

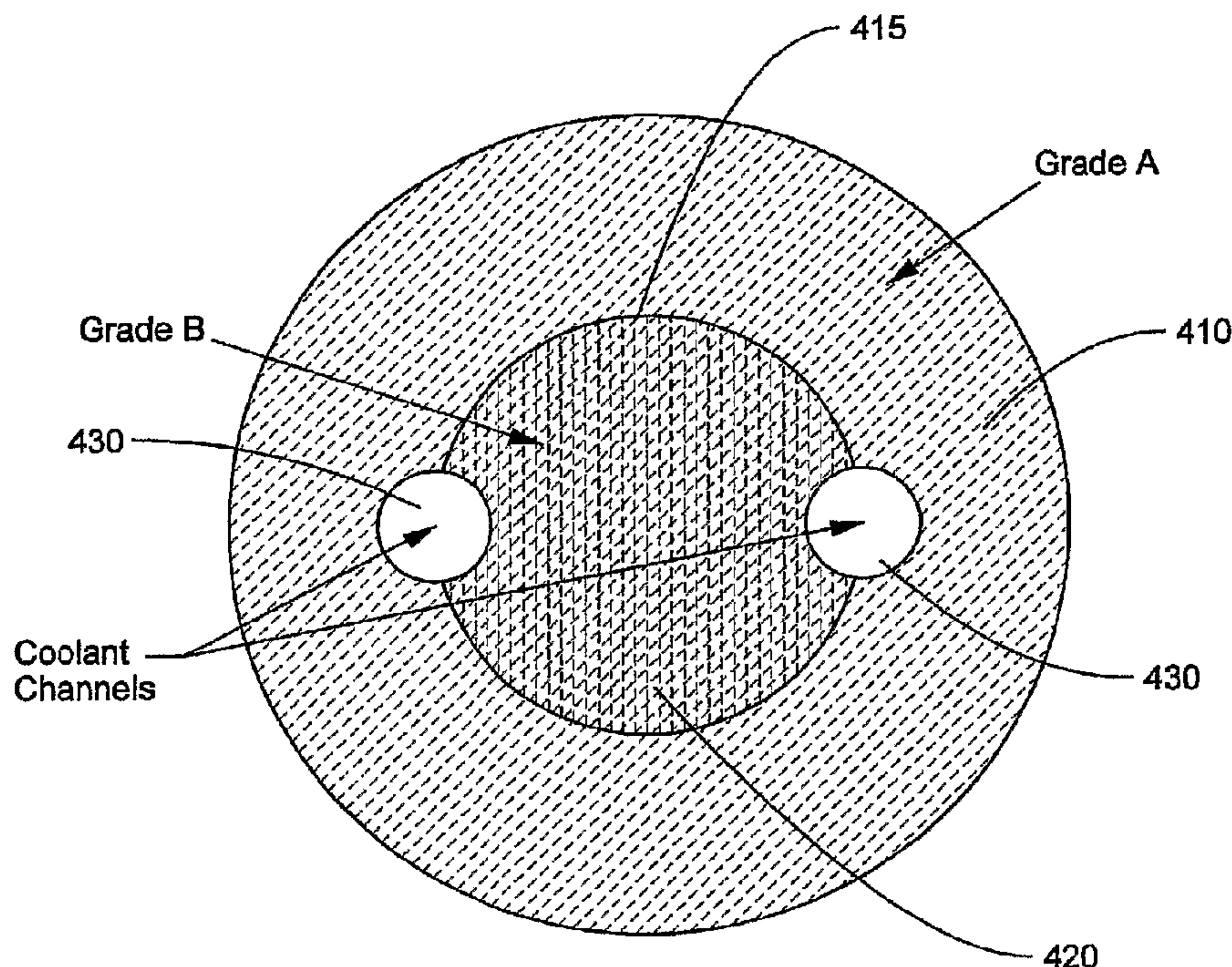


(86) Date de dépôt PCT/PCT Filing Date: 2006/06/14
(87) Date publication PCT/PCT Publication Date: 2007/01/04
(85) Entrée phase nationale/National Entry: 2007/07/27
(86) N° demande PCT/PCT Application No.: US 2006/023238
(87) N° publication PCT/PCT Publication No.: 2007/001870
(30) Priorité/Priority: 2005/06/27 (US11/167,811)

(51) Cl.Int./Int.Cl. *B22F 7/06* (2006.01),
B22F 5/10 (2006.01)
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(54) Titre : ARTICLE COMPOSITE AVEC DES CANAUX DE REFRIGERATION ET PROCEDE DE FABRICATION
D'OUTILS

(54) Title: COMPOSITE ARTICLE WITH COOLANT CHANNELS AND TOOL FABRICATION METHOD



(57) **Abrégé/Abstract:**

Embodiments of the present invention include composite articles comprising at least a first region and a second region and methods of making such articles. The first region may comprise a first composite material, wherein the first region comprises less than 5 wt. % cubic carbides by weight, and the second region may comprise a second composite material, wherein the second composite material differs from the first composite material in at least one characteristic. The composite article may additionally comprise at least one coolant channel. In certain embodiments, the first and second composite material may individually comprise hard particles in a binder, wherein the hard particles independently comprise at least one of a carbide, a nitride, an boride, a silicide, an oxide, and solid solutions thereof and the binder comprises at least one metal selected from cobalt, nickel, iron and alloys thereof. In specific embodiments, the first composite material and the second composite material may individually comprise metal carbides in a binder, such as a cemented carbide.



