Title (en)

METHOD FOR MAKING IDENTITY CORES FOR ULTRASOUND SEALS

Title (de)

HERSTELLUNGSVERFAHREN EINES IDENTIFIKATIONSKERNS FÜR ULTRASCHALLSIEGEL

Title (fr)

PROCEDE DE FABRICATION DE NOYAUX D'IDENTITE POUR DES SCEAUX A ULTRASONS

Publication

EP 1042746 A1 20001011 (FR)

Application

EP 98965862 A 19981221

Priority

- EP 9808385 W 19981221
- LU 90187 A 19971222

Abstract (en)

[origin: WO9933045A1] The invention concerns a method for making identity cores for ultrasound seals. Each core comprises a chip consisting of a brazed stack of metal disks (1) bearing at least one notch (3), the resulting identity being defined by the number, the size and the random angular position of the various notches in the stack and by the unpredictability of the brazing. The invention is characterised in that the notched disks (1) provided with a central hole (2) are first stacked in large numbers in a tubular metal sheath (4) with a circular cross-section corresponding to said disks (1). The stack is then axially compressed in the sheath (4) and a brazing bead (7) is inserted in the channel constituted by the assembly of aligned central holes (2). After brazing in a vacuum oven, the two ends of the sheath are eliminated and the resulting column is segmented perpendicularly to its axis into a series of individual identity chips (8) of predetermined thickness. Such a chip is finally associated by brazing with a metal block (13) used as delay line to constitute the core. Identity control can be combined with integrity control by associating an integrity rod (10 to 12) with said block (13), whereby with one reading both identity and integrity can be ascertained.

IPC 1-7

G09F 3/03

IPC 8 full level

G21F 7/00 (2006.01); **G09F 3/03** (2006.01); **G21F 5/00** (2006.01)

CPC (source: EP US)

G09F 3/0317 (2013.01 - EP US); Y10T 29/49826 (2015.01 - EP US); Y10T 29/49904 (2015.01 - EP US); Y10T 29/49968 (2015.01 - EP US)

Citation (search report)

See references of WO 9933045A1

Cited by

EP3205996A1; EP3206211A1; WO2017140575A1; US11410578B2

Designated contracting state (EPC)

AT BE CH DE DK ES FI FR GB GR IE IT LI LU MC NL PT SE

DOCDB simple family (publication)

WO 9933045 A1 19990701; AT E214186 T1 20020315; CA 2310134 A1 19990701; CA 2310134 C 20080212; DE 69804140 D1 20020411; DE 69804140 T2 20020725; DK 1042746 T3 20020624; EP 1042746 A1 20001011; EP 1042746 B1 20020306; ES 2174541 T3 20021101; JP 2001527219 A 20011225; LU 90187 B1 19990624; NO 20001321 D0 20000314; NO 20001321 L 20000622; NO 315178 B1 20030721; PT 1042746 E 20020731; US 6694593 B1 20040224

DOCDB simple family (application)

EP 9808385 W 19981221; AT 98965862 T 19981221; CA 2310134 A 19981221; DE 69804140 T 19981221; DK 98965862 T 19981221; EP 98965862 A 19981221; ES 98965862 T 19981221; JP 2000525876 A 19981221; LU 90187 A 19971222; NO 20001321 A 20000314; PT 98965862 T 19981221; US 53035402 A 20020517