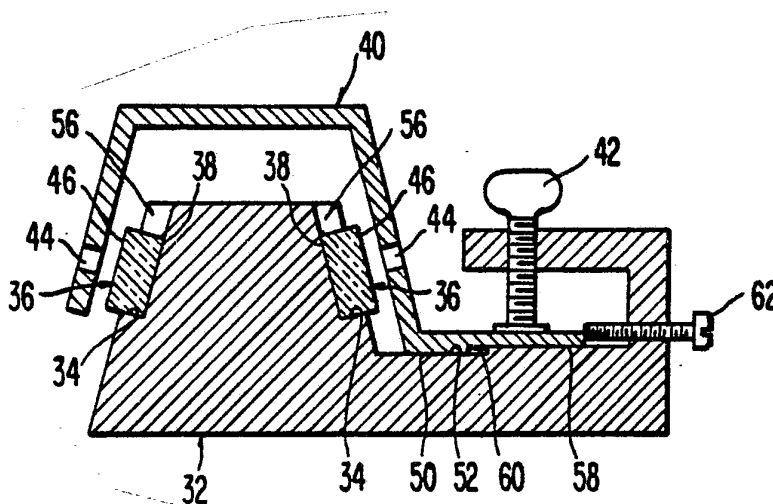




## INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

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(54) Title: METHOD AND APPARATUS FOR PRODUCING FOLDED OPTICAL PATH DEVICES



## (57) Abstract

Method and apparatus for the lowest cost assembly of precision optical devices utilizing single or multiple bounces. The apparatus makes use of a precision machined alignment platform (32) to support optical mirrors (34) in precise alignment. A low cost holding structure (40) is clamped over the alignment platform to position one of a plurality of connected sections adjacent to the back of each mirror. An adhesive (48) is injected through holes (44) provided in the holding structure adjacent to the back of each mirror. The adhesive bridges each mirror to the holding structure in a position corresponding exactly to the position of the mirrors on the alignment platform, thereby eliminating any need to adjust the mirrors for correct alignment.

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METHOD AND APPARATUS FOR PRODUCING FOLDED OPTICAL PATH  
DEVICES

Background of the Invention

A. Field of the Invention

5 This invention relates in general to an apparatus and method for assembling optical path folding devices. More particularly, the present invention relates to an apparatus and method for manufacturing low cost, precision optical devices which utilize single or multiple bounces.

B. Prior Art

10 In the prior art, various assemblies have been utilized to mount and align optical mirrors for use in single or multiple bounce optical path folding devices.

15 FIG. 1 shows one prior art system utilized to mount and align mirrors. In this system, the assembly 10 is formed from two identical subassemblies 12 which are joined together by appropriate means along the overlapping portions of frame members 14. A mirror holding member 16 is pivotably mounted to support 18 as shown. A mirror 20 is bonded to each mirror holding



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member 16 by means of a suitable adhesive 22. In such a prior art system, each mirror 20 may be pivoted in order to achieve accurate optical alignment.

5 The prior art system of FIG. 1 suffers from two major drawbacks. The system is mechanically complex and its production cost is not appropriate for use in low cost optical systems. The second drawback is in the time consuming and therefore costly alignment procedures required to achieve accurate optical alignment of the  
10 mirrors 20.

FIG. 2 shows another prior art system known as replication. Replication is typically used in precision optic devices where repeatability and large production quantities are required. In this system, a  
15 reflective coating 26 is bonded via an adhesive to a precision machined surface 28 on holding structure 30. The reflective coating 26 is very thin and of a uniform thickness. The quality of the surface 28 reflects the quality of the mirrored surface obtained after the  
20 reflective coating 26 is bonded to surface 28. Therefore, the surface 28 to which the coating 26 is bonded must be accurately machined to assure optical alignment of the completed assembly. The main drawback of replication is that the process is costly and time consuming.

25 It is the general object of the present invention to overcome the above-mentioned drawbacks of the prior art by providing an improved apparatus and method for assembling folded optical path folded mirror systems.

30 It is another object of the present invention to provide a repeatable and low cost method and apparatus for producing precision aligned folded optical path mirror systems.

