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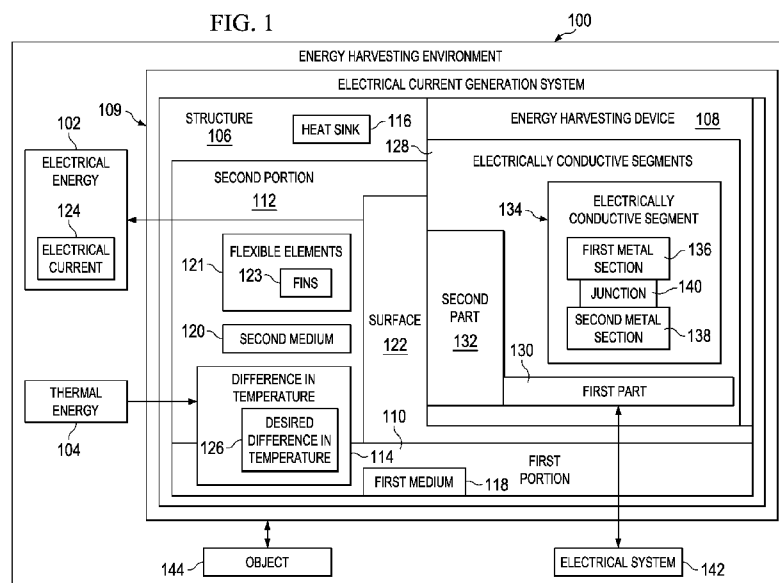
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(54) Title: THERMOELECTRIC ENERGY HARVESTING SYSTEM



(57) Abstract: An apparatus comprising a structure and an energy harvesting device. The structure is configured to have a first portion and a second. The energy harvesting device is formed as part of the structure. The energy harvesting device is configured to generate an electrical current when a difference in temperature occurs between the first portion and the second portion.



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THERMOELECTRIC ENERGY HARVESTING SYSTEM**BACKGROUND INFORMATION****Field**

[0001] The present disclosure relates generally to energy and, in particular, to energy harvesting devices. Still more particularly, the present disclosure relates to a method and apparatus for generating electrical energy from thermal energy using thermoelectric energy harvesting devices.

Background

[0002] Electrical devices are often used in different platforms to perform various functions. For example, sensors, lighting elements, routers, switches, and/or other types of devices may be present on an aircraft. These devices use electrical power to function. Wires are typically used to connect these devices to power sources. Additionally, batteries also may be used with these types of devices.

[0003] The use of wiring is often undesirable. Wiring increases the cost to design, install, maintain, and upgrade devices. When a device uses a battery, the battery has a size selected to sufficiently power the device for some desired period of time. Further, these batteries may need replacement and/or recharging periodically. Further, the cost and maintenance for batteries may be greater than desired.

[0004] One solution involves using energy harvesting devices. Energy harvesting devices are hardware devices that generate energy from a source external to the hardware devices. For example, these external sources may be solar power, thermal energy, wind energy, salinity

gradients, kinetic energy, and/or other suitable types of sources. Energy harvesting devices use these sources and generate electrical energy for use by other devices. For example, energy harvesting devices may be used to generate energy for electrical devices.

[0005] One example of an energy harvesting device is a solar cell. Solar cells convert light into electrical energy. These devices generate electrical energy in the form of an electrical current that may be stored in a battery for later use or may be used directly by another device. When batteries are used for storage, these batteries may be smaller than when the electrical devices rely on a battery as the only source of power.

[0006] Other types of energy harvesting devices include thermoelectric energy harvesting devices. These types of devices use temperature gradients to generate electrical energy. As another example, vibrational energy may be converted by cantilevered piezoelectric beams into electrical currents.

[0007] These types of devices are particularly useful with electronic devices that may need batteries or wired connections to electrical power sources. Energy harvesting devices, however, may still take up more space and add more complexity or cost than desired.

[0008] Therefore, it would be advantageous to have a method and apparatus that takes into account at least some of the issues discussed above, as well as possibly other issues.

SUMMARY

[0009] In one advantageous embodiment, an apparatus comprises a structure and an energy harvesting device. The structure is configured to have a first portion and a second portion. The energy harvesting device is formed as part of the structure. The energy harvesting device is configured to generate an electrical current when a difference in temperature occurs between the first portion and the second portion.

[0010] In one embodiment an apparatus may include a structure having a first portion and a second portion and an energy harvesting device formed as part of the structure, wherein the energy harvesting device is configured to generate an electrical current when a difference in temperature occurs between the first portion and the second portion. The one aspect the apparatus may further include a first part of the energy harvesting device is formed in the first portion of the structure and a second part of the energy harvesting device is formed in the second portion of the structure. In another aspect the energy harvesting device may further include electrically conductive segments formed as part of the structure, wherein a first part of the electrically conductive segments are formed as part of the first portion of the structure and a second part of the electrically conductive segments are formed as part of the second portion of the structure in which the difference in temperature is sufficient to cause the electrically conductive segments to generate the electrical current and wherein an electrically conductive segment in the electrically conductive segments comprises a first metal section and a second metal section in which

a first metal in the first metal section is different from a second metal in the second metal section and a junction at which the first metal section is associated with the second metal section. In another aspect the apparatus may further include elements formed on the structure, wherein the elements increase heat transfer from the first portion of the structure to the second portion of the structure and wherein the elements comprise at least one of flexible elements and rigid elements. In another aspect the apparatus may further include an object, wherein the object is configured to cause the difference in temperature between the first portion and the second portion of the structure and wherein the structure is associated with the object. In another aspect the object may be electrically conductive and the structure is comprised of a dielectric material configured to electrically insulate electrically conductive segments from the structure. In another aspect the apparatus may further include an electrical device electrically connected to the electrically conductive segments, wherein the electrically conductive segments supply the electrical current to the electrical device. In another aspect the electrical device may be selected from one of a sensor, a camera, a capacitor, a thermometer, a switch, a fan, a pump, a battery, a radio device, and a wireless access port. In another aspect the structure may further be comprised of an electrically conductive material and wherein a dielectric material is deposited onto the structure in a number of areas between locations for the electrically conductive segments before the electrically conductive segments are formed as part of the structure. In another aspect the electrically conductive segments may be in a location selected from one of on a surface of the structure and inside an

interior of the structure. In another aspect the electrically conductive segments may be formed by at least one of spraying the first metal onto a surface of the structure, spraying the second metal onto the surface of the structure, chemical vapor deposition, electron beam epitaxy, molecular beam epitaxy, printing the first metal onto the surface of the structure, printing the second metal onto the surface of the structure, sintering a powdered form of the first metal onto the surface of the structure, and sintering a powdered form of the second metal onto the surface of the structure.

[0011] In another advantageous embodiment an electrical current generation system may include a structure configured to conduct heat in a manner that generates a temperature gradient between a first portion of the structure and a second portion of the structure and a number of thermopiles formed as part of the structure, wherein the number of thermopiles generates an electrical current when a desired temperature gradient is present between the first portion and the second portion. In one aspect the electrical current generation system may further include a first part of the number of thermopiles is formed as part of the first portion of the structure and a second part of the number of thermopiles is formed as part of the second portion of the structure. In another aspect the thermopiles may further include electrically conductive segments formed on a surface of the structure, wherein a first part of the electrically conductive segments are formed as part of the first portion of the structure and a second part of the electrically conductive segments are formed as part of the second portion of the structure in which the desired temperature gradient is sufficient to cause the electrically conductive segments to generate the

electrical current and wherein an electrically conductive segment in the electrically conductive segments comprises a first metal section and a second metal section in which a first metal in the first metal section is different from a second metal in the second metal section and the first metal section is associated with the second metal section.

[0012] In yet another advantageous embodiment a method for manufacturing an electrical current generation system, the method may include forming a structure having a first portion and a second portion and forming an energy harvesting device as part of the structure, wherein the energy harvesting device is configured to generate an electrical current when a difference in temperature is present between the first portion and the second portion. In one aspect the step of forming the energy harvesting device as part of the structure may further include depositing a number of materials in a location on the structure to form the energy harvesting device, wherein the number of materials is deposited by at least one of spraying the number of materials, chemical vapor deposition, electron beam epitaxy, molecular beam epitaxy, and sintering a powdered form of the number of materials and wherein the location is selected from one of on a surface of the structure and in an interior of the structure. In another aspect the method of generating an electrical current may further include attaching an energy harvesting device to an object, the energy harvesting device being formed on a structure having a first portion and a second portion, receiving an electrical current from the energy harvesting device and powering an electrical system using the electrical current received from the energy harvesting device. In another aspect the method may

further include attaching an energy harvesting device is an exhaust manifold for an engine. In another aspect the electrical system may further include a sensor device that operates using the electrical current received from the energy harvesting device. In another aspect the method may further include the first portion has a higher temperature than the second portion and wherein the structure is configured to transfer thermal energy from the first portion to the second portion.

[0013] The features, functions, and advantages can be achieved independently in various embodiments of the present disclosure or may be combined in yet other embodiments in which further details can be seen with reference to the following description and drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

[0014] The novel features believed characteristic of the advantageous embodiments are set forth in the appended claims. The advantageous embodiments, however, as well as a preferred mode of use, further objectives, and advantages thereof, will best be understood by reference to the following detailed description of an advantageous embodiment of the present disclosure when read in conjunction with the accompanying drawings, wherein:

[0015] **Figure 1** is an illustration of a block diagram of an energy harvesting environment in accordance with an advantageous embodiment;

[0016] **Figure 2** is an illustration of a structure in accordance with an advantageous embodiment;

[0017] **Figure 3** is an illustration of a perspective view of a structure with an energy harvesting device

formed on the structure in accordance with an advantageous embodiment;

[0018] **Figure 4** is an illustration of a side view of a structure with an energy harvesting device formed on the structure in accordance with an advantageous embodiment;

[0019] **Figure 5** is an illustration of a different configuration for a structure in accordance with an advantageous embodiment;

[0020] **Figure 6** is an illustration of a structure having metal bands attached to an object in accordance with an advantageous embodiment;

[0021] **Figure 7** is an illustration of a structure having additional lines in accordance with an advantageous embodiment;

[0022] **Figure 8** is an illustration of a structure bent along lines and attached to an object in accordance with an advantageous embodiment;

[0023] **Figure 9** is an illustration of a structure associated with an object in accordance with an advantageous embodiment;

[0024] **Figure 10** is an illustration of an object with thermally conductive material sprayed over an object and supports on the object in accordance with an advantageous embodiment;

[0025] **Figure 11** is an illustration of an object with springs extending from the object in accordance with an advantageous embodiment;

[0026] **Figure 12** is an illustration of a side view of springs extending from an object in accordance with an advantageous embodiment;

[0027] **Figure 13** is an illustration of a side view of springs extending from an object and in contact with the object in accordance with an advantageous embodiment;

[0028] **Figure 14** is an illustration of a cross-sectional exposed view of the fuselage of an aircraft in accordance with an advantageous embodiment;

[0029] **Figure 15** is an illustration of an enlarged cross-sectional view of a section of an aircraft in accordance with an advantageous embodiment;

[0030] **Figure 16** is an illustration of a flowchart of a process for manufacturing an electrical current generation system in accordance with an advantageous embodiment; and

[0031] **Figure 17** is an illustration of a flowchart of a process for generating an electrical current in accordance with an advantageous embodiment.

DETAILED DESCRIPTION

[0032] The different advantageous embodiments recognize and take into account a number of different considerations. For example, the different advantageous embodiments recognize and take into account that energy harvesting devices that generate electrical energy from thermal energy may be especially useful in platforms that have thermal gradients. In other words, a platform in which one location has a higher temperature than another location may provide a temperature difference that is large enough for an energy harvesting device to generate electrical current from the difference in temperature.

[0033] The different advantageous embodiments recognize and take into account that energy harvesting devices using thermopiles may be used to generate electrical current from these temperature differences. An energy harvesting device may have one or more thermopiles. A thermopile is an electronic device that converts thermal energy into electrical energy. A

thermopile is often composed of several thermocouples that are usually connected in series, in parallel, or a combination of the two. A thermopile generates an output voltage that is related to the temperature of the thermopile.

[0034] These types of energy harvesting devices may be used to generate electrical current when they are placed near or in contact with structures in a platform, such as a hot pipe, an engine exhaust, or some other suitable heat source. The energy harvesting device may have one portion connected to the heat source and another portion exposed to a cooler environment.

[0035] The different advantageous embodiments recognize and take into account that thermopiles used in electrical harvesting devices are currently separate components that may be attached to a heat source. For example, energy harvesting devices that generate electrical current from a heat source using a thermopile are typically in a plate or wafer form. The thermopiles in the electrical energy harvesting device are typically placed between ceramic plates. These ceramic plates are typically planar and are connected to components, such as a pipe, exhaust tube, or other heat source.

[0036] The different advantageous embodiments recognize and take into account that an energy harvesting device that uses thermopiles is typically formed by placing the thermopiles between ceramic plates in a ceramic housing. The ceramic plates with the thermopiles are then connected to a heat source with a portion of the energy harvesting device being exposed to an environment with a cooler temperature than the heat source.