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

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
4 January 2007 (04.01.2007)

PCT

(10) International Publication Number
WO 2007/001870 A3

(51) International Patent Classification:

B22F 7/06 (2006.01) **B22F 5/10** (2006.01)

(21) International Application Number:

PCT/US2006/023238

(22) International Filing Date: 14 June 2006 (14.06.2006)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:

11/167,811 27 June 2005 (27.06.2005) US

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(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LV, LY, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NG, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RS, RU, SC, SD, SE, SG, SK, SL, SM, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, LV, MC, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

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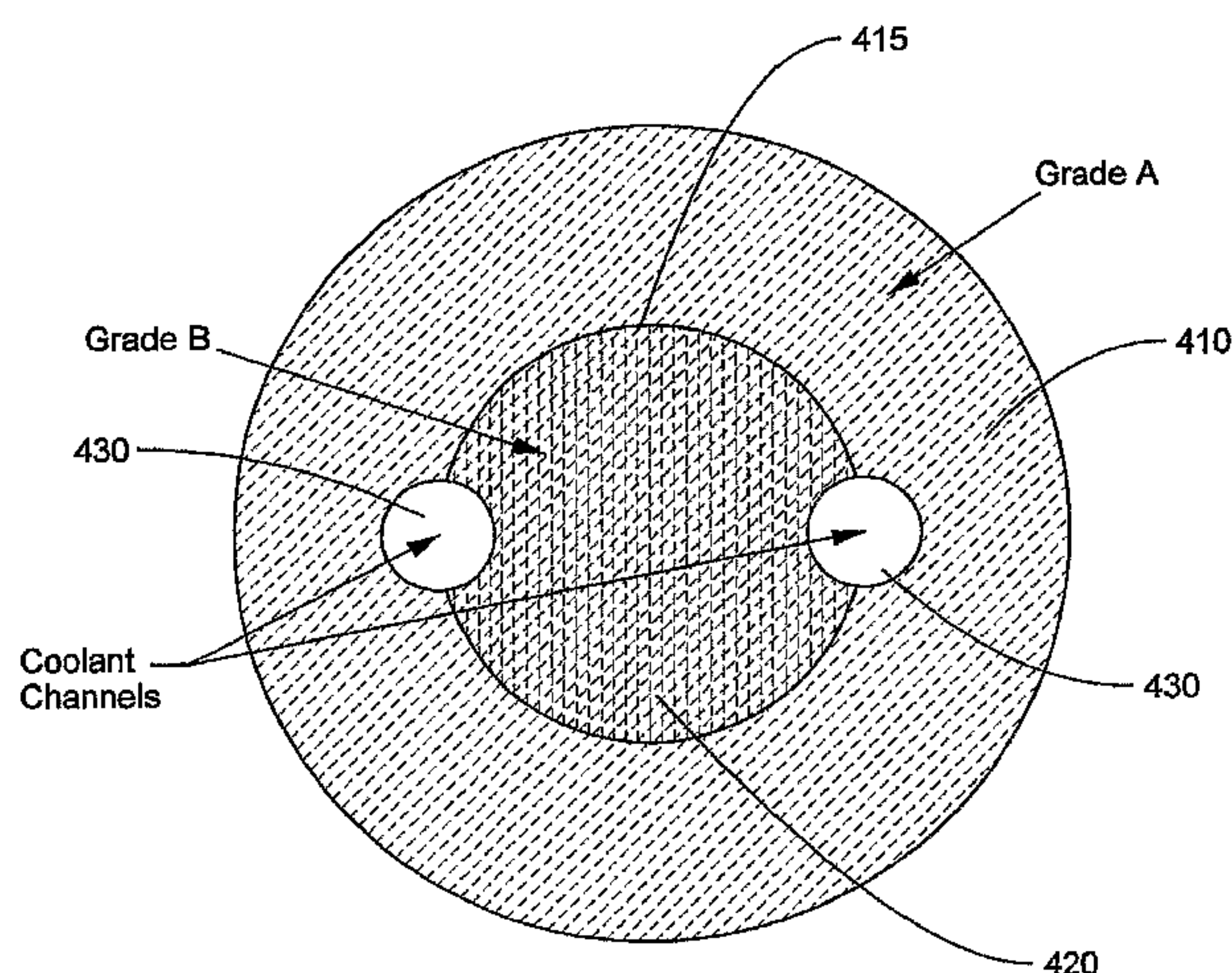
- as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii))
- as to the applicant's entitlement to claim the priority of the earlier application (Rule 4.17(iii))

Published:

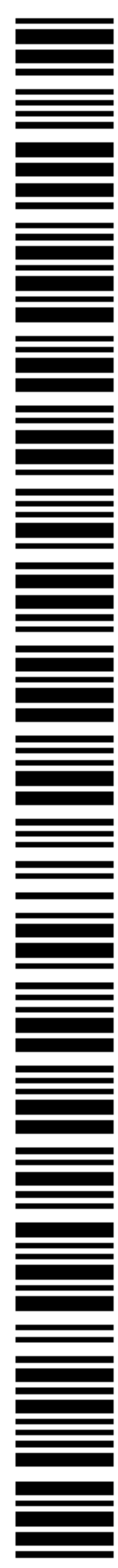
- with international search report

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(54) Title: COMPOSITE ARTICLE WITH COOLANT CHANNELS AND TOOL FABRICATION METHOD



(57) Abstract: Embodiments of the present invention include composite articles comprising at least a first region and a second region and methods of making such articles. The first region may comprise a first composite material, wherein the first region comprises less than 5 wt. % cubic carbides by weight, and the second region may comprise a second composite material, wherein the second composite material differs from the first composite material in at least one characteristic. The composite article may additionally comprise at least one coolant channel. In certain embodiments, the first and second composite material may individually comprise hard particles in a binder, wherein the hard particles independently comprise at least one of a carbide, a nitride, an boride, a silicide, an oxide, and solid solutions thereof and the binder comprises at least one metal selected from cobalt, nickel, iron and alloys thereof. In specific embodiments, the first composite material and the second composite material may individually comprise metal carbides in a binder, such as a cemented carbide.



