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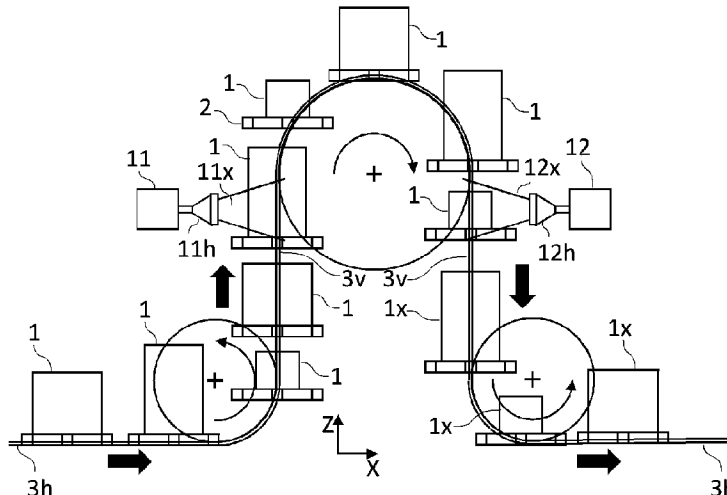
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(54) Title: APPARATUS FOR X-RAY IRRADIATION



(57) **Abrégé/Abstract:**

The present invention concerns an apparatus for irradiating goods (1g) with X-rays (11x, 12x), comprising

- A first source (11) of X-rays configured for emitting X-rays along a first irradiation volume (11x) centred on a longitudinal axis (X),
 - A conveyor (3h, 3v) configured for driving goods such as to expose a first portion of the goods (1g) through the first irradiation volume,
- wherein, the conveyor (3v) is configured for driving the target products (1) through the irradiation volume (11x) along the vertical axis (Z).



ABSTRACT

APPARATUS FOR X-RAY IRRADIATION

- 5 The present invention concerns an apparatus for irradiating goods (1g) with X-rays (11x, 12x), comprising
- A first source (11) of X-rays configured for emitting X-rays along a first irradiation volume (11x) centred on a longitudinal axis (X),
 - A conveyor (3h, 3v) configured for driving goods such as to expose a first portion of the goods
- 10 (1g) through the first irradiation volume,

wherein, the conveyor (3v) is configured for driving the target products (1) through the irradiation volume (11x) along the vertical axis (Z).

15 Fig. 5(b)

APPARATUS FOR X-RAY IRRADIATION

TECHNICAL FIELD

5 [0001] The present invention concerns an apparatus for irradiating goods with X-rays ensuring a dose deposition pattern which is independent of a height of pallets or containers holding the goods. This is made possible by a specific conveyor configured for driving the goods through the irradiation volume of a source of X-rays along a vertical axis (Z) instead of along a horizontal direction.

BACKGROUND OF THE INVENTION

10 [0002] Irradiation of a target product with X-rays has been used for different purposes, including sterilisation, cross-linking of resins and paints, shrink-fitting polymer sheets or tubes, such as sheaths about electric cables, and the like. X-ray sterilisation of medical devices, tools, and garments, and sterilisation of foodstuff have been reported in the art. X-ray sterilisation is advantageous over other types of sterilisation techniques such as γ -irradiation-, electron beam-, or ethylene oxide-sterilisation techniques, in that X-rays can penetrate deeply full pallets and containers with densities of up to
15 1.0 g / cm³, which is higher than the foregoing techniques, and X-ray sterilisation has a very high tolerance to density variations.

[0003] X-rays are a high-energy electromagnetic radiation. Most X-rays have a wavelength ranging from 10 pm to 10 nm, corresponding to frequencies in the range 3×10^{16} Hz to 3×10^{19} Hz. One common practice is to distinguish X-radiation from γ -radiation on the basis of their source: X-rays are emitted by
20 the interaction of electrons with a target, preferably a high-Z metal, while γ -rays are emitted by an atomic nucleus. One common alternative is to distinguish between the two types of radiation based on wavelength (or, equivalently, frequency or photon energy), with γ -radiations being defined as radiations shorter than some arbitrary wavelength, such as 10^{-11} m (= 0.1 Å). These two definitions generally coincide since the electromagnetic radiation emitted by X-ray tubes generally has a longer wavelength
25 and lower photon energy than the radiation emitted by radioactive nuclei.

[0004] X-rays are generated by interacting accelerated (energetic) electrons with atoms in a target material (11f). As high energy electrons pass in the vicinity of a nucleus all or part of the electron's energy is dissociated from it and propagates in space as electromagnetic radiation (= X-ray). The heavier the element (i.e., higher atomic number or 'Z-value'), the greater the X-rays' conversion
30 efficiency. Metals such as Tantalum (Ta) or Tungsten (W) are typically used as target material.

[0005] The energy of the electrons can be increased by accelerating them in an accelerator. The following accelerators are available on the market,

- L-band linacs (accelerating RF in the range of 1 GHz; single pass through multiple cavities; e.g. Impela)

- DC accelerators (direct current; e.g. Dynamitron)
- Rhodotron (an RF-type accelerator; multi-pass through a single cavity, e.g., TT200)

[0006] When the incident electron beam is < 100KeV, the resulting photons are emitted equally in all directions. As the energy of the incident radiation is increased, the Bremsstrahlung radiation beam becomes more "forward peaked," as illustrated in Figure 4(a). As illustrated in Figures 4(b) to 4(d) and in order to control the geometry of the irradiation volume emitted out of the converter (or target material), a scan horn (11h) is used, in the shape of an inverted funnel as illustrated in Figures 4(b)-4(d). The shape and dimensions of the scan horn determine the geometry and dimensions of a first irradiation volume generated by the first source of X-rays provided with a specific scan horn.

