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DESCRIPTION

TECHNICAL FIELD

[0001] The present invention relates generally to producing elongated glass components, and particularly to using a gripper system to produce large glass preforms with low bow.

BACKGROUND

[0002] Typically, preforms for quartz glass tubing, rods, or collapsed offline rods-in-cylinders (RICs) are produced by introducing a quartz glass component (e.g., a cylinder, an ingot, or an uncollapsed RIC) into an apparatus including a heating zone (e.g., a furnace) in a vertical orientation such that the lower end begins to soften and form a strand. The strand is then placed in a pulling device including one or more sets of pulling wheels. The rate of draw of the strand is controlled by the speed of the pulling wheels, which may apply either a downward or upward force depending on the forming zone temperature or viscosity and the weight of the strand supported by the wheels. Forming is accomplished without the aid of a die thus the strand dimensions are controlled by the feed rate of the quartz glass component, the temperature of the heating zone, and the speed of the pulling wheels.

[0003] Alternatively, the preform may be formed by fusing quartz sand by electricity or by flame in a furnace and extracting a strand from the furnace by pulling through a die. The strand is then placed into the pulling device as described above.

[0004] In either case, due to the small contact areas between the pulling wheels and the preform, the amount of force that can be applied to the preform by the pulling wheels is limited because excessive pressure can damage the glass surface of the preform. For large preforms that require a greater pulling force than can be applied by a single set of pulling wheels, multiple sets of pulling wheels may be applied to the strand at different levels to achieve the necessary total force. However, multiple sets of pulling wheels increase both apparatus height and cost. Further, low bow can only be achieved with multiple sets of pulling wheels if the sets of pulling wheels are precisely aligned, which is difficult to achieve in practice.

[0005] Referring to FIG. 1A, bow is understood to be a degree of curvature in the glass component, such as glass rod **10**. In the example depicted in FIG. 1A, the bow for the glass rod **10** with a single radius of curvature can be defined in terms of a horizontal offset x per length Z , or more commonly, by the maximum "camber" (deviation from the straight line "chord") of $x/2$ over the length Z , all typically expressed as millimeters/meter (mm/m). However, bow may also be described as a radius R of a curvature **12** for any point along the glass component. A greater radius of curvature reflects a lesser degree of bow present for that point of the glass component. In fact, it can be easily shown that to a very good approximation

$$R = Z^2 / (2 * x) \text{ (Equation 1).}$$

[0006] Referring to FIG. 1B, a glass component is formed by pulling a molten strand **15** as described above at a linear downward velocity **V**. This results in a frozen strand length $V * t$ after a time **t**. However, if the molten strand **15** experiences a transverse or perpendicular force to the glass draw direction **V** with an acceleration $V_{\perp}'$ (i.e. the time derivative of the transverse velocity $V_{\perp}$) then bow can form and be frozen into the strand. As depicted in FIG. 1C, if $V_{\perp}$ is zero (which also means $V_{\perp}'$ is zero), then after a time **t** the strand has a length of $V * t$ but the offset $x (=V_{\perp} * t)$ remains at zero so the strand is straight and does not have any bow. However, if $V_{\perp}'$ is not zero, then after a time **t** the strand has a length of $V * t$ but the bottom of the strand is offset by a distance $\frac{1}{2} V_{\perp}' * t^2$, as depicted in FIG. 1D. In the case where both the draw speed **V** and the transverse acceleration $V_{\perp}'$ are constant, the radius **R** of the bow in strand **15** will remain constant and it is equal to $V^2/V_{\perp}'$. This can be derived from Equation 1 as follows:

$$Z = V * t$$

$$x = \frac{1}{2} V_{\perp}' * t^2$$

$$R = Z^2 / (2 * x) = V^2 / V_{\perp}' \text{ (Equation 2)}$$

Accordingly, bow is minimized by minimizing the amount of the perpendicular or transverse acceleration $V_{\perp}'$ or equivalent perpendicular or transverse force experience by the molten strand before it is frozen. It is noted that while the pulling direction **V** is typically substantially vertical to minimize any gravitational contributions to $V_{\perp}'$, the pulling direction **V** may be in directions other than strictly vertical as long as the transverse force or acceleration is minimized for low bow. In fact, if $V_{\perp}'$ is zero but both **V** and $V_{\perp}$ are constant the strand can still be pulled straight without bow or curvature in a non-vertical direction with non-zero offset $x (=V_{\perp} * t)$.

[0007] In general, the bow or curvature of the glass component in any drawing process is simply a frozen record of how the glass is drawn or flows out of the furnace. No matter how complicated the preform or tube curvature is, at any given point (with an infinitesimal length) on the curvature it can always be described by a vector whose magnitude is the radius of curvature and whose direction is defined by the normal vector of the plane that contains the curvature of the infinitesimal length. This is a mathematically rigorous and complete description of any curvature in three dimensional space. The radius of curvature **R** at any given point can be again given by Equation 2, that is $R = V^2/V_{\perp}'$, just like the example considered above, where **V** is the instantaneous glass flow velocity at the given point and $V_{\perp}'$ is the acceleration or time derivative of the perpendicular or transverse velocity component $V_{\perp}$ relative to the velocity vector **V**. These general relationships among the radius of curvature, the draw velocity and the transverse acceleration or force in Equation 2 can easily be seen by noting the close analogy of a particle of mass **m** moving in a circle of radius **R** and at speed **V**: the centripetal force it experiences is $(m * V^2 / R)$ or the centripetal (i.e. transverse or perpendicular) acceleration is $V_{\perp}' = V^2 / R$.

[0008] Bow is undesirable for most applications where the input component is a glass rod or preform. Many applications require welding or joining a glass rod with another glass component in a glass working lathe. Bow "runout" or "wobble" in the free end of a chucked quartz rod makes it difficult to achieve a concentric and straight weld. In the case of fiber draw, a handle is welded to the top of the preform. The preform is held by the welded handle above a draw furnace in a chuck or holder and then the bottom of the preform is lowered to the furnace melt zone. Fiber is drawn from the bottom end of the preform. As preform glass is consumed during fiber drawing, the preform is lowered continuously into the melt zone. If the preform has bow, the bottom end of the preform will follow the bow and the melt zone will be offset relative to the center of the draw furnace resulting in undesirable asymmetric glass flow in fiber draw. Also, in fiber drawing it is often desirable to have the smallest possible annular gap between the preform and a sealing mechanism on the top of the draw furnace. The clearance required is a direct function of the preform bow.

[0009] Bow is also undesirable for overclad tubes used in the manufacture of Rod-in-Tube (RIT) optical fiber preforms because bowed overclad tubes make insertion of core rod difficult. The overclad tube bow also in effect results in larger overclad gaps which tend to increase the fiber core eccentricity that is detrimental to optical fiber performance.

[0010] Recent attempts have been made to replace fixed-position pulling wheels with guide elements that attach to the strand and are able to move vertically along with the strand. An example of such an attempt may be found in U.S. Patent No. 6,938,442. JP2006327898A discloses an apparatus for forming a glass strand by elongation of an initial glass preform wherein the apparatus employs gripping tools for holding and drawing the glass strand. A first chuck is capable of vertically moving by gripping a supporting rod attached to the strand which is heated by a heating furnace and pulled out downward. A second chuck and a third chuck are provided which are individually movable up and down by the vertical movement mechanism respectively. JP3864463B2 discloses an apparatus for elongating an initial base material using upper and lower chucks. The upper chuck and the lower chuck are movable in the axial direction of the furnace and the positions and angles in the x and y axis directions can be adjusted. Before stretching is started the position and angle of the chucks are adjusted so that the centre axis of the base material is aligned with the central axis of the furnace. During this stretching, the above adjusted chuck position and angle are maintained. However, such devices still require precise alignment of the guide elements to ensure that bow is not introduced into the strand and are not capable of adjusting the position of the guide elements to prevent misalignment. Accordingly, an apparatus for forming glass preforms including adjustable guide elements is desirable.

SUMMARY

[0011] The invention provides for an apparatus and methods for forming an elongated glass component with low bow. In one embodiment, the apparatus includes a heating element to

heat a bulk glass component where a strand may be drawn from the bulk glass component in a downward z direction, and a gripper device. The gripper device includes a clamping element to support the strand and move linearly with the strand while pulling or drawing it from the bulk glass component in a linear motion and a low-friction mounting element attached to the clamping element which allows translational movement in an x-y plane, where the z direction is defined by the direction in which the strand is drawn. Because the mounting element is low-friction, a force applied to the clamping element by the glass component will result in the clamping element being deflected along the mounting element rather than the clamping element applying a resistive transverse force to the glass component, minimizing the risk of introducing bow.

[0012] In another embodiment, an elongated component of glass with low bow may be produced by heating a bulk glass component to form a strand, determining a center of the strand, aligning a clamping element of a gripper device with the center of the strand, and moving the gripper device in a linear downward direction away from the bulk glass component to lengthen the strand. The gripper device further includes a low-friction mounting element attached to the clamping element which allows translational movement of the clamping element in an x-y plane, wherein the z direction is defined by the direction in which the strand is drawn. Because the mounting element is low-friction, the position of the strand is not disturbed by the clamping element clamping to the strand in the event of misalignment.

[0013] In another embodiment, bow may be corrected in an elongated component of glass being drawn from a bulk glass component by attaching a gripper device to a strand including a clamping element, and a mounting element attached to the clamping element which allows translational movement of the clamping device in an x-y plane; measuring an amount of transverse acceleration in the strand; and moving the clamping element attached to the strand on the mounting element in the opposite direction of the transverse acceleration to reduce the amount of bow in the strand. The amount of transverse acceleration of the strand may be measured by determining the transverse displacement of the strand at multiple points over time.

BRIEF DESCRIPTION OF DRAWINGS

[0014] The invention is best understood from the following detailed description when read in connection with the accompanying drawings. It is emphasized that, according to common practice, the various features of the drawings are not to scale. On the contrary, the dimensions of the various features are arbitrarily expanded or reduced for clarity. Included in the drawings are the following figures:

FIG. 1A is a side view of a bowed glass component;

FIG. 1B is a side view of a glass component with a first drawn length;

FIG. 1C is a side view of the glass component of FIG. 1B after being pulled to a second drawn

length without introducing bow;

FIG. 1D is a side view of the glass component of FIG. 1B after being pulled to a second drawn length while introducing bow;

FIG. 2A is a side view of an apparatus for forming an elongated glass component with low bow including a first gripper device attached to a strand, according to an embodiment of the invention;

FIG. 2B is a side view of the apparatus of FIG. 2 after the strand has been drawn to a second length, according to an embodiment of the invention;

FIG. 3A is a side view of an apparatus producing a bowing strand, according an embodiment of the invention;

FIG. 3B is a side view of the apparatus of FIG. 3A, after a gripper device has been attached to the bowed strand and pulled down linearly to prevent bow from propagating in the strand, according an embodiment of the invention;

FIG. 3C is a side view of the apparatus of FIG. 3A after a gripper device has been attached to the bowing strand, according an embodiment of the invention;

FIG. 3D is a side view of the apparatus of FIG. 3C, after the gripper device has been moved the strand to dampen transverse acceleration in the forming zone, according an embodiment of the invention;

FIG. 4A is a side view of an apparatus for forming a glass strand with low bow including three gripper devices attached to a strand, according to an embodiment of the invention;

FIG. 4B is a side view of the apparatus of FIG. 4A, where the three gripper devices have been moved downward to lengthen the strand, according an embodiment of the invention;

FIG. 4C is a side view of the apparatus of FIG. 4B, where the top gripper device has been detached from the strand, according an embodiment of the invention;

FIG. 4D is a side view of the apparatus of FIG. 4C, where the top gripper device has been reattached to the strand at a higher height, according an embodiment of the invention;

FIG. 4E is a side view of the apparatus of FIG. 4D, where the middle gripper device has been detached from the strand, according an embodiment of the invention;

FIG. 4F is a side view of the apparatus of FIG. 4E, where the middle gripper device has been reattached to the strand at a higher height below the top gripper device, according an embodiment of the invention;

FIG. 4G is a side view of the apparatus of FIG. 4F, where the bottom gripper device has been detached from the strand, according an embodiment of the invention;

FIG. 4H is a side view of the apparatus of FIG. 4G, where the bottom gripper device has been

reattached to the strand at a higher height below the middle gripper device, according an embodiment of the invention;

FIG. 4I is a side view of the apparatus of FIG. 4H, where the strand has been cut below the bottom gripper device, according an embodiment of the invention;

FIG. 4J is a side view of the apparatus of FIG. 4H, where the strand has been cut above the bottom gripper device, according an embodiment of the invention;

FIG. 5A is a side view of an apparatus for starting a process for forming a glass strand with low bow including three gripper devices and a removable pulling wheel device below the gripper devices, where the pulling wheel device is attached to a drip formed from a bulk glass component, according to an embodiment of the invention;

FIG. 5B is a side view of the apparatus of FIG. 5A, where the pulling wheel device has increased the diameter of the drip to form a strand, according to an embodiment of the invention;

FIG. 5C is a side view of the apparatus of FIG. 5B, where the pulling wheel device has increased the diameter of the strand and the gripper devices have been attached to the strand, according to an embodiment of the invention;

FIG. 5D is a side view of the apparatus of FIG. 5C, where the pulling wheel device has been removed and the strand has been cut, according to an embodiment of the invention;

FIG. 6A is a side view of an apparatus for starting a process for forming a glass strand with low bow including three gripper devices attached to a starting piece pre-welded to a bulk glass component, according to an embodiment of the invention;

FIG. 6B is a side view of the apparatus of FIG. 6A, where the three gripper devices have been moved downward to form a strand between the starting piece and the bulk glass component, according to an embodiment of the invention;

FIG. 6C is a side view of the apparatus of FIG. 6B, where the three gripper devices have been detached from the starting piece and reattached to the strand, according to an embodiment of the invention;

FIG. 6D is a side view of the apparatus of FIG. 6C, where the starting piece has been removed, according to an embodiment of the invention;

FIG. 7A is a side view of an apparatus for starting a process for forming a glass strand with low bow including three gripper devices attached to a starting piece separate from and below a bulk glass component in a heating element, according to an embodiment of the invention;

FIG. 7B is a side view of the apparatus of FIG. 7A, where the starting piece has been welded to the bulk glass component, according to an embodiment of the invention;

FIG. 7C is a side view of the apparatus of FIG. 7B, where the three gripper devices have been

moved downward to form a strand between the starting piece and the bulk glass component, according to an embodiment of the invention;

FIG. 7D is a side view of the apparatus of FIG. 7C, where the three gripper devices have been detached from the starting piece and reattached to the strand, according to an embodiment of the invention; and

FIG. 7E is a side view of the apparatus of FIG. 7D, where the starting piece has been removed, according to an embodiment of the invention.

