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# DESCRIPTION

## Technical Field

[0001] The present invention relates to a wind turbine blade bushing system, a method of manufacturing such a bushing system, and a wind turbine blade comprising such a bushing system.

## Background

[0002] Wind turbine blades and thereby also the root region thereof are often made by assembling two blade halves essentially corresponding to the suction side and the pressure side, respectively, along the chord plane. However, the blades may also be moulded in their entirety by so-called hollow moulding.

[0003] The root region comprises layers of fibres forming an outer layer and an inner layer between which fastening members in the form of bushings are placed. The bushings are used to mount the wind turbine blades to a blade bearing or pitch bearing at the rotor hub of the wind turbine by use of mounting bolts. Separately formed inserts may be placed between each pair of adjacent bushings, whereby the bushings are mutually separated by the inserts. The known inserts are made of glass fibres embedded in a suitable resin.

[0004] Current bushings are manufactured via a plurality of milling or turning operations starting from relatively large steel blank. The resulting bushing, combined with standard high-strength bolts provides a strong connection between the blade and the blade bearing or pitch bearing of the wind turbine. However, the cost of bushings is relatively high as the milling and turning operations are expensive operations with a high amount of waste product. Further, since the bushing is made from a single blank, the entire bushing has to be made from a material that has steel-grade capable of picking up the force of the bolts. This overall, makes the bushings relatively expensive. Since a modern wind turbine blade comprises a plurality of bushings and often between 64 and 128, the bushings are source to a significant part of the overall cost of manufacturing the wind turbine blade. EP 2 554 834 A1 discloses a wind turbine having a rotatable hub carrying blades and means for attaching a portion of the blades to a portion of the hub. The attaching means comprise bushings inside of which corresponding studs can be secured. At least some of the bushings are provided with at least one securing end adapted for providing the stud with a degree of rotation relative to the bushing. Bushings may include an inner receiving member for receiving a corresponding end of the stud, and the receiving member can be rotated inside the bushing. Further prior art is known from US 2012/045339 A1.

## Disclosure of the Invention

**[0005]** Therefore, it is an object of the invention to obtain a wind turbine blade bushing system and a method of manufacturing such bushing systems, which overcome or ameliorate at least one of the disadvantages of the prior art or which provide a useful alternative.

**[0006]** In a first aspect, the invention provides a wind turbine blade bushing system for arrangement in a root end of a wind turbine blade, according to claim 1. The wind turbine blade bushing system comprising:

- a threaded element for retaining a mounting bolt for a wind turbine blade, and
- an anchor element for arrangement at the root end of the wind turbine, wherein the anchor element acts to at least partly retain the threaded element in the wind turbine blade.

**[0007]** Thus, it is seen that the bushing system according to the invention is made of two separate parts, which may simplify manufacturing methods and lowering costs, since the parts to a higher degree may be made from standard components and the degree of post machining may be minimised. Advantageously, the threaded element is connected to the anchor element.

**[0008]** According to the invention, the wind turbine blade bushing system further comprises:

- a threaded element for retaining a mounting bolt for a wind turbine blade, the threaded element being formed from a first material; and
- an anchor element for arrangement at the root end of the wind turbine, wherein the anchor element acts to at least partly retain the threaded element in the wind turbine blade, the anchor element being formed from a second material,
- wherein the first material has a higher strength and higher fracture toughness than the second material.

**[0009]** Since the threaded element forms the primary interface with a mounting bolt, the use of a higher quality/strength material to form the threaded element allows the bushing system to handle the transfer of the relatively high root end pulling forces to the mounting bolt, without risk of fracture or pull-out. The second material, by contrast, primarily acts to anchor the bushing system in the root end of the blade. As the anchoring effect is primarily dependent on the surface area between the anchor element and the blade body and the bonding to the laminate structure of the wind turbine blade root, the use of a lower-quality material allows for the overall cost of the bushing system to be minimized, as the higher quality, relatively high-cost material can be used in that area of the bushing system where it is most effective, while the less critical function of anchoring the bushing system in a blade can be easily fulfilled through the use of a larger quantity of relatively low cost material.

**[0010]** It is recognised that the bushing system is adapted to take up the bolt. Accordingly, the bushing system comprises a bore, and the threaded element in general comprises an inner threading to engage an outer threading of the bolt.

**[0011]** In terms of the invention, "higher strength" and "higher fracture toughness" material here means that the first material may have a higher quality or grade than the second material. The first material may for instance be made of a harder material than the second material, e.g. by the first material being higher grade steel, and the second material being a lower grade steel.

**[0012]** In general, the first material may be a first metal, and the second material be a second metal, e.g. a first grade metal and a second, lower grade metal.

**[0013]** The threaded element and the anchor element are preferably connected via a permanent connection, such as adhesive, soldering or weld connection or a threaded connection, such that the bushing system may be arranged as a unitary element in the wind turbine blade.

**[0014]** In the following, a number of embodiments are described:

**[0015]** According to the invention, the threaded element is a bolt-receiving nut for receiving a mounting bolt for a wind turbine blade, and the anchor element comprises a tubular member for arrangement at the root end of the wind turbine blade so as to retain the tubular member in a wind turbine blade body, wherein the tubular member acts to at least partly retain the bolt-receiving nut in the wind turbine blade. Thereby, the anchor element can be made from a relative cheap standard made tubular material, e.g. a pipe, whereas the more critical threaded element can be made from a simple high-strength bolt-receiving nut.

**[0016]** The bolt-receiving nut is arranged in an interior part of the tubular member. Accordingly, the nut is retained within the tubular member.

**[0017]** In one embodiment, the bolt-receiving nut is retained in the tubular member by the tubular member being crimped or press-formed in a region of said tubular member to retain the bolt-receiving nut at said region.

**[0018]** According to the invention, the tubular member comprises a first open end to receive a bolt, wherein an internal chamber of the tubular member comprises a first constriction between a location of the bolt-receiving nut in the tubular member and the first open end so as to retain the bolt-receiving nut in the tubular member. Thus, the constriction is adapted to retain or take up the nut.

**[0019]** In general, when referring to the first end of the various parts, this first end corresponds to the proximal end relative to root end of blade.

**[0020]** In a simple, non-claimed embodiment, the bolt-receiving nut may be connected to an end face of the tubular member, e.g. by welding or soldering. The different parts of the bushing system may for instance be connected via friction welding.

**[0021]** According to the invention, the tubular member comprises a second end opposed to the first end, wherein the internal chamber comprises a second constriction between the location of the bolt-receiving nut in the tubular member and the second end so as to retain the bolt-receiving nut in place relative to the second end of the tubular member. Thus, the second constriction, in conjunction with the first constriction, is adapted to retain the nut, e.g. in a cavity having a shape accommodating the shape of the nut.

**[0022]** In general, when referring to the second end of the various parts, this second end corresponds to the distal end relative to the root end of blade.

**[0023]** According to a non-claimed embodiment, the bolt-receiving nut may also be connected between two tubular members. Accordingly, the bolt-receiving nut is arranged between the second (or distal) open end of a first tubular member and a first (or proximal) open end of a second tubular member.

**[0024]** The tubular member may be an open-ended pipe element. Accordingly, the tubular member may be made from a standard component.

**[0025]** According to an advantageous embodiment, a tapered or wedge-shaped element is arranged at a distal part of the tubular member. The tapered or wedge-shaped part may in principle also be open, but advantageously it is closed. The tapered or wedge-shaped part ensures that a smooth transition in stiffness is obtained in the longitudinal direction of the blade shell to the laminate of the wind turbine blade. The tapered or wedge shaped part may be integrally formed with the tubular member or provided as a separate element.

**[0026]** In another non-claimed embodiment, the threaded element comprises an inner bore provided with an internal thread, the anchor element comprises a threaded spigot at a first end of the anchor element, the internal thread is arranged to receive at least a portion of a mounting bolt, and the internal thread is further arranged to receive at least a portion of the threaded spigot such that the anchor element acts to at least partly retain the threaded element in the wind turbine blade. Again, the anchor element comprising the threaded spigot may advantageously be made from a lower quality and cheaper material than the threaded element, thereby lowering the unit cost without compromising the strength of the overall bushing system.

**[0027]** The anchor element may comprise a tapered or wedge-shaped member. Again this member has the purpose of providing smooth stiffness transition to the laminate structure of the wind turbine blade.

**[0028]** In yet another advantageous embodiment, the threaded element is made from a nut

element comprising an inner bore having an internal thread to receive and retain a mounting bolt, and the anchor element comprises a bore having at least a first open end to receive the mounting bolt, wherein the nut element is held in the bore of the anchor element, such that the anchor element acts to retain the nut element in a wind turbine blade.

**[0029]** The anchor element may be provided with a blind bore extending from the first open end to a second closed end, wherein the anchor element further comprises a tapered or wedge-shaped portion at the second closed end. Accordingly, it is seen that the part with the open bore and the tapered or wedge-shaped portion may be formed as a single integral part.

**[0030]** In one advantageous embodiment, the nut element further comprises an external thread, wherein an internal thread is defined on at least a portion of the bore in the anchor element, wherein said internal thread of said anchor element is arranged to receive at least a portion of said external thread of said nut element. Accordingly, the nut element is retained by the thread connection in the bore of the anchor element.

**[0031]** In another advantageous embodiment, the anchor element comprises a first portion and a second portion, the first portion substantially comprising a tubular element having an inner through bore, the second portion substantially comprising a tapered or wedge-shaped element, wherein said first portion and said second portion are joined to form said anchor element. The first portion and said second portion may advantageously be joined via or at said nut element. Accordingly, the anchoring element is assembled from two separately manufactured and preferably standard products. The two parts may be assembled such that the assembly retains the nut element and/or the nut element provides the assembly of the two parts.

