



- (51) **International Patent Classification:**  
*C03B 33/023* (2006.01) *C03B 33/09* (2006.01)  
*B65G 49/06* (2006.01)
- (21) **International Application Number:**  
PCT/US2013/067978
- (22) **International Filing Date:**  
1 November 2013 (01.11.2013)
- (25) **Filing Language:** English
- (26) **Publication Language:** English
- (30) **Priority Data:**  
13/673,385 9 November 2012 (09.11.2012) US
- (71) **Applicant:** CORNING INCORPORATED [US/US]; 1 Riverfront Plaza, Corning, New York 14831 (US).
- (72) **Inventors; and**
- (71) **Applicants :** CHANG, Chester Hann Huei [US/US]; 51 Katie Lane, Painted Post, New York 14870 (US). FLEMING, Todd Benson [US/US]; 112 Legion Heights Road, Elkland, Pennsylvania 16920 (US). MARSHALL, Dale Charles [US/US]; 1443 Drake Road, Brockport, New York 14420 (US). MERZ, Gary Edward [US/US]; 240 Windemere Road, Rochester, New York 14610 (US). RHOADS, Christopher Michael [US/US]; 300 N. 130th Street, Apt. 7204, Seattle, Washington 98133 (US).

TOSCH, John Earl [US/US]; 2583 South Broadway Avenue, Wellsburg, New York 14894 (US). TRZECIAK, Thaddeus Francis [US/US]; 16 B West Avenue, Naples, New York 14512 (US).

(74) **Agent:** ABLE, Kevin M; Corning Incorporated, Intellectual Property Department, SP-Ti-03-01, Corning, New York 14831 (US).

(81) **Designated States** (*unless otherwise indicated, for every kind of national protection available*): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IR, IS, JP, KE, KG, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) **Designated States** (*unless otherwise indicated, for every kind of regional protection available*): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV,

[Continued on next page]

(54) **Title:** METHODS OF PROCESSING A GLASS RIBBON

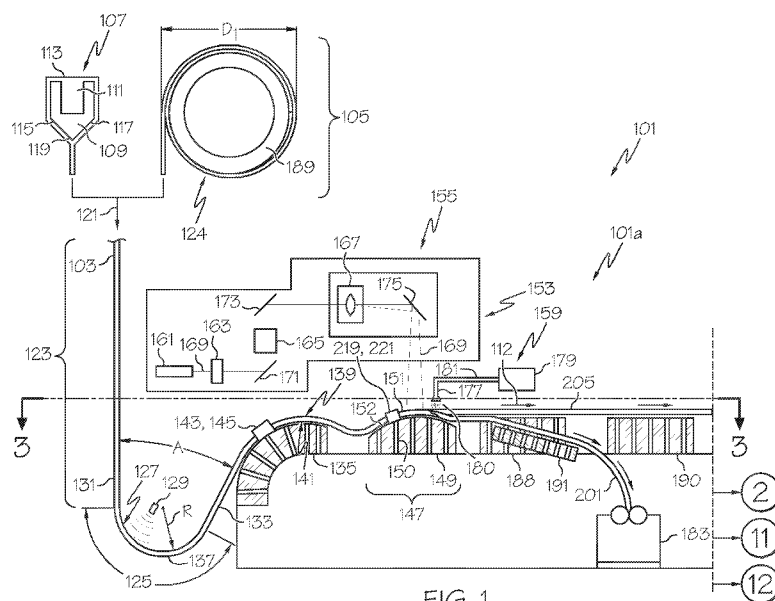


FIG. 1

(57) **Abstract:** Methods of processing a glass ribbon are provided. The method comprises the step of traversing the glass ribbon through a travel path at a predetermined velocity and severing the glass ribbon to create an upstream web and a downstream web. The method further includes the step of increasing a relative velocity of a downstream edge portion with respect to an upstream edge portion to create a gap between an upstream severed edge and a downstream severed edge. In other example methods, a segment of the glass ribbon is removed to create a gap between an upstream severed edge and a downstream severed edge. In still further example methods, an upstream severed edge is directed along a second travel path to create a gap between the upstream severed edge and a downstream severed edge.



MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, **Published:**

SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ,

GW, KM, ML, MR, NE, SN, TD, TG).

— *without international search report and to be republished  
upon receipt of that report (Rule 48.2(g))*

## METHODS OF PROCESSING A GLASS RIBBON

### CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application claims priority to U.S. Patent Application No. 13/673,385 filed on November 9, 2012, the content of which is included herein by reference in its entirety.

### TECHNICAL FIELD

[0002] The present invention relates generally to methods of processing a glass ribbon and, more particularly, to methods of processing a glass ribbon that creates a gap between an upstream severed edge and a downstream severed edge.

### BACKGROUND

[0003] Glass ribbon is known to be used to manufacture various glass products such as LCD sheet glass. Processing of the glass ribbon can be performed with a “roll-to-roll” process where glass ribbon is unwound from an upstream storage roll and then subsequently wound on a downstream storage roll.

### SUMMARY

[0004] The following presents a simplified summary of the disclosure in order to provide a basic understanding of some example aspects described in the detailed description.

[0005] In a first aspect, a method of processing a glass ribbon includes the step (I) of traversing the glass ribbon through a travel path at a predetermined velocity. The method further includes the step (II) of severing the glass ribbon along a direction transverse to the travel path to create an upstream web comprising a upstream edge portion including a upstream severed edge and a downstream web comprising an downstream edge portion including an downstream severed edge. The method further includes the step (III) of increasing a relative velocity of the downstream edge portion with respect to the upstream edge portion to create a gap between the upstream severed edge and the downstream severed edge.

[0006] In one example of the first aspect, step (III) includes increasing the velocity of the downstream edge portion to provide the increased relative velocity of the downstream edge portion with respect to the upstream edge portion.

[0007] In another example of the first aspect, an amount of the downstream web is collected by an accumulator to increase the velocity of the downstream edge portion.

[0008] In still another example of the first aspect, step (III) comprises decreasing the velocity of the upstream edge portion to provide the increased relative velocity of the downstream edge portion with respect to the upstream edge portion.

[0009] In yet another example of the first aspect, an amount of the upstream web is collected by an accumulator to decrease the velocity of the upstream edge portion.

[0010] In still another example of the first aspect, the glass ribbon of step (I) includes a width extending transverse to the travel path between a first side edge and a second side edge. At least one of the first or second side edge includes a handling tab with a mounting portion including an aperture configured to expose the entire respective first or second side edge within a target area. Step (II) includes severing the glass ribbon through the at least one of the first or second side edge within the target area.

[0011] In another example of the first aspect, step (II) is initiated in response to a storage roll reaching a predetermined storage capacity.

[0012] In yet another example of the first aspect, after step (III), the downstream web is wound on a first storage roll, and the upstream edge portion of the upstream web is introduced to a second storage roll to begin winding the upstream web on the second storage roll.

[0013] The first aspect may be carried out alone or in combination with one or more of the examples of the first aspect discussed above.

[0014] In a second aspect, a method of processing a glass ribbon comprising the step (I) of traversing the glass ribbon through a travel path at a predetermined velocity. The method further includes the step (II) of severing the glass ribbon at a first location transverse to the travel path. The method still further includes the step (III) of severing the glass ribbon at a second location transverse to the travel path such that a segment of glass ribbon is severed from an upstream web including an upstream severed edge and a downstream web including a downstream severed edge. The method also includes the step (IV) of removing the segment of the glass ribbon such that a gap is created between the upstream severed edge and the downstream severed edge.

[0015] In one example of the second aspect, a sever path created during step (II) is substantially parallel to a sever path created during step (III).

**[0016]** In another example of the second aspect, the glass ribbon of step (I) includes a width extending transverse to the travel path between a first side edge and a second side edge, wherein at least one of the first or second side edge includes a handling tab with a mounting portion including an aperture configured to expose the entire respective first or second side edge within a target area. Furthermore, step (II) includes severing the glass ribbon through the at least one of the first or second side edge within the target area.

**[0017]** In still another example of the second aspect, step (II) is initiated in response to a storage roll reaching a predetermined storage capacity.

**[0018]** In yet another example of the second aspect, after step (IV), the downstream web is wound on a first storage roll, and the downstream severed edge of the upstream web is introduced to a second storage roll to begin winding the upstream web on the second storage roll.

**[0019]** The second aspect may be carried out alone or in combination with one or more of the examples of the second aspect discussed above.

**[0020]** In a third aspect, a method of processing a glass ribbon comprises the step (I) of traversing the glass ribbon through a first travel path at a predetermined velocity to be wound on a first storage roll. The method further includes the step (II) of severing the glass ribbon along a direction transverse to the travel path to create an upstream web including an upstream severed edge and a downstream web including a downstream severed edge. The method further includes the step (III) of directing the upstream severed edge along a second travel path to create a gap between the upstream severed edge and the downstream severed edge.

**[0021]** In accordance with one example of the third aspect, step (III) includes directing the upstream severed edge along the second travel path to be wound on a second storage roll.

**[0022]** In accordance with another example of the third aspect, the glass ribbon of step (I) includes a width extending transverse to the travel path between a first side edge and a second side edge, wherein at least one of the first or second side edge includes a handling tab with a mounting portion including an aperture configured to expose the entire respective first or second side edge within a target area. Furthermore, step (II) includes severing the glass ribbon through the at least one of the first or second side edge within the target area.

[0023] In accordance with yet another example of the third aspect, step (II) is initiated in response to the first storage roll reaching a predetermined storage capacity.

[0024] The third aspect may be carried out alone or in combination with one or more of the examples of the third aspect discussed above.

#### BRIEF DESCRIPTION OF THE DRAWINGS

[0025] These and other aspects are better understood when the following detailed description is read with reference to the accompanying drawings, in which:

[0026] **FIG. 1** is a schematic illustration of an edge separation apparatus;

[0027] **FIG. 2** is a schematic illustration of an apparatus for severing a glass ribbon;

[0028] **FIG. 3** is a sectional view of the edge separation apparatus along line 3-3 of **FIG. 1**;

[0029] **FIG. 4** is a sectional view along line 4-4 of **FIG. 2** showing a scribe tip beginning to form a predetermined flaw in the first side of the glass ribbon;

[0030] **FIG. 5** is a sectional view similar to **FIG. 4** after forming the predetermined flaw;

[0031] **FIG. 6** is an enlarged view of a severing zone of **FIG. 2** with a portion of the glass ribbon including a predetermined flaw in a first orientation;

[0032] **FIG. 7** is a view similar to **FIG. 6** with a force being applied to the second side of the glass ribbon to bend a target segment of the glass ribbon;

[0033] **FIG. 8** is another view similar to **FIG. 7** with the predetermined flaw approaching a severing position;

[0034] **FIG. 9** illustrates the step of severing the central portion of the glass ribbon between opposed edge portions at the predetermined flaw located in the severing zone;

[0035] **FIG. 10** illustrates the portion of the glass ribbon being returned to the first orientation;

[0036] **FIG. 11** a schematic illustration demonstrating the step of switching between a first storage roll and a second storage roll;

[0037] **FIG. 12** is a schematic view of another example apparatus for severing a glass ribbon;

[0038] **FIG. 13** is a sectional view along line 13-13 of **FIG. 12**;

[0039] **FIG. 14** is an enlarged view of the apparatus for severing a glass ribbon from **FIG. 12** with the target segment in a first orientation;

[0040] **FIG. 15** is similar to **FIG. 14** with the target segment in a bent orientation;

[0041] **FIG. 16** is similar to **FIG. 15** with the target segment in the bent orientation and the glass ribbon being severed at the predetermined flaw located in the severing zone;

[0042] **FIG. 17** is a view similar to **FIG. 6** also showing pinch rolls and velocity indicators for each set of pinch rolls;

[0043] **FIG. 18** is similar to **FIG. 17** demonstrating the step of increasing the velocity of the downstream edge portion;

[0044] **FIG. 19** is similar to **FIG. 17** demonstrating the step of decreasing the velocity of the upstream edge portion;

[0045] **FIG. 20** is a view similar to **FIG. 6** also showing glass ribbon accumulators for the upstream web and the downstream web;

[0046] **FIG. 21** is similar to **FIG. 20** demonstrating the step of collecting an amount of the downstream web in the downstream accumulator;

[0047] **FIG. 22** is similar to **FIG. 20** demonstrating the step of collecting an amount of the upstream web in the upstream accumulator;

[0048] **FIG. 23** is a view similar to **FIG. 6** demonstrating the step of removing a segment of the glass ribbon;

[0049] **FIG. 24** is a view similar to **FIG. 6** demonstrating the step of directing the upstream severed edge along a second travel path; and

[0050] **FIG. 25** is a sectional view along line 25-25 of **FIG. 11**.

#### DETAILED DESCRIPTION

[0051] Examples will now be described more fully hereinafter with reference to the accompanying drawings in which example embodiments are shown. Whenever possible, the same reference numerals are used throughout the drawings to refer to the same or like parts. However, aspects may be embodied in many different forms and should not be construed as limited to the embodiments set forth herein.

[0052] **FIGS. 1 and 2** illustrate just one example of an apparatus **101** for fabricating a glass ribbon **103**. As shown, **FIG. 2** is a continuation of **FIG. 1**, wherein **FIGS. 1 and 2** can be read together as the overall configuration of the apparatus **101**.

Examples of the apparatus **101** can include an edge separation apparatus **101a** illustrated in **FIG. 1** although the edge separation apparatus may be omitted in further examples. In addition or alternatively, as shown in **FIG. 2**, the apparatus **101** can also include an apparatus **101b** for severing a glass ribbon. The edge separation apparatus **101a**, for example, may be optionally employed to remove beads or other edge imperfections as described more fully below. Alternatively, the edge separation apparatus **101a** may be used to divide the glass ribbon for further processing of the central portion and/or edge portions. The apparatus **101b** for severing a glass ribbon can be provided, for example, to help sever a sheet to the desired length, remove an undesirable segment of glass ribbon from the source of glass ribbon, and/or facilitate switching between a first storage roll and a second storage roll with minimal, if any, disruption in traversing of the glass ribbon from the source of glass ribbon.

[0053] The glass ribbon **103** for the apparatus **101** can be provided by a wide range of glass ribbon sources. **FIG. 1** illustrates two example sources **105** of glass ribbon **103** although other sources may be provided in further examples. For instance, as shown in **FIG. 1**, the source **105** of glass ribbon **103** can comprise a down draw glass forming apparatus **107**. As schematically shown, the down draw glass forming apparatus **107** can include a forming wedge **109** at the bottom of a trough **111**. In operation, molten glass **113** can overflow the trough **111** and flow down opposite converging sides **115**, **117** of the forming wedge **109**. Converging sides **115**, **117** meet at a root **119**. The two sheets of molten glass are subsequently fused together as they are drawn off the root **119** of the forming wedge **109**. As such, the glass ribbon **103** may be fusion down drawn to traverse in a downward direction **121** off the root **119** of the forming wedge **109** and directly into a downward zone **123** positioned downstream from the down draw glass forming apparatus **107**. Other down draw forming methods for the glass ribbon source **105** such as slot draw are also possible. Regardless of the source or method of production, the glass ribbon **103** can possibly have a thickness of  $\leq 500$  microns,  $\leq 300$  microns,  $\leq 200$  microns, or  $\leq 100$  microns. In one example, the glass ribbon **103** can include a thickness of from about 50 microns to about 300 microns, for example 50, 60, 80, 100, 125, 150, 175, 200, 225, 250, 260, 270, 280, 290, or 300 microns, although other thicknesses may be provided in further examples. The glass ribbon **103** can possibly have a width of  $\geq 20$ mm,  $\geq 50$ mm,  $\geq 100$ mm,  $\geq 500$ mm, or  $\geq 1000$ mm. The glass ribbon **103** can possibly have a variety of compositions including but not limited to soda-lime, borosilicate, alumino-



borosilicate, alkali-containing, or alkali-free. The glass ribbon **103** can possibly have a coefficient of thermal expansion of  $\leq 15\text{ppm}/^\circ\text{C}$ ,  $\leq 10\text{ppm}/^\circ\text{C}$ , or  $\leq 5\text{ppm}/^\circ\text{C}$ . The glass ribbon **103** can possibly have a speed as it traverses along travel direction **112** of  $\geq 50\text{mm/s}$ ,  $\geq 100\text{mm/s}$ , or  $\geq 500\text{mm/s}$ .

[0054] As shown by the cross section of **FIG. 3**, the glass ribbon **103** can include a pair of opposed edge portions **201**, **203** and a central portion **205** spanning between the opposed edge portions **201**, **203**. Due to the down draw fusion process, the edge portions **201**, **203** of the glass ribbon may have corresponding beads **207**, **209** with a thickness “ $T_1$ ” that is greater than a thickness “ $T_2$ ” of the central portion **205** of the glass ribbon **103**. The apparatus **101** can be designed to process glass ribbons **103** with a thin central portion **205**, such as glass ribbons with a thickness “ $T_2$ ” in a range of from about 20 microns to about 300 microns (e.g., 20, 30, 40, 50, 60, 70, 80, 90, 100, 110, 120, 130, 140, 150, 170, 190, 210, 230, 250, 260, 270, 280, 290, or 300 microns, for example), such as from about 50 microns to about 300 microns, such as from about 85 microns to about 150 microns although glass ribbons with other thicknesses may be processed in further examples. In addition or alternatively to what is shown in **FIG. 3**, the edge beads **207**, **209** may have non-circular shapes such as elliptical, oblong, rectangular, or other shapes with convex or other features.

[0055] Turning back to **FIG. 1**, another example source **105** of glass ribbon **103** can comprise a coiled spool **124** of glass ribbon **103**. For example, glass ribbon **103** may be wound into the coiled spool **124** after being drawn into a glass ribbon, for example, with the down draw glass forming apparatus **107**. The glass ribbon **103** rolled or coiled on the spool **124** may or may not have the illustrated edge beads **201**, **203**. However, if the greater thickness of the edge portions **201**, **203** are present, they may increase the minimum bend radius required to avoid cracking or breaking the glass ribbon. As such, if coiled, the glass ribbon **103** may be coiled with a relatively large bend radius such that a given length of glass ribbon **103** would require a coiled spool **124** with a relatively large diameter “ $D_1$ ”. Thus, if the source **105** comprises the coiled spool **124**, the glass ribbon **103** may be uncoiled from the coiled spool **124** of glass ribbon **103** to traverse the glass ribbon **103** in the downward direction **121** into the downward zone **123**.

