

Description

Technical Field

The present invention relates to an apparatus and a method in the field of metal finishing, most particularly the finish machining of the tips of airfoils for gas turbine engines according to the pre-characterizing part of claims 1 and 5 (see US—A 4 028 788).

A gas turbine engine is comprised of a multiplicity of airfoils having relative motion with respect to static parts of the machine. By way of illustration, a blade from the turbine section, such as is shown in Figs. 1 and 2 is mounted in a rotating disk. The tip of the blade is very closely positioned within the inside diameter of portions of the engine case or housing and from time to time contacts same. Due to this and other destructive forces in the engine environment the blade tip will deteriorate. In the normal course of events it is desirable to refurbish such worn components, and to this end it is common to add material, such as by welding, to the tip. Thereafter it is necessary to machine the tip to restore the airfoil to substantially the dimension of a new replacement part. One method of doing this, used with new parts, comprises the placing of the blade in a rotating fixture somewhat similar to the engine disk and contacting the tips with a grinding wheel placed at a circumferential point such as is common with new parts. But owing to the multiplicity of different part designs which a typical airfoil repair facility must handle, this approach is economically unattractive and requires large machines. Of course, when blade tips are weld repaired there will be a tendency within a particular design for the amount of material being added to vary, and thus the amount of material which must be removed will vary.

The needs of gas turbine airfoil repair facilities have been recognized in the past, and much preference has been given to the familiar process of abrasive belt machining since turbine blades which are comprised of difficult to machine superalloys. By way of example, US—A 4,028,788 discloses a machine wherein a component is contacted with a moving belt riding in a concave shoe, to produce a contoured airseal. The inventor herein, in his copending US—A 4 258 108, discloses another type of machine and method for refinishing turbine airfoils having outer shrouds with thin airseals; method involves the use of a contoured roller. However, the method in US—A 4 258 108 is not suited for finishing parts which have a substantial thickness as do blades such as shown in Figure 1. In US—A 4,065,879 is disclosed a means for resurfacing a gas turbine vane using an abrasive belt and a cam and cam follower which guides the belt along the complex contour of the vane. The abrasive is constantly controlled by the cam and in contact with the contoured airfoil (but not the tip). Similarly, US—A 4,051,636, discloses a method for airfoil abrasive contouring using a master pattern and mechanical copy machine principles. Thus, it may

be said that abrasive belt machines are well known. And of course they are adapted to refinishing airfoils held in small fixtures or by hand, as well as under the control of cams and the like.

However, the machines of the prior art in many instances have the disadvantage of not being specifically adapted to the finishing of gas turbine airfoil tips and therefore are not highly productive. And the machines in the prior art which are adapted to machining gas turbine airfoils, either are not suited to producing the precise contour necessary in a turbine blade, or will not be productive of sufficient output to minimize the cost. For example, the machine of US—A 4 285 108 is only readily adapted to finishing a rather thin straight airseal. Examination of that machine and Figures 1 and 2 herein will reveal that an unwanted concave surface will result at the tip.

There are other problems for which the solutions are not evident in such machines as either exist or may be obvious. One is sensing when the tip is finished so that the operator, or automatic mechanism as the case may be, will know to remove the part and start the next. Sparks and visual indication of material removal continue to be produced in abrasive machining for sometime after the part is substantially finished, even when substantial further removal of material is prevented by a device such as a cam. Another problem is that the length of the blades which are being finished may vary substantially insofar as the amount of excess material to be removed. Therefore, a machine in which the motion is entirely controlled by a cam or other unitary type of motion needs to be operated for machining and material removal at the point in space where the greatest excess tip material will lie, i.e., when the longest part is encountered. But such a machine will be relatively inefficient as it maintains its designed motion when a shorter tip is present and there is nothing at the point in space to machine.

Therefore, there is a need for an improved, rapid, and flexible method of refinishing the tips of varied size and contour blades.

Disclosure of Invention

An object of the invention is to provide relatively low cost machinery and a highly productive method for finishing turbine blade tips which have excess material thereof, such as material which has been added by processes such as welding. This object is achieved with the features of the characterizing part of claims 1 and 5.

According to the invention the tip of a blade is finished by first rapidly removing material in the manner which tends to concentrate removal wherever material remains, without respect to the final contour sought. Thereafter, material is removed according to a guided path which ultimately conforms with the intended final contour surface of the tip. The process is made more efficient by sensing when relatively little material is remaining above the intended finished surface

and thereafter limiting the amount of time in which the material removal means is allowed to engage the tip (or move along the aforesaid guided path).

