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- (71) **Applicant:** NUOVO PIGNONE SRL [IT/IT]; Via Felice Matteucci 2, I-50127 Florence (IT).
- (72) **Inventors:** VERACINI, Massimo; Via Felice Matteucci 2, I-50127 Florence (IT). GUERRINI, Massimo; Via Felice Matteucci 2, I-50127 Florence (IT). CHIARI, Francescosaverio; Via Felice Matteucci 2, I-50127 Florence (IT).
- (74) **Agent:** ILLINGWORTH-LAW, William; GE International Inc., The Ark, 201 Talgarth Road, Hammersmith London W6 8BJ (GB).

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(54) **Title:** METHOD FOR GENERATING A MACHINING PROGRAM AND MACHINE TOOL

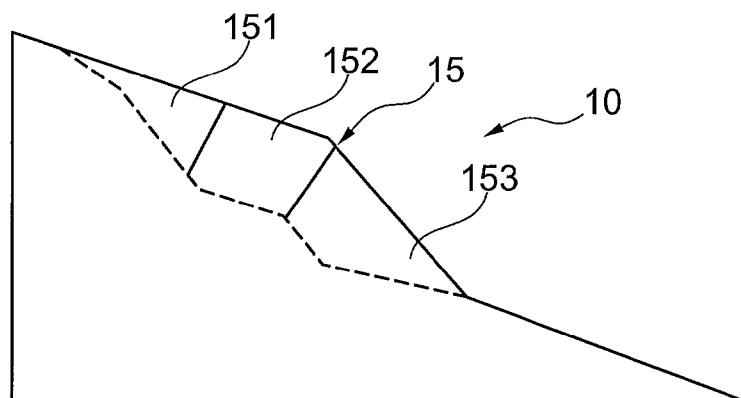


Fig. 4

(57) **Abstract:** Method for generating a machining program of a plunge mulling machine tool, comprising the steps of: establishing a machining (15) to be performed on a workpiece (10); acquiring first machining information (20) that indicates stable cut conditions of said machine tool for said workpiece (10); acquiring second machining information (30) that indicates engagement cut conditions of said machine tool during said machining on said workpiece (10); carrying out a determination of the rotation speeds of said machine tool during said machining (15) on the basis of said second machining information (30) and said first machining information (20); wherein said machining program is generated on the basis of the determination carried out.



METHOD FOR GENERATING A MACHINING PROGRAM AND MACHINE TOOL

FIELD

Embodiments of the subject matter disclosed herein relates to a method for
5 generating a machining program, a computer program product implementing
said method and a machine tool for machining workpiece according to said
method.

BACKGROUND ART

In the Oil & Gas industries, the continuous improvement in efficiency of
10 machines like large turbo compressors is imperative. Design specifications of
products like impellers are continuously updated to reach better performance
and to improve durability.

Often, a design specification consists in the shape of portions of the final
product, for example the shape of the vanes of an impeller. Also very often,
15 the desired shape is achieved by machining of the workpiece.

Project requirements imply particular shapes, with tight tolerances.
Consequently, machining requirements are very demanding.

Oil & Gas components are often machined through plunge milling. In plunge
milling, as known, the machining is performed with a plurality of subsequent
20 cylindrical milling operations. Such operations are carried out automatically
under the control of an expert machinist. A control unit equips the machine
tool, the machining program is loaded into the control unit for driving the
spindle accordingly.

The number of workpieces to produce are significant, but not so large to justify
25 other (much more expensive) manufacturing techniques. In this context,
machinists are typically very skilled operators, their control is central to obtain
a satisfying machining.

However, high requirements in machining prompted some research centers to develop software programs for determining the best conditions for perform the machining of a certain workpiece.

5 A first software program (some software programs of this kind are commercially available) provide stable cut conditions.

Such first software program receives as input the type of the material of the workpiece, the geometry of the machine tool, the engagement condition and the frequency response of the tool working on the workpiece. This information allows to calculate the work speed of the machine tool for machining the
10 workpiece in stable conditions, to safeguard the workpiece and the tool itself. Typically, such information are integrated in the machining program. This first software program may provide machining information only if the engagement condition (in input) are steady during the machining of the workpiece.

15 But often the machining of a workpiece, in particular a workpiece for the Oil & Gas industry, requires different engagement conditions, due to the particular geometry of the workpiece and/or the shape of the machining.