[0007] Goods to be irradiated with X-rays can be stacked on pallets or held in containers. The containers can be self-supporting or can themselves be laid on top of pallets. Such goods and pallets and / or containers form target products. As illustrated in Figures 1(a), 1(b), and 5(a), the target products are generally conveyed in prior art systems on a conveyor driving them horizontally, along a longitudinal axis (X), in front of a first source of X-rays (11). The dose deposition distribution on the goods with such systems decreases rapidly by absorption in the Y-direction, which the first irradiation volume is centred on as well known in the art. To solve this problem a second source of X-rays can be provided (not shown) pointing to a surface of the target products opposite the surface irradiated by the first source of X-rays. Alternatively, the target products can be returned in front of the first source of X-ray showing an opposite surface thereto (not shown), or the target products can be rotated.

[0008] One way of quantifying the dose deposition distribution along a given direction or plane is to calculate a dose uniformity ratio (DUR) along said direction or plane, wherein $DUR = DM / Dm$, with DM is the maximum dose and Dm the minimum dose deposited along said direction or plane. A value of $DUR = 1 \Leftrightarrow DM = Dm$, defines a perfectly homogenous dose deposition distribution along a given direction or plane. The larger the value of DUR, the larger the variations of dose deposition along the direction or plane.

[0009] In prior art apparatuses as illustrated in Figures 1(a), 1(b), and 5(a), the dose deposition distribution along the longitudinal axis (X) of the conveyor is substantially constant, with a DURx along the longitudinal axis (X) close to 1, since the target products scroll along the longitudinal axis (X) through the irradiation volume of the source of X-ray. The dose deposition distribution along the vertical axis (Z), however, varies substantially because the height of the target products can vary considerably from one pallet to another. Since high energy X-rays propagate in a forward peaked pattern as shown in Figure 4(a), higher X-ray doses are deposited into the target products at the level of the irradiation axis (X) and the X-ray doses deposited along the vertical axis (Z) decrease with increasing distance from the irradiation axis (X). Consequently, a variation of the height of the target products yields a substantial corresponding variation of the dose deposition distribution along the vertical axis (Z), thus increasing the values of the corresponding DURz's >> 1 along the vertical axis (Z). This is of course inadmissible, since either the portions of the target product receiving a minimum dose (Dm) are not sufficiently

irradiated to fulfil the objective of the irradiation, such as sterilisation, cross-linking, and the like, or the minimum dose (D_m) suffice to fulfil said objective, but then there is a risk that the portion receiving the maximum doses (D_M) be over-irradiated and may be degraded by the process. It is therefore important to reduce the DURz and thus ensure that the DUR along all directions is sufficiently close to 1.

5 **[0010]** To minimize the value of DURz in the vertical direction in a system as depicted in Figures 1(a), 1(b), and 5(a), the scan horn (11h) must be dimensioned such as to overscan beyond the boundaries of the target product, such as to deposit doses according to a relatively flat bottom of the approximately parabolic-shaped curve of dose deposition about the vertical axis (Z). In order to limit the size and the costs of the x-ray scan horn, the overscanning is generally limited to 20 to 30 cm beyond the
10 target product boundaries. Since the height of the target products, however, can vary substantially from one pallet to the other, it is impossible to optimize the DURz with a single scan horn fitting all heights at a reasonable cost. Note that it is cumbersome and impractical to change scan horn between two target products.

[0011] US6504898 discloses a rotation system where a product is rotated before the radiation means.
15 A pallet is turned slowly about its vertical axis as the x-ray radiation is scanned up and down. A shutter apparatus consisting of a pair of x-ray absorbing doors is located between the scan horn x-ray conversion plate and pallet to shape the x-ray pattern and to attenuate the x-ray intensity during the times that the face of pallet is turned towards the scan horn.

[0012] A disadvantage of this x-ray irradiation system is that the shutter causes valuable x-ray energy
20 to be converted into heat and be wasted. A further drawback is the dependence on precise mechanical movement and rotation of the target material being irradiated to achieve the desired dosage uniformity. The timing and control of shutter doors must be precisely mechanically synchronized with the rotation of the pallet on turntable to compensate for the varying material thickness.

[0013] US6940944 describes an apparatus for radiation processing of target products comprising a
25 radiation source, a collimator having a variable aperture, and a turntable. The collimator is adapted for adjusting its aperture prior to irradiation of a package.

[0014] Alternative irradiation methods have been developed to irradiate a great variety of products of different density with improved DUR. EP1459770 proposes a process where at least two pallets are loaded on rotation means for simultaneous irradiation. EP1738776 discloses a pallet x-ray irradiation
30 method where pallets are arranged on two superposed levels and the x-ray beam is directed along a height corresponding to a distance comprised between mid-height of the lower level up to mid-height of the upper level of said sets of pallets. Pallets are then switched of level for full irradiation.

[0015] The solutions of the prior art are adapted to situations where the pallets and/or containers have a specific shape or have all substantially the same height. In case pallets having different heights need
35 to be treated with such systems, the beam scanning width needs to be adapted to the product height to avoid processing inefficiency. This results in complex scheduling strategies.

[0016] The present invention offers a simple and easy to implement solution for reducing the DUR in

all directions and, in particular, in the vertical axis (Z) of target products of different shapes and dimensions irradiated by X-ray. These and other advantages of the present invention are presented in continuation.

