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**Biegelsen et al.**

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(54) **METHOD FOR CUTTING A MEMBER TO FORM A DESIRED STRUCTURE**

(75) Inventors: **David Kalman Biegelsen**, Portola Valley, CA (US); **Lars Erik Swartz**, Sunnyvale, CA (US)

(73) Assignee: **Xerox Corporation**, Stamford, CT (US)

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(52) **U.S. Cl.** ..... **156/248**; 156/247; 156/272.8; 156/257; 156/268; 219/121.67; 219/121.68; 219/121.69; 219/121.72; 219/121.7; 219/121.73

(58) **Field of Search** ..... 219/121.67, 121.68, 219/121.69, 121.72, 121.7, 121.73; 83/565; 156/247, 248, 249, 252, 253, 257, 267, 268, 272.8, 344

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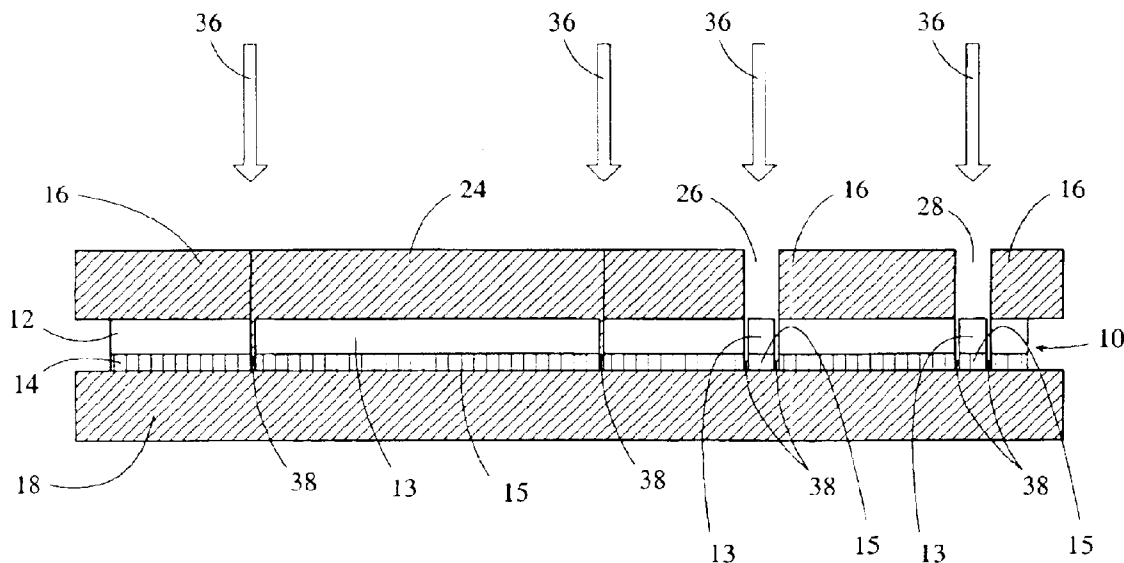
*Primary Examiner*—Linda L Gray

(74) *Attorney, Agent, or Firm*—Fay, Sharpe, Fagan, Minnich & McKee, LLP

(57) **ABSTRACT**

A method and apparatus for improved cutting of an object is provided. The object can take the form of many different structures including thin formations that require cutting precision, support, and dimensional control. In accordance with one example embodiment of the present invention, the method of cutting a member uses a laser and begins with the step of providing a template removably adhered to the member. The laser then projects through the template, without intersecting with the template, to cut the member and manufacture the desired formation. The laser does not intersect with, and therefore does not cut, the template structure and cause excess laser cutting dust.