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WO 2007/001870 A3



— *before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments*

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(88) Date of publication of the international search report:

10 May 2007

TITLE**COMPOSITE ARTICLE WITH COOLANT CHANNELS
AND TOOL FABRICATION METHOD**

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**TECHNICAL FIELD AND INDUSTRIAL APPLICABILITY OF THE
INVENTION**

The present invention is generally directed to methods of forming articles, such as tool blanks, having a composite construction including regions of differing composition and/or microstructure. The present invention is additionally directed to rotary tools and tool blanks for rotary tools having a composite construction and at least one coolant channel. The method of the present invention finds general application in the production of rotary tools and may be applied in, for example, the production of cemented carbide rotary tools used in material removal operations such as drilling, reaming, countersinking, counterboring, and end milling.

DESCRIPTION OF THE INVENTION BACKGROUND

Cemented carbide rotary tools (i.e., tools driven to rotate) are commonly employed in machining operations such as, for example, drilling, reaming, countersinking, counterboring, end milling, and tapping. Such tools are typically of a solid monolithic construction. The manufacturing process for such tools may involve consolidating metallurgical powder (comprised of particulate ceramic and binder metal) to form a compact. The compact is then sintered to form a cylindrical tool blank having a solid monolithic construction. As used herein, monolithic construction means that the tools are composed of a material, such as, for example, a cemented carbide material, having substantially the same characteristics at any working volume within the tool. Subsequent to sintering, the tool blank is appropriately machined to form the cutting edge and other features of the particular geometry of the rotary tool. Rotary tools include, for example, drills, end mills, reamers, and taps.

Rotary tools composed of cemented carbides are adapted to many industrial applications, including the cutting and shaping of materials of construction such as metals, wood, and plastics. Cemented carbide tools are industrially important because of the combination of tensile strength, wear resistance, and toughness that is characteristic of these materials. Cemented carbides materials comprise at least two phases: at least one hard ceramic component and a softer matrix of metallic binder. The hard ceramic component may be, for example, carbides of elements within groups IVB through VIB of the periodic table. A common example is tungsten carbide. The binder may be a metal or metal alloy, typically cobalt, nickel, iron or alloys of these metals. The binder "cements" the ceramic component within a matrix interconnected in three dimensions. Cemented carbides may be fabricated by consolidating a metallurgical powder blend of at least one powdered ceramic component and at least one powdered binder.

The physical and chemical properties of cemented carbide materials depend in part on the individual components of the metallurgical powders used to produce the material. The properties of the cemented carbide materials are determined by, for example, the chemical composition of the ceramic component, the particle size of the ceramic component, the chemical composition of the binder, and the ratio of binder to ceramic component. By varying the components of the metallurgical powder, rotary tools such as drills and end mills can be produced with unique properties matched to specific applications.

Monolithic rotary tools may additionally comprise coolant channels extending through its body and shank to permit the flow of a coolant, such as oil or water, to the cutting surfaces of the rotary tool. The coolant may enter the channel at the shank end and exit at the drill point. The coolant cools the rotary tool and work piece and assists in ejecting chips and dirt from the hole. The use of coolant during machining operations allows for the use of higher cutting speeds of the rotary tool and faster feed rates, in addition to extending tool life. Rotary tools with coolant channels are especially suited for drilling deep holes in hard materials.

However, the monolithic construction of rotary tools inherently limits their performance and range of applications. As an example, Figure 1 depicts side and end views of a twist drill 10 having a typical design used for creating and finishing holes in construction materials such as wood, metals, and plastics. The twist drill 10 includes a

chisel edge 11, which makes the initial cut into the workpiece. The cutting tip 14 of the drill 10 follows the chisel edge 11 and removes most of the material as the hole is being drilled. The outer periphery 16 of the cutting tip 14 finishes the hole. During the cutting process, cutting speeds vary significantly from the center of the drill to the drill's outer periphery. This phenomenon is shown in Figure 2, which graphically compares cutting speeds at an inner (D1), outer (D3), and intermediate (D2) diameter on the cutting tip of a typical twist drill. In Figure 2(b), the outer diameter (D3) is 1.00 inch and diameters D1 and D2 are 0.25 and 0.50 inch, respectively. Figure 2(a) shows the cutting speeds at the three different diameters when the twist drill operates at 200 revolutions per minute. As illustrated in Figures 2(a) and (b), the cutting speeds measured at various points on the cutting edges of rotary tools will increase with the distance from the axis of rotation of the tools.

Because of these variations in cutting speed, drills and other rotary tools having a monolithic construction will not experience uniform wear and/or chipping and cracking of the tool's cutting edges at different points ranging from the center to the outside edge of the tool's cutting surface. Also, in drilling casehardened materials, the chisel edge is typically used to penetrate the case, while the remainder of the drill body removes material from the casehardened material's softer core. Therefore, the chisel edge of conventional drills of monolithic construction used in that application will wear at a much faster rate than the remainder of the cutting edge, resulting in a relatively short service life for such drills. In both instances, because of the monolithic construction of conventional cemented carbide drills, frequent regrinding of the cutting edge is necessary, thus placing a significant limitation on the service life of the bit. Frequent regrinding and tool changes also result in excessive downtime for the machine tool that is being used.