[0037] The different advantageous embodiments also recognize and take into account that these types of energy harvesting devices also may take up more room than

desired. The thermopiles are typically formed so that they extend from one plate to another plate lengthwise. In other words, the thermopiles do not lay flat and extend from one edge to another edge of a ceramic plate.

[0038] The different advantageous embodiments also recognize and take into account that in some cases, the size of the ceramic plates may result in inadequate generation of electrical currents if insufficient contact to the heat source occurs. For example, with a pipe or exhaust tube, the surface of these structures may be curved. As a result, the ceramic plate for the thermoelectric energy harvesting device, which may be flat and not curved, may not have as much contact as desired with the pipe. One solution may be to employ smaller plate sizes so that the desired amount of contact occurs.

[0039] Further, the different advantageous embodiments recognize and take into account that another solution may use geometric adapter plates to conduct heat from a curved surface of a structure to the flat surface of the ceramic plates. In these cases, when geometric adapter plates are used, a thermal interface material may be used to provide sufficient contact. This thermal interface material may be needed in more areas than desired to provide the sufficient contact.

[0040] For example, the thermal interface material may be needed in areas, such as, for example, between the curved surface of the structure and a geometric adapter plate, between the geometric adapter plate and a first ceramic plate, between a second ceramic plate and a heat sink, and/or in other suitable areas. The thermal interface material may be, for example, a thermal grease, a thermal epoxy, a thermal pad, or some other suitable type of material.

[0041] The different advantageous embodiments recognize and take into account that these solutions, however, may increase the complexity, time, and effort needed to assemble and install devices needed to generate electrical energy from thermal energy. These types of solutions may require using or manufacturing energy harvesting devices with many different sizes and/or additional components to accommodate different curvatures of different heat sources.

[0042] Thus, the different advantageous embodiments provide an apparatus for generating an electrical current using thermal energy. In one advantageous embodiment, an apparatus comprises a structure configured to generate heat and an energy harvesting device formed as part of the structure. The heat generated by the structure is generated in a first portion of the structure. A second portion of the structure is cooler than the first portion of the structure when the heat is generated. The energy harvesting device is configured to generate an electrical current when a sufficient temperature difference is present between the first portion of the structure and the second portion of the structure.

[0043] With reference now to **Figure 1**, an illustration of a block diagram of an energy harvesting environment is depicted in accordance with an advantageous embodiment. Energy harvesting environment **100** is an example of one type of environment in which the different advantageous embodiments may be implemented to generate electrical energy **102** using thermal energy **104**.

[0044] In these illustrative examples, electrical energy **102** is generated from thermal energy **104** using structure **106** and energy harvesting device **108** in energy harvesting environment **100**. Structure **106** has first portion **110** and second portion **112** in these examples.

[0045] Structure **106** may be any type of structure in which difference in temperature **114** may be generated. For example, second portion **112** may be configured to be cooler than first portion **110** such that difference in temperature **114** is generated. Difference in temperature **114** may also be referred to as a temperature gradient. The temperature gradient is a gradual change in temperature.

[0046] In one illustrative example, structure **106** takes the form of heat sink **116**. Heat sink **116** may be any object configured to transfer thermal energy **104** from first medium **118** having a higher temperature to second medium **120** having a cooler temperature.

[0047] Typically, with a heat sink, such as heat sink **116**, first medium **118** having the higher temperature takes the form of a solid medium, while second medium **120** having the cooler temperature takes the form of a fluid medium. The solid medium may be, for example, a metal material, a metal alloy material, plastic, and/or some other suitable type of solid material. The fluid medium may be, for example, a liquid, air, or some other type of fluid.

[0048] Of course, in some cases, first medium **118** may take the form of a fluid medium having a higher temperature than second medium **120**. In still other illustrative examples, second medium **120** may take the form of a solid medium.

[0049] In these depicted examples, first medium **118** may be on or at a side of first portion **110** of heat sink **116**, around first portion **110**, and/or part of first portion **110**. Further, second medium **120** may be on or at a side of second portion **112** of heat sink **116**, around second portion **112**, and/or part of second portion **112**.

[0050] In one illustrative example, second portion 112 of heat sink 116 may comprise flexible elements 121. Flexible elements 121 may be in the form of fins 123. A fin is a surface that extends from an object to increase the rate of heat transfer to or from the environment by increasing convection. Further, fins 123 may be referred to as cooling fins when fins 123 are configured such that fins 123 have a cooler temperature than first portion 110 of heat sink 116. Fins 123 may include straight fins, pin fins, curved fins, angled fins, and/or other suitable types of fins.

[0051] As one illustrative example, difference in temperature 114 may be generated when a hot fluid flows near first portion 110 and a cold fluid is present around fins 123. In another illustrative example, difference in temperature 114 may be generated when first portion 110 generates heat and fins 123 are surrounded by cold air.

[0052] As illustrated, energy harvesting device 108 is formed as part of structure 106. Energy harvesting device 108 and structure 106 together form electrical current generation system 109.

[0053] In particular, in these depicted examples, energy harvesting device 108 is formed on surface 122 of structure 106 as part of structure 106. Surface 122 may be an outer surface, inner surface, or some other suitable type of surface of structure 106.

[0054] Surface 122 may have a shape that is substantially planar or curved prior to energy harvesting device 108 being formed on surface 122. In one illustrative example, surface 122 may be substantially planar prior to energy harvesting device 108 being formed on surface 122. In this illustrative example, once energy harvesting device 108 is formed, structure 106 may

be manipulated to change the shape of surface **122** to being curved.

[0055] As depicted in these examples, energy harvesting device **108** is configured to generate electrical energy **102** in the form of electrical current **124** when difference in temperature **114** between first portion **110** and second portion **112** of structure **106** is sufficient for generating electrical current **124**. In other words, when desired difference in temperature **126** is present between first portion **110** and second portion **112**, energy harvesting device **108** generates electrical current **124**.

[0056] In these illustrative examples, energy harvesting device **108** is formed on surface **122** of structure **106**. In particular, first part **130** of energy harvesting device **108** may be formed on surface **122** of first portion **110** of structure **106**, and second part **132** of energy harvesting device **108** may be formed on surface **122** of second portion **112** of structure **106**.

[0057] Further, in these depicted examples, energy harvesting device **108** may comprise electrically conductive segments **128**. Electrically conductive segment **134** is an example of one of electrically conductive segments **128**. Electrically conductive segment **134** may comprise first metal section **136** and second metal section **138**. A first metal in first metal section **136** may be different from a second metal in second metal section **138**. In other words, first metal section **136** and second metal section **138** are comprised of dissimilar metals.

[0058] In these illustrative examples, first metal section **136** and second metal section **138** may be formed as part of structure **106** on surface **122** using a number of various processes. These processes may include at least one of spraying a first metal and a second metal onto

surface **122** to form first metal section **136** and second metal section **138**, respectively, depositing the first metal and the second metal onto surface **122**, printing the first metal and the second metal onto surface **122**, sintering a powdered form of the first metal and the second metal onto surface **122**, chemical vapor deposition, electron beam epitaxy, molecular beam epitaxy, and/or some other suitable type of process.

[0059] As used herein, the phrase "at least one of", when used with a list of items, means that different combinations of one or more of the listed items may be used and only one of each item in the list may be needed. For example, "at least one of item A, item B, and item C" may include, for example, without limitation, item A, or item A and item B. This example also may include item A, item B, and item C, or item B and item C.

[0060] First metal section **136** and second metal section **138** may have junction **140** at which first metal section **136** and second metal section **138** are connected to each other and/or placed near each other. Of course, in some cases, a number of sections comprising various types of conductive material may be present between first metal section **136** and second metal section **138** at junction **140**. When the number of sections is present at junction **140**, the temperature at the connection between first metal section **136** and the number of sections and the temperature at the connection between second metal section **138** and the number of sections is substantially the same.

[0061] Junction **140** between first metal section **136** and second metal section **138** is configured such that the temperature of first metal section **136** and second metal section **138** changes along the length of these sections beginning at junction **140**. When electrically conductive

segment **134** is formed as part of structure **106**, this change in temperature may be caused by difference in temperature **114** generated between first portion **110** and second portion **112** of structure **106**.

[0062] Of course, in these illustrative examples, electrically conductive segment **134** may have one or more additional junctions at which electrically conductive segment **134** is connected to another electrically conductive segment in electrically conductive segments **128** and/or an electrical device.

[0063] When desired difference in temperature **126** is present between first portion **110** and second portion **112**, desired difference in temperature **126** is also present along first metal section **136** and second metal section **138**. A presence of desired difference in temperature **126** may cause electrically conductive segment **134** to generate electrical current **124**.

[0064] In these illustrative examples, electrically conductive segment **134** may take the form of a thermocouple. In this manner, when electrically conductive segments **128** take the form of a plurality of thermocouples, energy harvesting device **108** takes the form of a thermopile. As used herein, "a plurality of items" means two or more items. For example, "a plurality of thermocouples" means two or more thermocouples. The plurality of thermocouples may be connected to each other in parallel, in series, or in a combination of in parallel and in series.

[0065] As depicted, electrical system **142** may be electrically connected to electrically conductive segments **128**. As used herein, when a first component, such as electrical system **142**, is electrically connected to a second component, such as one or more of electrically conductive segments **128**, the first component

is connected to the second component such that an electrical signal can be sent from the first component to the second component, the second component to the first component, or a combination of the two. The first component may be electrically connected to the second component without any additional components between the two components. The first component also may be electrically connected to the second component by one or more other components.

[0066] For example, one electronic device may be electrically connected to a second electronic device without any additional electronic devices between the first electronic device and the second electronic device. In some cases, another electronic device may be present between the two electronic devices that are electrically connected to each other.

[0067] In these illustrative examples, electrical system **142** may be connected to at least one of electrically conductive segments **128**. Electrical system **142** may be one or more electrical devices. For example, an electrical device in electrical system **142** may take the form of, for example, without limitation, a sensor, a camera, a thermometer, a switch, a fan, a pump, a battery, a capacitor, a radio device, a wireless access port, and/or some other suitable type of electrical or electronic device.

[0068] Electrically conductive segments **128** may supply electrical current **124** to electrical system **142**. In this manner, electrical energy **102** in the form of electrical current **124** may be harvested by energy harvesting device **108** to supply power to electrical system **142**.

[0069] Additionally, in some illustrative examples, structure **106** may be associated with another structure, such as object **144**. In one illustrative example, object

144 may be configured to generate heat to heat first portion **110** of structure **106**. As another example, object **144** may be configured to transfer heat to first portion **110** of structure **106** such that first portion **110** has a higher temperature than second portion **112**.

[0070] Object **144** may be associated with structure **106**. For example, a portion of object **144** may be in contact with a portion of structure **106**. As another example, object **144** may be placed near or close to structure **106**.

[0071] In these illustrative examples, structure **106** and object **144** may take various forms. For example, structure **106** and/or object **144** may take the form of at least one of a pipe, a metal sheet, a tube, an exhaust tube, an engine exhaust, an engine intake, an exhaust manifold for an engine, a clamp, a band strap, a bulkhead, a beam, a floorboard, a floor beam, and/or some other suitable type of structure or object.

[0072] Further, structure **106** and/or object **144** may be associated with a platform. The platform may be selected from one of, for example, without limitation, a mobile platform, a stationary platform, a land-based structure, an aquatic-based structure, a space-based structure, an aircraft, a surface ship, a tank, a personnel carrier, a train, a spacecraft, a space station, a satellite, a submarine, an automobile, a power plant, a bridge, a dam, a manufacturing facility, a building, and/or some other suitable type of platform.

[0073] The illustration of energy harvesting environment **100** in **Figure 1** is not meant to imply physical or architectural limitations to the manner in which an advantageous embodiment may be implemented.

Other components in addition to and/or in place of the ones illustrated may be used. Some components may be

unnecessary. Also, the blocks are presented to illustrate some functional components. One or more of these blocks may be combined and/or divided into different blocks when implemented in an advantageous embodiment.

[0074] For example, in some illustrative examples, second portion **112** of heat sink **116** may comprise rigid elements instead of flexible elements **121**. These rigid elements may still be referred to as fins **123**, depending on the implementation.

[0075] In other illustrative examples, more than one of energy harvesting device **108** may be formed as part of structure **106**. For example, structure **106** may have additional portions in addition to first portion **110** and second portion **112**, which are configured to have difference in temperature **114**. Additional energy harvesting devices may be formed as part of structure **106** to generate electrical current **124** based on the temperature difference between these other portions of structure **106**.

[0076] Further, in still other examples, more than one object **144** may be configured to generate heat to heat first portion **110** of structure **106**. In some cases, more than one electrical device in electrical system **142** may be electrically connected to electrically conductive segments **128**.

