

AUXILIARY APPARATUS

BACKGROUND OF THE INVENTION

Field of the Invention

The present invention relates to an auxiliary apparatus for being coupled to a cutting apparatus.

Description of the Related Art

Wafers with a plurality of devices such as integrated circuits (ICs) or large scale integration (LSI) circuits constructed in respective areas demarcated on their face sides by a plurality of projected dicing lines are divided into individual device chips by a cutting apparatus. The device chips fabricated from the wafers will be incorporated in electronic appliances including cellular phones, personal computers, etc.

The cutting apparatus includes a chuck table having a holding surface for holding a wafer thereon, cutting means having a cutting blade mounted in place by a mounting nut for cutting the wafer held on the holding surface of the chuck table, X-axis feeding means for processing-feeding the chuck table in X-axis directions, Y-axis feeding means for indexing-feeding the cutting means in Y-axis directions perpendicular to the X-axis directions, and Z-axis feeding means for incising-feeding

the cutting means in Z-axis directions perpendicular to the X-axis directions and the Y-axis directions. The holding surface lies in a plane defined along the X-axis directions and the Y-axis directions, allowing the wafer placed on the holding surface to be divided by the cutting blade highly accurately into the individual device chips.

The applicant of the present application has proposed an automatic blade changer capable of automatically changing cutting blades for use on the cutting means (see, for example, JP 2007-98536A).

SUMMARY OF THE INVENTION

One problem with the automatic blade changer is that it is difficult to subsequently add the automatic blade changer to a cutting apparatus that has already been delivered to a user.

It is therefore an object of the present invention to provide an auxiliary apparatus capable of automatically changing cutting blades, which can subsequently be added with ease to a cutting apparatus that has already been delivered to a user.

In accordance with an aspect of the present invention, there is provided an auxiliary apparatus

adapted to be coupled to a cutting apparatus including a chuck table having a holding surface for holding a workpiece thereon, cutting means including a cutting blade mounted thereon with a mounting nut, for cutting the workpiece held on the chuck table, X-axis feeding means for processing-feeding the chuck table along an X-axis, Y-axis feeding means for indexing-feeding the cutting means along a Y-axis perpendicular to the X-axis, and Z-axis feeding means for incising-feeding the cutting means along a Z-axis perpendicular to the X-axis and the Y-axis, the holding surface being defined along the X-axis and the Y-axis, the auxiliary apparatus including cutting blade storing means for storing a plurality of cutting blades therein, unloading and loading means for unloading cutting blades from and loading cutting blades into the cutting blade storing means, Y-axis positioning means for selectively bringing the unloading and loading means into a working position and a retracted position along the Y-axis with respect to the cutting blade storing means, Z-axis moving means for moving the unloading and loading means along the Z-axis, and X-axis moving means for moving the unloading and loading means along the X-axis to act on the cutting blade mounted on a spindle of the cutting means. The unloading and loading

means includes a Z-axis rotational shaft extending along the Z-axis, a blade holder coupled radially to the Z-axis rotational shaft for holding the cutting blade under suction thereon, and a mounting nut holder for threading a mounting nut over or off an externally threaded distal end portion of the spindle, and the unloading and loading means is coupled to a distal end of a bendable arm by the Z-axis rotational shaft.

Preferably, the unloading and loading means is disposed in a frame by the bendable arm, and the frame is slidably supported on a guide rail disposed on a vertically movable table and extending along the Y-axis and is selectively positionable in the working position and the retracted position with respect to the cutting blade storing means by the Y-axis positioning means. The bendable arm advances and retracts the unloading and loading means along the X-axis.

Preferably, the cutting blade storing means includes a drive gear having a rotational shaft extending along the Y-axis, a driven gear spaced from the drive gear along the Z-axis and having a rotational shaft extending along the Y-axis, an endless track trained around the drive gear and the driven gear, and a plurality of blade support shafts disposed at

predetermined spaced intervals on the endless track, for supporting the cutting blades by being inserted in central openings defined in the cutting blades, the blade support shafts extending along the Y-axis. Preferably, a distance along the Z-axis between the drive gear and the driven gear is adjustable, and a length of the endless track is adjustable.

Preferably, each of the cutting blades storable by the cutting blade storing means includes a hub blade having a base and a cutting edge disposed on an outer circumferential portion of the base, each of the blade support shafts has an outside diameter commensurate with the inside diameter of a central opening defined in the hub blade, and the blade holder holds the hub blade.

Preferably, each of the cutting blades storable by the cutting blade storing means includes a washer blade including an annular cutting edge, each of the blade support shafts has an outside diameter commensurate with an inside diameter of a central opening defined in the washer blade, and the blade holder holds the washer blade and a mount flange for mounting the washer blade on the spindle of the cutting means.

Since the unloading and loading means is coupled to the distal end of the bendable arm by the Z-axis

rotational shaft, the auxiliary apparatus according to the present invention subsequently be added to a cutting apparatus that has already been delivered to the user.

The above and other objects, features and advantages of the present invention and the manner of realizing them will become more apparent, and the invention itself will best be understood from a study of the following description and appended claims with reference to the attached drawings showing a preferred embodiment of the invention.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a perspective view of an auxiliary apparatus according to an embodiment of the present invention;

FIG. 2 is an exploded perspective view of cutting blade storing means of the auxiliary apparatus illustrated in FIG. 1;

FIG. 3 is a perspective view of a blade support shaft of the cutting blade storing means illustrated in FIG. 2;

FIG. 4 is a cross-sectional view of the blade support shaft of the cutting blade storing means illustrated in FIG. 2;

FIG. 5 is a perspective view of the blade support shaft that supports washer blades;

FIG. 6 is a perspective view of unloading and loading means of the auxiliary apparatus illustrated in FIG. 1, with a blade holder and a mounting nut holder illustrated at an enlarged scale;

FIG. 7 is an exploded perspective view of a frame, a vertically movable table, and a base mount of the auxiliary apparatus illustrated in FIG. 1;

FIG. 8 is an exploded perspective view of the frame of the auxiliary apparatus illustrated in FIG. 1;

FIG. 9 is a perspective view of a cutting apparatus with which the auxiliary apparatus illustrated in FIG. 1 is to be coupled;

FIG. 10 is a perspective view of a chuck table of the cutting apparatus illustrated in FIG. 9;

FIG. 11 is a perspective view of cutting means of the cutting apparatus illustrated in FIG. 9;

FIG. 12 is a perspective view of the cutting means with a blade cover being open of the cutting apparatus illustrated in FIG. 9;

FIG. 13 is an exploded perspective view of the cutting means of the cutting apparatus illustrated in FIG. 9;

FIG. 14 is an exploded perspective view of the cutting means where a washer blade is mounted;

FIG. 15 is a perspective view of the cutting apparatus illustrated in FIG. 9 with which the auxiliary apparatus illustrated in FIG. 1 is coupled;

