

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
19 April 2001 (19.04.2001)

PCT

(10) International Publication Number
WO 01/26498 A1

(51) International Patent Classification⁷: A44C 17/04,
B29C 67/00, B23K 26/00

(74) Agent: JOHN & KERNICK; An Intellectual Property
Law Office of Biwnan Gilfillan Inc., P.O. Box 3511, 1685
Halfway House (ZA).

(21) International Application Number: PCT/ZA00/00182

(22) International Filing Date: 6 October 2000 (06.10.2000)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
99/6374 8 October 1999 (08.10.1999) ZA

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU,
AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CR, CU, CZ,
DE, DK, DM, DZ, EE, ES, FI, GB, GD, GE, GH, GM, HR,
HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR,
LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ,
NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM,
TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.

(84) Designated States (*regional*): ARIPO patent (GH, GM,
KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian
patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European
patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE,
IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG,
CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).

(71) Applicant (*for all designated States except US*): **RAPID
DESIGN TECHNOLOGIES (PTY) LIMITED**
[ZA/ZA]; Technology House, 75 Hill Street, Fern-
dale, Randburg 2125 (ZA).

Published:

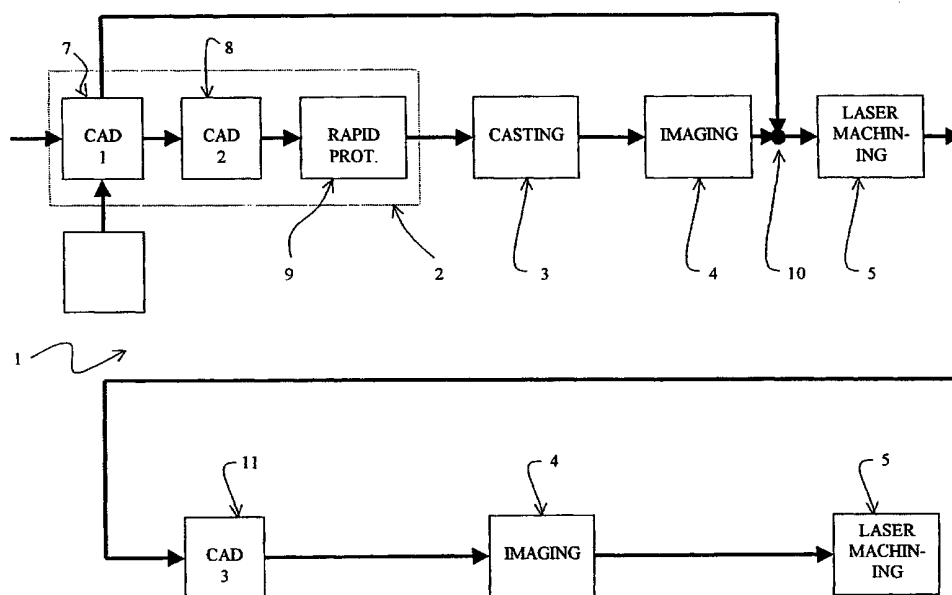
— With international search report.

(72) Inventor; and

(75) Inventor/Applicant (*for US only*): **BOND, Robert,
James** [ZA/ZA]; 37 Powder Road, Ifafi, 0216 Harte-
beespoort (ZA).

*For two-letter codes and other abbreviations, refer to the "Guid-
ance Notes on Codes and Abbreviations" appearing at the begin-
ning of each regular issue of the PCT Gazette.*

(54) Title: DIE MANUFACTURING



(57) Abstract: A system for producing a die includes means for generating a reference CAD model of a die of desired dimensions and a production facility arranged to produce an oversized casting of the die from a mould thereof. The system includes, further means for measuring the actual dimensions of the oversized casting, a comparator for comparing the measured dimensions of the oversized die against the reference CAD model, and a machining facility operable to machine the oversized casting until its dimensions are substantially the same as those of the reference CAD model.