[0077] With reference now to **Figures 2-15**, illustrations of an energy harvesting device formed as part of a structure are depicted in accordance with an advantageous embodiment. Various configurations and uses of a structure with an energy harvesting device formed as part of the structure are shown in **Figures 2-15**. The different components shown in these figures may be combined with components in **Figure 1**, used with

components in **Figure 1**, or a combination of the two. Additionally, some of the components in these figures may be illustrative examples of how components shown in block form in **Figure 1** can be implemented as physical structures.

[0078] Turning now to **Figure 2**, structure **200** is an example of one implementation for structure **106** in **Figure 1**. Energy harvesting device **201** is an example of one implementation for energy harvesting device **108** in **Figure 1**.

[0079] As depicted, structure **200** takes the form of metal sheet **202** in this example. Metal sheet **202** is substantially planar in this figure. Metal sheet **202** has side **203** and side **205**. Line **204** and line **206** indicate where metal sheet **202** may be bent when attaching structure **200** to another object.

[0080] In this illustrative example, metal sheet **202** has first portion **208** and second portion **210**. First portion **208** is the area of metal sheet **202** between line **204** and line **206**. Second portion **210** includes the areas of metal sheet **202** extending outward from line **204** and line **206**. In this illustrative example, second portion **210** is non-contiguous and comprises different areas of metal sheet **202**.

[0081] Further, second portion **210** includes fins **212**. Fins **212** are examples of one implementation for flexible elements **121** in **Figure 1**. In some cases, metal sheet **202** may be cut to form fins **212**.

[0082] As depicted, energy harvesting device **201** is formed as part of metal sheet **202**. In particular, energy harvesting device **201** is formed as part of metal sheet **202** on surface **214** of metal sheet **202**.

[0083] Energy harvesting device **201** takes the form of thermopile **215**. Thermopile **215** is formed on surface **214**

of metal sheet **202** such that first part **218** of thermopile **215** is formed on surface **214** of first portion **208** of metal sheet **202**, and second part **220** of thermopile **215** is formed on surface **214** of second portion **210** of metal sheet **202**.

[0084] Further, thermopile **215** comprises thermocouples **216**. In this illustrative example, thermopile **215** may be formed on surface **214** by printing thermocouples **216** onto surface **214** of structure **200**. Thermocouples **216** are connected in series in this illustrative example. As one specific example, thermocouple **224** and thermocouple **226** are connected in series on surface **214** of metal sheet **202**. As depicted, thermocouple **224** has first metal section **228** and second metal section **230** connected at junction **232**. Further, thermocouple **224** is connected to thermocouple **226** at junction **233**.

[0085] First metal section **228** is comprised of a different type of metal than the type of metal comprising second metal section **230** in this illustrative example. In other words, first metal section **228** and second metal section **230** are comprised of dissimilar metals with respect to each other.

[0086] Additionally, thermocouples **216** also include thermocouple **234**, which may be connected to an electrical device in electrical system **142** in **Figure 1**. For example, thermocouple **234** may be connected to a sensor device in electrical system **142** in **Figure 1**.

[0087] With reference now to **Figure 3**, an illustration of a perspective view of structure **200** with energy harvesting device **201** formed on structure **200** associated with an object is depicted in accordance with an advantageous embodiment. In this illustrative example, structure **200** from **Figure 2** is associated with object **300**. Object **300** is an example of one implementation for

object **144** in **Figure 1**. In particular, structure **200** is placed on object **300**. Object **300** takes the form of duct tube **302** in this depicted example.

[0088] As illustrated, duct tube **302** has curved surface **304**. Structure **200** has been manipulated to conform to curved surface **304**. In particular, metal sheet **202** has been bent along line **204** and line **206** such that first portion **208** of metal sheet **202** has a shape that conforms to curved surface **304** of duct tube **302**.

[0089] Further, the bending of metal sheet **202** along line **204** and line **206** causes second portion **210** of metal sheet **202** to extend away from curved surface **304** of duct tube **302** and away from first portion **208** of metal sheet **202**. In this manner, fins **212** extend away from first portion **208** of metal sheet **202**. Further, the bending of metal sheet **202** causes second part **220** of thermocouples **216** to extend away from first part **218** of thermocouples **216**.

[0090] In this illustrative example, hot fluid may flow through channel **306** of duct tube **302**. The hot fluid may be, for example, a warm or hot liquid or warm or hot air. The hot fluid may cause duct tube **302** to heat. This heat may, in turn, heat first portion **208** of metal sheet **202**. Further, second portion **210** may be surrounded by cold air in this illustrative example.

[0091] The heating of first portion **208** of metal sheet **202** causes first portion **208** to have a higher temperature than second portion **210** surrounded by cold air such that a difference in temperature is present between first portion **208** and second portion **210**. When this difference in temperature reaches a desired difference in temperature, thermocouples **216** are configured to generate an electrical current. Thermocouples **216** may supply the

electrical current to an electrical system such as, for example, a sensor device.

[0092] With reference now to **Figure 4**, an illustration of a view of structure **200** from side **203** with energy harvesting device **201** formed on structure **200** associated with object **300** is depicted in accordance with an advantageous embodiment. In this illustrative example, energy harvesting device **201** may not be seen in this view. As illustrated, hot fluid may flow through channel **306** in duct tube **302**.

[0093] Turning now to **Figure 5**, an illustration of a different configuration for structure **200** is depicted in accordance with an advantageous embodiment. In this illustrative example, structure **200** is in the form of metal sheet **202** and has a different configuration as compared to the configuration of structure **200** in **Figures 2-4**.

[0094] As illustrated, metal sheet **202** has metal bands **500**, **502**, **504**, and **506** formed from metal sheet **202**. Metal bands **500**, **502**, **504**, and **506** form third portion **508** of metal sheet **202**. Metal bands **500**, **502**, **504**, and **506** are bands configured to attach metal sheet **202** to an object, such as object **300** in **Figure 3**. In particular, these metal bands may be referred to as attachment bands that allow metal sheet **202** to wrap around the object to attach metal sheet **202** to the object.

[0095] With reference now to **Figure 6**, an illustration of structure **200** having metal bands **500**, **502**, **504**, and **506** attached to object **300** is depicted in accordance with an advantageous embodiment. In this illustrative example, metal bands **500**, **502**, **504**, and **506** are shown wrapped around object **300**. Metal bands **500**, **502**, **504**, and **506** attach metal sheet **202** to object **300**. As depicted, a component, such as component **600** may be

connected to thermocouples **216** at ends **602** of thermocouples **216**.

[0096] Referring now to **Figure 7**, an illustration of structure **200** with the configuration of structure **200** from **Figure 5** with additional lines is depicted in accordance with an advantageous embodiment. In this illustrative example, lines **702**, **704**, **706**, and **708** are present for metal sheet **202** in addition to line **204** and line **206**. Bending metal sheet **202** along lines **702**, **704**, **706**, and **708** may form sections **710**, **712**, **714**, **716**, and **718** from first portion **208** of metal sheet **202**.

[0097] Turning now to **Figure 8**, an illustration of structure **200** bent along lines **702**, **704**, **706**, and **708** from **Figure 7** and attached to object **300** is depicted in accordance with an advantageous embodiment. As depicted, this bending of metal sheet **202** forms sections **710**, **712**, **714**, **716**, and **718** such that section **714** has separation **800** from curved surface **304** of object **300** in the form of duct tube **302**. Separation **800** allows a component, such as component **802**, to be mounted to section **714** of metal sheet **202** to remain thermally isolated from duct tube **302**.

[0098] As illustrated, section **710** and section **718** of first portion **208** of metal sheet **202** are attached to curved surface **304** of duct tube **302**. This attachment allows heating of section **710** and section **718** when hot fluid passes through channel **306** of duct tube **302**.

[0099] The illustration of structure **200** in **Figures 2-8** is not meant to imply physical or architectural limitations to the manner in which an advantageous embodiment may be implemented. Other components in addition to and/or in place of the ones illustrated may be used. Some components may be unnecessary.

[00100] For example, in some illustrative examples, a number of thermopiles in addition to or in place of thermopile **215** may be associated with structure **200**. In other illustrative examples, structure **200** may not take the form of metal sheet **202**. Instead, structure **200** may be a sheet comprised of one or more materials in addition to and/or in place of metal.

[00101] For example, structure **200** may be comprised of materials comprising at least one of a metal, a metal alloy, a composite material, and/or any other suitable type of material that conducts heat with a desired level of thermal conductivity. A thermally conductive material is any material that conducts heat. These materials may include, for example, at least one of a composite material, a plastic comprising thermally conductive additives, a thermal paste, a metallic particle laced thermal paste, lithium, metal alloys, encapsulated liquids, carbon nanotube, formed ceramic, grapheme, diamond powder paste, and/or other suitable types of thermally conductive materials.

[00102] Further, in some cases, when structure **200** is comprised of an electrically conductive material, a substantially non-electrically conductive material may be deposited between portions of structure **200** and thermocouples **216**. For example, the substantially non-electrically conductive material may be deposited in a number of areas between locations for thermocouples **216**.

[00103] This substantially non-electrically conductive material may reduce and/or prevent the possibility of an electrical short circuit between thermocouples **216** through the electrically conductive surface of structure **200**. The substantially non-electrically conductive material may be, for example, without limitation, a

dielectric material, a ceramic, a spinel, and/or some other suitable type of material.

[00104] With reference now to **Figure 9**, an illustration of a structure associated with an object is depicted in accordance with an advantageous embodiment. In this illustrative example, structure **900** is an example of one implementation for structure **106** in **Figure 1**. As depicted, structure **900** takes the form of heat sink **902**.

[00105] In this illustrative example, heat sink **902** is a metallic object that has circular shape **904**. Circular shape **904** allows heat sink **902** to slide over pipe **906**. Pipe **906** is an example of one implementation for object **144** in **Figure 1**.

[00106] As depicted, heat sink **902** has first portion **908** and second portion **910**. Further, heat sink **902** has contact springs **912** connected to first portion **908**. Contact springs **912** contact curved surface **914** of pipe **906**. Second portion **910** has fins **913** connected to first portion **908** of heat sink **902**. Fins **913** are convection cooling fins in this illustrative example.

[00107] As depicted in this example, thermopile **916** is printed or deposited on surface **918** of heat sink **902**. Thermopile **916** has sets of thermocouples connected in series in this example. Set of thermocouples **920** is an example of one of the sets of thermocouples in thermopile **916**. The thermocouples in set of thermocouples **920** are connected in series.

[00108] As depicted, an object or component may be connected to thermopiles **916** at terminals **922** to receive electrical current generated by thermopiles **916**.

[00109] Turning now to **Figures 10-13**, illustrations for the forming and installation of contact springs on an object are depicted in accordance with an advantageous embodiment.

[00110] With reference now to **Figure 10**, an illustration of an object with thermally conductive material sprayed over an object and supports on the object is depicted in accordance with an advantageous embodiment. In this illustrative example, object **1000** may be a metallic object. Of course, object **1000** may be comprised of other thermally conductive materials, such as composite materials.

[00111] Supports **1002** are placed on surface **1004** of object **1000**. Supports **1002** provide a shape for forming thermally conductive strips using thermally conductive material. As depicted, thermally conductive material **1006** has been sprayed over supports **1002** and surface **1004** of object **1000** to form thermally conductive strips **1008**. Thermally conductive material **1006** may be, for example, a metallic material and/or some other suitable type of thermally conductive material. These strips are formed substantially perpendicular to supports **1002**. Further, as illustrated, supports **1002** are configured such that thermally conductive strips **1008** form curved shapes **1010**.

[00112] In other illustrative examples, thermally conductive material **1006** may be deposited over supports **1002** and surface **1004** of object **1000** in some other suitable manner. For example, thermally conductive material **1006** may be formed by printing or painting this material on surface **1004** and supports **1002** of object **1000**.

[00113] Thermally conductive material **1006** may be a material that adheres to surface **1004** of object **1000** in locations where the material is sprayed on surface **1004**. In some cases, a thermally conductive adhesive or some other type of mechanism may be used to adhere thermally conductive material **1006** to surface **1004** of object **1000**.

[00114] Turning now to **Figure 11**, an illustration of object **1000** with springs extending from object **1000** is depicted in accordance with an advantageous embodiment. In this illustrative example, supports **1002** have been removed. Supports **1002** may be removed by, for example, without limitation, chemically dissolving supports **1002**, physically removing supports **1002**, melting supports **1002**, chemically etching supports **1002**, and/or performing some other suitable type of removal operation.

[00115] With supports **1002** removed, thermally conductive strips **1008** form springs **1100**. Springs **1100** extend from surface **1004** of object **1000**. As depicted, more than one spring may be formed by each thermally conductive strip in thermally conductive strips **1008**.

[00116] With reference now to **Figure 12**, an illustration of a side view of springs **1100** extending from object **1000** is depicted in accordance with an advantageous embodiment. In this illustrative example, object **1000** has been moved into a position relative to object **1200**. As depicted, springs **1100** are not in contact with surface **1202** of object **1200**.