**[0032]** In one embodiment, the first portion comprises a through bore having an internal thread defined in the bore, the second portion comprises a blind bore having an internal thread defined in the bore, and the nut element further comprises an external thread, wherein the respective internal threads of the first and second portions are received on the external thread of the nut element to connect the first and second portions to the nut element. This provides a particular simple assembly, where the bushing system is assembled from three separately manufactured parts and assembled to a strong bushing system.

**[0033]** The first and/or second portions may for instance be press-formed or forged onto the nut element to join the first and second portions to the nut element.

**[0034]** In another non-claimed embodiment, the anchor part comprises a through-going bore from a first end for receiving a mounting bolt to a second end, wherein the through-going bore at the second end comprises an internal thread, and wherein the threaded element is connected via an external thread or press-fitted into the internal thread of the through going bore. A tapered or wedge-shaped element comprising a threaded spigot at a first end of said element may be connected to the second end of the anchor part via the internal thread of the through-going bore. As opposed to the earlier embodiment, the tapered or wedge-shaped

element is thus connected to the anchor element instead of the threaded element.

**[0035]** In one embodiment, the anchor part comprises at least a first tubular part surrounding a second tubular part, e.g. an inner pipe and an outer pipe. Thereby, it is possible to manufacture a thicker bushing via a number of standard pipes. The inner pipe and the outer pipe may for instance be connected via thermal fitting or via connecting threads. A collar may be used for retaining the threaded part for retaining a mounting bolt for a wind turbine blade.

**[0036]** In the following, a number of embodiments are described where the features may advantageously be combined with the first aspect or the afore-mentioned preferred embodiments.

**[0037]** In one embodiment, the bushing system comprises a bushing mouth, which is made from a third material. Again, the third material may have a higher strength and higher fracture toughness than the remainder of the bushing material. This will ease the machining of the rest of the bushing, e.g. the formation of a corrugated exterior surface and reduce material cost. It is seen that the idea may be broadened to a bushing, comprising a bushing mouth (or receiving opening), which is made of a material having a higher strength and higher fracture toughness than the remaining part of the bushing.

**[0038]** In a particularly advantageous embodiment, the anchor element comprises a metallic pipe, preferably formed from any one or a combination of the following: steel, aluminium, copper. The pipe may be a welded pipe, an extruded pipe, etc. The different parts of the bushing system may for instance be connected via friction welding.

**[0039]** The anchor element has an outer circular cross-section. Alternatively, the tubular member may have any other suitable cross-sectional shape, e.g. oval, square, rectangular, etc.

**[0040]** The description also provides a wind turbine blade bushing system comprising an external surface, said external surface has a surface effect to improve the retention of said bushing system in the root end of a wind turbine blade. The surface effect may be applied to the anchor member or tubular member of the first aspect of the invention.

**[0041]** The surface effect may comprise any combination of grooves, undulations, threads, corrugations, ribs, or ripples on the external surface of the bushing system.

**[0042]** In an embodiment, the surface effect comprises a shaped cross-sectional profile on the external surface, wherein a first series of undulations having a first spatial frequency are provided on the external surface of the tubular member, and wherein said first series of undulations are modulated with a second series of undulations having a second spatial frequency, said second spatial frequency being higher than said first spatial frequency. This embodiment provides a better anchoring in the surrounding laminate structure of the root section of the wind turbine blade.



**[0043]** It will be understood that that said undulations extend along the longitudinal direction of the tubular member.

**[0044]** In an advantageous embodiment, a height or amplitude of the first series of undulations is at least the same size as a height or amplitude of the second series of undulations.

**[0045]** The invention also provides a wind turbine blade according to claim 12.

**[0046]** In general, it is recognised that the invention pertains to modern wind turbine blades, which are made of a composite structure. Accordingly, the invention in greater detail provides (with reference to Figs. 1 and 2):

- A wind turbine blade (10) for a rotor of a wind turbine (2), said rotor comprising a hub (8), from which the blade (10) extends substantially in a radial direction when mounted to the hub (8), the wind turbine blade including a shell structure of a fibre-reinforced composite material comprising fibres embedded in a polymer matrix, the blade having a longitudinal direction (r) with a tip end (14) and a root end (16) and a transverse direction as well as having a blade length (L), the blade further comprising:
  - a profiled contour including a pressure side and a suction side, as well as a leading edge (18) and a trailing edge (20) with a chord having a chord length (c) extending there between, the profiled contour, when being impacted by an incident airflow, generating a lift, wherein the profiled contour comprises:
    - a root region (30) comprising a root end face (29),
    - an airfoil region (34) having a lift-generating profile furthest away from the hub, and
    - optionally a transition region (32) between the root region (30) and the airfoil region (34), wherein
  - the root region comprises a ring-shaped cross section with an outer surface (36) and an inner surface (35), wherein the root region (30) comprises a plurality of bushing systems (40) embedded mutually spaced apart in the fibre-reinforced polymer so as to substantially follow a circumference of the root region (30) and allow access from the outside to the bushing systems (40) used for mounting the blade (10) to the hub (8),
    - the bushing systems (40) comprise a first end (44) arranged at the root end face, a second end (46) opposite the first end (44) thereof and an outer periphery (42), wherein the wind turbine blade bushing systems comprise:
      - a threaded element for retaining a mounting bolt for a wind turbine blade, the threaded element being formed from a first material; and
      - an anchor element for arrangement at the root end of the wind turbine, wherein the anchor element acts to at least partly retain the threaded element in the wind turbine blade, the anchor element being formed from a second material,
      - wherein the first material has a higher strength and higher fracture toughness than the second material.

**[0047]** In one non-claimed embodiment, the threaded element is a bolt-receiving nut, and the anchor element comprises: a first tubular element having opposed first and second open ends, the tubular element comprising a body having a through bore extending between the first and second open ends, wherein the tubular element is embedded in the wind turbine blade at said root end such that said first open end is arranged to receive a mounting bolt at the root end of the blade, and wherein the bolt-receiving nut is arranged adjacent said second open end of first tubular element, wherein said nut bears against the body of said tubular element at said second end, said tubular element at least partly retaining said bolt-receiving nut in said wind turbine blade. This effect may simply be achieved by the tubular element against the bolt-receiving nut so as to retain the nut in the tubular element.

**[0048]** The bushing system according to this non-claimed embodiment may further comprise a second tubular element having a first open end, wherein said bolt-receiving nut is arranged between said second open end of said first tubular element and said first open end of said second tubular element, such that the first tubular element, the bolt-receiving nut, and the second tubular element together form a continuous bushing chamber to receive a mounting bolt.

**[0049]** The description also provides a sectionised wind turbine bushing system comprising at least a first longitudinal part connected to a second longitudinal part. Thus, it is recognised that the bushing system is made up from a plurality of sections, which are mutually connected. The first part may for instance comprise a threaded element for retaining a mounting bolt. The second longitudinal part may be an anchor element. The first longitudinal part may be made of a first material. The second longitudinal part may be made of a second material. The first material may have a higher strength and fracture toughness than the second material. Thus, the invention provides a bushing system, which is modular. Thereby, the bushing system may comprise standardised parts for one part of the bushing system, whereas customised parts may be used for other parts of the bushing system, e.g. for a particular wind turbine blade type. This embodiment may advantageously be combined with the embodiment, where the bushing system further comprises a separate manufactured mouth piece.

**[0050]** The invention also provides a method of manufacturing a wind turbine blade bushing according to claim 13.

**[0051]** In an advantageous embodiment, the fitting in step c) is carried out by at least a portion of the exterior of said tubular member to secure said bolt-receiving nut in the interior of said tubular member to form a bushing system to receive a mounting bolt for a wind turbine blade.

**[0052]** The method may advantageously comprise the step of surface treating an external surface of said tubular member to improve the retention of said bushing system in a root end of a wind turbine blade. The step of surface treating may comprise providing grooves, undulations, treads on external surface. The surface treating may comprise any of the

following steps: press-forming, milling, forging, turning, etc.

**Brief Description of the Drawings**

**[0053]** The invention is explained in detail below with reference to embodiments shown in the drawings, in which

Fig. 1 shows a wind turbine,

Fig. 2 is a diagrammatic perspective view of a wind turbine blade according to the invention,

Fig. 3 is a perspective, sectional view of a portion of a root region of a wind turbine blade according to the invention,

Fig. 4 is a longitudinal sectional view of a portion of the embodiment shown in Fig. 3,

Fig. 5 shows a first embodiment of a bushing system, not according to the invention,

Fig. 6 shows a second embodiment of a bushing system, not according to the invention,

Fig. 7 shows a third embodiment of a bushing system, not according to the invention,

Fig. 8 shows a fourth embodiment of a bushing system, according to the invention,

Fig. 9 shows a fifth embodiment of a bushing system, according to the invention,

Fig. 10 shows a sixth embodiment of a bushing system, not according to the invention,

Fig. 11 shows a seventh embodiment of a bushing system, not

Fig. 12 shows an eighth embodiment of a bushing system,

Fig. 13 shows a ninth embodiment of a bushing system,

Fig. 14 illustrates a first embodiment for manufacturing a bushing system,

Fig. 15 illustrates a second embodiment for manufacturing a bushing system,

Fig. 16 shows one embodiment of a bushing system that is not claimed,

Fig. 17 shows another embodiment of a bushing system that is not claimed, and

Fig. 18 shows yet another embodiment of a bushing system.