SUMMARY OF THE INVENTION

5 [0017] The present invention is defined in the appended independent claims. Preferred embodiments are defined in the dependent claims. In particular, the present invention concerns an apparatus for irradiating goods with X-rays, comprising

- a first source of X-rays configured for emitting X-rays along a first irradiation volume centred on a longitudinal axis (X),
- 10 • a conveyor configured for driving goods such as to expose a first portion of the goods through the first irradiation volume, the goods forming target products, and being preferably loaded on pallets and / or in containers, each target product being inscribed within a prismatic volume defined by a base plane and a height (h), wherein during conveying the base plane extends along the longitudinal axis (X) and a transverse axis (Y) normal to the longitudinal axis (X), and
- 15 the height (h) extends along a vertical axis (Z) normal to the base plane (X, Y),

wherein, the conveyor is configured for driving the target products through the irradiation volume, along the vertical axis (Z).

[0018] In an embodiment, the conveyor comprises a rotating element configured for rotating (N – 1) times a target product by $2\pi / N$ rad to successively expose N portions of the target products (1) to the first irradiation volume, wherein preferably, N = 2, 3, or 4. N is preferably equal to two.

[0019] The apparatus may comprise a second source of X-rays configured for emitting X-rays along a second irradiation volume centred on a second longitudinal axis such as to irradiate a second portion of the target products, wherein the second longitudinal axis is preferably parallel, more preferably coaxial to the first longitudinal axis (X), and irradiation proceeds in a direction opposite to the irradiation by the first source of X-rays. The second source of X-rays can be positioned such as to irradiate a target product simultaneously with the first source of X-rays, i.e., the two sources of X-rays are positioned face to face, *with the* second longitudinal axis being coaxial with the first longitudinal axis. Alternatively, the second source of X-rays can be positioned such as to irradiate a target product previously irradiated with the first source of X-rays. The second source of X-rays is therefore positioned downstream from the first source of X-rays, and facing a different portion of the target products than the first source of X-rays.

[0020] In a preferred embodiment, the conveyor comprises first and second horizontal portions, configured for moving the goods along the longitudinal axis (X) both upstream and downstream of a vertical portion of the conveyor driving the target products parallel to the vertical axis (Z), to expose the

first portion of the target products to the first irradiation volume. The conveyor may comprise a mechanism configured for ensuring that a top surface of a first target product be substantially equidistant from a bottom surface of a second target product located adjacent to and downstream from the first target product as they are driven along the vertical axis (Z), regardless of a height measured along the vertical axis (Z) of the target products. The mechanism preferably includes a detachable mechanism for varying a drive speed along the longitudinal axis (X) prior to changing direction of drive along the vertical axis.

[0021] In a first embodiment the conveyor comprises a vertical portion configured for driving the target products through the irradiation volume, along the vertical axis (Z) at a constant speed. In an alternative embodiment, the conveyor comprises a vertical portion configured for driving different target products through the irradiation volume, along the vertical axis (Z), at different speeds, depending on the target product properties, such as density of the goods, size of the target products along the longitudinal axis (X), and the like.

[0022] The present invention yields very narrow dose deposition distributions along the vertical axis (Z) regardless of the height (h) of the target products. For example, a vertical dose uniformity ratio (DUR_z) defined as a ratio (DM_z / Dm_z) of a maximum dose (DM_z) to a minimum dose (Dm_z) deposited into a target product over the vertical axis (Z) between a bottom of the good and a top of the good can be not more than 1.2, preferably not more than 1.1, more preferably not more than 1.05, for a uniform good density of 0.1 g / cm³.

[0023] A planar dose uniformity ratio (DUR_{yz}) defined as a ratio (DM_{yz} / Dm_{yz}) of a maximum dose (DM_{yz}) to a minimum dose (Dm_{yz}) deposited into a target product over a plane (Y, Z) normal to the longitudinal axis (X) for any value of penetration depth (x₁, x₂) along the longitudinal axis (X) is lower than 1.7, more preferably lower than 1.35, for an uniform good density of 0.1 g / cm³.

[0024] In order to narrow the dose deposition distribution along the transverse axis (Y), a scanning ratio (w₁ / w_x) of a target product width (w₁) to an irradiation span (w_x), both measured along the transverse axis (Y) can be comprised between 30% and 65%, preferably between 35% and 55%, more preferably between 40%, and 50%. A value of the irradiation span (w_x) can be controlled at least partly by a scan horn. For example, the target product width (w) is preferably 100 cm ± 20 cm, and the irradiation span (w_x) is preferably 220 cm ± 20 cm.

[0025] The present invention also concerns a method for irradiating with X-rays goods loaded on pallets comprising the following steps,

- Providing an apparatus as defined above,
- driving the goods through the irradiation volume, along the vertical axis (Z),
- irradiating the goods with X-ray as the goods are driven through the irradiation volume.

[0026] The target products can be driven through the irradiation volume, along the vertical axis (Z) at a constant speed.

[0027] The goods are preferably substantially equidistant from one another as they are driven along the vertical axis (Z), regardless of a height measured along the vertical axis (Z) of each target product.

[0028] The method of the present invention allows keeping parameters of the X-ray along the first irradiation volume independent of a height measured along the vertical axis (Z) of the target products.

5 BRIEF DESCRIPTION OF THE FIGURES

[0029] For a fuller understanding of the nature of the present invention, reference is made to the following detailed description taken in conjunction with the accompanying drawings in which:

Figure 1(a): shows a side view of an apparatus of the prior art for irradiating target products with x-ray.

Figure 1(b): shows a top view of the apparatus of the prior art of Figure 1(a).

10 **Figure 1(c):** shows a side view of an embodiment of apparatus according to the present invention.

Figure 2(a): shows the dose deposition distribution along the longitudinal axis (X) and the longitudinal axis (Y) of an apparatus according to the present invention.

Figure 2(b): shows the dose deposition distribution along the longitudinal axis (X) and the vertical axis (Z) of an apparatus according to the present invention.

15 **Figure 2(c):** shows the dose deposition distribution along the longitudinal axis (X) of an apparatus according to the present invention by irradiating two opposite surfaces of the target product.