WO 01/26498 A1

DIE MANUFACTURING

5

FIELD OF THE INVENTION

10 This invention relates to a system and to a method for the manufacture and production of dies and, more specifically, but not exclusively, to a system and to a method for the production and manufacture of dies to be utilised in a wide range of production processes, such as injection moulding, gravity die casting and the like.

BACKGROUND TO THE INVENTION

15 A method and a system for producing a metal article such as a die is disclosed in applicant's South African Patent Application No. 99/2209, which is incorporated herein in its entirety by reference.

The disclosed method of producing a die includes the steps of:
20 providing a CAD model of the die to be formed;
rapid prototyping a three-dimensional patterns of the die from the CAD model thereof;
producing mould of the die from the three-dimensional pattern thereof; and
casting the die from the mould.

25

Whilst the applicant's method is effective and allows for the rapid production of new tooling, a number of difficulties have emerged. In particular, the castings produced in the casting step of the method exhibit a degree of metal shrinkage which is difficult to predict and which affects the accuracy of a final article which is to be
30 produced by means of the die.

Further, texturing of the surface of such dies is difficult and costly to achieve.

OBJECT OF THE INVENTION

It is an object of this invention to provide a system and a method for the production
5 of a die for moulding or forming a metal article which will, at least partially, alleviate
the abovementioned difficulties and disadvantages.

SUMMARY OF THE INVENTION

- 10 In accordance with this invention there is provided a method for producing a die,
comprising the steps of:
providing a reference CAD model of the die of desired dimensions;
producing an oversized casting of the die from a mould thereof;
measuring the actual dimensions of the oversized casting;
15 comparing the measured dimensions of the oversized die against the reference
CAD model; and
ablating the oversized casting until its dimensions are substantially the same as
those of the reference CAD model.
- 20 Further features of the invention for producing an oversize casting of the die by the
steps of:
providing an oversize CAD model of the die;
including in the oversize CAD model a number of reference points sufficient to
define a three-dimensional co-ordinate system relative to the CAD model;
25 rapid prototyping a three-dimensional pattern of the die from the oversize CAD
model thereof;
producing a mould of the die from the three-dimensional pattern thereof; and
casting the oversize die from the mould.

Still further features of the invention provide for measuring the actual dimensions of the oversize casting by the steps of:

- imaging the oversize casting to obtain the co-ordinates of the surface of the oversize casting relative to the three dimensional co-ordinate system defined by the
5 number of reference points on the casting; and
converting the co-ordinates into a measured CAD model.

- Yet further features of the invention provide for ablating the oversize casting by any one of the methods of laser ablation, machining or spark erosion, and for imaging
10 the oversize casting by means of a laser-based, alternatively a contact-based imaging system.

- There is also provided for the method to include the additional step of texturing at least a portion of the surface of the casting; and
15 texturing at least a portion of the surface of the casting by:
providing a reference CAD model of the desired texture to be applied to the surface of the casting;
identifying the portion of the surface of the casting to be textured as a function of the co-ordinates of each one of the number of reference points on the casting; and
20 ablating the identified portion of the surface of the casting in accordance with the reference CAD model of the desired texture to be applied to the casting.

- There is further provided for ablating the portion of the surface of the casting by laser ablation.

25

There is further provided for including at least one integral cooling pathway through the oversize casting, and for the integral cooling pathway to also include a hollow back and a baffle to direct the flow of a coolant therethrough.

30

The invention extends to a system for producing a die comprising:
means for generating a reference CAD model of a die of desired dimensions to be produced;
a production facility arranged to produce an oversized casting of the die from a
5 mould thereof;
measuring means for measuring the actual dimensions of the oversized casting;
comparator means for comparing the measured dimensions of the oversized die against the reference CAD model; and
an ablating facility adapted to machine the oversized casting until its dimensions are
10 substantially the same as those of the reference CAD model.

There is further provided for the production facility to include:
means for generating an oversize CAD model of the die, containing a number of reference points sufficient to define a three-dimensional co-ordinate system relative
15 to the CAD model;
a rapid prototyping facility arranged to produce a three-dimensional pattern of the die from the oversize CAD model thereof; and
a production means for producing a mould of the die from the three-dimensional pattern thereof, and for casting the die from the mould thereof.