DETAILED DESCRIPTION

[0015] Referring to FIG. 2A, an apparatus **200** used to form an elongated glass component such as a glass preform is provided. The apparatus **200** includes a gripper device **210** attached to a tower **220**, and a heating element **240**, such as a furnace. The gripper device **210** includes a frame **212**, clamping elements **214**, and mounting elements **216** attaching the clamping elements **214** to the frame **212**. The gripper device **210** may be mounted along a tower **220** by an attaching element **230** that allows the gripper device **210** to move vertically parallel to the length of the tower **220** (defined in FIG. 1 as the **Z** direction). In another embodiment, the mounting elements **216** may be attached directly to the tower **220** rather than to the frame **212** or the attaching element **230**. The mounting elements **216** allow translational movement of the clamping elements **214** in the **X** direction and the **Y** direction (i.e., to any position within the X-Y plane). In one embodiment, the mounting elements **216** are x-y tables including a pair of arms mounted on linear bearings or linear rails and a motor, for example a manual or servo motor drive, to control movement of the arms. The mounting elements **216** are further low-friction devices, so that a force applied to the clamping elements **214** by an external object will result in the clamping elements **214** being deflected along the mounting elements **216** rather than the clamping elements **214** applying a resistive force to the external object.

[0016] The apparatus **200** may be used to produce an elongated glass component by first heating a bulk glass component **250** in the heating element **240**. As is understood by those skilled in the art, certain steps included in the method may be omitted; certain additional steps may be added; and the order of the steps may be altered from the order illustrated. By heating the glass component **250** in the heating element **240**, the lower end of the bulk glass component **250** will soften and form the strand **260** due to gravity and the reduced viscosity of the glass component **250**. In other embodiments, the strand **260** may be formed by applying a pressure to the heated bulk glass component **250** to force a portion of the bulk glass component **250** through a die (not shown) in the desired shape of the strand **260**. In an exemplary embodiment, the temperature of the heating element **240** may range from approximately 1600 °C to 2200 °C. The glass strand **260** may be either a solid cylinder or a tube having a hollow interior and have a cross-sectional area ranging from approximately 1

cm² to approximately 400 cm², though greater and lesser cross-sectional areas are explicitly contemplated. It is noted that for a tube, the cross-sectional area does not include the hollow interior of the tube (e.g., for a tube with an outside diameter d_1 and an inside diameter d_2 , the cross-sectional area equals $\pi[(d_1/2)^2 - (d_2/2)^2]$). While the strand **260** is typically substantially round, the cross section of the strand **260** is not limited to a circle.

[0017] Once the strand **260** has formed, the gripper device **210** may be attached by moving the clamping elements **214** into contact with the strand **260**. The clamping elements **214** may be sized to have convex regions having the opposite shape of the strand **260**, so that the clamping elements **214** fit securely around the strand **260** without causing damage to the strand **260**. In other embodiments, the clamping elements may contact only a portion of the outside surface of the strand **260**. In an exemplary embodiment, the clamping elements **214** may be made of a high temperature compressible material such as calcium silicate, asbestos, compressed glass or ceramic fibers (e.g., rock wool) or high temperature rubber (e.g., silicone or fluoropolymer elastomers).

[0018] The clamping elements **214** are first aligned with the center of the strand **260** by determining the center of the strand **260** and then moving the clamping elements **214** into alignment with the strand center **265** in the Y direction. In some embodiments, the clamping elements **214** may be aligned to an estimated center of the strand, for example the expected center based on the desired draw path. In other embodiments, in order to more accurately align the clamping elements **214** with the strand **260**, the apparatus **200** may further include a sensing element capable of locating the center of the strand and a computer for determining the center of the strand from the output of the sensing element. The sensing element may include one or more laser devices, a camera/vision system, or a mechanical contact (dial indicator) system. In an exemplary embodiment, the sensing element may be attached to the gripper device **212** or may be external to the gripper device, for example attached to the tower **220**. In another embodiment, the sensing element may be external to both the gripper device **210** and the tower **220**, for example cameras **270**. Because the gripper device **210** includes further elements to prevent misalignment, it is not necessary for the gripper device **210** to perfectly aligned with the center of the strand.

[0019] Once the clamping elements **214** are aligned, the clamping elements **214** are brought into contact with the strand **260** by movement of the mounting elements **216** in the x direction. The mounting elements **216** may be moved by any suitable means, for example a motor used to control the pair of arms of an x-y table. Because the mounting elements **216** are low-friction devices, if the clamping elements **214** attempt to attach to the strand **260** while not properly aligned with the strand center, the force of the strand **260** pushing against the clamping elements **214** will move the clamping elements **214** into an aligned position instead of the strand **260** being moved. The mounting elements **216** may further include a locking mechanism that may be engaged and disengaged to prevent movement of the clamping elements **214** once the clamping elements are attached to the strand **260**. While the clamping elements **214** are being moved into position, the locking mechanism is unlocked, so that the

clamping elements **214** may be moved by the motor while still being displaced by any additional force applied to the clamping elements **214**. Once the clamping elements **214** are in contact with the strand **260**, the locking mechanism is engaged to prevent further movement of the clamping elements **214** in the X-Y plane.

[0020] To detect misalignment, in one embodiment the gripper device **210** further includes a force sensing device **218**, such as load cells, to sense reaction forces to measure the reaction force that occurs during the process of the clamping elements **214** attaching to the strand **260**. Load cells are transducers that convert a force applied to the clamping elements **214** to a strain gauge (not shown) of each load cell into an electrical signal. The electrical signal may then be measured and correlated to the force applied to the strain gauge. Exemplary load cells include hydraulic load cells, pneumatic load cells, and strain gauge load cells. Should the clamping elements **214** not be properly aligned the center of the strand **260**, the reaction force will be greater than if the clamping elements **214** are properly aligned. By measuring the reaction force with the force sensing element **218**, misalignment may be detected and corrected before the clamping elements **214** apply a force to the strand **260** sufficient to result in movement of the strand **260**. In one embodiment, the force sensing device **218** may be used in conjunction with the low-friction mounting elements **216**, where the speed at which the clamping elements **214** are attached to the strand **260** is slowed in response to a greater than expected reaction force in order to allow the clamping elements **214** to move on the mounting elements **216** into an aligned position. In an exemplary embodiment, the clamping elements **214** may be moved toward the strand **260** at a rate ranging from approximately 50 mm/min to approximately 100 mm/min while no misalignment is detected by the force sensing device **218**, and the rate reduced to approximately 10 mm/min to approximately 25 mm/min if misalignment is detected. In other applications, the clamping speeds may exceed these ranges.

[0021] Referring to FIG. 2B, once the clamping elements **214** are properly aligned and attached to the strand **260**, the gripper device **210** may be moved downward to draw the strand **260** to a longer length. A motor attached to the tower **220** may be used to control the rate at which the gripper device **210** is moved. The rate at which the gripper device **210** is moved downward controls the rate at which the strand is drawn and may range from approximately 0.2 mm/s to approximately 2.5 mm/s, though greater and lesser rates are explicitly contemplated.

[0022] Once the strand **260** reaches a desired length, the strand **260** may be cut and the gripper device **210** moved back to its original position and reattached to the strand **260**. While the desired length of the strand **260**, like the cross-sectional area of the strand **260** is application-specific, in an exemplary embodiment the desired length may range from approximately 1 m to approximately 3 m, with shorter and longer lengths explicitly contemplated.

[0023] Referring to FIGS. 3A-3D, embodiments further include using an apparatus **300** including a gripper device **310** (FIG. 3B) attached to a tower **320**, and a heating element **340**, such as a furnace to correct bow in a glass strand **360** including a bowed portion **365** during

the draw process. Like the gripper device **210** described above in conjunction with FIGS. 2A-2B, the gripper device **310** includes a frame **312**, clamping elements **314**, and mounting elements **316** attaching the clamping elements **314** to the frame **312**. The clamping elements **314** and the mounting elements **316** have the same features as described above for the clamping element **214** (FIGS. 2A-2B) and the mounting element **216** (FIGS. 2A-2B), respectively. The gripper device **310** may be mounted along the tower **320** by attaching element **310** that allows the gripper device **310** to move vertically parallel to the length of the tower **320**. In another embodiment, the mounting elements **316** may be attached directly to the tower **320** rather than to the frame **312** or the attaching element **330**.

[0024] In FIG. 3A, the glass strand **360** is being formed from a bulk glass component **350**. Because of a transverse acceleration $V_{\perp}'$ in the forming zone (i.e., the zone at and slightly below the heating element **340**), the bowed portion **365** forms in the strand, offsetting the strand **360** from the desired draw axis. The transverse acceleration $V_{\perp}'$ in the strand may be determined by measuring its transverse offset or displacement at multiple points over time using cameras **370** (e.g., laser, LED or camera gauges) which track the position of the strand **360** (including bowed portion **365**). The cameras **370** are preferably positioned at or immediately below the heating element such that they measure the strand position before the strand has solidified.

[0025] The gripper device **310** may be used to reduce the impact of bow in the strand in two ways. First, as depicted in FIG. 3A, if the bowed portion **365** has cooled to the point of no longer being malleable and the transverse acceleration has diminished, the gripper device **310** may attach to the strand **360** in the offset position and continue pulling down linearly. As a result, the strand portion **364** above the bowed portion will exit the forming zone without any bow and the effect of the initial transverse acceleration $V_{\perp}'$ will not propagate further. In contrast, an apparatus including a plurality of pulling wheels will always need to follow the existing or drawn preform curvature causing the top end of the solidified glass to sway in the x-y plane which will induce new bow from the molten glass and thereby further propagate or even amplify the bow problem. In effect, unless the pulling wheels are perfectly aligned and the drawn preform within the pulling wheels is perfectly straight (i.e. no bow), the pulling wheels will always convert some of the draw or pulling motion into a transverse acceleration component $V_{\perp}'$ at the molten glass, resulting in additional bow. In summary, the strictly linear pulling motion of the gripper system can: (1) minimize the transverse force or acceleration $V_{\perp}'$ experienced by the molten glass, (2) decouple any existing curvature or bow in the drawn preform from subsequent draw and prevent further bow formation and propagation, and (3) allow bow to recover or return to a low level after transient transverse $V_{\perp}'$ disturbances as long as the strictly linear pulling motion is maintained - all of these help to achieve low bow in draw.

[0026] As depicted in FIGS. 3C-3D, if the bowed portion **365** has not yet solidified (FIG. 3C), the gripper device **310** may move the strand **360** in the direction opposite the bow to apply a force to dampen or negate the transverse acceleration $V_{\perp}'$, thereby preventing bow from forming in the strand **360** (FIG. 3D). Accordingly, the gripper device **310** can both correct for transverse acceleration to prevent bow from forming and also adapt to bow already present in

the strand and prevent it from causing any additional bow in subsequent preform draw.

[0027] Referring to FIGS. 4A-4J, embodiments further include methods of producing an elongated glass component using multiple gripper devices attached to a strand. As is understood by those skilled in the art, certain steps included in the method may be omitted; certain additional steps may be added; and the order of the steps may be altered from the order illustrated. While FIGS. 4A-4J depict an apparatus **400** including three gripper devices (a top gripper device **410a**, a middle gripper device **410b**, and a bottom gripper device **410c**) attached to a tower **420**, and a heating element **440**, such as a furnace, other embodiments may include one gripper device (as described above in conjunction with FIGS. 2A-2B), two gripper devices, or four or more gripper devices. The top gripper device **410a**, the middle gripper device **410b**, and the bottom gripper device **410c** are substantially similar to the gripper device **210** described above. The gripper devices **410a-410c** may be mounted along a tower **420** that allows the gripper devices **410a-410c** to move vertically parallel to the length of the tower **420**.