A second software program (some software programs of this kind are commercially available) provides engagement conditions, to establish the feed of the machine tool. In practice, this software programs provides an array
20 containing a plurality of engagement data of a plurality of corresponding points of the scheduled machining. In this way, a feed of the machine tool is assigned to each point of the scheduled machining. If the engagement data refer to steady engagement conditions during the machining, the stable cut conditions may be retrieved using the first software program. If the
25 engagement data do not refer to steady engagement conditions during the machining (as it often happens), the stable cut conditions retrievable from the first software program are not reliable. In these cases, the work and the experience of the machinist is fundamental to understand the cut conditions during the machining. On the subjective basis of what he hears and sees

during the machining of the workpiece, he corrects the speed of the machine tool to remain in the stable cut conditions.

Therefore, there is a need for a method for generating a machining program overcoming problems of the prior art.

5 SUMMARY

According to first exemplary embodiments, there is a method for generating a machining program of a machine tool comprising the steps of:

A - establishing a machining to be performed on a workpiece;

10 B - acquiring first machining information that indicates stable cut conditions of said machine tool for said workpiece;

C - acquiring second machining information that indicates engagement cut conditions of said machine tool during said machining on said workpiece;

15 D - carrying out a determination of the rotation speeds of said machine tool during said machining on the basis of said second machining information and said first machining information;

wherein said machining program is generated on the basis of the determination carried out at the step D.

20 According to second exemplary embodiments, there is a computer program product to be loaded into and executed by a computer implementing the method described.

According to third exemplary embodiments, there is a machine tool comprising a tool part adapted to perform a machining on a workpiece, and a control part, connected to said tool part, comprising storing devices and a processing device, to store and execute the computer program product
25 described to drive said tool part according to the machining program generated.

BRIEF DESCRIPTION OF THE DRAWINGS

The present invention will become more apparent from the following description of exemplary embodiments to be considered in conjunction with accompanying drawings wherein:

- 5 Figure 1 shows a block diagram of operations aimed at carrying out an embodiment of the method for generating a machining program;

Figure 2 shows a diagram of first information used in an embodiment of the method for generating a machining program;

- 10 Figure 3 shows a schematic view of second information used in an embodiment of the method for generating a machining program;

Figure 4 shows a view of a workpiece for which a machining is programmed;

Figure 5 shows a diagram of first information for the workpiece of figure 4;

Figure 6 shows a schematic view of second information for the workpiece of figure 4;

- 15 Figure 7 shows a schematic view of a step of an embodiment of the method;

Figure 8 shows a schematic view of another step of an embodiment of the method.

DESCRIPTION

- 20 The following description of exemplary embodiments refer to the accompanying drawings. The same reference numbers in different drawings identify the same or similar elements. The following detailed description does not limit the invention. Instead, the scope of the invention is defined by the appended claims.

- 25 Reference throughout the specification to “one embodiment” or “an embodiment” means that a particular feature, structure, or characteristic

described in connection with an embodiment is included in at least one embodiment of the subject matter disclosed. Thus, the appearance of the phrases “in one embodiment” or “in an embodiment” in various places throughout the specification is not necessarily referring to the same
5 embodiment. Further, the particular features, structures or characteristics may be combined in any suitable manner in one or more embodiments.

With reference to figure 1, is shown an embodiment of the method for generating a machining program of a plunge milling machine tool. It worth noting that the machine tool maybe adapted to carry out many type of milling,
10 including plunge milling. Nevertheless, embodiments of the method are in particular taught for the plunge milling.

According to one embodiment, the method provides to establish a machining
15 to be performed on a workpiece, as shown in the box 101. In such operation, the machinist or the project designer establishes the machining to be performed on the workpiece, and is typically conducted via a computer program.

Once the machining is established, first machining information 20 are acquired, as shown in the box 102. Such first machining information 20 indicates stable cut conditions of the machine tool performing the machining
20 on the workpiece 10. Typically, such information are acquired from a software specifically designed, that receives as input: the workpiece material, the geometry of the machine tool, the engagement condition and the frequency response of the tool working on the workpiece and gives as output the admissible rotation speeds of the machine tool (i.e. speed of rotation in which
25 the cut is stable) for a plurality of engagement cut conditions. The information provided are known with the term stable cut conditions, in fact provide speed rotations of the machine tool in which the cut is stable. Such first machining information refer to the workpiece for which the machining is carried out. In another embodiment such information may be calculated (providing all input

data necessary to carry out the calculus), instead of acquired as such from the software specifically designed.