20 There is still further provided for the measuring means to be an imaging system adapted to obtain the co-ordinates of the surface of the oversize casting relative to the three-dimensional co-ordinate system defined by the number of reference points on the casting, and to convert the co-ordinates into a measured CAD model.

25 There is yet further provided for the ablating facility to be any one of a laser ablating facility, a machining facility or a spark erosion facility and for the imaging system to be a laser-based, alternatively a contact-based imaging system.

30 There is also provided for the system to include a texturing means for texturing at least a portion of the surface of the casting, and for the texturing means to include:

means for generating a reference CAD model of a desired texture to be applied to the surface of the casting;

identification means for identifying the portion of the surface of the casting to be textured, as a function of the co-ordinates of each one of the number reference
5 points on the casting; and

an ablating facility adapted to ablate the identified portion of the surface of the casting in accordance with the reference CAD model of the desired texture to be applied to the casting.

10 There is also provided for the ablating facility to be a laser machining facility.

There is further provided for the oversize casting to include at least one integral pathway therethrough and for the pathway to include a hollow back and a baffle to direct a flow of coolant therethrough.

15

BRIEF DESCRIPTION OF THE DRAWINGS

A preferred embodiment of the invention is described below, by way of example only, and with reference to the accompanying drawings in which:

20

FIG.1 is a schematic representation of a system for producing a die, according to the invention;

DETAILED DESCRIPTION OF THE INVENTION

25

Referring to Figure 1, a system for producing a die is indicated generally by reference numeral (1).

The system (1) includes a rapid prototyping facility indicated generally by reference
30 numeral (2) and a production facility (3). The rapid prototyping facility (2) includes a CAD processor (not shown) and a Stereo Lithography (SL) machine (9). The rapid

prototyping facility (2) and its operation is well known in the art and will not be described here in detail.

5 The CAD processor (7) produces data relating to a three-dimensional model of a die which is to be manufactured. The CAD model includes a number, preferably three, of reference points on the die sufficient to define a three-dimensional co-ordinate system relative to the die. These reference points are used as a basis for measuring the physical dimensions of a die produced in accordance with the CAD model as will be described in more detail below.

10

The production facility (3) includes a electroforming bath, an investment casting facility and a flash fire furnace (not shown), which are well known in the art.

15

The system (1) includes further a measuring means (4) in the form of a laser imaging system, which is commercially available from Brenckmann GmbH of Germany as well as an ablation facility (5) in the form of a laser machining system of the type which are well known in the art and which are commercially available from HK Technologies Laser Systems of the United Kingdom or LANG GmbH and Co. of Germany.

20

In use, a CAD model (7) is produced by the CAD processor (not shown) of a die of desired dimensions to be manufactured by the system. The CAD processor also produces an oversized CAD model (8) of the die to compensate for nominal shrinking during a casting step of the production process which will be described in greater detail below. A three-dimensional pattern of the oversized die is produced from the oversized CAD model (8) thereof by means of the SL machine (9). A mould of the die is then produced by the investment casting facility from the oversized three-dimensional pattern of the die, and a casting of the oversized die is produced from the mould by casting techniques which are well known in the art.

25
30

The dimensions of the oversized casting are measured by the laser imaging system (4) and converted to a CAD representation which is compared, at (10) with the nominally sized CAD model (7) of the die produced by the CAD processor to determine the deviation therefrom. The deviation, or error, is used as a control input
5 for the ablation facility (5) to machine and remove material from the oversize casting until its dimensions conform to those of the desired size as reflected by the reference CAD model (7).

It will be appreciated by those skilled in the art that the system (1) and the method
10 described above enable the production of accurately cast dies which are unaffected by regular nominal shrinkage experienced during the casting of such dies.