Therefore, composite articles, such as composite rotary tools have been used, such as those tools described in described in United States Patent No. 6,511,265 which is hereby incorporated by reference in its entirety. If designed properly, composite rotary tools may have increased tool service life as compared to rotary tools having a more monolithic construction. However, there exists a need for drills and other rotary tools that have different characteristics at different regions of the tool and comprise coolant channels. As an example, a need exists for cemented carbide drills and other rotary tools that will experience substantially even wear regardless of the position on the

tool face relative to the axis of rotation of the tool and allow cooling at the cutting surfaces. There is a need for a composite rotary tool having coolant channels so composite rotary tools may have the same benefits as monolithic rotary tools. There is also a need for a versatile method of producing composite rotary tools and composite
5 rotary tools comprising coolant channels.

SUMMARY

Embodiments of the present invention include composite articles comprising at least a first region and a second region. The first region may comprise a
10 first composite material, wherein the first region comprises less than 5 wt. % cubic carbides by weight, and the second region may comprise a second composite material, wherein the second composite material differs from the first composite material in at least one characteristic. The composite article may additionally comprise at least one coolant channel. In certain embodiments, the first and second composite material may
15 individually comprise hard particles in a binder, wherein the hard particles independently comprise at least one of a carbide, a nitride, a boride, a silicide, an oxide, and solid solutions thereof and the binder comprises at least one metal selected from cobalt, nickel, iron and alloys thereof. In specific embodiments, the first composite material and the second composite material may individually comprise metal carbides in a binder.

20 The characteristic may be at least one characteristic selected from the group consisting of modulus of elasticity, hardness, wear resistance, fracture toughness, tensile strength, corrosion resistance, coefficient of thermal expansion, and coefficient of thermal conductivity. The composite article may be one of rotary tool, a rotary tool blank, a drill, an end mill, a tap, a rod, and a bar, for example. In some embodiments, the
25 composite article may further comprises two or more coolant channels and the coolant channels may be substantially straight or substantially helical shape.

Embodiments of the present invention further include a method of forming an article, comprising coextruding at least two composite materials comprising metal carbides to form a green compact. The composite materials may be as described
30 above. The coextruding at least two composite materials may be performed through a die and, in certain embodiments, the die may comprise means for making internal channels

in the green compact. The die may comprise at least one wire to form an internal channel within the green compact, wherein the wire may be rigid or flexible.

Embodiments also include a method of producing a rotary tool having a composite structure comprising placing an extruded first powder metal into a first region
5 of a void of a mold, placing a second metallurgical powder metal into a second region of the void, the extruded first powder metal differing from the second metallurgical powder, and compressing the mold to consolidate the extruded first powder metal and the second powder metal to form a green compact. The green compact may be sintered to form the article. Material may be removed material from the green compact to provide at least one
10 cutting edge prior to or after sintering.

The reader will appreciate the foregoing details and advantages of the present invention, as well as others, upon consideration of the following detailed description of embodiments of the invention. The reader also may comprehend such additional details and advantages of the present invention upon using the invention.

BRIEF DESCRIPTION OF THE DRAWINGS

The features and advantages of the present invention may be better understood by reference to the accompanying drawings in which:

Figures 1(a) and 1(b) are plan and on-end views, respectively, of a conventional twist drill with coolant channels;

Figure 2(a) is a graph indicating cutting speeds at the three diameters D1, D2, and D3 of a conventional twist drill indicated in Figure 2(b);

Figures 3(a) and (b) include a transverse section (Figure 3(a) and a longitudinal section (Figure 3(b)) of rods produced by embodiments of the method of the present invention comprising a core of centered carbide grade B and a shell of cemented carbide grade A;

Figures 4(a)-(d) are representations of a cross-sectional views of an embodiments of a composite cemented carbide;

Figures 5 (a)-(d) are embodiments of blanks showing examples of the different configurations of coolant channels, such as a straight single coolant channel (Figure 5(a)); two straight channels (Figure 5(b)); two helical or spiral channels (Figure 5(c)); and three helical or spiral channels (Figure 5(d));

Figure 6(a) is a representation of the coextrusion pressing apparatus used in coextrusion of a tube of grade A and a rod of grade B through a die with internal spiral serrations to produce a blank with helical or spiral channels.

Figure 6(b) is a representation of a channel die;

Figure 6(c) is a photograph of a coextruded composite cemented carbide rod with internal channels exiting from a die with spiral serrations;

Figure 7 is representation of a dry bag isostatic pressing apparatus used in an embodiment of a method of the present invention including consolidating cemented carbide grade B with an extruded rod with internal channels made from a cemented carbide grade A;

Figure 8(a) is a photograph of a longitudinal cross-section of a composite rod with internal coolant channels of the present invention, the nylon wires in the photograph have been inserted in the channels to more clearly show their location and the path of the coolant channels; and

Figure 8(b) is a photograph of a longitudinal cross-section of a drill made from a composite cemented carbide having internal coolant channels.

DESCRIPTION OF EMBODIMENTS OF THE INVENTION

The present invention provides rotary cutting tools, cutting tool blanks, rods, and other articles having a composite construction and a method of making such articles. The articles may further comprise internal channels, such as coolant channels, if desired. As used herein, a rotary tool is a tool having at least one cutting edge that is driven to rotate. As used herein, "composite" construction refers to an article having regions differing in chemical composition and/or microstructure. These differences result in the regions having properties differing with respect to at least one characteristic. The characteristic may be at least one of, for example, hardness, tensile strength, wear resistance, fracture toughness, modulus of elasticity, corrosion resistance, coefficient of thermal expansion, and coefficient of thermal conductivity. Composite rotary tools that may be constructed as provided in the present invention include drills and end mills, as well as other tools that may be used in, for example, drilling, reaming, countersinking, counterboring, end milling, and tapping of materials.