In a specific embodiment, a contact roller holding an abrasive belt is reciprocated generally across the cross section of a tip while being thrust along the longitudinal axis of the blade toward the tip by means of air cylinders. A fixed cam is disposed upon the base to which the airfoil is fixed. A cam follower attached to the contact roller engages the cam when material has been removed down to the desired contour surface, thereby mechanically preventing material removal below this surface. An electric switch is activated by proximity of the contact roller when the roller is several thousandths of an inch above the finished contour surface. After a predetermined time the contact roller is caused to retract from engagement with the blade. At this time it will be found that the blade has been finished and may be removed from the machine.

The invention is quite efficient, since with a limited amount of experiment the aforesaid predetermined time can be established. Therefore, the removal of material which is substantially in excess of the desired contour surface is removed in a very rapid fashion, as the abrasive is not required to be moved along an artificial and slow guided path, but is moved in a manner calculated to optimize the rate of removal of surplus material. Only when the intended finish surface is reached is the abrasive caused to move on the guided path. A feature of the invention is that the establishment of the predetermined fixed time in which to terminate the abrasive action avoids, on the other hand, undue lingering and "sparking out" which is common practice in ordinary grinding activities, or on the other, premature cessation and a resultant deviant part.

Brief Description of Drawings

Figure 1 shows a gas turbine blade having a contoured tip.

Figure 2 is an axial view of the blade in Figure 1.

Figure 3 is a partial view of a blade end showing the sequence of operations in repair of a tip.

Figure 4 is an elevation view showing an abrasive machine for refinishing a blade tip.

Figure 5 is a side view of the apparatus in Figure 4 with addition of a schematic control circuit.

Best Mode for Carrying Out the Invention

The preferred embodiment is described in terms of abrasive machining of a superalloy turbine blade. But it ought to be appreciated that the invention is applicable to all manner of gas turbine airfoils, including blades and vanes both with and without shrouds, as well as for components of other types of rotating machinery and generally for any other part requiring a contour surface at its end. The invention will be also found useful with other means than the abrasive belt of the preferred embodiment, such as grinding wheels, milling cutters, and the like which remove material in an analogous localized manner.

A gas turbine blade 20 is shown in Figure 1 as it is ordinarily mounted in a portion of a disk 22. For purposes of the present invention the blade can be characterized as having a longitudinal z axis perpendicular to orthogonal x and y axes. The y axis is taken as being directly tangent to the circumferential path around which the blade rotates when mounted in disk 22. The x axis is perpendicular to the y axis and therefore is nominally parallel with the axis of rotation of the disk. Figure 2 further illustrates the axes of the blade. The tip 24 of the blade has a curved surface, in this case a fragment of a surface of revolution, so as to conform closely with the inner diameter of the static engine case structure, shown as the fragmentary phantom section 26. Thus, the contour of the tip in the y-z plane is substantially a curved surface congruent with the circumference C (having radius R) of the inner diameter of the engine. Inasmuch as the diameter of the engine may change along the axis of the disk (that is, in a direction parallel to the x axis of the blade) the front portion of the tip may have a first radius R_1 while the back portion may have a second radius R_2 . Consequently it may be seen that to obtain the minimum clearance between the tip and the static structure a relatively accurate contour is needed on the tip.

Figure 3 illustrates in sequential fashion the repair process during which the invention is used. Figure 3a shows the change in length t which a worn blade sustains and which causes excess clearance and consequent gas turbine inefficiency. Figure 3B shows the result of adding a first layer of weld material, usually superalloy similar to the blade alloy; this is followed by a second layer, usually a hard facing material as shown in Figure 3c whereupon a purposeful excess of material, indicated by d results. Finally, a restored component, shown in Figure 3d, results by use of the method and apparatus of the present invention to obtain the desired dimensions.