FIG. 16 is a perspective view of the auxiliary apparatus illustrated in FIG. 1 where the cutting blade storing means and the unloading and loading means face each other;

FIG. 17 is a perspective view of the auxiliary apparatus illustrated in FIG. 1 where the frame has advanced from its position illustrated in FIG. 16 toward the cutting blade storing means;

FIG. 18 is a perspective view of the auxiliary apparatus illustrated in FIG. 1 where the frame has retracted from its position illustrated in FIG. 17 and the vertically movable table has been lifted; and

FIG. 19 is a perspective view of the auxiliary apparatus illustrated in FIG. 1 where the vertically movable table has advanced from its position illustrated in FIG. 18 toward the cutting apparatus.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

An auxiliary apparatus according to a preferred

embodiment of the present invention will hereinafter be described with reference to the drawings. As illustrated in FIG. 1, the auxiliary apparatus, generally denoted by the reference numeral 2, includes at least cutting blade storing means, i.e., a storing unit, 4 that stores a plurality of cutting blades, unloading and loading means, i.e., an unloading and loading unit, 6 for unloading a cutting blade from and loading a cutting blade into the cutting blade storing means 4, Y-axis positioning means, i.e., a positioning unit, 8 for positioning the unloading and loading means 6 selectively in a working position and a retracted position along a Y-axis with respect to the cutting blade storing means 4, a Z-axis moving means, e.g., a Z-axis moving mechanism, 10 for moving the unloading and loading means 6 along a Z-axis, and an X-axis moving means, i.e., X-axis moving means 12 for moving the unloading and loading means 6 along an X-axis to cause the unloading and loading means 6 to act on a cutting blade mounted on a spindle of cutting means, i.e., a cutting unit, of a cutting apparatus, not depicted in FIG. 1.

The X-axis refers to an axis indicated by the arrow X in FIG. 1, and the Y-axis refers to an axis indicated by the arrow Y in FIG. 1 and is perpendicular to the X-

axis. X-axis directions refer to horizontal directions along the X-axis, and Y-axis directions refer to horizontal directions along the Y-axis. The Z-axis refers to an axis indicated by the arrow Z in FIG. 1 and is perpendicular to the X-axis and the Y-axis. Z-axis directions refer to vertical directions along the Z-axis. A plane defined by and extending along the X-axis and the Y-axis lies substantially horizontally.

As illustrated in FIG. 2, the cutting blade storing means 4 includes a drive gear 16 having a rotational shaft 14 extending along the Y-axis, a driven gear 20 spaced from the drive gear 16 along the Z-axis and having a rotational shaft 18 extending along the Y-axis, an endless track 22 trained around the drive gear 16 and the driven gear 20, and a plurality of blade support shafts 24 mounted at predetermined spaced intervals on the endless track 22 and extending along the Y-axis for being inserted in the central openings of respective cutting blades to support the cutting blades thereon.

As illustrated in FIGS. 1 and 2, the cutting blade storing means 4 according to the present embodiment includes a base plate 26 (see FIG. 1) lying horizontally, a support wall 28 extending upwardly along the Z-axis from an upper surface of the base plate 26, and an

electric motor 30 fixedly mounted on a vertical surface of the support wall 28. As illustrated in FIG. 2, the rotational shaft 14 of the drive gear 16 is coupled to the output shaft of the electric motor 30, so that when the electric motor 30 is energized, it rotates the drive gear 16 about the Y-axis.

As illustrated in FIG. 2, the driven gear 20 is disposed above the drive gear 16, and the rotational shaft 18 of the driven gear 20 is supported on the support wall 28 such that the rotational shaft 18 is rotatable about the Y-axis and vertically movable along the Z-axis. The support wall 28 houses therein vertically moving means, not depicted, for vertically moving, i.e., lifting and lowering the driven gear 20 along the Z-axis. The vertically moving means may be of a structure having a ball screw coupled to the rotational shaft 18 of the driven gear 20 and extending along the Z-axis and an electric motor for rotating the ball screw about its central axis extending along the Z-axis.

The endless track 22 includes a number of interconnected links (reference numeral is omitted) and is trained around the drive gear 16 and the driven gear 20, as described above. The endless track 22 is rotated around the drive gear 16 and the driven gear 20 when the

drive gear 16 is rotated by the electric motor 30.

In the cutting blade storing means 4 according to the present embodiment, a distance along the Z-axis between the drive gear 16 and the driven gear 20 can be adjusted by changing the position of the driven gear 20 along the Z-axis with the vertically moving means. Furthermore, in the cutting blade storing means 4, a length of the endless track 22 can be adjusted by increasing or reducing the number of links of the endless track 22.

As illustrated in FIG. 2, the blade support shafts 24 are mounted at predetermined spaced intervals on the endless track 22, as described above. As illustrated in FIGS. 2 and 3, each of the blade support shafts 24 has a cylindrical base 32 coupled to the endless track 22 and a cylindrical shank 34 extending along the Y-axis from an end face of the cylindrical base 32. The shank 34 is smaller in diameter than the base 32.

FIG. 3 also illustrates hub blades 36 as cutting blades that can be stored in the cutting blade storing means 4. Each of the hub blades 36 has an annular base 38 and an annular cutting edge 40 disposed on an outer circumferential portion of the base 38. The base 38 is made of a metal material such as aluminum alloy. The base

38 has a circular central opening 38a defined in a centrally portion thereof. The cutting edge 40 is made of abrasive grains such as of diamond and a binding material such as metal or resin. The cutting edge 40 has a predetermined thickness ranging from about 10 to 30 μm , for example, and protrudes radially outwardly from the outer circumferential portion of the base 38.

The shank 34 of each of the blade support shafts 24 is commensurate in diameter with the central opening 38a of the hub blade 36. Each of the blade support shafts 24 supports a plurality of, e.g., five, hub blades 36 on the shank 34 that is inserted in the central openings 38a of the hub blades 36.

According to the present embodiment, as illustrated in FIG. 2, hub blades 36 are supported on half of the blade support shafts 24 on the endless track 22. As illustrated in FIG. 3, a plurality of ball plungers 42 are mounted at circumferentially spaced intervals on a distal end portion of each of the shanks 34 for retaining the hub blades 36 on the shank 34 to safeguard against dislodgement.

As illustrated in FIG. 4, the base 32 of each of the blade support shafts 24 has a fluid channel 32a defined therein. The endless track 22 has a plurality of

fluid channels 22a defined therein that are held in fluid communication with respective ends of the fluid channels 32a in the blade support shafts 24. As illustrated in FIG. 3, the other end of the fluid channel 32a is open at respective portions of the end face of the base 32 that are positioned radially outwardly of the shank 34.

As illustrated in FIG. 2, the support wall 28 supports thereon an air nozzle 44 that protrudes along the Y-axis below the drive gear 16. The air nozzle 44 is fluidly connected to a high-pressure air supply means, not depicted. According to the present embodiment, the air nozzle 44 has its tip end facing one of the blade support shafts 24 that is positioned as it is rotated.