[0028] Referring to FIG. 4A, the gripper devices **410a-410c** are attached to the strand **460** as described above for attaching the gripper device **210** to the strand **460**. In FIG. 4A, a strand **460** is being drawn from a bulk glass component **450**, with the gripper devices **410a-410c** distributed along the length of the strand **460**. Methods of beginning the production process are described in greater detail below in conjunction with FIGS. 5A-5D, 6A-6D, and 7A-7E. Referring to FIG. 4B, the gripper devices **410a-410c** are moved down the tower **420** to draw the strand **460** to a longer length. Referring to FIG. 4C, the top gripper device **410a** is unattached from the strand **460** while the strand **460** remains supported by the middle gripper device **410b** and the bottom gripper device **410c**. Referring to FIG. 4D, the top gripper device **410a** is moved back toward the top of the strand **460** and reattached to the strand **460**. Referring to FIG. 4E, once the top gripper device **410a** is reattached to the strand **460**, the middle gripper device **410b** is unattached from the strand **460** while the strand **460** remains supported by the top gripper device **410a** and the bottom gripper device **410c**. Referring to FIG. 4F, the middle gripper device **410b** is moved back toward the top of the strand **460** and reattached to the strand **460** below the top gripper device **410a**. Referring to FIG. 4G, once the middle gripper device **410b** is reattached to the strand **460**, the bottom gripper device **410c** is unattached from the strand **460** while the strand **460** remains supported by the top gripper device **410a** and the middle gripper device **410b**. Referring to FIG. 4H, the bottom gripper device **410c** is moved back toward the top of the strand **460** and reattached to the strand **460** below the middle gripper device **410b**. Referring to FIG. 4I, once the bottom gripper device **410c** is reattached to the strand **460**, the portion **470** of the strand **460** below the bottom gripper device **410c** is removed, for example by a draw or snap cut. In an alternate embodiment depicted in FIG. 4J, the strand **460** may be cut above the bottom gripper device **410c** so that the bottom gripper device **410c** may be used to lower the portion **470** of the strand **460** into a waiting receptacle (not shown).

[0029] As can be seen from the above description, using multiple gripper devices allows the strand to always be supported by at least one gripper and up to one less than the total number

of grippers during the draw process. In the above example with three gripper devices **410a-410c**, the strand **460** is always supported by at least two of the gripper devices **410a-410c**. The more gripper devices attached at a given time, the more rigid the strand **460** will be and the greater force will be required to disrupt the strand from the desired draw path (i.e., the more difficult it will be to introduce the transverse force or acceleration V_L'). Strand rigidity is also dependent on the spacing between the attached gripper devices, so more gripper devices may be used for longer strands. While not shown in the figures, it will be understood that each of the gripper devices is moving down at a constant desired rate while attached the strand, thereby allowing for a continuous draw process. A person of ordinary skill in the art will understand how to synchronize the movement of the multiple gripper devices to maintain the desired spacing between the gripper devices while cutting portions of the desired lengths from the strand.

[0030] It is noted that the process depicted in FIG. 4A-4J is a steady-state process where the process is already underway. In one embodiment, the preform production process may be formed by starting a drip from the bulk glass component, and then performing the method of FIGS. 4A-4J after attaching the gripper devices to the drip. By pulling down on the drip at a rate slower than softened glass exits the oven, the diameter of the drip may be increased until it reaches the desired diameter and forms the strand, at which point the gripper devices may pull faster to begin the steady-state process. Referring to FIGS. 5A-5D, 6A-6D, and 7A-7E, various methods may be used to begin the production process described above in conjunction with FIGS. 4A-4J. FIGS. 5A-5D depict a starting method utilizing a capstan or pulling wheel device, FIGS. 6A-6D depict a starting method utilizing a starting piece pre-welded to the bulk glass component, and FIGS. 7A-7E depict a starting method utilizing a starting piece welded to the bulk glass component in the oven or furnace.

[0031] Now referring specifically to FIGS. 5A-5D, a second method of starting the production process includes forming a drip by heating the bulk glass component in the oven, catching the drip with a pulling wheel device removably mounted beneath one or more gripper devices, pulling slowly on the drip with the pulling wheel device until the drip develops into a strand of the desired diameter, attaching the one or more gripper devices to the strand, and then removing the pulling wheel device.

[0032] Referring to FIG. 5A, an apparatus **600** is provided including three gripper devices (a top gripper device **610a**, a middle gripper device **610b**, and a bottom gripper device **610c**) attached to a tower **620**, and a heating element **630**, such as a furnace. The top gripper device **610a**, the middle gripper device **610b**, and the bottom gripper device **610c** are substantially similar to the gripper device **210** described above. As is understood by those skilled in the art, certain steps included in the method **60** may be omitted; certain additional steps may be added; and the order of the steps may be altered from the order illustrated. While the apparatus **600** includes three gripper devices, it will be understood that the method described in conjunction with FIGS. 5A-5D may be performed with more than three gripper devices. The apparatus **600** further includes a pulling wheel device **640** removably mounted below the gripper devices **610a**, **610b**, **610c**. The pulling wheel device **640** may be any device as is

typically known in the art including two or more wheels driven by a motor to vary the rotation speed of the wheels. The spacing between the wheels may also be increased or decreased during operation to accommodate strands having varying diameters. First, a bulk glass component **650** is heated in the heating element **630** to form a drip **660** which is caught between the wheels of the pulling device **640**.

[0033] Referring to FIG. 5B, the pulling wheel device **640** applies a force to the drip **660** to control the rate at which material flows from the bulk glass component **650** and out of the heating element **630**. The pulling wheel device **640** may apply either a downward force or an upward force, where a downward force will increase the rate of draw and an upward force will decrease the rate of draw, though the pulling wheel device **640** will typically apply an upward force to decrease the rate of draw. By applying a force that results in less material passing through the pulling wheel device **640** than exits the heating element **630**, the drip **660** will increase in diameter to form a strand **670**. The difference in material flow rates out of the heating element **630** and through the pulling wheel device **640** should be sufficiently close to prevent the strand **670** from bowing.

[0034] Referring to FIG. 5C, the pulling process continues until the strand **670** reaches the desired diameter. Once the strand **670** reaches the desired diameter, the gripper devices **610a**, **610b**, **610c** are attached to the strand **670** for support.

[0035] Referring to FIG. 5D, once the gripper devices **610a**, **610b**, **610c** are attached to the strand **670**, the pulling wheel device **640** is removed and the process described above in conjunction with FIGS 4A-4J may begin. As depicted in FIG. 5C, a bottom portion of the strand below the bottom gripper device **610c** may have an uneven diameter or a diameter less than the desired diameter. This bottom portion may be removed before the production process continues, as depicted in FIG. 5D.

[0036] Now referring specifically to FIGS. 6A-6D, a third method of starting the production process includes inserting into the furnace a bulk glass component with a starting piece pre-welded to the bulk glass component before heating the furnace. The gripper devices are then attached to the starting piece. The furnace is then heated until the bulk glass component softens enough to form a strand when the grippers pull down on the starting piece. Once the strand reaches a sufficient length, the gripper devices re-grip to the strand and the starting piece is removed.

[0037] Referring to FIG. 6A, an apparatus **700** is provided including three gripper devices (a top gripper device **710a**, a middle gripper device **710b**, and a bottom gripper device **710c**) attached to a tower **720**, and a heating element **730**, such as a furnace. As is understood by those skilled in the art, certain steps included in the method may be omitted; certain additional steps may be added; and the order of the steps may be altered from the order illustrated. While the apparatus **700** includes three gripper devices, it will be understood that the method described in conjunction with FIGS. 6A-6D may be performed with more than three gripper devices. The top gripper device **710a**, the middle gripper device **710b**, and the bottom gripper

device **710c** are substantially similar to the gripper device **210** described above.

[0038] First, a bulk glass component **740** is pre-welded (i.e., welded before being placed into the heating element **730**) to a starting piece **750** and placed into the heating element **730** before heating the heating element **730**. The starting piece **750** has approximately the diameter of the desired ultimate product and is held by the gripper devices **710a**, **710b**, **710c**. The starting piece **750** may be made of glass of lower quality than the bulk glass component **740**, which is made of the higher quality material intended for the ultimate product. In other embodiments, the starting piece **750** may also include a non-glass piece, such as a mechanical chuck. By utilizing the starting piece **750**, waste of the bulk glass component **740** is avoided, thereby reducing process costs. Because the starting piece **750** is also supported above by the bulk glass component **740**, the weight supported by the gripper devices **710a**, **710b**, **710c** is initially approximately zero.

[0039] Referring to FIG. 6B, the heating element **730** is then heated, causing the bulk glass component **740** to soften. Once the bulk glass component **740** reaches the desired viscosity, the gripper devices **710a**, **710b**, **710c** pull down on the starting piece **750** to form a strand **760** between the starting piece **750** and the bulk glass component **740**. The gripper devices **710a**, **710b**, **710c** move downward at a rate so that the strand **760** has the desired diameter, approximately the same as the diameter of the starting piece **750**. The viscosity of the bulk glass component **740** may be determined by measuring the weight supported by the gripper devices **710a**, **710b**, **710c**, as an increased viscosity will result in more material flowing out of the heating element **730** and pushing down on the gripper devices **710a**, **710b**, **710c**. The gripper devices **710a**, **710b**, **710c** may begin moving once a predetermined weight is measured.

[0040] Referring to FIG. 6C, once the strand **760** reaches a sufficient length, the gripper devices **710a**, **710b**, **710c** are unattached from the starting piece **750**, moved back up, and reattached to the strand **760**. The strand **760** has a sufficient length when there is room for all the gripper devices **710a**, **710b**, **710c** to be attached the strand **760**. The process of attaching and reattaching the gripper devices **710a**, **710b**, **710c** may be accomplished according to the method described above in conjunction with FIGS. 4C-4H, where at least two of gripper devices **710a**, **710b**, **710c** are attached to the strand at all times. In another embodiment, the regripping process may begin when the strand **760** has a sufficient length for just one or two of gripper devices **710a**, **710b**, **710c**, with the remaining gripper devices being attached to the strand **760** as the strand **760** increases in length.

[0041] Referring to FIG. 6D, once all of the gripper devices **710a**, **710b**, **710c** are attached to the strand **760** rather than the starting piece **750**, the starting piece **750** is cut from the strand **760** and removed. Once the starting piece **750** is removed, the process described above in conjunction with FIGS 4A-4J may begin.

[0042] Now referring specifically to FIGS. 7A-7E, a fourth method of starting the production process includes gripping a starting piece with the one or more gripper devices below the

furnace, raising the starting piece into the furnace in contact with the bulk glass component, and then heating the furnace to weld the starting piece to the bulk glass component. As above, the grippers may then pull down on the starting piece to form a strand. Once the strand reaches a sufficient length, the gripper devices re-grip to the strand and the starting piece is removed.

[0043] Referring to FIG. 7A, an apparatus **800** is provided including three gripper devices (a top gripper device **810a**, a middle gripper device **810b**, and a bottom gripper device **810c**) attached to a tower **820**, and a heating element **830**, such as a furnace. As is understood by those skilled in the art, certain steps included in the method may be omitted; certain additional steps may be added; and the order of the steps may be altered from the order illustrated. While the apparatus **800** includes three gripper devices, it will be understood that the method described in conjunction with FIGS. 7A-7E may be performed with more than three gripper devices. The top gripper device **810a**, the middle gripper device **810b**, and the bottom gripper device **810c** are substantially similar to the gripper device **210** described above.

[0044] Still to FIG. 7A, a bulk glass component **840** is placed into the heating element **830** and a starting piece **850** is gripped by the gripper devices **810a**, **810b**, **810c** below the heating element **830** before heating the heating element **830**. The starting piece **850** has approximately the diameter of the desired ultimate product and is held by the gripper devices **810a**, **810b**, **810c**. The starting piece **850** may be made of glass of lower quality than the bulk glass component **840**, which is made of the material intended for the ultimate product. In other embodiments, the starting piece **850** may also include a non-glass piece, such as a mechanical chuck. By utilizing the starting piece **850**, waste of the bulk glass component **840** is avoided, thereby reducing process costs.

[0045] Referring to FIG. 7B, the starting piece **850** is raised by the gripper devices **810a**, **810b**, **810c** into contact with the bulk glass component **840** and the heating element **830** is heated to weld the starting piece **850** to the bulk glass component **840**.

[0046] Referring to FIG. 7C, once the starting piece **850** is welded to the bulk glass component **840**, the heating element **830** is heated until the bulk glass component **840** reaches the desired viscosity. Once the bulk glass component **840** reaches the desired viscosity, the gripper devices **810a**, **810b**, **810c** pull down on the starting piece **850** to form a strand **860** between the starting piece **850** and the bulk glass component **840**. The gripper devices **810a**, **810b**, **810c** move downward at a rate so that the strand **860** has the desired diameter, approximately the same as the diameter of the starting piece **850**. The viscosity of the bulk glass component **840** may be determined by measuring the weight supported by the gripper devices **810a**, **810b**, **810c**, as an increased viscosity will result in more material flowing out of the heating element **830** and pushing down on the gripper devices **810a**, **810b**, **810c**. The gripper devices **810a**, **810b**, **810c** may begin moving once a predetermined weight is measured.

[0047] Referring to FIG. 7D, once the strand **860** reaches a sufficient length, the gripper

devices **810a**, **810b**, **810c** are unattached from the starting piece **850**, moved back up, and reattached to the strand **860**. The strand **860** has a sufficient length when there is room for all the gripper devices **810a**, **810b**, **810c** to be attached the strand **860**. The process of attaching and reattaching the gripper devices **810a**, **810b**, **810c** may be accomplished according to the method described above in conjunction with FIGS. 4C-4H, where at least two of gripper devices **810a**, **810b**, **810c** are attached to the strand at all times. In another embodiment, the regripping process may begin when the strand **860** has a sufficient length for just one or two of gripper devices **810a**, **810b**, **810c**, with the remaining gripper devices being attached to the strand **860** as the strand **860** increases in length.

[0048] Referring to FIG. 7E, once all of the gripper devices **810a**, **810b**, **810c** are attached to the strand **860** rather than the starting piece **850**, the starting piece **850** is cut from the strand **860** and removed. Once the starting piece **850** is removed, the process described above in conjunction with FIGS 4A-4J may begin.

[0049] The foregoing description of preferred embodiments of the invention should be taken as illustrating, rather than as limiting the present invention as defined by the claims. As will be readily appreciated, numerous variations and combinations of the features set forth above can be utilized without departing from the present invention as set forth in the claims. Such variations are not regarded as a departure from the spirit and scope of the invention, and all such variations are intended to be included within the scope of the following claims.