[0056] **FIGS. 1 and 2** illustrate aspects of just one example edge separation apparatus **101a** that may be optionally included although, if provided, other edge separation apparatus may be incorporated in further examples. As shown in **FIG. 1**, the

optional edge separation apparatus can include a bending zone **125** downstream from the downward zone **123**. In the bending zone **125**, the edge separation apparatus **101a** can be designed to permit the glass ribbon **103** to travel through a curved path such that an upper surface **127** of the glass ribbon **103** comprises an upwardly concave surface as the ribbon bends through a radius “**R**” within the bending zone **125**. The radius “**R**” may be greater than a minimum bend radius of the glass ribbon **103** to avoid excessive stress concentrations in the glass ribbon **103**. The glass ribbon **103** may extend through various arcs within the bending zone **125** such that a pre-bending portion **131** of the glass ribbon **103** entering the bending zone **125** can extend at various angles with respect to a post-bending portion **133** of the glass ribbon **103**. For example, as shown in **FIG. 1**, the angle “**A**” between the pre-bending portion **131** and the post-bending portion **133** can comprise an acute angle although angles of 90° or more may be provided in further examples while still providing the upwardly concave surface **127**.

[0057] The edge separation apparatus **101a** can further include an optional bending support member **135** in examples where the elevation of a lower portion **137** of the glass ribbon within the bending zone **125** is lower than a lateral travel elevation of the glass ribbon passing through support portions leading to a cutting zone **147**. The bending support member **135**, if provided, can comprise a non-contact support member **135** designed to support the glass ribbon **103** without touching the opposed first and second sides **141**, **139** of the central portion **205** of the glass ribbon **103**. For example, the bending support member **135** can comprise one or more curved air bars configured to provide a cushion of air to space the glass ribbon from contacting the bending support member **135**.

[0058] Examples of the edge separation apparatus **101a** can include lateral guides **143**, **145** to help orient the glass ribbon **103** in the correct lateral position relative to a travel direction **112** of the glass ribbon **103**. For example, as schematically shown in **FIG. 3**, the lateral guides can each comprise rollers **211** configured to engage a corresponding one of the opposed edge portions **201**, **203**, or if provided, corresponding handling tabs **651**, **653**. Handling tabs **651**, **653** may be, for example, a polymeric tape applied to the edge portions. Corresponding forces **213**, **215** applied to the edge portions **201**, **203** by the corresponding lateral guides **143**, **145** can help properly shift and align the glass ribbon **103** in the proper lateral orientation along a direction of an axis **217** transverse to the travel direction **112** of the glass ribbon **103**. The cutting zone produces

an edge quality that possibly enables the central portion **205** to be bent at a radius of  $\leq 500\text{mm}$ ,  $\leq 300\text{mm}$ ,  $\leq 200\text{mm}$ ,  $\leq 100\text{mm}$ , or  $\leq 50\text{mm}$ .

[0059] As further illustrated, the lateral guides **143**, **145** can be designed to engage the edge portions **201**, **203**, or corresponding handling tabs **651**, **653**, without engaging the central portion **205** of the glass ribbon **103**. As such, the pristine surfaces of the opposed sides **139**, **141** of the central portion **205** of the glass ribbon **103** can be maintained while avoiding undesired scratching or other surface contamination that might otherwise occur if the lateral guides **143**, **145** were to engage either of the opposed first and second sides **141**, **139** of the central portion **205** of the glass ribbon **103**. Engagement on the edge portions **201**, **203**, or corresponding handling tabs **651**, **653**, also prevents damage or contamination to opposed edges **223**, **225** of the central portion **205** which could degrade the strength of central portion **205** and increase the probability of breakage when central portion **205** is bent such as when rolled onto storage spool **185**. Moreover, the lateral guides **143**, **145** may engage the glass ribbon **103** as it is being bent about the axis **217** transverse to the travel direction **112** of the glass ribbon **103**. Bending the glass ribbon **103** over the bending support member **135** can increase the rigidity of the glass ribbon **103** throughout the bend. As such, the lateral guides **143**, **145** can apply lateral forces to the glass ribbon **103** in a bent condition as the glass ribbon **103** passes over the bending support member **135**. The forces **213**, **215** applied by the lateral guides **143**, **145** are therefore less likely to buckle or otherwise disturb the stability of the glass ribbon profile when laterally aligning as the glass ribbon **103** passes over the bending support member **135**.

[0060] The edge separation apparatus can further include a cutting zone **147** downstream from the bending zone **125**. In one example, the edge separation apparatus **101a** may include a cutting support member **149** configured to bend the glass ribbon **103** in the cutting zone **147** to provide a bent target segment **151** with a bent orientation in the cutting zone **147**. Bending the target segment **151** within the cutting zone **147** can help stabilize the glass ribbon **103** during the cutting procedure. Such stabilization can help prevent buckling or disturbing the glass ribbon profile during the procedure of severing at least one of the opposed edge portions **201**, **203** from the central portion **205** of the glass ribbon **103**. The cutting zone produces an edge quality that possibly enables the central portion **205** to be bent at a radius of  $\leq 500\text{mm}$ ,  $\leq 300\text{mm}$ ,  $\leq 200\text{mm}$ ,  $\leq 100\text{mm}$ , or  $\leq 50\text{mm}$ .

[0061] The cutting support member **149**, if provided, can comprise a non-contact cutting support member **149** designed to support the glass ribbon **103** without touching the opposed sides **139**, **141** of the glass ribbon **103**. For example, the non-contact cutting support member **149** can comprise one or more curved air bars configured to provide a cushion of air space between the glass ribbon **103** and the cutting support member **149** to prevent the central portion **205** of the glass ribbon **103** from contacting the cutting support member **149**.

[0062] In one example, the cutting support member **149** can be provided with a plurality of passages **150** configured to provide positive pressure ports such that an air stream can be forced through the positive pressure ports toward the bent target segment **151** to create an air cushion for a noncontact support of the bent target segment **151**. Optionally, the plurality of passages **150** can include negative pressure ports such that an air stream can be drawn away from the bent target segment **151** to create a suction to partially counteract the force from the air cushion created by the positive pressure ports. A combination of positive and negative pressure ports can help stabilize the bent target segment **151** throughout the cutting procedure. Indeed, the positive pressure ports can help maintain a desired air cushion height between the central portion **205** of the glass ribbon **103** and the cutting support member **149**. At the same time, the negative pressure ports can help pull the glass ribbon toward the cutting support member **149** to prevent the glass ribbon **103** from undulating and/or prevent portions of the bent target segment **151** from floating away when traversing over the cutting support member **149** in the travel direction **112**.

[0063] Providing a bent target segment **151** in the cutting zone **147** can also increase the rigidity of the glass ribbon **103** throughout the cutting zone **147**. Increasing the rigidity of the glass ribbon **103** throughout the cutting zone **147** can help reduce changes in orientation due to natural shape variation of the incoming ribbon **103** which can produce undesirable variation in the cutting process. Increasing the rigidity of the glass ribbon **103** throughout the cutting zone **147** can also reduce the impact of mechanical perturbations and vibrations on the cutting process. Also, as shown in **FIG. 3**, optional lateral guides **219**, **221** can apply lateral forces to the glass ribbon **103** in a bent condition as the glass ribbon **103** passes over the cutting support member **149** within the cutting zone **147**. Forces **223**, **225** applied by the lateral guides **219**, **221** are therefore less likely to buckle or otherwise disturb the stability of the glass ribbon profile when

laterally aligning as the glass ribbon **103** passes over the cutting support member **149**. The optional lateral guides **219**, **221** can therefore be provided to fine tune the bent target segment **151** at the proper lateral orientation along a direction of the axis **217** transverse to the travel direction **112** of the glass ribbon **103**.

[0064] As set forth above, providing the bent target segment **151** in a bent orientation within the cutting zone **147** can help stabilize the glass ribbon **103** during the cutting procedure. Such stabilization can help prevent buckling or disturbing the glass ribbon profile during the procedure of severing at least one of the opposed edge portions **201**, **203**. Moreover, the bent orientation of the bent target segment **151** can increase the rigidity of the target segment to allow optional fine tune adjustment of the lateral orientation of the bent target segment **151**. As such, relatively thin glass ribbons **103** can be effectively stabilized and properly laterally oriented without contacting the pristine opposed first and second sides **141**, **139** of the central portion **205** of the glass ribbon **103** during the procedure of severing at least one of the opposed edge portions **201**, **203** from the central portion **205** of the glass ribbon **103**.

[0065] Increased stabilization and rigidity of the bent target segment **151** of the glass ribbon **103** can be achieved by bending the target segment to include an upwardly convex surface and/or an upwardly concave surface along a direction of the axis **217** transverse to the travel direction **112**. For example, as shown in **FIG. 1**, the bent target segment **151** includes a bent orientation with an upwardly facing convex surface **152** configured to bend the glass ribbon **103** in the cutting zone **147** to achieve the illustrated bent orientation. Although not shown, further examples may include supporting the target segment **151** with an upwardly facing concave surface configured to allow the bent target segment to achieve an upwardly facing concave surface.

[0066] The edge separation apparatus **101a** can further include a wide range of cutting devices configured to sever the edge portions **201**, **203** from the central portion **205** of the glass ribbon **103**. In one example, as shown in **FIG. 1**, one example glass cutting device **153** can include an optical delivery apparatus **155** for irradiating and therefore heating a portion of the upwardly facing surface of the bent target segment **151**. In one example, optical delivery apparatus **155** can comprise a radiation source such as the illustrated laser **161** although other radiation sources may be provided in further examples. The optical delivery apparatus **155** can further include a circular polarizer **163**, a beam expander **165**, and a beam shaping apparatus **167**.

[0067] The optical delivery apparatus **155** may further comprise optical elements for redirecting a beam of radiation (e.g., laser beam **169**) from the radiation source (e.g., laser **161**), such as mirrors **171**, **173** and **175**. The radiation source can comprise the illustrated laser **161** configured to emit a laser beam having a wavelength and a power suitable for heating the glass ribbon **103** at a location where the beam is incident on the glass ribbon **103**. In one embodiment, laser **161** can comprise a CO<sub>2</sub> laser although other laser types may be used in further examples.

[0068] The laser **161** may be configured to initially emit the laser beam **169** with a substantially circular cross section (i.e. the cross section of the laser beam at right angles to the longitudinal axis of the laser beam). The optical delivery apparatus **155** is operable to transform laser beam **169** such that the beam has a significantly elongated shape when incident on glass ribbon **103**. As shown in **FIG. 3**, the elongated shape can produce an elongated radiation zone **227** that may include the illustrated elliptical footprint although other configurations may be provided in further examples. The elliptical footprint can be positioned on the upwardly facing convex or concave surface of the bent target segment **151**. Heat from the elongated radiation zone **227** can transmit through the entire thickness of the glass ribbon **103**.

[0069] The boundary of the elliptical footprint can be determined as the point at which the beam intensity has been reduced to  $1/e^2$  of its peak value, wherein “e” is the base of the natural logarithm. The laser beam **169** passes through circular polarizer **163** and is then expanded by passing through beam expander **165**. The expanded laser beam then passes through beam shaping apparatus **167** to form a beam producing the elliptical footprint on a surface of the bent target segment **151**. The beam shaping apparatus **167** may, for example, comprise one or more cylindrical lenses. However, it should be understood that any optical elements capable of shaping the beam emitted by laser **161** to produce an elliptical footprint on the bent target segment **151** may be used.

[0070] The elliptical footprint can include a major axis that is substantially longer than a minor axis. In some embodiments, for example, the major axis is at least about ten times longer than the minor axis. However, the length and width of the elongated radiation zone are dependent upon the desired severing speed, desired initial defect size, thickness of the glass ribbon, laser power, material properties of the glass ribbon, etc., and the length and width of the radiation zone may be varied as needed.

[0071] As further shown in **FIG. 1**, the example glass cutting device **153** can also include a coolant fluid delivery apparatus **159** configured to cool the heated portion of the upwardly facing surface of the bent target segment **151**. The coolant fluid delivery apparatus **159** can comprise a coolant nozzle **177**, a coolant source **179** and an associated conduit **181** that may convey coolant to the coolant nozzle **177**. As shown in **FIG. 1**, the forced fluid cooling can occur on the same side of the glass as the incident heating source. As shown, the forced fluid cooling and incident heating sources can be applied to the upper surface of the glass although they can both be applied to the lower surface in further examples. Still further, the heat source and cooling source can be incident on opposite surfaces of the glass ribbon. For example, one of the forced fluid cooling source and the heating source can be positioned to act on an upper surface of the ribbon while the other of the forced fluid cooling source and the heating source acts on the lower surface of the ribbon. In such a configuration, the oppositely located cooling and heating sources can be counter-propagating.

[0072] With reference to **FIG. 1**, the coolant nozzle **177** can be configured to deliver a coolant jet **180** of coolant fluid to the upwardly facing surface of the bent target segment **151**. The coolant nozzle **177** can have various internal diameters to form a cooling zone **229** (see **FIG. 3**) of a desired size. As with elongated radiation zone **227**, the diameter of coolant nozzle **177**, and the subsequent diameter of coolant jet **180**, may be varied as needed for the particular process conditions. In some embodiments, the area of the glass ribbon immediately impinged upon by the coolant (cooling zone) can have a diameter shorter than the minor axis of the radiation zone **227**. However, in certain other embodiments, the diameter of the cooling zone **229** may be larger than the minor axis of elongated radiation zone **227** based on process conditions such as speed, glass thickness, material properties of the glass ribbon, laser power, etc. Indeed, the (cross sectional) shape of the coolant jet may be other than circular, and may, for example, have a fan shape such that the cooling zone forms a line rather than a circular spot on the surface of the glass ribbon. A line-shaped cooling zone may be oriented, for example, perpendicular to the major axis of elongated radiation zone **227**. Other shapes may be beneficial.

[0073] In one example, the coolant jet **180** comprises water, but may be any suitable cooling fluid (e.g., liquid jet, gas jet or a combination thereof) that does not permanently stain or damage the upwardly facing surface of the bent target segment **151** of the glass ribbon **103**. The coolant jet **180** can be delivered to a surface of the glass

ribbon **103** to form the cooling zone **229**. As shown, the cooling zone **229** can trail behind the elongated radiation zone **227** to propagate an initial defect formed by aspects of the disclosure described more fully below.

[0074] Although not shown, in some configurations coolant fluid delivery apparatus **159** may not be required to perform the cutting operation. For example, heat transfer to the environment (e.g., air flowing through the support member **149** and natural convection of the moving web) may provide all the cooling that is required to sustain the cutting process without the presence or operation of the coolant fluid delivery apparatus **159**.

[0075] The combination of heating and cooling with the optical delivery apparatus **155** and the coolant fluid delivery apparatus **159** can effectively sever the edge portions **201**, **203** from the central portion **205** while minimizing or eliminating undesired residual stress, microcracks or other irregularities in the opposed edges **223**, **225** of the central portion **205** that may be formed by other severing techniques. Moreover, due to the bent orientation of the bent target segment **151** within the cutting zone **147**, the glass ribbon **103** can be properly positioned and stabilized to facilitate precise severing of the opposed edges **223**, **225** during the severing process. Still further, due to the convex surface topography of the upwardly facing convex support surface, the edge portions **201**, **203** can immediately travel away from the central portion **205**, thereby reducing the probability that the edge portions will subsequently engage (and therefore damage) the pristine first and second sides **141**, **139** and/or the high quality opposed edges **223**, **225** of the central portion **205**. As shown in **FIG. 1**, two curved support members **135**, **149** may be provided. In further examples, a single curved support member may be provided, thereby eliminating the need for a second curved support member.

[0076] Turning back to **FIG. 1**, the edge separation apparatus **101a** may include structures configured to further process the severed edge portions **201**, **203** and/or the central portion **205** of the glass ribbon **103** downstream from the cutting zone **147**. For example, one or more glass ribbon choppers **183** may be provided to chop, shred, break or otherwise compact the trim segments for disposal or recycling.

[0077] The central portion **205** of the glass ribbon **103** can be further processed by cutting into glass sheets for incorporation into optical components. For example, the apparatus **101** may include the apparatus **101b** for severing a glass ribbon described more fully below to sever the central portion **205** of the glass ribbon **103** along the axis **217**



transverse to the travel direction **112** of the glass ribbon **103**. In addition, or alternative to the apparatus **101b** for severing a glass ribbon, the central portion **205** of the glass ribbon **103** can be coiled into a storage roll **185** for later processing. As shown, removing the edge portions **201**, **203** consequently removes the corresponding beads **207**, **209**. Removing the beads reduces the minimum bend radius to allow the central portion **205** of the glass ribbon **103** to be more efficiently wound into a storage roll **185**. As represented in **FIG. 2**, the central core **187** of the storage roll **185** is significantly reduced when compared to the central core **189** of the coiled spool **124**. As such, the diameter “**D<sub>2</sub>**” of the storage roll **185** of the central portion **205** is significantly smaller than the diameter “**D<sub>1</sub>**” that would store the same length of pre-processed glass ribbon in the coiled spool **124**.

[0078] Still further shown in **FIG. 1**, the edge separation apparatus **101a** may also include further noncontact support members to guide at least the central portion **205** of the glass ribbon **103** downstream from the cutting zone **147**. For example, as shown, the apparatus can include a first air bar **188** and a second air bar **190** to guide the central portion **205** of the glass ribbon for final processing without contacting the surfaces. Two support members are illustrated although a single support member or more than two support members may be provided in further examples. As further shown, an optional support member **191** can also be provided to allow the edge portion to be guided to the glass ribbon chopper **183**. The optional support member **191** can optionally comprise an air bar or low friction surface to reduce binding and/or restricted movement as the edge portion proceeds to the glass ribbon choppers **183**.