**Detailed Description of the Invention**

**[0054]** Fig. 1 illustrates a conventional modern upwind wind turbine according to the so-called "Danish concept" with a tower 4, a nacelle 6 and a rotor with a substantially horizontal rotor shaft. The rotor includes a hub 8 and three blades 10 extending radially from the hub 8, each having a blade root 16 nearest the hub and a blade tip 14 farthest from the hub 8. The rotor has a radius denoted  $R$ .

**[0055]** Fig. 2 shows a schematic view of a of a wind turbine blade 10. The wind turbine blade 10 has the shape of a conventional wind turbine blade and comprises a root region 30 with a root end face 29 closest to the hub, a profiled or an airfoil region 34 farthest away from the hub and a transition region 32 between the root region 30 and the airfoil region 34. The blade 10 comprises a leading edge 18 facing the direction of rotation of the blade 10, when the blade is mounted on the hub, and a trailing edge 20 facing the opposite direction of the leading edge 18.

**[0056]** The airfoil region 34 (also called the profiled region) has an ideal or almost ideal blade shape with respect to generating lift, whereas the root region 30 due to structural considerations has a substantially circular or elliptical cross-section, which for instance makes it easier and safer to mount the blade 10 to the hub. The diameter (or the chord) of the root region 30 may be constant along the entire root area 30, but often the transition towards the airfoil region starts close to the root end face 29. The transition region 32 has a transitional profile gradually changing from the circular or elliptical shape of the root region 30 to the airfoil profile of the airfoil region 34. The chord length of the transition region 32 typically increases with increasing distance  $r$  from the hub. The airfoil region 34 has an airfoil profile with a chord extending between the leading edge 18 and the trailing edge 20 of the blade 10. The width of the chord decreases with increasing distance  $r$  from the hub.

**[0057]** The blade is often made of two blade halves assembled by being glued or bolted together substantially along a chord plane 38 of the blade. It should be noted that the chord plane does not necessarily run straight over its entire extent, since the blade may be twisted and/or curved, thus providing a chord plane with a correspondingly twisted and/or curved course, this being most often the case in order to compensate for the local velocity of the blade being dependent on the radius from the hub. Due to the circular cross section, the root region 30 does not contribute to the production of the wind turbine and, in fact, it lowers the production slightly due to the drag.

**[0058]** As seen in Figs. 3 and 4, the blade including the root region 30 is formed as a shell structure. The shell structure of the root region 30 is ring-shaped and comprises an outer surface 36 formed by an outer layer 72 of a fibre-reinforced polymer matrix advantageously of glass fibres and/or carbon fibres and a resin, such as epoxy, polyester or vinylester, and an oppositely arranged inner surface 35 formed by an inner layer 70 being made of the same material as the outer layer 72. Elongated fastening members 40 with fastening means 48 are placed between the layers 70, 72, optionally with an inner retaining layer 74 and outer retaining layer 76 in between. The elongated fastening members 40 are bushings having a bore for receiving a mounting bolt, and the bore comprises a threaded part 48 as fastening means. The

bushing 40 comprises a first end (or proximal end) 44 and an oppositely arranged second end (or distal end) 46. The first end 44 of the bushing 40 is placed at the root end face 29 of the root region. The bushings 40 are arranged mutually spaced apart so as to substantially follow the circumference of the root region and allow access from the outside to the fastening means 48, i.e. the threads used for mounting the blade to the hub, e.g. via stay bolts. Seen relative to the root region, the outer periphery 42 of the fastening members 40 comprises an outer surface, an opposite inner surface, a first lateral face, and an opposite lateral face, as shown in Fig. 4.

**[0059]** Intermediate retaining means 50, e.g. made of a fibre-reinforced polymer, may be arranged in each region between adjacent interspaced lateral surfaces of the fastening members 40, i.e. in the present example between the bushings. Further, in the present embodiment the intermediate retaining means are formed of separately manufactured inserts 50. The inserts 50 may comprise a first insert part and a second insert part. The first insert part essentially corresponds to the region between the lateral faces of adjacent bushings 40 and is provided with opposite lateral faces 52, 54 formed complimentary to the lateral faces of the adjacent bushings 40, as shown in Fig. 4. The inserts 50 substantially extend up next to the adjacent bushings when seen in circumferential direction. Further, the first insert part extends from the first end of the bushings 40 and beyond the second end thereof. The second insert part is a wedge-shaped tapering extension of the first insert part. The first insert part may have an extent substantially corresponding to that of the bushings 40.

**[0060]** While the embodiment shown in Figs. 3 and 4 comprises intermediate inserts 50, it is recognised that the blade root may be designed without such inserts. The bushings 40 may for instance be provided with a complimentary shape such that the neighbouring bushings 40 adjoin or abut each other.

**[0061]** Fig. 5 shows a first embodiment of a wind turbine blade bushing system 140, not according to the invention. The bushing system 140 is made up of at least two separately made parts comprising a threaded element 180 in form of a bolt-receiving nut having an internal thread 181 for obtaining a threaded connection with a mounting bolt or stay bolt for attaching the wind turbine blade to a blade bearing or pitch bearing at the hub of a wind turbine, and an anchor element 182, which bonds the bushing system 140 to the laminate structure of the wind turbine blade root. The anchor element 182 is provided with a through-going bore 184 between a first end 185 which is to be arranged proximal to the root end of the wind turbine blade and a second end to be arranged distal to the root end of the wind turbine blade. The anchor element 182 may advantageously be made of two separate pipes, which are attached to ends of the bolt-receiving nut 180, so that said nut 180 is retained between the two pipes via a first constraint 187 and a second constraint 188. The bolt-receiving nut 180 may for instance be attached to the two pipes via welding or soldering or any other suitable method. In an alternative embodiment, the anchor element 182 is made from a single pipe, and the bushing system 140 is manufactured by first arranging the bolt-receiving nut 180 in the interior of the bore 184 of the anchor element. The pipe is then press-formed or crimped next to the location of said nut 180 in order to form the first constriction 186 and/or the second

constriction 187.

**[0062]** The bolt-receiving nut 180 is preferably made from a first material, and the anchor element 182 is made from a second material, where the first material has a higher strength or quality than the second material. The first material may for instance be a higher grade and harder steel, whereas the second material may be a lower grade and softer steel. Since the threaded element 180 forms the primary interface with a mounting bolt, the use of a higher quality/strength material to form the threaded element 180 allows the bushing system to handle the transfer of the relatively high root end pulling forces to the mounting bolt, without risk of fracture or pull-out. The anchor element 182, by contrast, primarily acts to anchor the bushing system in the root end of the blade. As the anchoring effect is primarily dependent on the surface area between the anchor element 182 and the blade body and the bonding to the laminate structure of the wind turbine blade root, the use of a lower-quality material allows for the overall cost of the bushing system to be minimised, as the higher quality, relatively high-cost material can be used in that area of the bushing system where it is most effective, while the less critical function of anchoring the bushing system in a blade can be easily fulfilled through the use of a larger quantity of relatively low cost material.

**[0063]** Fig. 6 shows a second embodiment of a wind turbine blade bushing system 240, not according to the invention, wherein like reference numerals refer to like parts of the first embodiment. The bushing system comprises an anchoring part 282 and a threaded element 280 for establishing a threaded connection with a mounting bolt. In the shown embodiment, the bushing system 240 comprises a plurality of tubular members or pipes that combined make up layers of a thicker bushing. The anchoring to the surrounding laminate is primarily provided by the outer pipe. The inner threading 281 may be provided on an inner pipe. Alternatively, the threaded element may be provided as a bolt-receiving nut or collar which is either retained or constrained within the bore 284. This may for instance be achieved by providing two inner pipes that make the constraints and thus retain the threaded element between ends of the two inner pipes.

**[0064]** Said collar or nut may also be connected to the pipes via a threaded connection. The individual pipes (i.e. outer, inner and possible intermediate pipes) may be fitted to each other via thermal fitting, a threaded connection, or any other suitable means. The use of standard pipes will lower the overall cost of the bushing system. Again, the threaded element 280 may be made from a first material, and the anchor element 282 may be made from a second material, where the first material has a higher strength or quality than the second material.

**[0065]** Fig. 7 shows a third embodiment of a wind turbine blade bushing system 340, not according to the invention, wherein like reference numerals refer to like parts of the previous embodiments. The bushing system 340 comprises a threaded element 380 and an anchor element 382. The threaded element 380 comprises a through-going bore 384 between a first end 385 and a second end 386, and the bore 384 is provided with an inner thread 381 at the second end 386 of the threaded element 380. The anchor element 382 comprises a threaded spigot at a first end of the anchor element 380.

**[0066]** The internal thread 381 is arranged to receive at least a portion of a mounting bolt or stay bolt 390, and the internal thread is further arranged to receive at least a portion of the threaded spigot such that the anchor element 390 acts to at least partly retain the threaded element in the wind turbine blade.

**[0067]** The anchor element 382 further comprises a tapered or wedge-shaped part at a distal part of anchor element 382. The tapered or wedge-shaped part ensures that a smooth transition in stiffness is obtained in the longitudinal direction of the blade shell to the laminate of the wind turbine blade root.

**[0068]** Again, the threaded element 380 may be made from a first material, and the anchor element 382 may be made from a second material, where the first material has a higher strength or quality than the second material.

**[0069]** Fig. 8 shows a fourth embodiment of a wind turbine blade bushing system 440, according to the invention, wherein like reference numerals refer to like parts of the previous embodiments. The bushing system 440 comprises an anchor element 482 and a threaded element 482 in form of a bolt-receiving nut or collar having an inner thread 481 for establishing a threaded connection with a mounting bolt. The anchor element 482 comprises a first portion and a second portion, the first portion substantially comprising a tubular element having an inner through bore 484 extending between a first end 485 and a second end 486. The second portion substantially comprises a tapered or wedge-shaped element. The first portion and said second portion are joined to form an anchor element 482. The first portion and said second portion may advantageously be joined via or at said nut or collar 480, e.g. via a threaded connection. Accordingly, the anchoring element 482 is assembled from two separately manufactured and preferably standard products. The two parts may be assembled such that the assembly retains the bolt-receiving nut 480 and/or said nut 480 provides the assembly of the two parts. Further, the two portions may provide a first constriction 487 and a second constriction 488 so that the bolt-receiving nut 480 is retained in a cavity formed between said two portions.