When a hub blade 36 positioned on the distal end portion of the shank 34 of the blade support shaft 24 at the lowermost end of the path followed by the endless track 22 is unloaded from the cutting blade storing means 4, the air nozzle 44 ejects high-pressure air from the high-pressure air supply means through the fluid channel 22a in the endless track 22 into the fluid channel 32a in the base 32 of the blade support shaft 24, pushing the remaining hub blades 36 on the shank 34 toward the distal end portion of the shank 34. These remaining hub blades 36 are prevented from being dislodged from the shank 34

by the ball plungers 42.

The cutting blades that can be stored in the cutting blade storing means 4 are not limited to the hub blades 36 and may be washer blades 45 illustrated in FIG. 5. Each of the washer blades 45 includes an annular cutting edge. Providing washer blades 45 are stored in the cutting blade storing means 4, the shanks 34 of the blade support shafts 24 that are used to support the washer blades 45 have an outside diameter D commensurate with the inside diameter of a central opening 45a defined in each of the washer blades 45. Each of the blade support shafts 24 that are used to support the washer blades 45 supports a plurality of, e.g., ten, washer blades 45 on the shank 34 that is inserted in the central openings 45a of the washer blades 45.

The cutting blade storing means 4 may store only either hub blades 36 or washer blades 45 or may store both hub blades 36 and washer blades 45.

The unloading and loading means 6 will be described below with reference to FIG. 6. As illustrated in FIG. 6, the unloading and loading means 6 includes at least a Z-axis rotational shaft 46 extending along the Z-axis, a plurality of blade holders 48 coupled radially to the Z-axis rotational shaft 46 for holding cutting blades under

suction thereon, and a plurality of mounting nut holders 50 coupled radially to the Z-axis rotational shaft 46 for threading a mounting nut over or off an externally threaded distal end portion of a spindle of a cutting apparatus, to be described later.

As illustrated in FIG. 6, the unloading and loading means 6 also includes a casing 52 having a hexagonal top plate 54 and six side walls 56 each shaped as a rectangular plate extending downwardly from a peripheral edge of the top plate 54. The Z-axis rotational shaft 46 protrudes upwardly from an upper surface of the top plate 54. The casing 52 houses therein an electric motor, not depicted, coupled to the Z-axis rotational shaft 46.

According to the present embodiment, the blade holders 48 are mounted respectively on four of the six side walls 56 of the casing 52, and the mounting nut holders 50 are mounted respectively on the remaining two of the six side walls 56. The two of the six side walls 56 on which the mounting nut holders 50 are mounted are positioned diametrically opposite each other.

Each of the blade holders 48 is of a hollow cylindrical shape and includes an end face 58 having a circular central opening 60 defined therein that is capable of receiving therein the shanks 34 of the blade

support shafts 24 and the distal end portion of the spindle of the cutting apparatus and a plurality of first suction holes 61 defined therein at circumferentially equally spaced intervals around the central opening 60.

Each of the blade holders 48 also includes an annular ridge 62 projecting axially around an outer circumferential edge of the end face 58. The annular ridge 62 has a plurality of second suction holes 63 defined therein at circumferentially equally spaced intervals around the end face 58. The first and second suction holes 61 and 63 are fluidly connected to a suction means, not depicted.

The annular ridge 62 has an inside diameter slightly larger than the outside diameter D of the shanks 34 that support the washer blades 45, and is able to receive the shanks 34 that support the washer blades 45.

When each of the blade holders 48 is positioned to keep the end face 58 in contact with the base 38 of a hub blade 36 stored in the cutting blade storing means 4, the suction means generates and transmits suction forces to the first suction holes 61, holding the hub blade 36 under suction on the blade holder 48.

For holding a washer blade 45 in the cutting blade storing means 4, the suction means generates and

transmits suction forces to the second suction holes 63, holding the washer blade 45 under suction on the blade holder 48.

As illustrated in FIG. 6, each of the mounting nut holders 50 includes a hollow cylindrical housing 64 fixed to one of the side walls 56 of the casing 52, an annular rotor 66 rotatably housed in the housing 64, and an electric motor, not depicted, for rotating the annular rotor 66 about its central axis.

The rotor 66 has a central opening 68 defined therein that is capable of receiving therein the distal end portion of the spindle of the cutting apparatus. The rotor 66 has an end face 66a in which a plurality of suction holes 70 are defined and on which a plurality of pins 72 are axially movably disposed, the suction holes 70 and the pins 72 being alternately arrayed at circumferentially spaced intervals.

The suction holes 70 are fluidly connected to a suction means, not depicted. The pins 72 are normally biased by springs, not depicted, housing the rotor 66 to be placed in the position illustrated in FIG. 6 where the pins 72 protrude from the end face 66a of the rotor 66. When the pins 72 are pushed into the rotor 66, the pins 72 are accommodated within the rotor 66 while compressing

the springs. The pins 72 are positioned in alignment with respective pin holes, not depicted, defined in the mounting nut.

Each of the mounting nut holders 50 operates as follows. The suction means generates and transmits suction forces to the suction holes 70 to hold the mounting nut under suction on the mounting nut holder 50. While the pins 72 are being inserted in the respective pin holes defined in the mounting nut, the electric motor is energized to rotate the rotor 66 to thread the mounting nut over or off the externally threaded distal end portion of the spindle of the cutting apparatus, thereby mounting or dismounting a hub blade 36 or a washer blade 45 on or from the spindle.

Even if the pins 72 of the mounting nut holder 50 and the pin holes in the mounting nut are out of alignment with each other at the time the mounting nut is to be threaded off, i.e., removed from, the spindle, the end face 66a of the rotor 66 is brought against an end face of the mounting nut mounted on the spindle, pushing the pins 72 into the rotor 66, after which the electric motor is energized to rotate the rotor 66 until the pins 72 are aligned with the pin holes, whereupon the pins 72 are pushed out of the rotor 66 and inserted into the pin

holes under the bias of the springs.

According to the present embodiment, the unloading and loading means 6 thus constructed is disposed in a frame 74 as illustrated in FIG. 1. As illustrated in FIG. 1, the frame 74 is movably supported on a vertically movable table 76 for movement along the Y-axis. The vertically movable table 76 is vertically movably supported on a base mount 78 for vertical movement along the Z-axis.

As illustrated in FIG. 7 as well as FIG. 1, the frame 74 includes a bottom panel 80 shaped as a rectangular plate, four support posts 82 extending upwardly from respective four corners of an upper surface of the bottom panel 80, and a top panel 84 shaped as a rectangular plate fixed to upper ends of the support posts 82 (see FIG. 1). A pair of guided members 86 each having a groove 86a defined therein that extends along the Y-axis are mounted on a lower surface of the bottom panel 80. The guided members 86 are spaced from each other along the X-axis.