As shown in the box 103, second machining information 30 are afterwards acquired. Such information indicates engagement cut conditions of the machine tool during the machining 15. In one embodiment such second machining information are a plurality of engagement data of the machine tool performing the machining. This information reflects the machining 15 established for the workpiece 10, and are typically generated by a software specifically designed (different from the one providing first machining information).

It is worth noting that the order according to which first machining information are acquired before second machining information may be inverted, and in one embodiment may such steps may be carried out concurrently.

Thus, in the step of the box 104, first and second machining information 20, 30 are acquired and, on the basis of such information, the rotation speeds of the machine tool during the machining 15 are determined. Embodiments of such determination are explained in detail below.

The box 105 represents the last step of the method for generating a machining program. In particular, the machining program is generated on the basis of the determination of the rotation speeds of the machine tool previously carried out. The machining program is adapted to be loaded into the control part of the machine tool, and is adapted to drive the tool part of the machine tool itself. Rotation speeds of the machine tool are only part of the information populating data of the machining program that is conceived to drive the machine tool in order to carry out the machining on the workpiece. In this sense, the step described in the box 105 may gather other information to properly create the machining program.

With reference to figure 2, a diagram representing the first machining information 20 is shown. The X axis represents the rotation speeds of the

machine tool, the Y axis represents the engagement cut conditions of the machine tool. As said, the first machining information 20 refer to the workpiece 10. As shown, the diagram is fundamentally divided in two regions: the unstable cut region 21 and the stable cut region 22.

- 5 In the unstable cut region 21, the machining of the workpiece 10 at a plurality of engagement cut conditions for a plurality of rotation speeds of the machine tool is unstable. Vice versa, in the stable cut region 22 the machining of the workpiece 10 at a plurality of engagement cut conditions for a plurality of rotation speeds of the machine tool is stable. The aim is to perform the
- 10 machining in stable cut conditions, whilst the unstable cut conditions are to avoid. It worth noting that a certain engagement cut condition may correspond to a plurality of rotation speeds of the machine tool for which the cut is stable, as well as a certain engagement cut condition may correspond to a plurality of rotation speeds of the machine tool for which the cut is unstable. Such data
- 15 are i.a. used to determine rotation speeds of the machine tool during the machining 15, as well be explained in detail below.

According to one embodiment, rotation speeds of the machine tool represented on the X axis is in routes per minute of the machine tool (in particular the spindle of the machine tool). Engagement cut conditions may be

20 in various format. In general, engagement cut conditions describe the states of the machine tool and the operations it has to perform to carry out a machining. For example, the engagement cut conditions related to the machining of a workpiece may be represented from the following data: “at the position corresponding to 0 millimeter of the machining, a plunge of 5 mm of

25 depth at an angle of 45 degrees” and “at the position corresponding to 1 millimeter of the machining, a plunge of 2 mm of depth at an angle of 65 degrees”, and so on. Such data may be coded to be represented, for example, by a unique identifier. On the Y axis of the diagram of the first machining information 20 may thus be represented the unique identifier

30 associated to a particular engagement condition.

With reference to figure 3, is represented a schematic view of an embodiment of the data structure for storing the second machining information 30. According to this embodiment, the second machining information 30 comprise a plurality of engagement data of the machining established at the step A. It is worth noting that such engagement data specifically refer to the established machining 15 to be performed on the workpiece 10. The engagement data of the second machining information 30 may be stored in various form, for example according to the coding previously described.

The rotation speed of the machine tool is directly related to the material removal rate. According to one embodiment, the rotation speeds are in turn determined to maximize the material removal rate of the machining.

With reference to figures from 4 to 8 is shown an embodiment of method for generating a machining program to perform the machining 15 on the workpiece 10.

In figure 4, for the workpiece 10 a machining 15 is established. For simplicity, the machining 15 comprise three main machining portions: first machining portion 151, second machining portion 152 and third machining portion 153. As a further hypothesis, each machining portion has one engagement condition. Of course, in real cases the machining portions are much more. The three different engagements conditions of the three different machining portions are not steady.

Figure 5 shows first machining information 20 of the workpiece 10 (of figure 4). Such second machining information 20 are specific for the workpiece 10, and represent the stable cut conditions for the workpiece 10. On the Y_{10_15} axis are represented the engagement conditions of the machine tool on the workpiece 10. On the X_{10_15} axis are represented the rotation speeds of the machine tool.

