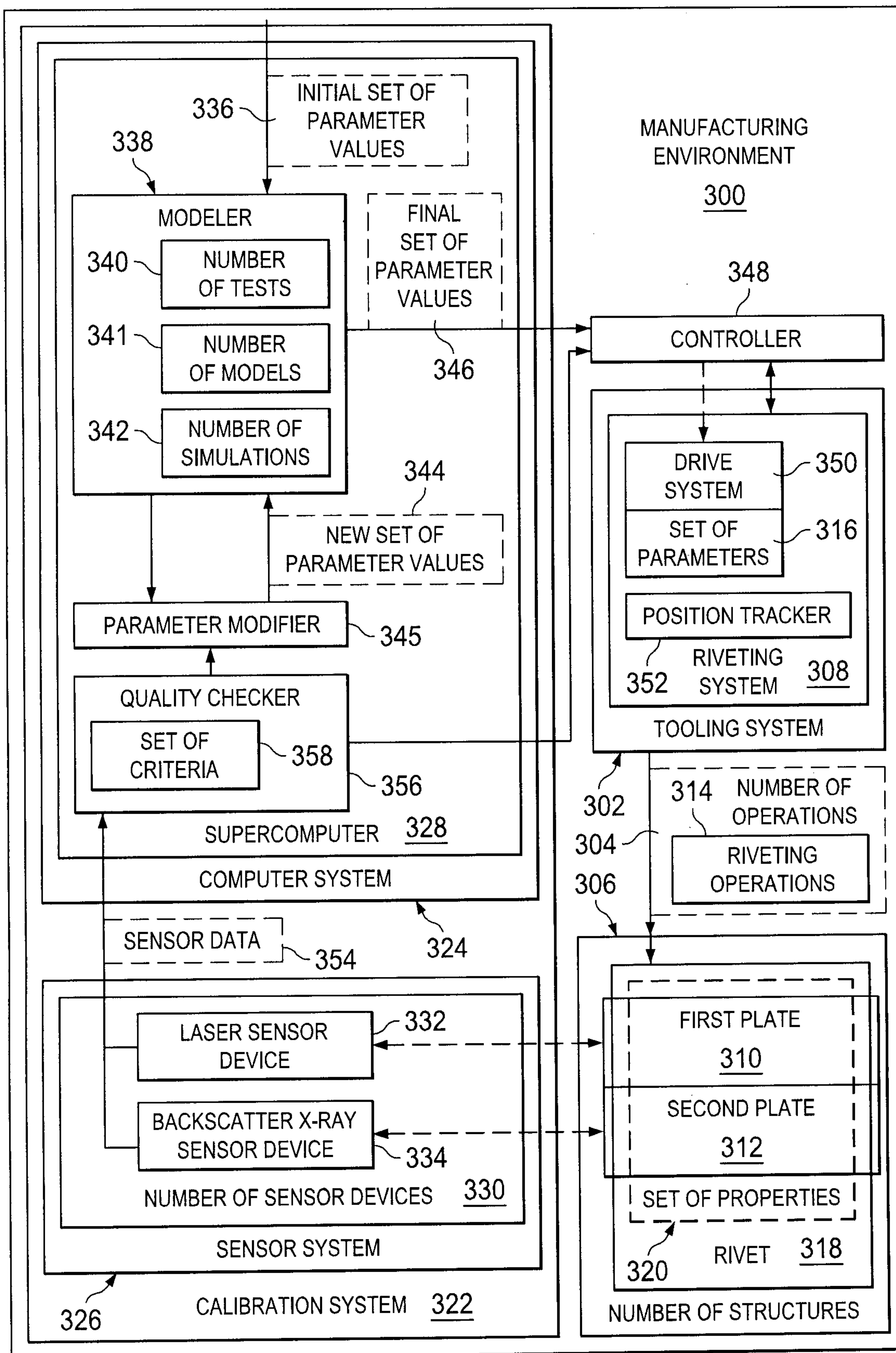


FIG. 3