Figure 2(d): shows a target product illustrated in Figures 2(a) to 2(c).

Figure 3(a): plots the dose deposition distribution over a plane (X, Y) of an apparatus according to the present invention.

20 **Figure 3(b):** plots the dose deposition distribution over a plane (Y, Z) of an apparatus according to the present invention.

Figure 3(c): plots the dose deposition distribution over a plane (X, Z) of an apparatus according to the present invention.

25 **Figure 4(a):** shows schematically the special distribution of photons resulting from the impact of an electron beam with a target made of a high-Z metal, for different beam energies.

Figure 4(b): shows a perspective view of an example of scan horn.

Figure 4(c): shows a top view of the scan horn of Figure 4(b).

Figure 4(d): shows a side view of the scan horn of Figure 4(b).

Figure 5(a): shows an alternative embodiment of apparatus according to the prior art.

30 **Figure 5(b):** shows an alternative embodiment of apparatus according to the present invention.

DETAILED DESCRIPTION OF THE INVENTION

[0030] As illustrated in Figures 1(c) and 5(b), the apparatus of the present invention is configured for irradiating goods (1g) with X-rays (11x, 12x). It comprises a first source (11) of X-rays configured for emitting X-rays (11x) along a first irradiation volume centred on a longitudinal axis (X). The apparatus
 5 further comprises a conveyor (3h, 3v) configured for driving goods such as to expose a first portion of the goods (1g) in front of the first irradiation volume, the goods being preferably loaded on pallets (2) and / or in containers, forming target products (1) as shown in Figure 2(d). Each target product (1) is inscribed within a prismatic volume defined by a base plane and a height (h), wherein during conveying the base plane extends along, on the one hand, the longitudinal axis (X) and, on the other hand, a
 10 transverse axis (Y) normal to the longitudinal axis (X), and the height (h) extends along a vertical axis (Z) normal to the base plane (X, Y).

[0031] The gist of the present invention rests on the conveyor being configured for driving the target products (1) through the irradiation volume, along the vertical axis (Z), as illustrated in Figures 1(c) and 5(b). This has the great advantage that with a single scan horn (11h) of limited size, substantially all
 15 target products can be irradiated with X-rays with an agreeably homogeneous dose deposition distribution, irrespective of the height (h) of the target products (1). This is not the case for the following reasons with apparatuses according to the prior art, as illustrated in Figures 1(a), 1(b), and 5(a), wherein the target products are irradiated along the longitudinal axis (Y) while the goods are driven along the longitudinal axis (X). The target products (1) located downstream of the first source of X-ray have been
 20 irradiated at least once with X-ray and are referred to in the Figures with the numeral (1x).

IRRADIATION AXIS AND IRRADIATION PLANE FORMED BY THE MOTION DIRECTION AND THE NORMAL DIRECTION

[0032] In apparatuses according to both prior art and the present invention, the first source of X-ray (11) is positioned such as to irradiate the target products (1) with an irradiation volume centred on an
 25 irradiation axis which is normal to an irradiation plane defined by a motion direction parallel to the direction of motion of the target products (1) and a normal direction, which is normal to both irradiation axis and motion direction.

- In an apparatus according to the prior art as illustrated in Figures 1(a), 1(b), and 5(a), the irradiation axis is parallel to the transverse axis (Y), the motion direction is parallel to the
 30 longitudinal axis (X), and the normal direction is parallel to the vertical axis (Z).
- In an apparatus according to the present invention as illustrated in Figures 1(c) and 5(b), the irradiation axis is parallel to the longitudinal axis (X), the motion direction is parallel to the vertical axis (Z), and the normal direction is parallel to the transverse axis (Y).

[0033] The gist of the present invention is to configure the conveyor such that the normal direction be

parallel to the longitudinal axis (Y), along which the width (w1) of the target products (1) is substantially constant, rather than parallel to the vertical axis (Z), as in the prior art apparatuses, along which the height (h) of the target products can vary substantially between two target products (1). This way the variations of dose deposition distribution along the normal direction can be maintained substantially homogeneous between different target products without changing the settings of the source of X-rays (11, 12) and of the scan horn (11h, 12h), as discussed below.

DOSE DEPOSITION DISTRIBUTION ALONG THE MOTION DIRECTION

[0034] The dose deposition distribution both within a given target product (1) and between different target products, along the motion direction is substantially homogeneous because the target products travel at a generally constant rate through the irradiation volume or, in some embodiments, at varying rates, controlled for further enhancing homogeneity of the dose deposition distribution between different target products (1), as a function, for example, of their densities or the like. This is illustrated in Figure 2(b), wherein as the target product has passed through the irradiation volume (11x) of an apparatus according to the present invention, wherein the motion direction is parallel to the vertical axis (Z), such that the dose thus deposited is substantially homogeneous.

[0035] This is not the case, however, of the dose deposition distribution along the normal direction which can vary substantially depending on the irradiation conditions.

DOSE DEPOSITION DISTRIBUTION ALONG THE NORMAL DIRECTION

[0036] Figure 2(a) shows the dose deposition distribution in an apparatus according to the present invention along the normal direction, which is parallel to the longitudinal axis (Y) for an apparatus according to the present invention. It can be approximated to a parabola centred on the irradiation axis —i.e., the longitudinal axis (X) for an apparatus according to the present invention— with a maximum of dose deposition at the vertex at the level of the irradiation axis and decreasing as distance on either side from the irradiation axis increases along the normal direction (i.e. the longitudinal axis (Y)). The dose deposition distribution along a direction (i) within a given target product (1) can be quantified by the dose uniformity ratio (DUR_i), defined as the ratio (DM_i / D_{mi}) of the maximum dose (DM_i) to minimum dose (D_{mi}) deposited along the axis (i). A value of DUR_i close to 1 is indicative of a homogeneous dose deposition distribution, with DUR_i = 1 corresponding to a flat dose distribution. A value of DUR >> 1 is indicative of a larger variation of dose deposition along the direction (i).