The vertically movable table 76 includes a top panel 88 shaped as a rectangular plate and four cylindrical legs 90 extending downwardly from respective four corners of a lower surface of the top panel 88. A

pair of parallel guide rails 92 spaced from each other along the X-axis and extending along the Y-axis are mounted on an upper surface of the top panel 88. The guide rails 92 are slidably fitted in the respective grooves 86a in the guided members 86 of the frame 74.

The Y-axis positioning means 8 is mounted on the upper surface of the top panel 88 of the vertically movable table 76. The Y-axis positioning means 8 has a ball screw 94 disposed between the guide rails 92 and extending along the Y-axis and an electric motor 96 for rotating the ball screw 94 about its central axis. The ball screw 94 is operatively threaded through a nut, not depicted, fixedly mounted on the lower surface of the bottom panel 80.

The Y-axis positioning means 8 operates as follows. When the electric motor 96 is energized, the ball screw 94 converts rotary motion of the electric motor 96 into linear motion and transmits the linear motion to the frame 74, moving the frame 74 along the Y-axis along the guide rails 92. The frame 74 where the unloading and loading means 6 is disposed is slidably supported on the guide rails 92 that is disposed on the vertically movable table 76 and extending along the Y-axis. The frame 74 can be positioned selectively in the working position and the

retracted position along the Y-axis with respect to the cutting blade storing means 4 by the Y-axis positioning means 8.

The working position refers to a position where the blade holders 48 of the unloading and loading means 6 are close to the cutting blade storing means 4 and are capable of holding under suction the cutting blades supported by the cutting blade storing means 4. The retracted position refers to a position where the blade holders 48 of the unloading and loading means 6 are spaced from the cutting blade storing means 4 farther than they are in the working position.

As illustrated in FIG. 7, the base mount 78 includes a frame 98 and a rectangular base plate 100 fixed to an upper portion of the frame 98. The base plate 100 has four circular holes 102 defined in respective four corners thereof for receiving the respective legs 90 of the vertically movable table 76 that are slidably inserted therein. The base plate 100 also has an internally threaded hole 104 defined centrally therein.

As illustrated in FIG. 7, the Z-axis moving means 10 is coupled to the vertically movable table 76 and the base mount 78. The Z-axis moving means 10 includes a ball screw 106 extending along the Z-axis, an electric motor

108 coupled to an end of the ball screw 106 for rotating the ball screw 106 about its central axis, and a joint plate 110 fixed to an upper end of the electric motor 108. The ball screw 106 is threaded through the internally threaded hole 104 in the base plate 100. The joint plate 110 is fastened to a lower surface of the top panel 88 of the vertically movable table 76 by a fastening means, not depicted, such as bolts.

The Z-axis moving means 10 operates as follows. When the electric motor 108 is energized, the ball screw 106 converts rotary motion of the electric motor 108 into linear motion, vertically moving the vertically movable table 76 with respect to the base mount 78 thereby to move the frame 74 where the unloading and loading means 6 is disposed along the Z-axis.

As illustrated in FIG. 8, the X-axis moving means 12 includes a bendable arm 112 mounted on the frame 74 and first and second electric motors 114 and 115 for actuating the bendable arm 112. The bendable arm 112 has, through a spacer 116 a first arm member 118 swingably coupled to a lower surface of the top panel 84 of the frame 74 and a second arm member 120 swingably coupled to a lower surface of the first arm member 118.

The spacer 116 is disposed on an end of the first

arm member 118. The first arm member 118 is swingably coupled to the top panel 84 for swinging movement about an axis on the spacer 116. Another spacer 122 is disposed on an opposite end of the first arm member 118. The second arm member 120 is swingably coupled to the first arm member 118 for swinging movement about an axis on the spacer 122.

The second arm member 120 has a distal end that is positioned remotely from the spacer 122 and that has a circular hole, not depicted, defined therein. The Z-axis rotational shaft 46 of the unloading and loading means 6 is inserted in the circular hole in the distal end of the second arm member 120 and non-rotatably fixed to the second arm member 120. When the electric motor coupled to the Z-axis rotational shaft 46 of the unloading and loading means 6 is energized, the casing 52 of the unloading and loading means 6 is turned with respect to the second arm member 120 to direct the blade holders 48 and the mounting nut holders 50 in desired orientations. The unloading and loading means 6 is thus coupled to the distal end of the bendable arm 112 through the Z-axis rotational shaft 46 and disposed in the frame 74 by the bendable arm 112.

The X-axis moving means 12 operates as follows.

When the first electric motor 114 is energized, it swings the first arm member 118 about the axis on the spacer 116. When the second electric motor 115 is energized, it swings the second arm member 120 about the axis on the spacer 122. The bendable arm 112 is thus bent or extended, moving the unloading and loading means 6 along the X-axis.

A cutting apparatus 170 to which the auxiliary apparatus 2 is to be coupled will be described below with reference to FIGS. 9 through 14.

As illustrated in FIG. 9, the cutting apparatus 170 includes a chuck table 172 having a holding surface for holding a workpiece thereon, a pair of cutting means 174 each having a cutting blade mounted in position by a mounting nut for cutting the workpiece held on the chuck table 172, X-axis feeding means 176 for processing-feeding the chuck table 172 along the X-axis, a pair of Y-axis feeding means 178 for indexing-feeding the cutting means 174 along the Y-axis perpendicular to the X-axis, and a pair of Z-axis feeding means 180 for incising-feeding the cutting means 174 along the Z-axis perpendicular to the X-axis and the Y-axis.

As illustrated in FIGS. 9 and 10, the cutting apparatus 170 also includes a base 182 (see FIG. 9), an

X-axis movable plate 184 movable along a pair of guide rails 182a disposed on an upper surface of the base 182 and extending along the X-axis, a support column 186 fixedly mounted on an upper surface of the X-axis movable plate 184, and a cover plate 188 fixedly mounted on an upper end of the support column 186. The cover plate 188 has a circular opening 188a defined therein. The chuck table 172 is rotatably mounted on the upper end of the support column 186 and extends upwardly through the circular opening 188a in the cover plate 188. The chuck table 172 is rotatable about its central axis along the Z-axis by an electric motor, not depicted, housed in the support column 186.

As illustrated in FIG. 10, a circular porous suction chuck 190 that is fluidly connected to a suction means, not depicted, is disposed on an upper end of the chuck table 172. In the chuck table 172, when the suction means generates and transmits suction forces to an upper surface of the suction chuck 190, the suction chuck 190 attracts and hold a workpiece under suction on the upper surface thereof.

Therefore, in the chuck table 172, the upper surface of the suction chuck 190 functions as a holding surface for holding the workpiece under suction thereon.

The holding surface lies in an XY plane defined along the X-axis and the Y-axis. A plurality of clamps 192 that are positioned at circumferentially spaced intervals are disposed on an outer circumferential surface of the chuck table 172.