[0079] In some examples, the glass ribbon **103** may also travel directly from the source **105** of glass ribbon to an apparatus **101b** for severing the glass ribbon **103**. Alternatively, as shown, the edge separation apparatus **101a** may optionally remove edge portions of the glass ribbon **103** at a location upstream. Subsequently, the central portion **205** of the glass ribbon **103** can travel with respect to the apparatus **101b** for eventual final processing of the glass ribbon. In some examples, the glass ribbon can be severed into appropriate severed lengths. In further examples, an undesired segment (e.g., segment of low quality) can be removed from the otherwise continuous length of high quality glass ribbon. In still further examples, the glass ribbon can be stored on the illustrated storage roll **185**. In one example, the apparatus **101b** for severing the glass

ribbon **103** can be used to switch between a full storage roll and a new storage roll without interrupting movement of the glass ribbon along travel direction **112**.

[0080] **FIG. 2** illustrates just one example of an apparatus **101b** that may be used to selectively sever the glass ribbon **103** although other apparatus may be used in further examples. As shown in **FIG. 2**, the apparatus **101b** may include a monitoring device **193** that may sense a characteristic of the glass ribbon **103** and send back a corresponding signal to a controller **195**. Characteristics can include, but are not limited to, optical quality, inclusions, cracks, inhomogeneous features, thickness, color, surface flatness or imperfections, and/or other features. In one example, the monitoring device **193** may comprise a quality control device configured to screen the glass ribbon, either continuously or periodically, in an effort to ensure a high quality glass ribbon passing to be stored or further processed.

[0081] As further illustrated, the apparatus **101b** may further include a device **197** configured to generate a predetermined flaw in the first side **141** of the glass ribbon **103**. In one example, the device **197** can include the illustrated mechanical scoring device wherein a relatively sharp tip **301** may be used to score the first side **141** of the glass ribbon **103**. In further examples, the device **197** can comprise a laser or other device configured to introduce the predetermined flaw at the edge, side surface, or within a portion along the width of the glass ribbon **103**.

[0082] As further illustrated in **FIG. 6**, the apparatus **101b** may optionally include a support member **130** configured to emit fluid **132** to impact the first side **141** of the glass ribbon **103** to at least partially support a weight of a portion **103a** of the glass ribbon **103** within a severing zone **134** while maintaining the portion **103a** of the glass ribbon **103** in a first orientation. As shown, the first orientation can comprise a substantially flat orientation that runs along the travel direction **112** although the first orientation may be curved or form other travel paths in further examples.

[0083] Examples of the apparatus **101b** for severing the glass ribbon **103** can further include a device **140** configured to temporarily bend the portion **103a** of the glass ribbon **103** in a direction **146** toward the support member from the first orientation (e.g., shown in **FIG. 6**) to a severing orientation (e.g., shown in **FIGS. 7 and 8**) by applying a force to the second side **139** of the glass ribbon **103**. The device **140** for temporarily bending the portion **103a** of the glass ribbon **103** can comprise a wide range of structures with various configurations.

[0084] FIG. 6 illustrates just one device 140 that may be used to temporarily bend the portion 103a of the glass ribbon 103. The example device 140 may include a fluid nozzle 142. As schematically shown in FIG. 5, the fluid nozzle 142 may extend along substantially the entire width of the glass ribbon 103. Furthermore, as shown, the nozzle 142 may have a width that is substantially greater than the width of the glass ribbon 103. The nozzle 142, if provided, can be a continuous nozzle and/or a plurality of nozzles spaced apart from one another in a row across the width of the glass ribbon.

[0085] The nozzle 142 can include an orifice 144 designed to emit fluid, such as gas, to impact the second side 139 of the glass ribbon 103 within the severing zone 134. As shown in FIG. 2, the nozzle 142 can receive pressurized fluid, such as gas, from a fluid source 136 by way of a fluid manifold 138 configured to be controlled by the controller 195.

[0086] FIG. 12 illustrates yet another example of an apparatus 601 for severing the glass ribbon 103. The apparatus 601 can include at least a first roller 603 configured to apply a force to the second side 139 of the glass ribbon 103. The apparatus 601 can further include a second roller 605 and a third roller 607 spaced from the second roller along a support width “S.” The first roller 603 applies the force to the second side 139 of the glass ribbon 103 along the support width “S” defined between the second roller 605 and the third roller 607. Optionally, an endless belt 609 can be configured to rotate with the second roller 605 and the third roller 607. For example, the endless belt 609 can be mounted with the second roller 605 acting as one end roller and the third roller 607 acting as the second end roller, wherein the rollers can be biased away from each other to help maintain the endless belt 609 in tension.

[0087] As further shown in FIG. 12, the apparatus 601 can include a support member 611 that may support the portion 103a of the glass ribbon in the first orientation shown in FIG. 12. In one example, the support member can include passages to transfer fluid, such as gas, through the passages to support the portion 103a of the glass ribbon with a liquid (e.g., gas) cushion generated between the first side 141 and the support member 611.

[0088] In one example, there may be a plurality of support members 611 offset relative to one another along the width “W” of the support member extending transverse to the travel direction 112. For example, as shown in FIG. 13, the support member 611 comprises three spaced support members 611a, 611b, 611c spaced from one another.

Likewise, in such examples, a plurality of endless belts may be provided between each of the spaced support members. For example, as shown in **FIG. 13**, the endless belt **609** includes a first endless belt **609a** positioned between adjacent support members **611a**, **611b** and a second endless belt **609b** positioned between adjacent support members **611b**, **611c**. As such, the portion **103a** of the glass ribbon **103** may be adequately supported in the first orientation shown in **FIGS. 12 and 14** (i.e., by the fluid cushion) and the bent orientation shown in **FIGS. 15 and 16**.

[0089] In yet another example, the apparatus for severing the glass ribbon may include an apparatus similar to **FIGS. 6-10** but include at least one roller, rather than the fluid nozzle **142**, configured to apply the force to the second side of the glass ribbon. In such an example, the roller (e.g., similar to the first roller **603** discussed above) can rotate while temporarily bending the portion of the glass ribbon in the direction toward the support member. As such, rather than the non-contact fluid nozzle **142**, a contact roller may be provided that temporarily bends the portion of the glass ribbon in the direction toward the support member similar to that shown in **FIGS. 7-9**. At the same time, as shown in **FIGS. 7-9** upstream and downstream support members can provide a contact-free support of the first side of the glass ribbon with corresponding fluid cushions provided by the support members.

[0090] As described above, the glass ribbon **103** can be severed by any number of means. After the glass ribbon **103** is severed as shown in **FIG. 11**, the glass ribbon is separated into an upstream web **631** and a downstream web **633**. The upstream web **631** comprises an upstream edge portion **635** including an upstream severed edge **637**. The downstream web **633** comprises a downstream edge portion **639** including a downstream severed edge **641**. It can be advantageous to create a gap **683** between the upstream web **631** and the downstream web **633**. The gap **683** can help facilitate storage roll **501**, **503** change without changing the process speed of the apparatus **101**. Additionally, the gap **683** can also help reduce or eliminate damage to the glass ribbon **103** created by glass-to-glass contact between the downstream severed edge **637** and the upstream severed edge **641**.

[0091] Processing glass substrates in sheet or roll form can include the use of a handling tabs **651**, **653** (e.g., see **FIG. 3**) located on the glass ribbon **103** to aid in various processing steps. The handling tabs **651**, **653** may be provided on the edge portions **201**, **203**. For instance, the handling tabs **651**, **653** may have been previously applied and

rolled into the spool **124**. Such handling tabs **651**, **653** may be provided, for example to help align the glass ribbon in the spool **124** and help space the pristine surfaces of the glass ribbon wound in the spool **124**. **FIG. 3** schematically illustrates the handling tabs **651**, **653** adjacent the beads **207**, **209** for illustration purposes. While the handling tabs **651**, **653** may be provided on the beads, in addition or alternatively, the handling tabs may also be provided on the edges **223**, **225** of the central section **205** of the glass ribbon **103** after the edge portions **201**, **203** have been removed.

[0092] If provided, handling tabs **651**, **653** can be placed on the glass ribbon to help reduce physical damage to the glass ribbon during handling. In another example, the handling tabs **651**, **653** can help align layers of glass ribbon **103** within storage rolls **501**, **503** (e.g., see **FIG. 11**) so that the edges of the roll remain aligned with respect to one another while spacing the pristine surfaces of the glass ribbon from one another as the glass ribbon **103** is rolled. In yet another example, the handling tabs **651**, **653** can be configured to permit glass ribbon **103** location and manipulation without physical contact of one layer of the glass ribbon **103** with an adjacent layer of the glass ribbon within the storage roll **501**, **503**. Furthermore, the handling tabs **651**, **653** can be removable.

[0093] As shown in **FIG. 3** and mentioned previously, the handling tabs **651**, **653** can be applied to the glass ribbon **103** prior to the optional step of edge separation. In addition or alternatively, the handling tabs **651**, **653** can be applied to the glass ribbon **103** after the optional edge separation. In another example, the handling tabs **651**, **653** can be applied to the glass ribbon **103** prior to being wound about glass ribbon source **105** (e.g., **FIG. 1**), remain applied to the glass ribbon through the glass ribbon severing process, and then be wound with the glass ribbon onto a storage roll **501**, **503**. In another example, the handling tabs **651**, **653** can be applied to the upstream web **631** and the downstream web **633** after the glass ribbon has been severed. **FIG. 25** illustrates a handling tab **651** attached to a first side edge **657** and a handling tab **653** attached to a second side edge **659**. Further examples can include only one of the handling tabs **651**, **653** attached to one of the first side edge **657** or the second side edge **659**.

[0094] **FIG. 25** shows one example of handling tabs **651**, **653** located on the glass ribbon **103**. Handling tab **651** is shown attached to the first side edge **657** and handling tab **653** is shown attached to the second side edge **659**. Each of the handling tabs **651**, **653** can include apertures **661** open at an interior edge of the handling tab to expose the entire width of the glass ribbon **103** across its width, i.e., parallel to the direction of axis

217, which can be substantially perpendicular to the travel direction 112 of the glass ribbon 103. Each of the apertures 661 can extend only partially across the handling tabs 651, 653, so that at least a portion of the handling tabs 651, 653 is continuous along the glass ribbon 103. The apertures 661 can be said to resemble “mouse holes” in their appearance with an opening at an interior edge of the handling tab to effectively reduce the transverse width of the tab across the apertures 661 to expose a target area 663. As previously described, the handling tabs 651, 653 can be applied to the upstream web 631 and the downstream web 633 after the glass ribbon has been severed. In this case, the apertures 661 are aligned with the sever line or resulting gap between the upstream web 631 and the downstream web 633. In another example, the handling tabs 651, 653 can be applied to the glass ribbon 103 prior to the severing operation. In this case, the apertures 661 allow the glass ribbon 103 to be severed across its entire width (e.g. in the target area 663) while maintaining a physical connection between the individual severed pieces of the glass ribbon 103. The handling tabs 651, 653 can be removed entirely or can be cut at the apertures 661 at a later time to enable separate processing of the upstream web 631 and the downstream web 633.

[0095] As shown in FIG. 17, the velocity of the glass ribbon 103 can be controlled by sets of powered pinch rolls 665, 667. It is to be appreciated that pinch rolls are but one example of mechanisms configured to control the velocity of the glass ribbon 103, and any mechanism as is known in the art can be used. In one example, a set of pinch rolls 665 can control the velocity of the upstream web 631, while another set of pinch rolls 667 can control the velocity of the downstream web 633. Of course, any number of sets of pinch rolls 665, 667 may be employed to control the velocity of the glass ribbon 103, and a controls system (not shown) can track which sets of pinch rolls 665, 667 are in contact with the upstream web 631 and the downstream web 633 in order to better control the glass ribbon 103 manufacturing process.

[0096] FIG. 20 illustrates an additional device that can be used to control the velocity of at least a portion of the glass ribbon 103. For instance, the apparatus may include at least one accumulator such as an upstream accumulator and/or a downstream accumulator. For illustration purposes, FIG. 20 is a schematic representation of an upstream accumulator 673 and a downstream accumulator 675 although only one of the accumulators may be provided in further examples. The upstream accumulator 673 can be located on the upstream side of a severing zone 134, and the downstream accumulator

**675** can be located on the downstream side of the severing zone **134**. As a result, the upstream accumulator **673** and the downstream accumulator **675** can provide some control of the velocity of the upstream web **631** and the downstream web **633**, respectively, by varying the path length of the upstream web **631** and the downstream web **633** as will be described below. As shown, the accumulators **673**, **675** may comprise rollers that can selectively increase the travel path of portions of the glass ribbon to selectively create a gap as described below. In the illustrated example, each accumulator **673**, **675** includes six rollers although more or less rollers may be used in further examples. For instance, in one example, three rollers may be provided with two rollers located above the glass ribbon **103** (e.g., the outer two rollers of the three illustrated upper rollers) and a single roller located below the glass ribbon **103** (e.g., the center roller of the three illustrated lower rollers). While rollers are shown, further examples can include expanding air bars or other structures configured to selectively increase the travel path of portions of the glass ribbon to likewise create a gap during processing.

[0097] Methods of fabricating the glass ribbon **103** with the apparatus **101** that creates a gap between an upstream severed edge and a downstream severed edge will now be described. As shown, in one example, the method can include use of the edge separation apparatus **101a** shown in **FIG. 1**. In addition or alternatively, the method can use an apparatus for severing the glass ribbon (e.g., see apparatus **101b** in **FIG. 2** or apparatus **601** in **FIG. 12**, for example).

[0098] Turning to the example edge separation apparatus **101a** of **FIG. 1**, one example method can include the step of traversing the glass ribbon **103** in a downward direction **121** relative to the source **105** through the downward zone **123**. As shown, the glass ribbon **103** can travel substantially vertically in the downward direction **121** although the downward direction may be angled in further examples wherein the glass ribbon **103** can travel at an inclined orientation in the downward direction. Also, if the glass ribbon **103** is supplied on a spool such as **124**, it may also traverse from the spool to the cutting unit in a substantially horizontal direction. For example, the coiled spool **124** and cutting zone may exist in nearly the same horizontal plane. In further examples, the spool may be positioned below the horizontal travel plane and unwound horizontally or upwardly to traverse along travel direction **112**. Similarly, if other methods of making the ribbon are used, for example a float process or an up-draw process, the ribbon may travel

in a horizontal, or upward direction as it travels from the forming source to the cutting unit and/or cutting zone.

[0099] The method can further include the step of bending the glass ribbon **103** in the bending zone **125** downstream from the downward zone **123**, wherein the glass ribbon **103** includes the upwardly concave surface **127** through the bending zone **125**. As shown, the lower portion **137** can be significantly lower than the bent target segment **151** in the cutting zone **147** although the lower portion **137** may be at substantially the same elevation or even higher than the bent target segment in further examples. Providing the lower portion **137** at a significantly lower position, as shown, can develop a predetermined amount of accumulated glass ribbon prior to engaging the support members (e.g., support member **135**) of the edge separation apparatus **101a**. As such, vibrations or other disturbances upstream from the lower portion **137** may be absorbed by the accumulated glass ribbon within the bending zone. Moreover, the glass ribbon **103** may be drawn at a substantially constant or desired predetermined rate as it passes through the cutting zone **147** independent of how fast the glass ribbon **103** is being fed into the downward zone **123** by the source **105**. As such, providing an accumulation within the bending zone **125** can allow for further stabilization of the glass ribbon **103** within the cutting zone **147** while also allowing the glass ribbon **103** to be passed through the cutting zone **147** at a substantially constant or predetermined rate.

[00100] If provided, various techniques may be used to help maintain a desired accumulation of glass ribbon **103** within the bending zone **125**. For example, a proximity sensor **129** or other device may be able to sense a position of the accumulated ribbon to adjust the rate at which glass ribbon is fed into the downward zone **123** by the source **105** to provide the appropriate accumulation of glass ribbon **103**.

[00101] In further examples, the method can further include the step of bending the glass ribbon **103** downstream from the bending zone **125** to redirect the glass ribbon to travel in the travel direction **112**. As shown, the bending support member **135** may comprise a bent air bar designed to effect the desired change of direction without contacting the central portion **205** of the glass ribbon **103**. Furthermore, the method can also include the optional step of orienting the glass ribbon **103** being bent with the bending support member with the lateral guides **143**, **145** to help orient the glass ribbon **103** in the correct lateral position relative to the travel direction **112** of the glass ribbon **103**.



**[00102]** The method can also include the step of traversing the glass ribbon **103** into the cutting zone **147** downstream from the bending zone **125** and then bending the glass ribbon **103** in the cutting zone **147** to provide the bent target segment **151** with a bent orientation in the cutting zone **147**.

**[00103]** As shown in **FIG. 1**, the glass ribbon **103** can be bent such that the bent orientation of the target segment **151** includes the upwardly facing convex surface. In one example, the method can include the step of supporting the bent target segment **151** with the cutting support member **149** comprising the illustrated curved air bar. As shown, the cutting support member **149** can include an upwardly facing convex support surface **152** configured to bend the target segment **151** to establish the upwardly facing convex surface.

**[00104]** As shown in **FIG. 1**, the method can further include the step of severing at least one of the edge portions **201**, **203** from the central portion **205** of the bent target segment **151** within the cutting zone **147**. As shown in **FIG. 3**, the examples of the disclosure can include severing both of the edge portions **201**, **203** from the central portion **205** although a single edge portion may be severed from the central portion in further examples. Moreover, as shown in **FIG. 3**, both of the edge portions **201**, **203** are severed simultaneously from the central portion **205** although one of the edge portions may be severed before the other edge portion in further examples.