**[0070]** The threaded element 480 is made from a first material, and the anchor element 482 is made from a second material, where the first material has a higher strength and higher fracture toughness than the second material.

**[0071]** Fig. 9 shows a fifth embodiment of a wind turbine blade bushing system 540, according to the invention, wherein like reference numerals refer to like parts of the fourth embodiment. The embodiment shown differs from the fourth embodiment in that the connection between the two portions of the anchor element 582 and the threaded element 580 is provided by a thermal shrink fit or similar process to retain the threaded element 580 in a cavity formed between the two portions.

**[0072]** Fig. 10 shows a sixth embodiment of a wind turbine blade bushing system 640, not

according to the invention, wherein like reference numerals refer to like parts of the previous embodiments. The bushing system 640 comprises an anchor element 682 and a threaded element 680 in form of a bolt-receiving nut or collar having an inner thread 681 for establishing a threaded connection with a mounting bolt. The anchor element 682 comprises a first portion and a second portion, the first portion substantially comprising a tubular element having an inner through bore 684 extending between a first end 685 and a second end 686. The second portion substantially comprises a tapered or wedge-shaped element. The bore 684 of the first portion comprises an inner thread, and the second portion is connected to said inner thread via a threaded male part such that the first portion and said second portion are joined to form the anchor element.

**[0073]** The threaded element 680 is also connected via a threaded connection to the inner thread of the bore of the first portion. The bore may further comprise a constraint 687 such as to further retain the threaded part 680 in the anchor part 682 and the wind turbine blade.

**[0074]** Again, the threaded element 680 may be made from a first material, and the anchor element 682 may be made from a second material, where the first material has a higher strength or quality than the second material.

**[0075]** While the embodiments shown in Figs. 5-10 are shown with an apparent smooth exterior surface, it is recognised that the bushing system may comprise an external surface, provided with a surface effect to improve the retention of said bushing system in the root end of a wind turbine blade. The surface effect may comprise any combination of grooves, undulations, threads, corrugations, ribs, or ripples on the external surface of the bushing system. The surface effect is preferably made to the anchor element.

**[0076]** The description also provides a wind turbine blade bushing 740 as shown in Fig. 11. The bushing 740 is provided with a surface effect in form of a shaped cross-sectional profile on the external surface, wherein a first series of undulations having a first spatial frequency are provided on the external surface of the bushing, and wherein said first series of undulations are modulated with a second series of undulations having a second spatial frequency, said second spatial frequency being higher than said first spatial frequency. This embodiment provides a better anchoring in the surrounding laminate structure of the root section of the wind turbine blade. The height or amplitude of the first series of undulations are advantageously at least the same size as a height or amplitude of the second series of undulations. This surface effect may be combined with any of the afore-mentioned embodiments or with any prior art bushings. Accordingly, it is seen that the novel surface effect provides a generic idea.

**[0077]** The description also provides a wind turbine blade bushing system 840 as shown in Fig. 12. In this embodiment, a separately manufactured bushing mouth 892 is made as an insert to an anchor element 882 of the bushing system. The bushing mouth may be made from a higher grade or harder material than the anchor element 882. Thus, a bushing system 840 is provided with a bushing mouth of a high-grade material, whereas post milling operations or the



like may more easily be carried out on the material of the anchor element 882. The bushing mouth may be combined with any of the afore-mentioned embodiments or with prior art bushings, e.g. as a blade bushing system comprising three or more pieces and comprising a bushing mouth, a cylindrical tube and a threaded transition part.

**[0078]** The bushings and intermediate inserts are often pre-arranged on a root plate. This may be carried out by first arranging a number of outer layers, after which the bushings and inserts are arranged on the outer layers via the root plate. Finally a number of inner layers are arranged on top of the bushings and inserts, cf. also the layout shown in Figs. 3 and 4. This process is known in the art.

**[0079]** Figs. 13a and 13b show a side view and end view of a bushing 940 that is particularly advantageous for the above layout method using a root plate. In this embodiment an end face of the bushing 940 is provided with an alignment bore. A corresponding bore is provided in a root plate 994, and the bushing may thus be aligned in a correct angular position on the root plate 994 by use of an alignment pin 995 inserted through the bore of the root plate 994 and into the alignment bore 993 of the bushing 940. This embodiment may be combined with any of the afore-mentioned embodiments or prior art bushings.

**[0080]** The description also provides two manufacturing methods that minimise the manufacturing costs by reducing the amount of scrap compared to the prior art manufacturing methods, where the bushings are manufactured from relatively bulky blanks. A first embodiment for manufacturing a bushing 1040 is illustrated in Fig. 14. The bushing is manufactured by first forging a template having a little extra material than the final bushing. The diameter  $D_{forge}$  of the bore is chosen to follow maximum material conditions. The diameter may for instance be chosen as the minimum diameter of the inner thread, which is to provide the threaded connection to a mounting bolt. A later minimum machining is carried out to remove the extra material in the bore. The surface treatment such as providing the exterior of the bushing with corrugations may be carried out via the forging process. Thus, no post machining is necessary to the exterior of the forged template.

**[0081]** A second embodiment for manufacturing a bushing 1140 is illustrated in Fig. 15. In this embodiment the bushing is manufactured by first casting a template by use of outer mould parts 1196, 1197 and a mould core part 1198. The outer mould parts 1196, 1197 may be used to cast the exterior surface of the template. The surface treatment such as providing the exterior of the bushing with corrugations may be carried out via the shape of the outer mould parts 1196, 1197. Thus, no post machining is necessary to the exterior of the forged template. The diameter  $D_{core}$  of the mould core part 198 is chosen to provide a through-going bore which follows maximum material conditions. The diameter may for instance be chosen as the minimum diameter of the inner thread, which is to provide the threaded connection to a mounting bolt. A later minimum machining is carried out to remove the extra material in the bore.

**[0082]** Figs. 16a and 16b illustrate an embodiment of a sectionised bushing system 1240

according to a non-claimed embodiment. The bushing system 1240 comprises a first longitudinal part 1280 in form of a threaded element for retaining a mounting bolt, and a second longitudinal part 1282, which forms part of the anchor element. The first longitudinal part 1280 comprises a plurality of bores 1290 at an end face thereof, and the second longitudinal part 1282 comprises a plurality of bores 1292 at an end face thereof. The two longitudinal parts 1280, 1282 are connected via pins 1294 that are connected to the bores 1290, 1292 of said end faces. The pin and bore connection may for instance provide an interference fit or a friction fit, which fastens the two longitudinal parts 1280, 1282. This provides a modular bushing system, where for instance the threaded element may be a standard component, whereas the anchor element may be customised to the particular wind turbine blade type. Again, the threaded element 1280 may be made from a first material, and the anchor element 1282 may be made from a second material, where the first material has a higher strength or quality than the second material.

**[0083]** Figs. 17a and 17b illustrate an embodiment of a sectionised bushing system 1340 according to a non-claimed embodiment. The bushing system 1340 comprises a first longitudinal part 1380 in form of a threaded element for retaining a mounting bolt, and a second longitudinal part 1382, which forms part of the anchor element. The two longitudinal parts 1380, 1382 are connected via a socket connection, and the bushing system may as shown in Fig. 17b have a local thickening at the connection. This also provides a modular bushing system, where for instance the threaded element may be a standard component, whereas the anchor element may be customised to the particular wind turbine blade type. Again, the threaded element 1380 may be made from a first material, and the anchor element 1382 may be made from a second material, where the first material has a higher strength or quality than the second material.

**[0084]** In the embodiments shown in Figs. 16 and 17, the connection between the longitudinal parts may advantageously be located near the threaded part.

**[0085]** Fig. 18a illustrates a cross-section through bushing system 1440, which is made from a sheet material 1490 with application of a rolling process. The bushing system 1440 may for instance be manufactured according to the following process. The sheet may be formed from a billet. Then a tubular element is formed by rolling said sheets. Subsequently a thread may be drilled or tapped in the interior of said tubular element. The sheet 1490 may as shown be formed with an exterior surface effect, such as corrugations, in order to improve an anchoring effect to the wind turbine blade root. This can for instance be carried out by a plate being rolled with stepped or different size rollers. This embodiment provides a very simple and inexpensive method of manufacturing a bushing system. The bushing system 1440 may have a slit 1492, which extends in the longitudinal direction of the bushing system. It may be advantageous to seal the slit before the bushing system is embedded in the composite blade root so that resin does not flow into the bushing system during the infusion process. The slit 1492 may extend at the same angular position along the entire longitudinal extent of the bushing system 1440. Alternatively, the sheet material may be rolled such that the angular position of the slit 1492 varies in the longitudinal direction of the blade.

[0086] The invention has been described with reference to preferred embodiments. However, the scope of the invention is not limited to the illustrated embodiments, and alterations and modifications may be carried out without deviating from the scope of the invention, which is defined by the following claims.