[00117] Turning now to **Figure 13**, an illustration of a side view of springs **1100** extending from object **1000** and in contact with object **1200** is depicted in accordance with an advantageous embodiment. As depicted in this example, object **1200** is placed over object **1000**. In this manner, when object **1000** and object **1200** are moved towards each other, surface **1202** of object **1200** contacts surface **1300** of springs **1100**. In other words, installation of object **1000** causes contact between surface **1202** of object **1200** and surface **1300** of springs **1100**. This contact causes springs **1100** to deform and/or bend as shown such that locations of thermal contact between object **1200** and object **1000** may be formed.

[00118] The illustration of the manufacturing of springs **1100** and their use in **Figures 10-13** are not meant to imply physical or architectural limitations to the manner in which an advantageous embodiment may be implemented. Other components in addition to and/or in place of the ones illustrated may be used. For example, springs **1100** may be formed having other types of shapes other than curved shapes **1010** depicted in **Figure 10**.

[00119] With reference now to **Figure 14**, an illustration of a cross-sectional exposed view of the fuselage of an aircraft is depicted in accordance with an advantageous embodiment. In this illustrative example, aircraft **1400** has fuselage **1402**. Further, aircraft **1400** also has floor beam **1404** that extends across fuselage **1402**. For example, floor beam **1404** intersects with fuselage **1402** at section **1405**.

[00120] A difference in temperature is present between side **1406** of fuselage **1402** and side **1408** of fuselage **1402**. For example, the temperature inside of side **1406** of fuselage **1402** may be higher than the temperature on the outside of side **1408** of fuselage **1402**. A skin (not shown) may be present on side **1408** of fuselage **1402** for aircraft **1400**.

[00121] For example, side **1406** may be exposed to a first temperature. In this illustrative example, this first temperature is a temperature of the air inside fuselage **1402** or, in other words, the air inside the cabin of aircraft **1400**. This first temperature may be about 20 degrees Celsius. Side **1408** of fuselage **1402** is exposed to a second temperature. This second temperature is a temperature of the air or environment around fuselage **1402** of aircraft **1400**. Side **1408** may be exposed to a second temperature that may be, for example, about negative 30 degrees Celsius.

[00122] In this manner, side **1406** is exposed to a first temperature that is higher than the second temperature to which side **1408** is exposed. Thus, the temperature may become cooler and cooler in a direction from side **1406** to side **1408**. This difference in temperature is a temperature gradient that may occur when aircraft **1400** is flying at high altitudes or is otherwise in use.

[00123] With reference now to **Figure 15**, an illustration of an enlarged cross-sectional view of a section of an aircraft is depicted in accordance with an advantageous embodiment. In this illustrative example, section **1405** from **Figure 15** is depicted in an enlarged view.

[00124] As illustrated, thermopile **1500** and thermopile **1502** have been formed as part of fuselage **1402** and floor beam **1404**. For example, thermopile **1500** is formed as part of fuselage **1402**. Thermopile **1500** may be deposited in an interior of fuselage **1402** during the manufacturing of fuselage **1402**. In this illustrative example, the interior of fuselage **1402** is an interior of frame **1504** forming fuselage **1402**. As one illustrative example, thermopile **1500** may be deposited on frame **1504** of fuselage **1402** before manufacturing of fuselage **1402** has been completed or as part of manufacturing fuselage **1402**.

[00125] Thermopile **1500** generates an electrical current in response to a temperature gradient caused by a difference in temperature between side **1406** and side **1408** of fuselage **1402**.

[00126] In this illustrative example, thermopile **1502** is formed as part of floor beam **1404** at or near an intersection of floor beam **1404** and frame **1504** of fuselage **1402**. For example, thermopile **1502** may be deposited on a surface of floor beam **1404** in this illustrative example. Thermopile **1502** generates an

electrical current in response to a temperature gradient caused by the difference in temperature between end **1506** of floor beam **1404** and portion **1508** of floor beam **1404**.

[00127] Portion **1508** of floor beam **1404** is exposed to a first temperature that is higher than a second temperature to which end **1506** of floor beam **1404** is exposed. In other words, the air in the cabin inside fuselage **1402** has a higher temperature than the air outside fuselage **1402**. This difference in temperature may be greater when aircraft **1400** is flying at high altitudes and/or in use in some other manner as compared to when aircraft **1400** is flying at low altitudes, on the ground, and/or not in use.

[00128] In other illustrative examples, thermopiles may be formed in other locations within aircraft **1400**. For example, thermopiles may be formed as part of an air vent, a wall, a door, a stringer, a rib, a bulkhead, an engine exhaust, an engine component, an engine mount, a floor truss, a fuel tank wall, a frame, and/or other suitable types of structures.

[00129] With reference now to **Figure 16**, an illustration of a flowchart of a process for manufacturing an electrical current generation system is depicted in accordance with an advantageous embodiment. The process illustrated in **Figure 16** may be implemented to form electrical current generation system **109** in **Figure 1**.

[00130] The process begins by forming a structure having a first portion and a second portion (operation **1600**). The second portion is configured to have a lower temperature than a temperature of the first portion. For example, the second portion of the structure may be exposed to a temperature that is lower than a temperature to which the first portion of the structure is exposed

when the first portion of the structure is attached to a platform, connected to an object configured to generate heat, attached to a platform while the platform is in use, and/or heated in some other suitable manner.

[00131] The process forms an energy harvesting device as part of the structure (operation **1602**), with the process terminating thereafter. The energy harvesting device is configured to generate an electrical current when a desired difference in temperature is present between the first portion and the second portion. Operation **1602** may be performed in a number of different ways.

[00132] For example, the energy harvesting device may comprise electrically conductive segments that are sprayed onto a surface of the structure, deposited onto a surface of the structure, printed onto a surface of the structure, chemically applied to an interior of the structure, and/or formed as part of the structure in some other suitable manner.

[00133] Further, depending on the implementation, operation **1602** may be performed during operation **1600**. For example, operation **1602** may be performed to form the energy harvesting device in an interior of the structure prior to the forming of the structure being completed. Once the energy harvesting device has been formed, operation **1600** may then be completed to form the completed structure.

[00134] With reference now to **Figure 17**, an illustration of a flowchart of a process for generating an electrical current is depicted in accordance with an advantageous embodiment. The process illustrated in **Figure 17** may be implemented using electrical current generation system **109** in **Figure 1**.

[00135] The process begins by attaching an energy harvesting device to an object (operation **1700**). The energy harvesting device is formed on a structure having a first portion and a second portion. The first portion of the structure has a higher temperature than the second portion. Further, the structure is configured to transfer thermal energy from the first portion to the second portion.

[00136] The process receives an electrical current from the energy harvesting device (operation **1702**). The electrical current is generated in response to the transfer of thermal energy from the first portion of the structure to the second portion of the structure. The process then powers an electrical system using the electrical current received from the energy harvesting device (operation **1704**), with the process terminating thereafter.

[00137] The electrical system may, for example, comprise a sensor device that is connected to the energy harvesting system and configured to operate using the electrical current received from the energy harvesting device.

[00138] The flowcharts and block diagrams in the different depicted embodiments illustrate the architecture, functionality, and operation of some possible implementations of apparatus and methods in an advantageous embodiment. In this regard, each block in the flowchart or block diagrams may represent a module, segment, function, and/or a portion of an operation or step. For example, one or more of the blocks may be implemented as program code, in hardware, or a combination of the program code and hardware. When implemented in hardware, the hardware may, for example, take the form of integrated circuits that are

manufactured or configured to perform one or more operations in the flowchart or block diagrams.

[00139] In some alternative implementations of an advantageous embodiment, the function or functions noted in the block may occur out of the order noted in the figures. For example, in some cases, two blocks shown in succession may be executed substantially concurrently, or the blocks may sometimes be executed in the reverse order, depending upon the functionality involved. Also, other blocks may be added in addition to the illustrated blocks in a flowchart or block diagram.

[00140] Thus, the different advantageous embodiments provide an apparatus comprising a structure. The structure is configured to have a first portion and a second portion in which the second portion has a lower temperature than a temperature of the first portion. The structure is configured to have an energy harvesting device formed as part of the structure. The energy harvesting device is configured to generate an electrical current when a desired difference in temperature is present between the first portion and the second portion.

[00141] In this manner, the different advantageous embodiments provide an energy harvesting device that is configured to span more widely-spaced temperature gradients as compared to currently used energy harvesting devices. Further, the different advantageous embodiments allow an energy harvesting device to be formed on both a first portion of a structure and a second portion of the structure that comprises cooling fins and has a lower temperature than the first portion.

[00142] The description of the different advantageous embodiments has been presented for purposes of illustration and description and is not intended to be exhaustive or limited to the embodiments in the form

disclosed. Many modifications and variations will be apparent to those of ordinary skill in the art. Further, different advantageous embodiments may provide different advantages as compared to other advantageous embodiments. The embodiment or embodiments selected are chosen and described in order to best explain the principles of the embodiments, the practical application, and to enable others of ordinary skill in the art to understand the disclosure for various embodiments with various modifications as are suited to the particular use contemplated.

CLAIMS:

What is claimed is:

1. An apparatus comprising:
a structure **106,200** having a first portion **110,208** and a second portion **112,210**; and
an energy harvesting device **108,201** formed as part of the structure **106,200**, wherein the energy harvesting device **108** is configured to generate an electrical current when a difference in temperature occurs between the first portion **110** and the second portion **112**.
2. The apparatus of claim 1, wherein a first part of the energy harvesting device is formed in the first portion of the structure and a second part of the energy harvesting device is formed in the second portion of the structure.
3. The apparatus of claim 1 or claim 2, wherein the energy harvesting device comprises:
electrically conductive segments formed as part of the structure, wherein a first part of the electrically conductive segments are formed as part of the first portion of the structure and a second part of the electrically conductive segments are formed as part of the second portion of the structure in which the difference in temperature is sufficient to cause the electrically conductive segments to generate the electrical current and wherein an electrically conductive segment in the electrically conductive segments comprises a first metal section and a second metal section in which a first metal in the first metal section is different

from a second metal in the second metal section and a junction at which the first metal section is associated with the second metal section.

4. The apparatus of any of the preceding claims further comprising:

elements formed on the structure, wherein the elements increase heat transfer from the first portion of the structure to the second portion of the structure and wherein the elements comprise at least one of flexible elements and rigid elements.

5. The apparatus of any of the preceding claims further comprising:

an object, wherein the object is configured to cause the difference in temperature between the first portion and the second portion of the structure and wherein the structure is associated with the object.

6. The apparatus of claim 3 further comprising:

an electrical device electrically connected to the electrically conductive segments, wherein the electrically conductive segments supply the electrical current to the electrical device.

7. The apparatus of claim 6, wherein the electrical device is selected from one of a sensor, a camera, a capacitor, a thermometer, a switch, a fan, a pump, a battery, a radio device, and a wireless access port.

8. The apparatus of claim 3, wherein the structure is comprised of an electrically conductive material and wherein a dielectric material is deposited onto the structure in a number of areas between locations for the

electrically conductive segments before the electrically conductive segments are formed as part of the structure.

9. The apparatus of claim 3, wherein the electrically conductive segments are in a location selected from one of on a surface of the structure and inside an interior of the structure.

10. The apparatus of claim 3, wherein the electrically conductive segments are formed by at least one of spraying the first metal onto a surface of the structure, spraying the second metal onto the surface of the structure, chemical vapor deposition, electron beam epitaxy, molecular beam epitaxy, printing the first metal onto the surface of the structure, printing the second metal onto the surface of the structure, sintering a powdered form of the first metal onto the surface of the structure, and sintering a powdered form of the second metal onto the surface of the structure.

11. A method of generating an electrical current comprising:

attaching an energy harvesting device **108,201** to an object **144**, the energy harvesting **108,201** device being formed on a structure **106,200** having a first portion **110, 208** and a second portion **112,210**;

receiving an electrical current from the energy harvesting device **108,201**; and

powering an electrical system **142** using the electrical current received from the energy harvesting device **108,201**.

12. The method of claim 11, wherein the object is an exhaust manifold for an engine.

13. The method of claim 11 or claim 12, wherein the electrical system comprises a sensor device that operates using the electrical current received from the energy harvesting device.

14. The method of any of claims 11 through 13, wherein the first portion has a higher temperature than the second portion and wherein the structure is configured to transfer thermal energy from the first portion to the second portion.