[0037] The DUR along the normal direction can be reduced by increasing the irradiation span of the parabolic dose deposition pattern or, in other terms, by flattening the tip of the parabola relative to the size of the target product along the normal direction. The difference, $\Delta D_y = DM_y - D_{my}$, of dose depositions in the target product (1) along the normal direction can be reduced by reducing a scanning ratio (w_1 / w_x) of a target product size (w_1) to an irradiation span (w_x), both measured along the normal

direction. The irradiation span (w_x) can be controlled by the scan horn (11h, 12h), which modifies the dimensions of the parabolic dose deposition pattern. Although from a theoretical point of view, an infinite irradiation span (w_x) would be desirable, in practice the irradiation span (w_x) is strongly limited and increasing w_x with a larger scan horn is more than proportionally expensive.

5 DUR vs HEIGHT (h) OF THE TARGET PRODUCTS (1)

[0038] The DUR along the normal direction depends on the scanning ratio (w_x / w_1). Whilst the irradiation span (w_x) can be controlled at the level of the apparatus, this is not the case of the target product size (w_1), which obviously depends on the target product which is being presented to the first source of X-ray (11). It may not be feasible to impose a unique dimension to all the target products being conveyed before the first source of X-ray.

- In apparatuses according to the prior art (cf. Figures 1(a), 1(b), and 5(a)), the target product size (w_1) measured along the normal direction is the height (h) measured along the vertical axis (Z) (i.e., $w_1 = h$),
- In apparatuses according to the present invention (cf. Figures 1(c) and 5(b)), the target product size (w_1) measured along the normal direction is the width (w_1) measured along the transverse axis (Y) (i.e., $w_1 = w$)

[0039] The height (h) of the target products varies substantially more than the width (w_1) thereof, which is limited by the width of the pallets (2). This means that the variations on the scanning ratio (w_1 / w_x) is substantially higher when the target product size (w_1) is the height (h) of the target products (i.e., $w_1 = h$) as is the case with prior art apparatuses, than if the target product size (w_1) is the width (w) of the target products, as with the apparatus of the present invention. It follows that, with the apparatus of the present invention, a single scan horn (11h, 12h) of limited size suffices to ensure a substantially homogeneous dose deposition between different target products (1) of different dimensions on a same irradiation line, as well as an agreeably homogeneous dose deposition within a given target product (1) regardless of the height (h) of the target product (1).

[0040] For example, the scanning ratio (w_1 / w_x) of a target product width (w_1) to an irradiation span (w_x), both measured along the transverse axis (Y) (corresponding to the normal direction) can be comprised between 30% and 65%, preferably between 35% and 55%, more preferably between 40%, and 50%. As discussed supra, the value of the irradiation span (w_x) is controlled at least partly by the scan horn (11h, 12h), which can be configured for yielding an irradiation span (w_x) preferably of $220 \text{ cm} \pm 20 \text{ cm}$. The target product width (w_1) is limited by and therefore not greater than the width of the pallet the target product rests upon. The pallets width (w_2) is generally of the order of $100 \text{ cm} \pm 20 \text{ cm}$. Approximately the same applies to the containers generally used in the art.

[0041] In a preferred embodiment of the present invention, the vertical dose uniformity ratio (DUR_z)

defined as a ratio (DM_z / Dm_z) of a maximum dose (DM_z) to a minimum dose (Dm_z) deposited into a good (1g) at a given value of depth of penetration (x_1, x_2) along the irradiation axis (X), over the vertical axis (Z) (corresponding to the motion direction) between a bottom of the good and a top of the good is not more than 1.2, preferably not more than 1.1, more preferably not more than 1.05, for a uniform good density of 0.1 g / cm³.

DUR_{yz} OVER THE IRRADIATION PLANE (X, Y)

[0042] Figures 3(a) to 3(c) show dose deposition distributions into a target product (1) over planes (i, j), with each of i and j being one of X, Y, Z. Figure 3(a) shows the doses deposited over the base plane (X, Y) by first and second sources of X-ray (11, 12). Figure 3(b) shows the doses deposited over the irradiation plane (Y, Z) at given values x_1 and x_2 of X. Figure 3(c) shows the doses deposited over a plane (X, Y) at a given value y_1 of Y. In all cases the corresponding values of the maximum and minimum values (DM_{ij}, Dm_{ij}) and dose deposition variation ($\Delta D_{ij} = DM_{ij} - Dm_{ij}$) of doses deposited on the planes (i, j) are indicated.

[0043] The planar dose uniformity ratio (DUR_{yz}) over the irradiation plane (Y, Z) normal to the longitudinal axis (X) (corresponding to the irradiation axis), defined as the ratio (DM_{yz} / Dm_{yz}) of a maximum dose (DM_{yz}) to a minimum dose (Dm_{yz}) deposited into a good over the irradiation plane (Y, Z) for any value of penetration depth (x_1, x_2) along the longitudinal axis (X) is preferably lower than 1.7, more preferably lower than 1.5, more preferably lower than 1.4, most preferably lower than 1.35, for a target product having a uniform density of 0.1 g / cm³ (cf. Figure 3(b)). Since $DUR_z \simeq 1$, it follows that $DUR_{yz} \simeq DUR_y$. Prior art apparatuses are generally characterized by a DUR over the irradiation plane of the order of greater than 1.7 and even of 1.8. The same can be said of $DUR_{xz} \simeq DUR_x$, because $DUR_z \simeq 1$ (cf. Figure 3(c)).