REFERENCES CITED IN THE DESCRIPTION

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Patent documents cited in the description

- [US6938442B \[0010\]](#)
- [JP2006327898A \[0010\]](#)
- [JP3864463B \[0010\]](#)

DANNELSE AF LANGSTRAKTE GLASKOMPONENTER MED RINGE BØJNING UNDER ANVENDELSE AF EN GRIBEANORDNING

Patentkrav

1. Apparat (200; 300; 400) til dannelse af en langstrakt komponent af glas (260; 360; 460) med ringe bøjning, hvilket apparat (200; 300; 400) omfatter:

et varmelegeme (240; 340; 440) til opvarmning af en bulkglaskomponent (250; 350; 450), hvor der kan trækkes en streng (260; 360; 460) fra bulkglaskomponenten (250; 350; 450) i en nedadgående z-retning; og

en gribeanordning (210; 310; 410a; 410b; 410c), hvor gribeanordningen (210; 310; 410a; 410b; 410c) omfatter:

et fastspændingselement (214; 314) til understøtning af strengen (260; 360; 460) og flytning lineært med strengen (260; 360; 460), mens den trækkes fra bulkglaskomponenten (250; 350; 450),

kendetegnet ved, at gribeanordningen (210; 310; 410a; 410b; 410c) yderligere omfatter:

et lavfriktionsmonteringsselement (216; 316), der er fastgjort til fastspændingselementet (214; 314), hvilket muliggør en translatorisk bevægelse af fastspændingselementet (214; 314) i et x-y-plan,

hvor en kraft, som udøves på fastspændingselementet (214; 314) af strengen (260; 360; 460), resulterer i, at fastspændingselementet (214; 314) afbøjes langs monteringsselementet (216; 316).

2. Apparat ifølge krav 1, hvor apparatet (200; 300; 400) yderligere omfatter et strengcentrumssensorelement (270; 370), hvor strengcentrumssensorelementet (270; 370) detekterer strengens (260; 360; 460) position i forhold til fastspændingselementets (214; 314) position.

3. Apparat ifølge krav 1 eller 2, hvor monteringsselementet (216; 316) omfatter et krydsbord, der indbefatter et par arme, som er monteret på lineære lejer eller lineære skinner, og endvidere fortrinsvis omfatter en motor til styring af bevægelsen af parret af arme.

4. Apparat ifølge et hvilket som helst af kravene 1-3, hvor monteringsselementet (216; 316) yderligere omfatter en låsemekanisme, hvor fastspændingselementet (214; 314), når låsemekanismen er udløst, kan glide frit på monteringsselementet (216; 316), og

fastspændingselementet (214; 314), når låsemekanismen er i indgreb, er fikseret i position.

5. Apparat ifølge et hvilket som helst af kravene 1-4, hvor gribeanordningen (210; 310; 410a; 410b; 410c) yderligere omfatter en kraftmåleanordning (218) til registrering af en reaktionskraft som følge af, at fastspændingselementet (214; 314) fastspænder strengen (260; 360; 460), hvor kraftmåleanordningen (218) fortrinsvis omfatter en vejecelle.

6. Apparat ifølge et hvilket som helst af kravene 1-5, der endvidere omfatter en strengpositionssensor, hvor bøjning (365) i strengen (260; 360; 460) kan udledes af strengpositionssensorerne baseret på strengens (260; 360; 460) forskydning fra den kendte trækakse.

7. Fremgangsmåde til fremstilling af en langstrakt komponent af glas (260; 360; 460) med ringe bøjning, hvilken fremgangsmåde omfatter, at:

en bulkglaskomponent (250; 350; 450) opvarmes til dannelse af en streng (260; 360; 460);

strengens (260; 360; 460) centrum bestemmes;

et fastspændingselement (214; 314) på en gribeanordning (210; 310; 410a; 410b; 410c) justeres i forhold til strengens (260; 360; 460) centrum,

fastspændingselementet (214; 314) bringes i kontakt med strengen (260; 360; 460),
og

gribeanordningen (210; 310; 410a; 410b; 410c) bevæges i en lineær nedadgående retning (z) væk fra bulkglaskomponenten (250; 350; 450) for at forlænge strengen (260; 360; 460)

kendetegnet ved, at gribeanordningen (210; 310; 410a; 410b; 410c) yderligere omfatter et lavfriktionsmonteringselement (216; 316), der er fastgjort til fastspændingselementet (214; 314), hvilket muliggør en translatorisk bevægelse af fastspændingselementet (214; 314) i et x-y-plan, hvor z-retningen er defineret af retningen, som strengen (260; 360; 460) trækkes i, således at strengens (260; 360; 460) position i tilfælde af en fejljustering ikke forstyrres af, at fastspændingselementet (214; 314) er fastspændt til strengen (260; 360; 460).

8. Fremgangsmåde ifølge krav 7, hvor gribeanordningen (210; 310; 410a; 410b; 410c) yderligere omfatter en sensor til bestemmelse af strengens (260; 360; 460)

centrum.

9. Fremgangsmåde ifølge krav 7 eller 8, hvor monteringselementet (216; 316) omfatter et krydsbord, der indbefatter et par arme, som er monteret på lineære lejer eller lineære skinner.

10. Fremgangsmåde ifølge et hvilket som helst af kravene 7-9, der endvidere omfatter fastlåsning af fastspændingselementet (214; 314) i position på monteringselementet (216; 316), efter at gribeanordningen (210; 310; 410a; 410b; 410c) er fastgjort til strengen (260; 360; 460).

11. Fremgangsmåde ifølge et hvilket som helst af kravene 7-10, der endvidere omfatter måling af en reaktionskraft mellem gribeanordningen (210; 310; 410a; 410b; 410c) og strengen (260; 360; 460), mens gribeanordningen (210; 310; 410a; 410b; 410c) fastgøres til strengen (260; 360; 460), med henblik på at detektere fejljustering, og hvor reaktionskraften fortrinsvis måles ved hjælp af en vejecelle, som er monteret på gribeanordningen (210; 310; 410a; 410b; 410c).

12. Fremgangsmåde ifølge et hvilket som helst af kravene 7-11, der endvidere omfatter:

måling af et omfang af bøjning (365) i strengen (260; 360; 460); og
bevægelse af fastspændingselementet (214; 314), der er fastgjort til strengen (260; 360; 460), på monteringselementet (216; 316) med henblik på at reducere omfanget af bøjning (365) i strengen (260; 360; 460).

13. Fremgangsmåde til korrektion af bøjning i en langstrakt komponent af glas, som trækkes fra en bulkglaskomponent (250; 350; 450) i et varmelegeme (240; 340; 440), hvilken fremgangsmåde omfatter:

fastgørelse af en gribeanordning (210; 310; 410a; 410b; 410c) på en streng (260; 360; 460), hvilken gribeanordning (210; 310; 410a; 410b; 410c) indbefatter et fastspændingselement (214; 314) og et monteringselement (216; 316), som er fastgjort til fastspændingselementet (214; 314), hvilket muliggør en translatorisk bevægelse af fastspændingsanordningen i et x-y-plan, hvor z-retningen er defineret af retningen, som strengen (260; 360; 460) trækkes i;

måling af et omfang af tværacceleration i strengen (260; 360; 460); og
bevægelse af fastspændingselementet (214; 314), der er fastgjort til strengen (260;

360; 460), på monteringselementet (216; 316) i den modsatte retning af tværaccelerationen med henblik på at reducere omfanget af bøjning (365) i strengen (260; 360; 460).

14. Fremgangsmåde ifølge krav 13, hvor måling af et omfang af tværacceleration i strengen (260; 360; 460) omfatter bestemmelse af tværforskydning af strengen (260; 360; 460) ved flere punkter over tid.

15. Fremgangsmåde ifølge krav 14, hvor bestemmelse af strengens (260; 360; 460) tværforskydning omfatter anvendelse af laser-, LED- eller kameramåleapparater (370), og

hvor laser-, LED- eller kameramåleapparaterne (370) fortrinsvis er positioneret ved eller umiddelbart under varmelegemet (240; 340; 440).