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FIG. 1

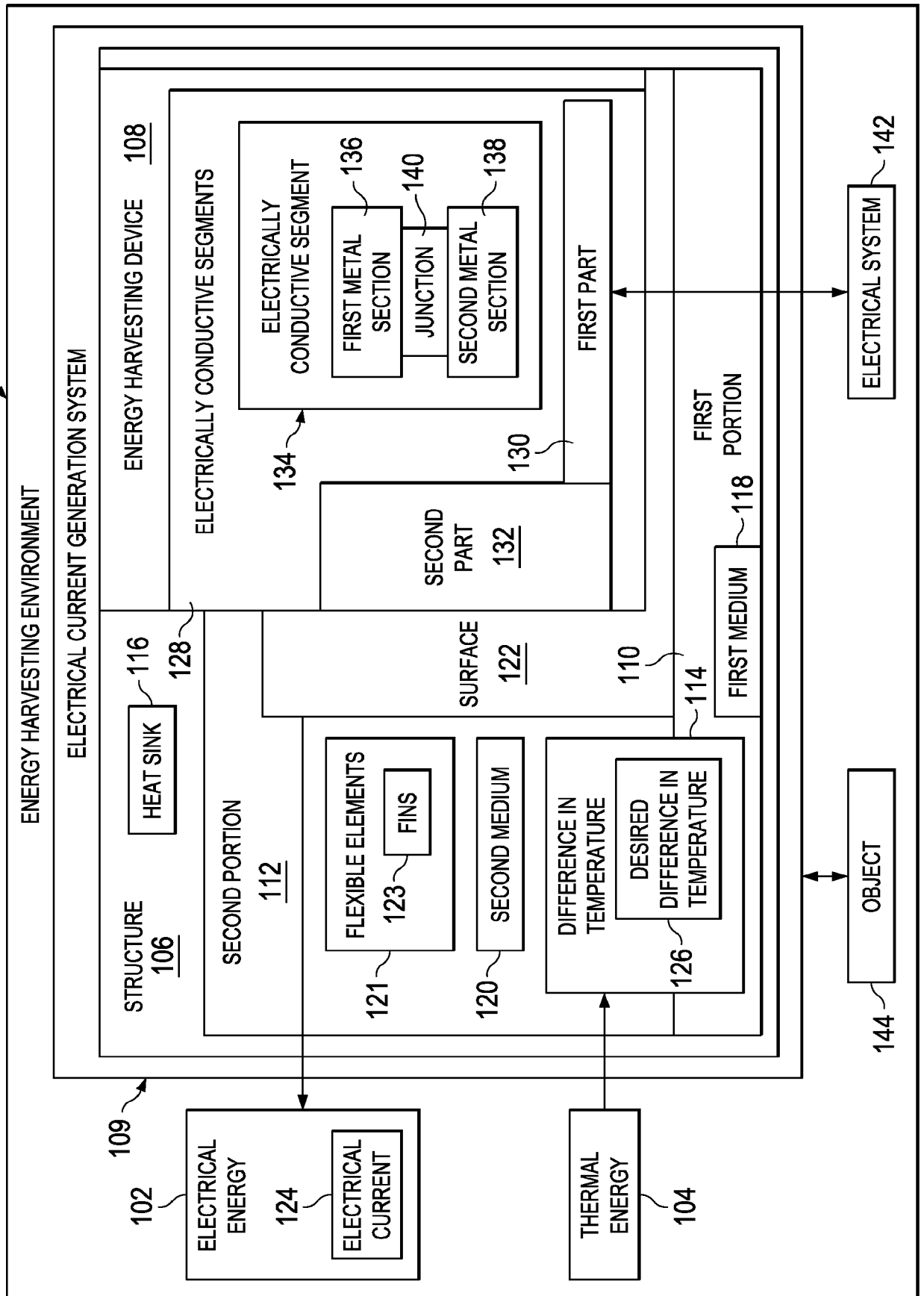


FIG. 2

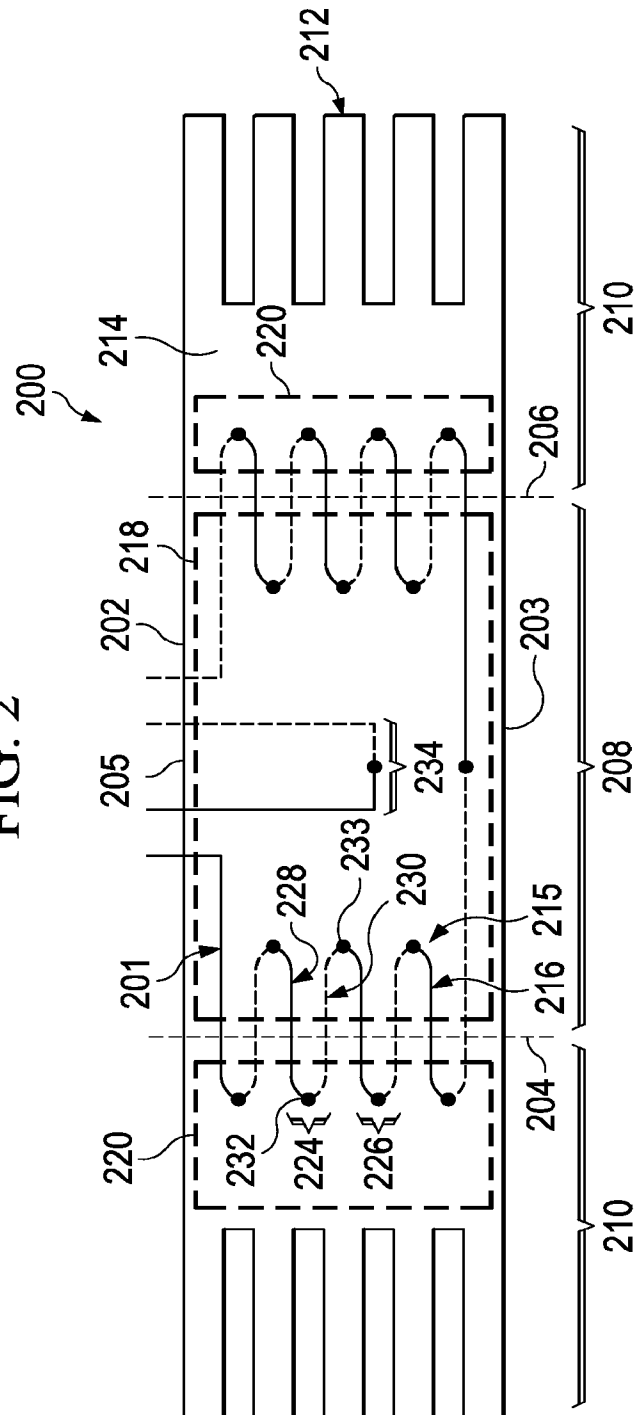


FIG. 3

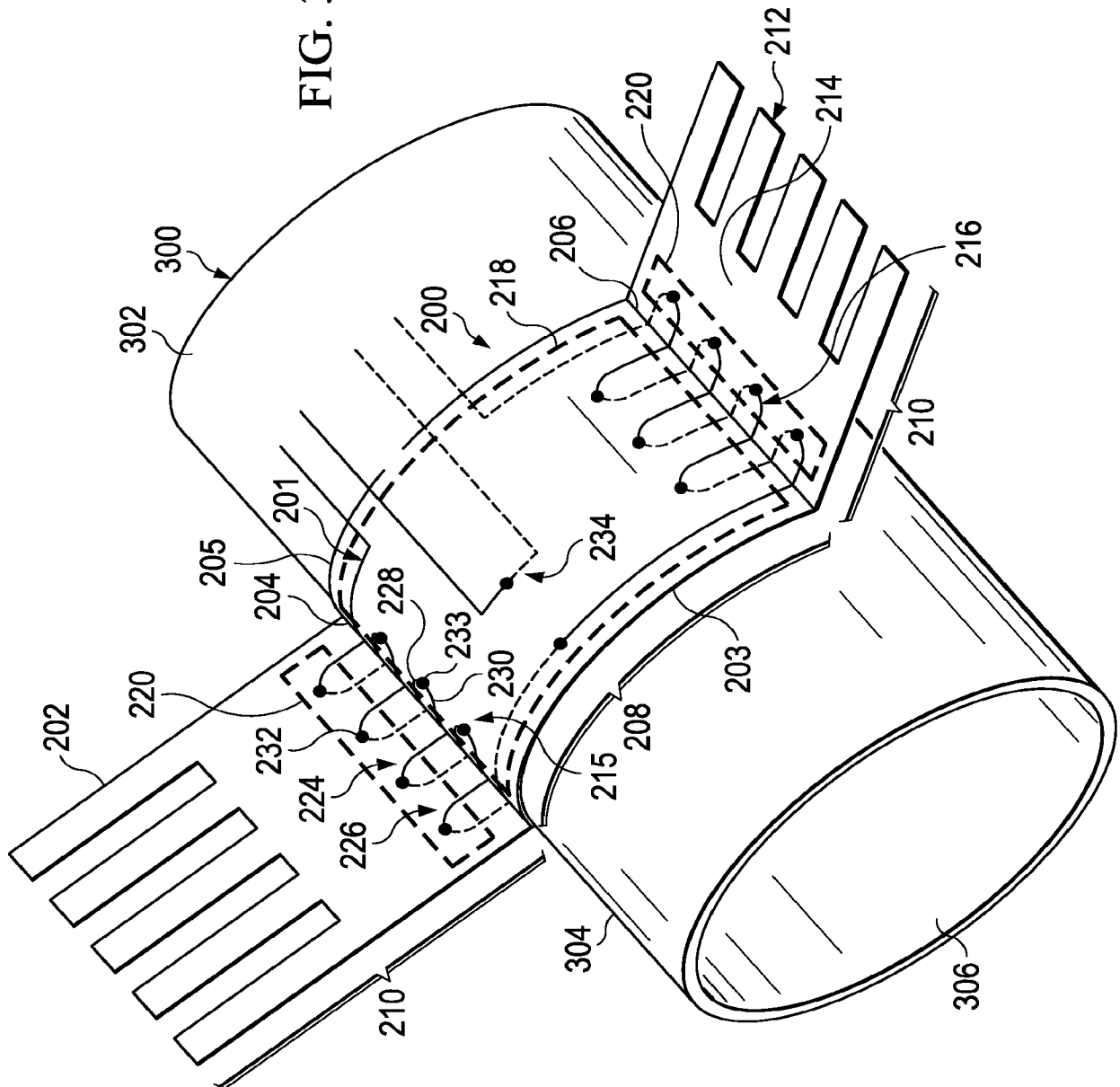
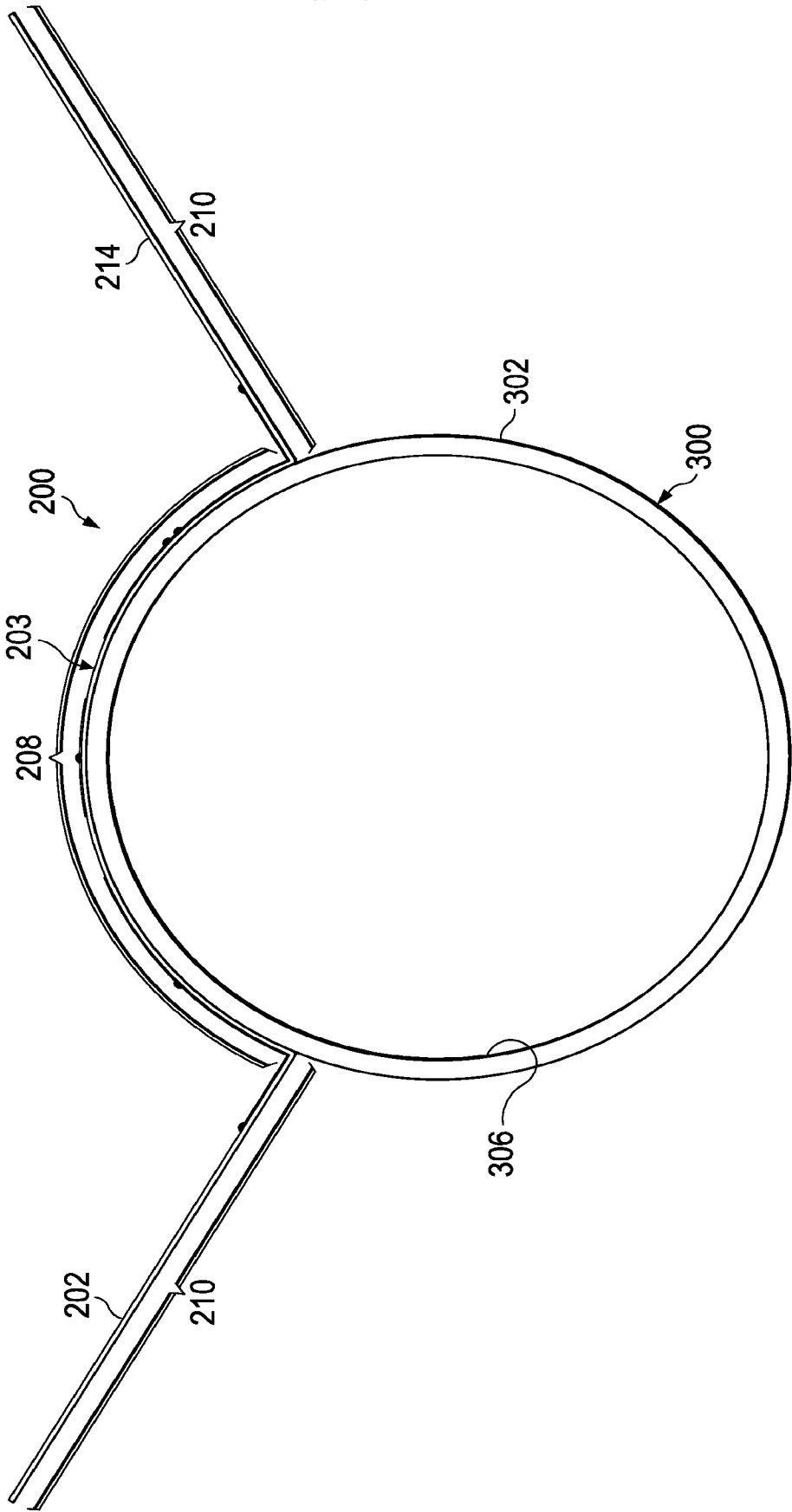