The present invention more specifically provides a composite rotary tool having at least one cutting edge, at least two regions of cemented carbide material that differ with respect to at least one characteristic, and at least one coolant channel. The differing characteristics may be provided by variation of at least one of the chemical composition and the microstructure among the two regions of cemented carbide material. The chemical composition of a region is a function of, for example, the chemical composition of the ceramic component and/or binder of the region and the carbide-to-binder ratio of the region. For example, one of the two cemented carbide material regions of the rotary tool may exhibit greater wear resistance, enhanced hardness, and/or a greater modulus of elasticity than the other of the two regions.

Aspects of present invention may be described in relation to the tool blank 400, shown in Figure 4(a) in a cross-sectional view transverse to the axis. The tool blank 400 is a generally cylindrical sintered compact with two coaxially disposed cemented carbide regions 410, 420 and coolant channels 430. It will be apparent to one skilled in the art, however, that the following discussion of the present invention also may be adapted to the fabrication of composite rotary tools and tool blanks having more complex

geometry and/or more than two regions. Thus, the following discussion is not intended to restrict the invention, but merely to illustrate embodiments of it.

In the embodiment of Figure 4(a), the cylindrical rotary tool blank 400 is comprised of two differing cemented carbide regions, a core region 400 and an outer region 410. The core region 420 and the outer region 410 are both of a cemented carbide material including ceramic particles in a continuous matrix of binder. Preferably, the cemented carbide materials in the core region 420 and in the outer region 410 include a ceramic component composed of carbides of one or more elements belonging to groups IVB through VIB of the periodic table including less than 5% cubic carbides or, in some applications, less than 3 wt. % cubic carbides. Embodiments of the present invention may comprise less than 5 wt. % cubic carbides because cubic carbides may reduce strength transverse rupture strength of the article, increase the production costs, and reduce the fracture toughness. This is especially important for tools used to machine hard work pieces where the machining results in a shearing action and the strength of the drill should be the greatest..

The ceramic component preferably comprises about 60 to about 98 weight percent of the total weight of the cemented carbide material in each region. The carbide particles are embedded within a matrix of binder material that preferably constitutes about 2 to about 40 weight percent of the total material in each region. The binder preferably is one or more of Co, Ni, Fe, and alloys of these elements. The binder also may contain, for example, elements such as W, Cr, Ti, Ta, V, Mo, Nb, Zr, Hf, and C up to the solubility limits of these elements in the binder. Additionally, the binder may contain up to 5 weight percent of elements such as Cu, Mn, Ag, Al, and Ru. One skilled in the art will recognize that any or all of the constituents of the cemented carbide material may be introduced in elemental form, as compounds, and/or as master alloys.

The core region 420 of the tool blank 400 is autogenously bonded to the outer region 410 at an interface 415. The interface 440 is shown in Figure 4(a) to be cylindrical, but it will be understood that the shapes of the interfaces of cemented carbide material regions of the composite rotary tools of the present invention are not limited to cylindrical configurations. The autogenous bond between the regions at the interface 415 may be formed by, for example, a matrix of binder that extends in three dimensions from the core region 420 to the outer region 410, or vice versa. The ratio of binder to ceramic component in the two regions may be the same or different and may be varied between

the regions to affect the regions' relative characteristics. By way of example only, the ratio of binder to ceramic component in the adjacent regions of the composite tool blank 30 may differ by 1 to 10 weight percent. The characteristics of the cemented carbide materials in the different regions of the composite rotary tools of the present invention
5 may be tailored to particular applications.

One skilled in the art, after having considered the description of present invention, will understand that the improved rotary tool of this invention could be constructed with several layers of different cemented carbide materials to produce a progression of the magnitude of one or more characteristics from a central region of the
10 tool to its periphery. Thus, for example, a twist drill may be provided with multiple, coaxially disposed regions of cemented carbide material and wherein each such region has successively greater hardness and/or wear resistance than the adjacent, more centrally disposed region. Coolant channels may be provided in any of the regions or intersecting two or more regions. The method of the present invention provides great design
15 flexibility in the design of extruded articles. Alternately, rotary tools of the present invention could be made with other composite configurations wherein differences in a particular characteristic occur at different regions of the tool.

A major advantage of the composite cemented carbide rotary tools of the present invention is the flexibility available to the tool designer to tailor properties of
20 regions of the tools to suit different applications. For example, the size, location, thickness, geometry, and/or physical properties of the individual cemented carbide material regions of a particular composite blank of the present invention may be selected to suit the specific application of the rotary tool fabricated from the blank. In addition, the coolant channels may be located in the desired locations and be helical, spiral, linear,
25 or a combination of such shapes. Thus, for example, the stiffness of one or more cemented carbide regions of the rotary tool experiencing significant bending during use may be of a cemented carbide material having an enhanced modulus of elasticity; the hardness and/or wear resistance of one or more cemented carbide regions having cutting surfaces and that experience cutting speeds greater than other regions may be increased;
30 and/or the corrosion resistance of regions of cemented carbide material subject to chemical contact during use may be enhanced.