**9 Claims, 10 Drawing Sheets**



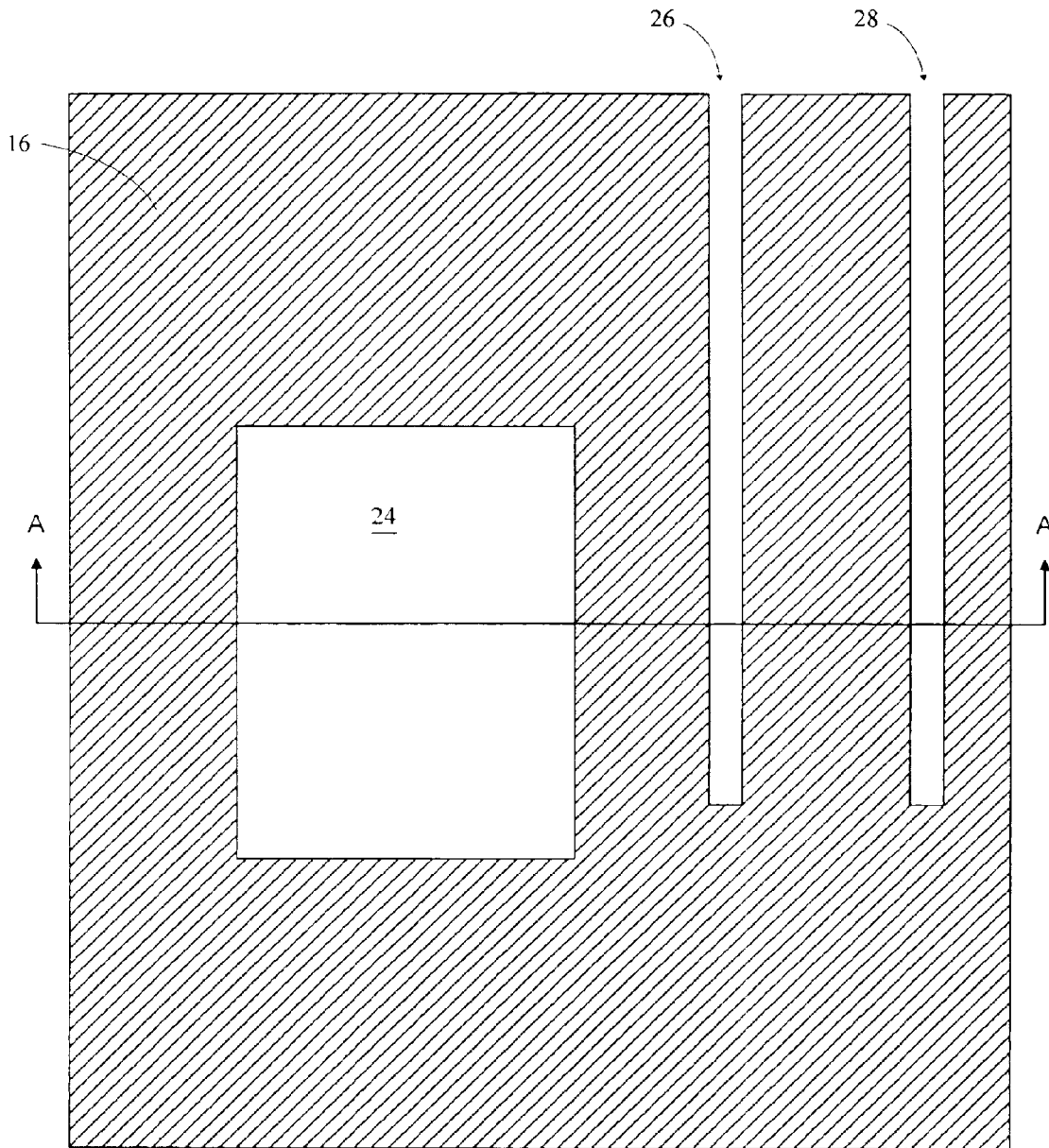


FIG. 1

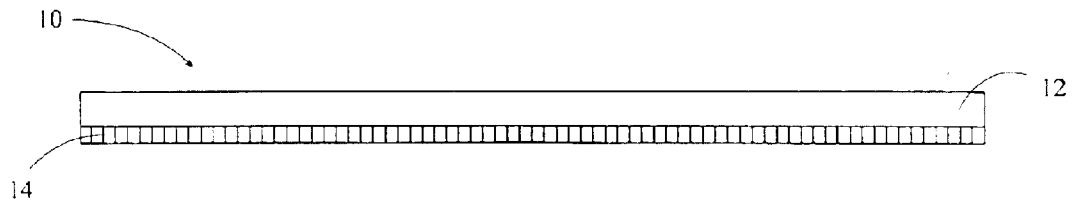


FIG. 2

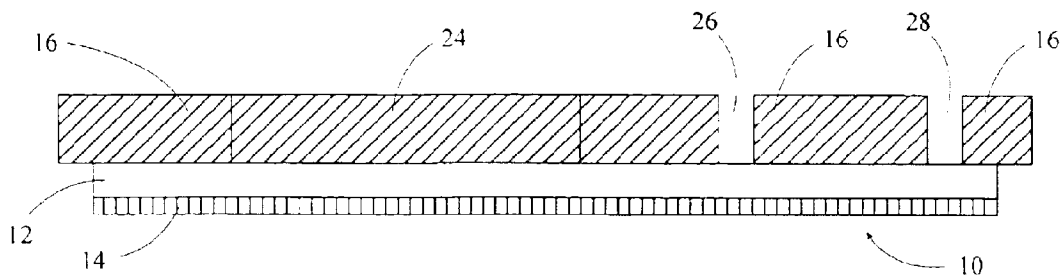


FIG. 3

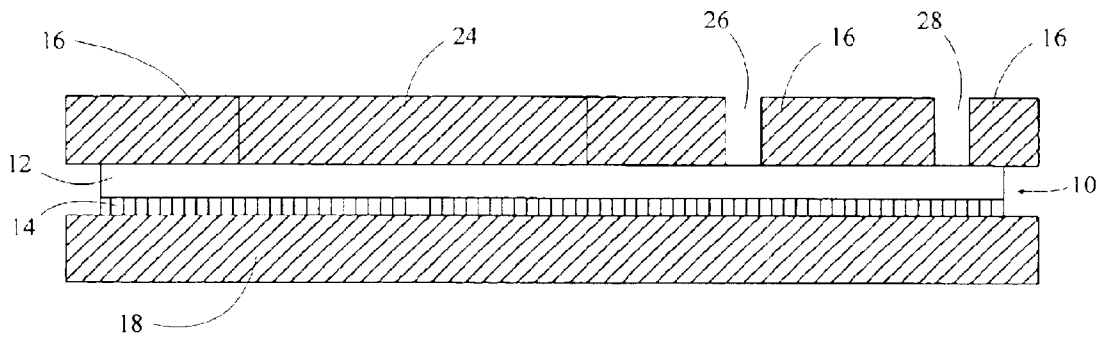


FIG. 4

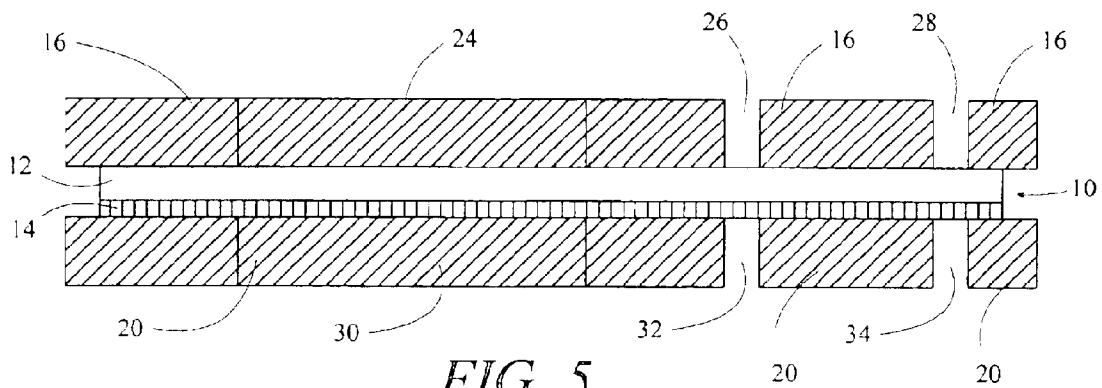


FIG. 5

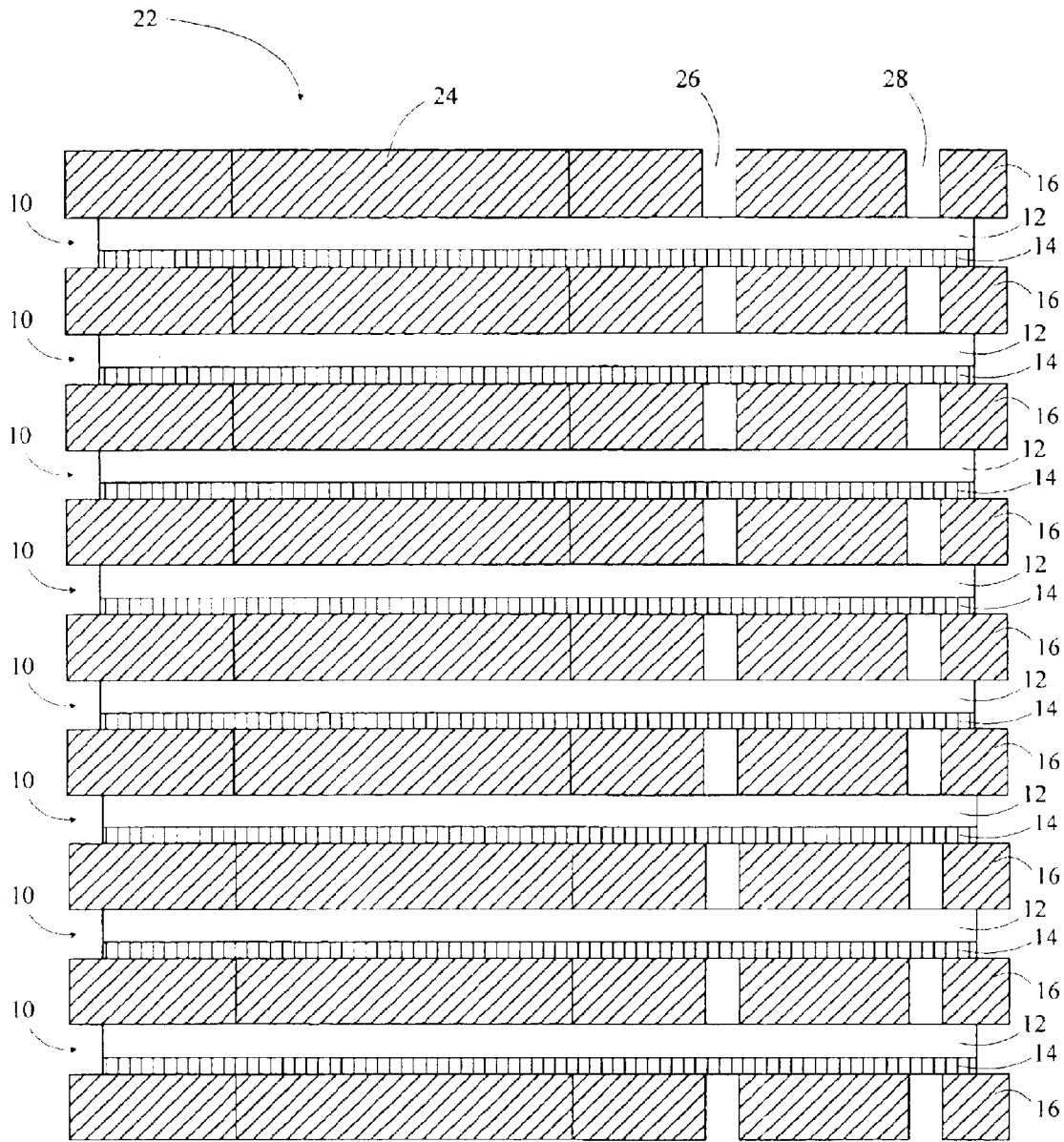


FIG. 6

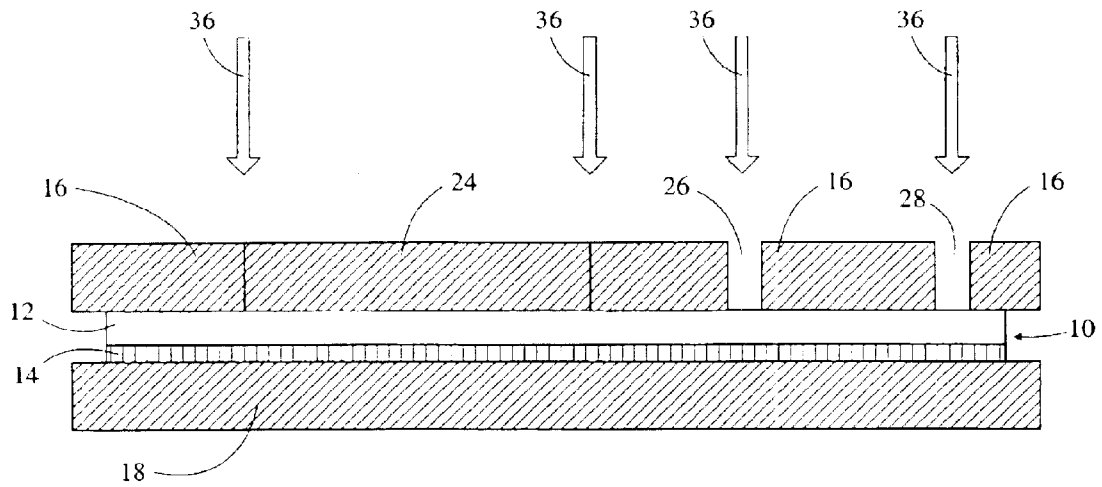


FIG. 7

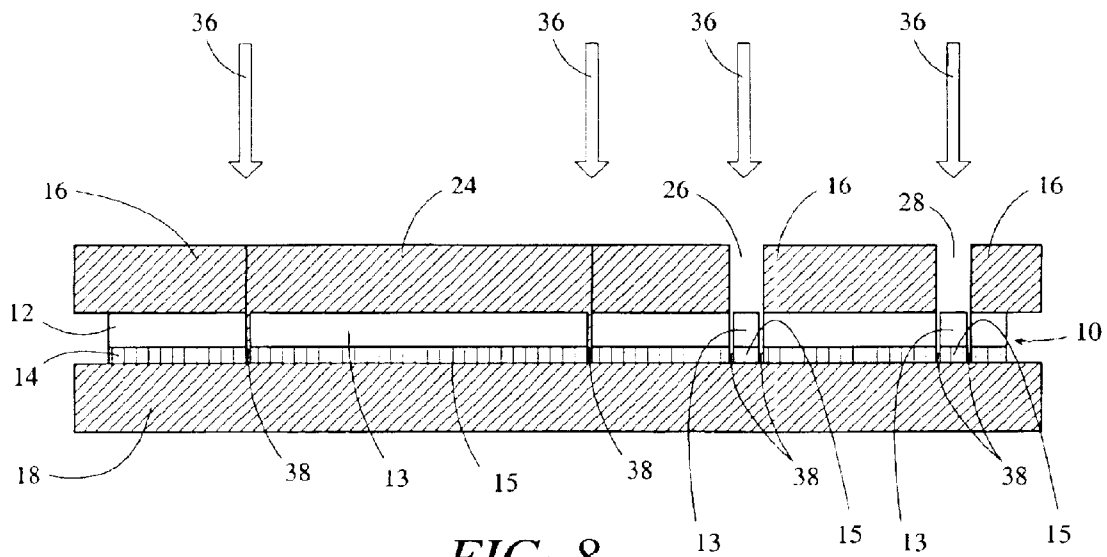


FIG. 8

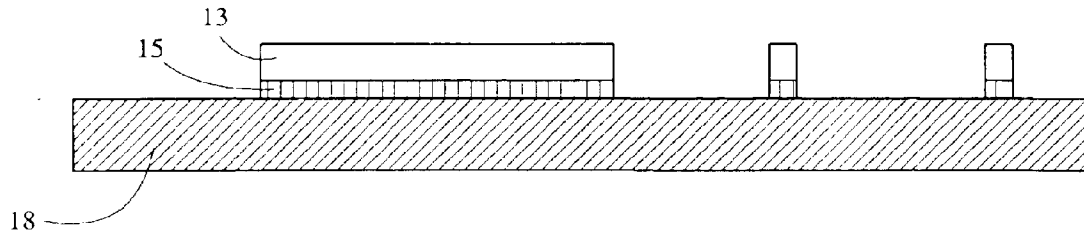


FIG. 9

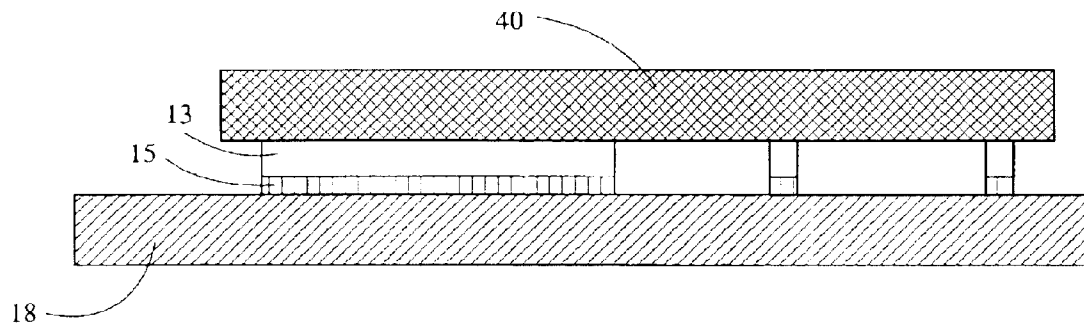


FIG. 10

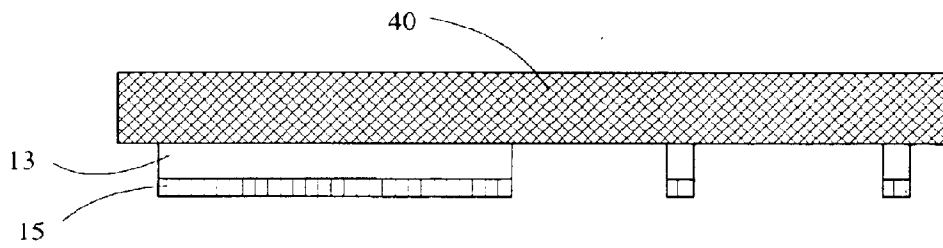


FIG. 11

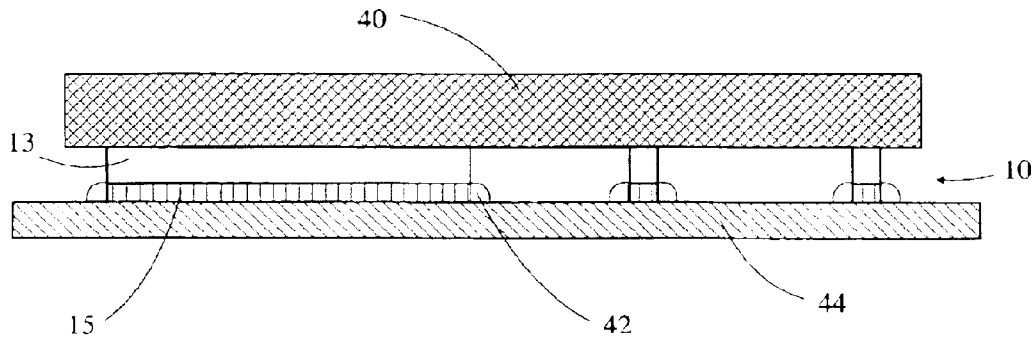


FIG. 12

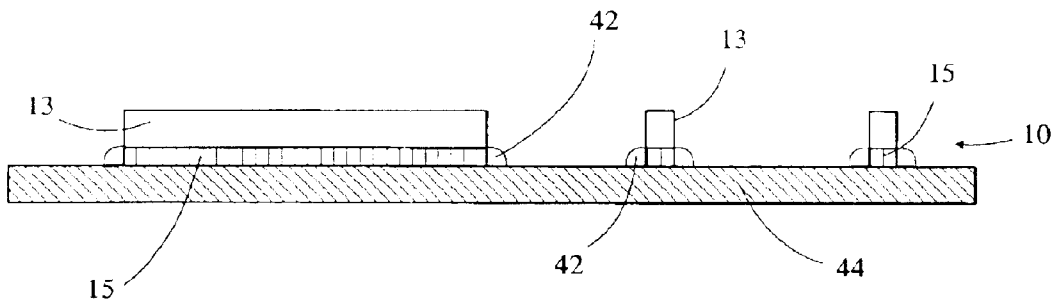


FIG. 13

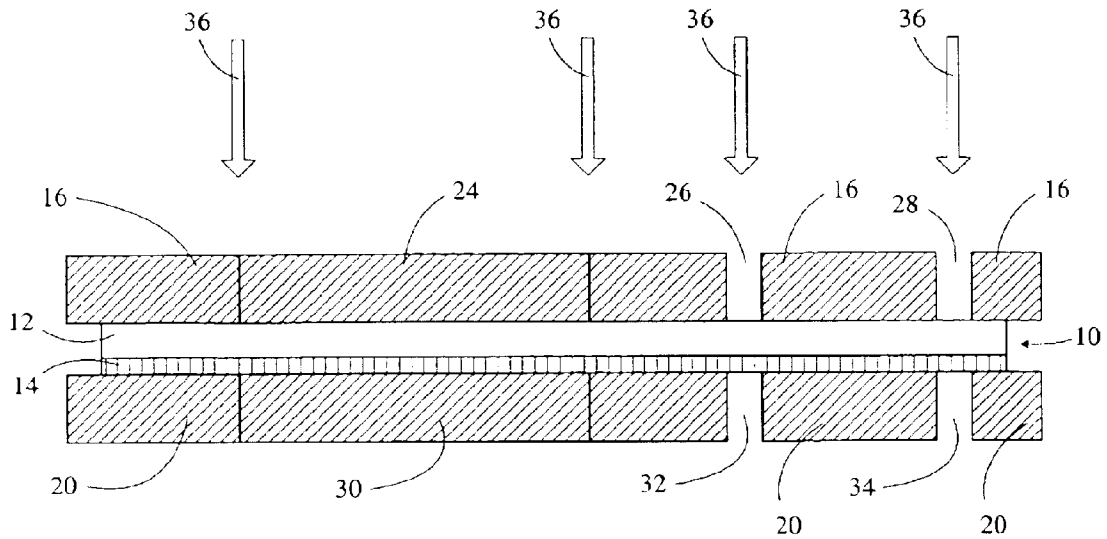


FIG. 14

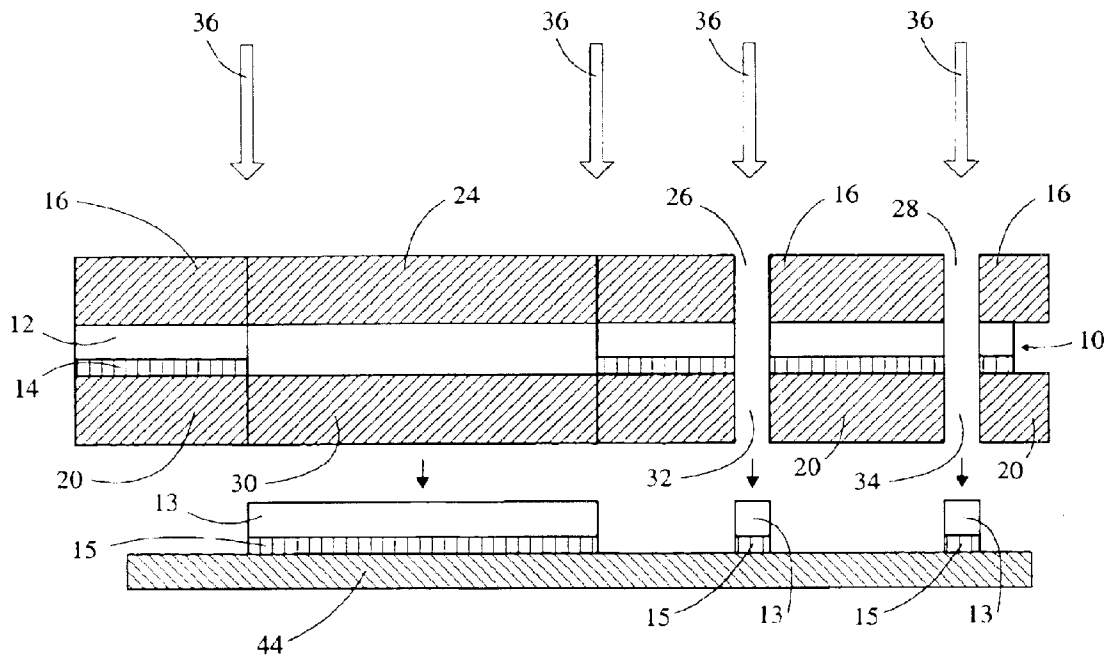


FIG. 15



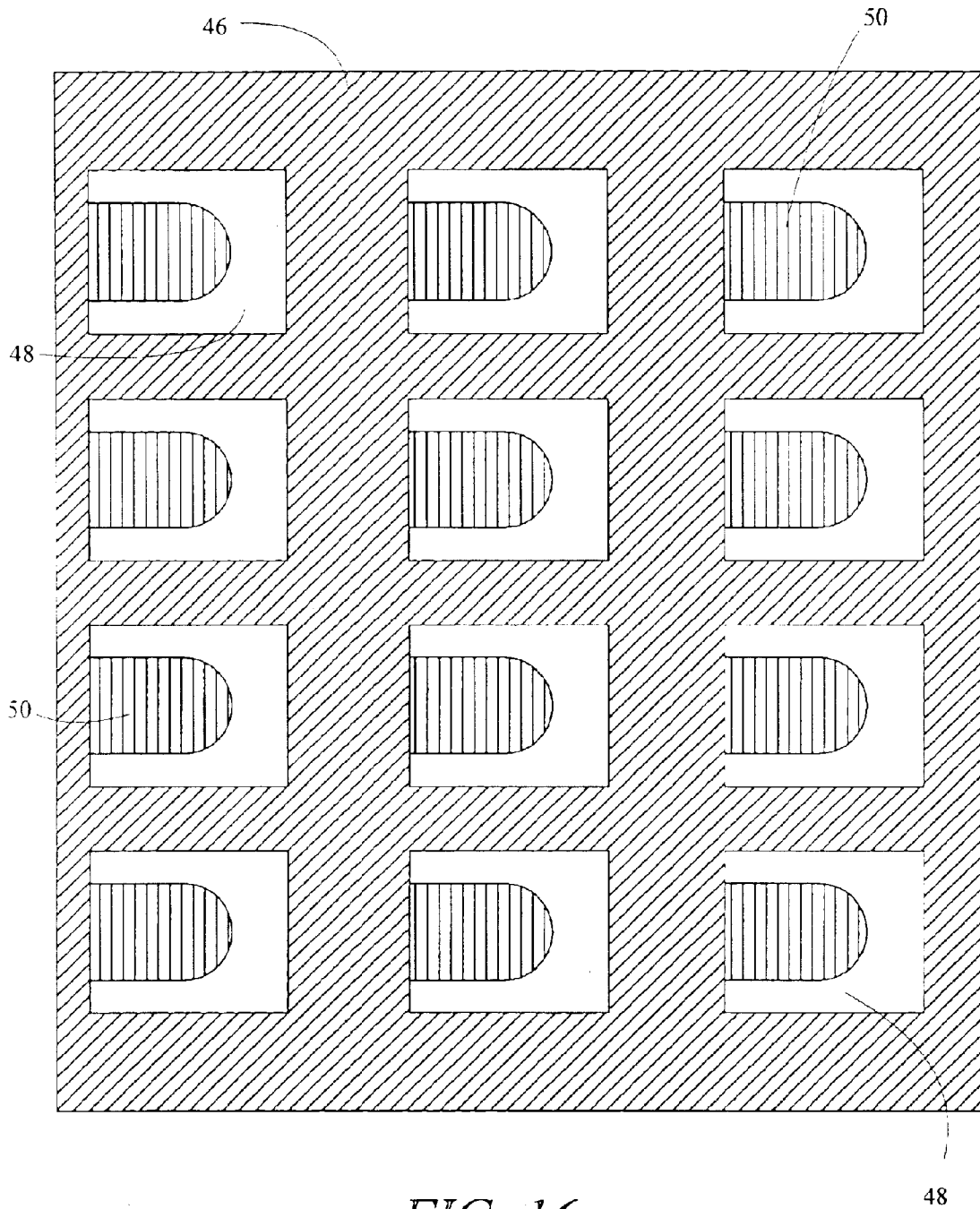
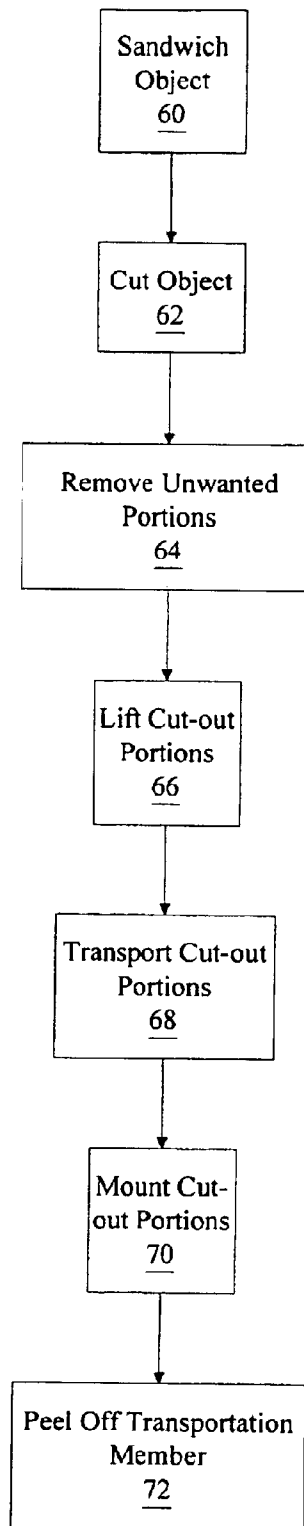
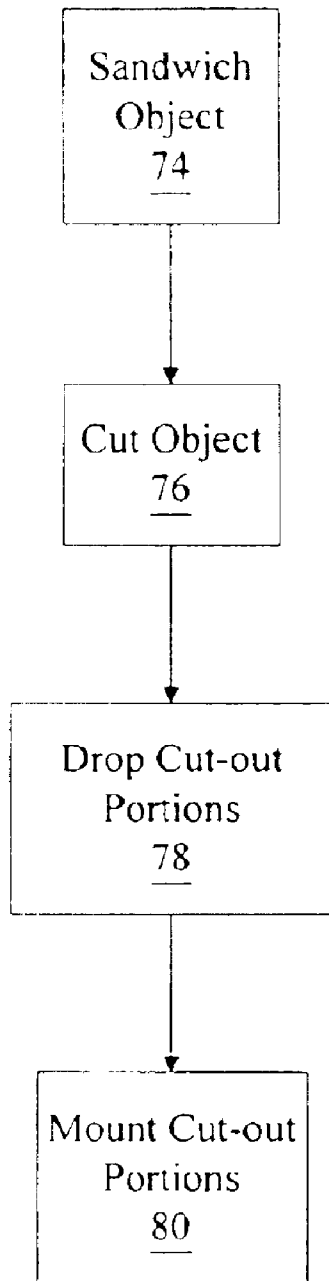


FIG. 16



*FIG. 17*



*FIG. 18*

## METHOD FOR CUTTING A MEMBER TO FORM A DESIRED STRUCTURE

### FIELD OF THE INVENTION

The present invention relates to an improved method for cutting, and more particularly to the production of structures by laser cutting layers, or members of film or thin film structures.