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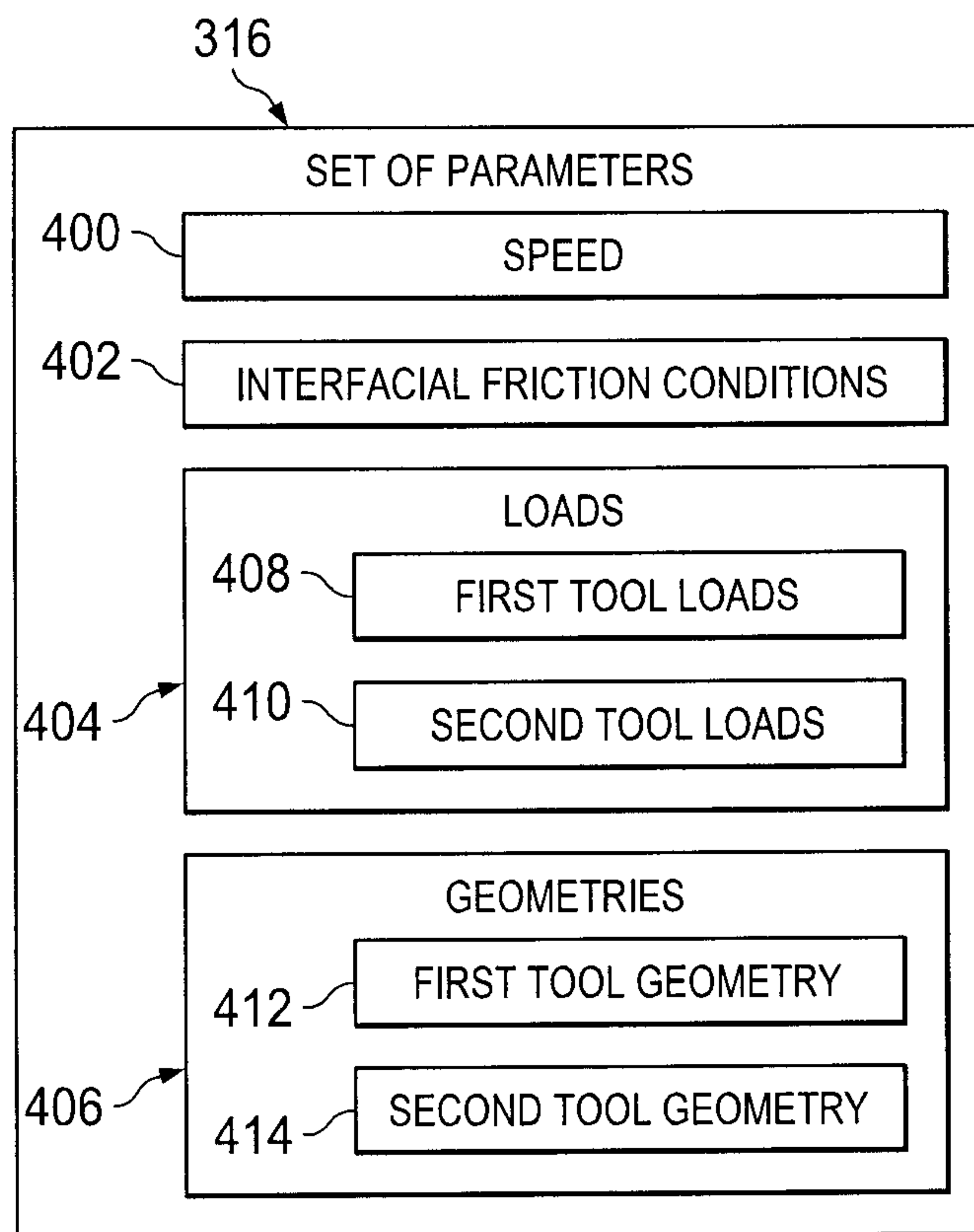