Figures 4(b) and 4(c) show additional embodiments of the present invention. These embodiments may additional comprise channels, such as coolant

channels. The embodiment of Figure 4(b) comprises a tube with internal regions of different cemented carbide grades. In this example, the rod 440 comprises an outer region 441 of a first cemented carbide, a first inner region 442 of a second cemented carbide, and an additional inner regions 443 that could comprise the same or different cemented carbides. The rod 440 could be produced, for example, by coextruding a set 450 comprising a tube 451 filled with rods 452 and 453. Rods 452 may be formed from a cemented carbide that has at least one characteristic that differs from the rods 453, for example.

By way of example only, additional embodiments of rotary tools of the present invention are shown in Figures 4 and 5. Figure 4 depicts a step drill 110 constructed according to the present invention. The drill 110 includes a cutting portion 112 including several helically oriented cutting edges 114. The drill 110 also includes a mounting portion 116 that is received by a chuck to mount the drill to a machine tool (not shown). The drill 110 is shown in partial cross-section to reveal three regions of cemented carbide materials that differ relative to one another with regard to at least one characteristic. A first region 118 is disposed at the cutting tip of the drill 110. The cemented carbide material from which region 118 is composed exhibits an enhanced wear resistance and hardness relative to a central region 120 forming the core of the drill 110. The core region is of a cemented carbide material that exhibits an enhanced modulus of elasticity relative to the remaining two regions. The enhanced modulus of elasticity reduces the tendency of the drill 110 to bend as it is forced into contact with a work piece. The drill also includes an outer region 122 that defines the several helically oriented cutting edges 114. The outer region surrounds and is coaxially disposed relative to the core region 120. The outer region 122 is composed of a cemented carbide material that exhibits enhanced hardness and wear resistance relative to both the core region 120 and the tip region 118. The cutting surfaces 114 that are defined by the outer region 122 experience faster cutting speeds than cutting regions proximate to the drill's central axis. Thus, the enhanced wear resistance and hardness of the outer region 122 may be selected so that uniformity of wear of the cutting surfaces is achieved.

Embodiments of the present invention also include additional methods of making composite cemented carbide articles. Embodiments include a method of forming a composite article by coextruding at least two composite materials comprising cemented carbides to form a green compact. The coextruding may be performed by direct or

indirect extrusion process. The feed chamber of the extruder is filled with two grades of materials, such as two grades of carbide powder and binder powder mixed with a plastic binder. The plastic binder material may be present in concentrations from about 33 wt.% to 67 wt.% and decreases the viscosity of the powder metal mixture to allow extrusion.

5 The extrusion process for cemented carbides is well known in the art. In a typical extrusion process, metal powders are mixed with a plastic binder. Any typical plastic binder may be used such as plastic binders based upon benzyl alcohol, cellulose, polymers, or petroleum products. Typically, a high sheen mixing process is used to ensure intimate contact between the metal powders and the plastic binder.

10 The metal/binder mixer may then be pumped by screw feeder through the extruder to produce an extruded product. Embodiments of the method of the present invention include coextrusion of at least two cemented carbide grades. The term coextrusion, as used herein, means that two materials are extruded simultaneously to form a single article incorporating both materials. Any coextrusion process may be used
15 in the method of the present invention such as, pumping two grades of cemented carbide to separate sections of funnel or die wherein the two grades exit the die in intimate contact with each other.

 An embodiment of the coextrusion process is shown in Figure 6(a). The feed chamber 600 is filled with a rod 610 of a first grade of cemented carbide powder and
20 a tube 620 of a second grade of cemented carbide powder. The rod 610 and the tube 620 were individually formed by separate extrusion processes as known in art. In certain embodiments, the tube 620 may be extruded directly into the feed chamber 600. The rod 610, formed in a separate extrusion process may then be inserted into the tube 620 already in the feed chamber 600.

25 In this embodiment of the extrusion process, a plunger (not shown) pushes the rod 610 and the tube 620 through the feed chamber and into the funnel 630. The funnel 630 reduces in cross-sectional area from the feed chamber to the die 640. The funnel 630 causes compaction and consolidation of the cemented carbide powders resulting in intimate contact between the rod 610 and tube 620 and formation of a green
30 compact ("extruded material").

 In certain embodiments, the extrusion process may also include a channel die 650 incorporated between the funnel 630 and the die 640. The channel die comprises two wires 660 or the channel die may comprise other means for making internal channels

in the green compact. The wires 660 are connected to arms 670 which hold the wires 660 so they may contact the extruded material. The wires 660 result in the formation of channels in the extruded material. The wires 660 may be made from any material capable of forming channels in the extruded material, such as, but not limited to, nylon, polymer coated metal wire, polyethylene, high density polyethylene, polyester, polyvinyl chloride, polypropylene, an aramid, Kevlar, polyetheretherketone, natural materials, cotton, hemp, and jute. Preferably in certain applications, such as for formation of helically oriented channels, the wire is a flexible wire. However, for linearly oriented channels and in some helical applications, rigid wires may be used. The channels may be used as coolant channels in rotary tools. The wires 660 may be used to form helically oriented channels, linearly oriented channels, or a combination thereof. A cross-section of the wire or other channel making component may be any shape, such as round, elliptical, triangular, square, and hexagonal.

Helically oriented channels may be formed in the extruded material in embodiments where the extruded material rotates relative to the channel die 650. The extruded material may be rotated by incorporating spiral serrations in the die 640. In Figure 6(c), extruded material 680 exits die 645 that includes helical serrations on the internal surface of the die 645. As the extruded material passes over the serrations, the extruded material is caused to rotate relative to the channel die (not shown).

Alternatively, the die may rotate to cause the extruded material to rotate relative to the channel die. Other channel dies may be used, such dies comprising fixed helical coils wherein the extruded material is caused to rotate relative to the channel die in the same rotation as the helical coils, or any other channel forming means.