DRAWINGS

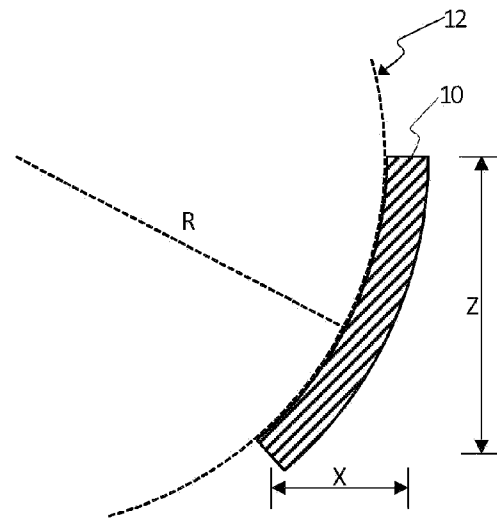


FIG. 1A

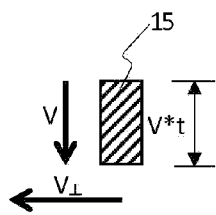


FIG. 1B

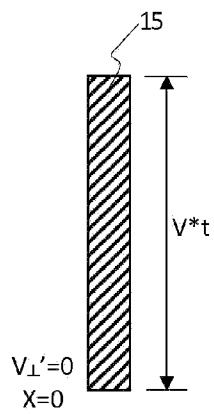


FIG. 1C

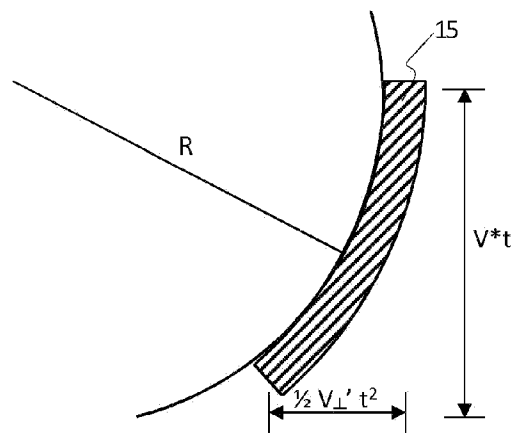


FIG. 1D

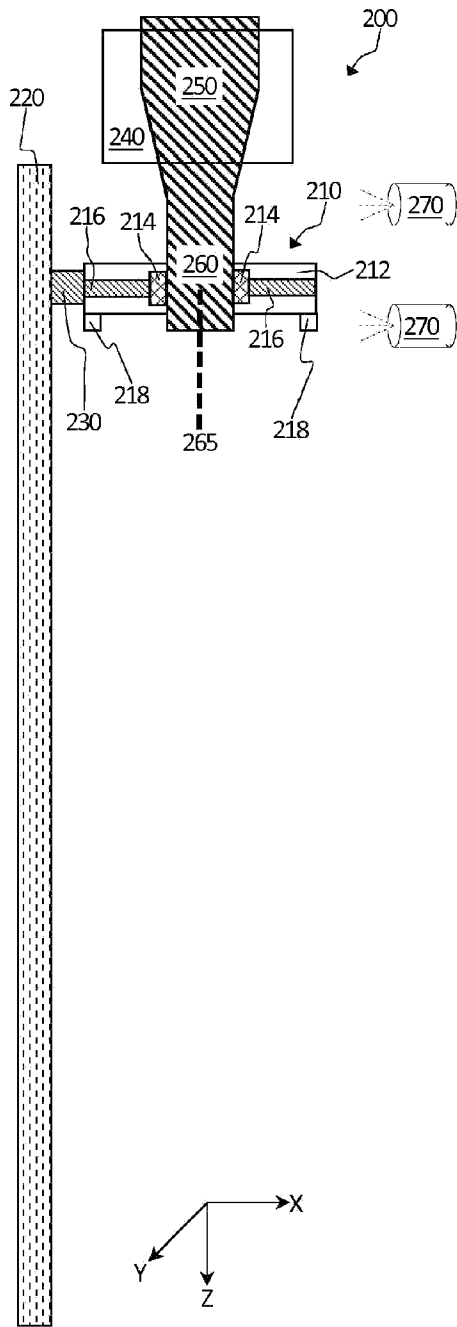


FIG. 2A

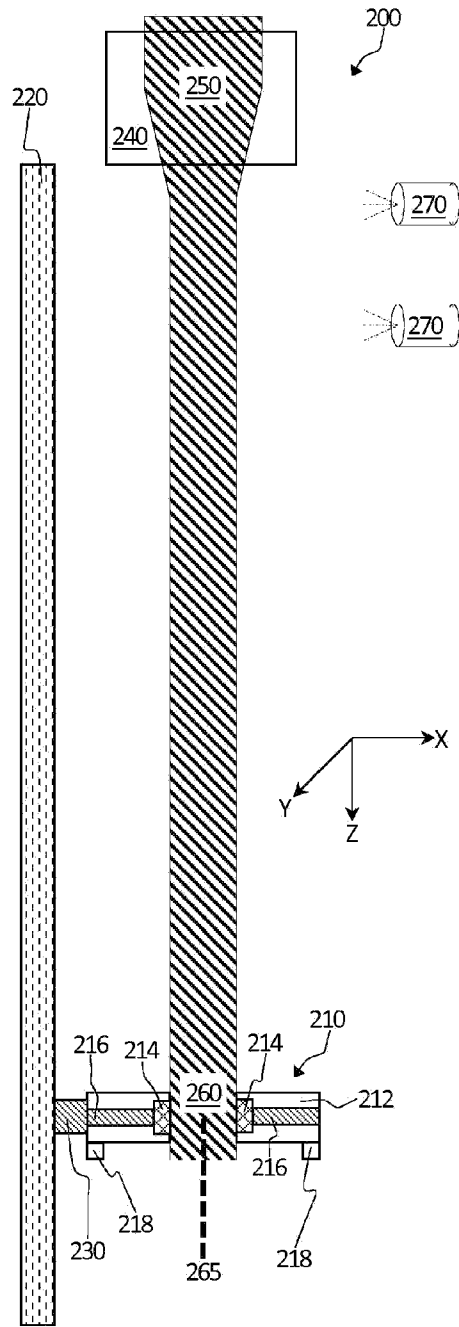


FIG. 2B

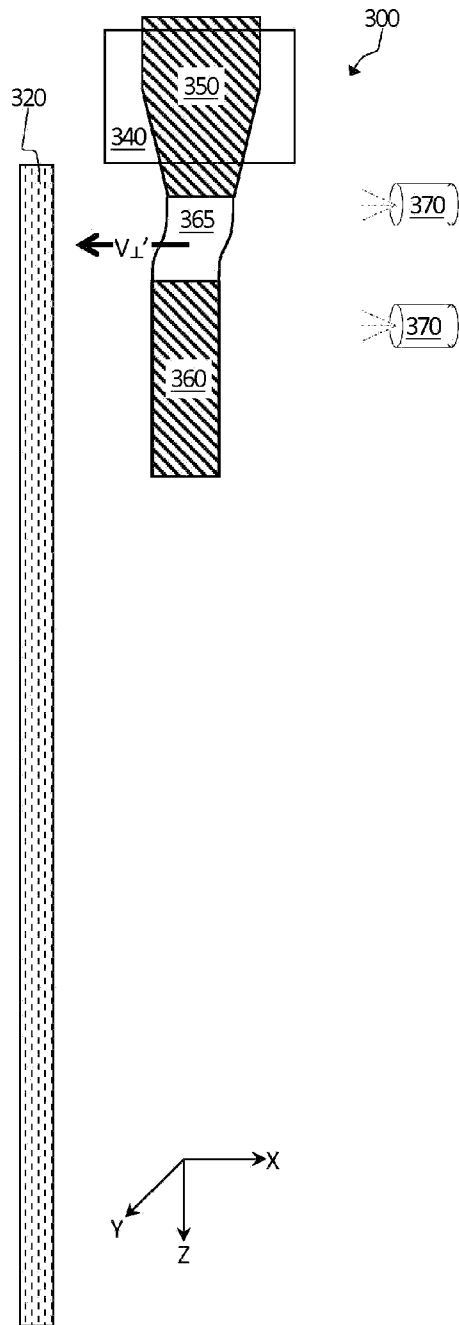


FIG. 3A

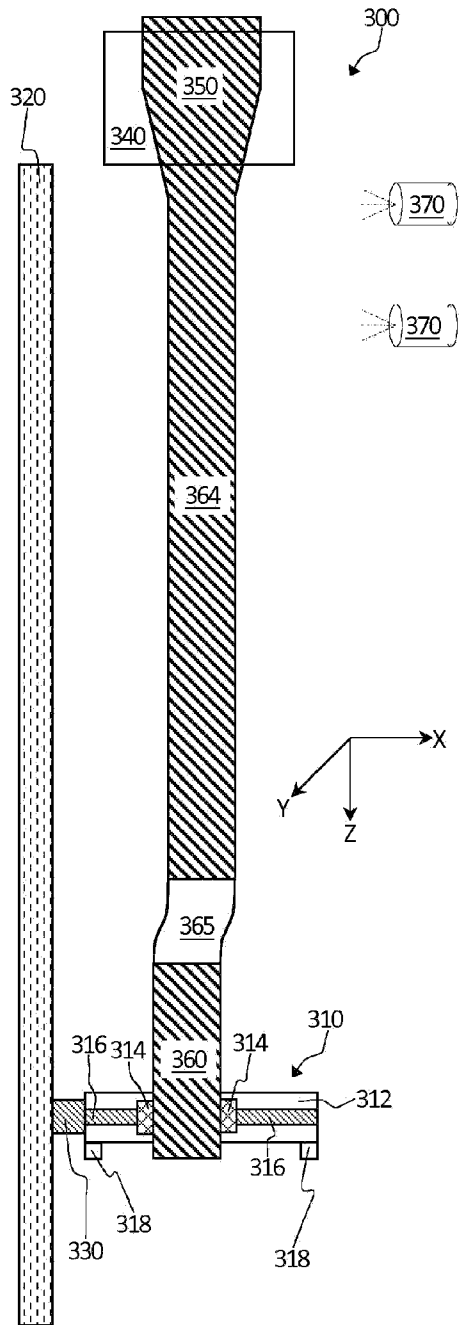


FIG. 3B

