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(71) Applicant: CONXTECH, INC. [US/US]; 24493 Clawiter Road, Hayward, CA 94545 (US).

(72) Inventor: SIMMONS, Robert, J.; 27308 Fairview Avenue, Hayward, CA 94545 (US).

(74) Agent: DICKINSON, Jon, M.; Jon M. Dickinson, P.c., 8015 Se 31st Avenue, Portland, OR 97202 (US).

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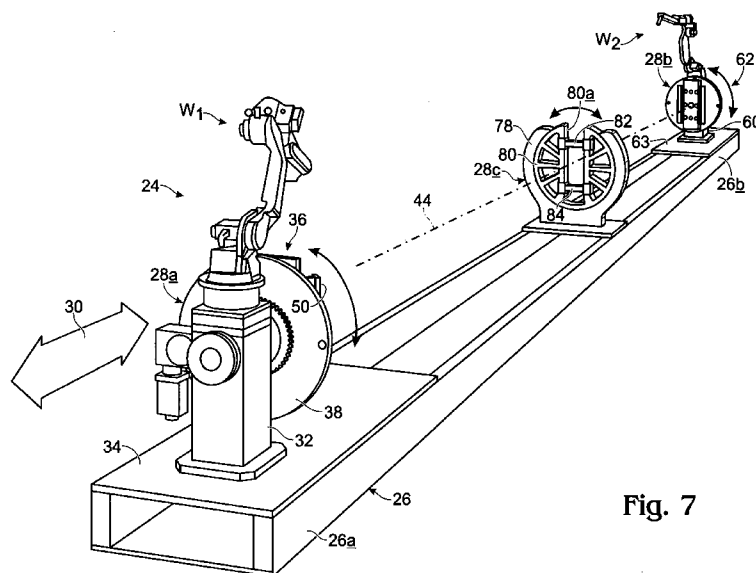


Fig. 7

(57) Abstract: Adjustable, elongate, beam-offset jig structure for assisting in welding a pair of beam-end, column-interface components to the opposite ends of an elongate beam. The jig structure includes spaced, adjustable head-stock and tail-stock structures, each capable of holding such a component adjacent a beam end for adjustment to an infinite number of different, pre-weld angular-offset dispositions relative to such a beam end in order to accommodate planned horizontal and vertical beam offsets which will be encountered when such beams are installed in a building frame. A computer-controlled, robotic welder is preferably provided adjacent each end of the jig structure to implement appropriate welding when any and all offset angles have been j ig-established.



WO 2008/150474 A1

MULTI-ANGLE, ARTICULATED-JIG-SUPPORTED, BEAM-END COMPONENT
WELDING

Background and Summary of the Invention

Recent years have seen significant improvements in the fabrication of
5 components for, and in the assembly of, full-moment nodal connections between
columns and beams in a plural-story building frame. An excellent illustration of this
progress is found in the disclosure of U.S. Patent No. 6,837,016. Reference is here
made to this U.S. Patent for the purpose of providing background information relative
to the present invention.

10 Among the elements of building-frame component and assembly progress
which are represented by the disclosure content of that U.S. Patent are that
components which enable the creation of robust, full-moment nodal connections
between columns and beams may be fabricated under factory and computer-controlled
precision conditions for the preassembly of column and beam components which may
15 then be put together on a jobsite quickly, accurately, with immediate, full-moment
stability as components are gravity-locked in place without any additional hardware
required, and all done in significantly safety-improved conditions which avoid
subjecting steel workers to major, long-time, high-level injury exposure.

As those skilled in the building art know, there are various kinds of building
20 frames which not only benefit from the kinds of improvements reflected in the
mentioned U.S. Patent, but also frames which introduce certain complexities with
respect to nodal connections that must be brought into being between beams and
columns where so-called vertical and/or horizontal design offsets need to be
addressed. For example, a vertical offset is typified by a building frame which is
25 designed to support a parking structure having multiple, sloping floors connected by

sloping vehicle ramps, wherein various beams that extend between next-adjacent columns must be inclined rather than horizontal. A horizontal offset is one which, for example, results when the grid pattern for a layout of columns is other than orthogonal, at least in certain regions of a building frame. Such a horizontal offset
5 may be one wherein next-adjacent columns that reflect an offset are positioned with their “confronting faces” parallel to one another but not directly facing one another, or one wherein a polar grid pattern is utilized to deal, for example, with a curved outside building surface.

Where one or both of these kinds of offsets exists, singular or compound, it is
10 of course necessary to accommodate these offsets by introducing appropriate angular adjustments near the ends of the beams where they connect with columns, so that appropriate full-moment connections can be confidently established. Angular adjustments required to deal with typical vertical offsets lie in the range of about $\pm 8^\circ$ (relative to the horizontal) in a vertical plane. Angular adjustments needed to
15 accommodate horizontal offsets typically lie in the same range of about $\pm 8^\circ$ in a horizontal plane. Compound offsets (combined vertical and horizontal) may, of course, be characterized by angular-adjustment needs formed by any combination of these two “singular-character” offsets.

In this kind of a situation, it is, of course, highly desirable to be able easily and
20 relatively inexpensively to accommodate such offsets and such angular construction considerations while at the same time utilizing the various advantages which have been offered to the industry by advances like those which are expressed in the above-referred-to U.S. Patent.

The present invention takes square aim at this situation by proposing a unique,
25 plural-axis, articulated jig structure, also referred to as a beam-offset jig structure, and

related methodology, which accommodate manual, or more preferably computer-controlled robotic, welding of beam-end column-interface components, also called beam-end components and beam-end connecting components, to the opposite ends of beams intended to be locked into a building frame between next-adjacent columns through full-moment connections, regardless of whether or not vertical, horizontal or both kinds, if any, of the types of offsets mentioned above are involved. A preferred and best-mode embodiment, and manner of practicing, the present invention, are specifically illustrated and described herein in the context of computer-controlled robotic welding.

10 It should be understood at this point that the jig-structure (and associated methodology) features of the present invention, which features are illustrated herein in conjunction with a specific type of representative, full-moment, nodal-connection componentry, is not *per se* linked to the geometry of that componentry. Rather, the structure and methodology of the present invention, as proposed herein, are simply representatively illustrated in this disclosure, in relation to such a particular kind of nodal-connection componentry, in the realm of including complementary receiving structure that allows such componentry, i.e., its particular configuration, to be handled easily during the process of weld attachment to the opposite ends of a beam, with the full recognition that similar complementary accommodating structures could just as well be employed to deal with other specific geometries of nodal-connection hardware.

All of the central features of the invention which one of skill in the art needs to understand in order to practice the invention are fully and clearly disclosable in high-level schematic and stylized drawings, and that is precisely the lead-in approach to disclosure of this invention which is employed below in the detailed description of the

invention. Beyond the fully informative schematic drawings, more detailed component drawings are provided simply to illustrate a specific design approach which has been chosen to implement the handling of one illustrative type of beam-end column-interface component (nodal-connection hardware) recently developed as part of a newly proposed, full-moment, beam-column nodal connection. This just-mentioned, newly proposed nodal connection is illustrated and described in currently co-pending U.S. Patent Application (Serial No. to be determined), filed May 30, 2008, for "Halo/Spider, Full-Moment, Column/Beam Connection in a Building Frame". Reference is here made to this co-pending application for more detailed information regarding this particular kind of nodal connection.

Accordingly, proposed by the present invention, in its preferred form, is a unique, elongate jig structure of the type suggested above, which features an elongate, generally horizontal frame that defines a bed for receiving a pair of longitudinally spaced head-stock and tail-stock structures. Each of these structures is equipped with a conventional, plural-axis (such as a six-axis), computer-controlled, robotic welder disposed in the relevant head-stock or tail-stock structure immediately adjacent specially designed angulation and pivot structure (articulation structure, or motion structure) which is adjustable, in accordance with the features of the invention, to produce proper relative angular positioning between the opposite ends of an elongate beam, such as an I-beam, and a pair of opposite, beam-end column-interface components which are to be employed ultimately in connecting a beam between a pair of columns to produce full-moment connections with those columns. Such beam-end column-interface components can be visualized as each possessing a nominal plane, and the angular positioning which takes place in the practice of the present invention is referred to herein as occurring between such a nominal plane and the long axis of a

beam. In the proposed jig structure, the head-stock is equipped, at least in part, with motor-drive equipment to effect certain motion, such as rotation, of certain componentry, with the tail-stock, while having similar, overall motion structure, operating as a slave unit, as will shortly be explained.

5 The apparatus of the invention is fully capable of dealing not only with conventional, “squared-off”, “non-angular” alignment and pre-positioning between the long axis of a beam and the nominal planes of a pair of beam-end connecting components, where no horizontal or vertical offset needs to be accounted for, but also with infinite (within a range), pre-welding angular alignment and pre-positioning of
10 beam-end components relative to a beam to deal with one or both kinds of offsets, singularly or in combination. In most instances, the jig structure, if equipped to accommodate angular beam-end connecting-component adjustments in the range of about $\pm 8^\circ$ for each kind of offset, will adequately handle all typical offset conditions. The jig structure illustrated herein is so equipped.

15 Thus, and as will be seen from the detailed description of the invention which appears below, the mentioned head-stock and tail-stock structures each includes (a) a main rotator which is capable of rotating on what is referred to herein as the principal long axis of the jig structure of the invention, which axis is also called the jig-rotation axis and the rotation axis, (b) a rocker, or rocker structure, which is carried on that
20 rotator and which allows for limited, reversible, angular rocking about a rocker axis which is orthogonal to, and which intersects, the jig-rotation axis, and (c), what is referred to herein as a beam-end, column-interface-component gripper which is mounted on the rocker for independent 360° rotation about a rocker-rotation axis that orthogonally intersects the rocker axis at the location where the rocker axis intersects
25 the jig-rotation axis.