FIG. 4



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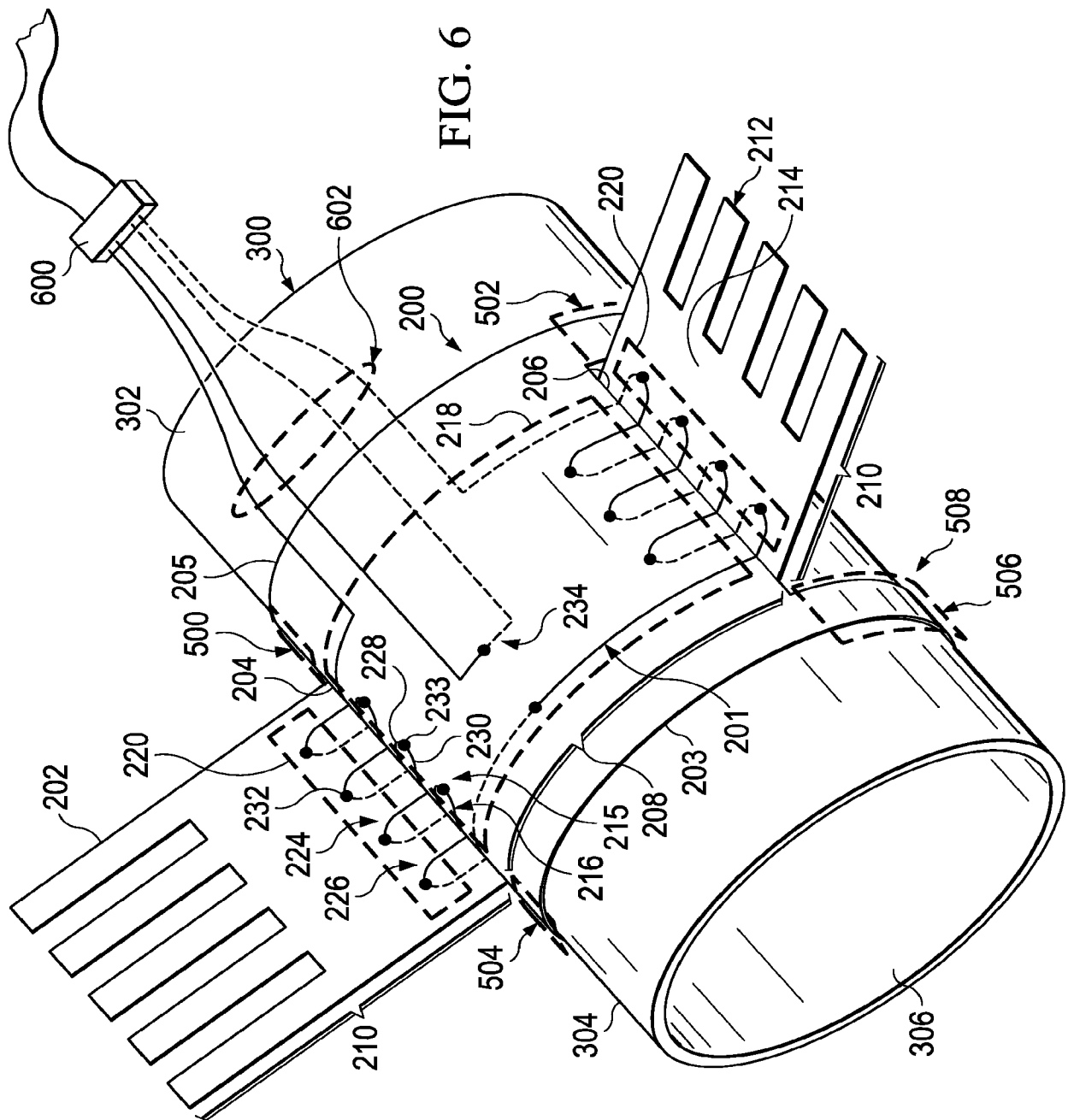


FIG. 7

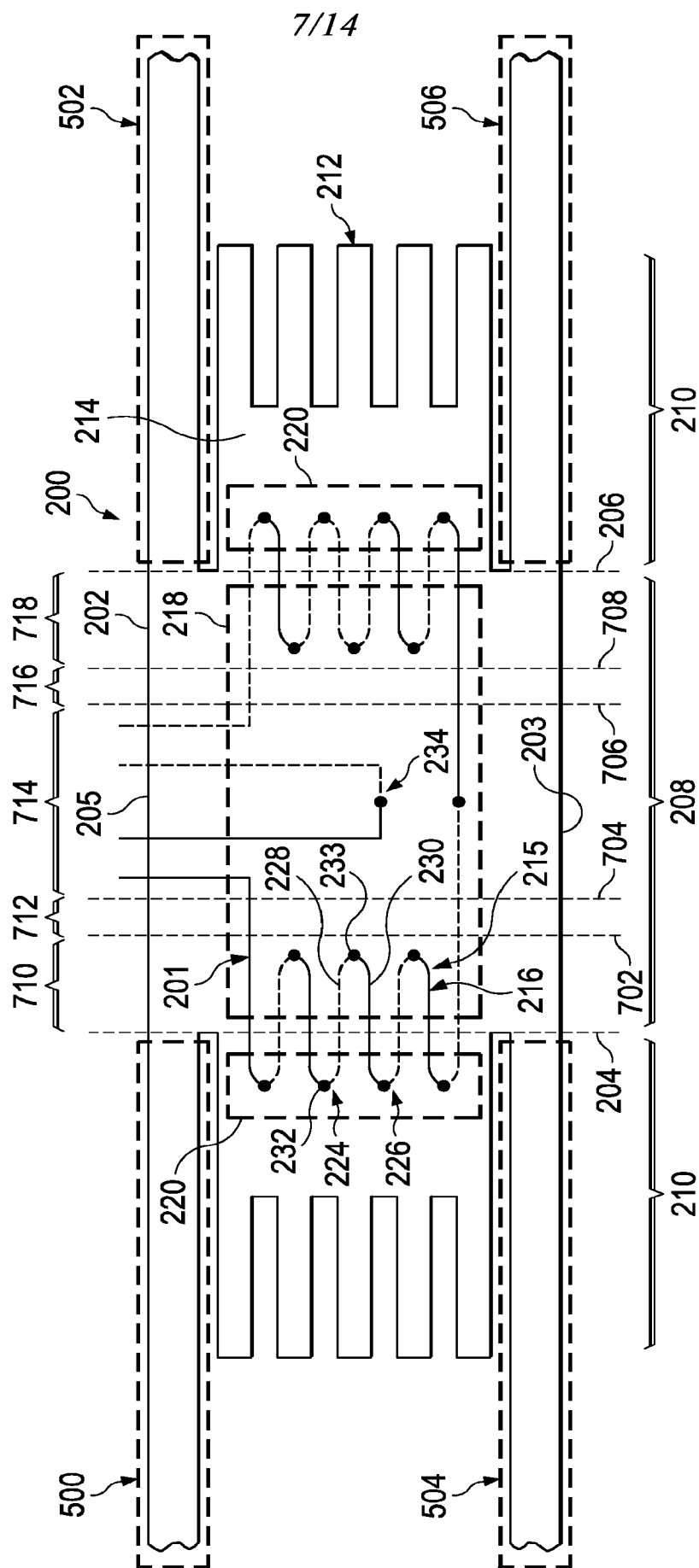
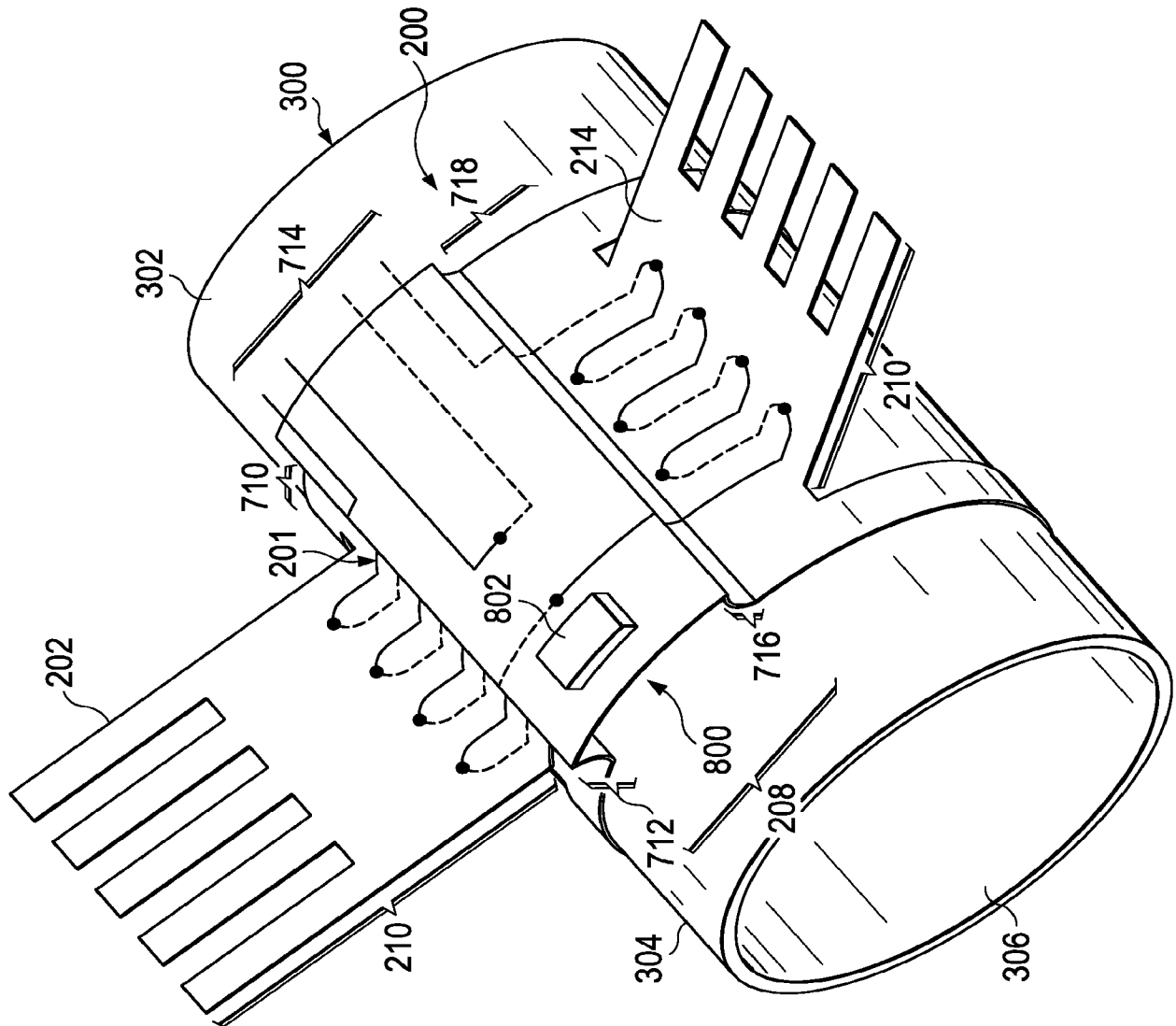
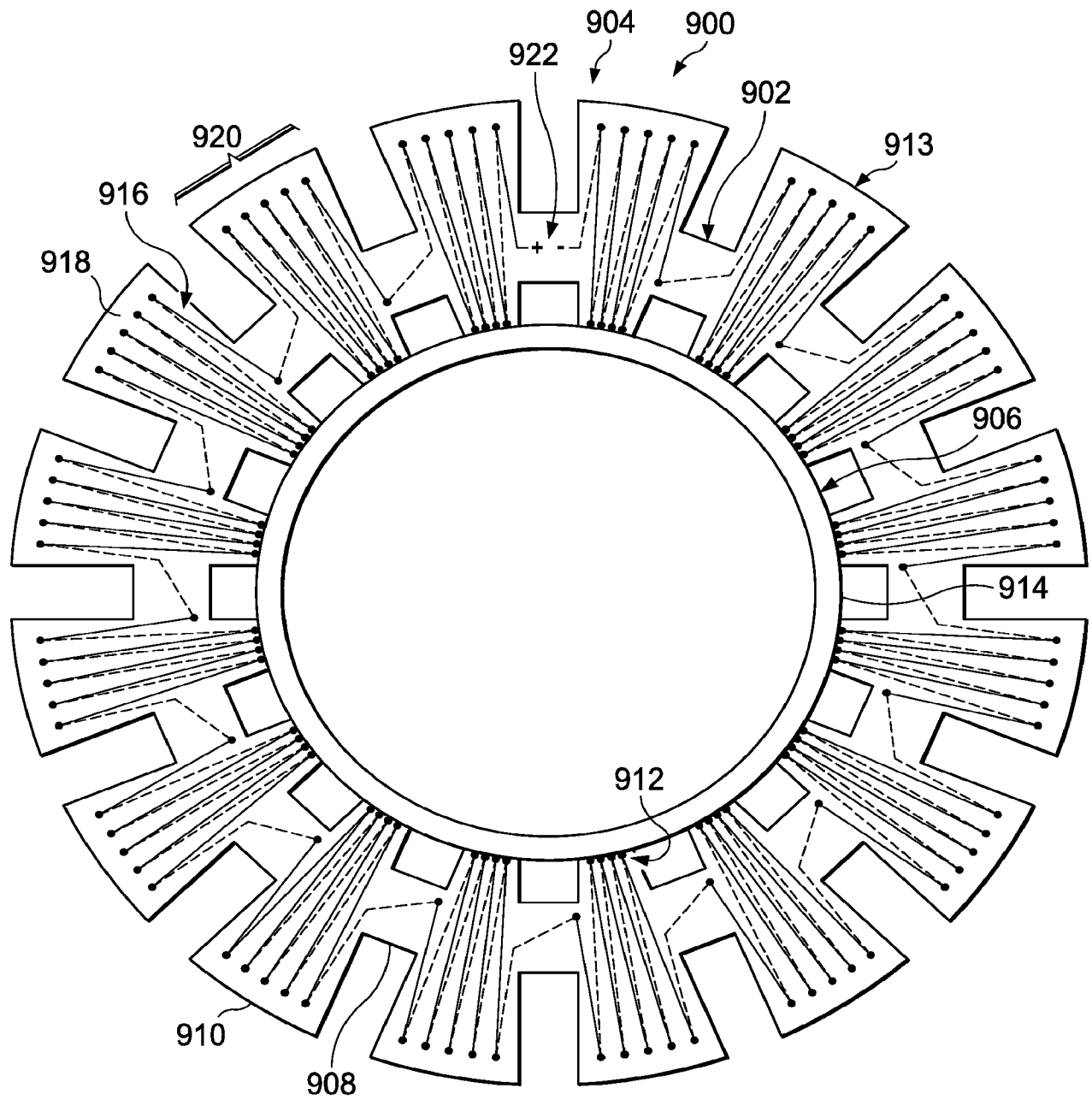