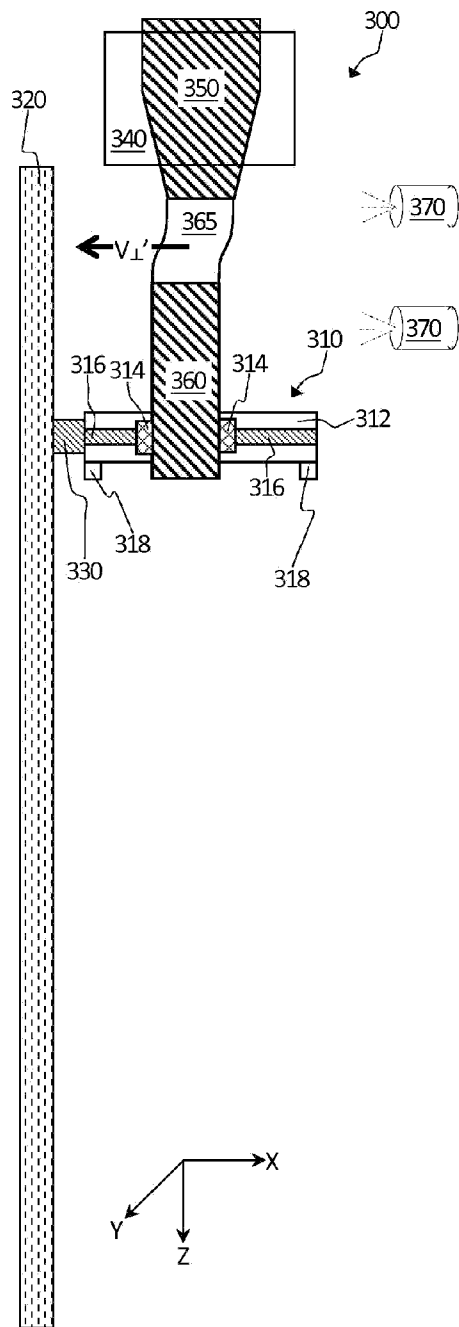


FIG. 3C

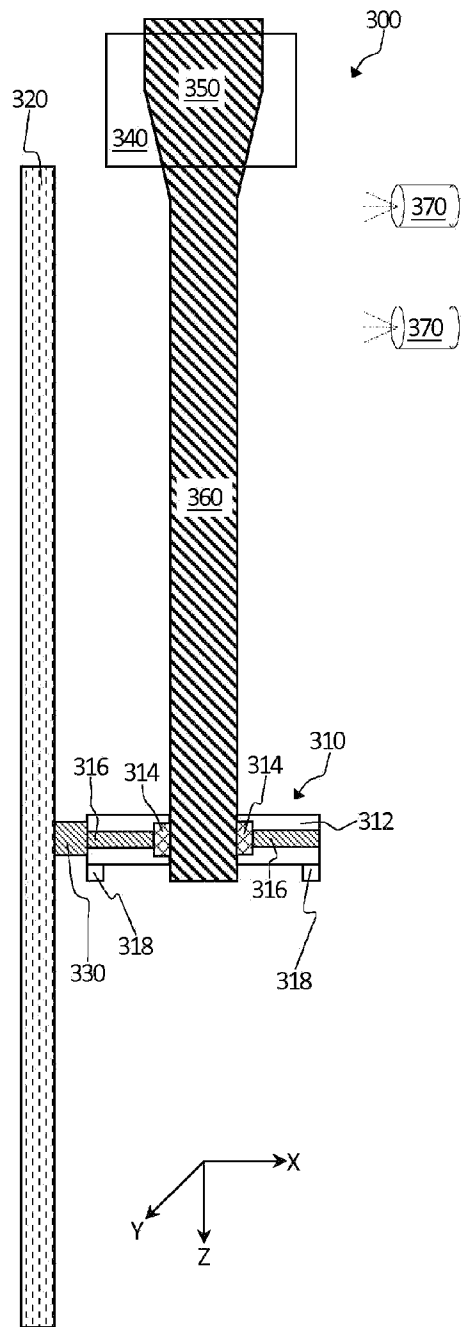


FIG. 3D

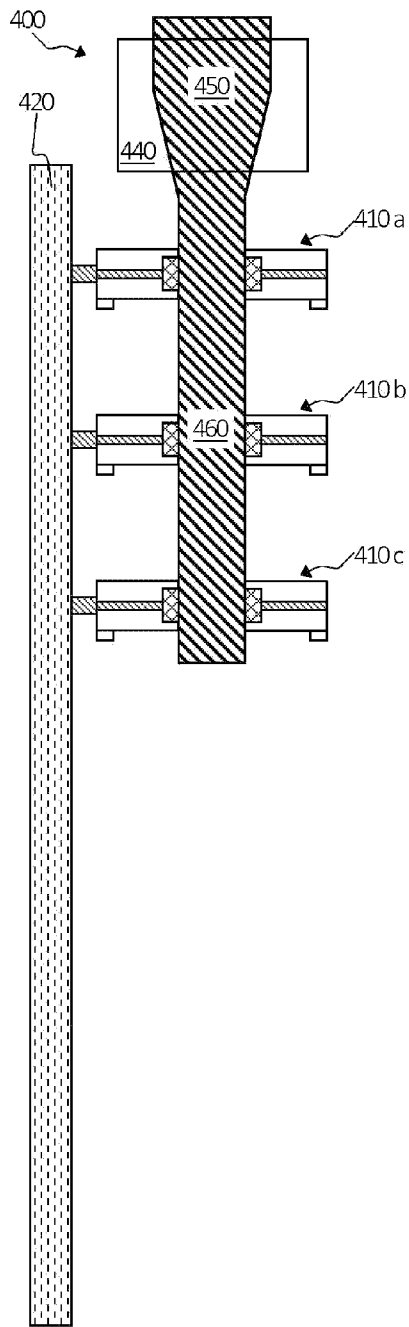


FIG. 4A

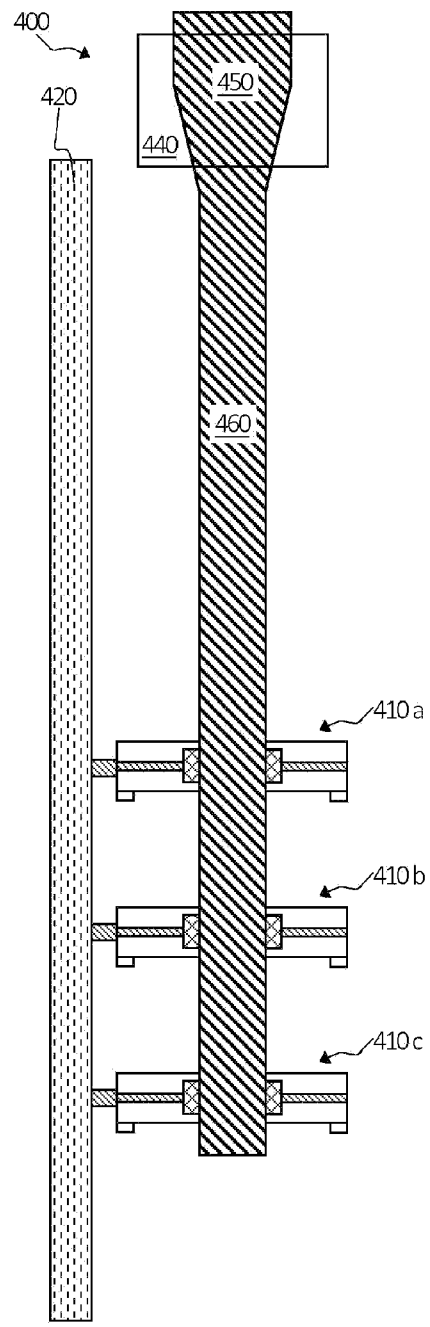


FIG. 4B

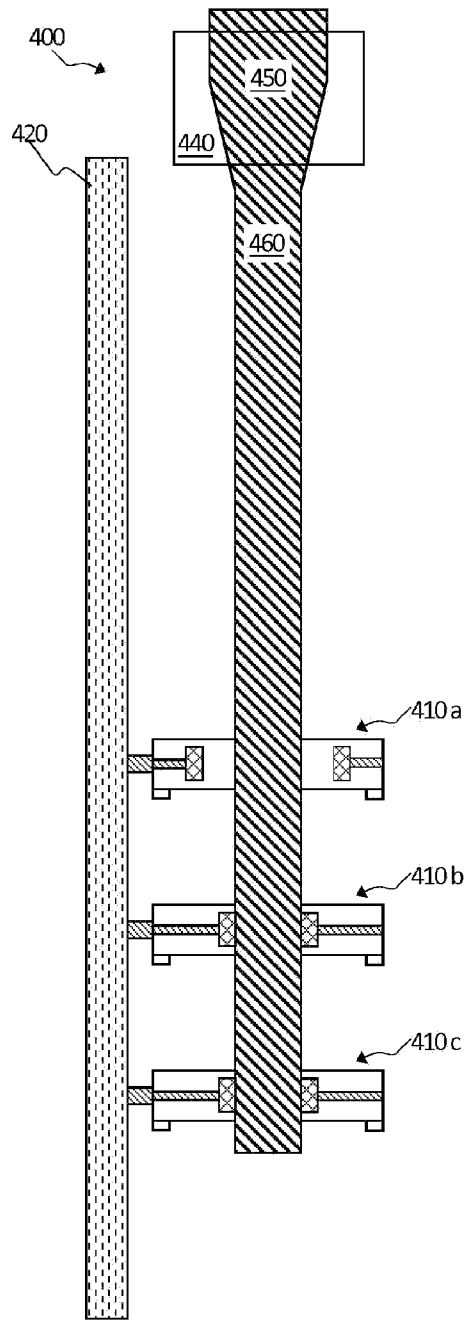


FIG. 4C

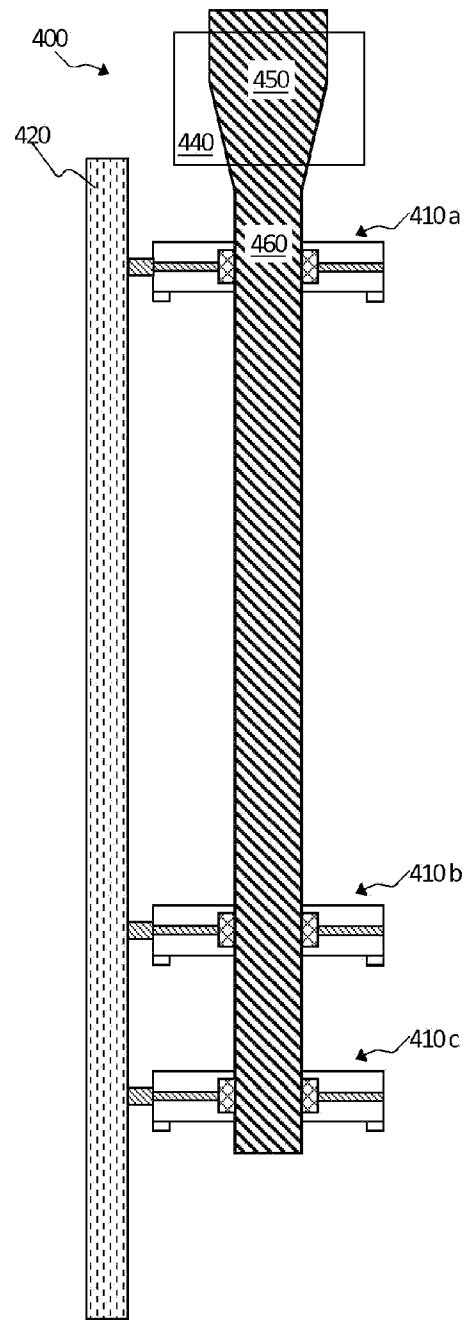


FIG. 4D

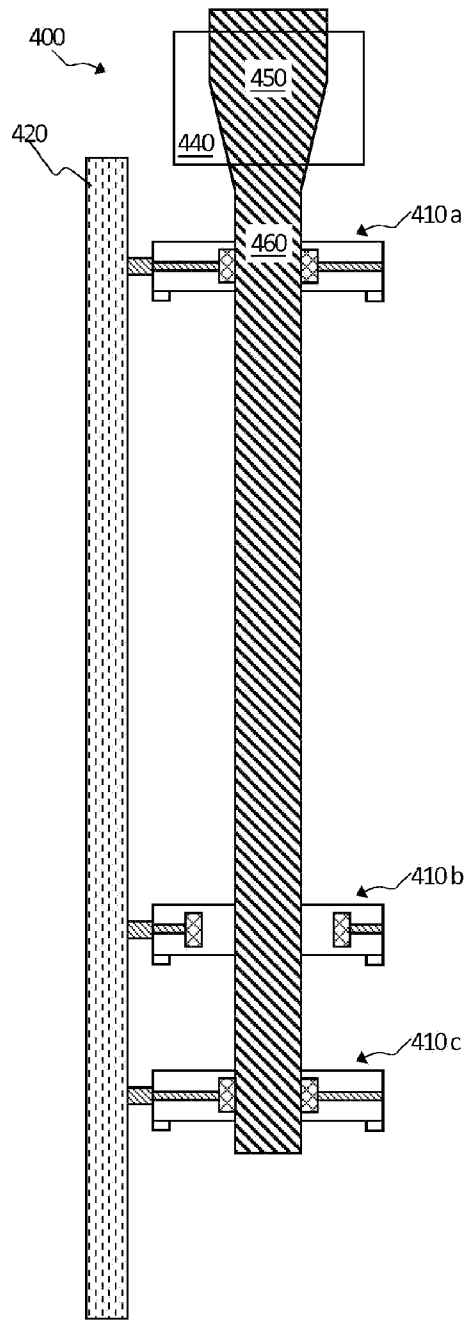


FIG. 4E

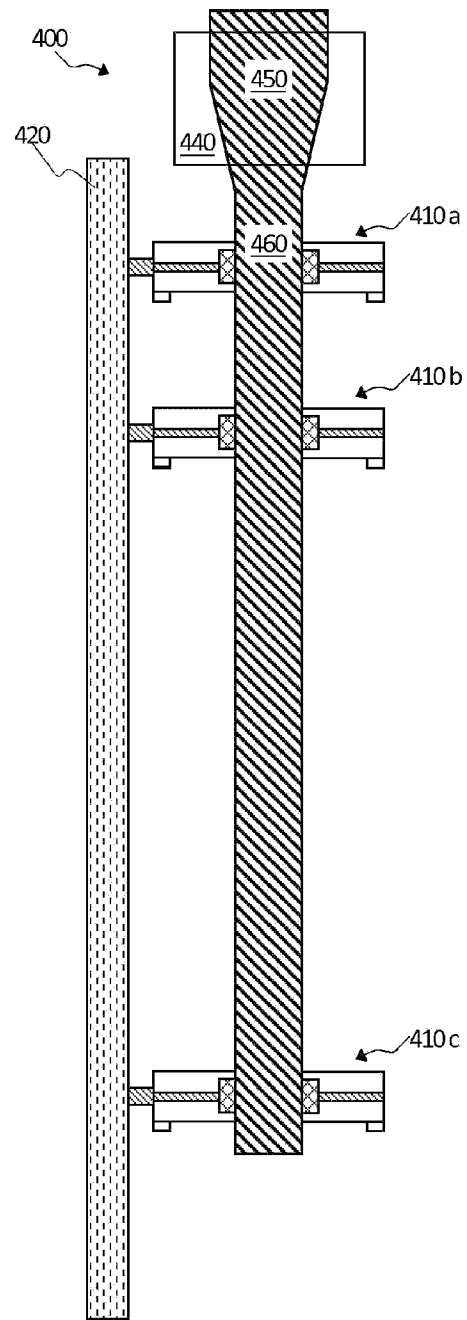


FIG. 4F