This unique arrangement of componentry allows for appropriate, compound angular adjustment, if such is necessary, effectively in an infinite adjustability way to accommodate all arrangements of angular disposition which are normally expected may be required between the long axis of a beam and the nominal plane of a beam-
5 end column-interface component in order to accommodate not only squared-off ultimate disposition of that beam, but also angular offset disposition as desired.

Within the apparatus of the invention, and as was stated more generally above, the gripper just mentioned is one which, while illustrated herein specifically shaped to deal with one illustrative kind of beam-end column-interface component, will of
10 course be configured, as necessary, to deal with whatever particular-geometry beam-end component may be the kind which is intended to be joined by welding to the end of a beam.

The above-mentioned features and advantages presented and offered by the jig structure of the present invention will become more fully apparent as the detailed
15 description thereof which shortly follows is read in conjunction with the accompanying drawings.

Descriptions of the Drawings

Fig. 1 is perspective view of an elongate I-beam whose opposite ends are fitted with a particular style of beam-end, column-interface component. In this figure, the
20 beam-end, column-interface components are shown in what is referred to as being a square-fitted condition relative to the illustrated beam, that is, with the nominal planes of these beam-end components disposed substantially normal to the long-axis of the illustrated beam.

Fig. 2 is a lateral elevation of the beam and beam-end components shown in
25 Fig. 1. In this view, the two beam-end components are shown in solid lines in what

was just mentioned as being their square-fitted conditions, and they are also shown in dash-double-dot lines in commonly counterclockwise-angulated dispositions relative to the long axis of the beam. These angulated dispositions are designed to accommodate what has been described earlier herein as a vertical offset in a building
5 frame.

Fig. 3 is a downward-looking plan view of the beam and of the beam-end components of Fig. 1. Here, the beam is illustrated with its two, connected beam-end components shown in solid lines in their square-fitted conditions, in dash-double-dot lines in commonly counterclockwise-angulated conditions suitable for dealing with a
10 non-polar, non-orthogonal column pattern requiring a horizontal offset, and in a combination of dash-double-dot (left side) and dash-dot (right side) lines in another set of angulated conditions suitable for dealing with a horizontal offset associated with a polar-grid arrangement of columns.

Fig. 4 is a simplified, high-level, schematic elevation illustrating the overall
15 arrangement of a beam-offset jig structure constructed in accordance with a preferred and best-mode embodiment of the present invention. In this view, an I-beam is shown which has been prepared to be lowered into a seated and supported condition in the jig structure of the invention, preparatory to having a pair of beam-end, column-interface components, appropriately adjusted angularly relative to the long axis of the beam --
20 thereafter to be welded to the beam. In this view, the beam is shown with two beam-end components preliminarily and temporarily linked to its opposite ends under pressure furnished by removable tension-spring clips of suitable design which will eventually be removed. These spring clips form no part of the present invention.

Fig. 5 is a larger-scale, simplified, high-level schematic view illustrating
25 angular articulation structure which appears at the left-hand side of Fig. 4 in a head-

stock structure that forms part of the jig structure of the invention. This schematic view fully illustrates all of the angulation articulation capabilities of the jig structure of the invention.

Fig. 6 includes four parts (a), (b), (c) and (d) which schematically illustrate, 5 nonexclusively, several, different, spatial relationships which may exist individually between the long axis of a beam and the above-mentioned jig-rotation axis during different beam-end-component-to-beam welding operations. The straight lines in this figure variously represent these axes.

Figs. 7-11, inclusive, are even larger-scale and more detailed, representational 10 drawings illustrating, generally, one specific set of components which have been made to implement the jig structure shown in Figs. 4 and 5.

Detailed Description of the Invention

Turning now to the drawings and referring first of all to Figs. 1-6, inclusive, Figs. 1, 2 and 3 illustrate an elongate I-beam 20 having a long axis 20a, and a pair of 15 particular-style, beam-end column-interface components 22 welded in place to the opposite ends of the beam. Beam-end components 22 each possesses what is referred to herein as a nominal plane, shown at 22a. In Figs. 1-3, inclusive, the two beam-end components are shown in solid lines square-fitted to the opposite ends of beam 20. As a consequence, nominal planes 22a are illustrated in conditions disposed 20 substantially normal to beam long axis 20a.

Digressing here for a moment, and as was mentioned earlier herein, no aspect of the present invention is specifically concerned with the particular design of a beam-end component which is to be welded to the end of a beam. Notwithstanding this statement, the particular beam-end components which are illustrated in Figs. 1-3, 25 inclusive, are of a category which is designed, with appropriate hardware attached to

the sides of a column, to establish gravity-seat-and-lock, full-moment connections simply through the process of lowering a beam-end-component-equipped-beam vertically downwardly into a prepared receiving space between a pair of next-adjacent columns. The beam-end components specifically illustrated are formed, on their
5 laterally opposite sides, with male-tapered bearing surfaces which seat by gravity complementarily into receiving sockets which are defined by female-tapered bearing surfaces that are included in structures which are anchored at appropriate common elevations to the corners of next-adjacent columns in a steel building frame structure.

As will become apparent, and as should be well understood, appropriate
10 gripper structure, soon to be described in the jig structure of the present invention, has been made so as to replicate the just-mentioned female receiving socket structure which is expected to be made present adjacent the sides of a column to which the beam of Figs. 1, 2 and 3 is ultimately to be connected. Such an arrangement thus equips the jig structure of this invention to receive and support a beam with the
15 appropriate beam-end components during the process of making appropriate angular adjustments in the beam-end components relative to a beam's long axis prior to welding in place.

While, as has just been stressed, there is no part of the present invention which is linked specifically to any particular beam-end-component design, the design
20 specifically illustrated in Figs. 1-3, inclusive, is, as stated earlier herein, fully described in the above-mentioned, currently co-pending U.S. Patent Application. Accordingly, reference may be made to that pending patent application for a further elaboration regarding the relevant beam-end component structure.

As was mentioned above in conjunction with descriptions given so far for
25 Figs. 1-3, inclusive, in the drawings, in each of these three drawing figures, beam-end

components 22 are shown in solid lines in their square-fitted conditions. These square-fitted conditions are conditions which result from the beam-end components being welded to the ends of beam 20 with their nominal planes disposed substantially normal to the long axis 20a in the beam.

5 As was also mentioned earlier, in Fig. 2, in dash-double-dot lines, beam-end components 22 are shown commonly angulated in a counterclockwise manner relative to their solid-line positions. Specifically, they are here shown rotated at a common angle in order to accommodate what has been referred to earlier herein as a vertical offset in a building frame.

10 In dash-double-dot lines in Fig. 3, the beam-end components are shown in commonly counterclockwise-rotated angular dispositions relative to beam long axis 20a -- suitable for dealing with a simple lateral offset in a non-orthogonal column pattern in a building frame. In a combination of dash-dot (right side) and dash-double-dot (left side) lines in Fig. 3, the beam-end components are shown counter-
15 angulated relative to beam long-axis 20a, i.e., in reverse directions, so-to-speak, in order to accommodate a horizontal offset of the type experienced in a column grid pattern which is polar.

The jig structure of the present invention, now shortly to be described in detail, is designed with great versatility to receive and support a beam and a pair of
20 beam-end components, prior to welding, in conditions establishing the appropriate angulations required between a beam's long axis and the beam-end components' nominal planes in order to accommodate one or both (singularly or in combination) type(s) of the beam offsets mentioned above.

In terms of establishing proper confronting surfaces to perform welding under
25 angulated conditions, there are principally two approaches which one might choose to

use. One approach involves crosscutting the ends of a beam in planes that are pre-angled so as to parallel the after-welding nominal planes of attached beam-end components, and to do this in such a fashion that such beam-end components end up being attached by welding to the beam at the appropriate angles to suit a particular kind of offset. Another approach involves leaving the opposite ends of a beam crosscut in squared-off conditions, with the jig structure of the invention being employed then to define the proper angular dispositions for beam end components, and with resulting, modest, angular gaps existing between each beam-end component and the squared-off end of a beam, which gaps will be filled appropriately during welding. Which one of these approaches to use is entirely up to the discretion of the person invoking the practice of the present invention, and both approaches are readily accommodated by the jig structure of the invention.

Focusing attention now particularly on Figs. 4-6, inclusive, indicated generally at 24 is a preferred and best-mode embodiment of the beam-offset jig structure of the present invention. As was mentioned earlier herein, the illustration of jig structure 24 in Figs. 4 and 5 is presented in a very high-level, schematic fashion in order to convey an understanding quickly and easily about the components which make up this jig structure. Another reason for employing such high-level, schematic views is that the specific details of construction of the various components of jig structure 24 do not particularly form any part of the present invention. Put another way, one skilled in the art, after reading the schematic description of the invention herein alone, will be fully equipped to build and operate the jig structure of the invention by adapting its components to specific beam-end componentry which may be involved in a particular application. Figs. 7-11 herein, still to be described, are non-schematic, and rather

picture one representational rendering of the jig structure of the invention. These figures point out one way of implementing the invention in a more specific fashion.

Jig structure 24 includes an elongate frame 26 having opposite ends 26a, 26b. End 26a will be referred to herein as the head end of frame 26, and end 26b as the tail
5 end of the frame.