As illustrated in FIG. 10, the X-axis feeding means 176 includes a ball screw 198 threadedly coupled to the X-axis movable plate 184 and extending along the X-axis and an electric motor 200 connected to an end of the ball screw 198 for rotating the ball screw 198 about its central axis. The X-axis feeding means 176 operates as follows. When the electric motor 200 is energized, the ball screw 198 converts rotary motion of the electric motor 200 into linear motion and transmits the linear motion to the X-axis movable plate 184, moving the X-axis movable plate 184 along the guide rails 182a on the base 182 thereby to processing-feed the chuck table 172 along the X-axis.

As illustrated in FIG. 9, the cutting apparatus 170 includes a portal-shaped frame 202 disposed on the upper surface of the base 182 and straddling the chuck table 172. The frame 202 includes a pair of support posts 204 spaced from each other along the Y-axis and extending upwardly from the upper surface of the base 182 and a

beam 206 extending along the Y-axis between respective upper ends of the support posts 204.

The cutting means 174 are disposed on a side surface of the beam 206, i.e., a rear side surface of the beam 206 that faces away from the viewer of FIG. 9, and are spaced from each other along the Y-axis. In the cutting apparatus 170 according to the present embodiment, the cutting means 174 have respective cutting blades facing each other along the Y-axis and are capable of simultaneously cutting the workpiece held on the chuck table 172 with the cutting blades. According to the present invention, however, the cutting apparatus 170 may have only one cutting means.

As illustrated in FIG. 11, each of the cutting means 174 includes a rectangular Y-axis movable member 208 movably supported on a side surface of the beam 206 for movement along the Y-axis, a Z-axis movable member 210 having an L-shaped cross section that is vertically movably supported on the Y-axis movable member 208 for vertical movement along the Z-axis, and a spindle housing 212 fixed to a lower end of the Z-axis movable member 210.

The Y-axis movable member 208 has a pair of guided grooves 208a defined in a side surface thereof that faces

the viewer of FIG. 11 and vertically spaced from each other along the Z-axis, the guided grooves 208a extending along the Y-axis. The guided grooves 208a are slidably fitted over respective guide rails, not depicted, extending on the rear side surface of the beam 206 along the Y-axis and vertically spaced from each other along the Z-axis.

Each of the Y-axis feeding means 178 includes a ball screw 214 extending over the rear side surface of the beam 206 along the Y-axis and an electric motor 216 coupled to an end of the ball screw 214 for rotating the ball screw 214 about its central axis. The ball screw 214 is threadedly coupled to the Y-axis movable member 208. The Y-axis feeding means 178 operates as follows. When the electric motor 216 is energized, the ball screw 214 converts rotary motion of the electric motor 216 into linear motion and transmits the linear motion to the Y-axis movable member 208, indexing-feeding the Y-axis movable member 208 along the guide rails on the rear side surface of the beam 206 along the Y-axis.

The Y-axis movable member 208 has a pair of vertical guide rails, not depicted, spaced from each other along the Y-axis and extending along the Z-axis on another side surface of the Y-axis movable member 208,

i.e., a rear side surface of the Y-axis movable member 208 that faces away from the viewer of FIG. 11. The Z-axis movable member 210 has a pair of vertical guided grooves, not depicted, defined in a side surface thereof that faces the viewer of FIG. 11 and spaced from each other along the Y-axis. The guided grooves are slidably fitted respectively over the vertical guide rails of the Y-axis movable member 208.

Each of the Z-axis feeding means 180 includes a ball screw, not depicted, threadedly coupled to the Z-axis movable member 210 and extending along the Z-axis and an electric motor 218 coupled to an end of the ball screw for rotating the ball screw about its central axis. The Z-axis feeding means 180 operates as follows. When the electric motor 218 is energized, the ball screw converts rotary motion of the electric motor 218 into linear motion and transmits the linear motion to the Z-axis movable member 210, incising-feeding the Z-axis movable member 210 along the guide rails of the Y-axis movable member 208 along the Z-axis.

As illustrated in FIG. 12, the spindle housing 212 supports thereon a cylindrical spindle 220 that is rotatable about its central axis along the Y-axis, and houses therein an electric motor, not depicted, for

rotating the spindle 220 about its central axis. A cutting blade for cutting a workpiece is detachably fixed to a distal end of the spindle 220 by a mounting nut 222. In FIG. 12, a hub blade 36, for example, is fixed as the cutting blade to the spindle 220.

The cutting blade is covered with a blade cover 224 mounted on a distal end of the spindle housing 212. The blade cover 224 has a first cover member 224a fixed to the distal end of the spindle housing 212 and a second cover member 224b movably mounted on a distal end of the first cover member 224a. The second cover member 224b is movable along the X-axis by an actuator, not depicted, such as an air cylinder. When the cutting blade is to be replaced, the second cover member 224b is moved to and positioned in an open position illustrated in FIG. 12. When the cutting blade is to cut a workpiece, the second cover member 224b is moved to and positioned in a closed position illustrated in FIG. 11.

As illustrated in FIG. 13, an annular mount flange 226 that protrudes radially outwardly is mounted on the outer circumferential surface of a distal end portion of the spindle 220. The mount flange 226 has an annular recess 226a defined in a radially inward portion of a distal end face thereof. The distal end face of the mount

flange 226 also includes a radially outward portion acting as an annular bearing portion 226b that protrudes axially. The spindle 220 includes a distal end portion extending axially beyond the mount flange 226 and having an externally threaded surface 228.

When a hub blade 36 is mounted as a cutting blade on the spindle 220, the central opening 38a of the hub blade 36 is fitted over the distal end portion of the spindle 220, and the mounting nut 222 is threaded over, i.e., tightened on, the externally threaded surface 228 of the spindle 220, sandwiching the hub blade 36 between the bearing portion 226b of the mount flange 226 and the mounting nut 222. In this manner, the hub blade 36 is detachably secured to the distal end portion of the spindle 220. The mounting nut 222 has a plurality of pin holes 222a defined in a side surface of the mounting nut 222 at circumferentially equal spaced intervals for receiving the respective pins 72 of each of the mounting nut holders 50 in the unloading and loading means 6.

When a washer blade 45 is mounted as a cutting blade on the spindle 220, as illustrated in FIG. 14, the washer blade 45 is placed between the bearing portion 226b of the mount flange 226 and an annular mount flange 229, and the mounting nut 222 is threaded over, i.e.,

tightened on, the externally threaded surface 228 of the spindle 220, sandwiching the washer blade 45 between the bearing portion 226b of the mount flange 226 and the annular mount flange 229. In this manner, the washer blade 45 is detachably secured to the distal end portion of the spindle 220.