35 It is a further object of the present invention to provide a method and apparatus for assembling folded optical path mirror optical systems without the need to adjust the mirrors for proper alignment.



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It is an additional object of the present invention to provide an apparatus and method for producing optical mirror systems utilizing inexpensive mechanical substrates.

5           These and other objects, features and advantages of the present invention will become more apparent from the detailed description of the preferred embodiment when read in conjunction with the drawings.

Summary of the Invention

10           According to the invention, a system and method is provided for mounting optical mirrors to a holding structure without the need for adjusting the mirrors to obtain optical alignment.

15           The system includes an alignment platform having precision machined recesses to support a plurality of mirrors in precise optical alignment with each other. A holding structure is positioned over the alignment platform and clamped against a reference surface of the alignment platform. The holding structure includes  
20           connected sections which are thereby positioned adjacent to, but not in contact with the backs of the mirrors.

25           A hole is provided in the holding structure section adjacent to the back of each mirror. An adhesive is injected through each hole and bridges the gap between the back of each mirror and the adjacent holding structure section. After the adhesive cures, the clamp is released and the assembled holding structure is removed.

30           In the completed holding structure, the mirrors are permanently connected to the holding structure in precise optical alignment with each other. At this point, the completed holding structure is ready for installation in the optical system of a using device.



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Brief Description of the Drawings

FIG. 1A is a side view of a prior art system used to mount and align mirrors.

5 FIG. 1B is a front view of the prior art system of FIG. 1A.

FIG. 2A is a side view of the prior art replication system used to produce precision optic devices.

FIG. 2B is an enlarged view of a portion of FIG. 2A.

10 FIG. 3 is a pictorial view of the present system for producing aligned optical systems.

FIG. 4 is a section view of FIG. 3 taken along the lines 4-4.

15 FIG. 5 is a side view, with portion broken away, of the assembled mirror holding structure produced by the present system.

Description of the Preferred Embodiment

The present invention provides a system for mounting optical mirrors on a holding unit. The mirrors  
20 are mounted in the exact position required for use in a using optical system, such as a folded mirror system used in some facsimile equipment or a camera-like scanner for digitizing images from a sheet of paper. The assembled holding unit is designed to be installed within the using  
25 optical system.

FIGS. 3 and 4 show the preferred embodiment of the alignment/assembly system of the present invention. FIG. 5 shows a completely assembled and aligned holding unit ready for installation in the using optical system.

30 The key element of the alignment/assembly system is alignment platform 32. Alignment platform 32 may be fabricated from steel or another suitable material which is not susceptible to warping. Cavities 56 in platform 32 are positioned to support a pair of mirrors 36 in correct  
35 alignment with each other in accordance with the



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requirements of the using optical system in which the assembled holding unit will be installed. Those skilled in the art will therefore appreciate that the positions of the mirrors 36 will vary depending on the using optical system the completed holding unit will be installed in.

The mirrors 36 are placed in the cavities 56 with their reflective surfaces 38 facing inward as shown. The mirrors 36 are supported in their aligned positions by the surfaces 34 of cavities 56. No additional means are utilized to hold the mirrors 36 on the platform 32. The surfaces 34 of cavities 56 are precisely machined so that the mirrors 36 are supported at the exact optical alignment required by the optical system in which they will be used.

After the mirrors 36 are positioned on platform 32, a mirror holding structure 40 is positioned over the platform 32. The holding structure 40, after having the mirrors 36 mounted to it, will provide an optically aligned mirror subsystem which can then be installed in a using device as part or all of its optical system. In the preferred embodiment, the holding structure 40 is fabricated from extruded aluminum. However, those skilled in the art will appreciate that the holding structure may alternatively be fabricated from sheet metal or other suitable materials.

In the preferred embodiment, the holding structure 40 is longitudinally aligned with the alignment platform 32 via a bar shaped member 58 on the surface 52 of platform 32 which mates with a slot 60 in the base 50 of holding unit 40. The holding structure 40 is thus positioned on the platform 32 with slot 60 and bar 58 slidably mated. In such a position, the holding structure



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40 is longitudinally fixed with respect to the platform 32, but may be slid back and forth in the orthogonal direction.