DOSE DEPOSITION DISTRIBUTION ALONG THE IRRADIATION AXIS (X)

[0044] The dose deposition distribution along the irradiation axis (X) into a target product by a single X-ray source (11) is illustrated in Figures 2(a) and 2(b) (bottom graphs). In order to decrease the difference between DM_x and Dm_x , it can be preferable to irradiate the target good from different orientations. In one embodiment, each target product (1) rotates continuously or intermittently about the vertical axis (Z) as it stands within the irradiation volume of the first source of X-ray (11). For example, the conveyor may comprise a rotating element configured for rotating (N – 1) times a target product by $2\pi / N$ rad to successively expose N portions of the target products (1) to the first irradiation volume (10x). In general, N can be equal to 2 or 3, or 4. Preferably, N = 2 and the rotation is of π rad (= 180°).

[0045] Alternatively, the conveyor may drive each target product (1) N times (preferably twice) in front of a single source of X-ray (11), exposing diametrically opposed surfaces of the target product. The foregoing solutions improve the homogeneity of the dose deposition distribution along the irradiation

axis (X) but they also prolong the treatment time, as rotating or passing a second time the target products is time-consuming.

[0046] In another embodiment illustrated in Figures 1(c) and 5(b) (in dotted lines), the apparatus may comprise a second source (12) of X-rays configured for emitting X-rays (12x) along a second irradiation volume centred on a second longitudinal axis (X2) such as to irradiate a second portion of the target products (1). The second longitudinal axis (X2) is preferably parallel to, more preferably coaxial with the first longitudinal axis (X), and irradiation proceeds in a direction opposite to the irradiation by the first source of X-rays (11). This solution is more expensive than the previous ones, as it requires a second source of X-rays (12) but it allows a faster and continuous irradiation of the target products (1) as they do not need to be rotated or recirculated. The second source (12) of X-rays can be positioned such as,

- to irradiate a target product (1) simultaneously with the first source (11) of X-rays, or such as
- to irradiate a target product (1x) previously irradiated with the first source (11) of X-rays (as shown in Figures 1(c) and 5(b)).

[0047] The resulting dose deposition distribution along the irradiation axis (X) by irradiating $N = 2$ opposed surfaces of a target product (1) is illustrated at the bottom graph of Figure 3(c). Figure 3(c) shows first and second sources of X-rays (11, 12), but the same result is obtained by rotating by an angle π rad ($= 180^\circ$) or by recirculating the target product a second time before the first source of X-rays (11). By comparing Figures 2(a) with Figure 2(c), it can be seen that the dose deposition variation (ΔDx) obtained by irradiating a single portion of the target products along the irradiation axis (X) can be reduced substantially to a value $\Delta Dx_2 < \Delta Dx$, by exposing $N = 2$ opposite portions of the target products to X-ray irradiation along the irradiation axis (X).

DOSE DEPOSITION DISTRIBUTION OVER PLANES (X, Y) AND (X, Z) INCLUDING THE IRRADIATION AXIS (X), WITH $N = 2$

[0048] The resulting dose deposition distributions over a plane (X, Y) and over a plane (X, Z) by irradiating $N = 2$ opposed surfaces of a target product (1) are illustrated in Figures 3(a) and 3(c), respectively. The dose deposition distribution over the plane (X, Y) illustrated in Figure 3(a) has a horse-saddle shape, due to the combination of, on the one hand, the attenuation of the cumulative doses deposited by first and second sources of X-rays (11, 12) along the irradiation axis (X) and, on the other hand, by the parabolic dose deposition pattern along the transverse axis (Y) discussed supra. The attenuation along the irradiation axis (X) is controlled by the absorption of the materials being irradiated and the depth of penetration of the X-rays. Solutions have been discussed supra for mitigating said attenuation, e.g., by rotating the target product (1) about the vertical axis (Z) within the irradiation volume. But apart from these solutions, there is no other way to limit the attenuation of the X-ray along the irradiation or longitudinal axis (X), as the X-radiation penetrates deeper into the target products (1x).

[0049] The parabolic dose deposition distribution along the transverse axis (Y) can be flattened to

reduce the dose deposition span ($\Delta Dy = DMy - Dmy$) by decreasing the scanning ratio ($w1 / wx$) by increasing the irradiation variation (wx) with an appropriate scan horn. Flattening the parabolic dose deposition distribution decreases the difference, $\Delta Dy = DMy - Dmy$, and hence drives the value of $DURy = DMy / Dmy$ closer to unity. The value of the scanning ratio is a compromise between
 5 optimization of the $DURy$ and cost.

CONVEYOR

[0050] As illustrated in Figures 1(c) and 5(b), the conveyor is preferably configured for moving the goods along the longitudinal axis (X) both before and after driving the goods along the vertical axis (Z) to expose the first portion of the goods in front of the first irradiation volume (11x). In the embodiment
 10 of Figure 1(c), the pallets are pivotally fixed to a conveyor rail such that the base plane remains constantly horizontal (parallel to the axes (X, Y)) regardless of the orientation of the rail. The rail comprises a horizontal portion (3h) followed by a vertical portion (3v), by driving through a guide, such as a cylindrical guide or drum. The target products (1) are driven vertically in the vertical portion (3v) in front of the first, and optionally second source(s) of X-ray (11, 12). Once irradiated, the target products
 15 (1x) can be guided to proceed horizontally again, along a second horizontal portion (3h). But it is preferred, as illustrated in Figure 1(c), that the target products be driven vertically back prior to being guided to the second horizontal portion (3h) to the same level as the first horizontal portion (3h). This solution is advantageous in terms of energy saving as the weight of the target products (1x) being driven down can be used to drive the target products (1) up. In Figures 1(c) and 5(b), the target products are
 20 first driven up and then driven down. It is clear that the other way round is also possible, with the target products being driven down first and then driven up again to the same level as the first horizontal portion (3h), depending on the architecture of the workshop hosting the apparatus.