Figures 4 and 5 represent the important elements of the instant invention. Figure 5 is a side view of the elements shown in Figure 4, with the addition of a schematic control system. Referring to Figure 4, a turbine blade 20 is shown mounted by its root 32 in a holder 34 which is affixed to a base 35. The base has x, y and z axes and the airfoil is mounted to have its previously described axes co-aligned with these. Also mounted on the base are a fixed cam 36 and fixed horizontal (y axis) air cylinder actuator 38 which translates a movable vertical (z axis) air cylinder in horizontal track 49. An abrasive belt 42 is shown as it passes over a contact roller 44; this is referred hereafter as the abrasive. The abrasive belt is driven by a motor and tensioned and guided by other rollers which are not illustrated but which are familiar in the art. The contact roller is mounted in a bracket 46 which is connected to the output rod 48 of the vertical actuator 40. Thus, it will be seen that the roller and abrasive thereon is movable in the z axis by operation of the vertical air cylinder actuator 40 and movable in the horizontal y axis through the

action of the horizontal air cylinder actuator 38. Thus, it will be appreciated that the abrasive may be translated in the y-z plane by controlled operation of the air cylinders 38 and 40. Prior to the start of the tip finishing operation, the turbine blade 20 will have excess material 30' which is shown in phantom in Figure 4. Thus, operation of the air cylinders can cause the abrasive to contact the excess material at all points on the tip and thereby effect its removal.

In operation, the vertical cylinder is pressurized to cause the abrasive to move downward along the z axis while the horizontal cylinder causes a back and forth reciprocation generally along the y axis. The nature of the air cylinder actuator is that owing to the use of a compressible fluid, the force of the abrasive on the tip will be relatively constant regardless of small changes in displacement of the contact roller due to encountering higher or lower levels of excess material on the tip. The advance along the z axis toward the tip of the blade is controlled by the rate at which air is supplied to the cylinder, or by supplemental mechanical means.

Attached to the contact roller is a cam follower 50 which is adapted to contact the surface 52 of the cam 36. The surface has a contour B which is generally reflective of the contour surface desired in the airfoil tip (represented by line C). The cam contour B has due adjustment for the mechanical compensations that are ordinary and necessary in cam follower systems, to cause the desired movement of the roller 44 along the path C. Consequently, it may be seen from Figure 4 that if the above-described operation of the air-cylinders is undertaken, the abrasive will remove all the excess material until a point where the cam follower 50 will locally contact the surface 52 of cam 36. This contact will then cause the abrasive to be guided at that point along the path C. The area of cam contact and guided path length will increase as the excess material is removed and the desired contour surface on the airfoil tip is achieved. Thus, the action of the abrasive can be characterized as initially being productive of constant force with a vertical translation component dependent on the tip material which remains, i.e., it is not positively controlled. This is then converted to an action characterized by a guided path of controlled displacement, as the vertical force on the tip is lowered and absorbed by the cam system. It will be appreciated that the cam system is but one mechanical means of achieving the guided path and that other means, such as purely mechanical or a programmed control and feedback system, may be substituted to limit the translation and institute the desired final motion.

During the first development of the invention herein, the foregoing was the apparatus and mode of operation which were employed. But, while the use of the motions described produced an advantageous result, the process was somewhat inefficient in that it was not readily determinable when all the required material had been removed from the blade tip. Naturally, if the

machine was continued in operation it ultimately became evident from the absence of any signs of cutting action that the part had been completed. Thereupon the abrasive belt could be removed from proximity of the blade and the part was removed from the holder. Therefore, a means was sought to improve the operation of the apparatus to increase the productivity of labor.

This was accomplished by introduction of an electrical position sensing system which is shown in Figure 5 (and obscured in Figure 4). The system is comprised of a probe 60 which is fixed to the holder 46 and thereby moves with substantially the same motion as do the contact wheel axis 53 and abrasive contacting the tip. The sensor is mounted on the base 35 and is slidably movable along the z axis. Thus, the probe will be sensed when the movable portions of the apparatus arrive at a position represented by the phantom lines E, wherein the cam follower 50 is a very small distance away from contact with the cam 36. Upon sensing the presence of the probe, the sensor sends a signal to a controller 64 which by means of suitable transducers and the like causes the reversal of the downward motion of the vertical cylinder 40 and the resultant withdrawal of the abrasive from proximity of the blade tip. Simply, the controller is comprised of a delay timer 66 which is settable to a desired delay increment during which the cutting action of the abrasive may be continued and following which it is then ceased through action of the driver 68 and actuator 40.

The probe-sensor system is preferably comprised of a circuit connected to the sensor so that it is above ground potential. Momentary contact of the probe with the sensor causes grounding, activation of the circuit, and transmittal of the signal to the timer. Other devices such as mechanical actuated electric or fluidic switches, magnetic or photo-optical proximity devices, and the like will be found suited as well.