Screw 62 provides a stop against which the holding unit 40 may be slid in order to achieve equal spacing between the backs 46 of mirrors 36 and the adjacent sides of holding structure 40. In practice, screw 62 need only be adjusted the first time a set of mirrors 36 is mounted to a holding structure 40.

Those skilled in the art will appreciate that alternate mechanisms may be utilized to longitudinally align the holding structure with respect to platform 32 and to achieve equal spacing.

With the holding structure 40 positioned over the platform 32 as shown in FIGS. 3 and 4, clamp 42 is engaged to securely hold the holding structure 40 at the required longitudinal alignment and spacing. Next, a suitable adhesive 48 is injected through holes 44 which pass through the holding structure 40. A sufficient quantity of adhesive 48 is injected to bridge the gaps between the surfaces 46 of mirrors 36 and the opposed surface of holding structure 40. In the preferred embodiment, a urethane adhesive is utilized. The adhesive 48 is then allowed to cure, after which the clamp 42 is loosened and the completed holding structure 54 (FIG. 5) is removed from the platform 32.

As shown in FIG. 5, the mirrors 36 are permanently mounted to the completed holding structure 54 in the precise optical alignment required by the using optical system. Therefore, no further adjustment of the mirrors 36 is required in order for them to be in alignment. The completed holding structure 54 is now ready for installation in the using device.





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It should be appreciated that the holding structure 40 need not be precisely machined since it does not effect the alignment of the mirrors. Instead, the holding structure indirectly supports the mirrors 36 which are in alignment due to the adhesive 48 filling the gaps between the prealigned mirrors 36 and the holding structure 40.

Those skilled in the art will appreciate that if the clamping surface 52 of platform 32 is used as the reference surface for machining the remainder of the platform 32, then the surface 50 of holding structure 40 will be precisely located with respect to the mirror surfaces 38. This will allow the surface 50 of the holding structure 40 to be used for mounting other components in the optical path of the using system.

Although the preferred embodiment has only considered a system for assembling a holding system employing two mirrors 36, those skilled in the art will appreciate tht the system may readily be modified to facilitate the mounting and alignment of a single mirror or more than two mirrors at various positions required for optical alignment in the using system.

Further, those skilled in the art will appreciate that the system may be used to mount both optical and nonoptical elements in addition to mirrors.

Having shown and described the preferred embodiment of the present invention, those skilled in the art will realize that various omissions, substitutions and changes in forms and details may be made without departing from the spirit of the invention. It is the intention, therefore, for the invention to be limited only as indicated by the scope of the following claims.



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What is claimed is:

1. A system for mounting optical elements, comprising:

alignment platform means for supporting said optical elements;

5 holding means, mountable on said alignment platform means, said holding means including means to accept a bridging means, said bridging means for interconnecting said optical elements and said holding means.

2. The system in accordance with claim 1 wherein said alignment platform means includes:

means for supporting said optical elements in aligned position; and

5 means for clamping said holding means on said alignment platform means.

3. The system in accordance with claim 2 wherein said support means includes a member having a first recess, said first recess having a first semivertical wall and a first connected semihorizontal platform, wherein a first one  
5 of said optical elements may be supported in said aligned position by said first recess.



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4. The system in accordance with claim 3 wherein said member has a second recess, said second recess having a second semivertical wall and a second connected semihorizontal platform, wherein a second one of said optical elements may be supported in said aligned position by said second recess.

5. The system in accordance with claim 4 wherein said first and second recesses are positioned with respect to each other such that said supported first and second optical elements are optically aligned.

6. The system in accordance with claim 5 wherein the surfaces of said first and second recesses are precision machined to the exact tolerances required to obtain optical alignment of the supported optical elements.



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7. The system in accordance with claim 3 wherein said bridging means is an adhesive.

8. The system in accordance with claim 7 wherein said holding means includes:

a frame having a first side, said first side positioned adjacent to and in spaced relationship with said first optical element when said holding means is mounted on said alignment platform means; and

wherein a first hole passes through said first side at a point opposite said first optical element, whereby said adhesive may be injected through said first hole to bridge together said first side and said first optical element and thereby hold said first optical element in the same position that said first optical element is supported at.