[0051] The apparatus of Figure 1(c) is depicted with first and second sources of X-rays (11, 12). It is clear that it may comprise a single source of X-ray, either the first or the second source only. As
 25 discussed supra, even with a single source of X-ray, the target products can be irradiated over several portions thereof, e.g., by rotating the target products.

[0052] In a preferred embodiment, the conveyor comprises a mechanism configured for ensuring that a top surface of a first target product be substantially equidistant from a bottom surface of a second target product located adjacent to and downstream from the first target product as they are driven along
 30 the vertical axis (Z), regardless of a height measured along the vertical axis (Z) of the target products.

[0053] For example, the target products can be fixed to the conveyor of the apparatus of Figure 1(c), at fixed positions of a moving element of the conveyor, which they keep during the whole duration of the treatment. The fixing position of the target products can be optimized by measuring the height (h) of each target product prior to fixing it to the moving element of the conveyor, and calculating the optimal
 35 relative positions of adjacent target products to ensure that when they reach the vertical portion (3v) of

the conveyor, the gap separating the top of any target product from the bottom of the adjacent target product located downstream thereof be constant (the terms “upstream” and “downstream” are expressed relative to the motion direction of the target products).

5 [0054] Alternatively, the target products are not coupled to a fixed point of the moving element of the conveyor, but the mechanism comprises instead a detachable mechanism for varying a drive speed along the longitudinal axis (X) prior to changing direction of drive along the vertical axis, such as to ensure a constant gap between adjacent target products as they are driven through the irradiation volume (11x, 12x).

10 [0055] Figure 5(b) shows an alternative embodiment, wherein the goods, preferably enclosed in containers, are laid on top of pallets (2) provided with coupling elements jutting out on either side along the longitudinal axis (Y). The pallets (2) are conveyed over the first horizontal portion (3h) and upon reaching the vertical portion (3v), the coupling elements engage mating receiving elements belonging to the conveyor, which drive the target products vertically along the vertical axis (Z) through the irradiation volume (11x, 12x). Again, the relative positions of the target products (1) in the first horizontal
15 portion (3h) can be determined as a function of the heights, previously measured, of the target products, such as to keep a constant gap between adjacent target products in the vertical portions of the conveyor. Alternatively, the conveyor may comprise a detachable mechanism for varying a drive speed along the longitudinal axis (X) prior to changing direction of drive along the vertical axis.

20 [0056] In one embodiment, the vertical portion (3v) of the conveyor is configured for driving the target products (1) through the irradiation volume, along the vertical axis (Z) at a constant speed. This is a simple and reliable embodiment.

[0057] In a more sophisticated embodiment, the vertical portion (3v) of the conveyor is configured for driving the target products (1) through the irradiation volume, along the vertical axis (Z) at different speeds, depending on the target product being irradiated. For example, the speed for a given target
25 product can be varied upon crossing the irradiation volume, based on the density of the goods, or on the depth (d) of the target product measured along the longitudinal (and irradiation) axis (X). This embodiment requires measurement of the parameter, or retrieval thereof from a database or from a machine-readable information label provided on the target product. It also requires a detachable mechanism for varying a drive speed along the vertical axis (Z) depending on the value of the
30 parameter. This embodiment ensures a higher homogeneity the X-ray treatment between different target products of different densities or sizes.

METHOD FOR IRRADIATING GOODS WITH X-RAYS

[0058] The apparatus of the present invention can advantageously be used in a method for irradiating with X-rays (11x, 12x) goods (1) loaded on pallets (2) comprising the following steps,

- 35
- providing an apparatus as discussed supra,

- driving the goods (1) through the irradiation volume, along the vertical axis (Z),
- irradiating the goods with X-ray as the goods are driven through the irradiation volume.

[0059] This very simple, easy to implement solution allows a substantial enhancement of the uniformity of the dose deposition distribution into the goods with a single, standard size scan horn (11h, 12h), as can be quantified, e.g., by the dose uniformity ratio, $DUR = DM / Dm$. This means that the programmed parameters of the X-ray along the first irradiation volume are independent of a height measured along the vertical axis (Z) of the goods loaded on each pallet and can be maintained constant regardless of the height of the target products.

[0060] As discussed supra, the goods (1) can be driven through the irradiation volume, along the vertical axis (Z) at a constant speed. Alternatively, they can be driven at different speeds depending on some parameters of the goods, such as their densities, the depth (d) of the target product, and the like. This guarantees an enhanced homogeneity of treatment between target products differing substantially in one or more of the foregoing parameters.

REF	DESCRIPTION
1	Target product
1g	Goods
1x	X-ray irradiated target product
2	Pallet
3h	Horizontal portion of the conveyor
3v	Vertical portion of the conveyor
11	First source of X-ray
11h	Scan horn of first source of X-ray
11x	First irradiation volume
12	Second source of X-ray
12h	Scan horn of second source of X-ray
12x	Second irradiation volume
d	Dimension of the target product along the longitudinal axis (X)
DMi	Maximum dose deposition rate along a direction or plane I, with $i = x, y, z, xy, yz, \text{ or } yz$
Dmi	Minimum dose deposition rate along a direction or plane I, with $i = x, y, z, xy, yz, \text{ or } yz$
DUR	Dose uniformity ratio
DURi	Dose uniformity ratio $DURi = DMi / Dmi$, with $i = x, y, z, xy, yz, \text{ or } yz$
h	Dimension of the target product along the vertical axis (Z)
wx	Dimension of the irradiation volume along the longitudinal axis (Y)
w1	Dimension of the target product along the longitudinal axis (Y)
X	Longitudinal directiON
Y	Transvere direction
Z	vertical direction
ΔDi	$= DMi - Dmi$, with $i = x, y, z, xy, yz, \text{ or } yz$
$\Delta Dx2$	$= \Delta Dx$, with $N = 2$ sources of X-rays