### BACKGROUND OF THE INVENTION

Many different structures often require the use of a laser to cut through a membrane, layer, or film, to form a desired formation. One example field that requires the precision and other features of a laser for cutting and forming these formations is the field of microelectromechanical or micro-electronic devices. Such devices often require cutting and transporting a delicate thin film structure from a source substrate to a new position on a target substrate. As such, a number of different procedures have been developed for cutting and transporting the thin film formations. For example, low tack adhesives or methods utilizing electrostatic forces have been developed to enable the formation and transportation of the thin film formations.

One known method for machining and attaching a thin film formation is taught in U.S. Pat. No. 6,210,514 to Cheung et al., which is incorporated herein by reference. The process of separating a thin film formation from the layer from which it has been cut, or from an adhesive transportation layer, can often deform, alter, stress, or destroy the thin film structure undesirably. Defects ranging from slight deformation or improper positioning, to major tears or structural deficiencies, can ultimately lead to the failure of the microelectromechanical device into which the thin film formations are placed.

The method of machining an attachment as described in the '514 patent can be summarized as follows. A thin film is affixed to a low tack polymeric membrane. While positioned on the polymeric membrane, the thin film is machined to define a thin film structure. This thin film structure (or array of thin film structures) is then separated from the polymeric membrane in a mostly deformation-free state. In this manner, various target substrates, including glass, silicon, or printed circuit boards, can be equipped with mostly stress-free thin film structures suitable for use in a wide variety of microelectromechanical or microelectronic devices.

However, structures that are cut through the low tack polymeric membrane still have significant stresses induced by edge contamination resulting from the molten polymeric material, as well as from plastic deformations that arise during delamination of the low tack polymeric membrane from the thin film structure. In addition, a collection of dust results when the laser cuts through the low tack polymeric membrane. This laser cutting dust is a source of additional contamination for the thin film and the microelectromechanical device into which the thin film ultimately mounts. The collection of dust on the thin film can have adverse effects on the functionality of the microelectromechanical or microelectronic devices. Further, once the laser cuts the low tack polymeric membrane during the manufacture of the thin film formation, it is not possible to reuse the low tack polymeric membrane to cut additional thin film structures to form like formations. Reusability would promote reduced costs and improved efficiency.

### SUMMARY OF THE INVENTION

There is a need in the art for an improved laser cutting method and corresponding apparatus, for manufacturing

structures such as thin formations that require laser cutting precision. The present invention is directed toward further solutions to address this need.

In accordance with one example embodiment of the present invention, a method of cutting a member with a laser begins with the step of providing the member. A template is then provided, and adhered to the member. The laser then projects through the template, without intersecting with the template, to cut the member and manufacture the desired formation. The laser does not intersect with, and therefore does not cut, the template structure and cause excess laser cutting dust.