Mounted on frame 26, as will shortly be more fully described, is what is referred to herein as beam-support structure 28 which takes the form of a head-stock structure 28a, a tail-stock structure 28b, and an adjustable, central, beam-support yoke structure 28c. Head-stock structure 28a is appropriately supported on frame 26,
10 adjacent frame end 26a, for selective, reversible travel back and forth along frame 26, as is generally indicated by double-headed linear arrow 30 in Fig. 4. Motion, as indicated by arrow 30, may be effected by a suitable drive motor and gear arrangement (not shown) which operates between frame 26 and head-stock structure 28a. The purpose for this back and forth moveability of the head-stock on the jig
15 apparatus frame is to accommodate use of the jig structure in conjunction with beams having different lengths.

Previously mentioned beam 20 is shown disposed overhead jig structure 24 in a condition poised to be lowered into the jig structure for beam-end-component adjustment and welding. More will be said about this poised condition of beam 20
20 shortly.

Included in head-stock structure 28a are a head-stock frame 32 which is mounted on a sled 34 which in turn is mounted for reversible translation, as indicated by arrow 30, on frame 26. Carried on head-stock frame 32 is articulation structure 36 which is constructed in accordance with the present invention, and which includes a
25 rotator 38, a rocker 40, and a gripper 42.

Rotator 38 is suitably journaled on head-stock frame 32 for reversible, 360° rotation, under non-illustrated drive-motor control, about an axis 44 which is referred to herein both as a rotator axis, and as a jig-rotation axis. Rotator axis 44 is considered herein to be the main articulation/rotation axis which is provided in jig structure 24.

Rotator 38 may typically take the form of a generally circular, vertical plate which, while fully rotatable as just described, is also appropriately equipped to be locked selectively against rotation at four, different, orthogonally-related positions which are relevant to a beam-end component welding operation, as will shortly be described.

Rocker 40 takes the form of any suitably shaped, generally planar plate, which is pivoted through suitable pivot structure 45 on rotator 38 for limited (about $\pm 8^\circ$) angular rocking about what is referred to herein as a rocker axis 46. The nominal plane of rocker 40 is shown at 40a. Axis 46, which extends normally into the plane of Fig. 5, is orthogonal with respect to rotator axis 44. Axis 46 rotates in a vertical plane in space with rotation of rotator 38.

Rocking action of rocker 40 is generally illustrated in Fig. 5 by double-headed, curved arrow 48. In the particular embodiment of jig structure 24 which is now being described, appropriate, reverse-direction limit structure (not shown in Fig. 5) is interposed rotator 38 and rocker 40 so as to limit the possible reversible rocking range of rocker 40 about axis 46 to about $\pm 8^\circ$ (as mentioned earlier) relative to the solid-line position shown for the rocker in Fig. 5. Rocking of rocker 40 to a particular angular rotation relative to the rotator is accomplished in structure 24 manually, as will shortly be explained, but could also just as well be performed under appropriate motor-drive control, if desired.

Gripper 42, which includes appropriate gripping structure, such as that generally illustrated by curved lines 50 in Figs. 4 and 5, is rotatably mounted at 51 on rocker 48 for rotation about what is referred to herein as a rocker-rotation axis 52. Axis 52 herein is disposed substantially normal to the nominal plane 40a of rocker 40, and this rocker rotation axis, as seen nominally in Fig. 5, coincides with rotator axis 44 under circumstances with the components of articulation structure 36 shown in their solid-line dispositions in Fig. 5. Rocker-rotation axis 52 intersects rocker axis 46 orthogonally at the very location where axis 46 orthogonally intersects rotator axis 44.

In dash-double-dot lines 52a and 52b in Fig. 5, rocker rotation axis 52 is shown in two different angulated dispositions which have resulted, respectively, from limited-angle, counterclockwise and clockwise rocking of rocker 42 through a range of about $\pm 8^\circ$. Under all circumstances, the rocker-rotation axis retains the conditions of "other-axes" intersections as were just described.

Toward the right side of Fig. 5, three double-headed, curved arrows 54, 56, 58 illustrate different articulation motions. Arrow 54 represents reversible 360° rotation of rotator 38, and all of the structure which it carries, about jig-rotation axis 44. Arrow 56 represents reversible, limited-angle (about $\pm 8^\circ$) rocking of rocker 40, and all of the componentry which it carries, about rocker axis 46. Arrow 58 represents reversible 360° -possible rotation of gripper 42 about rocker-rotation axis 52.

Although shown only very schematically in Figs. 4 and 5, gripper structure 50 which is provided on gripper 42 is designed to receive a beam-end component 22 in the same fashion, essentially, that such a component will be received adjacent the side of a beam in an intended full-moment nodal connection. Accordingly, and as was mentioned earlier herein, this beam-end-component-receiving gripper structure will

always be appropriately designed, by one employing the jig apparatus of the present invention, to be suitably configured to receive whatever form of beam-end component is being attached to the end of a beam.

What will be very evident from the description of the structure of the invention which has been presented so far (with respect to Figs. 4 and 5) is that articulation structure 30, with motion therein and thereby permitted about the relevant articulation axes which have just been described, is fully capable of angulating a received and gripped beam-end component relative to the long axis of a beam to which it is to be welded, to any angular condition within the range of angles mentioned herein, suitable for preparing the associated end of a beam to be attached to a column in a manner which will accurately accommodate any one or combination of the offsets earlier described herein.

Included in tail-stock structure 28b are a tail-stock frame 60 which is like previously mentioned head-stock frame 32, and articulation structure 62 which is essentially duplicative of just-described articulation structure 36. Frame 60 is mounted on a platform 63 which is anchored to jig-structure frame 26 adjacent frame end 26b. Articulation structure 62 includes a rotator, a rocker, and a gripper (not specifically pictured in Figs. 4 and 5) which are like previously described rotator 38, rocker 40, and gripper 42, respectively. The articulation components in articulation structure 62 essentially face those same like components in articulation structure 36, with the rotator in structure 62 being designed also to rotate on jig-rotation axis 44. Within articulation structure 62, there are included rocker- and rocker-rotation axes which are counterparts to axes 46, 52, respectively, described in relation to articulation structure 36.

Yoke structure 28c, a particular, representational rendering of which is seen in Figs. 10 and 11 (not yet discussed) is provided generally centrally between head-stock structure 28a and tail-stock structure 28b for releasably clamping, via yoke-provided clamping structure, onto the length mid-region of a beam 20 supported in jig structure 24. The yoke structure may be adapted to be shiftable in position, as desired, along frame 26 between structure 28a, 28b, and is equipped with a beam-receiving, slave-rotor plate which can rotate on axis 44 during rotation of a beam about its long axis in the context of weld-attaching of a pair of beam-end components to that beam.

Finally with regard to structure which is pictured in Fig. 4, indicated generally at W_1 and W_2 , suitably attached to, or near, head-stock frame 32 and tail-stock frame 60, respectively, are two, conventional, computer-controllable, multi-axis robotic welders which are to be employed, in the preferred practice of the present invention, to perform computer-controlled welding of beam-end components 22 to the ends of I-beams, such as I-beam 20.

As was mentioned earlier herein, shown poised above jig structure 24 in Fig. 4 is a beam 20 which has been readied for lowering and seating into jig structure 24 for the purpose of adjusting, and then weld-attaching, two beam-end components 22 to the opposite ends of the beam. The condition of beam 20, as such is shown schematically in Fig. 4, is that its opposite ends are square-cut in accordance with one of the two earlier-mentioned approaches typically to be followed in terms of preparing a beam and a pair of end components for weld attachment.

Accordingly, the two, illustrated (in Fig. 4) beam-end components 22 are seated in square-fitted conditions, temporarily in place adjacent the opposite ends of beam 20, and are held there by appropriately configured tension spring-clip devices 64 which have only been shown symbolically in Fig. 4. The intention of these spring-

clip devices, is to provide a way, initially, to support a beam-end component in a “nominally” correct condition against the end of a beam, with that beam-end component pressed against the beam, but permitted to be adjusted against spring-biasing resistance, as will shortly be explained, preparatory to performing a beam-end-component-to-beam welding operation. The specific design of such a spring-clip device is well within the skill level of those generally skilled in the art, and will depend, of course, upon the specific nature of a beam-end component which is involved. The spring-clip component, will, with proper design, be one which is easily detachable when it is no longer needed, and which will in no way interfere with lowering and seating of a beam with its temporarily attached beam-end components, as seen in Fig. 4, into the gripper structures in the articulation structures in jig structure 24.

Specifically with respect to relative motion between a beam-end component and a beam which is permitted by spring-clip structures 64, these spring-clip structures accommodate a modest amount of axial translation of a beam-end component relative to its associated beam-end, as is generally indicated by reverse-direction arrows 66, 68, and also permit angulation of associated beam-end components freely about two, orthogonally disposed axes, such as axes 70, 72 shown adjacent the left side of Fig. 4, and axes 74, 76 shown adjacent the right side of Fig. 4.

Axes 70, 74, extend normally into the plane of Fig. 4. Axes 72, 76, are vertical axes which are orthogonal with respect to axes 70, 74, respectively, and lie within the plane of Fig. 4. It will be understood that axes 70, 72, 74, 76, pictured adjacent opposite ends of beam 20 in Fig. 4, and with respect to a frame of reference which involves the long axis $20a$ of beam 20, are orthogonal in each case to axis $20a$. It is about axes 70, 72, 74, 76 that manipulation and operation of the articulation

structures in jig structure 24 make adjustments in beam-end components to dispose them properly for weld attachment to the opposite ends of a beam 20.

While it will become apparent to those skilled in the art that there are many ways to employ jig structure 24 specifically in a set of procedural steps to accommodate beam-end-component welding, one preferred manner of implementing these steps will now be described.