CLAIMS

1. Apparatus for irradiating goods (1g) with X-rays (11x, 12x), comprising
 - A first source (11) of X-rays configured for emitting X-rays along a first irradiation volume (11x) centred on a longitudinal axis (X),
- 5 • A conveyor (3h, 3v) configured for driving goods such as to expose a first portion of the goods (1g) through the first irradiation volume, the goods forming target products (1), and being preferably loaded on pallets (2) and / or in containers, each target product (1) being inscribed within a prismatic volume defined by a base plane and a height (h), wherein during conveying the base plane extends along the longitudinal axis (X) and a transverse axis (Y) normal to the longitudinal axis (X), and the height (h) extends

10 along a vertical axis (Z) normal to the base plane (X, Y),

Characterized in that, the conveyor (3v) is configured for driving the target products (1) through the irradiation volume, vertically along the vertical axis (Z).
2. Apparatus according to claim 1, wherein the conveyor comprises a rotating element configured for rotating (N – 1) times a target product by $2\pi / N$ rad to successively expose N portions of the target products (1)

15 to the first irradiation volume, wherein preferably, N = 2, 3, or 4.
3. Apparatus according to claim 1, comprising a second source (12) of X-rays configured for emitting X-rays along a second irradiation volume (12x) centred on a second longitudinal axis such as to irradiate a second portion of the target products, wherein the second longitudinal axis is preferably parallel, more preferably coaxial to the first longitudinal axis (X), and irradiation proceeds in a direction opposite to the irradiation by the first source of

20 X-rays.
4. Apparatus according to claim 3, wherein the second source (12) of X-rays is positioned such as,
 - to irradiate a target product (1) simultaneously with the first source (11) of X-rays, or such as
 - to irradiate a target product (1) previously irradiated with the first source (11) of X-rays.
5. Apparatus according to anyone of the preceding claims, wherein the conveyor comprises first and second

25 horizontal portions (3h), configured for moving the goods along the longitudinal axis (X) both upstream and downstream of a vertical portion (3v) of the conveyor driving the target products parallel to the vertical axis (Z), to expose the first portion of the target products to the first irradiation volume (11x).
6. Apparatus according to the preceding claim, wherein the conveyor comprises a mechanism configured for ensuring that a top surface of a first target product be substantially equidistant from a bottom surface of a second

30 target product located adjacent to and downstream from the first target product as they are driven along the vertical axis (Z), regardless of a height measured along the vertical axis (Z) of the target products, wherein the mechanism preferably includes a detachable mechanism for varying a drive speed along the longitudinal axis (X) prior to changing direction of drive along the vertical axis.
7. Apparatus according to anyone of the preceding claims, wherein the conveyor comprises a vertical portion

35 (3v) configured for driving the target products (1) through the irradiation volume, along the vertical axis (Z) at a

constant speed.

8. Apparatus according to anyone of claims 1 to 4, wherein the conveyor comprises a vertical portion (3v) configured for driving different target products (1) through the irradiation volume, along the vertical axis (Z), at different speeds, depending on the target product properties.

5 9. Apparatus according to anyone of the preceding claims, wherein a vertical dose uniformity ratio (DUR_z) defined as a ratio (DM_z / Dm_z) of a maximum dose (DM_z) to a minimum dose (Dm_z) deposited into a target product over the vertical axis (Z) between a bottom of the good and a top of the good is not more than 1.2, preferably not more than 1.1, more preferably not more than 1.05, for a uniform good density of 0.1 g / cm³.

10 10. Apparatus according to anyone of the preceding claims, wherein a scanning ratio (w_1 / w_x) of a target product width (w_1) to an irradiation span (w_x), both measured along the transverse axis (Y) is comprised between 30% and 65%, preferably between 35% and 55%, more preferably between 40%, and 50%, and wherein a value of the irradiation span (w_x) is controlled at least partly by a scan horn, and wherein the target product width (w) is preferably 100 cm \pm 20 cm, and wherein the irradiation span (w_x) is preferably 220 cm \pm 20 cm.

15 11. Apparatus according to anyone of the preceding claims, wherein a planar dose uniformity ratio (DUR_{yz}) defined as a ratio (DM_{yz} / Dm_{yz}) of a maximum dose (DM_{yz}) to a minimum dose (Dm_{yz}) deposited into a target product over a plane (Y, Z) normal to the longitudinal axis (X) for any value of penetration depth (x_1, x_2) along the longitudinal axis (X) is lower than 1.7, more preferably lower than 1.35, for an uniform good density of 0.1 g / cm³.

20 12. Method for irradiating with X-rays (11x, 12x) goods (1) loaded on pallets (2) comprising the following steps,

- Providing an apparatus according to anyone of the preceding claims,
- driving the target products (1) through the irradiation volume, along the vertical axis (Z),
- irradiating the goods with X-ray as the goods are driven through the irradiation volume.

13. Method according to the preceding claim, wherein the target products (1) are driven through the irradiation volume, along the vertical axis (Z) at a constant speed.

25 14. Method according to claim 12 or 13, wherein the target products are substantially equidistant from one another as they are driven along the vertical axis (Z), regardless of a height measured along the vertical axis (Z) of the target products.

15. Method according to anyone of claim 12 to 14, wherein parameters of the X-ray along the first irradiation volume are independent of a height measured along the vertical axis (Z) of the target products.

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