In operation the sensor is set at a distance which is about 0.025 mm (0.005 inches) away from the furthest possible downward motion of the probe at the particular y coordinate of the sensor, as limited by the cam system. When the location determined by the sensor position is reached, the abrasive will be acting to vigorously remove material wherever it is in excess, as described above. (Depending on the y axis location of the sensor, the cam may or may not have engaged the cam follower at another y location, but this is not particularly important to the functioning of the invention.) A limited amount of experiment with the particular part will have revealed how much further time is required to remove the remaining excess material across the entire tip subsequent to the signal being transmitted by the sensor to the control system. The experiment involves reducing the time delay duration until gauging shows that the excess material is not being entirely removed. The distance is chosen to be rather small and the tip will be near its final dimension. Thus, when the

sensor sends its signal it will be generally found that the amount of material remaining to be removed from one blade to the next will be relatively constant, since all the initial irregularities in surface contour that result from the welding will have been removed during the initial operations. The distance at which the signal is transmitted may be varied; preferably a distance of 0.025—0.125 mm is desirable for parts where about 2.0 mm of material are removed. But distances substantially in excess may be used for other situations provided at the time the signal is transmitted the volume of remaining material is relatively constant in amount and property from one part to the next. On the other hand, if the sensor is set too close to the final position to which the probe will move, the sensor positioning becomes accordingly much more critical and the apparatus will be prone to error. As an example, if the sensing point is set at the cam surface level then a small error in positioning of a sensitive sensor could result in no signal. Consequently, placing the sensor a significant but small distance above the cam has been found to eliminate a great deal of uncertainty and requirement for high precision in the apparatus.

The apparatus shown is quite amenable to finishing of differing parts, since different shape parts merely require substitution of a different holder and cam and appropriate adjustment of the sensor (which of course can be recorded and retrieved each time the particular design of part is repeated).

Other variations of the apparatus are possible. The cam 36 may have a surface 52 which is other than a simple curve. The contour 70 of the roller 44 may be varied along the x axis if it is desired to produce a compound curve on the part. Further, it should be evident that another degree of motion may be employed, namely, in the x direction, with cam dimension accordingly changed and presented, to produce a considerably more complex part than is required presently in gas turbine repair. Lastly, it will be appreciated that the original assignment of axes x and y to the blade was arbitrarily but conveniently made and that other obvious combinations of dispositions of the part may be made with respect to the axes of the machine of the invention.

Although this invention has been shown and described with respect to a preferred embodiment, it will be understood by those skilled in this art that various changes in form and detail thereof may be made without departing from the spirit and scope of the claimed invention.

Claims

1. Apparatus for finishing the tip (24) of a gas turbine airfoil to a desired contour surface wherein said apparatus has a base (35) with x, y and z axes, abrasive means (42) for removing material from the tip (24), and means (34) for holding an airfoil on the base (35) so that its longitudinal axis is substantially aligned with the

said z axis in a manner which presents the tip (24) for contact by the abrasive,

means (36, 50) for guiding the abrasive in the y-z plane along the path of the desired finished contour surface, said guiding means (36, 50) becoming independently operable along said path of translation at a point proximate the intended finished contour surface location;

means (38, 40) for translating the material removal means (42) toward the airfoil tip location with a generally reciprocating action on a path in the y-z plane of the base, to remove material from multiple points on the tip;

characterized in comprising means (60, 62) for producing an output signal as a function of a location of the abrasive (42) with respect to the finished contour line, said location being along said y-z plane path and spaced apart along the z axis from the intended finished contour surface location in the direction from which the material removal means approaches;

means (64, 66, 68) responsive to said signal, for terminating removal of material after a predetermined time.

2. The apparatus according to claim 1 characterized in that the abrasive (42) is a moving belt; the means (36, 50) for guiding the abrasive (42) along the finished contour surface comprises a mechanical cam (36) fixed to the base (35) and a cam follower (50) connected to the abrasive (42); and

the means (60, 62) for producing an output signal comprises a device adjustable along the z axis of the base, said device producing a signal when the abrasive is a small z distance from the finished contour.