**[00105]** The glass ribbon **103** may include edge beads **207**, **209**. Alternatively, the glass ribbon **103** may have edge portions **201**, **203** that are free from substantial edge beads or features. For example, the edge beads **207**, **209** may have been already removed in a previous cutting process or the glass ribbon **103** may have been formed without significant edge bead features. Also, the included figures indicate that the separated edge portions **201**, **203** are disposed of or recycled. In another example, the separated edge portions form useable glass ribbon in addition to the central portion **205** and can likewise be either cut into sheets or spooled as product. In this case, multiple cutting operations can exist across the glass ribbon width as it traverses through the cutting unit.

**[00106]** The step of severing can incorporate a wide range of techniques. For example, the edge portions **201**, **203** can be severed from the central portion **205** by way of the glass cutting device **153** that can include the illustrated optical delivery apparatus **155** and the coolant fluid delivery apparatus **159**.

[00107] One example of initiating the severing process can use a scribe or other mechanical device to create an initial defect (e.g., crack, scratch, chip, or other defect) or other surface defect at the site where the glass ribbon is to be severed. The scribe can include a tip although an edge blade or other scribe technique may be used in further examples. Still further, the initial defect or other surface imperfection may be formed by etching, laser impact, or other techniques. The initial defect may be created at the edge of the ribbon or at an inboard location on the ribbon surface.

[00108] The initial defect or surface imperfection can be initially formed adjacent a leading edge of the glass ribbon **103** traversing in the travel direction **112**. As shown in **FIG. 3**, the elongated radiation zone **227** may be formed on the upwardly facing convex surface. As the elongated radiation zone **227** is elongated in the travel direction **112**, the radiation heats the region in proximity to the initial defect. The coolant jet **180** then contacts the cooling zone **229** to generate a crack at the initial defect that completely travels through the thickness “ $T_2$ ” of the glass ribbon **103** due to the created tensile stress to sever the corresponding edge portions **201**, **203** from the central portion **205**.

[00109] The severed opposed edge portions **201**, **203** can be effectively removed while leaving the central portion **205** with high quality opposed edges **223**, **225** with reduced internal stress profiles, reduced cracks, or other imperfections in the opposed edges **223**, **225**. As such, the central portion **205** can be bent, such as wound in the storage roll **185** without cracking that may otherwise occur with reduced quality edges. Moreover, the higher quality edges can avoid scratching the central portion **205** during coiling that might otherwise occur with edge portions including glass shards or other imperfections. In addition, the edge portions **201**, **203** can likewise be optionally wound on a spool for use in different applications.

[00110] The method can further include the step of supporting the bent target segment **151** with the upwardly facing convex surface **152** of the cutting support member **149**. For instance, the bent target segment **151** can be supported by the convex surface **152** of the illustrated air bar while severing the edge portions **201**, **203** from the central portion **205** of the bent target segment **151** within the cutting zone **147**.

[00111] The method can still further include the step of coiling the central portion **205** of the glass ribbon **103** into the storage roll **185** after the step of severing. As such, the high quality central portion **205** of the glass ribbon may be efficiently coiled into a storage roll **185** for subsequent shipping or processing into glass sheets. As shown

in **FIGS. 1 and 3**, the severed edge portion **201, 203** can be disposed of in a glass ribbon chopper **183** although alternative methodologies may be employed to use the edge portions for other applications. In such examples, one or both of the severed edge portions **201, 203** may be stored on corresponding storage rolls for subsequent processing.

**[00112]** Example methods of severing a glass ribbon **103** across its width, i.e., parallel to the direction of axis **217** will now be described. As shown, the method can begin with providing the source **105** of the glass ribbon **103** with a pair of edge portions **201, 203** that may or may not include the beads **207, 209**. Optionally, the edge portions **201, 203** may be severed by way of the procedure discussed above although the edge portions may not be removed in further examples.

**[00113]** As shown, the central portion **205** of the glass ribbon **103** includes a first side **141** facing a first direction and a second side **139** facing a second direction opposite the first direction. In one example, the apparatus **101** can sense the amount of glass ribbon that has been coiled on the storage roll **185** and/or sense a characteristic of the glass ribbon **103** with the monitoring device **193**.

**[00114]** If it is determined the glass ribbon should be severed across its width, the controller **195** can activate the device **197**, such as the illustrated scribe or other mechanical device, to create an initial defect (e.g., crack, scratch, chip, or other defect) with the point of the scribe to create a controlled and predetermined surface defect at the site where the glass ribbon is to be severed. The scribe can include a tip although an edge blade or other scribe technique may be used in further examples. Still further, the initial defect or other surface imperfection may be formed by etching, laser impact, or other techniques. The initial defect may be created at the edge of the ribbon or at an inboard location on the ribbon surface at a point along the width of the ribbon. In one example, the predetermined surface defect comprises a predetermined flaw that is generated by the device **197**.

**[00115]** **FIG. 4** illustrates the tip **301** engaging the first side **141** and moving in direction **303** to create the predetermined flaw **305** shown in **FIG. 5**. As shown, in one example, the predetermined flaw **305** can be generated as a linear segment having a length substantially less than a width of the central portion of the glass ribbon defined between the pair of opposed edge portions. In addition or alternatively, the predetermined flaw **305** can be generated as a linear segment extending in a direction of a

width of the central portion **205** of the glass ribbon **103** defined between the pair of opposed edge portions. Although not shown, the predetermined flaw **305** can extend across a substantial portion, such as the entire width of the central portion **205**. However, as the glass ribbon **103** continues to move in travel direction **112**, a relatively small segment may be desired to provide a linear segment to control proper severing of the glass ribbon along the width.

[00116] **FIG. 6** illustrates the portion **103a** of the glass ribbon **103** including the predetermined flaw **305** traversing to the severing zone **134** downstream from the source **105** of the glass ribbon **103**. As further shown, fluid **132** being emitted from the support member **130** impacts the first side **141** of the glass ribbon **103** to at least partially support a weight of the portion of glass ribbon within the severing zone **134** while maintaining the portion of the glass ribbon in the first orientation. As shown in **FIG. 6**, the first orientation can substantially provide the glass ribbon along a planar orientation that may be substantially parallel to the travel direction **112**.

[00117] **FIG. 7** illustrates the predetermined flaw **305** being traversed farther downstream along travel direction **112** wherein the portion **103a** of the glass ribbon **103** is temporarily bent in the direction **146** toward the support member **130**. The portion **103a** can be temporarily bent, for example, by applying a force to the second side **139** of the glass ribbon **103**. In one example, a roller may be used to apply a force to the second side **139** of the glass ribbon. Alternatively, as shown, applying the force can be achieved by impacting the second side **139** of the glass ribbon **103** with fluid **401** emitting from the orifice **144** of the nozzle **142**. Using a fluid to bend the glass ribbon can be desirable to prevent scratching or otherwise damaging the glass ribbon that may otherwise occur with mechanical contact configurations.

[00118] As shown, the portion **103a** includes two parallel parts **402a**, **402b** that extend along the same plane although the two parts **402a**, **402b** may not be parallel in further examples and/or may extend along different planes. As shown, the orientation of the parts **402a**, **402b** can be oriented by supporting them with a support member **130**. More particularly, the first part **402a** can be supported by an upstream support member **404a**, and the second part **402b** can be supported by a downstream support member **404b**. For instance, as shown the support members **404a**, **404b** can comprise air bars configured to emit fluid **132**, such as gas, to provide respective air cushions. Indeed, the upstream support member **404a** can place a first support air cushion between the upstream support

member **404a** and the first part **402a** of the portion **103a** of glass ribbon **103**. Likewise, the downstream support member **404b** can place a second support air cushion between the downstream support member **404b** and the second part **402b** of the portion **103a** of glass ribbon **103**. As such, impacting the first side **141** of the glass ribbon **103** with fluid emitting from each of the upstream support member **404a** and the downstream support member **404b** can provide respective gas cushions that at least partially support a weight of the portion **103a** of glass ribbon **103** at respective upstream and downstream positions. Providing support with corresponding air cushions can help position the glass ribbon **103** for severing without touching the pristine surfaces of the glass ribbon. As such, scratching or other damage to the pristine surfaces can be avoided.

[00119] As further illustrated in **FIG. 7**, the portion **103a** of the glass ribbon **103** includes a target segment **402c** that can be defined between the upstream support member **404a** and the downstream support member **404b**. As shown in **FIG. 6**, the upstream support member **404a** and the downstream support member **404b** can maintain the target segment **402c** of the glass ribbon **103** in the first orientation within the severing zone **134**. Moreover, as shown, at least a portion of the target segment **402c** can be substantially free from support by the gas cushions of the support members **404a**, **404b**.

[00120] As shown in **FIG. 7**, the method can further include the step of temporarily bending the target segment **402c** of the glass ribbon **103** in the direction **146** toward the support member **130** from the first orientation to a severing orientation with a force generated by impacting the second side **139** of the glass ribbon **103** with fluid **401** emitting from the fluid nozzle **142**. Optionally, the method can include the step of increasing the rate that fluid is being emitted from at least one of the support members **404a**, **404b**, such as both support members, to at least partially counteract the force generated by impacting the second side of the glass ribbon with fluid emitting from the fluid nozzle.

[00121] Once bent, the second side **139** has an upwardly concave portion provided between the two parts **402a**, **402b** of the portion **103a** of glass ribbon **103**. As such, the lower side of the target segment **402c** is placed in tension. **FIG. 8** shows the portion **103a** further traversing in travel direction **112** such that the predetermined flaw **305** enters in the target segment **402c** and is placed in tension. **FIG. 9** demonstrates the step of severing the central portion **205** of the glass ribbon **103** between the opposed edge

portions at the predetermined flaw **305** located within the severing zone **134**. As can be seen from **FIGS. 7 and 8**, the upwardly concave portion is provided downstream of the predetermined flaw **305**. Then, as the glass ribbon **103** travels in the travel direction **112**, the predetermined flaw **305** travels to the upwardly concave portion, and as it travels through that upwardly concave portion, the ribbon **103** is severed across its width at the point of the predetermined flaw **305**. It would be difficult, on a traveling ribbon, to form an upwardly concave portion exactly at the predetermined flaw. Accordingly, forming the upwardly concave portion first, and allowing the flaw to travel to that portion facilitates severing the ribbon across its width. Additionally, or alternatively, forming the upwardly concave portion in the severing zone **134** and allowing the flaw to travel to the upwardly concave portion eliminates the need for a separate accumulator or stoppage of the ribbon **103** in order to sever the ribbon **103** across its width.

**[00122]** If there are any constraints in the travel direction **112** upon the motion of the glass ribbon **103**, they can be controlled during the severing process to allow formation of the curvature that places the lower side of the target segment **402c** in tension. If, for example, a set of driven pinch rolls were located near the lateral guides **143, 145**, in **FIG. 3**, the length of the center section **205** may be influenced. In order to assist bending the glass ribbon **103**, relative speed in the travel direction **112** between the driven pinch rolls and the downstream takeup device (ex. central core **187** in **FIG. 2**) can allow for a slight accumulation of length within the severing zone **134**.

**[00123]** In addition, the apparatus may include a mechanism to facilitate movement of the glass ribbon along the travel direction **112**. For example, in some embodiments, the central core **187** may be driven to rotate to help facilitate movement of the glass ribbon **103** along the travel direction **112**. In addition, or alternatively, a set of drive rollers may facilitate movement of the glass ribbon. Providing a set of drive rollers, for example, can help facilitate movement of the glass ribbon together with the severed end **409** that is no longer connected to the central core **187** after severing. As such, the drive rollers can continue to move the severed end **409** along to be wound on to another central core **187** after switching the storage rolls. The drive rollers can be provided at various locations. For instance, the lateral guides **143, 145** may be provided as driven rollers to help drive the glass ribbon along the travel direction **112** although the driven rollers may be provided at alternative locations in further examples.

**[00124]** **FIGS. 9 and 10** demonstrate the step of returning the target segment **402c** of the glass ribbon **103** to the first orientation by removing the force being applied by the fluid nozzle **142**. For example, once the flow of fluid from the nozzle is stopped, the flow of fluid from the support member **130** can act against the glass ribbon to restore the glass ribbon to the first orientation, particularly as the severed area **406** travels up into a linear support region of the second support member **404b**. As shown, the downstream support member **404b** can include a leading end with a convex support surface **407**. The convex support surface **407**, if provided, can inhibit obstruction of the severed end **409** of the glass ribbon **103** after the step of severing.

**[00125]** **FIG. 12** illustrates another apparatus **601** wherein the first roller **603** is designed to provide the force to bend the glass ribbon. Providing a roller that rotates can minimize friction and damage to the surface that will likely occur due to the necessary mechanical engagement between the roller and the glass ribbon. Alternatively, driving the first roller **603** to match the speed of the glass ribbon **103** can further reduce friction and damage to the surface. The first roller **603** can bend the glass ribbon temporarily, thereby minimizing the length of glass ribbon that is contacted by the roller. As such, the first roller **603** may only be temporarily moved to bend the glass ribbon shortly before or substantially when the severing is to occur.

**[00126]** **FIG. 14** shows the predetermined flaw **305** approaching the severing zone **134** wherein the portion **103a** of the glass ribbon **103** including the predetermined flaw **305** in the first orientation. This orientation may be maintained, for example, by the support member **611** configured to emit fluid to contact the first side **141** to provide a support cushion.

**[00127]** **FIG. 15** shows the roller **603** being moved in direction **801** to apply a force to the second side **139** of the glass ribbon **103**. As shown, the roller **603** rotates while temporarily bending the portion of the glass ribbon in the direction **801** toward the support member **611**. In some examples, the air cushion generated by the support member **611** can cause the support member **611** to act against the bias of springs **803** and move in the direction **801** to avoid contacting the glass ribbon **103**. As shown in **FIG. 13**, three spaced support members **611a**, **611b**, **611c** can, in some examples, be independently supported such that the support members **611a**, **611b**, **611c** can each move downward to avoid contacting the glass ribbon when bending the glass ribbon with the roller **603**.

[00128] As further shown in **FIG. 15**, once the roller **603** is moved in direction **801**, the first side **141** of the glass ribbon **103** can be supported with the second roller **605** and the third roller **607**. Indeed, the first side **141** of the glass ribbon **103** can be supported along the support width “S”. As shown, the first roller **603** applies the force to the second side **139** of the glass ribbon **103** along the support width “S” defined between the second roller **605** and the third roller **607**. As such, a three point bending configuration may be provided to help bend the ribbon traversing along travel direction **112** through a bend similar to the bend illustrated in **FIGS. 7 and 8**.

[00129] Optionally, the endless belt **609** can be provided to rotate with the second roller **605** and the third roller **607** and the endless belt **609** temporarily engages the first side **141** of the glass ribbon **103**. Providing the endless belt **609** can help support the portion **103a** of the glass ribbon **103** as it traverses through the bend. Moreover, the endless belt **609** can help redirect the severed area **406** through the bend and ultimately back to the first orientation shown in **FIG. 14**.

[00130] As shown in **FIG. 13**, the endless belt **609** can comprise two or more belts **609a**, **609b** to provide adequate support across the width “W” of the glass ribbon **103**. Pressing the first roller **603** in direction **801** consequently bends the travel path of the endless belt **609** as shown in **FIGS. 15 and 16**. The belt can be substantially flexible and resilient to allow the belt to stretch to accommodate the increased overall belt length resulting from the bent travel path if the second and third rollers **605**, **607** remain at the same spacing relative to one another. Alternatively, as shown, the second and third rollers **605**, **607** may be provided with corresponding springs **613a**, **613b** that allow the second and third rollers **605**, **607** to be biased together, against the force of the springs, in corresponding directions **615a**, **615b**. In such an example, the overall length of the endless belt **609** may remain substantially the same, wherein the second and third rollers **605**, **607** move toward each other to accommodate the bend of the travel path.

[00131] Once the portion **103a** of the glass ribbon **103** is severed along the predetermined flaw **305**, the first roller **603** can be retracted such that the first, second and third rollers do not apply a force to the glass ribbon and the gas cushions from the support member **611** can again maintain the portion of the glass ribbon in the first orientation as shown in **FIG. 14**. Consequently, the springs **613a**, **613b**, if provided, can bias the second and third rollers **605**, **607** away from one another such that the upper segment of the endless belt again achieves the linear profile illustrated in **FIG. 14**. Moreover, as the



portion **103a** is repositioned from the bent orientation to the first orientation, the springs **803** again bias the portion **103a** to be positioned above, and out of contact with the endless belt **609**. As such, as shown in **FIG. 14**, the endless belt **609** does not engage the glass ribbon **103** in the first orientation. Rather, the air cushion provided by the support member **611** can be designed to provide the necessary support to the glass ribbon to maintain the first orientation.

[00132] It will therefore be appreciated that the roller **603** can provide temporary bending of the portion **103a** of the glass ribbon including the predetermined flaw **305** for a brief period of time. As such, bending can be achieved to the extent necessary to sever the glass ribbon at the predetermined flaw **305**. Moreover, the first orientation may be achieved shortly after severing, wherein the glass ribbon is again supported without mechanically engaging objects that may otherwise scratch or otherwise damage the glass ribbon.

[00133] The method can also include steps to create a gap between an upstream severed edge and a downstream severed edge. One example method can increase a relative velocity of a downstream edge portion with respect to an upstream edge portion to create the gap between the upstream severed edge and the downstream severed edge. For illustration purposes, **FIG. 17** schematically shows gauges **687**, **689** displaying a velocity of the glass ribbon **103** at each set of pinch rolls **665**, **667**. The method further includes severing the glass ribbon **103** along a direction transverse to the travel direction **112**. Severing the glass ribbon **103** can be accomplished by any of the methods described above. In one example, the severing operation can be initiated in response to a storage roll reaching a predetermined storage capacity as shown in **FIG. 11**. Sensors **505** can send a signal to the controller **195** based upon the weight of the first storage roll **501** or the second storage roll **503**. Upon receipt of a signal indicating a storage roll **501**, **503** is at capacity, the controller **195** can then initiate the severing operation. Additionally, or alternatively, the sensors **505** can send a signal to the controller **195** based upon a length of the glass ribbon **103** that has been wound around the storage roll **501**, **503**.