In the stable cut region 22, engagement cut conditions for the corresponding rotation speeds of the machine tool correspond to a stable cut of the

workpiece. On the contrary, in the unstable cut region 21 the engagement cut conditions for the corresponding rotation speeds of the machine tool correspond to an unstable cut of the workpiece. On the Y_{10_15} axis a plurality of engagement conditions of the machine tool on the workpiece 10 are represented, but only the three engagement conditions Y1, Y2 and Y3 related respectively to the three portions 151, 152 and 153 of the machining 15 are of interest to generate the machining program for the workpiece 10.

Figure 6 shows third machining information 30 of the workpiece 10. According to an embodiment, third machining information are stored as an array of engagement data. The records 31_{151} , 31_{152} , 31_{153} of the array of engagement data represent the engagement conditions of the machine tool for the machining 15. In the embodiment shown, there are three records: the first record 31_{151} represents the first engagement condition 151, the second record 32_{152} represents the second engagement condition 152 and the third record 33_{153} represents the third engagement condition 153.

Figure 7 and 8 show a schematic representation of an embodiment of the step in which the determination of the rotation speeds of machine tool is carried out.

As said, this determination occurs on the basis of the second machining information 30 (in particular 31_{151} , 31_{152} , 31_{153}) and the first machining information 20.

According to this embodiment, the determination is repeated for the portions that constitutes the whole machining. The first step is thus establishing the current portion of machining of the workpiece. This allow to determine the rotation speed for that portion of machining. In the embodiment, it is established that the first portion of the machining of the workpiece 10 is the first portion 151. From the engagement data 30, the value of the engagement cut condition for the current portion of machining of the workpiece is retrieved. As said, according to one embodiment, the portion of machining 151, 152, 153 are related to the engagement data 30.

Thus, the engagement cut condition of the first machining portion 151 is stored in the first record 31₁₅₁ of the engagement data 30.

5 The engagement cut condition for the first machining portion 151 is thus retrieved. As shown in figure 7, the next step is to control in the first machining information 20, the admissible(s) rotation speed for the first portion 151 of the machining. The engagement cut condition 31₁₅₁ of the first machining portion 151 is in the stable region 22, thus according to one embodiment the rotation speed of the machine tool for the machining of the first portion 151 is set as the maximum speed admissible, corresponding to speed indicated as X_{151} .

10 The determination of the rotation speeds provide to repeat the previous step for the remaining portions of machining. In this embodiment, the next portion of machining is the second portion 152 for which the engagement cut condition is retrievable from the second record 32₁₅₂ of the engagement data 30. Also in this case, the engagement cut condition 32₁₅₂ of the second machining portion 152 is in the stable region 22, thus the rotation speed of the machine tool for the machining of the second portion 152 is set as the maximum speed admissible, corresponding to speed indicated as X_{152} .

20 The determination of the rotation speeds is repeated for the last portion of machining - the third machining portion 153 - of the machining 15. The engagement cut condition 33₁₅₃ of the third machining portion 153 comprises some rotation speeds in the unstable region 22. These speeds are indicated with the reference number 210, and are to avoid for the machining 15 of the workpiece 10. The speeds admissible for the machining of the third portion 153 are lower than the other two. The chosen one is the higher one (in terms of routes per minute); X_{153} .

30 Once the rotation speeds for the machining 15 has been established, the machining program may be generated. With reference to figure 8, are shown part of the data collected to generate such program, in particular the rotation speeds for the machining 15 of the workpiece 10. To the first machining portion 151, which corresponds the engagement cut condition 31₁₅₁, the

rotation speed X_{151} is assigned. To the second machining portion 152, which corresponds the engagement cut condition 32_{152} , the rotation speed X_{152} is assigned. To the third machining portion 153, which corresponds the engagement cut condition 33_{153} , the rotation speed X_{153} is assigned. It worth
5 noting that rotation speeds determined maximize the material removal rate, while performing the machining on the workpiece 10 in stable cut conditions.

According to an embodiment, the machining program is generated as a part program, is thus adapted to drive the plunge milling machine tool for performing the machining of the workpiece 10.

10 According to another embodiment, there is a computer program product adapted to be loaded into and executed by a computer, implementing the method previously described.

According, there is a machine tool comprising a tool part adapted to perform a machining on a workpiece, and a control part connected to the tool part
15 comprising storing devices and a processing device, to store and execute the computer program product described, to drive the tool part according to the machining program generated.