List of reference numerals

2	wind turbine
4	tower
6	nacelle
8	hub
10	blade
14	blade tip
16	blade root
18	leading edge
20	trailing edge
22	pitch axis
29	root end face
30	root region
32	transition region
34	airfoil region
35	inner surface of root region
36	outer surface of root region
38	chord plane
40	fastening member, bushing
42	outer periphery of fastening member
44	first end of fastening member
46	second end of fastening member
48	fastening means, threaded bore
50	insert
52	first lateral face of insert
54	second lateral face of insert
60	wedge-shaped element
62	first end of wedge-shaped element
64	second end of wedge-shaped

	element
70	inner layer
72	outer layer
140, 240, 340, 440, 540, 640, 740, 840, 940, 1040, 1140, 1240, 1340, 1440	Bushing system
180, 280, 380, 480, 580, 680, 1280, 1380	threaded element / bolt-receiving nut
181, 281, 381, 481, 581, 681	internal thread
182, 282, 382, 482, 582, 682, 882, 1282, 1382	anchor element
184, 284, 384, 484, 584, 684	Bore
185, 285, 385, 485, 585, 685	first end / proximal end
186, 286, 386, 486, 586, 686	second end / distal end
187, 487, 587, 687	first constriction
188, 488, 588	second constriction
390	mounting bolt / stay bolt
892	bushing mouth
993	alignment bore
994	root plate
995	alignment pin
1196, 1197	outer mould parts
1198	mould core part
1290, 1292	bores
1294	pins
1490	sheet material
1492	slit
$r$	local radius, radial distance from blade root
$L$	blade length

## REFERENCES CITED IN THE DESCRIPTION

Cited references

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form part of the European patent document. Even though great care has been taken in compiling the references, errors or omissions cannot be excluded and the EPO disclaims all liability in this regard.

**Patent documents cited in the description**

- EP2554834A1 [0004]
- US2012045339A1 [0004]

Krav

1. Vindmøllevingebeøsningssystem (440, 540) til anbringelse i en rodende af en vindmøllevinge, hvor vindmøllevingebeøsningssystemet (440, 540) omfatter:
- 5           - et gevindskåret element (480, 580) til fastholdelse af en monteringsbolt til en vindmøllevinge, hvor det gevindskårne element (480, 580) er dannet af et første materiale;
- et forankringselement (482, 582) til anbringelse ved en rodendeflade (29) af vindmøllevingen, hvor forankringselementet (482, 582) virker til i det mindste delvist at fastholde det gevindskårne element (480, 580) i vindmøllevingen, hvor forankringselementet
- 10 (482, 582) er dannet af et andet materiale,
- hvor det første materiale har en højere styrke og højere brudstyrke end det andet materiale,
- hvor det gevindskårne element (480, 580) er en boltmodtagende møtrik til at modtage en monteringsbolt til en vindmøllevinge,
- 15           - hvor forankringselementet (482, 582) omfatter et rørformet element til anbringelse ved rodenden af vindmøllevingen for at fastholde det rørformede element i et vindmøllevingelegeme,
- hvor det rørformede element virker til i det mindste delvist at fastholde den boltmodtagende møtrik i vindmøllevingen,
- 20           - hvor det rørformede element omfatter en første åben ende (485, 585) til at modtage en bolt, hvor et indre kammer i det rørformede element omfatter en første indsnævring (487, 587) mellem en position for den boltmodtagende møtrik i det rørformede element og den første åbne ende for at fastholde den boltmodtagende møtrik i det rørformede element, og
- 25           - hvor det rørformede element omfatter en anden ende (486, 586) modsat den første ende, hvor et indre kammer i det rørformede element omfatter en anden indsnævring (488, 588) mellem positionen af den boltmodtagende møtrik i det rørformede element og den anden ende for at holde den boltmodtagende møtrik på plads i forhold til den anden ende af det rørformede element, hvorved den boltmodtagende møtrik er anbragt i en
- 30 indre del af det rørformede element, og således den første indsnævring og anden indsnævring sammen er tilpasset til at fastholde den boltmodtagende møtrik.

2. Vindmøllevingebeøsningssystem ifølge krav 1,

hvor den boltmodtagende møtrik fastholdes i det rørformede element ved, at det rørformede element krympes eller presformes i et område af det rørformede element for at fastholde den boltmodtagende møtrik ved nævnte område, og/eller

- 5 hvor det rørformede element er et rørelement med åben ende, og/eller hvor et tilspidset eller kileformet element er anbragt ved en distal del af det rørformede element.

3. Vindmøllevingebøsningssystem ifølge et hvilket som helst af de foregående krav, hvor  
- gevindelementet (480, 580) er lavet af et møtrikelement, der omfatter en indvendig  
10 boring med et indvendigt gevind til at modtage og fastholde en monteringsbolt, og forankringselementet (482, 582) omfatter en boring med i det mindste en første åben ende til at modtage monteringsbolten,  
- hvor møtrikelementet holdes i boringen af forankringselementet (482, 582), således at forankringselementet (482, 582) virker til at fastholde møtrikelementet i en vind-  
15 møllevinge.

4. Vindmøllevingebøsningssystem ifølge krav 3, hvor forankringselementet (482, 582) er forsynet med en blind boring, der strækker sig fra den første åbne ende til en anden lukket ende, hvor forankringselementet (482, 582) yderligere omfatter en tilspidset eller  
20 kileformet del ved den anden lukkede ende, eksempelvis hvor møtrikelementet yderligere omfatter et udvendigt gevind, hvor et indvendigt gevind er defineret på i det mindste en del af boringen i forankringselementet (482, 582), hvor det indvendige gevind af forankringselementet (482, 582) er indrettet til at modtage i det mindste en del af det udvendige gevind på møtrikelementet.

- 25 5. Vindmøllevingebøsningssystem ifølge et hvilket som helst af kravene 3-4, hvor forankringselementet (482, 582) omfatter en første del og en anden del, hvor den første del i det væsentlige omfatter et rørformet element med en indre gennemgående boring, idet den anden del i det væsentlige omfatter et tilspidset eller kileformet element, hvor den  
30 første del og den anden del er forbundet for at danne forankringselementet (482, 582).

6. Vindmøllevingebøsningssystem ifølge krav 5, hvor den første del og den anden del er forbundet via møtrikelementet, og/eller  
hvor  
35 - den første del omfatter en gennemgående boring med et indvendigt gevind formet i boringen,

- den anden del omfatter en blind boring med et indvendigt gevind formet i boringen,  
og

- møtrikelementet yderligere omfatter et udvendigt gevind,

- hvor de respektive indvendige gevind af den første og anden del modtages på det  
5 udvendige gevind af møtrikelementet for at forbinde den første og anden del til møtrik-  
elementet, og/eller

hvor den første og/eller den anden del kan være presformet eller smedet på mø-  
trikelementet for at forbinde den første og anden del med møtrikelementet.

10 7. Vindmøllevingebøsningssystem ifølge et hvilket som helst af de foregående krav, hvor  
forankringsdelen omfatter i det mindste en første rørformet del, der omgiver en anden  
rørformet del.

8. Vindmøllevingebøsningssystem ifølge et hvilket som helst af de foregående krav, hvor  
15 bøsningssystemet omfatter en bøsningmunding, som er fremstillet af et tredje materi-  
ale.

9. Vindmøllevingebøsningssystem ifølge et hvilket som helst af de foregående krav, hvor  
forankringselementet (482, 582) omfatter et metallisk rør, fortrinsvis dannet af en hvilken  
20 som helst af eller en kombination af de følgende materialer: stål, aluminium, kobber.

10. Vindmøllevingebøsningssystem ifølge et hvilket som helst af de foregående krav,  
hvor bøsningssystemet omfatter en ydre overflade, hvilken ydre overflade har en over-  
fladevirkning til at forbedre fastholdelsen af bøsningssystemet i rodenden af en vindmøl-  
25 levinge,

eksempelvis hvor overfladeeffekten kan omfatte en hvilken som helst kombination  
af riller, ondulationer, gevind, korrugeringer, ribber eller krusninger på den ydre overflade  
af bøsningssystemet.

30 11. Vindmøllevingebøsningssystem ifølge krav 10, hvor overfladeeffekten omfatter en  
formet tværsnitsprofil på den ydre overflade, hvor en første række ondulationer med en  
første rumlig frekvens er tilvejebragt på den ydre overflade af det rørformede element,  
og hvor den første række af ondulationer er moduleret med en anden række af bølger  
med en anden rumlig frekvens, hvor den anden rumlige frekvens er højere end den første  
35 rumlige frekvens,



eksempelvis hvor en højde eller amplitude af den første række af ondulationer er i det mindste den samme størrelse som en højde eller amplitude af den anden række af ondulationer.

- 5 12. En vindmøllevinge omfattende en tipende og en rodende, hvor vindmøllevingen omfatter en flerhed af bøsningssystemer (440, 540) placeret ved rodenden til modtagelse en monteringsbolt, hvor hvert bøsningssystemet (440, 540) omfatter:
- et gevindskåret element (480, 580) til at fastholde en monteringsbolt til en vindmøllevinge, hvor det gevindskårne element (480, 580) er dannet af et første materiale;
- 10 og
- et forankringselement (482, 582) til anbringelse ved en rodendeflade (29) af vindmøllevingen, hvor forankringselementet (482, 582) virker til i det mindste delvist at fastholde det gevindskårne element (480, 580) i vindmøllevingen, hvor forankringselementet (482, 582) er dannet af et andet materiale,
- 15 - hvor det første materiale har en højere styrke og højere brudstyrke end det andet materiale,
- hvor det gevindskårne element (480, 580) er en boltmodtagende møtrik til at modtage en monteringsbolt til en vindmøllevinge,
  - hvor forankringselementet (482, 582) omfatter et rørformet element til anbringelse
- 20 ved rodenden af vindmøllevingen for at fastholde det rørformede element i et vindmøllevingelegeme,
- hvor det rørformede element virker til i det mindste delvist at fastholde den boltmodtagende møtrik i vindmøllevingen,
  - hvor det rørformede element omfatter en første åben ende (485, 585) til at mod-
- 25 tage en bolt, hvor et indre kammer i det rørformede element omfatter en første indsnævring (487, 587) mellem en position for den boltmodtagende møtrik i det rørformede element og den første åbne ende for at fastholde den boltmodtagende møtrik i det rørformede element, og
- hvor det rørformede element omfatter en anden ende (486, 586) modsat den første
- 30 ende, hvor et indre kammer i det rørformede element omfatter en anden indsnævring (488, 588) mellem positionen for den boltmodtagende møtrik i det rørformede element og den anden ende for at holde den boltmodtagende møtrik på plads i forhold til den anden ende af det rørformede element, hvorved den boltmodtagende møtrik er anbragt i en indre del af det rørformede element, og således at den første indsnævring og anden
- 35 indsnævring i forbindelse er tilpasset til at fastholde den boltmodtagende møtrik.