FIG. 4

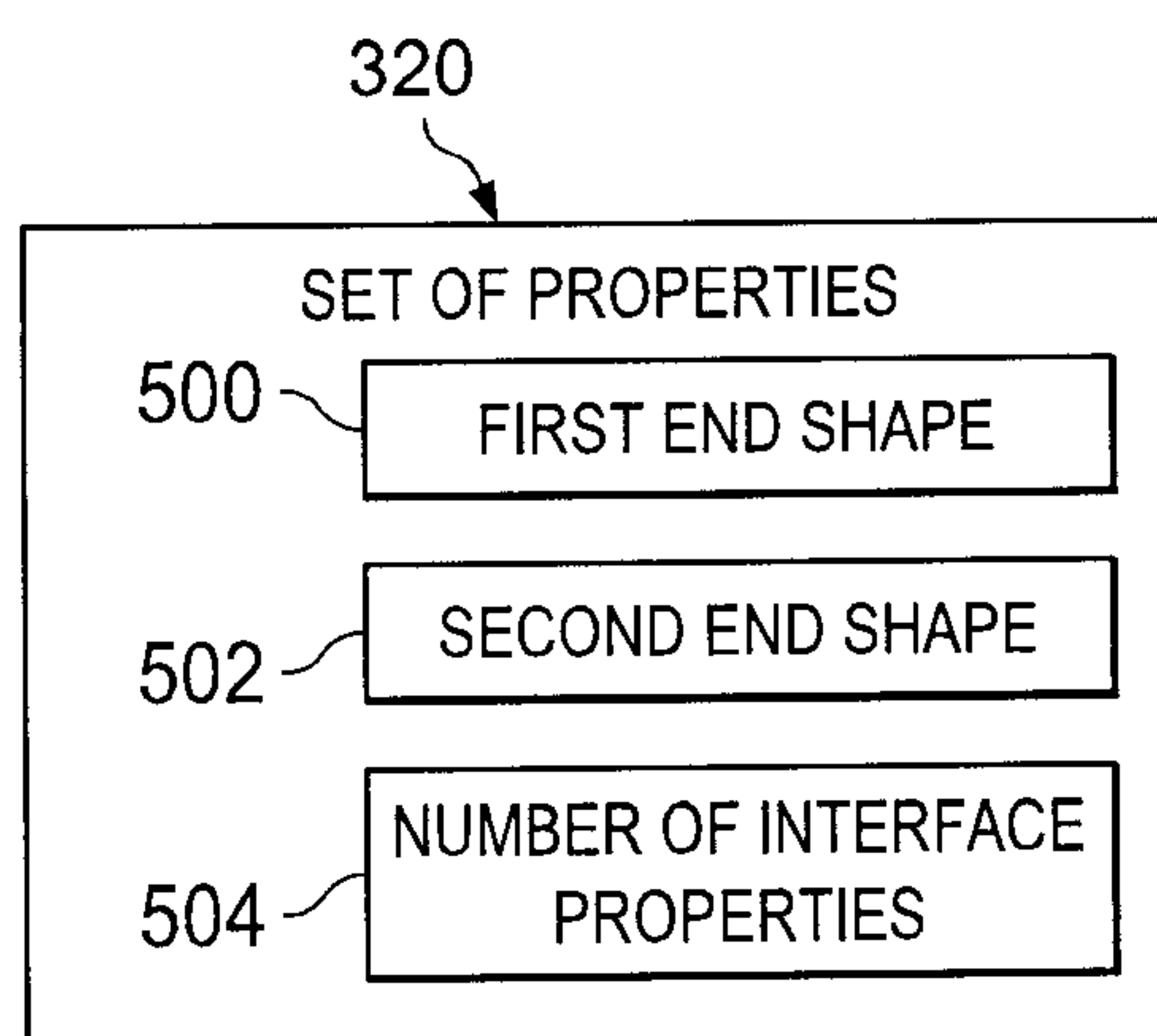


FIG. 5