With a beam poised, as illustrated in Fig. 4, for "insertion" into the gripper structures in jig structure 24, and describing the approach involving beginning with beam-ends square-cut, articulation structures 38, 62, are adjusted so as to enable the gripper structures therein to receive by gravity-lowering, and to allow the seating of, the opposite-end beam-end components as a beam 20 is lowered into place in the jig structure. When beam-seating has taken place in the gripper structures, appropriate releasable anchoring of the spring-clip-attached beam-end components in the gripper structures is performed. As will be seen representatively in relation to other drawing figures herein still to be described, regarding the particular design of beam-end components 22 which are pictured in those other drawings, threaded bolts are employed to accomplish such anchoring.

Lowering of beam 20, as just generally described, causes the central portion of the beam, and in most instances the exact longitudinal center of the beam, to settle into previously described yoke structure 28c. Eventually, and as will shortly be explained, the central portion of a beam received in yoke structure 28c will be releasably clamped therein for beam-central stabilization in the yoke structure during a welding operation. Just where along frame 26 this yoke structure is located will depend, to some extent, upon the manner in which it is expected that the long axis of a received beam 20 will be disposed in space relative to rotator axis 44.

Fig. 6 in the drawings illustrates non-exclusively at (a), (b), (c) and (d) four, different, representative spatial relationships which may exist between these two axes, such a relationship ultimately depending upon what kinds of angular adjustments need to be implemented between a beam's long axis and end components 22. Illustration
5 (a) represents a situation wherein a beam's long axis and axis 44 exactly coincide with one another. This is a condition which will regularly occur if no angular adjustment is required between the nominal plane of a beam-end component and the long axis of a beam. Illustration (b) shows a situation in which a beam's long axis 20_a and rotator axis 44 are spaced from, but parallel to, one another. Illustration (c) represent a
10 spatial orientation of these two axes wherein they intersect one another substantially centrally between the positions of the head-stock and the tail-stock, which positions are represented in Fig. 6 by two, laterally spaced, vertically disposed lines. Illustration (d) represents a situation which is similar to that shown in illustration (c), except that the point of intersection of the two mentioned axes is displaced to one side
15 of the central point between the head-stock and the tail-stock.

Once a beam with its spring-clip-attached end components has been settled into jig structure 24, the articulation structures in the head-stock and the tail-stock structures are maneuvered, such as manually maneuvered, to angulate the nominal planes of the associated beam-end components so as to deal with a particular, pre-
20 known type of building-frame offset which is to exist between a pair of next-adjacent columns. The spring-clips allow such adjustments to be made under spring tension, while, at all times, continuing to stabilize the beam-end components in appropriate contact adjacency with the opposite ends of a beam 20.

When proper angulation has been accomplished, tack welds are applied at appropriate locations between the beam ends and the now-angulated, beam-end components so as to enable removal of the spring-clips from further use.

When angulation as just described has taken place, at this point in time, the
5 location in the region of yoke structure 28c through which beam axis 20a passes is established, and the yoke-included clamping structure, mentioned above, is adjusted so as to clamp onto the faces and edges in the flanges in the relevant beam, thus to stabilize the longitudinal central region of the beam during the about-to-be-performed, full-welding operation.

10 When all of these steps have been performed, the drive motor which is provided for rotating rotator 38 in head-stock structure 36, is operated to place the beam and its associated beam-end components in, successively, four, different, orthogonally-related, temporarily-fixed dispositions, wherein the major, to-be-welded edge-lines of contact (or near contact because of angulation) in existence between the
15 beam-end components and the beam ends will lie in horizontal planes appropriate to accommodate full welding.

In each of these four orthogonal positions, welding takes place, preferably under computer control operating the two robotic welders which have been shown in the drawing figures described so far herein at W_1 and W_2 . When welds have been
20 produced in all four of the mentioned orthogonal rotated conditions for a beam, that beam, and its now fully weld-attached beam-end components is essentially finished and is appropriately removed from jig structure 24.

Proper angular adjustment of the beam-end components relative to a supported beam, and proper orthogonal fixed-positioning of a beam and associated beam-end
25 components about rotator axis 44 as just mentioned, is stabilized through appropriate

affixing hardware which is operable, effectively, to lock the angulation-structure components, and rotator 38, in their respective, adjusted-to conditions. The details of this positional locking structure do not form any part of the present invention, and accordingly are not specifically illustrated and described herein, though they are
5 illustrated appropriately in Figs. 7-11, inclusive.

As was mentioned earlier herein, Figs. 7-11, inclusive, are representational drawings illustrating one very specific way in which jig structure 24 has been constructed to handle beam-end components and nodal connections like those described in the above-referred-to, copending U.S. Patent Application. In these
10 several figures, in addition to additional labeling of several further-discussed components which are particularly labeled only in these figures, components, and other drawing-illustration elements, which appear, and which are directly related to what has been shown already schematically in Figs. 4 and 5, are similarly labeled.

Fig. 7 provides a perspective illustration essentially of the same organization
15 of components which is shown schematically in Fig. 4. Yoke structure 28c can be seen to include a yoke 78, and rotatably supported in yoke 78, a generally circular slave rotor plate 80 which includes a deep and wide, nearly full-diametral, central slot 80a which is specifically adapted to receive the longitudinal central portion of a beam
20 (not shown in Fig. 7). Two crossbars, which are shown at 82, 84 in Fig. 7, span the width of slot 80a, are adjustable, selectively and independently, vertically in Fig. 7 within slot 80a, and carry, as will shortly be seen in two other drawing figures, screw-adjustable clamping instrumentalities which form the previously mentioned yoke clamping structure, and which are employed to clamp against the faces and lateral edges of the two flanges present in a yoke-received I-beam 20. The two other
25 drawing figures which more specifically show details of construction of the particular

form of yoke structure 28c which is pictured herein are Figs. 10 and 11. More will be said about these two figures very shortly.

Fig. 8 provides an axial view along rotator axis 44 looking essentially at that face of articulation structure 36 which faces the end of a beam 20 placed in jig structure 24 for handling. In solid lines in this figure, rocker 40 and gripper 42 are shown in what may be thought of as being “nominally unrotated” dispositions, with elongate gripper structures 50 -- female bearing-surface elements which are provided to receive the male bearing-surface portions in the particular type of beam-end component 20 specifically shown in Figs 1-3, inclusive -- disposed substantially vertical in conditions ready to receive, by gravity lowering, a beam end component 22 of the type temporarily spring-clipped to the end of a beam 20 in preparation for ultimate angular adjustment and welding to the beam end.

In dash-dot lines in Fig. 8, gripper structure 42 is shown rotated slightly clockwise relative to its solid-outline position in Fig. 8.

In dash-double-dot lines in Fig. 8, rocker structure 40 is shown rotated slightly counterclockwise relative to its solid-outline position in Fig. 8.

With respect to the disposition of components specifically illustrated in Fig. 8, the rocker structure and the gripper structure are pictured essentially in the same solid-outline positions shown for these structures in the schematic, side-view illustration provided in Fig. 5. Under these circumstances, rocker-rotation axis 52 is coincident with rotator axis 44.

Fig. 9 is essentially a cross-sectional view taken generally along the line 9-9 in Fig. 8. Here, too, the various components in articulation structure 36 are labeled in the same fashion as they are in schematic Fig. 5.

In solid lines in Fig. 9, the rotator, the rocker and the gripper in articulation structure 36 are shown in precisely the same solid-outline positions in which they are pictured in Fig. 5. Under these circumstances, rotator axis 44 and rocker-rotation axis 52 are coincident, and this is indicated by a shared dash-dot line which appears at the right side of Fig. 9. In dash-double-dot lines, the rocker structure -- carrying gripper 42 -- is shown in a slightly counterclockwise-rocked condition about axis 46. Dash-double-dot lines are also companionly employed here to illustrate the "following and connected" rotation of attached gripper 42.

One will note that the rocker structure includes a pair of components, each labeled by a curved arrow extending from reference numeral 45 in Fig. 9, and it will be obvious to those skilled in the art that the two, illustrated, basic rocker components which rock relative to one another in the rocker structure, as attached to the right-hand side of rotator 38, are formed with slightly angulated upper and lower shoulders as seen in Fig. 9, which shoulders provide ultimate rocking range limits for the rocker structure. As was mentioned earlier, the rocking-range permitted rocker 40 is about $\pm 8^\circ$. Manually adjustable screws, such as those shown generally at 86 in Fig. 9, may be adjusted to set the rocker angle, and to affix that angle for a particular welding operation through tightening of bolts 86 against the right-hand face of rotator 38 in Fig. 9.

Turning attention finally to Figs. 10 and 11, here, and as was mentioned earlier, certain details of a specific yoke structure 28c are made evident. In particular, a beam 20 is shown in a condition received within slave rotor plate slot 80a, with crossbars 82, 84 which carry a plurality of screw-adjustable, quite evident clamping devices, locking an illustrated beam 20 in a condition with its central flange substantially lying in a plane paralleling the long axis of slot 80a, and with beam axis

20a, as illustrated especially in Fig. 10, shown in coincident alignment with rotator axis 44.

In Fig. 10, a slight clockwise rotation of plate 80 is shown in dash-double-dot lines to reflect rotation which occurs when, during a welding operation, motor-driven rotator 38 turns on axis 44.