9. The system in accordance with claim 8 further including means for longitudinally aligning said holding means with said alignment platform means, whereby said first hole is positioned at said point opposite said first optical element.

10. The system in accordance with claim 9 further including means for adjusting the amount of space between said first side and said first optical element.



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11. The system in accordance with claim 8 wherein said first optical element is a mirror, said mirror supported by said first recess with its face against said first semivertical wall.

12. The system in accordance with claim 4 wherein said bridging means is an adhesive.

13. The system in accordance with claim 12 wherein said holding means includes a frame, said frame including a semi-U-shaped section, said frame mountable over said alignment platform means with each of said  
5 frame's legs adjacent to and in spaced relationship with one of said optical elements; and

wherein a hole passes through each of said legs at a point opposite the adjacent optical element, whereby said adhesive may be injected through each of  
10 said holes to bridge the space between and thereby join together each of said legs and its respective adjacent optical element.

14. The system in accordance with 13 wherein each of said optical elements is a mirror, each mirror supported by one of said recesses with its face against the respective recess's semivertical wall.



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15.           The system in accordance with Claim 14 wherein said frame further includes a clamping section extending from the end of one of said legs, said clamping section engaged by said clamping means to hold said holding means on said alignment platform means, said clamping section having a groove in its bottom, said groove slidably mating with a bar mounted on said alignment platform means.

16.           An assembly for holding at least two optical elements in precise alignment, comprising:  
a U-shaped frame, each one of said optical elements positioned in spaced relationship adjacent to the inner surface of one of the legs of said U-shaped frame, each of said optical elements held in said spaced relationship by a quantity of adhesive, said adhesive filling the space between each of said optical elements and its adjacent leg.

17.           The assembly in accordance with claim 16 wherein each leg has a hole through it, each of said holes adjacent to its respective optical element, each of said holes for receiving said adhesive, said adhesive injected into each of said holes so it flows through the hole and bridges the gap between each of said legs and the adjacent optical element.



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18. The assembly in accordance with claim 17 wherein each of said optical elements is a mirror, the back side of each mirror facing the inner surface of each mirror's adjacent leg, each of said mirrors positioned so it is optically aligned.

19. A method of connecting optical elements to a holding frame so the optical elements are optically aligned, said method comprising the steps of:

a - positioning said optical elements on an alignment platform so they are in optical alignment;

b - positioning said holding frame over and in spaced relationship to said aligned optical elements; and

c - injecting an adhesive through holes in the holding frame so that the adhesive flows between each of said optical elements and an adjacent section of said holding frame.

20. The method in accordance with claim 18 further including the following additional steps between said steps b and c:

d - longitudinally aligning said holding frame with respect to said alignment platform;

e - clamping said holding frame in its position relative to said aligned optical elements.



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21. The method in accordance with claim 20 further including the following additional steps after said step c:

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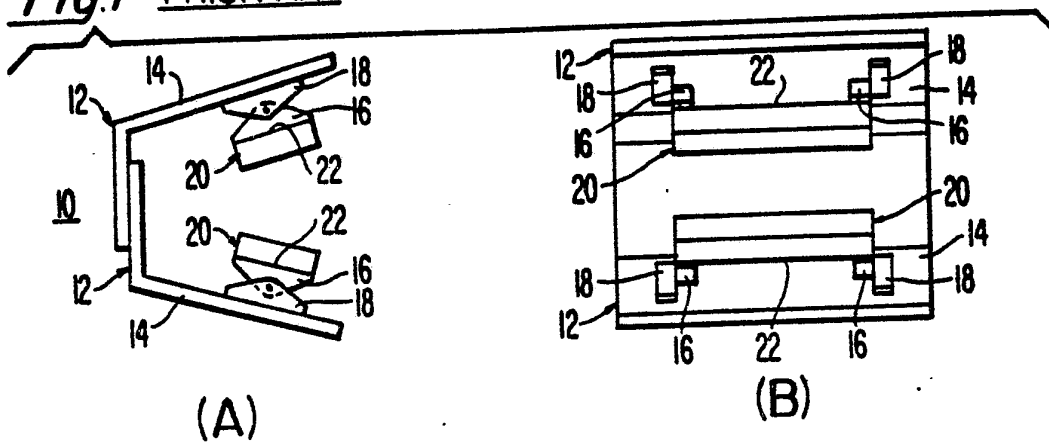
- f - allowing said adhesive to cure;
- g - unclamping said holding frame.