[00134] This severing operation divides the glass ribbon **103** into two components; the upstream web **631** and the downstream web **633**. As is best seen in **FIG. 18**, the upstream web **631** comprises the upstream edge portion **635** including the upstream severed edge **637**. Similarly, the downstream web **633** comprises the

downstream edge portion **639** including the downstream severed edge **641**. It is often advantageous to develop a glass web separation by forming a gap **683** between the upstream severed edge **637** and the downstream severed edge **641**. The gap **683** can facilitate ease of transfer of the upstream web portion to a second storage roll without changing the linear velocity of the glass ribbon in upstream locations of the manufacturing process. The gap can also help eliminate and/or reduce damage that may otherwise result from two severed edges of the glass contacting each other during glass ribbon manufacturing processes. Indeed, the gap can help prevent abutting engagement between the severed edges. The gap can also help prevent one severed edge from riding over (or under) the other edge, thereby possibly creating cracks, breaks and/or other edge or surface imperfections in the glass ribbon. As such, creating the gap can help protect the upstream and downstream edge portions of the glass ribbon without interruption of the glass ribbon process. In one example, the gap can help protect the upstream and downstream edge portions of the glass ribbon in order to allow roll to roll processing of glass ribbon without damage to the glass ribbon and without interrupting the flow of the glass ribbon through various processing locations.

**[00135]** One method of creating the gap **683** can include increasing the relative velocity of the downstream edge portion **639** with respect to the upstream edge portion **635** to create the gap **683** between the downstream severed edge **641** and the upstream severed edge **637**. **FIG. 18** illustrates a step of increasing the velocity of the downstream edge portion **639** to provide the increased relative velocity of the downstream edge portion **639** with respect to the upstream edge portion **635**. A readout on gauge **687** represents the velocity of the upstream web **631** as it is moved through the apparatus **101** with the pinch rolls **665**. A readout on gauge **689** shows an increased velocity of the downstream web **633**, thereby increasing the relative velocity of the downstream edge portion **639** with respect to the upstream edge portion **635**. This difference in relative velocities creates a gap **683** between the downstream severed edge **641** and the upstream severed edge **637**. In one example, the velocity of the downstream edge portion **639** can be returned to the velocity of the upstream edge portion **635** at a time when the gap **683** has reached a desired width. This change in velocity of the downstream edge portion **639** can be termed a “jog.” Alternatively, the described velocity change controlled by the pinch rolls **665** can be controlled by the speed of one of the storage rolls **501**, **503**.

[00136] Turning to **FIG. 19**, another method of increasing the relative velocity of the downstream edge portion **639** with respect to the upstream edge portion **635** to create a gap **683** between the downstream severed edge **641** and the upstream severed edge **637** is shown. This method includes the step of decreasing the velocity of the upstream edge portion **635** to provide the increased relative velocity of the downstream edge portion **639** with respect to the upstream edge portion **635**. A readout on gauge **687** represents the velocity of the upstream web **631** as it is moved through the apparatus **101** with the pinch rolls **665**. A readout on gauge **687** shows an decreased velocity of the upstream web **631**, thereby increasing the relative velocity of the downstream edge portion **639** with respect to the upstream edge portion **635**. This difference in relative velocities creates a gap **683** between the downstream severed edge **641** and the upstream severed edge **637**. In one example, the velocity of the upstream edge portion **635** can be returned to the velocity of the downstream edge portion **639** at a time when the gap **683** has reached a desired width.

[00137] In further examples of the method, the previously described accumulators **673**, **675** may be optionally employed in the step of increasing the relative velocity of the downstream edge portion **639** with respect to the upstream edge portion **635** to create a gap **683** between the downstream severed edge **641** and the upstream severed edge **637**. As shown in **FIG. 21**, a set of guide rollers in the downstream accumulator **675** is moved in the direction of arrow **695** to create a longer travel path for the downstream web **633**. As such, an amount of the downstream web **633** is collected by the downstream accumulator **675** to increase the velocity of the downstream edge portion **639**. If the speed at which the downstream web **633** is moved through apparatus **101** remains constant, then the longer travel path will tend to increase the velocity of the downstream edge portion **639**. The difference in relative velocity between the downstream edge portion **639** with respect to the upstream edge portion **635** creates the gap **683** between the downstream severed edge **641** and the upstream severed edge **637**.

[00138] Similarly, as shown in **FIG. 22**, a set of guide rollers in the upstream accumulator **673** is moved in the direction of arrow **697** to create a longer travel path for the upstream web **631**. As such, an amount of the upstream web **631** is collected by the upstream accumulator **673** to decrease the velocity of the upstream edge portion **635**. If the speed at which the upstream web **631** is moved through apparatus **101** remains constant, then the longer travel path will tend to decrease the velocity of the

upstream edge portion **635**. The difference in relative velocity between the downstream edge portion **639** with respect to the upstream edge portion **635** creates the gap **683** between the downstream severed edge **641** and the upstream severed edge **637**.

[00139] In another example of the method, the gap **683** between the downstream severed edge **641** and the upstream severed edge **637** can facilitate ease of transfer of glass ribbon **103** flow from a first storage roll **501** to a second storage roll **503** as seen in **FIG. 11**. As shown, the downstream web **633** is wound on the first storage roll **501**. A sensor **509** can detect the gap **683** and communicate the existence of the gap to the controller **195**. The controller **195** can then initiate a path change for the upstream web **631**. In one example, the upstream web can then be guided toward the second storage roll **503** between a second storage roll support **404c** and a first storage roll support **404d**. The upstream edge portion **635** of the upstream web **631** is introduced to the second storage roll **503** to begin winding the upstream web **631** on the second storage roll **503**. It is to be appreciated that any method of changing the flow of the upstream web **631** to the second storage roll **503** can be used. As the second storage roll **503** reaches capacity, the steps can be repeated to introduce the following severed glass web section to the first storage roll **501**.

[00140] Returning to **FIG. 25**, the glass ribbon **103** can include a width **701** extending transverse to the travel path between a first side edge **657** and a second side edge **659**. At least one of the first side edge **657** or second side edge **659** includes a handling tab **651**, **653**. The handling tabs include a mounting portion including an aperture **661** configured to expose the entire respective first side edge **657** or the second side edge **659** within the target area **663**. In one example of the method, the step of severing the glass ribbon **103** includes severing the glass ribbon **103** through the at least one of the first side edge **657** or the second side edge **659** within the target area **663**.

[00141] Another example method of developing a glass web separation between the upstream web **631** and the downstream web **633** is shown in **FIG. 23**. The method includes severing the glass ribbon **103** at a first location **707** transverse to the travel path as represented by travel direction **112**. As an example, the direction transverse to the travel path can be substantially similar to the direction of axis **217** shown in **FIG. 3**. The method further includes severing the glass ribbon **103** at a second location **709** transverse to the travel path. The first and second severing operations create a segment of glass ribbon **713** that is severed from an upstream web **631** including an upstream severed

edge **637** and a downstream web **633** including a downstream severed edge **641**. Removing the segment of the glass ribbon **713** creates a gap **683** between the upstream severed edge **637** and the downstream severed edge **641**. In one example, the first sever path is substantially parallel to the second sever path.

**[00142]** An example method can also include directing the upstream severed edge **637** along a second travel path **721** to create the gap **683** between the upstream severed edge **637** and the downstream severed edge **641**. Introduction of the upstream web **631** to the second travel path **721** can occur within the severing zone **134**. The second travel path **721** can lead to the second storage roll **503** (as shown in **FIG. 11**) where the upstream web **631** can be introduced to the second storage roll **503** for winding about the second storage roll **503**.

**[00143]** The described methods of developing a glass web separation between the upstream web **631** and the downstream web **633** can be beneficial for various processing techniques. In one example, the methods of severing can be useful to allow continuous traversing of the glass ribbon along travel direction **112** or other directions without having to interrupt movement of the glass ribbon. In one example, the methods of severing can be used to allow continuous storage of glass ribbon on storage rolls. For example, the methods of developing a glass web separation can be used during a step of switching between storing a portion of the glass ribbon on a first storage roll and storing another portion of the glass ribbon on a second storage roll.

**[00144]** **FIG. 11** illustrates one example of switching between a first storage roll **501** and a second storage roll **503**. The method of switching between rolls is illustrated with the severing method including the fluid nozzle **142** with the understanding that the method of switching can also be used with the severing method including the roll mechanism illustrated in **FIGS. 12-16**. As shown in **FIG. 11**, a sensor **505**, such as the illustrated scale may be used to measure the amount of glass ribbon that has been coiled on the storage roll. The controller **195** can be designed to initiate a severing command once a predetermined amount of glass ribbon has been stored on the roll. Once severed, for example, by one of the techniques discussed above, the controller **195** can alter the path of the glass ribbon **103** from a path leading to the first storage roll **501** to a path leading to the second storage roll **503** that may be loaded with subsequent glass ribbon (e.g. the upstream web **631**). As such, the storage rolls **501**, **503** can be operated sequentially without interruption of the continuous glass ribbon being processed, or a

change in operating speed. It is to be appreciated that **FIG. 11** represents a simplified schematic of the storage roll switching process. Additional equipment such as vacuum belts and pinner devices can be included.

**[00145]** In addition or alternatively, the methods of severing can be used to remove an undesirable segment of glass ribbon from the source **105** of glass ribbon **103**. For example, the monitoring device **193** may sense an undesired glass ribbon characteristic. In response, the controller **195** can initiate a severing command, wherein the first storage roll **501** may thereafter be removed with high quality glass ribbon stored thereon. Next, a predetermined length of glass ribbon may be traversed through the system for disposal. For instance, as shown, a glass ribbon chopper **507** may receive the predetermined length **103b** of glass ribbon having undesired characteristics. Once the monitoring device **193** again senses high quality glass, the controller **195** can again initiate the severing command. After disposing of the predetermined length **103b** of glass ribbon, subsequent high quality ribbon can then be stored on the second storage roll **503** (or again on the first storage roll **501** if desired).

**[00146]** It will be apparent to those skilled in the art that various modifications and variations can be made without departing from the spirit and scope of the claimed invention.

What is claimed is:

1. A method of processing a glass ribbon comprising the steps of:
  - (I) traversing the glass ribbon through a travel path at a predetermined velocity;
  - (II) severing the glass ribbon along a direction transverse to the travel path to create an upstream web comprising an upstream edge portion including an upstream severed edge and a downstream web comprising a downstream edge portion including a downstream severed edge; and
  - (III) increasing a relative velocity of the downstream edge portion with respect to the upstream edge portion to create a gap between the upstream severed edge and the downstream severed edge.
2. The method according to claim 1, wherein step (III) comprises increasing the velocity of the downstream edge portion to provide the increased relative velocity of the downstream edge portion with respect to the upstream edge portion.
3. The method according to claim 2, wherein an amount of the downstream web is collected by an accumulator to increase the velocity of the downstream edge portion.
4. The method according to claim 1, wherein step (III) comprises decreasing the velocity of the upstream edge portion to provide the increased relative velocity of the downstream edge portion with respect to the upstream edge portion.
5. The method according to claim 4, wherein an amount of the upstream web is collected by an accumulator to decrease the velocity of the upstream edge portion.
6. The method according to claim 1, wherein the glass ribbon of step (I) includes a width extending transverse to the travel path between a first side edge and a second side edge, wherein at least one of the first or second side edge includes a handling tab with a mounting portion including an aperture configured to expose the entire respective first or second side edge within a target area; and step (II) includes severing

the glass ribbon through the at least one of the first or second side edge within the target area.

7. The method of claim 1, wherein step (II) is initiated in response to a storage roll reaching a predetermined storage capacity.

8. The method of claim 1, wherein after step (III), the downstream web is wound on a first storage roll, and the upstream edge portion of the upstream web is introduced to a second storage roll to begin winding the upstream web on the second storage roll.

9. A method of processing a glass ribbon comprising the steps of:

(I) traversing the glass ribbon through a travel path at a predetermined velocity;

(II) severing the glass ribbon at a first location transverse to the travel path;

(III) severing the glass ribbon at a second location transverse to the travel path such that a segment of glass ribbon is severed from an upstream web including an upstream severed edge and a downstream web including a downstream severed edge; and

(IV) removing the segment of the glass ribbon such that a gap is created between the upstream severed edge and the downstream severed edge.

10. The method of claim 9, wherein a sever path created during step (II) is substantially parallel to a sever path created during step (III).

11. The method according to claim 9, wherein the glass ribbon of step (I) includes a width extending transverse to the travel path between a first side edge and a second side edge, wherein at least one of the first or second side edge includes a handling tab with a mounting portion including an aperture configured to expose the entire respective first or second side edge within a target area; and step (II) includes severing the glass ribbon through the at least one of the first or second side edge within the target area.



12. The method of claim 9, wherein step (II) is initiated in response to a storage roll reaching a predetermined storage capacity.

13. The method of claim 9, wherein after step (IV), the downstream web is wound on a first storage roll, and the downstream severed edge of the upstream web is introduced to a second storage roll to begin winding the upstream web on the second storage roll.

14. A method of processing a glass ribbon comprising the steps of:

(I) traversing the glass ribbon through a first travel path at a predetermined velocity to be wound on a first storage roll;

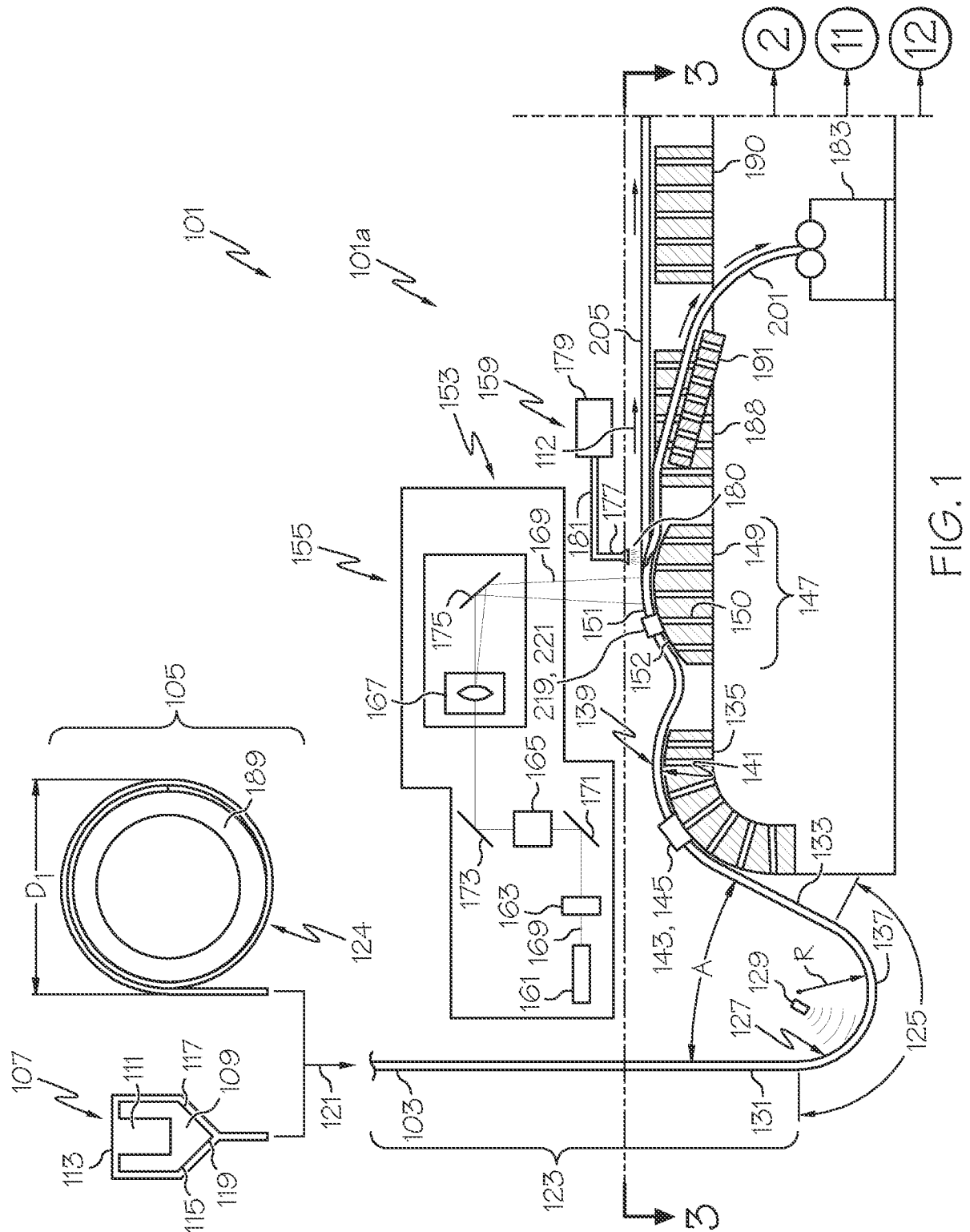
(II) severing the glass ribbon along a direction transverse to the travel path to create an upstream web including an upstream severed edge and a downstream web including a downstream severed edge; and