CLAIMS:

1. Method for generating a machining program of a plunge milling machine tool, comprising the steps of:

A - establishing a machining (15) to be performed on a workpiece (10);

B - acquiring first machining information (20) that indicates stable cut conditions of said machine tool for said workpiece (10);

C - acquiring second machining information (30) that indicates engagement cut conditions of said machine tool during said machining (15);

D - carrying out a determination of the rotation speeds of said machine tool during said machining (15) on the basis of said second machining information (30) and said first machining information (20);

wherein said machining program is generated on the basis of the determination carried out at the step D.

2. Method according to claim 1 wherein said first machining information (20) are processed to provide rotation speeds of said machine tool for a plurality of corresponding engagement cut conditions.

3. Method according to claim 1 or 2 wherein said second machining information (30) comprise a plurality of engagement data of the machining established at the step A.

4. Method according to any of the preceding claims wherein the determination of the rotation speeds is carried out to maximize the material removal rate of said machining.

5. Method according to any of the preceding claims, wherein said determination comprises the following steps:

E - establishing the current portion of machining (151, 152, 153) of said workpiece;

F - retrieving from the engagement data the value of the engagement cut condition of the current portion of machining (151, 152, 153);

G - controlling in the first machining information (20) the rotation speed of the machine tool associated to the retrieved engagement cut condition;

H - determining the machining speed for the current state of machining of said workpiece (10) on the basis of the control carried out at the step G.

I - repeating the previous steps for the remaining portions of machining (151, 152, 153) of said workpiece.

6. Method according to claim 5 wherein said machining program is generated as a part program adapted to drive said plunge milling machine tool for performing the machining of said workpiece.

7. Computer program product adapted to be loaded into and executed by a computer, implementing the method from claims 1 to 6.

8. Machine tool comprising a tool part adapted to perform a machining on a workpiece and a control part connected to said tool part comprising storing devices and a processing device, to store and execute the computer program product of claim 7 to drive said tool part according to the machining program generated.

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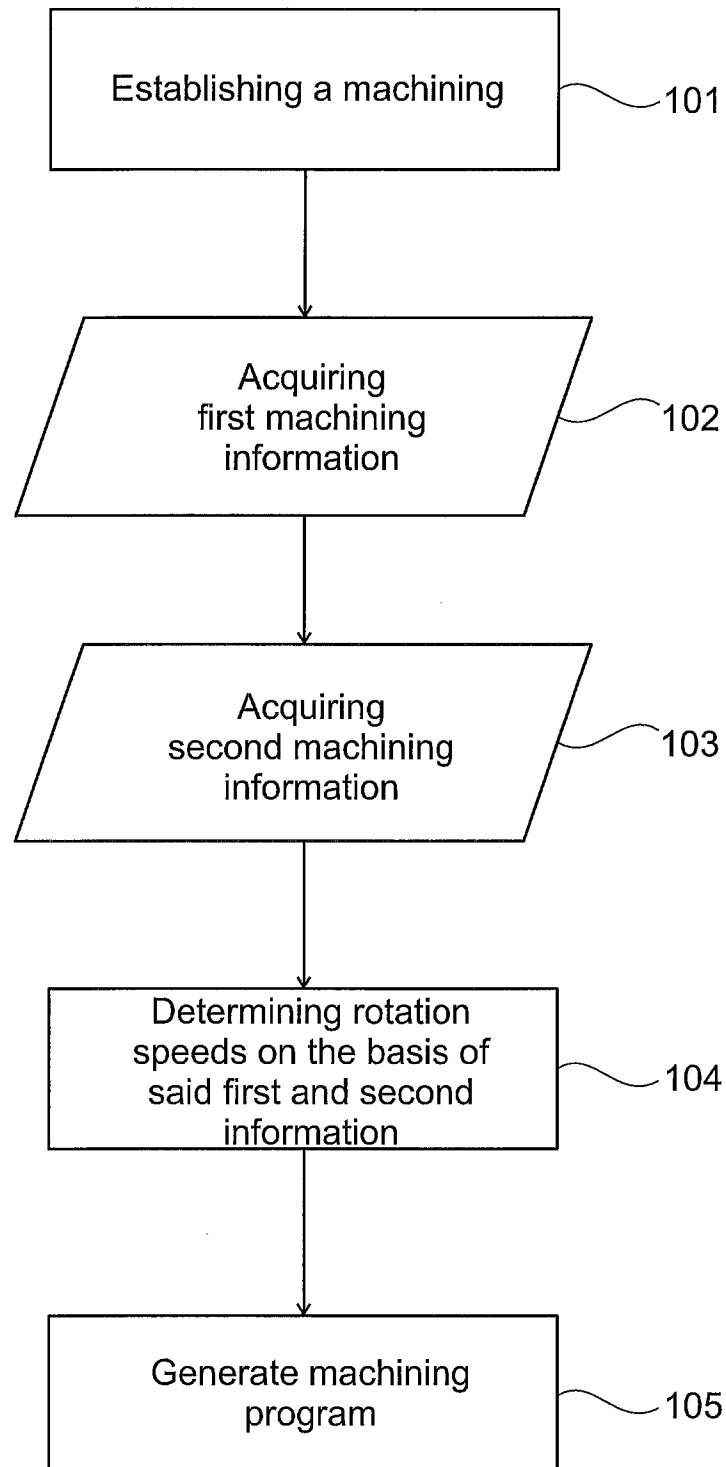