13. Fremgangsmåde til fremstilling af et vindmøllevingebøsningssystem (440, 540), hvor fremgangsmåden omfatter trinene til:

a) tilvejebringelse af et gevindskåret element (480, 580) til at fastholde en monteringsbolt til en vindmøllevinge, hvor det gevindskårne element (480, 580) er dannet af et første materiale;

b) tilvejebringelse af et forankringselement (482, 582) til anbringelse ved en rodendeflade (29) af vindmøllevingen, hvor forankringselementet (482, 582) er dannet af et andet materiale, og

c) montering af det gevindskårne element (480, 580) til forankringselementet (482, 582), således at forankringselementet (482, 582) virker til i det mindste delvist at fastholde det gevindskårne element (480, 580) i vindmøllevingen,

- hvor det første materiale har en højere styrke og brudstyrke end det andet materiale,

- hvor det gevindskårne element (480, 580) er en boltmodtagende møtrik til at modtage en monteringsbolt til en vindmøllevinge,

- hvor forankringselementet (482, 582) omfatter et rørformet element til anbringelse ved rodenden af vindmøllevingen for at fastholde det rørformede element i et vindmøllevingelegeme,

- hvor det rørformede element virker til i det mindste delvist at fastholde den boltmodtagende møtrik i vindmøllevingen,

- hvor det rørformede element omfatter en første åbne ende (485, 585) til at modtage en bolt, hvor et indre kammer i det rørformede element omfatter en første indsnævring (487, 587) mellem en position for den boltmodtagende møtrik i det rørformede element og den første åbne ende for at fastholde den boltmodtagende møtrik i det rørformede element, og

- hvor det rørformede element omfatter en anden ende (486, 586) modsat den første ende, hvor et indre kammer i det rørformede element omfatter en anden indsnævring (488, 588) mellem positionen for den boltmodtagende møtrik i det rørformede element og den anden ende for at holde den boltmodtagende møtrik på plads i forhold til den anden ende af det rørformede element, hvorved den boltmodtagende møtrik er anbragt i en indre del af det rørformede element, og således at den første indsnævring og anden indsnævring i forbindelse er tilpasset til at fastholde den boltmodtagende møtrik.

14. Fremgangsmåde ifølge krav 13, hvor monteringen i trin c) udføres af i det mindste en del af det ydre af det rørformede element for at fastgøre den boltmodtagende møtrik

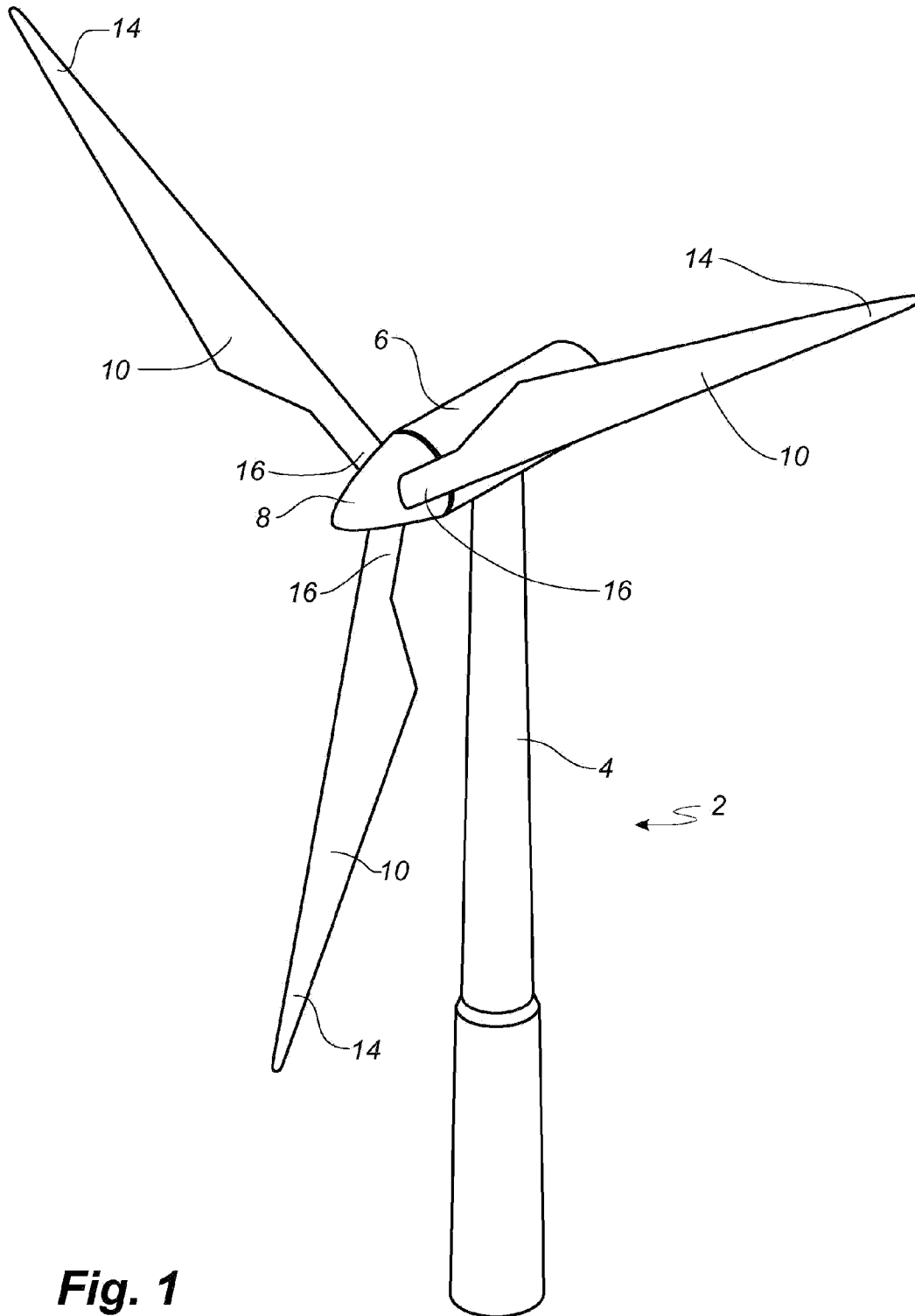
i det indre af det rørformede element for at danne et bøsningssystem at modtage en monteringsbolt til en vindmøllevinge,

eventuelt hvor fremgangsmåden omfatter trinnet til overfladebehandling af en ydre overflade af det rørformede element for at forbedre fastholdelsen af bøsningssystemet i