It is often desired to texture all or part of the surface of a die such as one produced by the system and method described above. The system (1) may be conveniently
15 utilised to achieve such a result. In order to achieve this, the system provides for the CAD processor (not shown) to generate a reference CAD model (11) of a desired texture to be applied to the surface of the casting. In use, the imaging system (4) is also employed to identify a desired portion of the surface of the casting to be textured, as a function of the co-ordinates of each of the three reference points
20 on the casting. The CAD processor is then used to compute the depth and scale of the texture to be applied to the surface of the casting and to control the laser head of the laser machining system (5) to ablate the identified portion of the surface of the casting such that the desired texture is applied to the casting as required.

25 Numerous modifications are possible to this embodiment without departing from the scope of the invention. In particular, the imaging system (4) may be a contact-based rather than a laser-based imaging system, and the laser machining system used for size reduction of the oversized casting maybe three-dimensional laser machining system, while that employed for texturing of the nominally sized casting
30 may be a two-dimensional rather than a three-dimensional laser machining system. Further, size reduction of the oversize casting may be achieved by conventional

machining or by spark erosion instead of laser ablation. Further, the oversize casting may be produced to include one or more integral pathways therethrough, each pathway having a hollow back and a baffle to direct a flow of coolant therethrough. When such hollow back dies are used in a production process, they
5 will allow a shorter cycle time of the die to be achieved.

The invention therefore provides a system and a method for the production of dies which eliminates the need for accurate prediction and compensation of shrinkage during casting in prior art methods.
10

CLAIMS

1. A method for producing a die, comprising the steps of:
5 providing a reference CAD model of the die of desired dimensions;
producing an oversized casting of the die from a mould thereof;
measuring the actual dimensions of the oversized casting;
comparing the measured dimensions of the oversized die against the
reference CAD model; and
10 ablation the oversized casting until its dimensions are substantially the
same as those of the reference CAD model.
2. A method as claimed in claim 1 in which an oversize casting of the die is
produced by the steps of:
15 providing an oversize CAD model of the die;
including in the oversize CAD model a number of reference points
sufficient to define a three-dimensional co-ordinate system relative to the
CAD model;
rapid prototyping a three-dimensional pattern of the die from the oversize
20 CAD model thereof;
producing a mould of the die from the three-dimensional pattern thereof;
and
casting the oversize die from the mould.
- 25 3. A method as claimed in claim 2 in which the actual dimensions of the
oversize casting by the steps of:
imaging the oversize casting to obtain the co-ordinates of the surface of
the oversize casting relative to the three dimensional co-ordinate system
defined by the number of reference points on the casting; and
30 converting the co-ordinates into a measured CAD model.

4. A method as claimed in any one of the preceding claims in which the oversize casting is ablated by means of any one of the methods of laser ablation, machining or spark erosion.
- 5 5. A method as claimed in claim 3 in which the oversize casting is imaged by means of a laser-based imaging system.
6. A method as claimed in claim 3 in which the oversize casting is imaged by means of a contact-based imaging system
- 10 7. A method as claimed in claim 2 which includes the additional step of texturing at least a portion of the surface of the casting.
8. A method as claimed in claim 7 in which a portion of the surface of the casting is textured by:
- 15 providing a reference CAD model of the desired texture to be applied to the surface of the casting;
- identifying the portion of the surface of the casting to be textured as a function of the co-ordinates of each one of the number of reference points on the casting; and
- 20 ablating the identified portion of the surface of the casting in accordance with the reference CAD model of the desired texture to be applied to the casting.
- 25 9. A method as claimed in claim 8 in which the portion of the surface of the casting is ablated by means of laser ablation .
- 10 .A system for producing a die comprising:
- means for generating a reference CAD model of a die of desired dimensions to be produced;
- 30

a production facility arranged to produce an oversized casting of the die from a mould thereof;

measuring means for measuring the actual dimensions of the oversized casting;

5 comparator means for comparing the measured dimensions of the oversized die against the reference CAD model; and

an ablation facility adapted to machine the oversized casting until its dimensions are substantially the same as those of the reference CAD model.

10

11. A system as claimed in claim 10 in which the production facility includes: means for generating an oversize CAD model of the die, containing a number of reference points sufficient to define a three-dimensional co-ordinate system relative to the CAD model;

15 a rapid prototyping facility arranged to produce a three-dimensional pattern of the die from the oversize CAD model thereof; and a production means for producing a mould of the die from the three-dimensional pattern thereof, and for casting the die from the mould thereof.