3. Apparatus according to claim 1 characterized in comprising a contact roller (44) having an abrasive belt (42) moving thereon in the y-z plane; a cam (36) having a surface (52) generally reflective of the finished contour surface desired in the airfoil;

a cam follower (50) connected to the contact roller (44), for causing the contact roller (44) and abrasive belt (42) thereon to follow the path of said desired finished contour surface and for preventing removal of material beneath said surface;

means (40, 48, 46) for moving the contact roller (44), along the z axis, so the contact roller (44) moves toward location where the airfoil tip (24) is positionable while reciprocating the roller generally along the y axis, to remove material at points along the tip of an airfoil;

a sensor (60, 62) for signaling the position of the follower (50) when it is a small distance above a point on the cam; and

means (64, 66, 68) for separating the contact roller (44) from the base (35) along the z axis in response to a signal from the sensor.

4. The apparatus according to claim 3 characterized in that the means (40, 48, 46) for moving the contact roller (44) along the z axis is comprised of a gas pressure device (40) such as an air cylinder, said device being productive of rapid

sensor sends its signal it will be generally found that the amount of material remaining to be removed from one blade to the next will be relatively constant, since all the initial irregularities in surface contour that result from the welding will have been removed during the initial operations. The distance at which the signal is transmitted may be varied; preferably a distance of 0.025—0.125 mm is desirable for parts where about 2.0 mm of material are removed. But distances substantially in excess may be used for other situations provided at the time the signal is transmitted the volume of remaining material is relatively constant in amount and property from one part to the next. On the other hand, if the sensor is set too close to the final position to which the probe will move, the sensor positioning becomes accordingly much more critical and the apparatus will be prone to error. As an example, if the sensing point is set at the cam surface level then a small error in positioning of a sensitive sensor could result in no signal. Consequently, placing the sensor a significant but small distance above the cam has been found to eliminate a great deal of uncertainty and requirement for high precision in the apparatus.

The apparatus shown is quite amenable to finishing of differing parts, since different shape parts merely require substitution of a different holder and cam and appropriate adjustment of the sensor (which of course can be recorded and retrieved each time the particular design of part is repeated).

Other variations of the apparatus are possible. The cam 36 may have a surface 52 which is other than a simple curve. The contour 70 of the roller 44 may be varied along the x axis if it is desired to produce a compound curve on the part. Further, it should be evident that another degree of motion may be employed, namely, in the x direction, with cam dimension accordingly changed and presented, to produce a considerably more complex part than is required presently in gas turbine repair. Lastly, it will be appreciated that the original assignment of axes x and y to the blade was arbitrarily but conveniently made and that other obvious combinations of dispositions of the part may be made with respect to the axes of the machine of the invention.

Although this invention has been shown and described with respect to a preferred embodiment, it will be understood by those skilled in this art that various changes in form and detail thereof may be made without departing from the spirit and scope of the claimed invention.

Claims

1. Apparatus for finishing the tip (24) of a gas turbine airfoil to a desired contour surface wherein said apparatus has a base (35) with x, y and z axes, abrasive means (42) for removing material from the tip (24), and means (34) for holding an airfoil on the base (35) so that its longitudinal axis is substantially aligned with the

said z axis in a manner which presents the tip (24) for contact by the abrasive,

means (36, 50) for guiding the abrasive in the y-z plane along the path of the desired finished contour surface, said guiding means (36, 50) becoming independently operable along said path of translation at a point proximate the intended finished contour surface location;

means (38, 40) for translating the material removal means (42) toward the airfoil tip location with a generally reciprocating action on a path in the y-z plane of the base, to remove material from multiple points on the tip;

characterized in comprising means (60, 62) for producing an output signal as a function of a location of the abrasive (42) with respect to the finished contour line, said location being along said y-z plane path and spaced apart along the z axis from the intended finished contour surface location in the direction from which the material removal means approaches;

means (64, 66, 68) responsive to said signal, for terminating removal of material after a predetermined time.

2. The apparatus according to claim 1 characterized in that the abrasive (42) is a moving belt;

the means (36, 50) for guiding the abrasive (42) along the finished contour surface comprises a mechanical cam (36) fixed to the base (35) and a cam follower (50) connected to the abrasive (42); and

the means (60, 62) for producing an output signal comprises a device adjustable along the z axis of the base, said device producing a signal when the abrasive is a small z distance from the finished contour.

3. Apparatus according to claim 1 characterized in comprising a contact roller (44) having an abrasive belt (42) moving thereon in the y-z plane;

a cam (36) having a surface (52) generally reflective of the finished contour surface desired in the airfoil;

a cam follower (50) connected to the contact roller (44), for causing the contact roller (44) and abrasive belt (42) thereon to follow the path of said desired finished contour surface and for preventing removal of material beneath said surface;

means (40, 48, 46) for moving the contact roller (44), along the z axis, so the contact roller (44) moves toward location where the airfoil tip (24) is positionable while reciprocating the roller generally along the y axis, to remove material at points along the tip of an airfoil;

a sensor (60, 62) for signaling the position of the follower (50) when it is a small distance above a point on the cam; and

means (64, 66, 68) for separating the contact roller (44) from the base (35) along the z axis in response to a signal from the sensor.