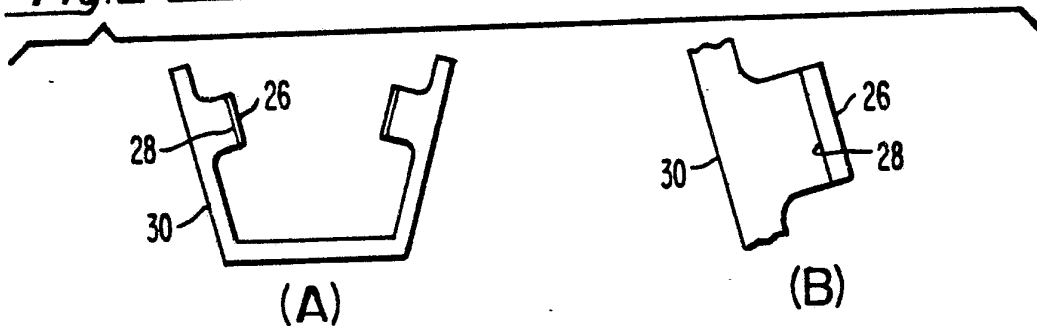


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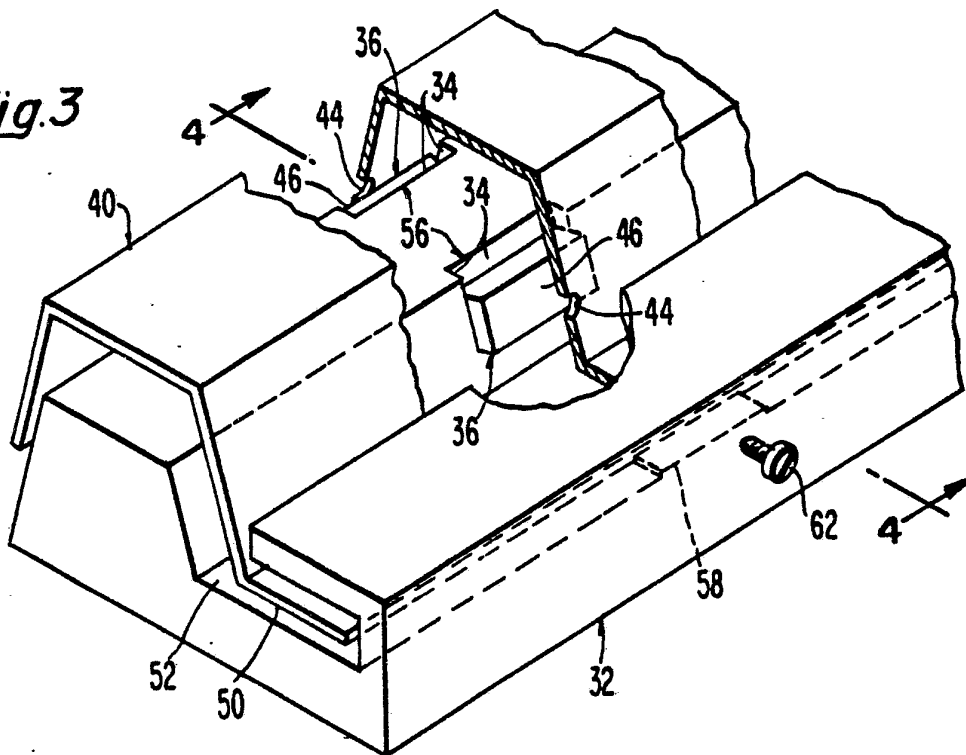
**Fig. 1** PRIOR ART