20

12. A system as claimed in claim 11 in which the measuring means is an imaging system adapted to obtain the co-ordinates of the surface of the oversize casting relative to the three-dimensional co-ordinate system defined by the number of reference points on the casting, and to convert
25 the co-ordinates into a measured CAD model.

25

13. A system as claimed in any one of claims 10 to 12 in which the ablation facility is any one of a laser ablation facility, a machining facility or a spark erosion facility.

30

14. A system as claimed in claim 12 in which the imaging system is a laser-based imaging system,
- 5 15. A system as claimed in claim 12 in which the imaging system is a contact-based imaging system.
16. A system as claimed in claim 2 which includes a texturing means for texturing at least a portion of the surface of the casting.
- 10 17. A system as claimed in claim 16 in which the texturing means includes:
means for generating a reference CAD model of a desired texture to be applied to the surface of the casting;
identification means for identifying the portion of the surface of the casting to be textured, as a function of the co-ordinates of each one of
15 the number reference points on the casting; and
an ablation facility adapted to ablate the identified portion of the surface of the casting in accordance with the reference CAD model of the desired texture to be applied to the casting.
- 20 18. A system as claimed in claim 17 in which the ablation facility is a laser machining facility.
19. A method for producing a die, substantially as herein described with reference to the accompanying drawings.
- 25 20. A system for producing a die, substantially as herein described with reference to and as illustrated in the accompanying drawings.