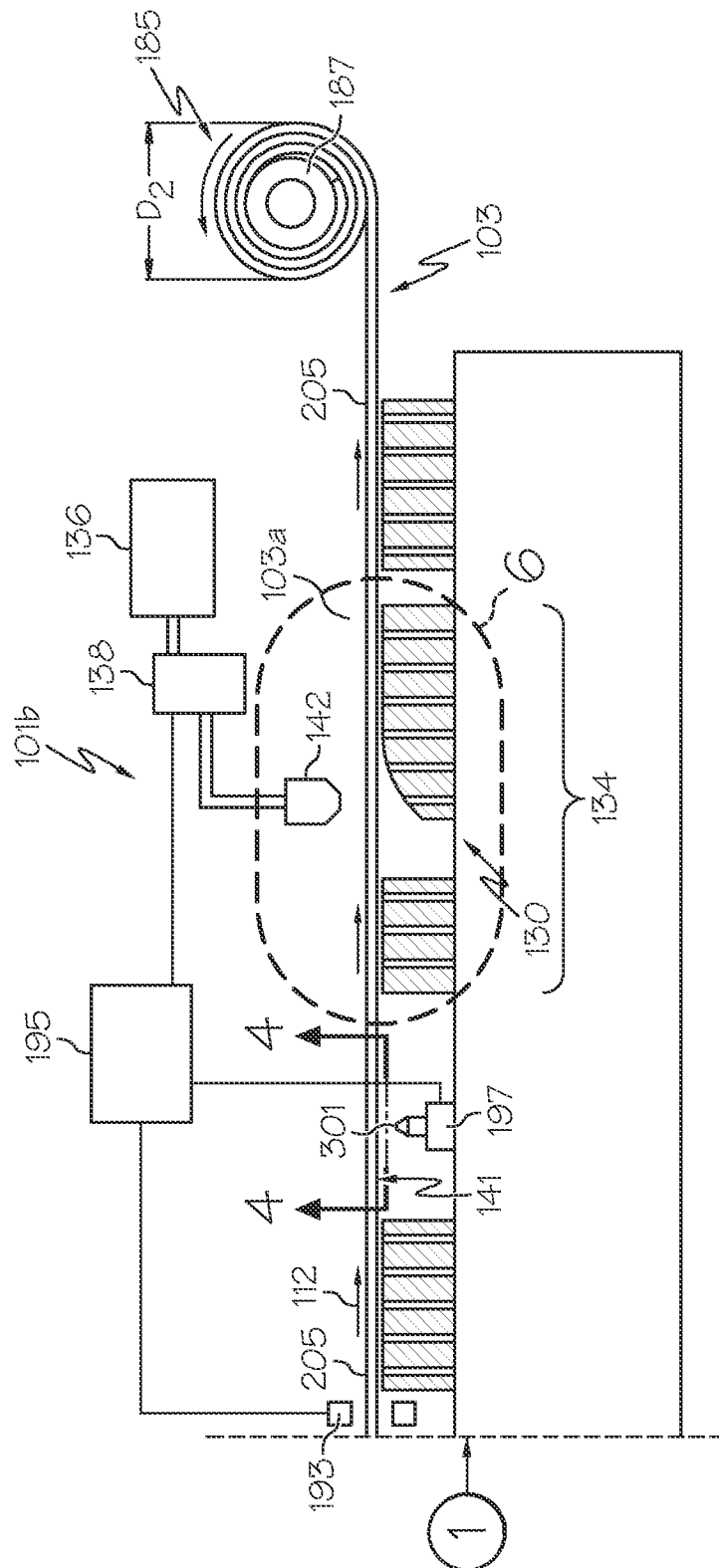
(III) directing the upstream severed edge along a second travel path to create a gap between the upstream severed edge and the downstream severed edge.

15. The method of claim 14, wherein step (III) includes directing the upstream severed edge along the second travel path to be wound on a second storage roll.

16. The method according to claim 14, wherein the glass ribbon of step (I) includes a width extending transverse to the travel path between a first side edge and a second side edge, wherein at least one of the first or second side edge includes a handling tab with a mounting portion including an aperture configured to expose the entire respective first or second side edge within a target area; and step (II) includes severing the glass ribbon through the at least one of the first or second side edge within the target area.

17. The method of claim 14, wherein step (II) is initiated in response to the first storage roll reaching a predetermined storage capacity.