FIG. 8



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FIG. 9



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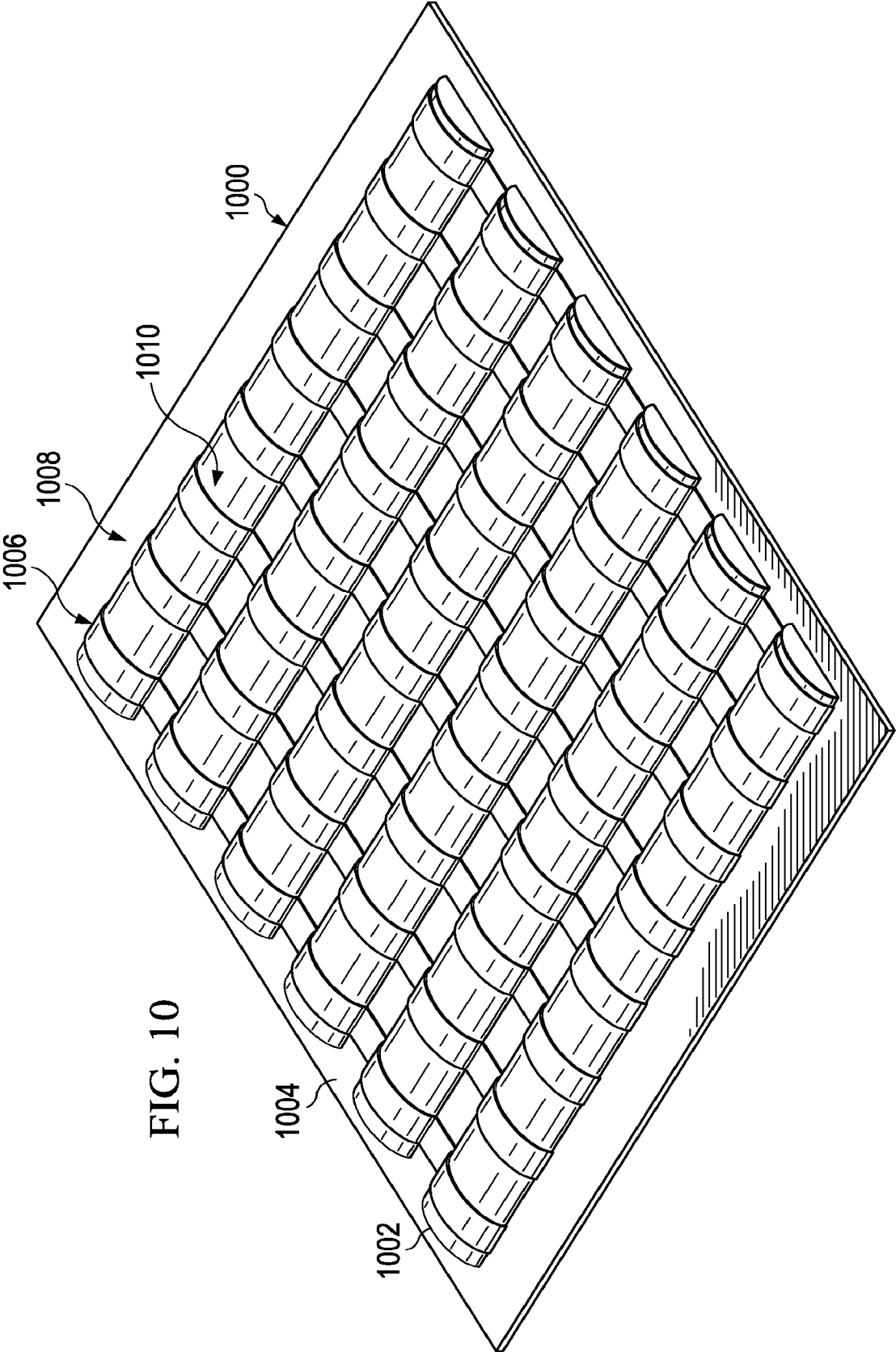