4. The apparatus according to claim 3 characterized in that the means (40, 48, 46) for moving the contact roller (44) along the z axis is comprised of a gas pressure device (40) such as an air cylinder, said device being productive of rapid



motion when no resistance is encountered and of increasing but yieldable force when resistance is encountered, said resistance being such as is encountered from contact of the roller (44) with the tip (24) or contact of the cam follower (50) with the cam (36).

5. The method of removing material and finishing the tip of a gas turbine airfoil to a desired curved contour surface comprising:

(a) providing means (42) for material removal, the means being adapted to engage only a small portion of the tip (24) surface at one time;

(b) moving said material removal means (42) against the tip approximately along the longitudinal axis of the airfoil with a constant force;

(c) removing material by reciprocating the material removal means (42) across the tip (24) surface in a plane approximately perpendicular to the longitudinal axis of the airfoil;

(d) thereafter causing the material removal means (42) to move fully along the path of the desired curved contour surface, to limit the force on the tip when said path is encountered; and characterized in

(e) limiting the time period of engagement of the material removing means (42) with the tip (24), this time period commencing after step (c) commences but prior to step (d).

Patentansprüche

1. Vorrichtung zum Fertigbearbeiten der Spitze (24) einer Gasturbinenschaufel, um ihr eine Oberfläche mit gewünschter Kontur zu geben, wobei die Vorrichtung eine Basis (35) mit x-, y- und z-Achsen hat, eine Schleifeinrichtung (42) zum Abtragen von Material von der Spitze (24) und eine Einrichtung (34) zum Festhalten einer Schaufel auf der Basis (35), so daß ihre Längsachse mit der z-Achse im wesentlichen ausgerichtet ist, und zwar auf eine Weise, die die Spitze (24) zur Berührung durch die Schleifeinrichtung darbietet,

eine Einrichtung (36, 50) zum Führen der Schleifeinrichtung in der y-z-Ebene längs des Weges der Oberfläche mit der gewünschten Fertigkontur, wobei die Führungseinrichtung (36, 50) längs des Translationsweges in einem Punkt unabhängig betätigbar wird, der sich nahe bei der Stelle der Oberfläche mit der gewünschten Fertigkontur befindet;

eine Einrichtung (38, 40) zur Translationsbewegung der Materialabtrageeinrichtung (42) zu der Schaufelspitzenstelle in einem insgesamt hin- und hergehenden Vorgang auf einem Weg in der y-z-Ebene der Basis, um Material von mehreren Punkten auf der Spitze abzutragen;

gekennzeichnet durch eine Einrichtung (60, 62) zum Erzeugen eines Ausgangssignals als Funktion einer Lage der Schleifeinrichtung (42) in bezug auf die Fertigkonturlinie, wobei sich die Lage längs der y-z-Ebene-Weges und mit Abstand längs der z-Achse von der Stelle der Oberfläche mit der gewünschten Fertigkontur in der Richtung, aus der sich die Materialabtrageeinrichtung nähert, befindet;

eine Einrichtung (64, 66, 68), die auf das Signal hin das Abtragen von Material nach einer vorbestimmten Zeit beendigt.

2. Vorrichtung nach Anspruch 1, dadurch gekennzeichnet, daß Schleifeinrichtung (42) ein sich bewegendes Band ist;

daß die Einrichtung (36, 50) zum Leiten der Schleifeinrichtung (42) längs der Fertigkonturoberfläche eine mechanische Kurve (36) aufweist, die an der Basis (35) befestigt ist, und einen Kurvenabtaster (50), der mit der Schleifeinrichtung (42) verbunden ist; und

daß die Einrichtung (60, 62) zum Erzeugen eines Ausgangssignals eine Vorrichtung aufweist, die längs der z-Achse der Basis einstellbar ist und ein Signal erzeugt, wenn die Schleifeinrichtung in einem kleinen z-Abstand von der Fertigkontur ist.