A member, according to one aspect of the present invention, can be in the form of a film having multiple layers. One layer can be a metal layer and another layer can be a polymer layer. For example, the metal layer can be formed of aluminum and the polymer layer can be formed of polyester.

According to another aspect of the present invention, the step of adhering the member to the template can include removably attaching the template having low tack properties to a surface of the member through compression.

According to still another aspect of the present invention, the step of projecting the laser through the template includes directing the laser to pass through the template, without cutting the template, to cut through the member in a pattern corresponding to the template.

In accordance with one embodiment of the present invention, the method further includes the step of transferring the member formations to a removed location. The invention can further include the step of removing the template from the member in a manner such that the template is reusable.

In accordance with still another embodiment of the present invention, a method of cutting a member with a laser is provided. The method includes providing the member, a template, and a base. The member is sandwiched between the base and the template. A laser then projects through the template, without intersecting the template, to cut the member and form one or more member formations.

In accordance with still another embodiment of the present invention, an assemblage includes a member and a template removably adhering to the member. The template is suitable for accommodating a laser in cutting the member.

According to one aspect of the present invention, the member is a film. The film can be formed of multiple layers, such as a metal layer and a polymer layer. The metal layer can be aluminum and the polymer layer can be polyester.

According to another aspect of the present invention, the template can include a layer having a predefined cut out section suitable for accommodating the cutting of the member by the laser.

According to still another aspect of the present invention, the template can have low tack properties and be removably attached to a surface of the member through compression. The template can further be reusable after being removed from the member.

### BRIEF DESCRIPTION OF THE DRAWINGS

The aforementioned features and advantages, and other features and aspects of the present invention, will become better understood with regard to the following description and accompanying drawings, wherein:

FIG. 1 is a polymeric member according to one aspect of the present invention;

FIG. 2 is a cross-sectional view of the thin film assembly of FIG. 1 taken along line A—A;

FIG. 3 is a cross-section of a thin film assembly and polymeric member according to one aspect of the present invention;

FIG. 4 is a cross-section of the thin film assembly and two polymeric members according to one aspect of the present invention;

FIG. 5 is a cross-section of the thin film assembly and two polymeric members according to still another aspect of the present invention;

FIG. 6 is a cross-section of a stack assembly according to one aspect of the present invention;

FIG. 7 is a cross-section of the thin film assembly sandwiched between two polymeric members according to a further aspect of the present invention;

FIG. 8 is the assembly of FIG. 7 with laser incisions according to one aspect of the present invention;

FIG. 9 is a cross-section of metal and polyester formations on an adhesive layer according another aspect of the present invention;

FIG. 10 is a cross-section of the assembly of FIG. 9 with an adhesive layer according to one aspect of the present invention;

FIG. 11 is a cross-section of the adhesive layer of FIG. 10 bonded to the formations according one aspect of the present invention;

FIG. 12 is a cross-section of the adhesive and formations bonding to a board according to a further aspect of the present invention;

FIG. 13 is a cross-section of the formations mounted on the board according to the teachings of the present invention;

FIG. 14 is a cross-section of the thin film assembly sandwich between two polymeric members according to one aspect of the present invention;

FIG. 15 is a cross-section of the assembly of FIG. 14 with formations having fallen out and come to rest on a board according to a further aspect of the present invention;

FIG. 16 is an alternative embodiment of a polymeric member according to further aspects of the present invention;

FIG. 17 is a flowchart illustrating a cutting process in accordance with one aspect of the present invention; and

FIG. 18 is a flowchart illustrating an additional cutting process in accordance with another aspect of the present invention.

#### DETAILED DESCRIPTION

An illustrative embodiment of the present invention relates to an improved method and apparatus for cutting a member with a laser. In accordance with the method of the present invention, the member, often in the form of a film or thin film, is affixed to a template. The template includes a plurality of apertures or patterns generally in the shape of desired formations to-be-cut into the member. The template serves to support the member, especially a thin film member that requires additional support, and allows a laser to pass through the apertures of the template to directly cut the member without cutting the template layer. The support provided by the template reduces the stress on the member, and more reliably holds the member in place prior to, and during, cutting. In addition, the template provides access for the laser such that excess laser dust particles do not result

from having to cut through the template layer in addition to the member. The reduced quantity of laser dust levels improves the overall quality of the resulting formations, and decreases the propensity of unwanted dust particles to interfere with the transfer and use of the member formations.

FIGS. 1 through 18, wherein like parts are designated by like reference numerals throughout, illustrate example embodiments of an improved laser cutting process and associated apparatus, according to the teachings of the present invention. Although the present invention will be described with reference to the example embodiments illustrated in the figures, it should be understood that many alternative forms can embody the present invention. One of ordinary skill in the art will additionally appreciate different ways to alter the parameters of the embodiments disclosed, such as the size, shape, or type of elements or materials, in a manner still in keeping with the spirit and scope of the present invention.

FIG. 1 illustrates a polymeric member 16, according to the teachings of the present invention. The polymeric member 16 is utilized for descriptive purposes herein. One of ordinary skill in the art will appreciate that the member can be made of a number of other materials, such as metal with a thin silicone tack layer, or bare plastic where tacking is effected by electrostatic adhesion. The polymer member 16 includes a first cut-out 24, a second cut-out 26, and third cut-out 28. The polymeric member 16 can be formed from a number of different chemically inert polymeric materials. It is preferable for the polymeric member 16 to have low tack properties and be formed from, e.g., polysiloxanes, polyurethanes, urethanes, styrenes, olefins, copolyesters, polyamides, or other melt processible rubber materials. Two suitable materials are known as SYLGARD 184, manufactured by Dow Corning Corp., and GEL-PAK, made by Vichem Corporation of Sunnyvale, Calif.

The first, second, and third representative cut-outs 24, 26, and 28, represent openings in a polymeric member 16 that enable a laser to pass through the polymeric member 16 without intersecting with, or cutting, the polymeric member 16. The laser passes through the polymeric member 16 to cut an object on an opposite side of the polymeric member 16, as will be discussed later herein.

It should be noted that FIGS. 2 through 15 herein are cross-sectional views of the polymeric member 16 (and some alternative forms and structures of the polymeric member 16) as viewed along the cross-section indicated by line A—A in FIG. 1.

A method of cutting as taught herein can be applied to a number of different layers, members, films, surfaces, objects, and the like. However, for purposes of clarity in describing the invention, an example of a thin film assembly 10, as illustrated in FIG. 2, will be utilized herein to describe the features and aspects of the present invention. The thin film assembly will be cut with a cutting element, in the form of a laser, however, other cutting elements can be utilized based in part on what is being cut. One of ordinary skill in the art will understand that the teachings of the present invention are applicable to objects other than thin film assemblies. In fact, the teachings of the present invention are applicable to a number of the identified structures in addition to other known objects requiring laser cutting, such as metal foils, textiles, tissue, biological membranes, and the like.

FIG. 2 illustrates the example thin film assembly 10. A metal layer 12 combines with a synthetic layer 14 to form the assembly 10. The synthetic layer can take the form of, e.g., MYLAR, which is available from E. I. Du Pont de

Nemours and Company Corporation of Wilmington, Del. The synthetic layer **14** provides support and insulation for the thin metal layer **12** to reducing unwanted stresses on the metal layer **12**. There are many other possible assemblies in the form of uniform or composite thin layers that can be handled in a same manner.

A cutting element in the form of a laser **36** (see FIG. 7) cuts the thin film assembly **10** into a desired number of pieces or formations. However, the stresses caused by the heat of the laser **36**, and subsequent transportation of the formations, makes it useful to have a polymeric member **16** as illustrated in FIG. 3. The polymeric member **16** adheres to the top of the thin film assembly **10**. The polymeric member **16** includes the first cut-out **24**, the second cut-out **26**, and the third cut-out **28**. Each of the cut-outs **24**, **26**, and **28** corresponds to desired patterns or shapes for the cutting of the thin film assembly **10**.