FIG. 10

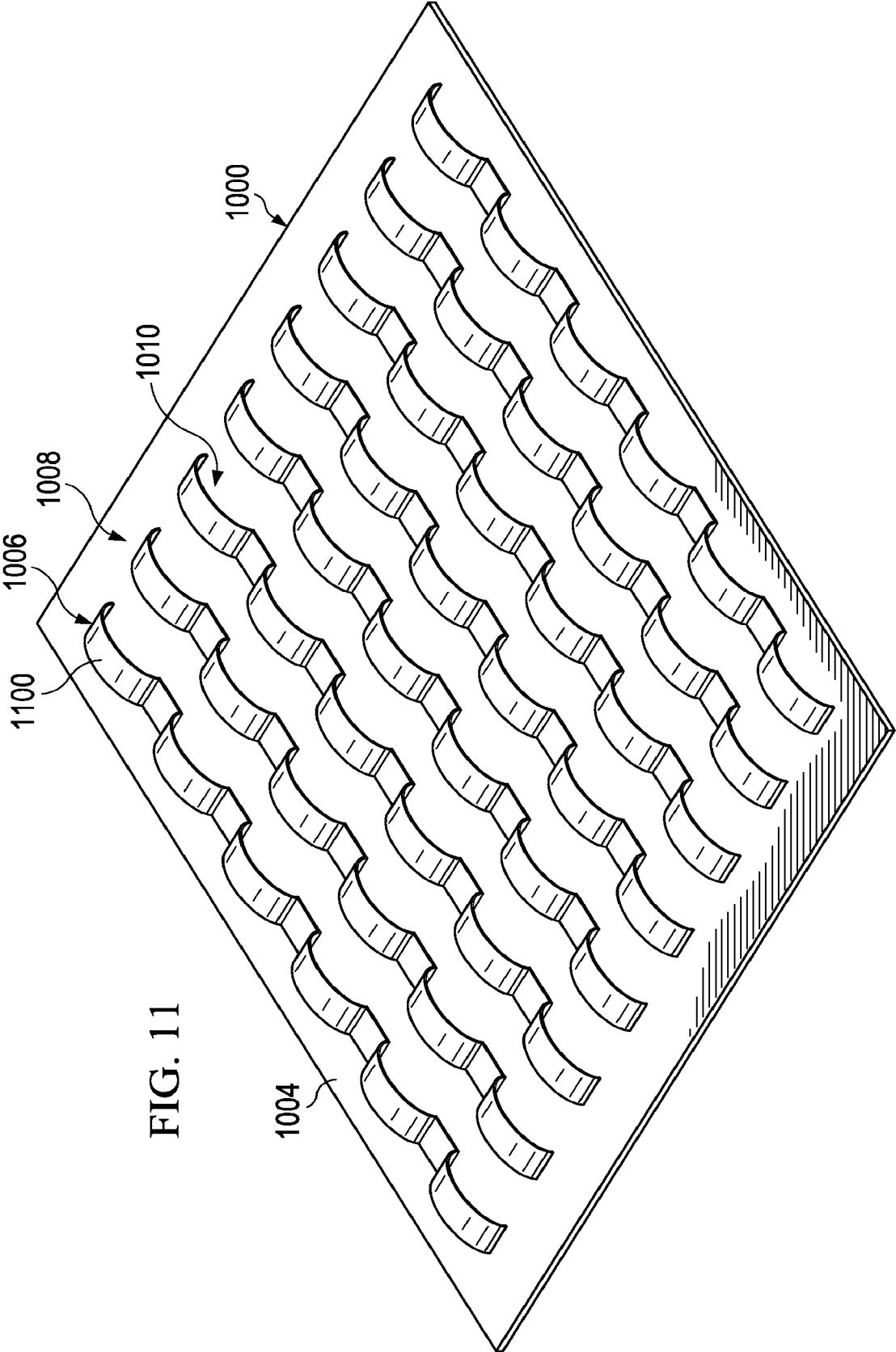


FIG. 12

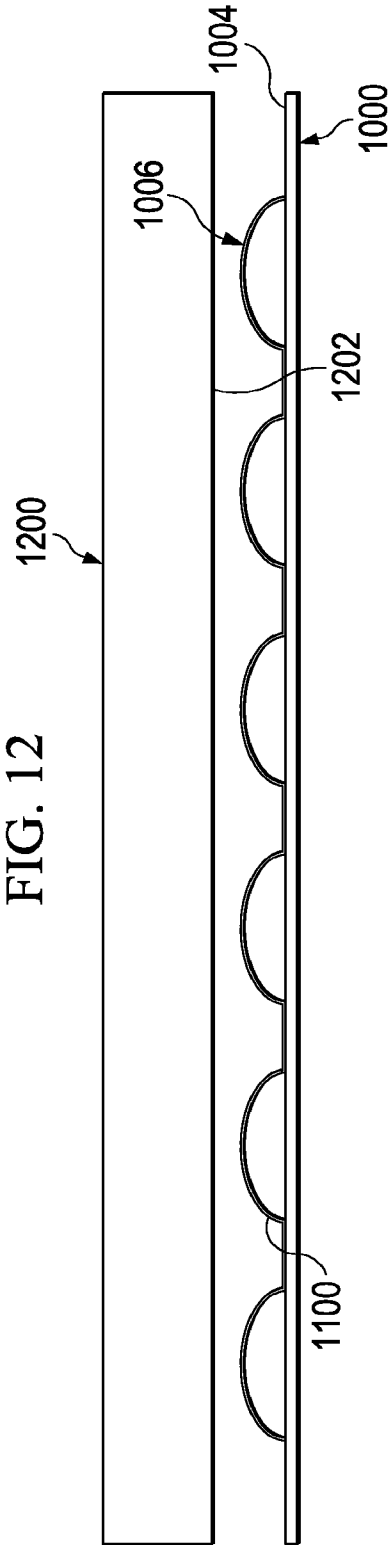
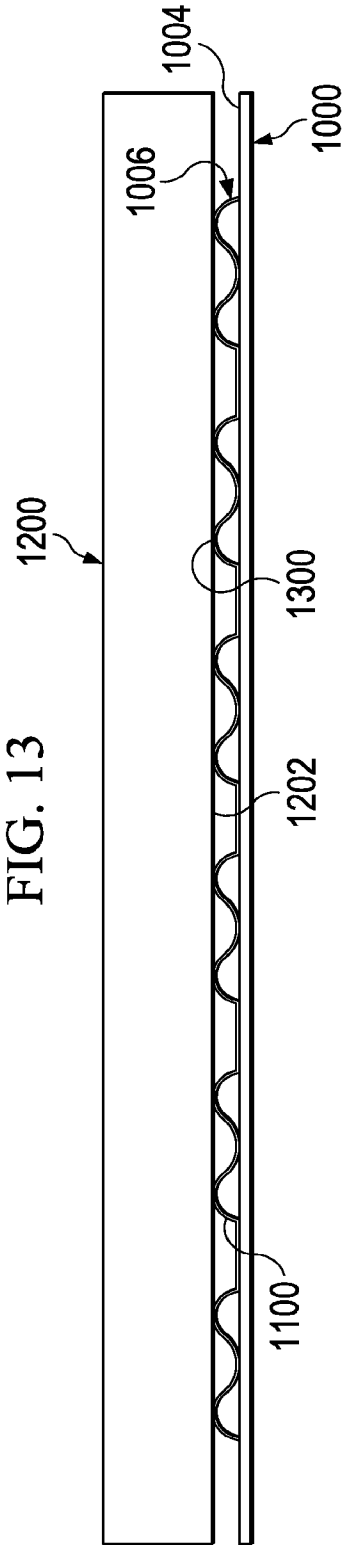
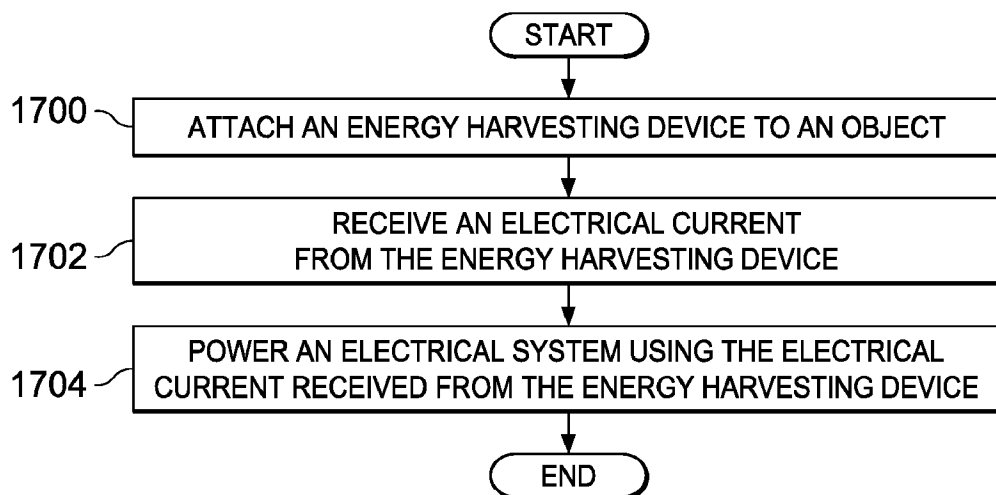
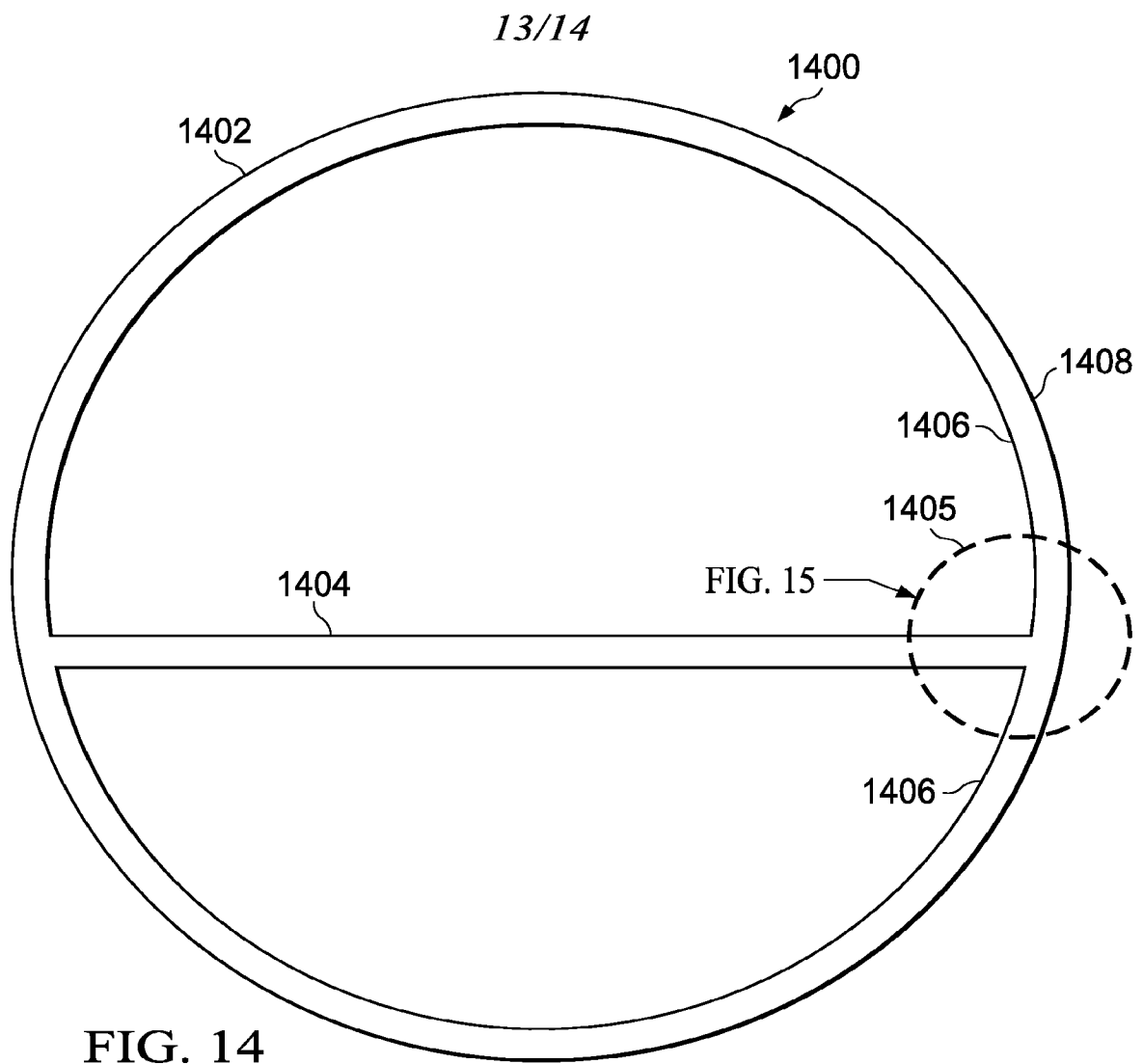


FIG. 13





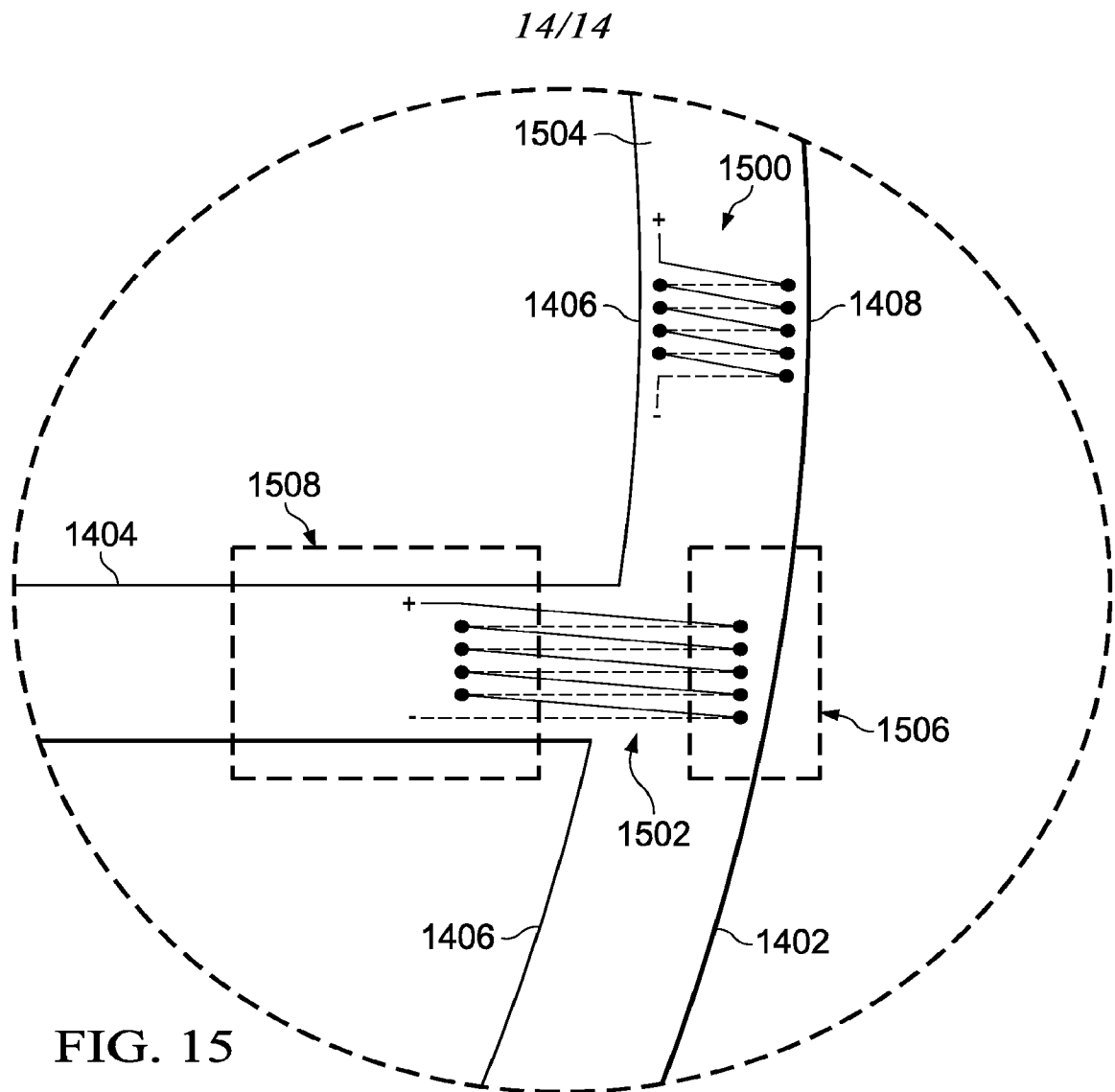


FIG. 15

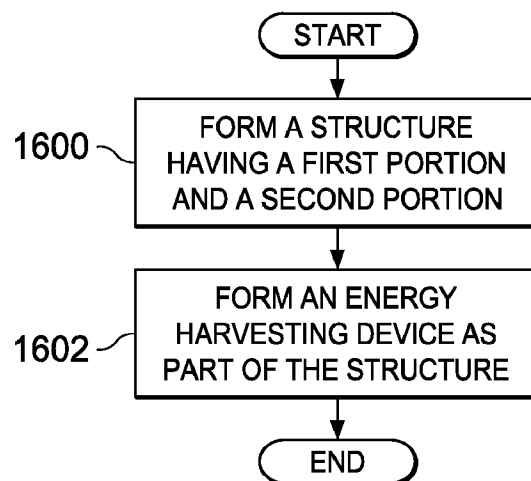


FIG. 16

INTERNATIONAL SEARCH REPORT

International application No
PCT/US2012/032326

A. CLASSIFICATION OF SUBJECT MATTER
INV. H01L35/32
ADD.

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

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
H01L B64D

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)

EP0-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X A	US 2 694 098 A (LEINS OSCAR J) 9 November 1954 (1954-11-09) column 2, line 32 - column 4, line 59; figures 1-3 -----	1-3,5-7, 9-11,14 4,8,12, 13
X A	GB 2 447 333 A (BOEING CO [US]) 10 September 2008 (2008-09-10) page 9, paragraph 2 - page 11, paragraph 3; figures 6,7 -----	1-7,9, 11,13,14 8,10,12
X	WO 2009/062635 A1 (EADS DEUTSCHLAND GMBH [DE]; BOVELLI SERGIO [DE]; KLUGE MARTIN [DE]; KU) 22 May 2009 (2009-05-22) page 6, line 10 - page 9, line 18; figures 1-3 ----- -/--	1,2,4-7, 11,13,14



Further documents are listed in the continuation of Box C.



See patent family annex.

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Date of the actual completion of the international search

12 September 2012

Date of mailing of the international search report

19/09/2012

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INTERNATIONAL SEARCH REPORT

International application No
PCT/US2012/032326

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	FR 2 917 997 A1 (RENAULT SAS [FR]) 2 January 2009 (2009-01-02) figures 1-6	11, 12

A	FR 2 947 529 A1 (AIRBUS [FR]) 7 January 2011 (2011-01-07) figures 1-7	1-14

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/US2012/032326

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
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WO 2009062635	A1	22-05-2009	DE 102007055090 A1	28-05-2009
			WO 2009062635 A1	22-05-2009

FR 2917997	A1	02-01-2009	NONE	

FR 2947529	A1	07-01-2011	NONE	