**Fig. 2** PRIOR ART



**Fig. 3**



SUBSTITUTE SHEET



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Fig.4

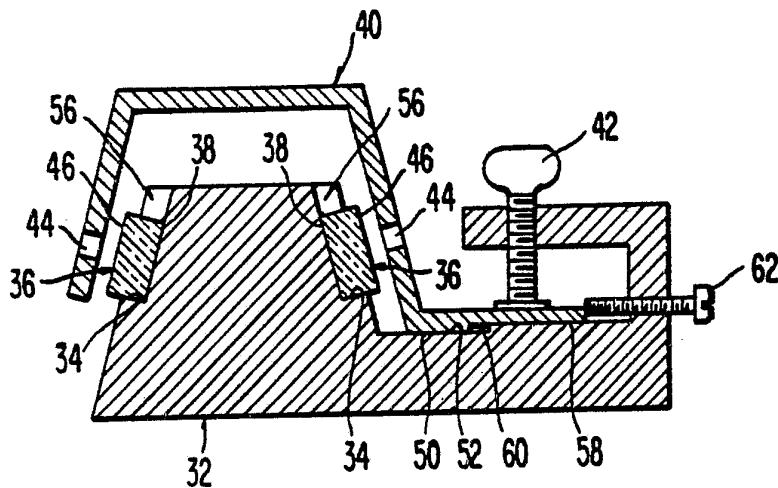
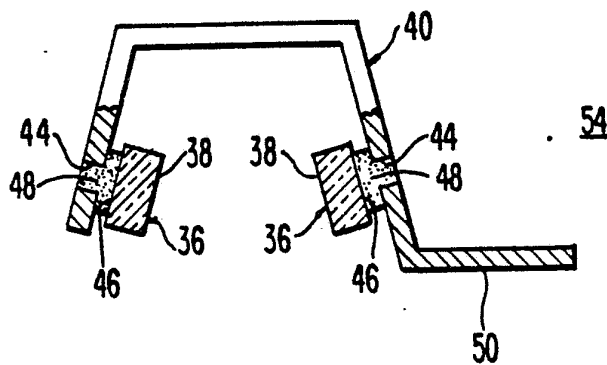


Fig.5



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# INTERNATIONAL SEARCH REPORT

International Application No **PCT/US84/01782**

<b>I. CLASSIFICATION OF SUBJECT MATTER</b> (if several classification symbols apply, indicate all) <sup>3</sup>		
According to International Patent Classification (IPC) or to both National Classification and IPC		
INT. CL. <sup>3</sup> G02B 07/18, ; B23Q 03/00; B29D 11/00; B32B 31/06. US. CL. 350/299, 320; 264/1.9, 261; 269/303		
<b>II. FIELDS SEARCHED</b>		
Minimum Documentation Searched <sup>4</sup>		
Classification System	Classification Symbols	
US	350/299, 287, 288, 320; 369/40, 303, 249; 364/1.7, 1.9, 261; 249/93.	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched <sup>5</sup>		
<b>III. DOCUMENTS CONSIDERED TO BE RELEVANT</b> <sup>14</sup>		
Category <sup>a</sup>	Citation of Document, <sup>16</sup> with indication, where appropriate, of the relevant passages <sup>17</sup>	Relevant to Claim No. <sup>18</sup>
X	US, A, 4,277,141, 07 July 1981, Kleiber	1-7 + 12
Y	US, A, 2,420,606, 13 May 1947, McLeod	3-6 + 11
A	US, A, 4,367,014, 04 January 1983, Howden	8, 13 +17
Y	FR, A, 924,998, 17 March 1947, Int. Polaroid Corp.	8, 13 +17
Y	US, A, 4,143,869, 13 March 1979 Paterson et al.	1 + 2
A	US, A, 3,175,249, 30 March 1965, Ferreira	1
<p>* Special categories of cited documents: <sup>15</sup></p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.</p> <p>"&amp;" document member of the same patent family</p>		
<b>IV. CERTIFICATION</b>		
Date of the Actual Completion of the International Search <sup>2</sup>	Date of Mailing of this International Search Report <sup>2</sup>	
27 NOVEMBER 1984	07 DEC 1984	
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