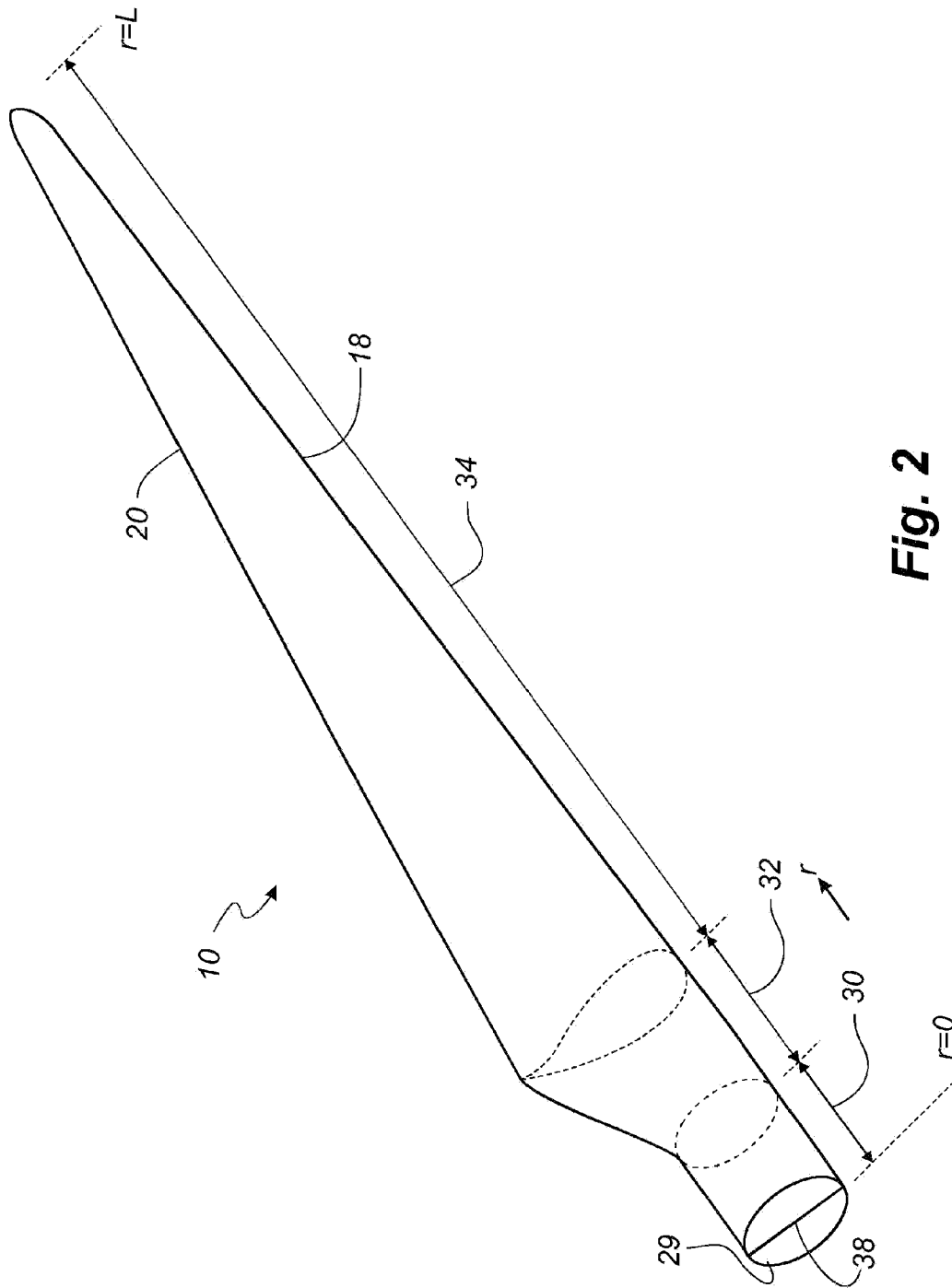
5 en rodende af en vindmøllevinge,

eksempelvis hvor trinnet med overfladebehandling omfatter tilvejebringelse af riller, bølger, slidbaner på udvendig overflade.

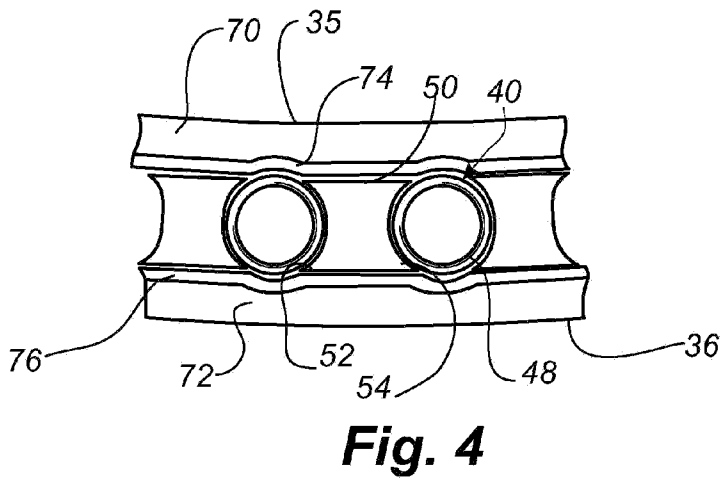
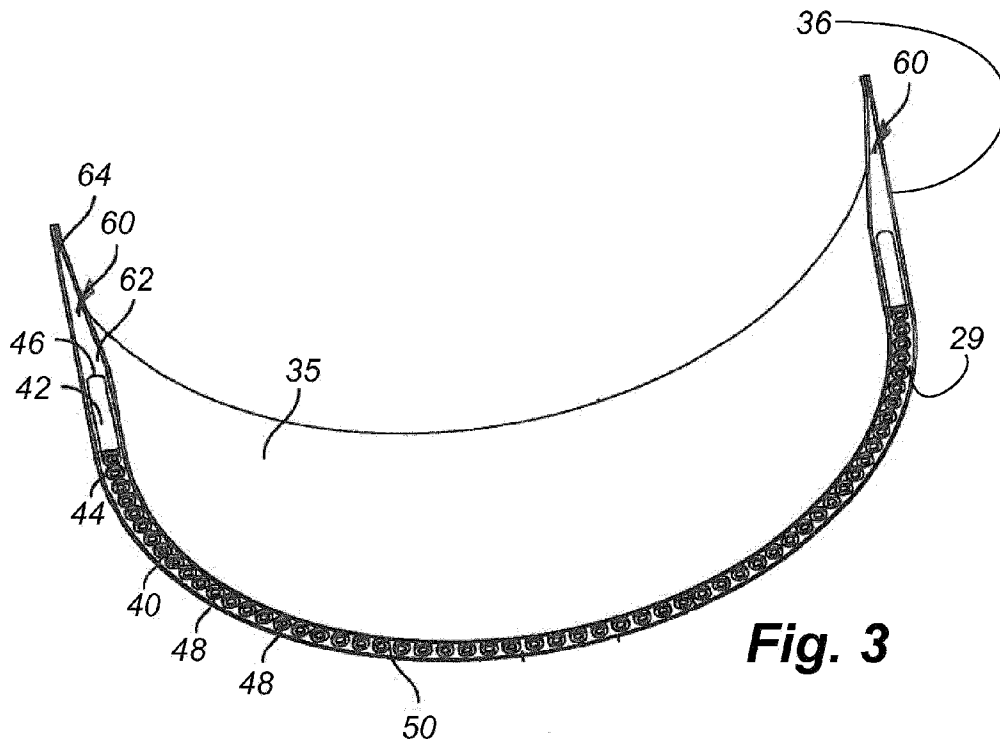
**DRAWINGS**