There has now thus been described a unique, articulated jig structure which may be employed to aid in the weld-attachment of beam-end components in different, specially angulated conditions, to opposite ends of an I-beam, all for the purposes stated above herein. Adjustments to produce angular dispositions required to deal with vertical and/or horizontal frame-column and beam offsets as described, are performed in structure 24 manually, although it is entirely possible, and those skilled in the art will recognize this, that these adjustments may in fact be computer-controlled adjustments, performed by the influence of appropriately computer-driven motor structures which are engaged with the moveable components in the articulation structures. The adjustments which are possible within the angular adjustment range of $\pm 8^\circ$ described herein for representational purposes, are infinite in nature within that range. Accordingly, essentially any offset condition which will require an angular adjustment within the stated range, may be made readily utilizing jig structure 24.

As has been stated several times heretofore, it should be understood that a jig structure having all of the features of jig structure 24 may be constructed to accommodate various different kinds of elongate beams, and various kinds of beam-end, column-interface components. Accordingly, the specific details which relate to these particular nodal connection hardware pieces, as illustrated in Figs. 7-11, inclusive, are only presented herein for the purpose of illustrating one very specific

way in which jig structure 24 has been constructed to deal with a certain style of building frame hardware.

Accordingly, while a preferred and best-mode embodiment of the invention, and manner of utilizing that embodiment, have been illustrated and described herein,
5 and certain variations and modifications suggested, it is appreciated that other variations and modifications may be made without departing from the spirit of the invention.

I CLAIM:

1. A jig-aided method for producing predetermined-location welds between, and joining, an end in an elongate beam having a long axis and a beam-end column-interface component which possesses a nominal plane, and doing so in a
5 manner which accommodates, within a predetermined range, an infinite number of different, relative, angular, spatial dispositions between the long axis of such a beam and the nominal plane of such a component, said method comprising

employing articulated, plural-axis jig structure, establishing a selected, angular, spatial disposition between such a beam long axis and such a beam-end
10 component nominal plane through implementing, in the jig structure, positional adjustments, as required, between the associated beam and component effectively about a pair of orthogonally related axes, each of which orthogonally intersects the beam's long axis, and

following said establishing, and under computer control, spatially
15 maneuvering and operating a robotic welder adjacent the beam and the beam-end component, and in relation to the mentioned, adjustment-established beam-end and beam-end-component spatial disposition, to create joining welds in the mentioned predetermined locations.

2. The method of claim 1, wherein said implementing is performed, as required, in a combination of steps including (a) simultaneously and commonly rotating the beam-end component and the beam about a rocker-rotation axis which is
5 normal to the component's nominal plane, and generally, though not necessarily precisely, aligned with the beam's long axis, and (b) independently rocking the beam-end component about a rocker axis which orthogonally intersects the rocker-rotation axis.

10 3. The method of claim 2 which further comprises disposing the rocker axis in a condition (a) spaced from the opposite side of the nominal plane of the beam-end component relative to the beam, and (b) generally parallel to that plane.

4. The method of claim 3, wherein said spatial maneuvering is performed
15 in relation to staged rotation of the beam and beam-end component to plural rest orientations about a rotator axis which (a) orthogonally intersects the rocker axis, and (b) intersects the rocker-rotation axis at the point where the rocker-rotation axis intersects the rocker axis.

5. A jig-aided method for producing predetermined-location welds joining, to each of the opposite ends in an elongate beam having a long axis, a beam-end column-interface component which possesses a nominal plane, and performing

5 said joining in a manner accommodating, within a predetermined range, an infinite number of different, relative, angular, spatial dispositions between the long axis of such a beam and the nominal planes associated with such components, said method, with respect to each beam end and each beam-end column-interface component, comprising

10 employing articulated, plural-axis jig structure, establishing a selected, angular, spatial disposition between such a beam long axis and such a component nominal plane through implementing, in the jig structure, positional adjustments, as required, between the associated beam and beam-end component effectively about a pair of orthogonally related axes, each of which orthogonally intersects the beam's

15 long axis, and

following said establishing, and under computer control, spatially maneuvering and operating a robotic welder adjacent the beam and the beam-end component, and in relation to the mentioned, adjustment-established beam-end and beam-end-component spatial disposition, to create joining welds in the mentioned

20 predetermined locations.

6. Jig structure for assisting with the securing, as by manual, or computer-controlled robotic, welding, of a beam-end column-interface component which possesses a nominal plane to the end of an elongate beam having a long axis,

5 said jig structure comprising:

- an elongate frame having opposite ends; and
- beam-support structure carried on said frame adjacent one of the frame's ends for supporting a beam in a condition with the beam's long axis disposed generally in a horizontal condition, said beam-support structure accommodating both lateral
- 10 translation and angulation of a supported beam as evidenced by spatial repositioning of its long axis, and longitudinal rotation of such a beam generally about its long axis, said beam-support structure including
 - a rotator constructed for enabled, reversible, preferably 360° rotation relative to the frame about a generally horizontal rotator axis,
 - 15 a rocker pivoted on said rotator for limited-angle, reversible, relative-motion, angular rocking about a rocker axis which orthogonally intersects said rotator axis, and
 - a beam-end-component gripper mounted on said rocker for enabled, reversible, preferably 360° rotation about a rocker-rotation axis which orthogonally
 - 20 intersects said rocker axis at the point where the latter intersects said rotator axis, said gripper being configured to receive and grip such a beam-end column-interface component in contact juxtaposition relative to the end of a beam supported by said beam-support structure, said rocker-rotation axis being disposed generally normal to the nominal plane of a gripper-gripped, beam-end component.

7. The jig structure of claim 6, which is designed for use with a beam-end column-interface component intended to be connected via a full-moment nodal connection to the side of an elongate column, wherein said gripper is adapted to position such a gripped beam-end column-interface component at a location in the jig structure relative to said rocker axis which will effectively replicate the location of that component relative to the long axis of a column to which the component will ultimately be connected in such a full-moment nodal connection.

8. The jig structure of claim 6, wherein said beam-support structure further includes, adjacent the other end of said frame, a rotator, a rocker, and a gripper such as those set forth in claim 6.

9. The jig structure of claim 6, wherein said rotator, rocker and gripper are carried on a common, moveable sled which is selectively position-adjustable on and along at least a portion of the length of said frame.

10. The jig structure of claim 6 which further comprises a computer-controllable, articulated, plural-axis, robotic welder effectively carried on said frame adjacent said rotator, functional to weld a beam-end column-interface component to the end of a beam supported by said beam-support structure.

11. The jig structure of claim 10, wherein said rotator, rocker, gripper and welder are carried on a common, moveable sled which is selectively position-adjustable on and along at least a portion of the length of said frame.

12. Computer-assisted, robotic-weld jig structure for attaching, in infinite, angularly differentiated dispositions, beam-end column-interface components to the opposite ends of appropriately supported, elongate beams, said jig structure, for each end of such a beam, comprising

- 5 a rotator rotatably defining an elongate, common, jig-rotation axis,
a rocker pivoted on said rotator for rocking about a rocker axis which orthogonally intersects said jig-rotation axis,
a beam-end column-interface-component gripper mounted on said rocker for rotation about a rocker-rotation axis which orthogonally intersects said rocker axis at
10 the point where the latter intersects said jig-rotation axis, and
a computer-controllable, articulated, plural-axis robotic welder disposed operationally adjacent said rotator.

13. An adjustable, beam-offset jig structure for assisting in welding a pair
15 of beam-end, column-interface components to the opposite ends of an elongate beam, said structure including spaced, adjustable head-stock and tail-stock structures, each capable of holding such a component adjacent a beam end for adjustment to an infinite number of different, pre-weld angular-offset dispositions relative to such a beam end.

20

14. An adjustable, beam-offset jig structure for assisting in robotically welding a pair of beam-end, column-interface components to the opposite ends of an elongate beam, said structure including spaced, adjustable head-stock and tail-stock structures, each capable of holding such a component adjacent a beam end for
5 adjustment to an infinite number of different, pre-weld angular-offset dispositions relative to such a beam end.