2011

3 / 19

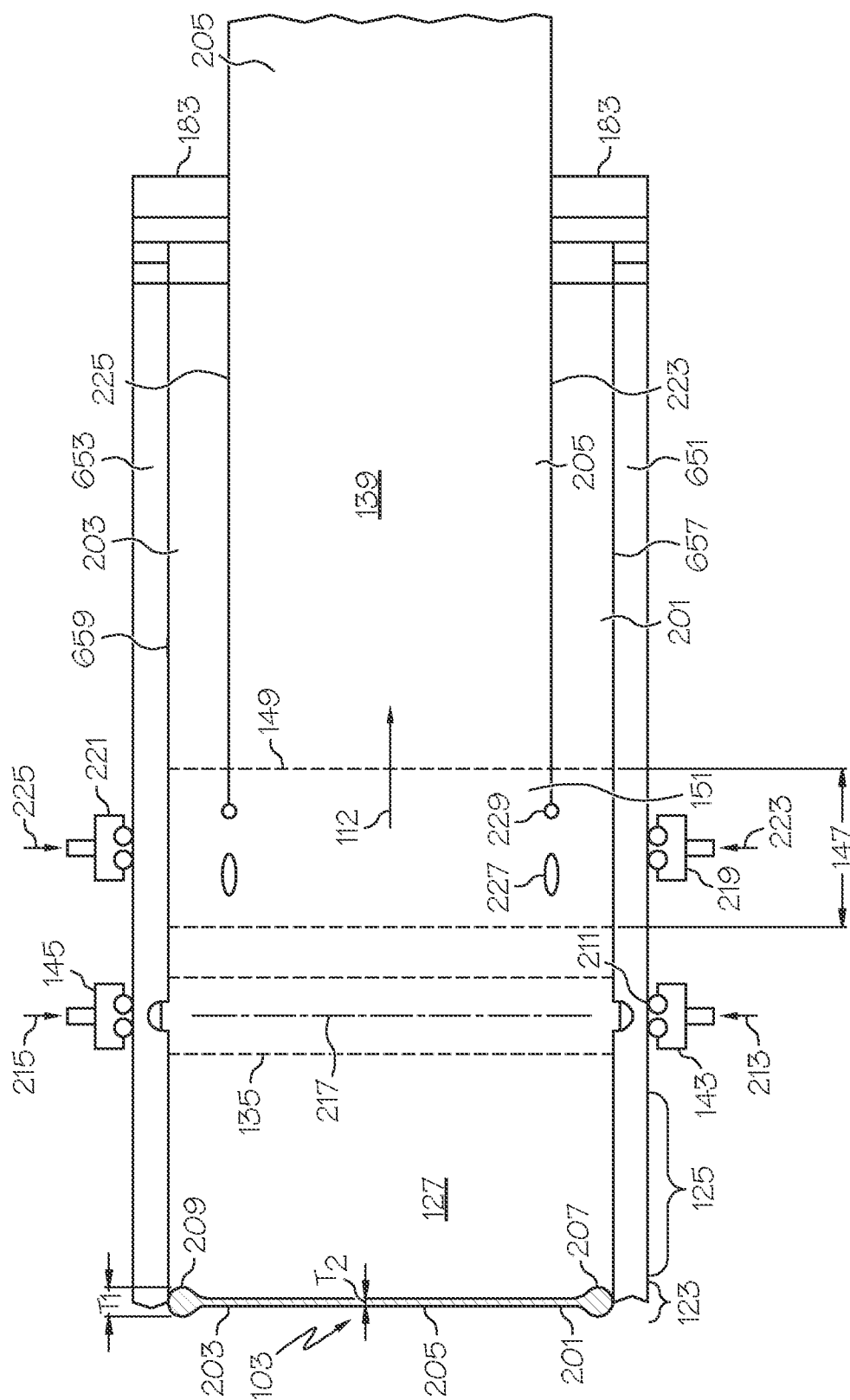


FIG. 3

4 / 19

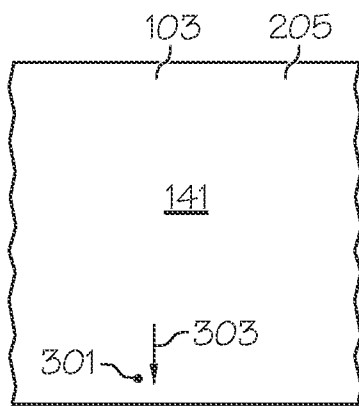


FIG. 4

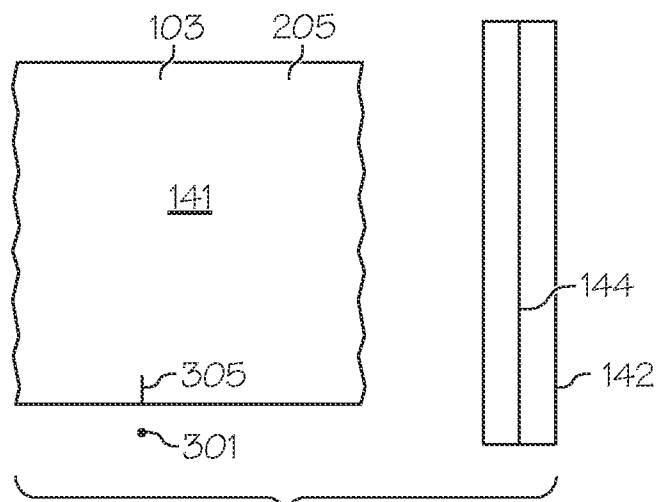


FIG. 5

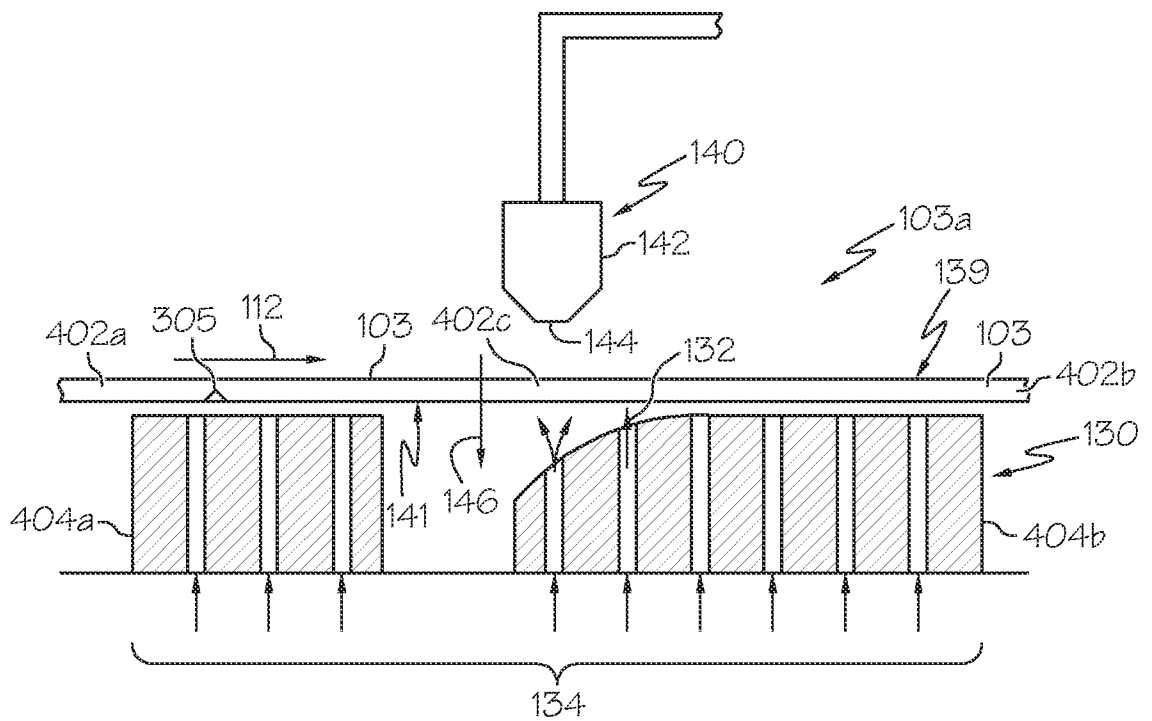


FIG. 6

5 / 19

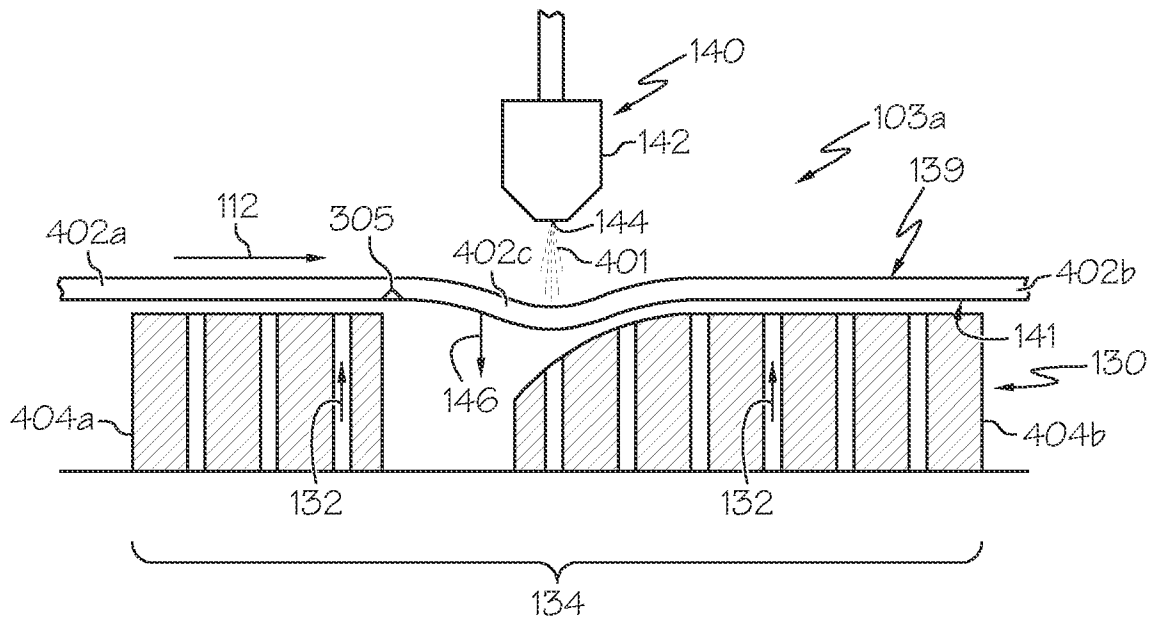


FIG. 7

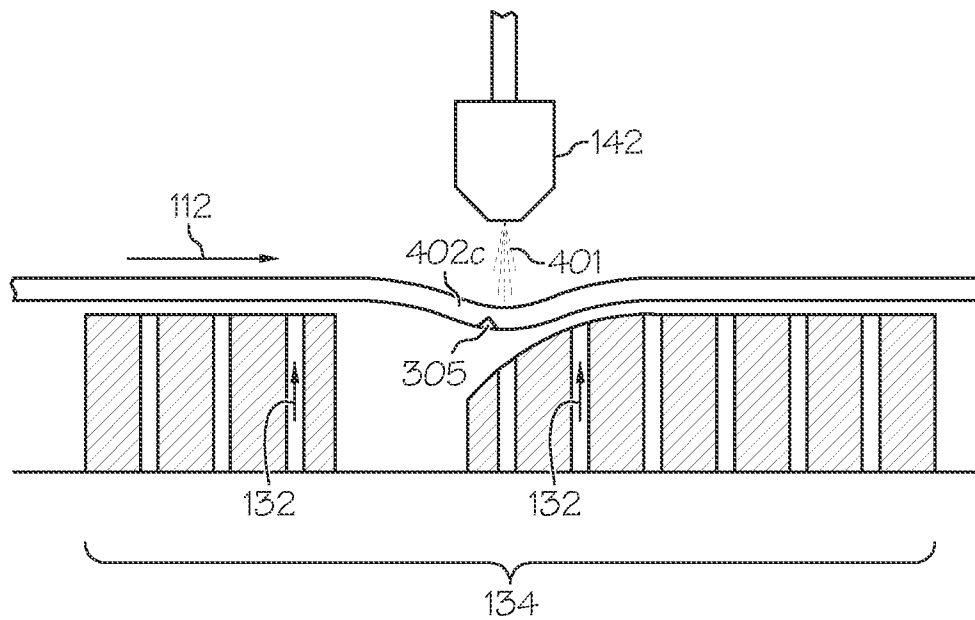


FIG. 8

6 / 19

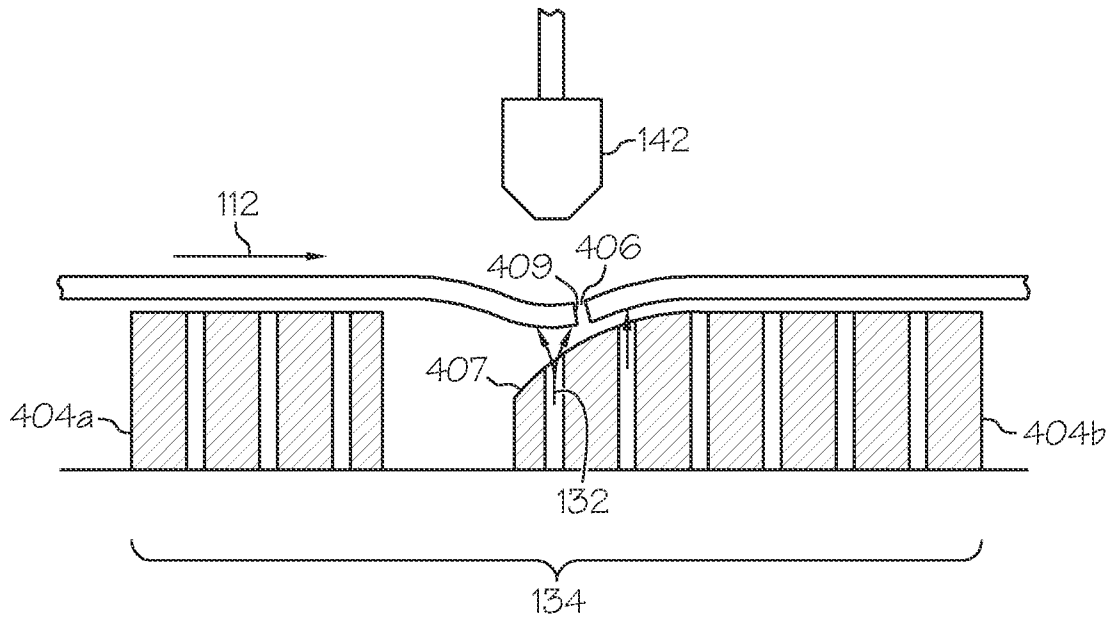


FIG. 9

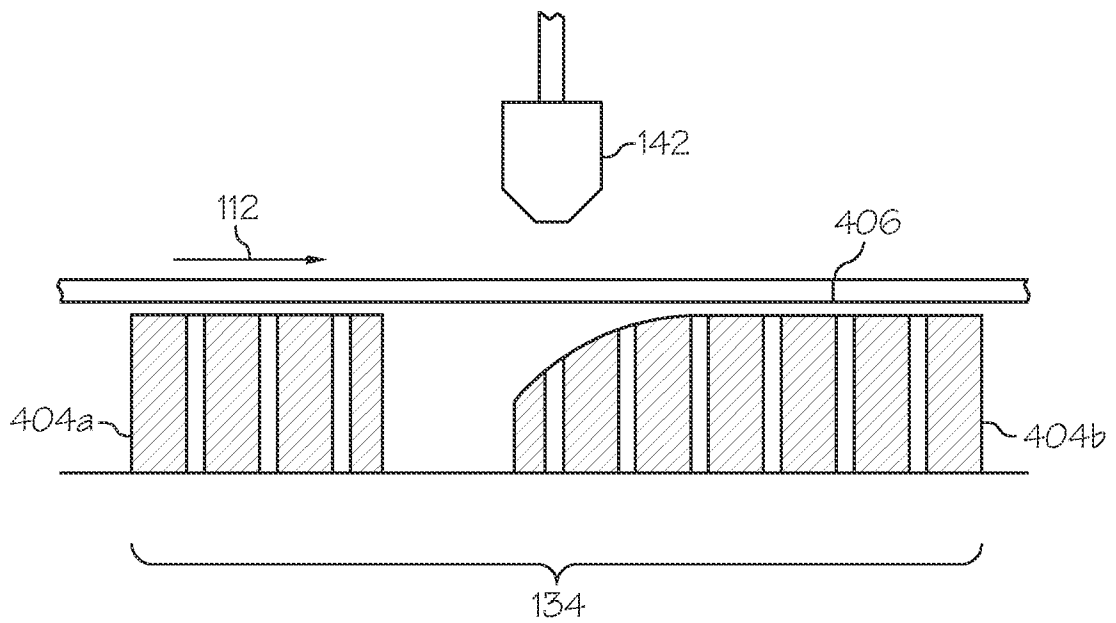
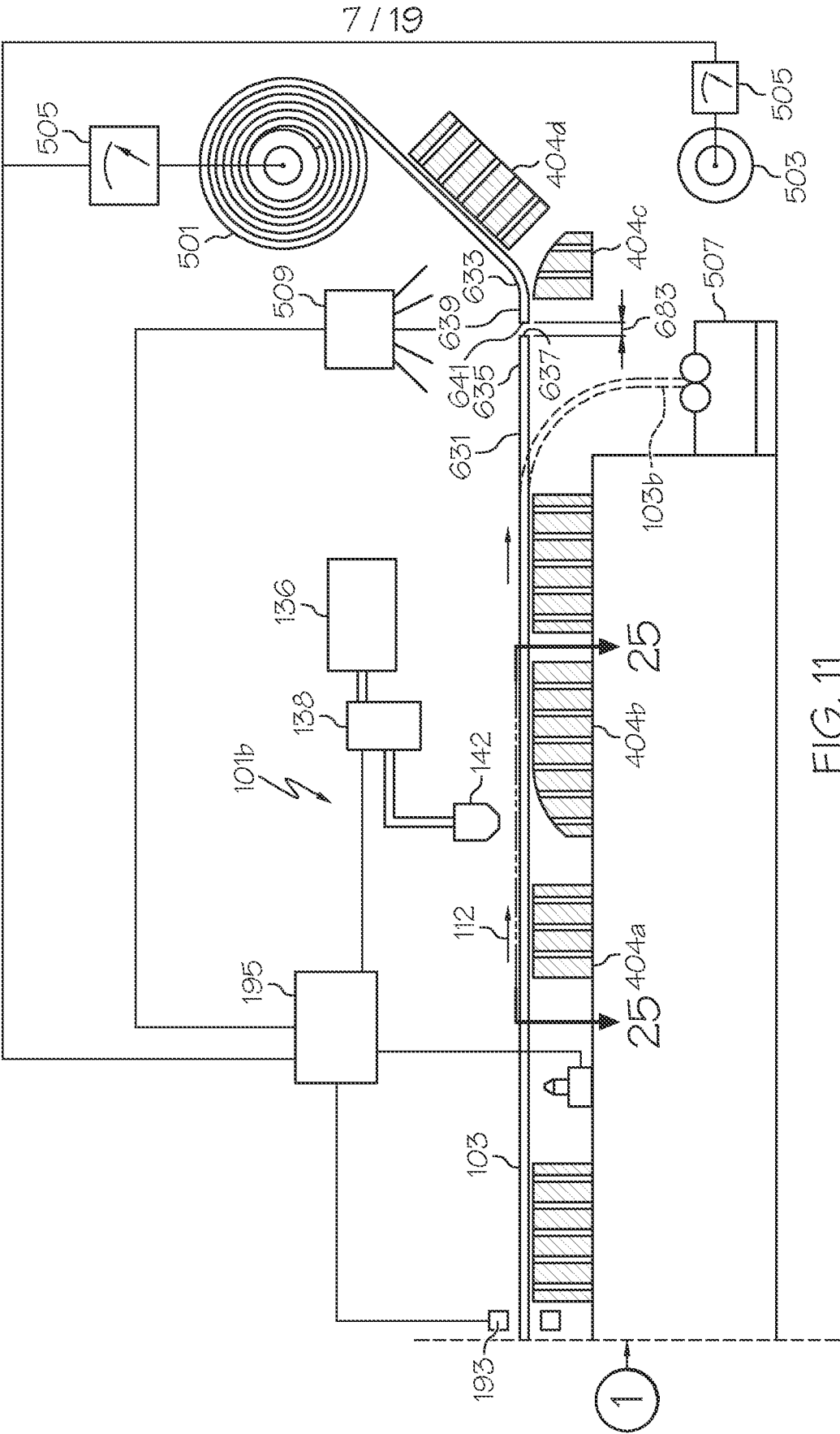
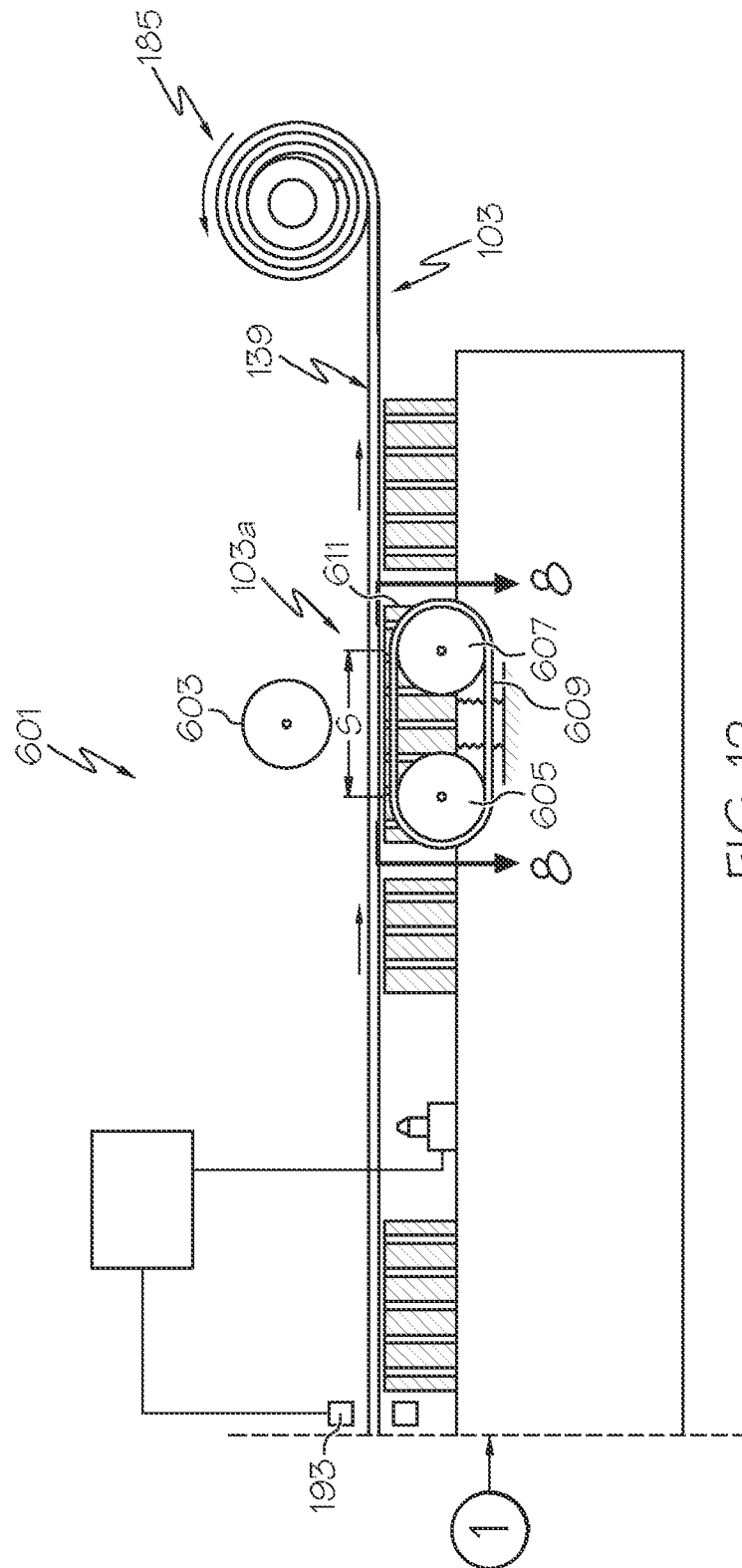