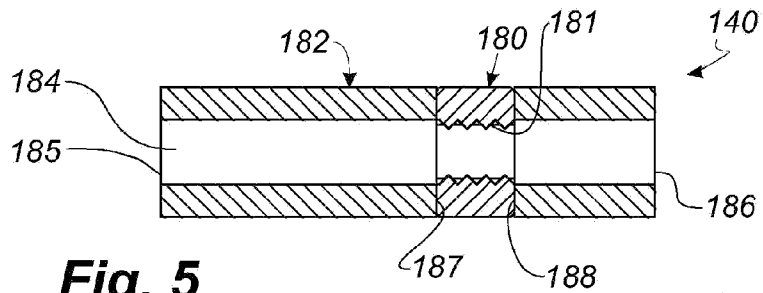


**Fig. 1**

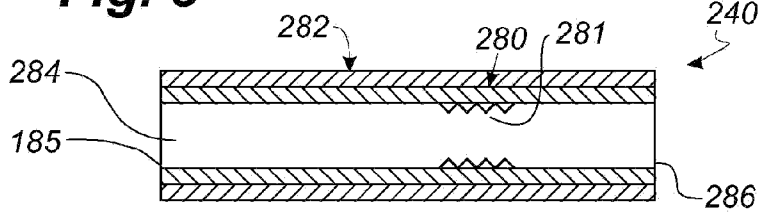


**Fig. 2**

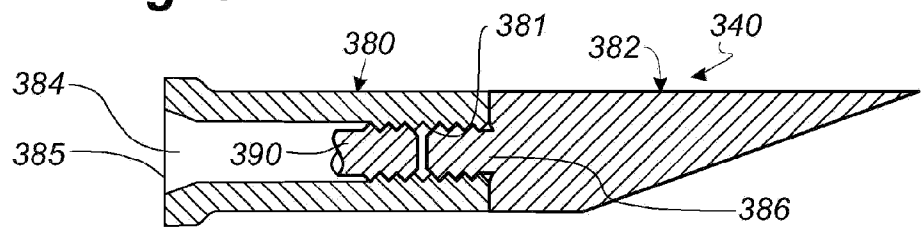




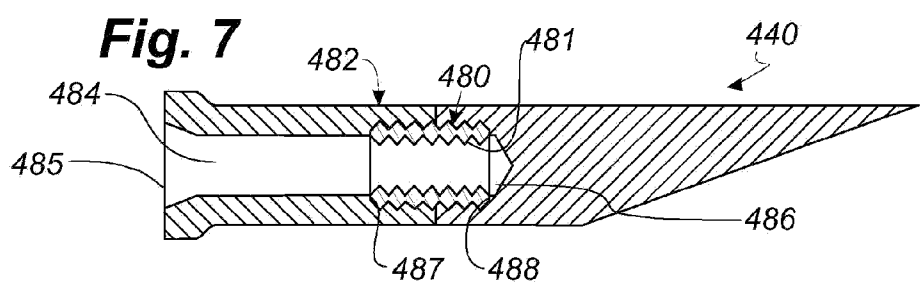
**Fig. 5**



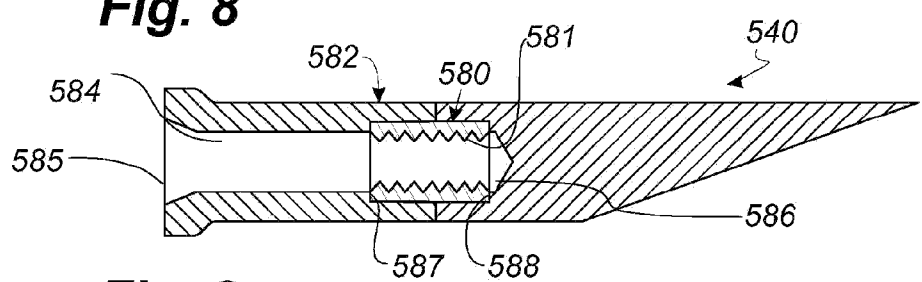
**Fig. 6**



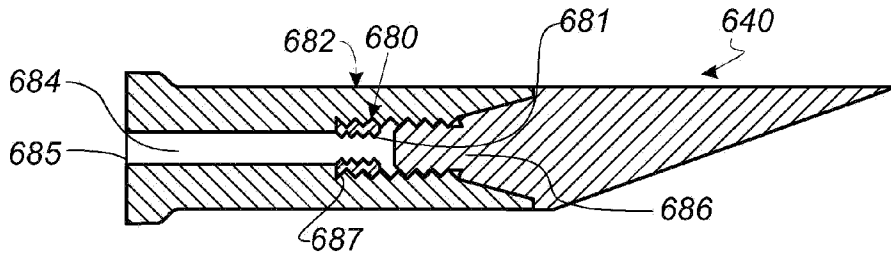
**Fig. 7**



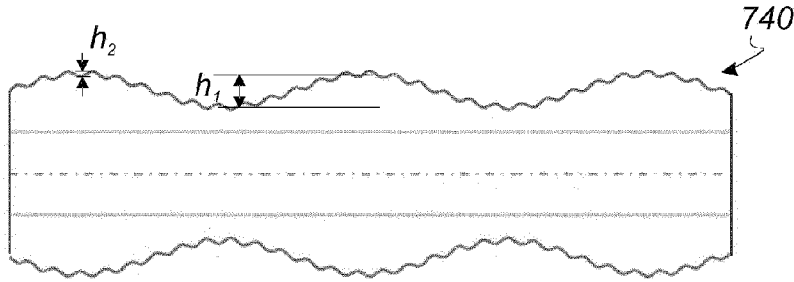
**Fig. 8**



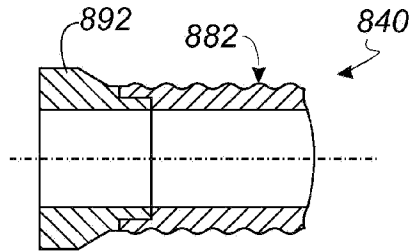
**Fig. 9**



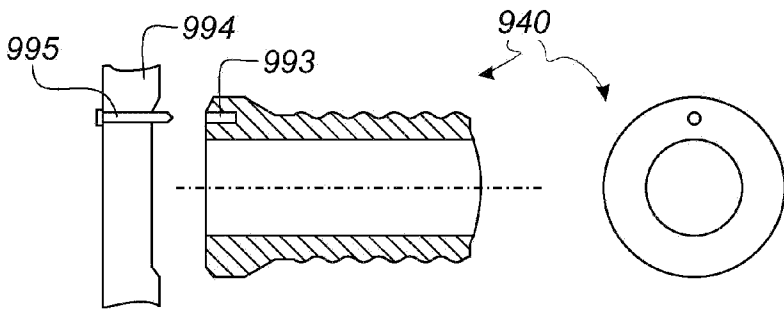
**Fig. 10**



**Fig. 11**



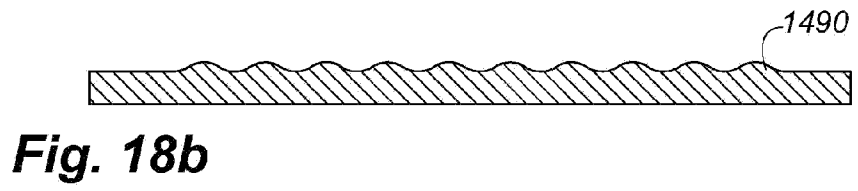
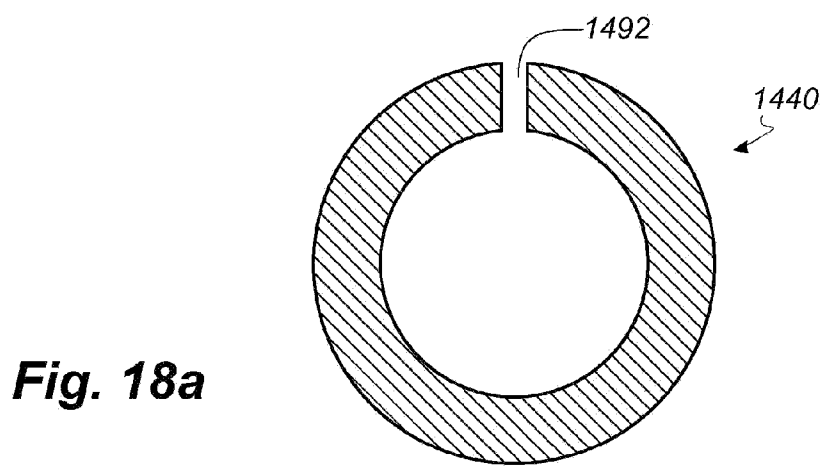
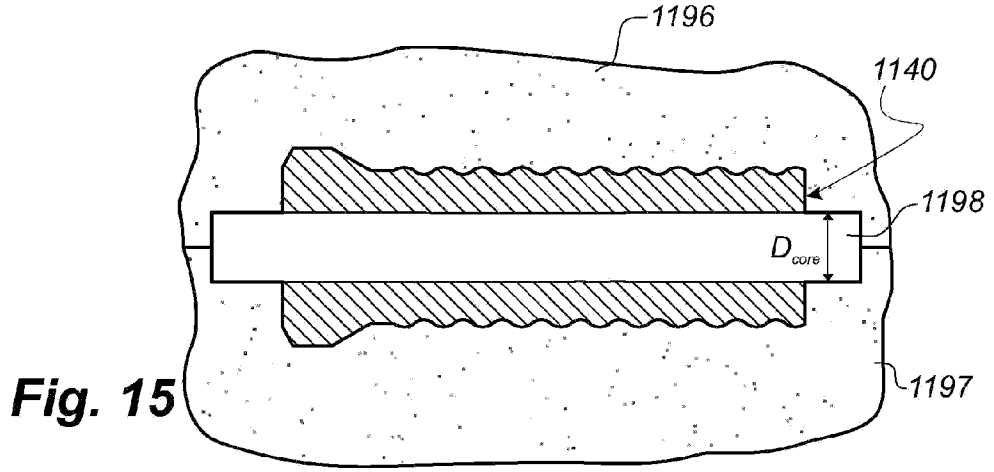
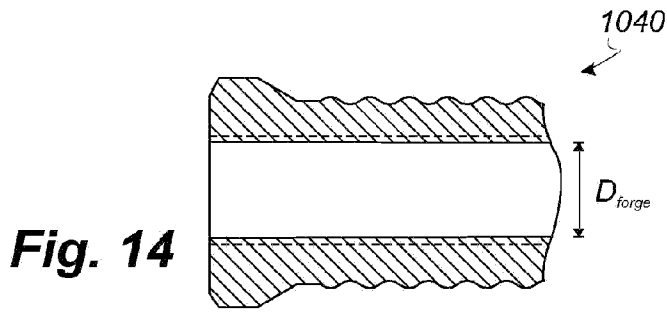
**Fig. 12**

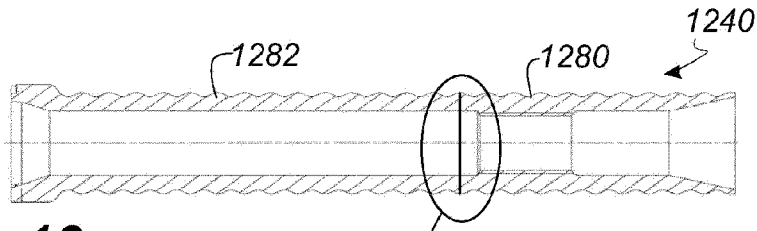


**Fig. 13a**

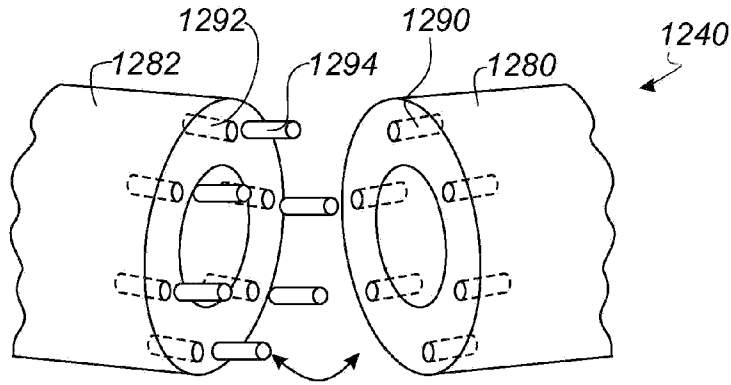
**Fig. 13b**



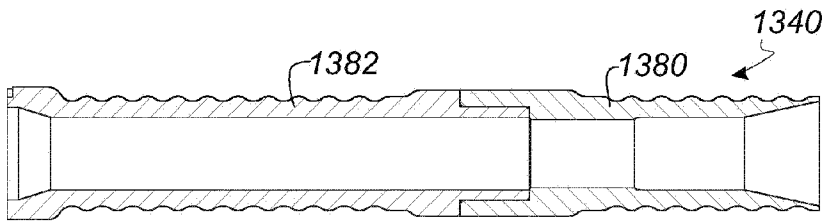




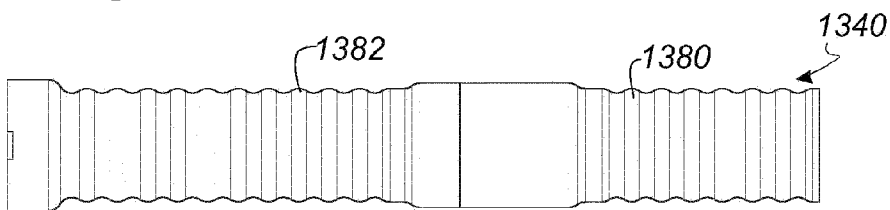
**Fig. 16a**



**Fig. 16b**



**Fig. 17a**



**Fig. 17b**