The mount flange 229 has an annular land 229a axially protruding from a reverse side thereof and having an outside diameter D, which is the same as the outside diameter D of the shank 34 of the cutting blade storing means 4, commensurate with the inside diameter of the central opening 45a of the washer blade 45. When the washer blade 45 is fixedly mounted on the spindle 220, the central opening 45a in the washer blade 45 is fitted over the annular land 229a of the mount flange 229.

As illustrated in FIG. 9, a pair of image capturing means 230 for capturing images of a workpiece held on the chuck table 172 are movably mounted on another side surface, i.e., a front side surface facing the viewer of FIG. 9, of the beam 206 of the frame 202. The image capturing means 230 are movable along the Y-axis by a pair of respective moving means 232 mounted on the front side surface of the beam 206.

Each of the moving means 232 has a ball screw 234

extending over the front side surface of the beam 206 along the Y-axis and an electric motor 236 coupled to an end of the ball screw 234 for rotating the ball screw 234 about its central axis. The ball screw 234 is coupled to the image capturing means 230. The moving means 232 operates as follows. When the electric motor 236 is energized, the ball screw 234 converts rotary motion of the electric motor 236 into linear motion and transmits the linear motion to the image capturing means 230, moving the image capturing means 230 along the Y-axis along guide rails 206a mounted on the front side surface of the beam 206. Although the cutting apparatus 170 according to the present embodiment includes two image capturing means 230, the cutting apparatus 170 may have only one image capturing means 230.

For cutting a workpiece such as a wafer on the cutting apparatus 170, the workpiece is held under suction on the chuck table 172. Then, the X-axis feeding means 176 moves the chuck table 172 to a position below the image capturing means 230, and the moving means 232 adjust the positions of the image capturing means 230 along the Y-axis. Then, the image capturing means 230 capture images of the workpiece and detect regions to be cut of the workpiece.

On the basis of the regions to be cut of the workpiece that have been detected by the image capturing means 230, the chuck table 172 is rotated about its central axis to adjust the orientation of the regions to be cut of the workpiece with respect to the cutting blades of the cutting means 174. Then, the X-axis feeding means 176 moves the chuck table 172 along the X-axis, and the Y-axis feeding means 178 move the spindle housings 212 along the Y-axis, positioning the cutting blades above the regions to be cut of the workpiece.

Then, the Z-axis feeding means 180 lower the spindle housings 212 to cause the cutting edges of the cutting blades that are rotating at a high speed to cut into the regions to be cut of the workpiece. At the same time, while cutting water is being supplied to the regions of the workpiece into which the cutting edges of the cutting blades are cutting, the X-axis feeding means 176 incising-feeds the chuck table 172 along the X-axis to cause the cutting blades to cut the regions to be cut of the workpiece. Then, the Y-axis feeding means 178 indexing-feeds the spindle housings 212 along the Y-axis, after which the above cutting process is repeated to fully cut the regions to be cut of the workpiece. The workpiece that has been cut in the cutting process is

delivered to a next processing step.

When the cutting process is repeated, the cutting blades are progressively worn. When the cutting blades are worn to a certain threshold level, their cutting accuracy drops below a required accuracy level.

Therefore, those unduly worn cutting blades mounted on the spindles 220 need to be replaced with fresh cutting blades. Even if the cutting blades mounted on the spindles 220 have not been worn to the threshold level, when the cutting apparatus 170 is required to cut workpieces of a material different from the material of the workpieces that have been cut previously, the cutting blades mounted on the spindles 220 need to be replaced with cutting blades that match the different material of the workpieces to be cut.

According to the present embodiment, as illustrated in FIG. 15, the auxiliary apparatus 2 that is capable of automatically replacing the cutting blades of the cutting apparatus 170 is coupled to the cutting apparatus 170. A process of replacing hub blades 36 on the spindles 220 using the auxiliary apparatus 2 will be described below by way of example.

As illustrated in FIG. 15, the auxiliary apparatus 2 is disposed behind the cutting apparatus 170 along the

X-axis. The auxiliary apparatus 2 can subsequently be added to the cutting apparatus 170 that has already been delivered to the user. The cutting blades on the cutting apparatus 170 are replaced with fresh cutting blades by the auxiliary apparatus 2, as follows. First, the endless track 22 of the cutting blade storing means 4 is rotated to bring the blade support shaft 24 that is supporting a fresh hub blade 36 to be loaded into the cutting apparatus 170 to a predetermined position, e.g., a position at the lowermost end of the path followed by the endless track 22.

Then, as illustrated in FIG. 16, the electric motor coupled to the Z-axis rotational shaft 46 of the unloading and loading means 6 is energized to rotate the casing 52 until one of the side walls 56 of the casing 52 on which a blade holder 48 is mounted extends along the X-axis, thereby causing the blade holder 48 to face the cutting blade storing means 4.

The X-axis moving means 12 and the Z-axis moving means 10 are actuated to adjust the position of the blade holder 48 along the X-axis and the position of the blade holder 48 along the Z-axis in order to allow the shank 34 of the blade support shaft 24 in the predetermined position referred to above to be inserted into the

central opening 60 (see FIG. 6) of the blade holder 48.

Then, as illustrated in FIG. 17, the Y-axis positioning means 8 is actuated to move the frame 74 along the Y-axis to position the unloading and loading means 6 in the working position where the blade holder 48 can hold the hub blade 36 supported on the blade support shaft 24. The shank 34 of the blade support shaft 24 in the predetermined position is now inserted into the central opening 60 of the blade holder 48, and the end face 58 of the blade holder 48 is brought into contact with the end face of the hub blade 36 that is positioned on the distal end portion of the shank 34. Then, suction forces are generated and transmitted to act in the first suction holes 61 of the blade holder 48, enabling the blade holder 48 to hold the hub blade 36 positioned on the distal end portion of the shank 34 under suction.

Then, the Y-axis positioning means 8 is actuated to space the unloading and loading means 6 away from the cutting blade storing means 4 along the Y-axis and position the unloading and loading means 6 in the retracted position. Then, the casing 52 of the unloading and loading means 6 is turned 180° to cause the blade holder 48 that is diametrically opposite the blade holder 48 that is holding the hub blade 36 under suction to face

the cutting blade storing means 4.

Then, the Y-axis positioning means 8 is actuated to position the unloading and loading means 6 in the working position where the opposite blade holder 48 can hold a hub blade 36 supported on a blade support shaft 24. Then, suction forces are generated and transmitted to act in the first suction holes 61 of the opposite blade holder 48, enabling the opposite blade holder 48 to hold the hub blade 36 positioned on the distal end portion of the shank 34 under suction. Now, the two diametrically opposite blade holders 48 of the four blade holders 48 have held fresh hub blades 36 under suction.