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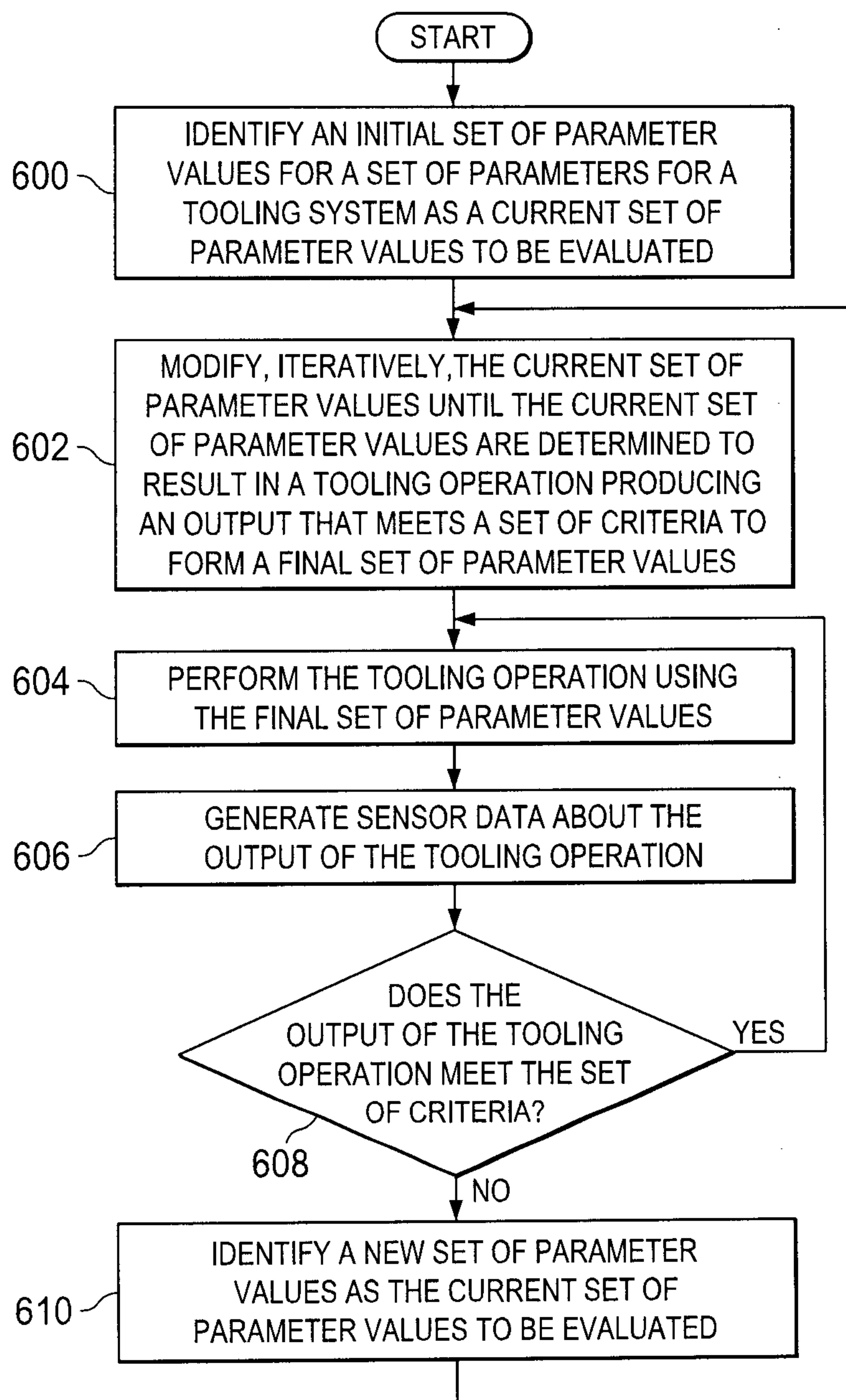