Fig. 1

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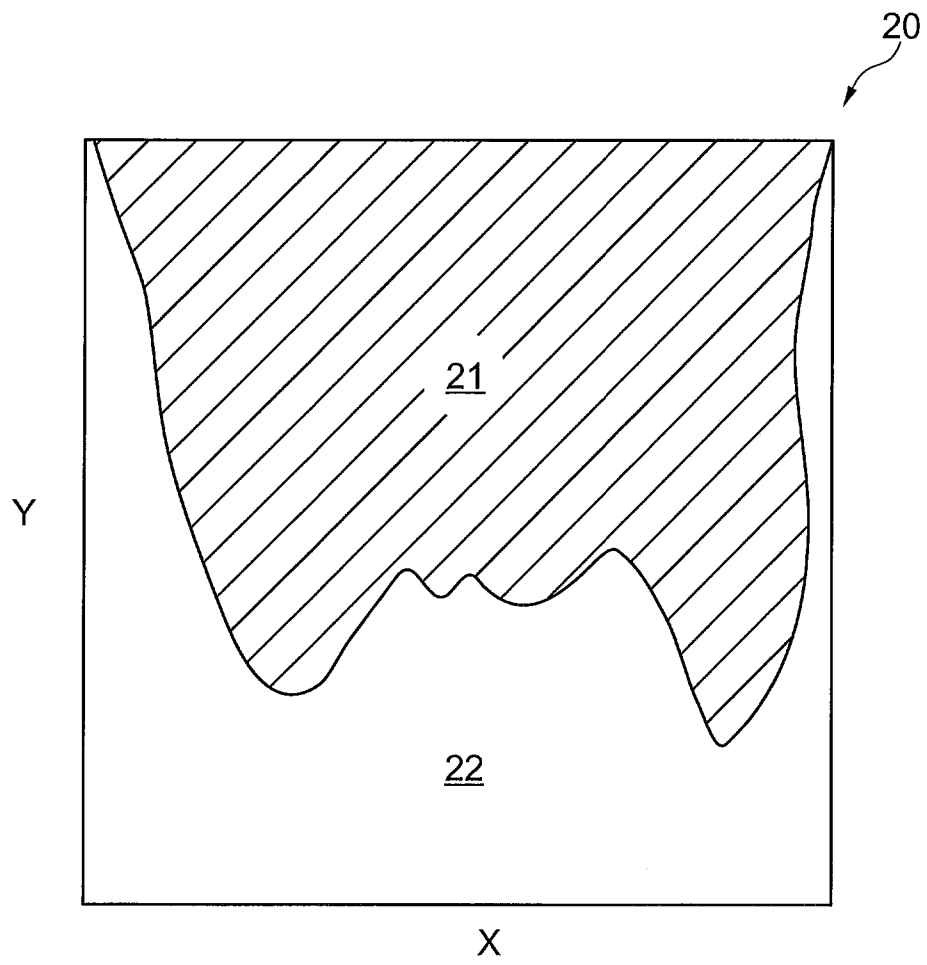