FIGS. 4 and 5 illustrate alternative variations for additional polymeric members in the form of a polymeric base **18** adhered to a bottom of the thin film assembly **10**. In FIG. 4, the polymeric base **18** is a solid structure that provides additional support to ease the transportation of the thin film assembly **10** during the manufacturing process. The polymeric base **18** contains no apertures, and can have a low-tack surface for mildly adhering to the synthetic layer **14** of the thin film assembly **10**.

FIG. 5 provides a second polymeric member **20** in addition to the original polymeric member **16**. The thin film assembly **10** is sandwiched between the first polymeric member **16** and the second polymeric member **20**. The second polymeric member **20** serves as a base structure similar to the polymeric base **18** of FIG. 4. Contrary to the structure of the solid polymeric member **18**, the second polymeric member **20** includes a collection of apertures that pass through the second polymeric member **20**. The collection of apertures, in the form of a fourth cut-out **30**, a fifth cut-out **32**, and a sixth cut-out **34**, are in substantially the same shape and substantially the same location as the previously discussed first, second, and third cut-outs **24**, **26**, and **28**. Thus, when the polymeric member **16** is placed in alignment with the second polymeric member **20**, the first, second, and third cut-outs **24**, **26**, and **28** match substantially with the fourth, fifth, and sixth cut-outs **30**, **32**, and **34**, to create apertures that pass completely through the combined polymeric member **16** and second polymeric member **20**.

The cut-outs **24**, **26**, **28**, **30**, **32**, and **34** allow a laser to pass completely through the thin film assembly **10** sandwiched between the polymeric members **16** and **20** without actually cutting, or making contact with, either polymeric member **16** or **20**. Alternatively, in the assembly of FIG. 4, one must adjust the laser to stop cutting at the bottom edge of the thin film assembly **10**, just as the laser passes through the thin film assembly **10** to kiss-cut the polymeric base **18**. The tackiness of the two support layer polymeric membranes **16** and **20** is beneficially different so that in peeling the first membrane **16**, the thin film remains adhered to the second membrane **20**.

It should be noted that the actual structure of a number of layers can vary as understood by one of ordinary skill in the art. For example, some layers could include different apertures or cut-outs than others. Some layers may be made of different materials from others. Some layers may be larger or smaller than other layers. FIG. 6 illustrates, for example, a stack of layers similar to the arrangement of FIG. 5. In FIG. 6, eight thin film assemblies **10** stack with polymeric members separating each of the thin film assemblies **10**. This

forms a stack **22** of polymeric members in combination with thin film assemblies. Each polymeric member includes a first cut-out **24**, a second cut-out **26**, and a third cut-out **28**. Therefore, the laser passing through the stack **22** can pass through each of the apertures **24**, **26**, and **28** without cutting the polymeric member.

The overall arrangement and material selection can vary in ways too numerous to detail, but such arrangements and material selections fall within the spirit and scope of the present invention.

FIGS. 7 and 8 illustrate a portion of the laser cutting process for cutting the thin film assembly **10** into desired formations. The laser **36** is directed as illustrated in a downward cutting direction along the perimeter of each of the first, second, and third cut-outs **24**, **26**, and **28**. The laser **36** does not come into contact with the polymeric member **16** in FIG. 7, but it does kiss-cut the polymeric base **18** as it cuts through the metal layer **12** and the synthetic layer **14** of the thin film assembly **10**. The existence of each of the cut-outs **24**, **26**, and **28** makes it possible for the laser to pass through the polymeric member **16**, while the polymeric member **16** serves to provide the additional support to hold the thin film assembly **10** in place during the cutting process and during any subsequent transportation of the thin film assembly **10**.

FIG. 8 illustrates the result after the laser **36** has cut through the thin film assembly **10**. The laser passes through the first cut **24** and cuts through the metal layer **12** followed by the synthetic layer **14** and just to the top edge of the polymeric base **18**. The resulting laser cuts **38** separate the thin film assembly **10** into the original metal layer **12** and the synthetic layer **14**, and the new metal layer formation **13** in conjunction with the new synthetic layer formation **15**. Each of the metal layer and synthetic layer formations **13** and **15** are shown as three separate pieces in FIG. 8 surrounded by laser cuts **38**.

The next step in the manufacturing process is often to remove the unwanted metal layer **12** and synthetic layer **14** of the original thin film assembly **10**, in addition to the polymeric member **16**. FIG. 9 illustrates the result of the removal of each of these unwanted elements, leaving metal layer formation **13** and the synthetic layer formation **15** resting on top of the polymeric base **18**. The low tack properties of the polymeric base **18** helps to hold the metal layer formation **13** and the synthetic layer formation **15** in place. As further described below, in the example embodiments illustrated in FIGS. 4, 5, and 6, the unwanted elements fall (or are blown) away when detached.

FIG. 10 illustrates a first step in the transportation process of the metal layer formation **13** and the synthetic layer formation **15** to a desired location. In this illustration, a transportation member **40**, in the form of an adhesive member, is compressed onto the surface of the metal layer formation **13**. The adhesive forces between the transportation member **40** are greater than those of the polymeric base **18**. Therefore, as illustrated in FIG. 11, when the transportation member **40** raises, the synthetic layer formation **15** peels off the polymeric base **18** and is transported with the transportation member **40**.

The transporting member **40** then drops the metal layer formation **13** and the synthetic layer formation **15** onto a desired location, such as a circuit board **44**. Spot welds, or conducting adhesive, **42** bond the metal layer formation **13** and the synthetic layer formation **15** onto the board **44**. Then, as illustrated in FIG. 13, the transporting member **40** peels off the metal layer formation **13** to leave the metal

layer formation **13** and the synthetic layer formation **15** welded onto the board **44** in desired locations.

FIG. **14** illustrates an alternative approach in accordance with the teachings of the present invention. The arrangement illustrated is similar to that of FIG. **5**, wherein there is a polymeric member **16** having the first, second, and third cut-outs **24**, **26**, and **28**, in addition to the second polymeric member **20** having the fourth, fifth, and sixth cut-outs **30**, **32**, and **34**. The laser **36** makes the desired cuts to the assembly **10**.

FIG. **15** illustrates the result of the laser cuts, wherein the metal layer formation **13** and the synthetic layer formation **15** drop from the metal layer **12** and the synthetic layer **14** location onto the board **44** after being cut by the laser **36**. The apertures, or cutouts, of the templates in the form of the polymeric member **16** and the second polymeric member **20** allow the formed portions **13** and **15** of the metal layer **12** and the synthetic layer **14** to fall directly onto the board **44** without need for a transporting member **40**. This arrangement greatly reduces the added stresses on the thin film caused by the transportation of the metal layer formation **13** and the synthetic layer formation **15** from the cutting location to the board **44**. Once the metal layer formation **13** and the synthetic layer formation **15** have fallen to the board **44**, additional welds **42** can mount the metal layer formation **13** and the synthetic layer formation **15** in place as previously depicted in FIG. **13**.

FIG. **16** illustrates still another embodiment of the present invention, wherein a polymeric member **46** includes a variety of different cut-outs **48** forming individual flaps **50**. One of ordinary skill in the art will understand and appreciate that any number of different patterns, such as the one illustrated in FIG. **16** and the other figures herein, can be executed to result in a variety of different patterns and shapes for the thin film formations.