Then, as illustrated in FIG. 18, the Y-axis positioning means 8 is actuated to move the frame 74 away from the cutting blade storing means 4 along the Y-axis, and the Z-axis moving means 10 is actuated to move the vertically movable table 76 along the Z-axis. Thus, the unloading and loading means 6 is spaced from the cutting blade storing means 4 and placed in the retracted position, and the positions of the unloading and loading means 6 along the Y-axis and the Z-axis with respect to the cutting apparatus 170 are adjusted. The adjusted position of the unloading and loading means 6 along the Y-axis lies between the pair of cutting means 174 of the

cutting apparatus 170, and the adjusted position of the unloading and loading means 6 along the Z-axis lies above the holding surface of the chuck table 172.

Then, as illustrated in FIG. 19, the X-axis moving means 12 is actuated to move or advance the unloading and loading means 6 along the X-axis to adjust the position of the unloading and loading means 6 along the X-axis with respect to the pair of cutting means 174. Specifically, the positions along the X-axis of the centers of the fresh hub blades 36 held under suction respectively by the two blade holders 48 of the unloading and loading means 6 and the positions along the X-axis of the centers of the hub blades 36 mounted on the pair of cutting means 174 are aligned with each other.

The Z-axis moving means 10 of the auxiliary apparatus 2 or the Z-axis feeding means 180 of the cutting apparatus 170 is actuated to align the positions along the Z-axis of the centers of the hub blades 36 on the blade holders 48 and the positions along the Z-axis of the centers of the hub blades 36 on cutting means 174 with each other.

Then, the casing 52 of the unloading and loading means 6 is turned 60° to cause the two mounting nut holders 50 to face the hub blades 36 on the pair of

cutting means 174. The casing 52 may be turned 60° before the unloading and loading means 6 is advanced.

Then, the second cover members 224b of the respective blade covers 224 of the cutting means 174 are brought into the open position (see FIG. 12). Then, the Y-axis feeding means 178 of the cutting apparatus 170 are actuated to move the cutting means 174 along the Y-axis until the mounting nuts 222 by which the hub blades 36 are mounted on the spindles 220 are brought into contact with the end faces 66a of the rotors 66 of the mounting nut holders 50. The pins 72 of the mounting nut holders 50 are pushed into the rotors 66 by the mounting nuts 222, and the distal end portions of the spindles 220 are placed in the central openings 68 of the rotors 66.

Then, the electric motors of the mounting nut holders 50 are energized to rotate the rotors 66 until the pins 72 are aligned with the respective pin holes 222a in the mounting nuts 222 whereupon the pins 72 are fitted respectively into the pin holes 222a. The rotary motion of the rotors 66 is transmitted through the pins 72 to the mounting nuts 222, loosening the mounting nuts 222. The mounting nuts 222 are now threaded off, i.e., removed from, the externally threaded surfaces 228 of the spindles 220 of the cutting means 174. Then, suction

forces are generated and transmitted to act in the suction holes 70 of the mounting nut holders 50, enabling the mounting nut holders 50 to hold the mounting nuts 222 that have been removed from the spindles 220.

Then, the Y-axis feeding means 178 are actuated to space the cutting means 174 away from the unloading and loading means 6, and the casing 52 of the unloading and loading means 6 is turned 60° to cause empty blade holders 48 that are not holding hub blades 36 under suction to face the hub blades 36 on the cutting means 174.

Then, the Y-axis feeding means 178 are actuated to move the cutting means 174 closer to the unloading and loading means 6 until the spindles 220 of the cutting means 174 are inserted into the central openings 60 of the empty blade holders 48 and the end faces 58 of the empty blade holders 48 are brought into contact with the end faces of the hub blades 36 on the cutting means 174. Then, suction forces are generated and transmitted to act in the first suction holes 61 of the empty blade holders 48, enabling the empty blade holders 48 to hold the hub blades 36 on the cutting means 174 under suction.

Then, the Y-axis feeding means 178 are actuated to space the cutting means 174 away from the unloading and

loading means 6, and the casing 52 of the unloading and loading means 6 is turned 60° to cause the blade holders 48 that are holding the fresh hub blades 36 under suction to face the spindles 220 of the cutting means 174.

Then, the Y-axis feeding means 178 are actuated to move the cutting means 174 closer to the unloading and loading means 6 until the spindles 220 are inserted into the central openings 60 of the fresh hub blades 36 and the end faces of the fresh hub blades 36 are brought into contact with the bearing portions 226b of the mount flanges 226 of the spindles 220. Then, the blade holders 48 are released of the suction forces, transferring the fresh hub blades 36 to the spindles 220.

Then, the Y-axis feeding means 178 are actuated to space the cutting means 174 away from the unloading and loading means 6, and the casing 52 of the unloading and loading means 6 is turned 60° to cause the mounting nut holders 50 that are holding the removed mounting nuts 222 under suction to face the spindles 220 of the cutting means 174.

Then, the Y-axis feeding means 178 are actuated to move the cutting means 174 closer to the unloading and loading means 6 until the mounting nuts 222 held under suction by the mounting nut holders 50 are fitted over

the distal end portions of the spindles 220. Then, the electric motors of the mounting nut holders 50 are reversed to rotate the mounting nuts 222 in a direction opposite the direction in which the mounting nuts 222 have been rotated for removal from the spindles 220, threading the mounting nuts 222 over, i.e., tightening the mounting nuts 222 on, the external threaded surfaces 228 of the spindles 220.

In this manner, the fresh hub blades 36 to be mounted on the cutting means 174 are fixedly mounted on the spindles 220 by being sandwiched between the bearing portions 226b of the mount flanges 226 of the spindles 220 and the mounting nuts 222.

Then, after the mounting nut holders 50 have been released of the suction forces, the second cover members 224b of the blade covers 224 of the cutting means 174 are brought into the closed position. The mounting nuts 222 and the hub blades 36 may be mounted on or removed from the pair of cutting means 174 simultaneously or separately.

Then, the unloading and loading means 6 is retracted and the casing 52 of the unloading and loading means 6 is turned 60° to cause one of the pair of removed hub blades 36 to face the cutting blade storing means 4.

The endless track 22 of the cutting blade storing means 4 is rotated to place an empty blade support shaft 24 that is not supporting a hub blade 36 into a predetermined position, e.g., a position at the lowermost end of the path followed by the endless track 22.

Then, the X-axis moving means 12 and the Z-axis moving means 10 are actuated to adjust the position of the blade holder 48 along the X-axis and the position of the blade holder 48 along the Z-axis in order to allow the shank 34 of the blade support shaft 24 in the predetermined position referred to above to be inserted into the central opening 38a of one of the hub blades 36 that is held under suction by the blade holder 48.

Then, the Y-axis positioning means 8 is actuated to move the frame 74 along the Y-axis to insert the shank 34 of the blade support shaft 24 in the predetermined position referred to above into the central opening 38a of one of the hub blades 36 held under suction by the blade holders 48 and to bring the end face of the one of the hub blades 36 into contact with the end face of the base 32 of the blade support shaft 24. Then, the blade holder 48 is released of the suction forces, transferring the removed one of the hub blades 36 to the blade support shaft 24.