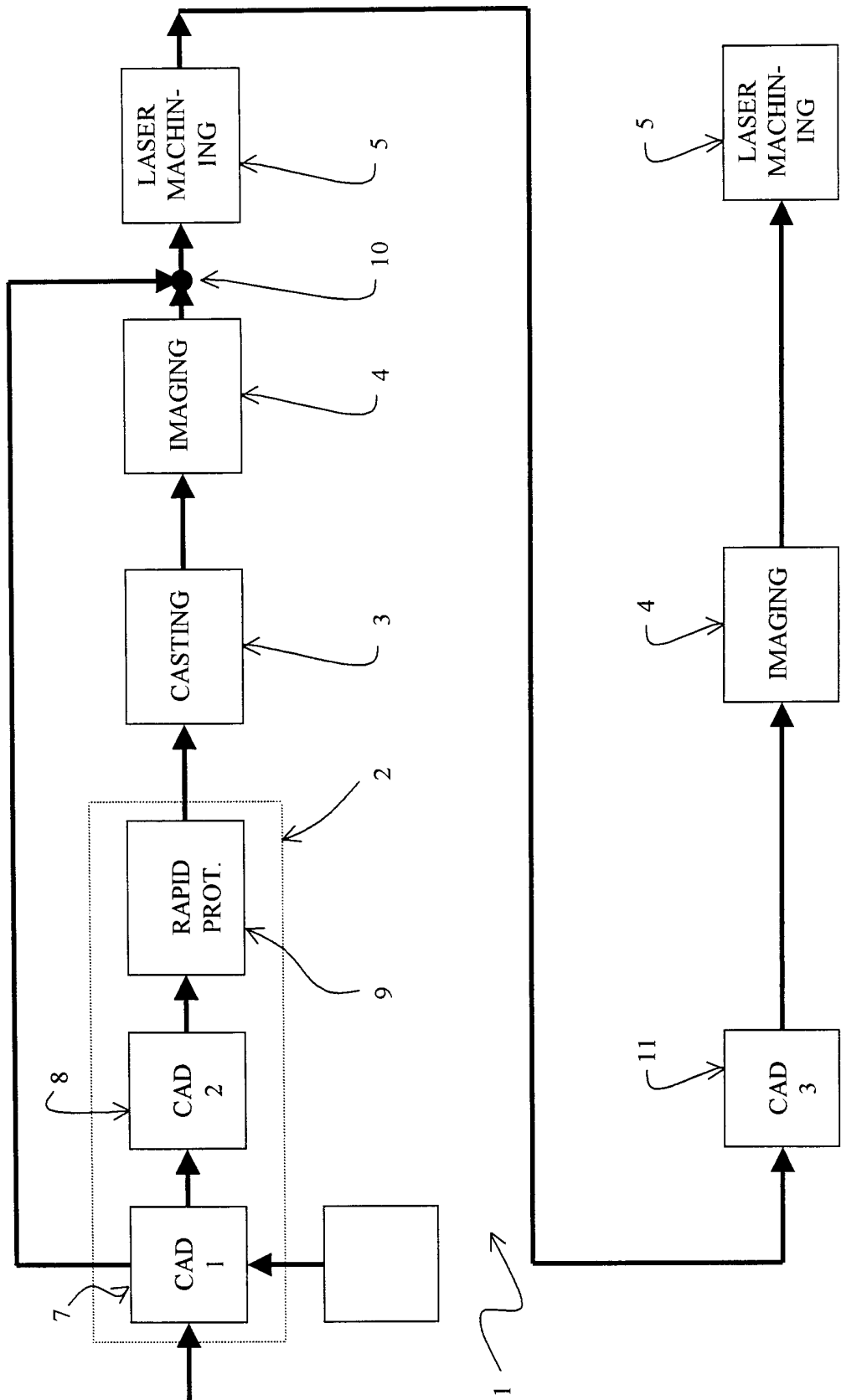


FIGURE 1

INTERNATIONAL SEARCH REPORT

International Application No
PCT/ZA 00/00182

A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 A44C17/04 B29C67/00 B23K26/00

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 7 B29C B23K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	W0 99 39889 A (EXPRESS TOOL INC) 12 August 1999 (1999-08-12) page 10, line 28 -page 11, line 3 ---	1-18
Y	US 5 823 778 A (SCHMITT STEPHEN M ET AL) 20 October 1998 (1998-10-20)	1-18
Y	column 2, line 1-37; claims 8,13 ---	1-18
A	US 5 837 960 A (BARBE MICHAEL R ET AL) 17 November 1998 (1998-11-17) column 14, line 31 -column 15, line 54; claims 23,24 -----	1-18

☐ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance
"E" earlier document but published on or after the international filing date
"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
"O" document referring to an oral disclosure, use, exhibition or other means
"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
"&" document member of the same patent family

Date of the actual completion of the international search

Date of mailing of the international search report

22 January 2001

02.02.01

Name and mailing address of the ISA
European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

Dupuis, J-L

INTERNATIONAL SEARCH REPORT

International application No.
PCT/ZA 00/00182

Box I Observations where certain claims were found unsearchable (Continuation of item 1 of first sheet)

This International Search Report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☒ Claims Nos.: 19, 20
because they relate to parts of the International Application that do not comply with the prescribed requirements to such an extent that no meaningful International Search can be carried out, specifically:
see FURTHER INFORMATION sheet PCT/ISA/210
3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box II Observations where unity of invention is lacking (Continuation of item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this International Search Report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this International Search Report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this International Search Report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.
- ☐ No protest accompanied the payment of additional search fees.

FURTHER INFORMATION CONTINUED FROM PCT/ISA/ 210

Continuation of Box I.2

Claims Nos.: 19, 20

Claims 19 and 20 contain a reference to the drawings, so that their scope cannot be defined precisely.

The applicant's attention is drawn to the fact that claims, or parts of claims, relating to inventions in respect of which no international search report has been established need not be the subject of an international preliminary examination (Rule 66.1(e) PCT). The applicant is advised that the EPO policy when acting as an International Preliminary Examining Authority is normally not to carry out a preliminary examination on matter which has not been searched. This is the case irrespective of whether or not the claims are amended following receipt of the search report or during any Chapter II procedure.

INTERNATIONAL SEARCH REPORT

International Application No

PCT/ZA 00/00182

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
WO 9939889	A	12-08-1999	AU 2496699 A	23-08-1999
US 5823778	A	20-10-1998	NONE	
US 5837960	A	17-11-1998	NONE	