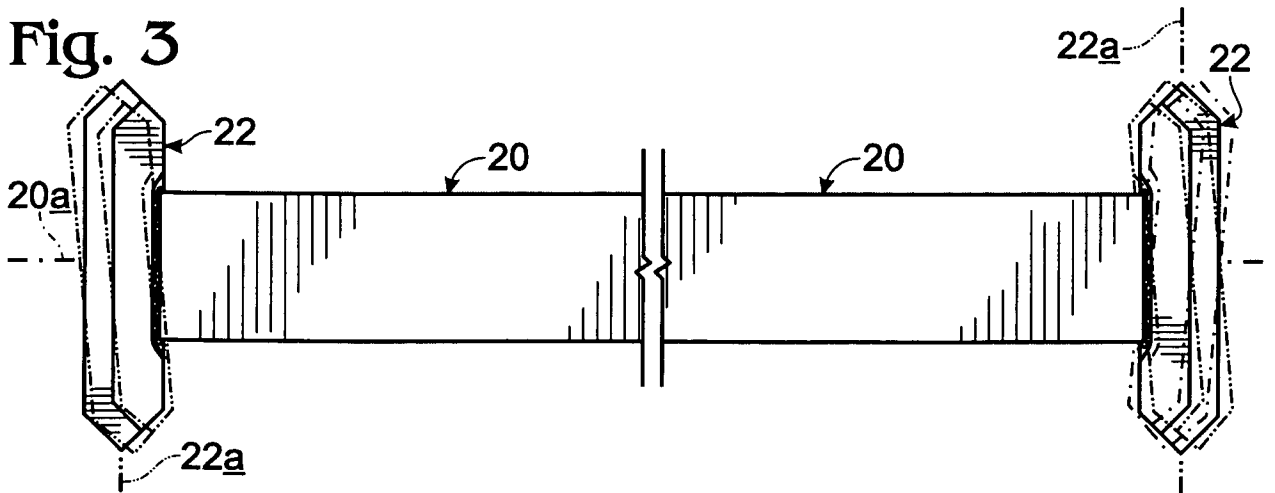
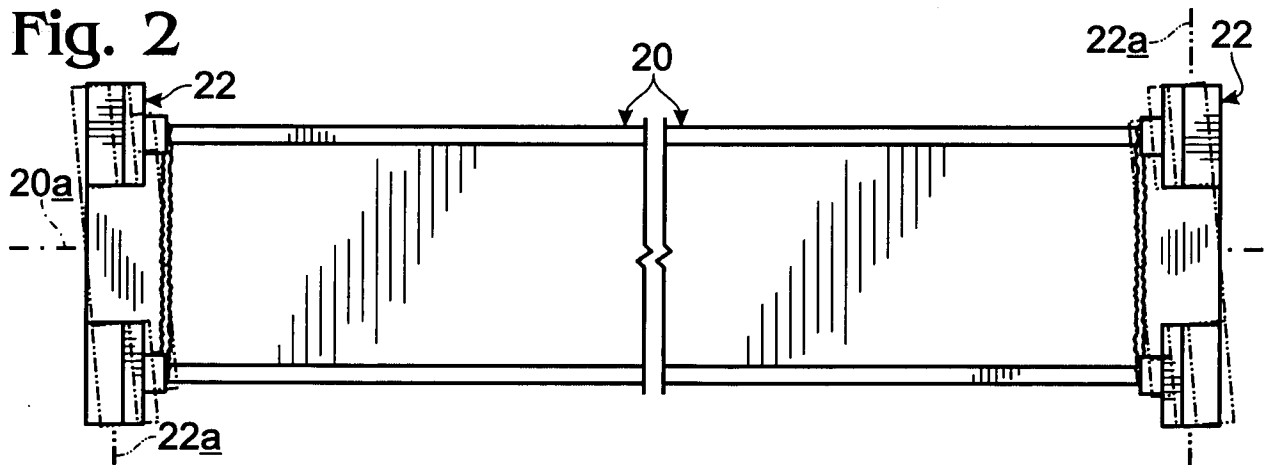
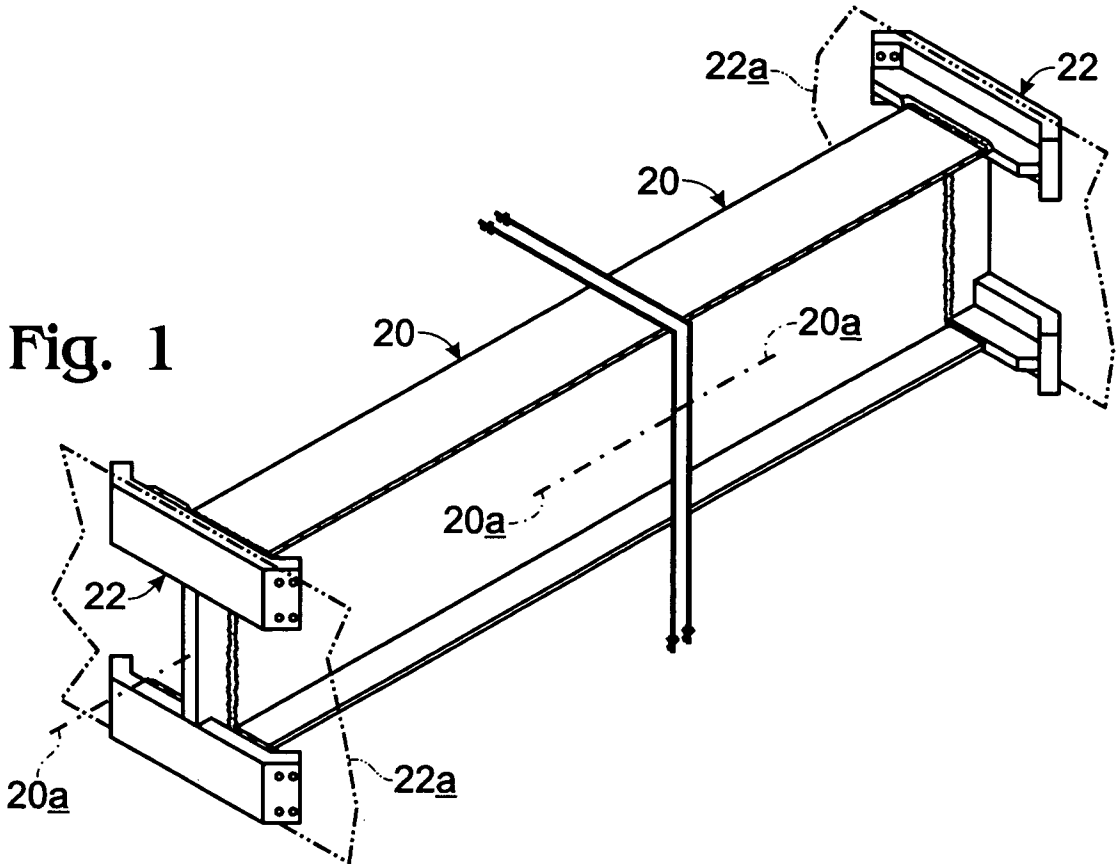


Fig. 4

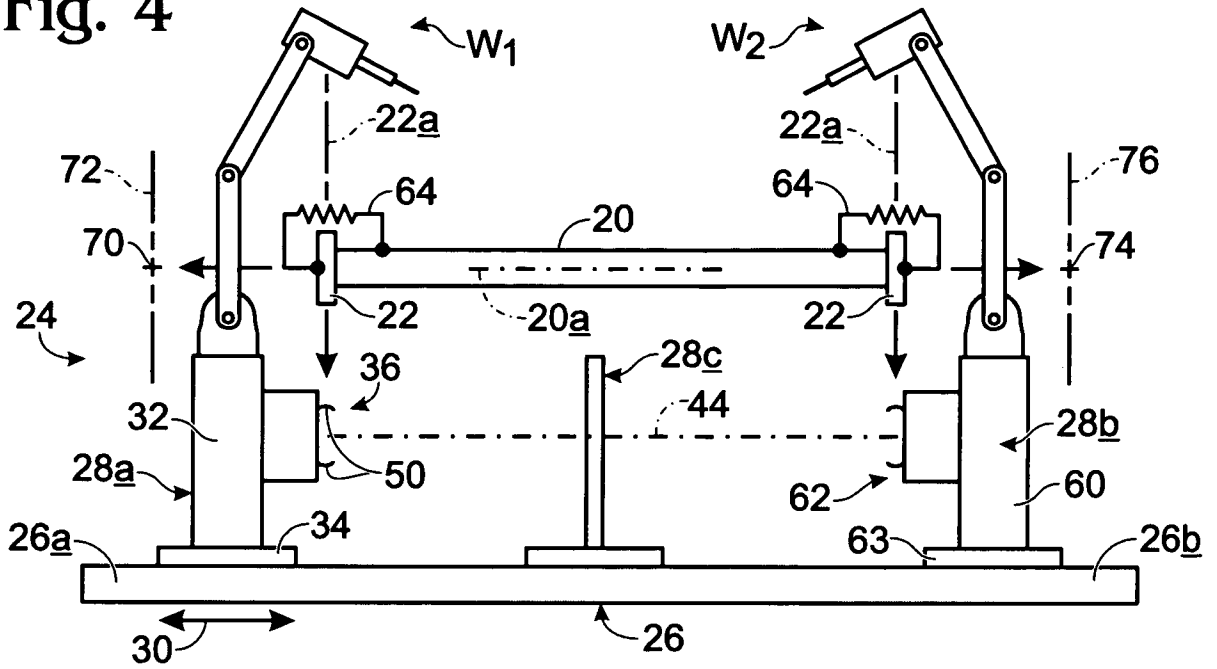


Fig. 5

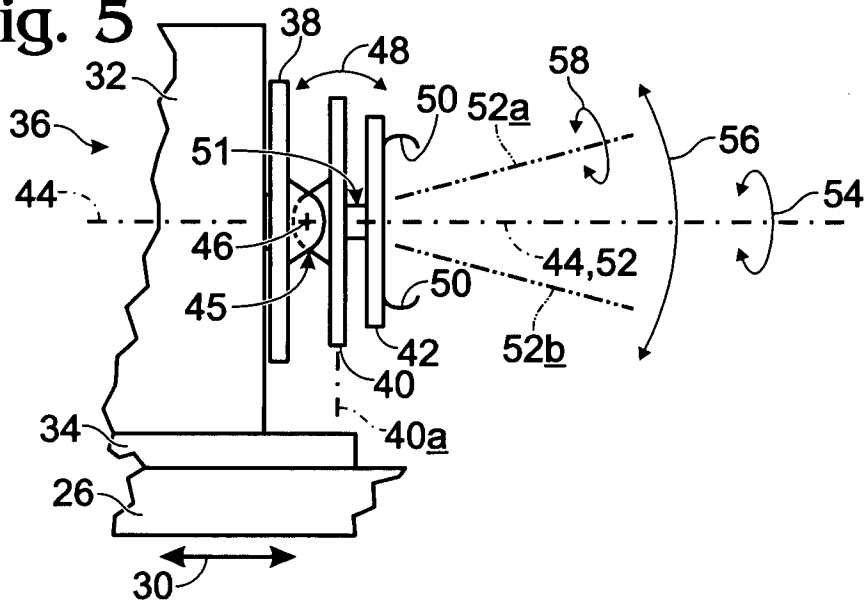
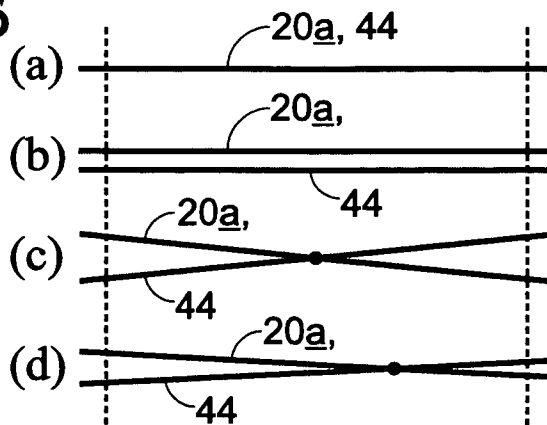