The Y-axis positioning means 8 is actuated to space the unloading and loading means 6 away from the cutting blade storing means 4 along the Y-axis, and the casing 52 of the unloading and loading means 6 is turned 180° to cause the blade holder 48 that is diametrically opposite the blade holder 48 that is holding the removed other hub blade 36 under suction to face the cutting blade storing means 4.

Then, the Y-axis positioning means 8 is actuated to move the frame 74 along the Y-axis to insert the shank 34 of the blade support shaft 24 in the predetermined position referred to above into the central opening 38a of the other hub blade 36 held under suction by the diametrically opposite blade holder 48 and to bring the end face of the other hub blade 36 into contact with the end face of the hub blade 36 supported on the blade support shaft 24. Then, the blade holder 48 is released of the suction forces, transferring the removed other hub blade 36 to the blade support shaft 24.

As described above, the auxiliary apparatus 2 according to the present embodiment can subsequently be added to the cutting apparatus 170 that has already been delivered to the user for replacing the cutting blades mounted on the cutting means 174 of the cutting apparatus

170.

In the above example, the process of replacing hub blades 36 on the spindles 220 using the auxiliary apparatus 2 has been described. According to the present embodiment, the auxiliary apparatus 2 may be used to replace washer blades 45 on the spindles 220.

For replacing washer blades 45 on the spindles 220, the unloading and loading means 6 is positioned between the pair of cutting means 174 of the cutting apparatus 170 while fresh replacement washer blades 45 are not being held under suction by the blade holders 48. Then, the mounting nut holders 50 are positioned to face the cutting means 174 and actuated to remove the mounting nuts 222 from the spindles 220 of the cutting means 174.

Then, the blade holders 48 are positioned to face the cutting means 174, and suction forces are generated and transmitted to act in the first suction holes 61 of the blade holders 48, enabling the blade holders 48 to hold the mount flanges 229 under suction and remove the mount flanges 229 from the spindles 220. Suction forces are also generated and transmitted to act in the second suction holes 63, enabling the blade holders 48 to hold the washer blades 45 mounted on the spindles 220.

Then, the unloading and loading means 6 is moved

toward the cutting blade storing means 4, and the blade holders 48 that are holding the mount flanges 229 and the washer blades 45 under suction are caused to face the cutting blade storing means 4. The second suction holes 63 are released of suction forces, allowing the washer blades 45 to be stored in the cutting blade storing means 4. Then, suction forces are generated and transmitted to act in the first suction holes 61 of the blade holders 48 that are holding the mount flanges 229 under suction, enabling the blade holders 48 to hold fresh replacement washer blades 45 under suction. Namely, the same blade holders 48 hold the fresh replacement washer blades 45 as well as the mount flanges 229 under suction.

Then, the blade holders 48 that are holding the mount flanges 229 and the fresh washer blades 45 are caused to face the cutting means 174, and transfer the mount flanges 229 and the fresh washer blades 45 to the spindles 220. After the mounting nut holders 50 have been caused to face the cutting means 174, the mounting nuts 222 are threaded over the externally threaded surfaces 228 of the spindles 220. In this fashion, the auxiliary apparatus 2 can subsequently be added to the cutting apparatus 170 that has already been delivered to user for replacing the washer blades 45 on the cutting apparatus

170.

The present invention is not limited to the details of the above described preferred embodiment. The scope of the invention is defined by the appended claims and all changes and modifications as fall within the equivalence of the scope of the claims are therefore to be embraced by the invention.

WHAT IS CLAIMED IS:

1. An auxiliary apparatus adapted to be coupled to a cutting apparatus including a chuck table having a holding surface for holding a workpiece thereon, cutting means including a cutting blade mounted thereon with a mounting nut, for cutting the workpiece held on the chuck table, X-axis feeding means for processing-feeding the chuck table along an X-axis, Y-axis feeding means for indexing-feeding the cutting means along a Y-axis perpendicular to the X-axis, and Z-axis feeding means for incising-feeding the cutting means along a Z-axis perpendicular to the X-axis and the Y-axis, the holding surface being defined along the X-axis and the Y-axis, the auxiliary apparatus comprising:

cutting blade storing means for storing a plurality of cutting blades therein;

unloading and loading means for unloading cutting blades from and loading cutting blades into the cutting blade storing means;

Y-axis positioning means for selectively bringing the unloading and loading means into a working position and a retracted position along the Y-axis with respect to the cutting blade storing means;

Z-axis moving means for moving the unloading and

loading means along the Z-axis; and

X-axis moving means for moving the unloading and loading means along the X-axis to act on the cutting blade mounted on a spindle of the cutting means,

wherein the unloading and loading means includes a Z-axis rotational shaft extending along the Z-axis;

a blade holder coupled radially to the Z-axis rotational shaft for holding the cutting blade under suction thereon, and

a mounting nut holder for threading a mounting nut over or off an externally threaded distal end portion of the spindle, and

wherein the unloading and loading means is coupled to a distal end of a bendable arm by the Z-axis rotational shaft.

2. The auxiliary apparatus according to claim 1,

wherein the unloading and loading means is disposed in a frame by the bendable arm, and the frame is slidably supported on a guide rail disposed on a vertically movable table and extending along the Y-axis and is selectively positionable in the working position and the retracted position with respect to the cutting blade storing means by the Y-axis positioning means.

3. The auxiliary apparatus according to claim 1 or 2, wherein

the bendable arm advances and retracts the unloading and loading means along the X-axis.

4. The auxiliary apparatus according to claim 1, wherein

the cutting blade storing means includes

a drive gear having a rotational shaft extending along the Y-axis,

a driven gear spaced from the drive gear along the Z-axis and having a rotational shaft extending along the Y-axis,

an endless track trained around the drive gear and the driven gear, and

a plurality of blade support shafts disposed at predetermined spaced intervals on the endless track, for supporting the cutting blades by being inserted in central openings defined in the cutting blades, the blade support shafts extending along the Y-axis.

5. The auxiliary apparatus according to claim 4, wherein

a distance along the Z-axis between the drive gear and the driven gear is adjustable, and a length of the endless track is adjustable.

6. The auxiliary apparatus according to claim 4,
wherein

each of the cutting blades storable by the cutting
blade storing means includes a hub blade having a base
and a cutting edge disposed on an outer circumferential
portion of the base,

each of the blade support shafts has an outside
diameter commensurate with an inside diameter of a
central opening defined in the hub blade, and

the blade holder holds the hub blade.

7. The auxiliary apparatus according to claim 4,
wherein

each of the cutting blades storable by the cutting
blade storing means includes a washer blade including an
annular cutting edge,

each of the blade support shafts has an outside
diameter commensurate with an inside diameter of a
central opening defined in the washer blade, and

the blade holder holds the washer blade and a mount
flange for mounting the washer blade on the spindle of
the cutting means.