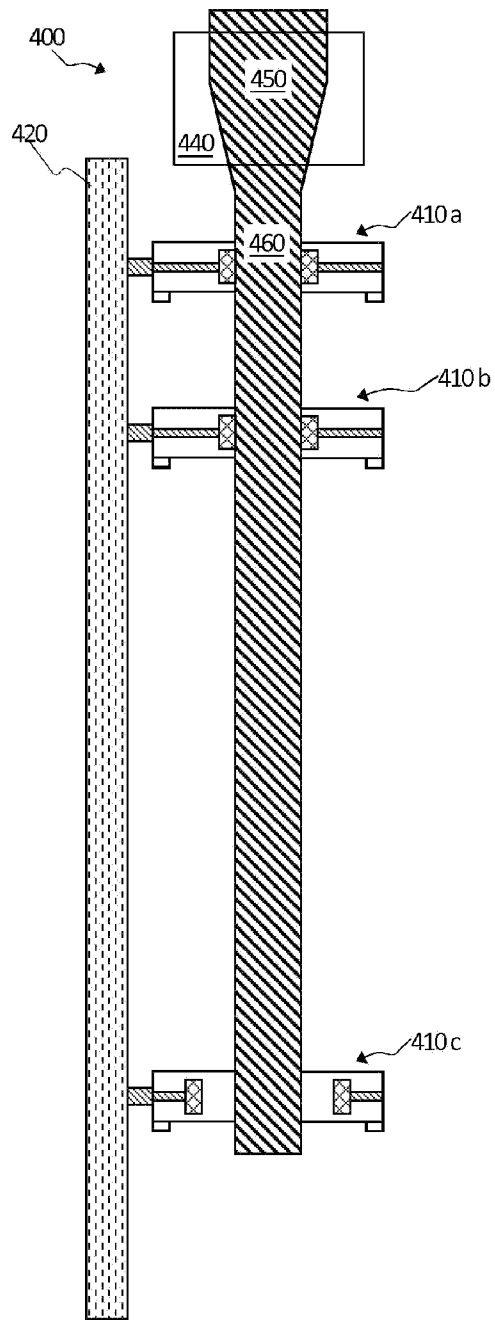


FIG. 4G

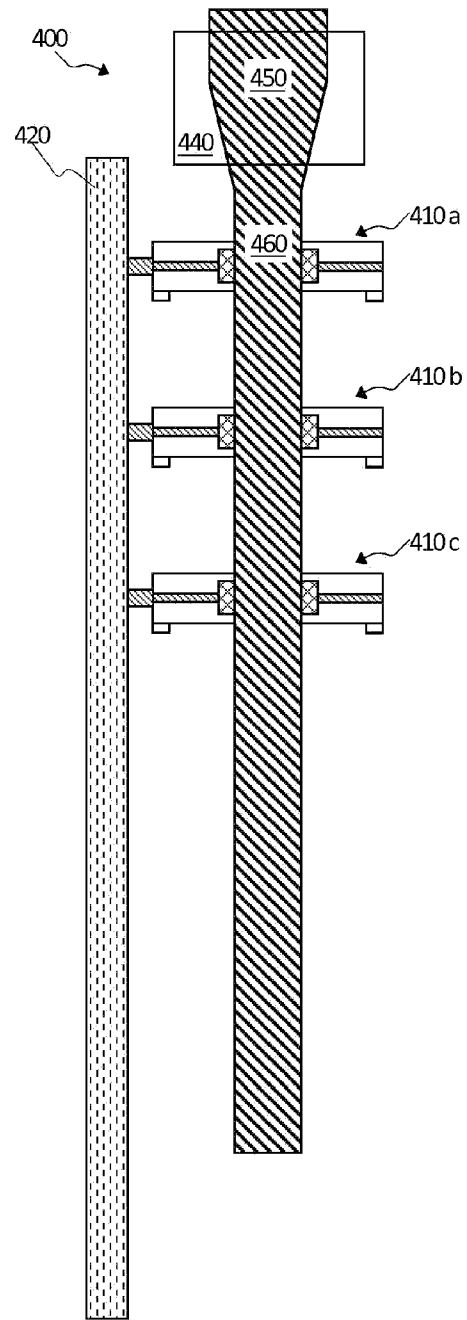


FIG. 4H

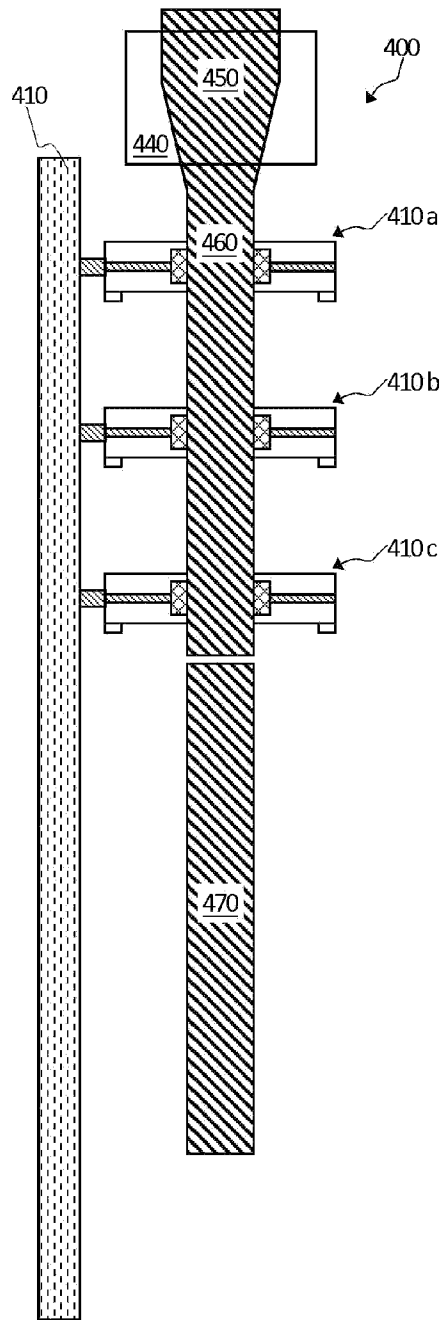


FIG. 4I

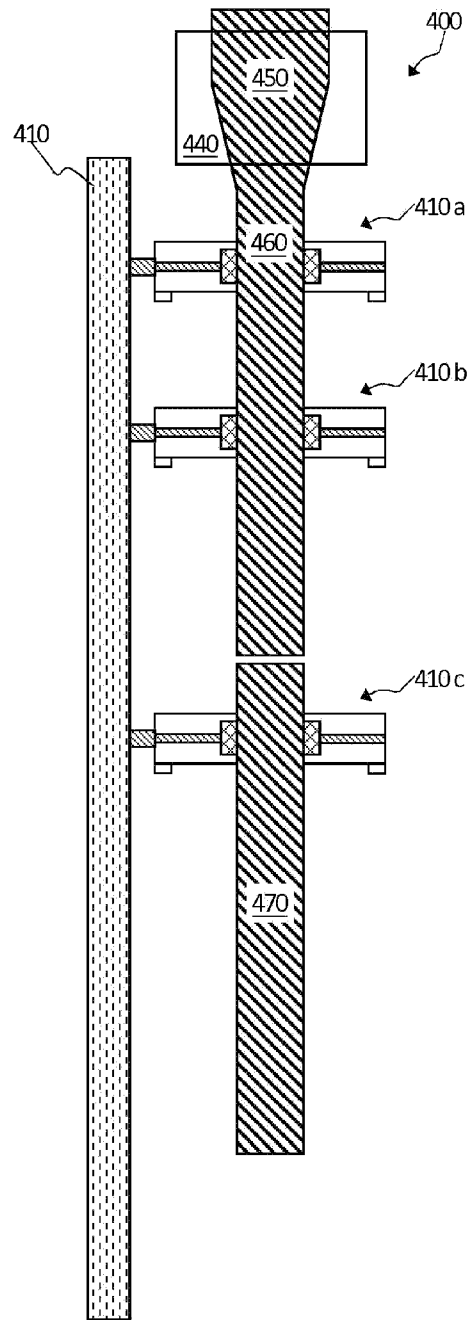


FIG. 4J

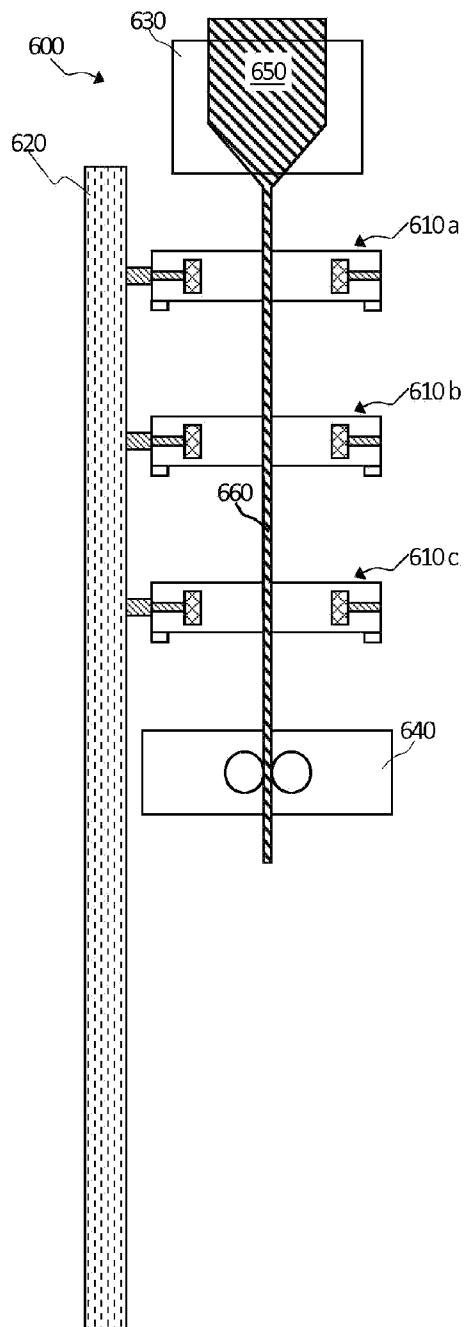


FIG. 5A

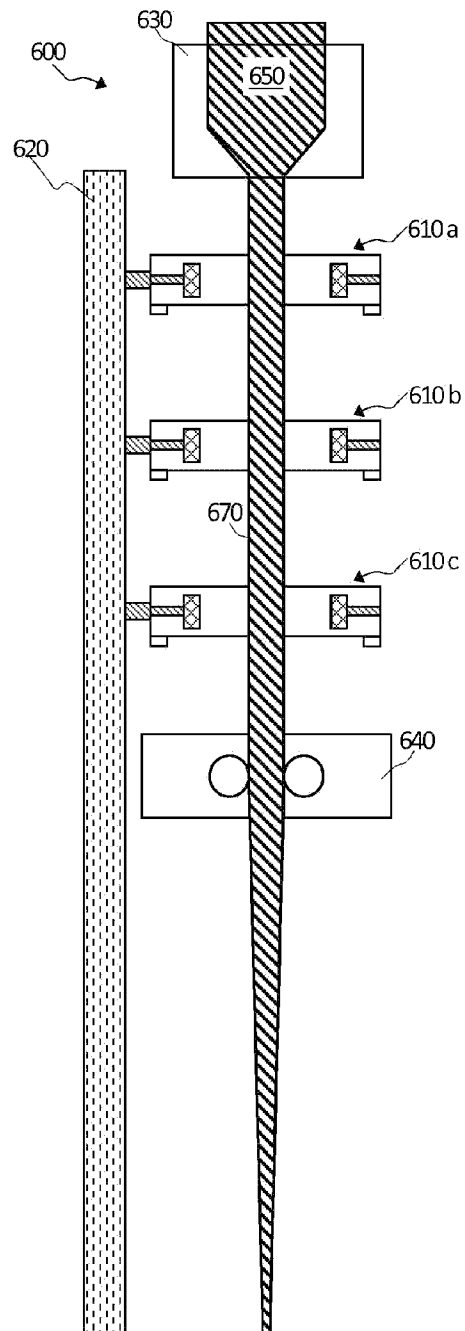


FIG. 5B

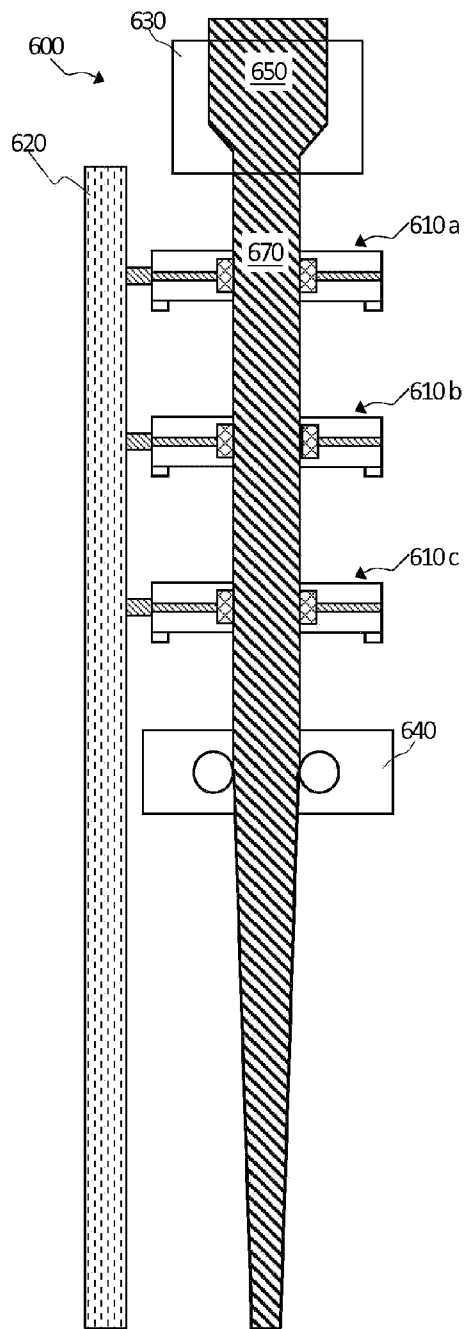


FIG. 5C

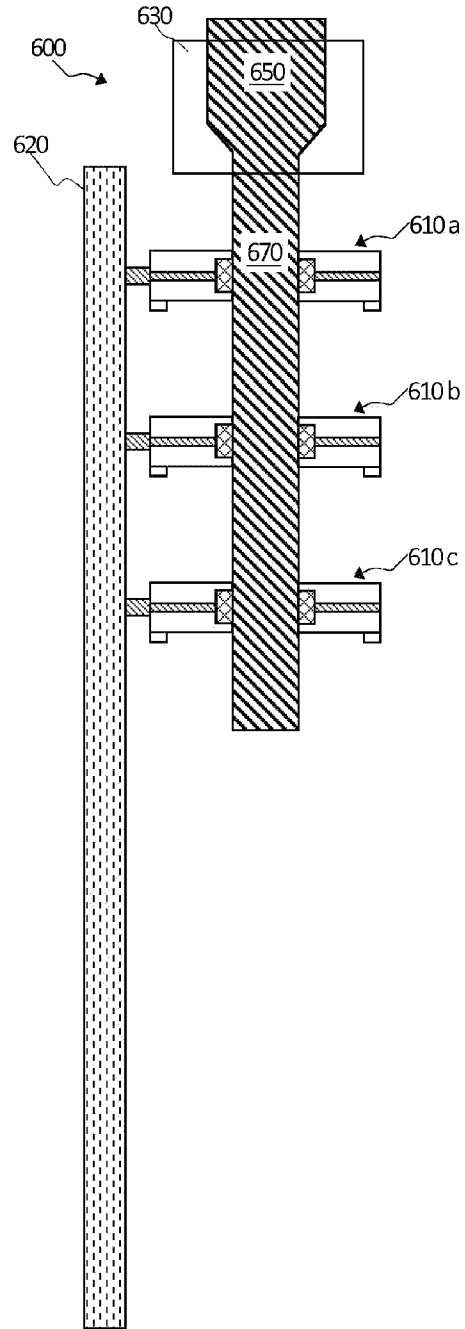


FIG. 5D

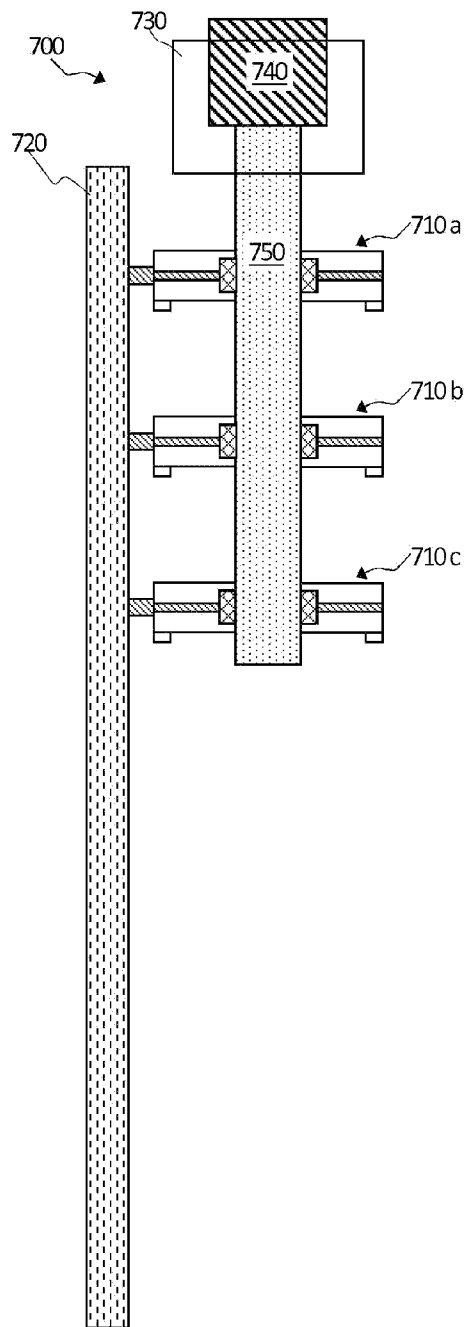