Fig. 2

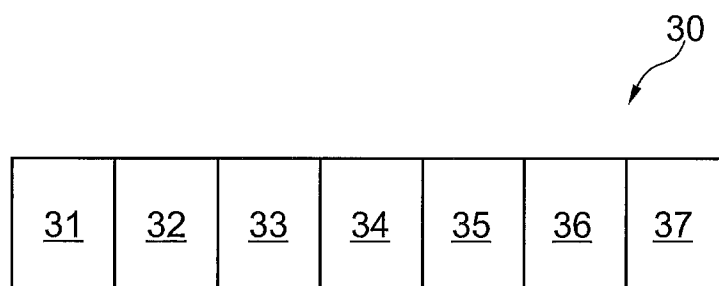


Fig. 3

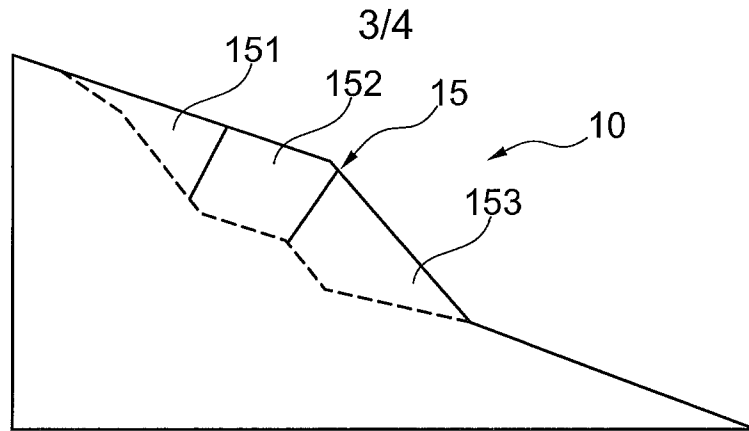


Fig. 4

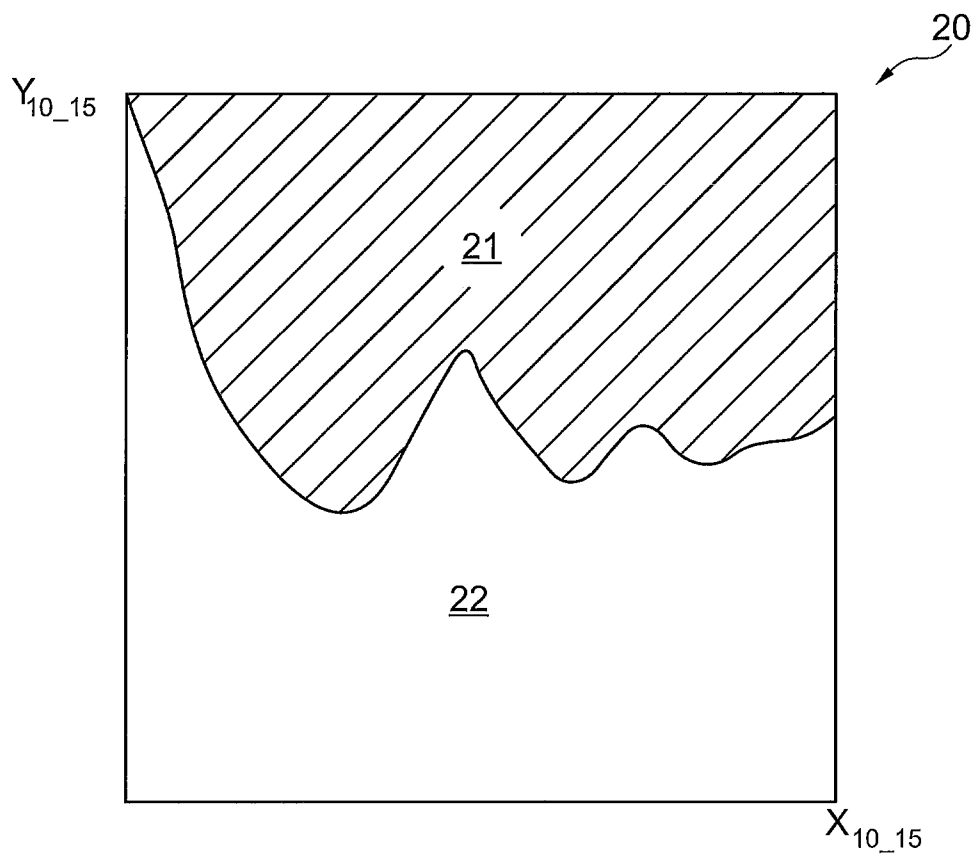


Fig. 5

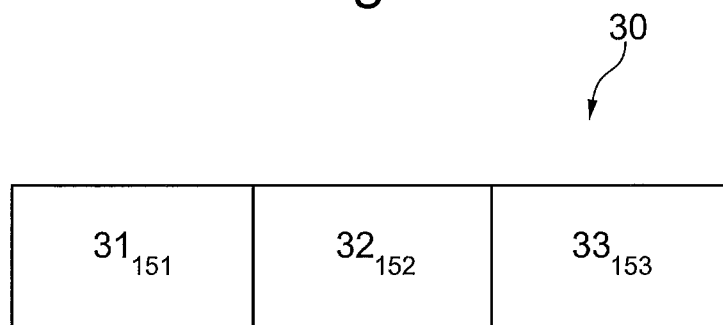
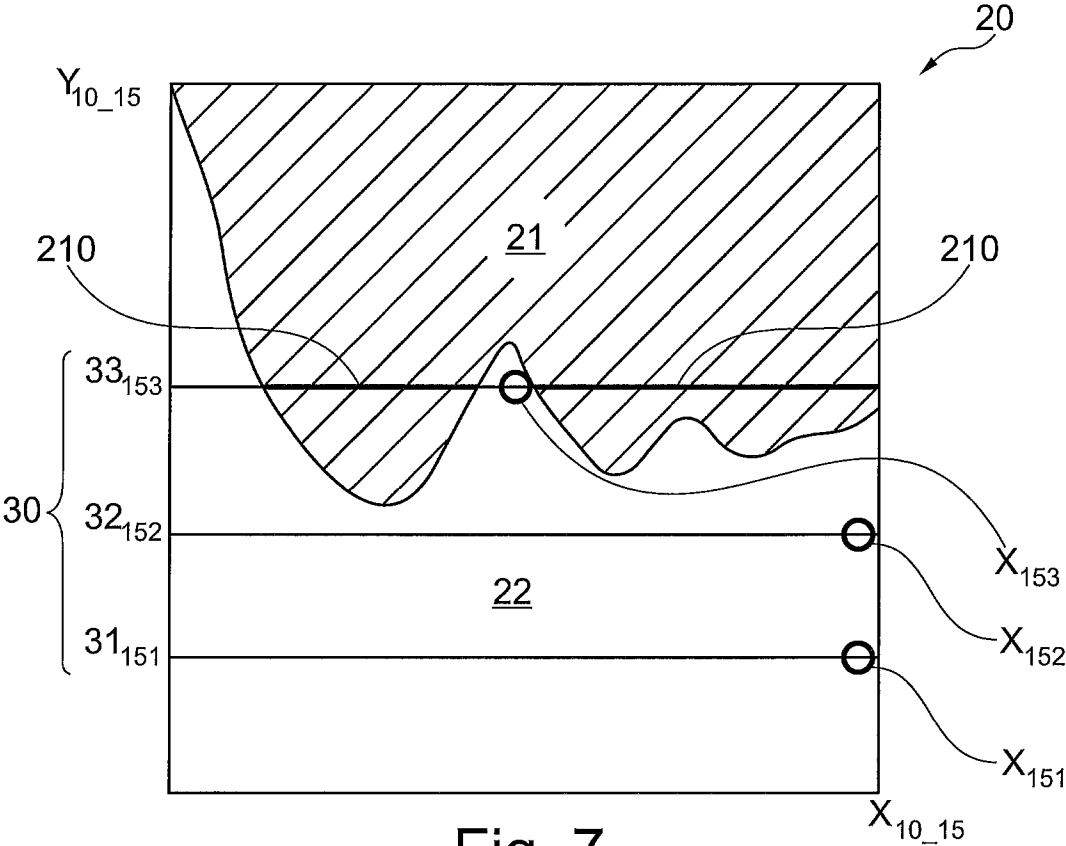


Fig. 6



31 ₁₅₁	X ₁₅₁
32 ₁₅₂	X ₁₅₂
33 ₁₅₃	X ₁₅₃

Fig. 8

INTERNATIONAL SEARCH REPORT

International application No
PCT/EP2015/075741

A. CLASSIFICATION OF SUBJECT MATTER
INV. G05B19/4093 B23C3/00
ADD.

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)
G05B B23C

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

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

EPO-Internal, WPI Data, INSPEC

C. DOCUMENTS CONSIDERED TO BE RELEVANT

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Y	US 8 676 372 B1 (BOLIN JARED LEE [US] ET AL) 18 March 2014 (2014-03-18) column 6, line 50 - column 7, line 21 column 9, line 15 - column 14, line 17 figures 12-14 ----- -/-	1-8



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Date of the actual completion of the international search

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Date of mailing of the international search report

15/01/2016

Name and mailing address of the ISA/

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NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040,
Fax: (+31-70) 340-3016

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Orobitg Oriola, R

INTERNATIONAL SEARCH REPORT

International application No
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C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

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