FIG. 10







204

9 / 19

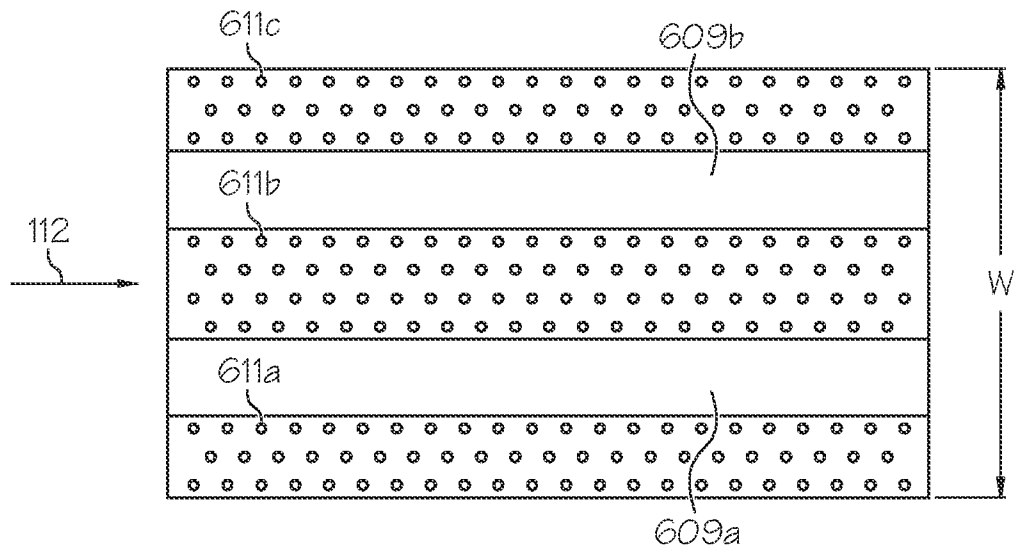


FIG. 13

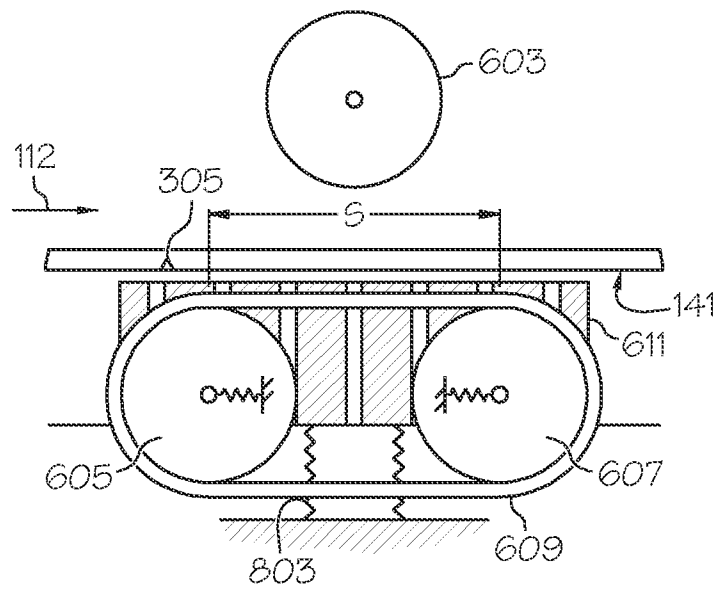


FIG. 14

10 / 19

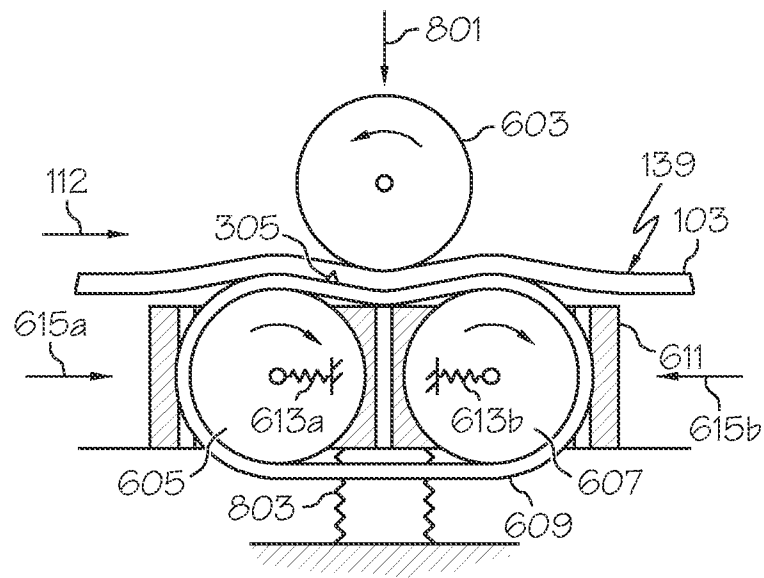


FIG. 15

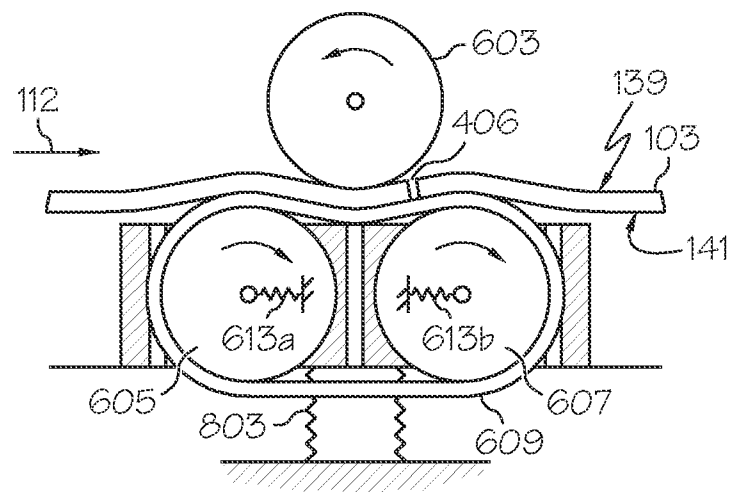


FIG. 16

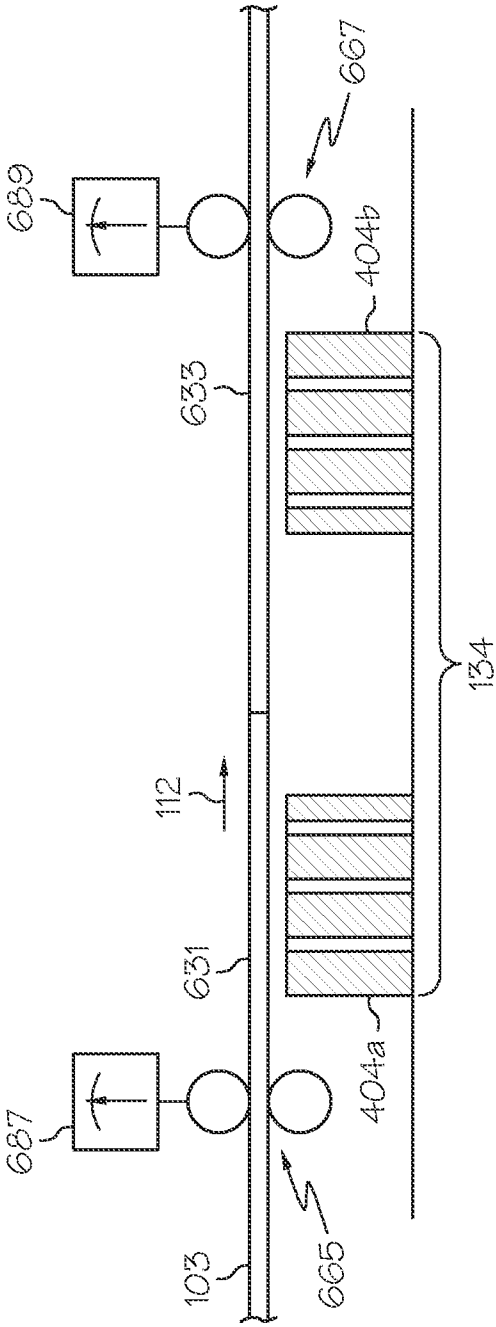


FIG. 17

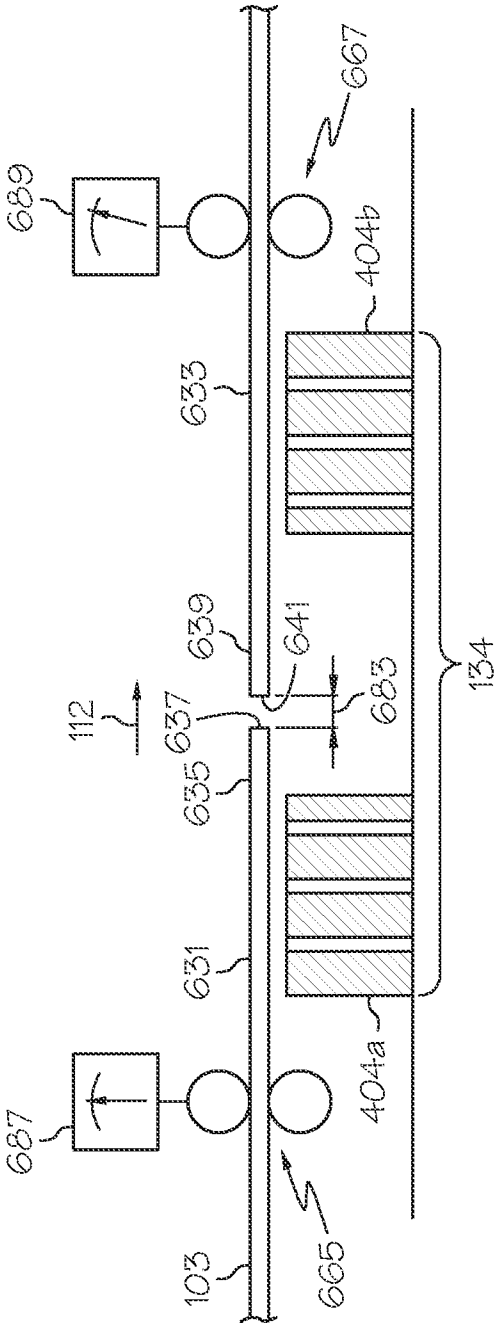


FIG. 18

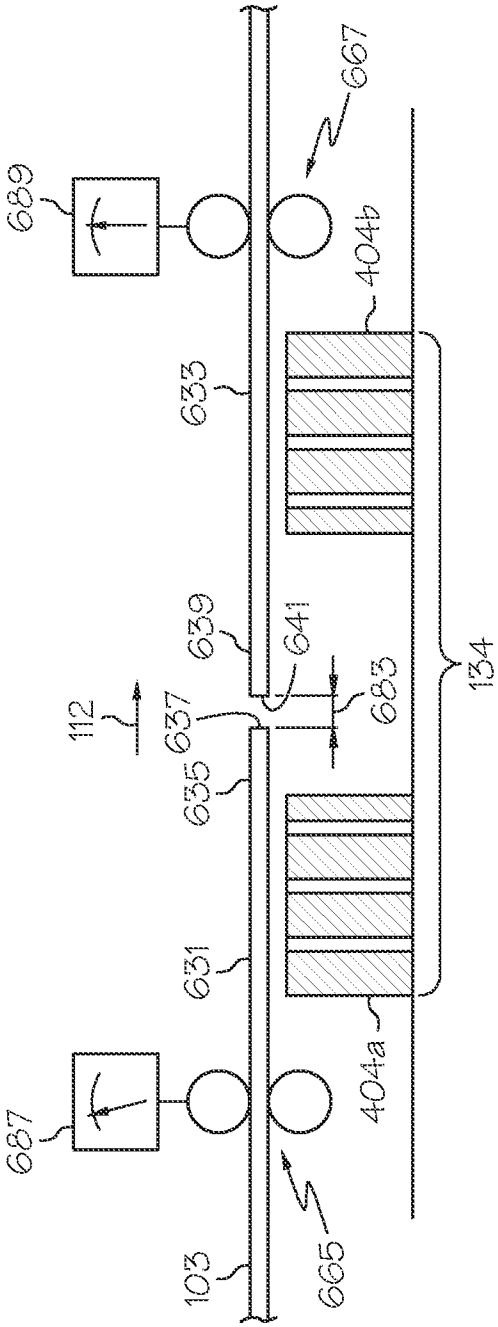


FIG. 19

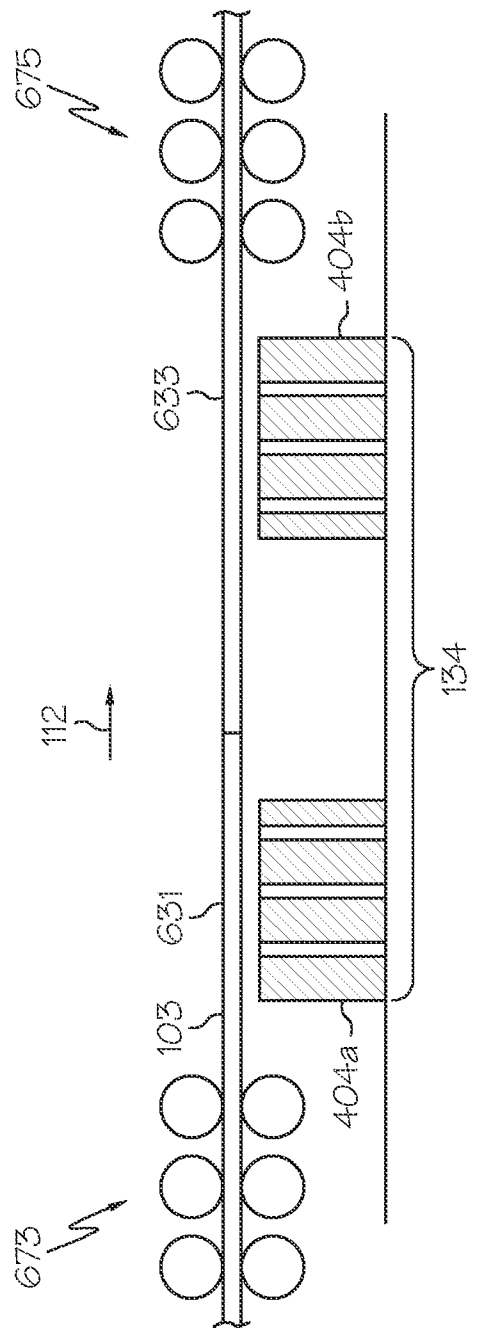


FIG. 20

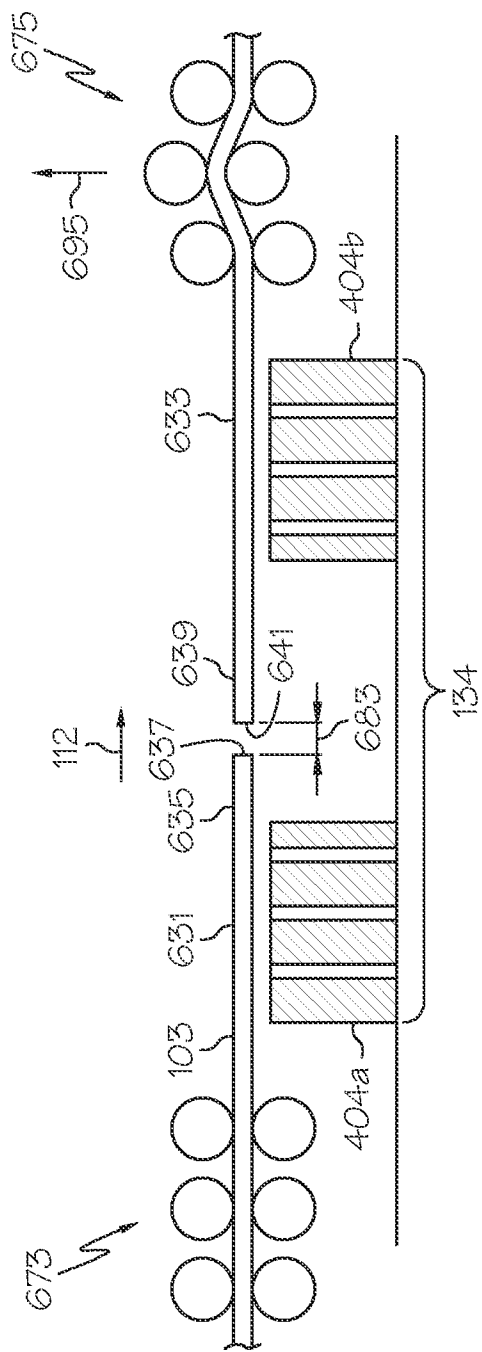
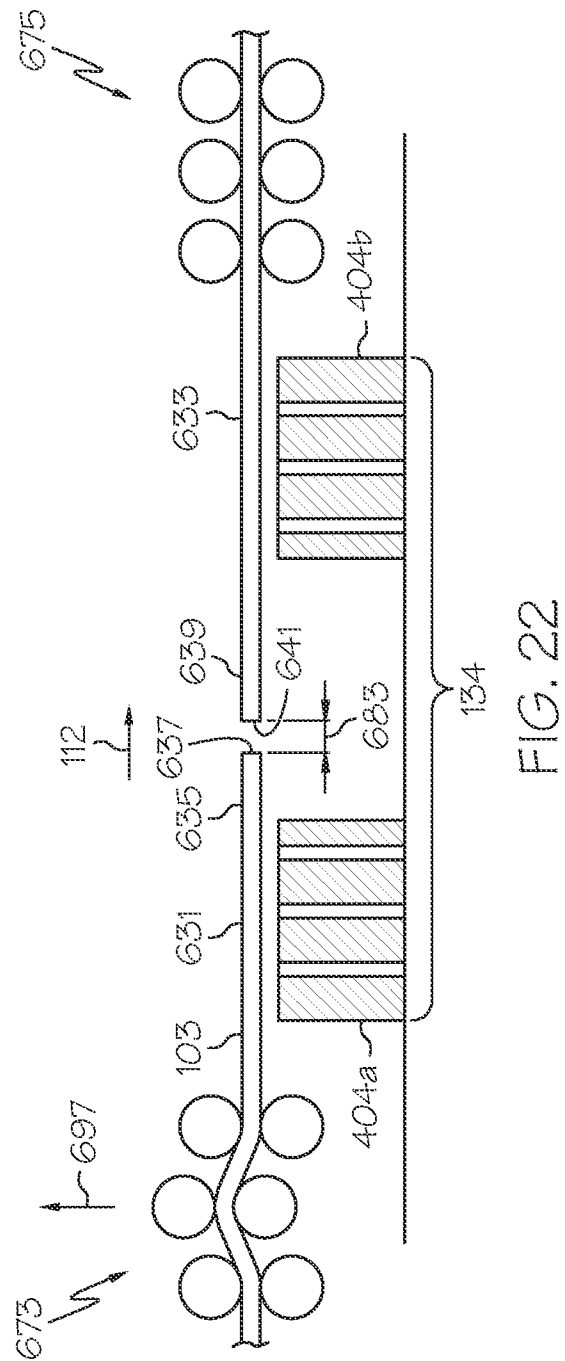
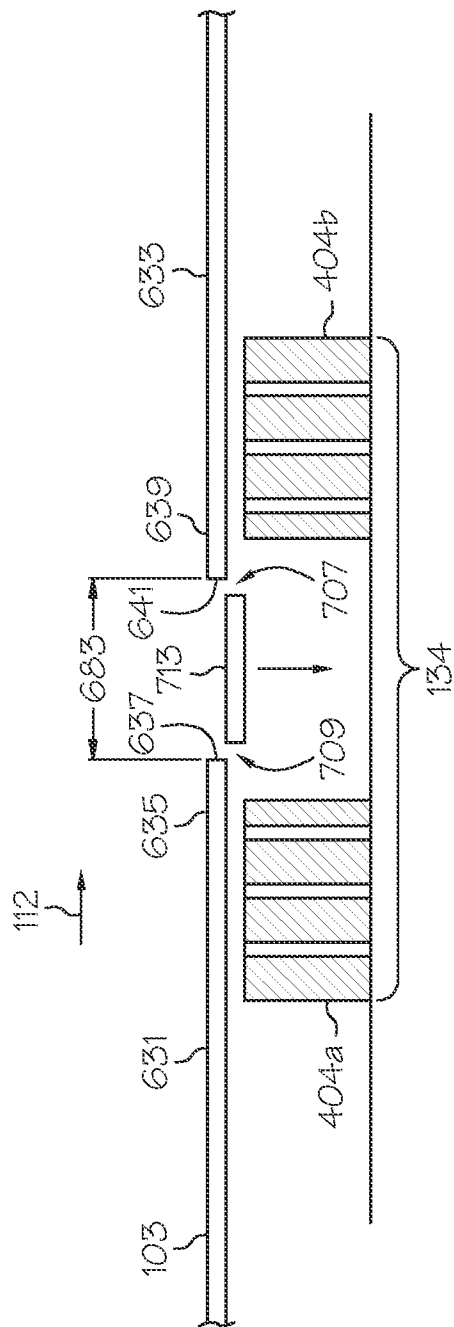


FIG. 21







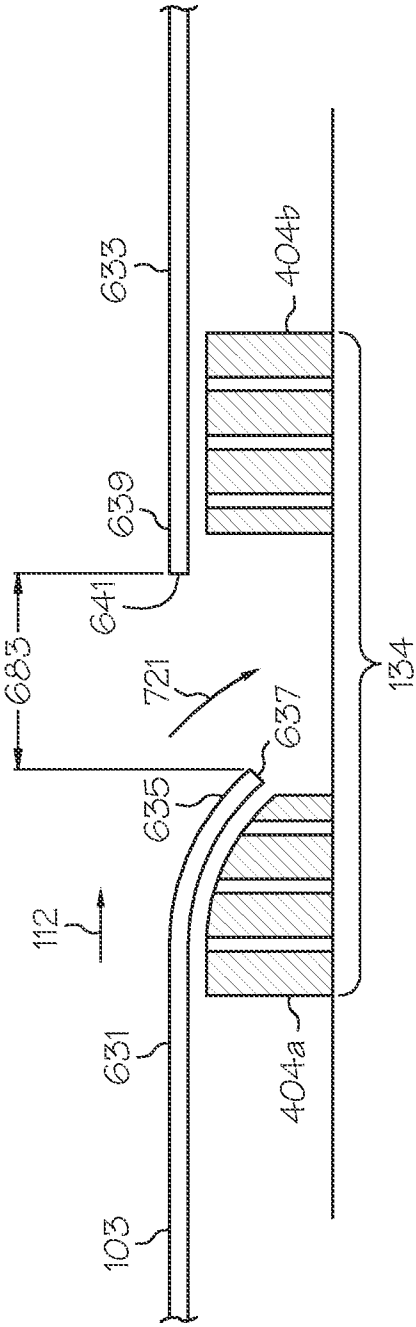


FIG. 24

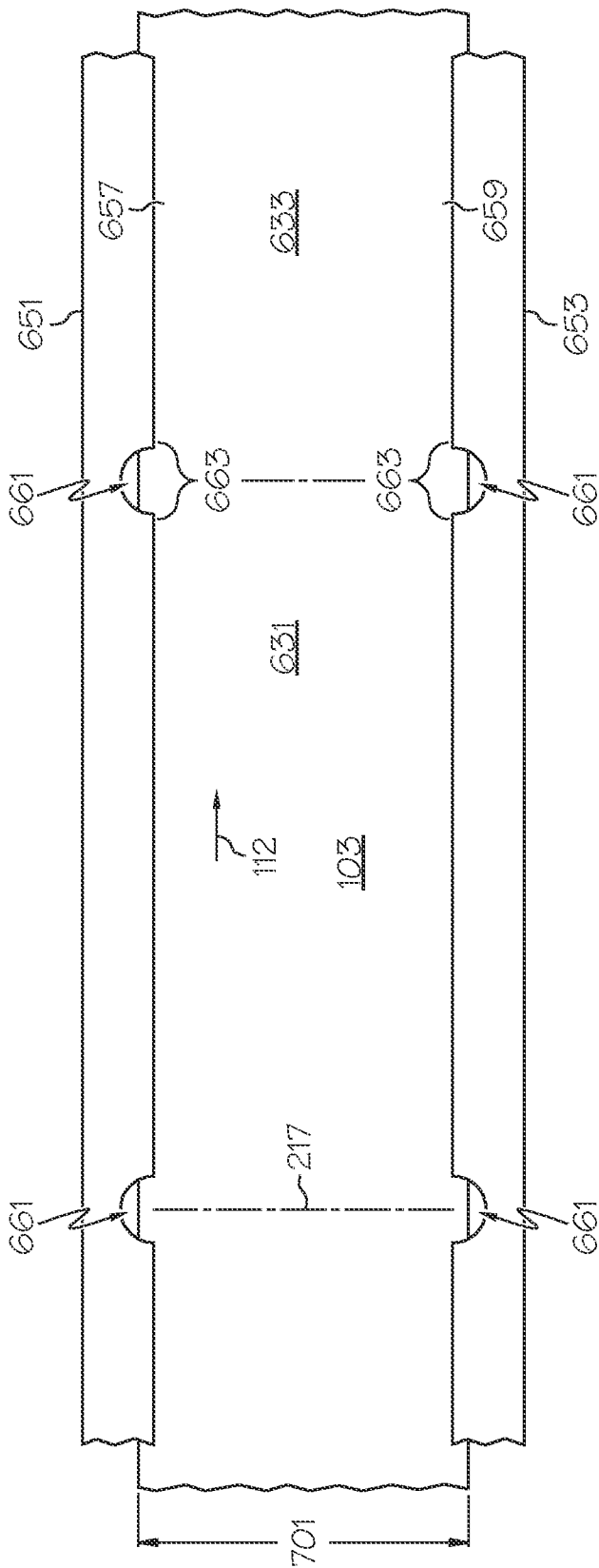


FIG. 25