The channel die may be a separate component or may be integral to the funnel, die, or other component in the extrusion system. The channel die may be capable of making at least one channel in the extruded material. The number and size of the channels may be limited by the size of the extruded material, the size of the channels, and the application for the ultimate use of the extruded material. In embodiments comprising a channel die comprising wires, the number of wires will correspond to the number of channels formed in the extruded material. For an rotary tool application, it may be preferable to have an equal number of channels as there will be flutes for example.

Embodiments of the present invention may further include loading the feed chamber with at least two cemented carbide grades. At least one cemented carbide

grade loaded in the feed chamber may be an extruded form of either a rod, tube, bar, strips, rectangles, gear profiles, star shapes, or any other shape that may be formed in an extrusion process. In rotary tool or roller applications, it may be preferable that at least one of the two cemented carbide grades be in the form of a rod shape and at least one
5 cemented carbide in a shape of a tube. In other applications, the feed chamber may be filled with multiple tubes and/or multiple rods of different cemented carbide grades. If multiple rods are used, the extruded material may be formed with specific grades of cemented carbides in specific regions or randomly distributed throughout the cross-section of the extruded material.

10 A further embodiment of the present invention may comprise extruding a cemented carbide grade to form an extruded green compact and pressing the extruded green compact with a second cemented carbide grade to form a pressed green compact. The extruded green compact may optionally comprise internal channels formed as described above, for example.

15 Actual examples of application of the foregoing method to provide composite rotary tools according to the present invention follow.

Although the present invention has been described in connection with certain embodiments, those of ordinary skill in the art will, upon considering the foregoing description, recognize that many modifications and variations of the invention
20 may be employed. All such variations and modifications of the present invention are intended to be covered by the foregoing description and the following claims.

WE CLAIM:

1. A composite article, comprising:
at least a first region and a second region, wherein the first region comprises a first composite material and less than 5 wt. % cubic carbides by weight, the second region comprises a second composite material, wherein the first composite material differs from the second composite material in at least one characteristic; and
at least one coolant channel.
2. The composite article of claim 1, wherein the first and second composite material individually comprise hard particles in a binder and the hard particles independently comprise at least one of a carbide, a nitride, a boride, a silicide, an oxide, and solid solutions thereof and the binder comprises at least one metal selected from cobalt, nickel, iron and alloys thereof.
3. The composite article of claim 1, wherein the characteristic is at least one characteristic selected from the group consisting of modulus of elasticity, hardness, wear resistance, fracture toughness, tensile strength, corrosion resistance, coefficient of thermal expansion, and coefficient of thermal conductivity.
4. The composite article of claim 1, wherein the first composite material and the second composite material individually comprises a metal carbide in a binder.
5. The composite article of claim 4, wherein the metal of the metal carbide of the first composite material and the metal of the metal carbide of second composite material are individually selected from the group consisting of group IVB, group VB and group VIB elements.
6. The composite article of claim 4, wherein the first region is autogenously bonded to the second region by a matrix of the binders.

7. The composite article of claim 4, wherein the binder of the first composite material and the binder of the second composite material each individually comprise a metal selected from the group consisting of cobalt, cobalt alloy, nickel, nickel alloy, iron, and iron alloy.
8. The composite article of claim 4, wherein the binder of the first composite material and the binder of the second composite material differ in chemical composition.
9. The composite article of claim 4, wherein the weight percentage of the binder of the first composite material differs from the weight percentage of the binder of the second composite material.
10. The composite article of claim 4, wherein the metal carbide of the first composite material differs from the metal carbide of the second composite material in at least one of chemical composition and average grain size.
11. The composite article of claim 4, wherein the first composite material and the second composite material individually comprises 2 to 40 weight percent of the binder and 60 to 98 weight percent of the metal carbide.
12. The composite article of claim 11, wherein one of the first composite material and the second composite material includes from 1 to 10 weight percent more of the binder than the other of the first composite material and the second composite material.
13. The composite article of claim 1, wherein the composite article is one of rotary tool, a rotary tool blank, a drill, an end mill, a tap, a rod, and a bar.
14. The composite article of claim 1, wherein the modulus of elasticity of the first composite material within the first region differs from the modulus of elasticity of the second composite material within the second region.
15. The composite article of claim 1, wherein at least one of the hardness and wear resistance of the first composite material within the first region differs from the second composite material within the second region.

16. The composite article of claim 1, further comprises two coolant channels.
17. The composite article of claim 1, wherein the at least one coolant channel is substantially straight.
18. The composite article of claim 1, wherein the at least one coolant channel is in a substantially helical shape.
19. The composite article of claim 18, comprising two coolant channels.
20. The composite article of claim 1, wherein the composite materials are cemented carbides.
21. A method of forming an article, comprising:
coextruding at least two composite materials comprising metal carbides to form a green compact.
22. The method of forming an article of claim 21, wherein the coextruding at least two composite materials is performed through a die.
23. The method of claim 22, wherein the die comprises means for making internal channels in the green compact.
24. The method of claim 22, wherein the die comprises at least one wire.
25. The method of claim 24, wherein the at least one wire forms an internal channel within the green compact.
26. The method of claim 24, wherein the die comprises at least two wire.
27. The method of claim 26, wherein the die comprises three wires.
28. The method of claim 24, wherein at least one wire is a flexible wire.