3. Vorrichtung nach Anspruch 1, gekennzeichnet durch eine Kontaktrolle (44), auf der sich ein Schleifband (42) in der y-z-Ebene bewegt;

durch eine Kurve (36), die eine Oberfläche (52) hat, welche insgesamt die für die Schaufel gewünschte Fertigkonturoberfläche wiedergibt;

durch einen Kurvenabtaster (50), der mit der Kontaktrolle (44) verbunden ist, um die Kontaktrolle (44) und das darauf befindliche Schleifband (42) zu veranlassen, dem Weg der gewünschten Fertigkonturoberfläche zu folgen und das Abtragen von Material unter der Oberfläche zu verhindern;

eine Einrichtung (40, 48, 46) zum Bewegen der Kontaktrolle (44) längs der z-Achse, so daß sich die Kontaktrolle (44) zu der Stelle bewegt, wo die Schaufelspitze (24) positionierbar ist, während die Rolle insgesamt längs der y-Achse hin- und herbewegt wird, um Material an Punkten längs der Spitze einer Schaufel abzutragen;

durch einen Sensor (60, 62) zum Melden der Position des Abtasters (50), wenn er in einem kleinen Abstand über einem Punkt auf der Kurve ist; und

durch eine Einrichtung (64, 66, 68) zum Trennen der Kontaktrolle (44) von der Basis (35) längs der z-Achse auf ein Signal aus dem Sensor hin.

4. Vorrichtung nach Anspruch 3, dadurch gekennzeichnet, daß die Einrichtung (40, 48, 46) zum Bewegen der Kontaktrolle (44) längs der z-Achse aus einer Gasdruckvorrichtung (40), wie beispielsweise einem Luftzylinder, besteht, die eine schnelle Bewegung erzeugt, wenn kein Widerstand angetroffen wird, und mit zunehmender, aber nachgiebiger Kraft, wenn Widerstand angetroffen wird, wobei der Widerstand so ist, wie er aufgrund von Kontakt der Rolle (44) mit der Spitze (24) oder von Kontakt des Kurvenabtasters (50) mit der Kurve (36) auftritt.

5. Verfahren zum Abtragen von Material und zum Fertigbearbeiten der Spitze einer Gasturbinenschaufel, um ihr eine Oberfläche mit gewünschter gekrümmter Kontur zu geben, durch:

(a) Bereitstellen einer Einrichtung (42) zum Abtragen von Material, wobei die Einrichtung in der Lage ist, nur einen kleinen Teil der Spitze (24) der Oberfläche gleichzeitig zu berühren;

(b) Bewegen der Materialabtrageeinrichtung (42)



(16)

gegen die Spitze ungefähr längs der Längsachse der Schaufel mit einer konstanten Kraft;

(c) Abtragen von Material durch Hin- und Herbewegen der Materialabtrageinrichtung (42) über die Oberfläche der Spitze (24) in einer Ebene, die zu der Längsachse der Schaufel ungefähr rechtwinklig ist;

(d) anschließendes Bewegen der Materialabtrageinrichtung (42) vollständig längs des Weges der Oberfläche mit der gewünschten gekrümmten Kontur, um die auf die Spitze ausgeübte Kraft zu begrenzen, wenn der Weg angegriffen wird; und gekennzeichnet durch

(e) Begrenzen der Zeitspanne der Berührung der Materialabtrageinrichtung (42) mit der Spitze (24), wobei diese Zeitspanne nach dem Schritt (c), aber vor dem Schritt (d) beginnt.

Revendications

1. Appareil pour l'usinage de finition de la tête (24) d'une aube de turbine à gaz en vue de lui donner une surface de contour désirée, cet appareil comprenant une base (35) avec des axes x, y et z, un moyen abrasif (42) pour l'enlèvement de matière de la tête (24) de l'aube, ainsi qu'un moyen (34) destiné à maintenir une aube sur la base (35), de telle sorte que son axe longitudinal soit pratiquement aligné avec l'axe z d'une manière permettant de présenter la tête (24) au contact du moyen abrasif,

un moyen (36, 50) destiné à guider le moyen abrasif dans le plan y-z le long du parcours de la surface de contour définitive désirée, ce moyen de guidage (36, 50) devenant indépendamment opérant le long de ce parcours de translation en un point proche de l'emplacement prévu de la surface de contour définitive;

un moyen (38, 40) destiné à imprimer un mouvement de translation au moyen d'enlèvement de matière (42) en direction de l'emplacement de la tête de l'aube avec, d'une manière générale, un effet de va-et-vient sur un parcours situé dans le plan y-z de la base, afin de permettre un enlèvement de matière de la tête de l'aube en des points multiples;