FIG. 6

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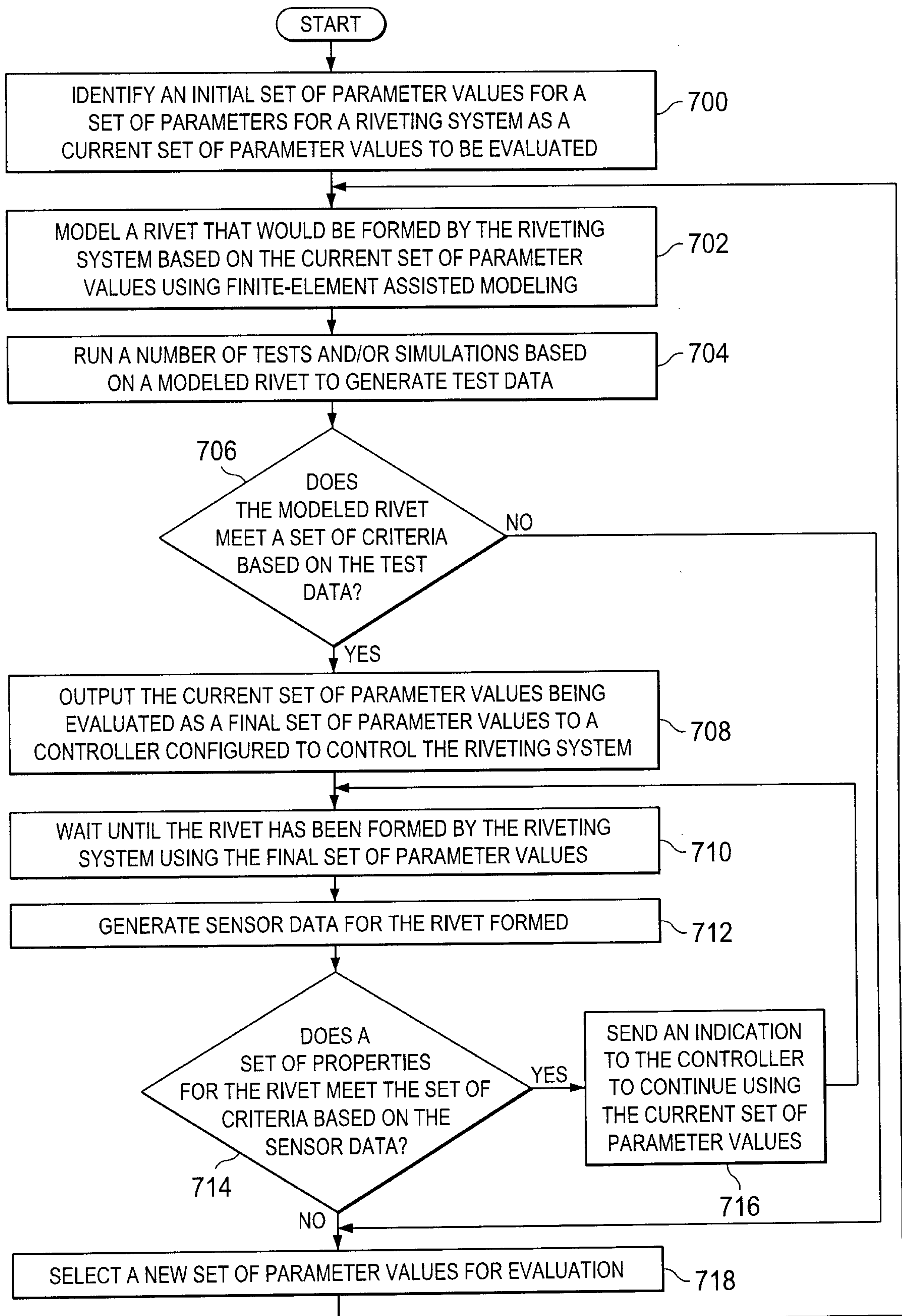


FIG. 7

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