FIG. 6A

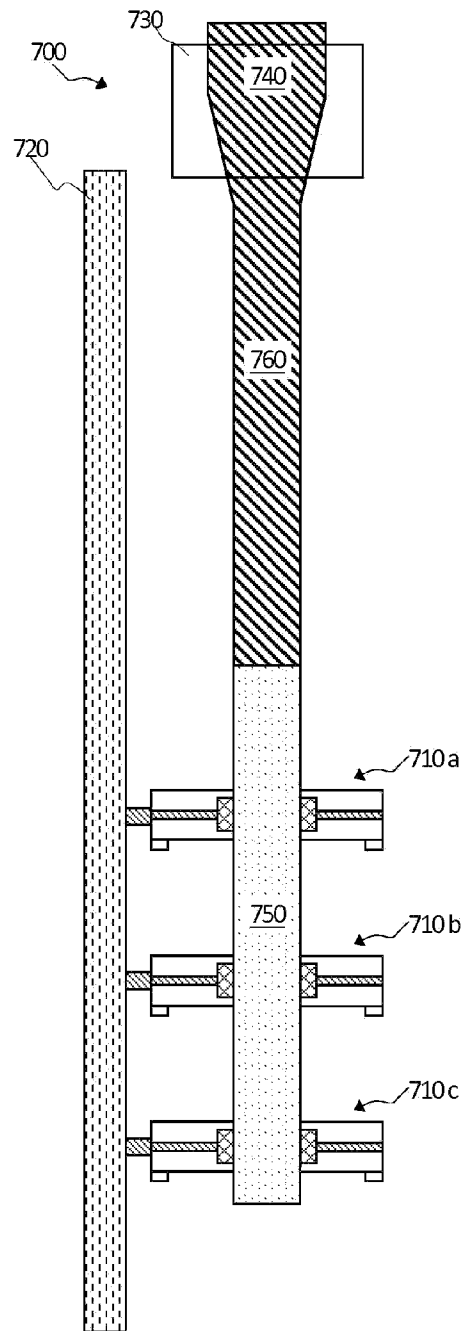


FIG. 6B

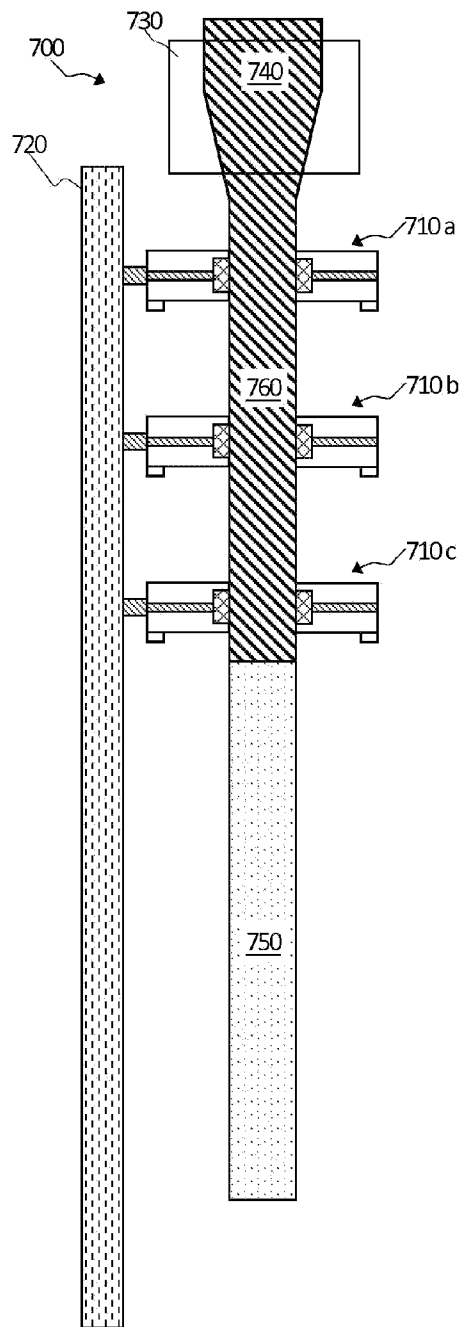


FIG. 6C

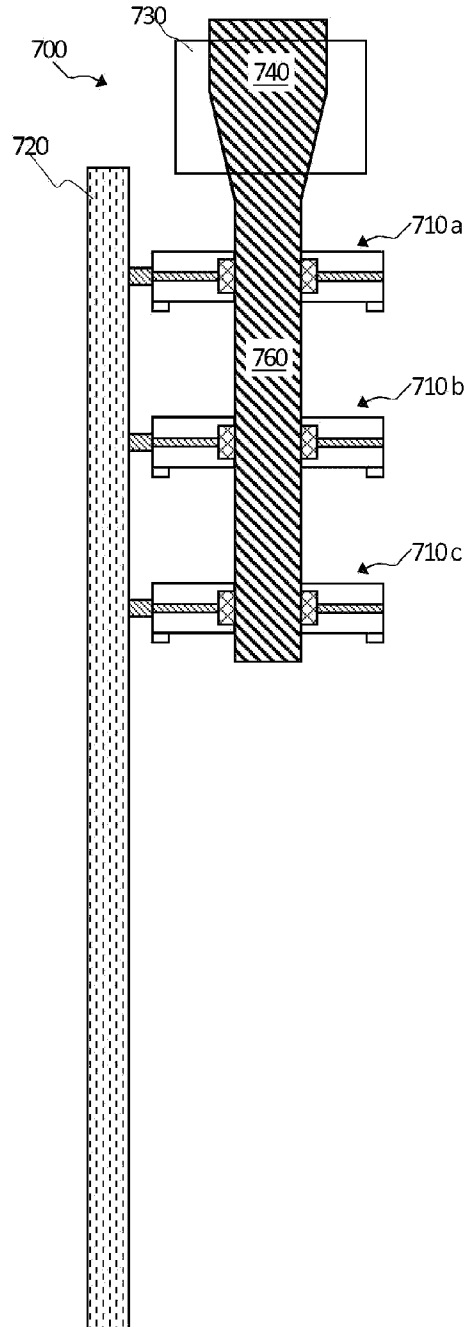


FIG. 6D

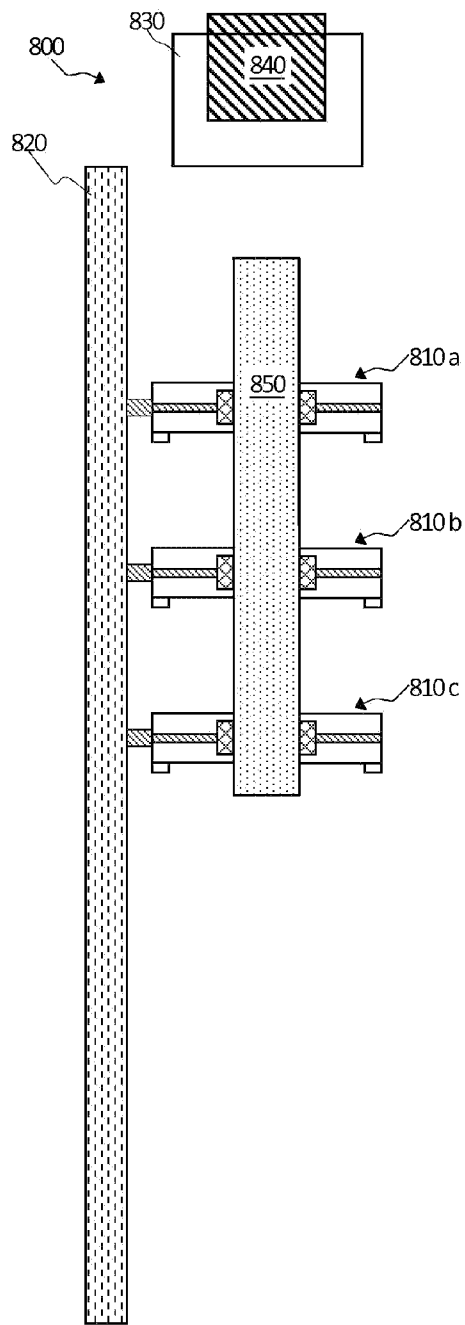


FIG. 7A

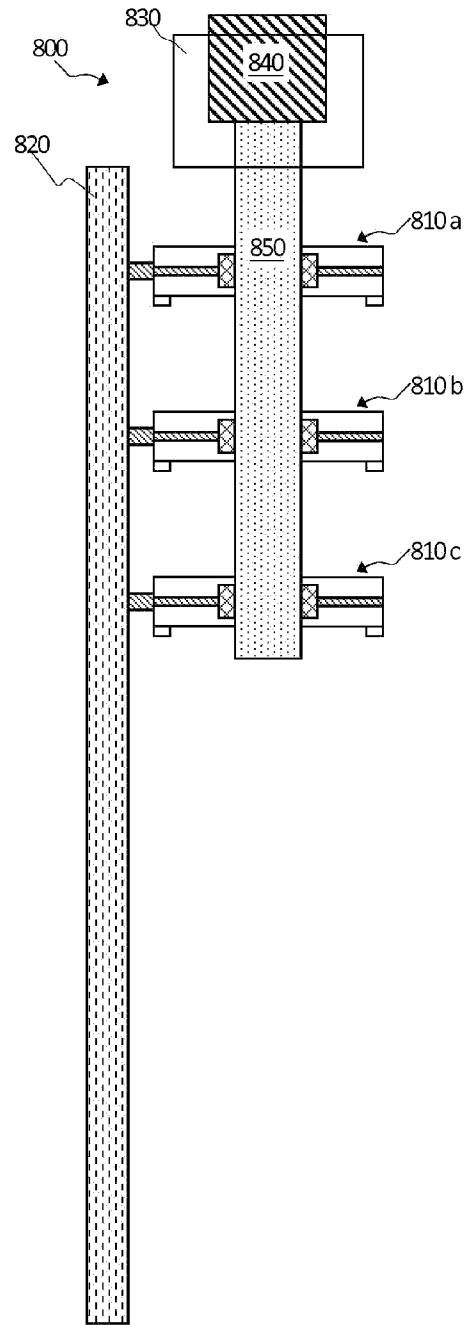


FIG. 7B

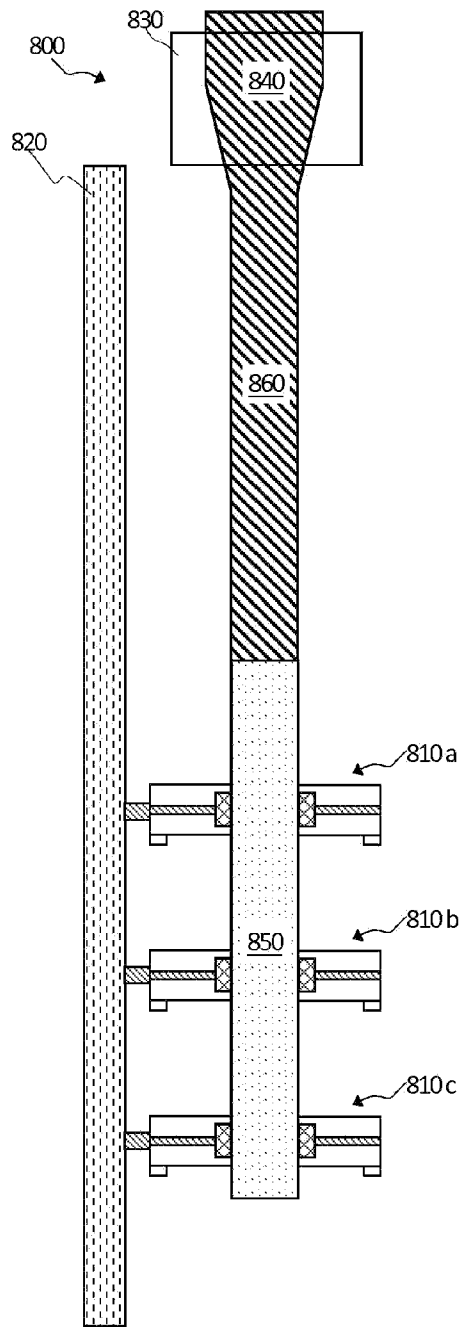


FIG. 7C

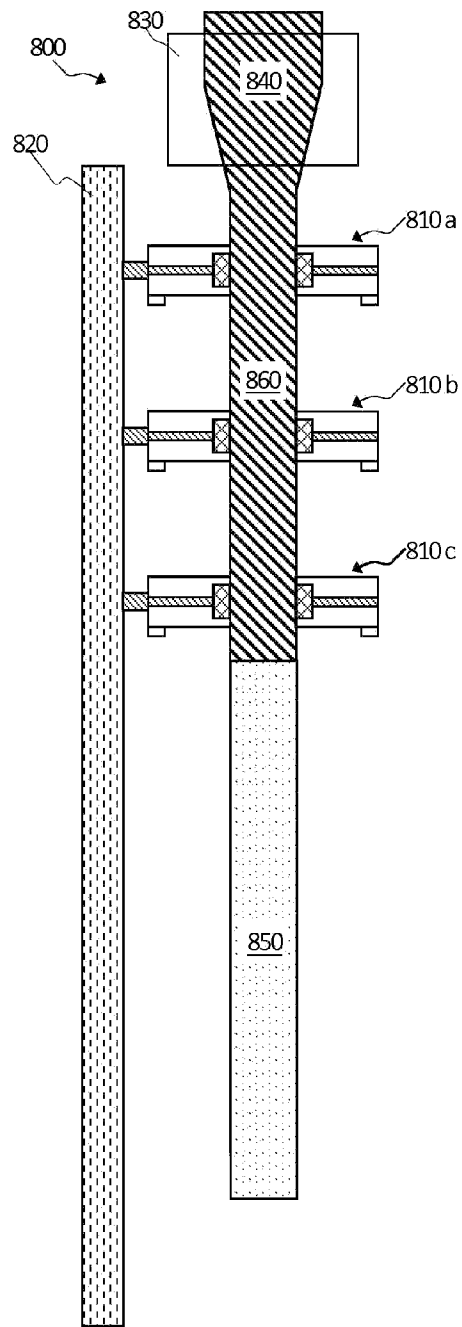


FIG. 7D

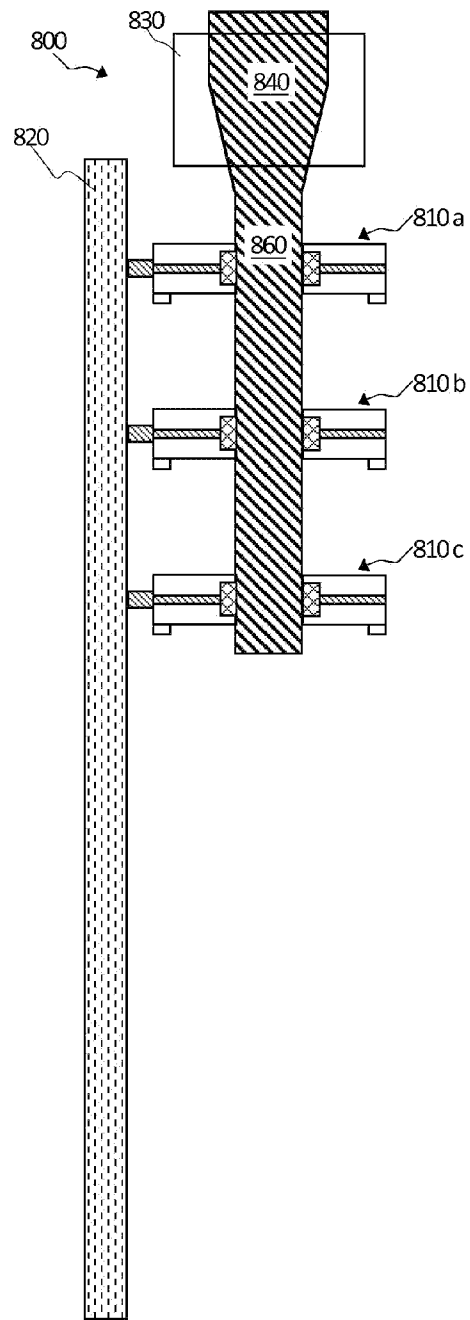


FIG. 7E