Fig. 6



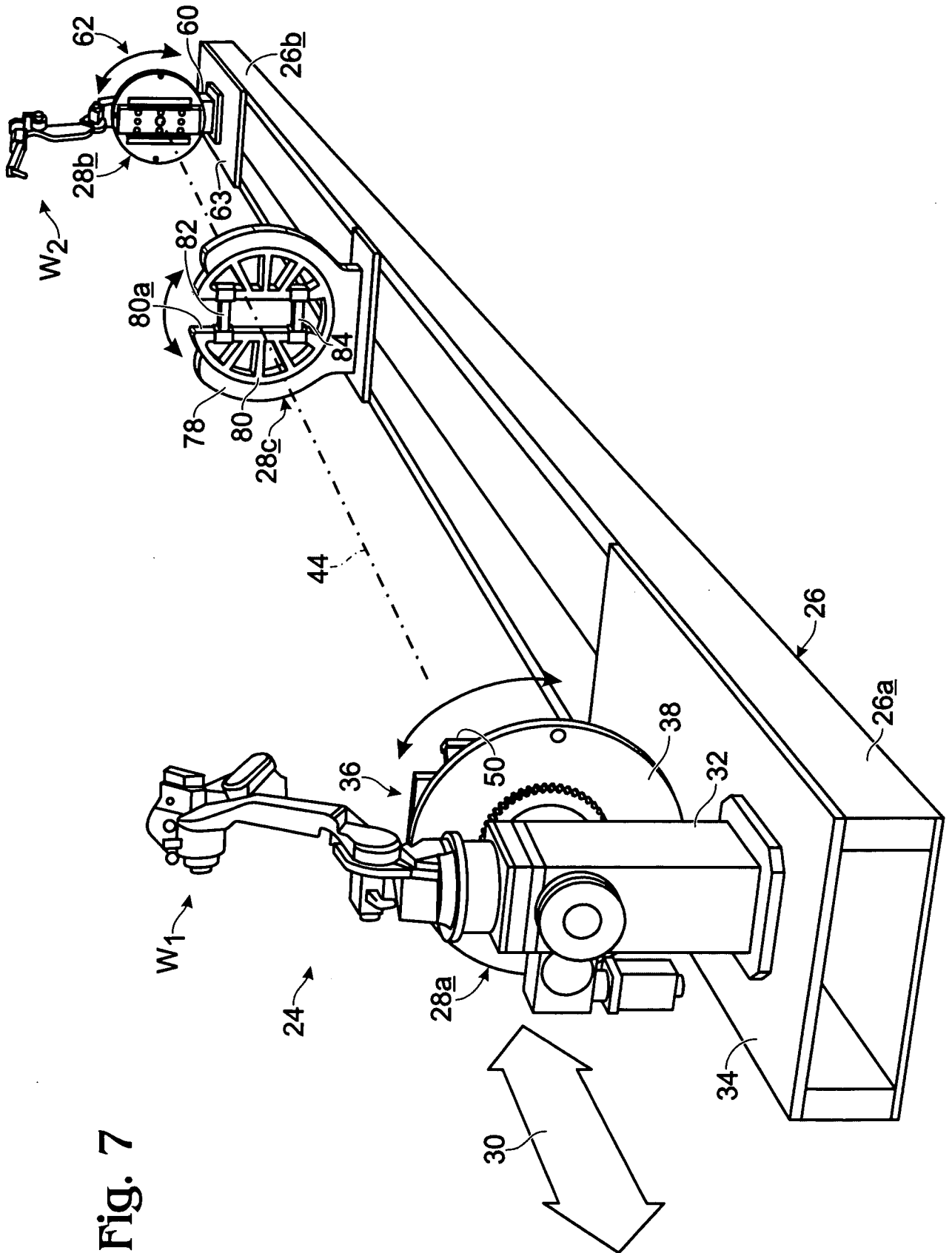


Fig. 7

Fig. 8

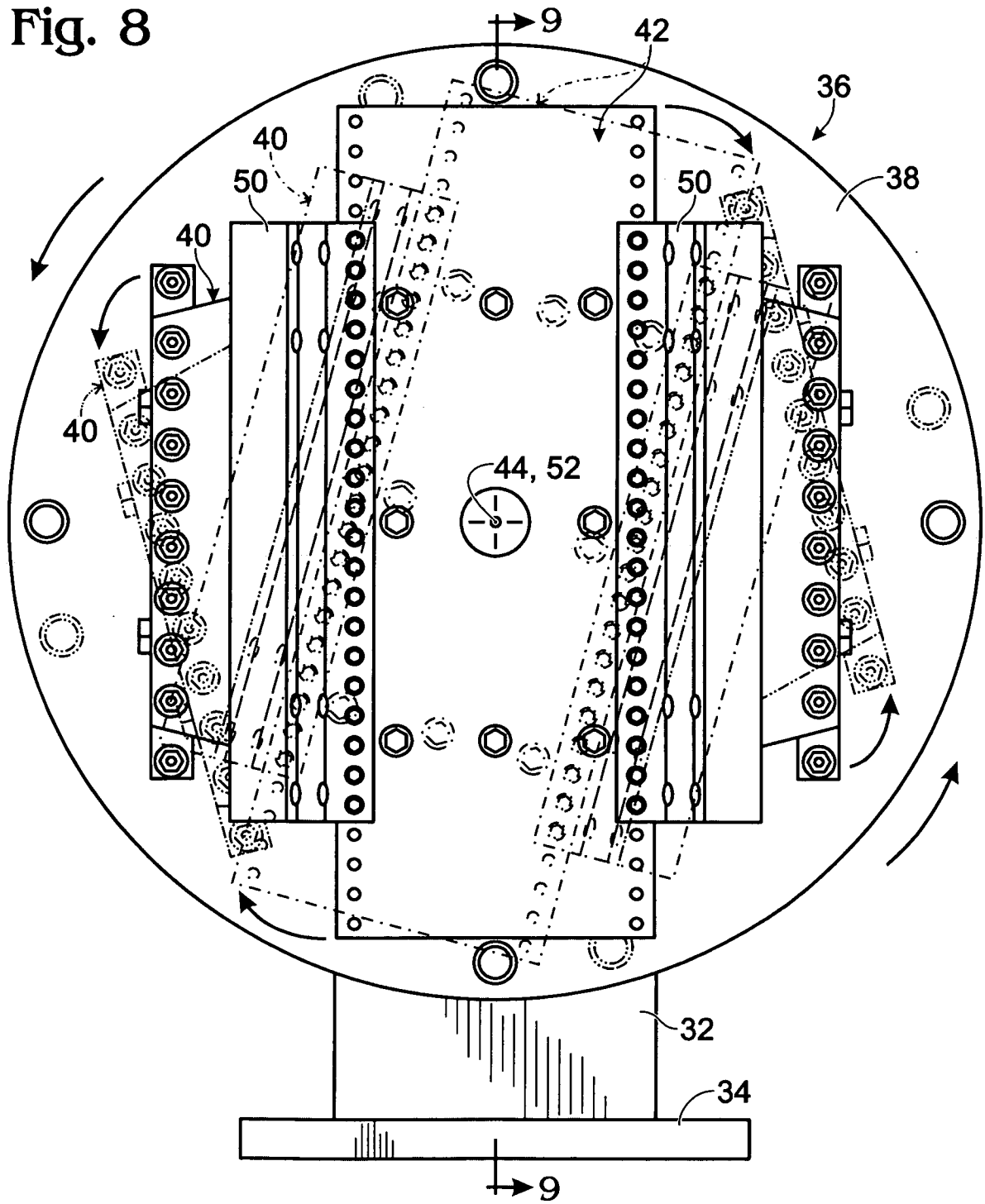


Fig. 9

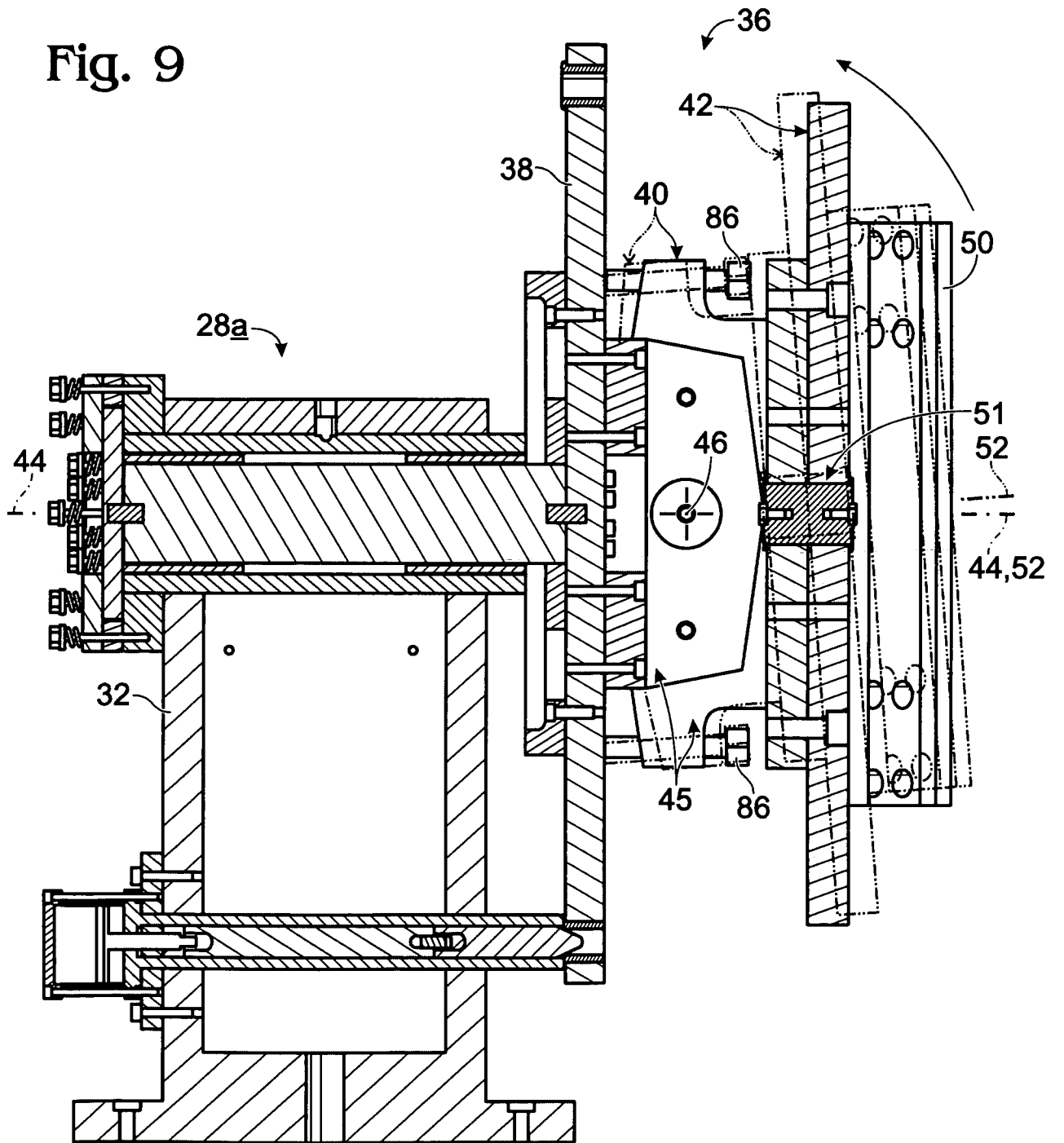


Fig. 10

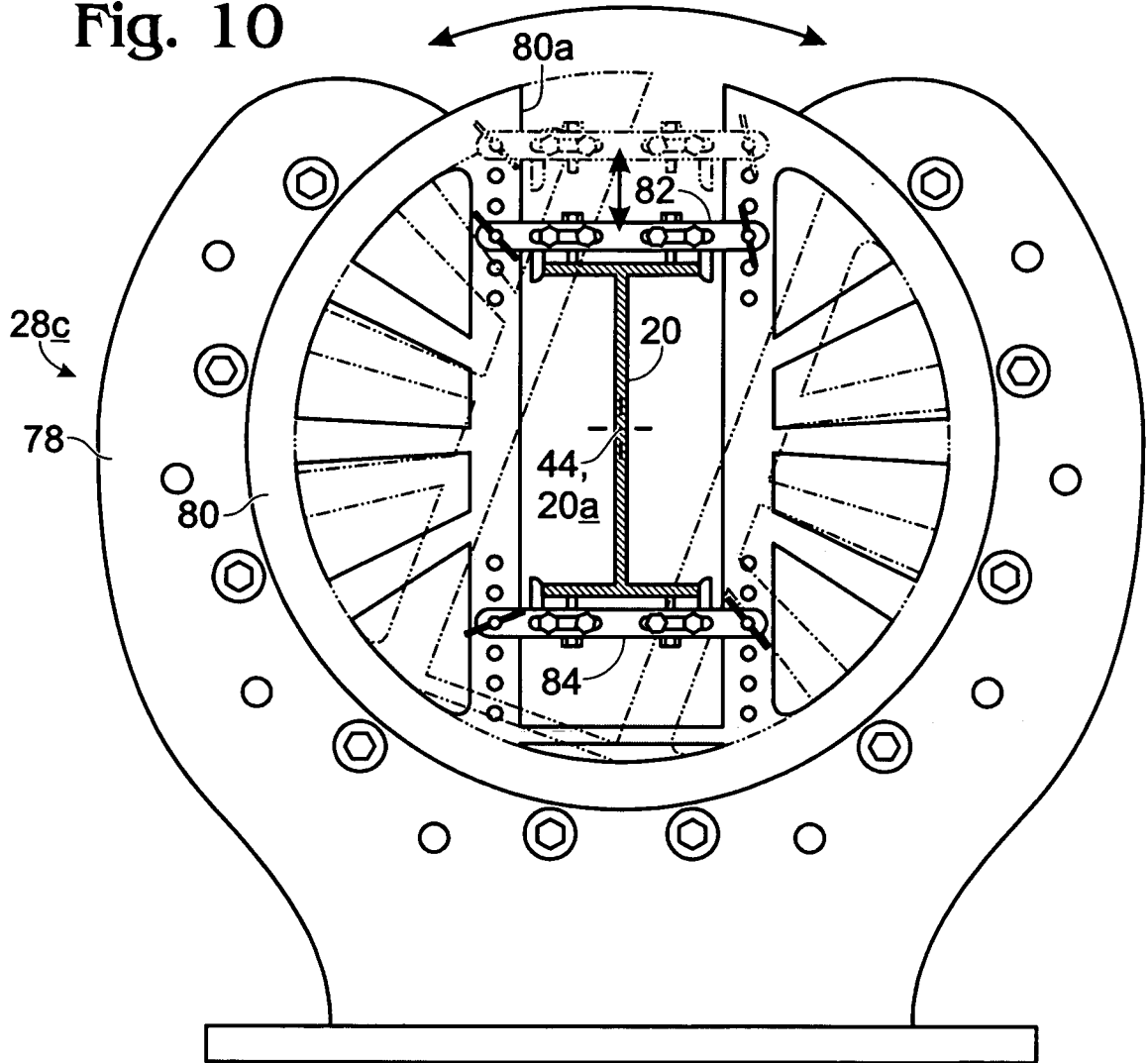
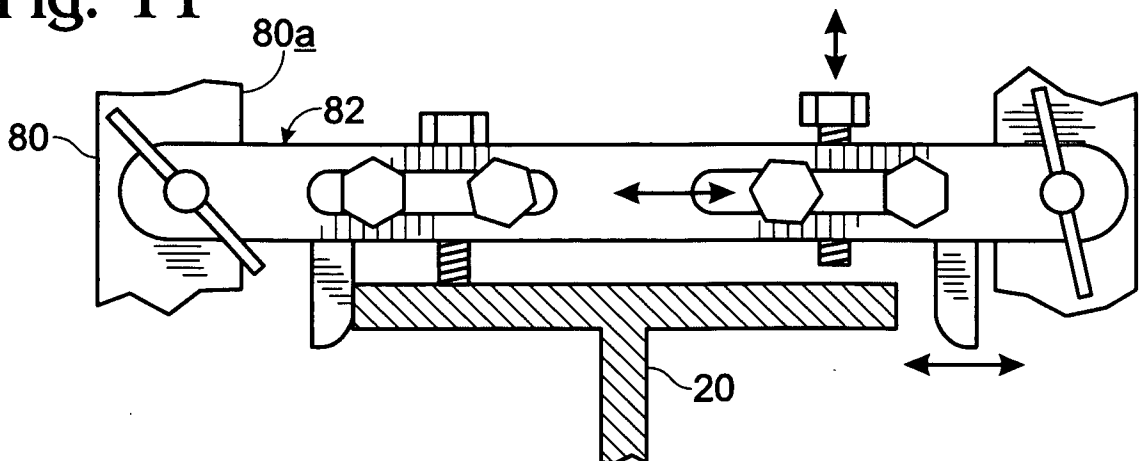


Fig. 11



INTERNATIONAL SEARCH REPORT

International application No.

PCT/US2008/006892

A. CLASSIFICATION OF SUBJECT MATTER

IPC(8) - E04B 5/10 (2008.04)
USPC - 52/633

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

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC(8) - E04B 5/10 (2008.04)
USPC - 52/633

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

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

USPTO WEST System (US, USPG-PUB, EPO, DERWENT), MicroPatent, IP.com, Google Patents

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 2005/0055954 A1 (SIMMONS) 17 March 2005 (17.03.2005) entire document	1-14
Y	US 3,291,321 A (HAMILTON) 13 December 1966 (13.12.1966) entire document	1-14
A	US 3,877,129 A (DOBSON et al) 15 April 1975 (15.04.1975) entire document	1-14

Further documents are listed in the continuation of Box C.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"E" earlier application or patent but published on or after the international filing date	"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
"O" document referring to an oral disclosure, use, exhibition or other means	"&" document member of the same patent family
"P" document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search 17 September 2008	Date of mailing of the international search report 24 SEP 2008
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Name and mailing address of the ISA/US Mail Stop PCT, Attn: ISA/US, Commissioner for Patents P.O. Box 1450, Alexandria, Virginia 22313-1450 Facsimile No. 571-273-3201	Authorized officer: Blaine R. Copenheaver PCT Helpdesk: 571-272-4300 PCT OSP: 571-272-7774
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