caractérisé en ce qu'il comprend un moyen (60, 62) destiné à engendrer un signal de sortie en fonction d'un emplacement du moyen abrasif (42) par rapport à la ligne du contour définitif, cet emplacement étant situé le long du parcours dans le plan y-z, tout en étant espacé, le long de l'axe z, de l'emplacement prévu de la surface de contour définitive dans le sens de rapprochement du moyen d'enlèvement de matière; et

un moyen (64, 66, 68) réagissant au signal précité pour mettre un terme à l'enlèvement de matière après un laps de temps prédéterminé.

2. Appareil selon la revendication 1, caractérisé en ce que le moyen abrasif (42) est une bande mobile;

le moyen (36, 50) destiné à guider le moyen

abrasif (42) le long de la surface de contour définitive comprend une came mécanique (36) fixée à la base (35) et un galet de came (50) solidarisé au moyen abrasif (42); et

le moyen (60, 62) destiné à engendrer un signal de sortie comprend un dispositif pouvant être réglé le long de l'axe z de la base, ce dispositif engendrant un signal lorsque le moyen abrasif est situé à une courte distance z du contour définitif.

3. Appareil selon la revendication 1, caractérisé en ce qu'il comprend un galet de contact (44) sur lequel une bande abrasive (42) se déplace dans le plan y-z;

une came (36) comportant une surface (52) qui est généralement le reflet de la surface de contour définitive que l'on désire obtenir dans l'aube;

un galet de came (50) solidarisé au galet de contact (44), en vue d'amener celui-ci et la bande abrasive (42) qui s'y déplace, à suivre le parcours de la surface de contour définitive désirée, ainsi qu'à empêcher un enlèvement de matière en dessous de cette surface;

un moyen (40, 48, 46) destiné à déplacer le galet de contact (44) le long de l'axe z, de telle sorte que ce galet de contact (44) se déplace en direction de l'emplacement auquel peut être positionnée la tête (24) de l'aube, tout en imprimant un mouvement de va-et-vient au galet généralement le long de l'axe y, afin de permettre un enlèvement de matière en des points situés le long de la tête d'une aube;

un capteur (60, 62) destiné à signaler la position du galet de came (50) lorsqu'il est situé à une courte distance au-dessus d'un point de la came; et

un moyen (64, 66, 68) destiné à éloigner le galet de contact (44) de la base (35) le long de l'axe z en réponse à un signal émis par le capteur.

4. Appareil selon la revendication 3, caractérisé en ce que le moyen (40, 48, 46) destiné à déplacer le galet de contact (44) le long de l'axe z est constitué d'un dispositif à pression de gaz (40) tel qu'un cylindre à air, ce dispositif étant à même d'engendrer un mouvement rapide lorsqu'il ne rencontre aucune résistance, ainsi qu'une force croissante, mais élastique en présence d'une résistance, cette résistance étant celle rencontrée, par exemple, à la suite du contact entre le galet (44) et la tête (24) de l'aube ou du contact entre le galet de came (50) et la came (36).

5. Procédé pour l'enlèvement de matière et l'usinage de finition de la tête d'une aube de turbine à gaz en vue de lui conférer une surface de contour courbe désirée, ce procédé comprenant les étapes qui consistent à:

(a) prévoir, pour l'enlèvement de matière, un moyen (42) qui est conçu pour venir s'engager uniquement sur une petite partie de la surface de la tête (24) à la fois;

(b) déplacer le moyen d'enlèvement de matière (42) avec une force constante contre la



tête à peu près le long de l'axe longitudinal de l'aube;

(c) procéder à l'enlèvement de matière en imprimant, au moyen d'enlèvement de matière (42), un mouvement de va-et-vient en travers de la surface de la tête (24) dans un plan à peu près perpendiculaire à l'axe longitudinal de l'aube;

(d) amener ensuite le moyen d'enlèvement de matière (42) à se déplacer sur toute la longueur du

parcours de la surface de contour courbe désirée, de façon à limiter la force exercée sur la tête lors du franchissement de ce parcours; ce procédé étant caractérisé en ce qu'il comprend également l'étape qui consiste à:

(e) limiter la période pendant laquelle le moyen d'enlèvement de matière (42) vient s'engager sur la tête (24), cette période commençant après le début de l'étape (c), mais avant l'étape (d).

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