As understood by one of ordinary skill in the art, a number of different cutting tools can be utilized to cut the metal and synthetic layers **12** and **14**, such as various mechanical, electrical, chemical, acoustical, or optical technologies. Some cutting techniques that can be used in conjunction with the templates of the polymeric members **16** as utilized herein can include stamping, die cutting, kiss-cutting, shearing, punching, breaking, forming, bending, forging, coming, and the like. Electrical technologies can further include electrical discharge machining using high frequency electric sparks. Chemical technologies can include chemical/mechanical polishing, electromechanical machining, electrolytic grinding, electrochemical arc machining, and acid electrolyte capillary drilling. Acoustic technologies can include ultrasonic machining, ultrasonic twist drilling, and other optical techniques such as laser cutting and drilling.

The present invention is particularly useful in conjunction with the laser cutting of fragile thin films and thin film assemblies. The thin films can be organic, inorganic, or composite. Thin films are generally extremely sensitive to different applied stresses. Actions such as handling and processing of the thin films often have the potential to cause wrinkling, creasing, scratching, stretching, contamination, and added residual stressing. Any of these different actions can permanently damage the thin film. Lamination of the thin film with the polymeric members greatly reduces the potential for this damage to occur.

The polymeric member as described herein can be made of any number of different materials for supporting the thin film assemblies. The polymeric member can be formed of

various chemically inert polymeric materials, and can be used in cross link or gel form. Some embodiments may require the use of substantially transparent, or transparent, polymeric members. It is preferable to utilize low tack elastomeric membranes to aid the members in adhering to the films. However, bare plastic, metal, or layered structures, such as metal with a thin silicone layer, can be used as support members. The support members can be flexible and dimensionally stable, or non-stretchable.

Typically, the synthetic layer of the thin film assembly, which adds additional support to the metal layer, has a thickness on the order of 10 microns for supporting a metal layer having a thickness on the order of 0.1 microns. One of ordinary skill in the art will appreciate that in addition to polyester or aluminum thin films (which are most common), films based on other polymers including organic polymers such as polyethylene, polystyrene, polyamides, polyimides, and the like can be used. Some embodiments may additionally require the use of inorganic polymers such as silanes, or other silicones. Some microelectronic and microelectromechanical devices require the use of glass or polycrystalline films, silica wafers, or other crystalline materials commonly used in the semiconductor processing industry. Conductive metal films such as chromium, copper, tin, or gold can also be utilized in addition to a number of non-conductive dielectric films. Uniform thin metal foils without polymer layers, polymer films without metal foils, biological membranes, or the like, can be handled in a similar manner.

A typical laser utilized for the laser cutting of the thin film assemblies as described herein, can be a conventional 50 watts infrared carbon dioxide laser operated at about 10 watts with a 200 micron beam diameter near focus. During the laser cutting process, the thin film assembly is ablatively heated and evaporated to leave the laser cuts. Only the thin film assembly is cut in accordance with the present invention, not the template in the form of the polymeric member.

A suitable adhesive for forming the transporting member **40** can be Scotch 467 MP high performance adhesive manufactured by 3M Corporation. As previously mentioned, an assortment of particulates and dust that collects from the laser cutting of the thin film assembly represent a quality control issue. With the use of a polymeric member **16**, and **20**, the amount of material cut by the laser is significantly reduced, thereby significantly reducing the amount of left-over laser cutting dust. This greatly decreases the quality control issues surrounding contamination by particulate matter. The added support of the template in the form of the polymeric member **16**, **20**, also provides the required support for transporting the thin film assembly as desired.

In addition, the shape of the cut-outs in the templates or polymeric members **16**, **20** can vary substantially. The shapes can closely mimic the desired formations, or they can be more generously portioned. The shapes can, for example, follow the exact lines of the desired formations, with a predetermined border. Alternatively, the shapes can simply provide openings in the general shape of, e.g., a square, rectangle, circle, and the like, with the laser cutting a more unique shape in the thin film within the boundaries of the template cut-outs.

Referring to FIGS. **17** and **18**, in operation, the object to-be-cut (e.g., the thin film assembly **10**) is sandwiched between a pre-cut template (in the form of, e.g., polymeric member **16**) and a base member (in the form of, e.g., polymeric base **18**) (step **60**). A cutting device, (e.g., a laser **36**) passes through apertures in the template, cuts desired

patterns or shapes in the thin film assembly **10**, and kiss-cuts the base member (step **62**). Unwanted portions of the template and the thin film assembly are removed (step **64**). A transportation member, (e.g., an adhesive coated member) compresses against the cut-out portions of the thin film assembly, and lifts the portions off the base member (step **66**). The transportation member moves the cut-out portions to a desired location (step **68**) and lowers the cut-out portions to, e.g., a board. The cut-out portions are fixed to the board by, for example, a welding process (step **70**), and the transportation member peels off the cut-out portions that are now mounted in place (step **72**).

FIG. **18** illustrates an alternative method in accordance with the teachings of the present invention. First, the object is sandwiched between a template and a base containing the same cut-out sections as the template (as depicted in FIG. **14**) (step **74**). The cutting device passes through the apertures of the top template, and also through the apertures of the bottom base, while cutting the object in-between (step **76**). The cut-out portions of the object drop to a board positioned below the thin film assembly (step **78**), and the cut-out portions can be fixed to the board as desired (**80**).

Numerous modifications and alternative embodiments of the present invention will be apparent to those skilled in the art in view of the foregoing description. Accordingly, this description is to be construed as illustrative only and is for the purpose of teaching those skilled in the art the best mode for carrying out the present invention. Details of the structure may vary substantially without departing from the spirit of the present invention, and exclusive use of all modifications that come within the scope of the appended claims is reserved. It is intended that the present invention be limited only to the extent required by the appended claims and the applicable rules of law.

What is claimed is:

1. A method of cutting a thin film member, comprising the steps of:
  - adhering the member to a re-usable template having low-tack surfaces and pre-defined cut-out sections;
  - projecting a laser through the template, without intersecting the template;

cutting the member with the laser to form one or more member formations;

removing the template from the member, which carries off dust generated during the cutting of the member; and discarding portions of the member that are adhered to the template and maintaining portions cut-out from the thin film member corresponding to the open template portions.

2. The method according to claim **1**, wherein the member comprises a multi-layered film having a metal layer and a polymer layer.

3. The method according to claim **2**, wherein the polymer layer of the multi-layered film adds additional support to the metal layer, has a thickness of 10 microns for supporting the metal layer having a thickness of 0.1 microns.

4. The method according to claim **1**, wherein the step of providing the template increases dimensional stability, and lowers accumulation of cutting debris, excess heating, and detachment stress.

5. The method according to claim **1**, further comprising the step of sandwiching each thin film member with the templates on each side when there is one or more members to be cut.

6. The method according to claim **5**, wherein the step of sandwiching the member with the templates comprises having a beneficially different tackiness value between the templates, so that in peeling the template off, the thin film member remains adhered to the other template.

7. The method according to claim **1**, further comprising the step of providing a base having a low tack surface and a solid layer for supporting the member, on the side opposite the template, and the one or more member formations.

8. The method according to claim **7**, wherein the step of providing the base comprises supplying a re-usable layer having pre-defined cut-out section.

9. The method according to claim **1**, further comprising the step of transferring the member formations adhered to the template, which were formed by the cutting element, to a separate location.

\* \* \* \* \*



UNITED STATES PATENT AND TRADEMARK OFFICE  
**CERTIFICATE OF CORRECTION**

PATENT NO. : 6,802,927 B2  
APPLICATION NO. : 10/033958  
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INVENTOR(S) : David K Biegelsen et al.

Page 1 of 1

It is certified that error appears in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

Column 1, line 3, insert as a new paragraph:

This invention was made with Government support under DABT63-95-C-0025 awarded by ARPA. The Government has certain rights in this invention.

Signed and Sealed this

Twenty-seventh Day of May, 2008

A handwritten signature in black ink that reads "Jon W. Dudas". The signature is written in a cursive style with a large, looped initial "J".

JON W. DUDAS  
*Director of the United States Patent and Trademark Office*