29. The method of claim 28, wherein the flexible wire comprises at least one of nylon, a polymer coated metal wire, polyethylene, high density polyethylene, polyester, polyvinyl chloride, polypropylene, an aramid, Kevlar, polyetheretherketone, cotton, animal gut, hemp and jute.
30. The method of claim 24, wherein the wire is an inflexible.
31. The method of claim 30, wherein the wire comprises a metal.
32. The method of claim 21, further comprising:
loading a feed chamber with at least two cemented carbide grades.
33. The method of claim 32, wherein at least one cemented carbide grade is in extruded form.
34. The method of claim 33, wherein the extruded form is at least one of a rod, bar, and a tube.
35. The method of claim 32, wherein loading the feed chamber comprises loading at least one cemented carbide grade in a rod shape and at least one cemented carbide in a tube shape.
36. The method of claim 33, wherein a plurality of cemented carbide grades are loaded into the feed chamber in the shape of a tube.
37. The method of claim 32, further comprising:
extruding a first cemented carbide grade in the form of a tube.
38. The method of claim 37, further comprising:
extruding a second cemented carbide in the form of a rod.
39. The method of claim 38, wherein the cemented carbide in the form of a rod is extruded directly into a feed chamber of a coextruder.

40. The method of claim 21, wherein composite materials are cemented carbides.
41. The method of claim 21, wherein the green compact comprises two cemented carbide grades and the cemented carbide grades are coaxially disposed.
42. The method of claim 21, wherein at the die includes a channel die.
43. The method of claim 42, wherein the at least two cemented carbide grades are coextruded through a die comprising internal spiral serrations.
44. The method of claim 42, wherein the at least two cemented carbides are coextruded through a rotating die.
45. The method of claim 22, wherein the green compact comprises at least one channel.
46. The method of claim 22, wherein the green compact comprises two helical channels.
47. The composite article of claim 1, wherein at least one of said first cemented carbide material and said second cemented carbide material comprise tungsten carbide particles having an average grain size of 0.3 to 10 μm .
48. The composite article of claim 1, wherein at least one of said first cemented carbide material and said second cemented carbide material comprises tungsten carbide particles having an average grain size of 0.5 to 10 μm and the other of said first cemented carbide material and said second cemented carbide material comprises tungsten carbide particles having an average particle size of 0.3 to 1.5 μm .
49. The composite article of claim 1, wherein the composite article is one of a drill, an end mill, and a tap.
50. The composite article of claim 5, wherein one of said first cemented carbide material and said second carbide material includes 1 to 10 weight percent more of said binder than the other of said first cemented carbide material and said second cemented carbide material.

51. The composite article of claim 1, wherein the modulus of elasticity of said first cemented carbide material within said first region differs from the modulus of elasticity of said second cemented carbide material within said second region.
52. The composite article of claim 1, wherein the modulus of elasticity of said first cemented carbide material within said first region is 90×10^6 to 95×10^6 psi and the modulus of elasticity of said second cemented carbide material within said second region is 69×10^6 to 92×10^6 psi.
53. The composite article of claim 1, wherein the at least one of the hardness and wear resistance of said first cemented carbide material within said first region differs from the said second cemented carbide material within said second region.
54. The composite article of claim 1, wherein said first cemented carbide material comprises 6 to 15 weight percent cobalt alloy and said second cemented carbide material comprises 10 to 15 weight percent cobalt alloy.
55. A method of producing a rotary tool having a composite structure, the method comprising:
- placing extruded first powder metal into a first region of a void of a mold;
 - placing a second metallurgical powder metal into a second region of the void, the extruded first powder metal differing from the second metallurgical powder;
 - compressing the mold to consolidate the extruded first powder metal and the second powder metal to form a green compact; and
 - over-pressure sintering the green compact.
56. The method of claim 55, further comprising:
- removing material from the green compact to provide at least one cutting edge.
57. The method of claim 56, wherein the mold is a dry-bag rubber mold, and further wherein compressing the mold comprises isostatically compressing the dry-bag rubber mold to form the green compact.

58. The method of claim 56, wherein removing material from the green compact comprises machining the compact to form at least one helically oriented flute defining at least one helically oriented cutting edge.

59. The method of claim 55 wherein the extruded first compost powder comprises at least one channel.

60. The method of claim 59, wherein the extruded first powder metal comprises at least two channels.

61. The method of claim 55, wherein both the first powder metal and the second powder metal comprise a powdered binder and particles of at least one carbide of an element selected from the group consisting of group IVB, group VB and group VIB elements.

62. The method of claim 61, wherein the binders of the first powder metal and the second powder metal each individually comprise at least one metal selected from the group consisting of cobalt, cobalt alloy, nickel, nickel alloy, iron, and iron alloy.

63. The method of claim 55, wherein the first powder metal and the second powder metal each individually comprise 2 to 40 weight percent of the powdered binder and 60 to 98 weight percent of the carbide particles.

64. The method of claim 55, wherein at least one of the first powder metal and the second powder metal comprises tungsten carbide particles having an average particle size of 0.3 to 10 μm .

65. The method of claim 55, wherein over pressure sintering the compact comprises heating the compact at a temperature of 1350°C to 1500°C under a pressure of 300-2000 psi.

66. The method of claim 55, wherein compressing the mold comprises isostatically compressing the mold at a pressure of 5,000 to 50,000 psi.

67. The method of claim 55, wherein the green compact formed by compressing the mold comprises:

a first region comprising a first cemented carbide material provided by consolidation of the first metallurgical powder; and
a second region comprising a second cemented carbide material provided by consolidation of the second metallurgical powder, the first region and second region differing with respect to at least one characteristic.

68. The method of claim 67, wherein the characteristic is at least one selected from the group consisting of modulus of elasticity, hardness, wear resistance, fracture toughness, tensile strength, corrosion resistance, coefficient of thermal expansion, and coefficient of thermal conductivity.

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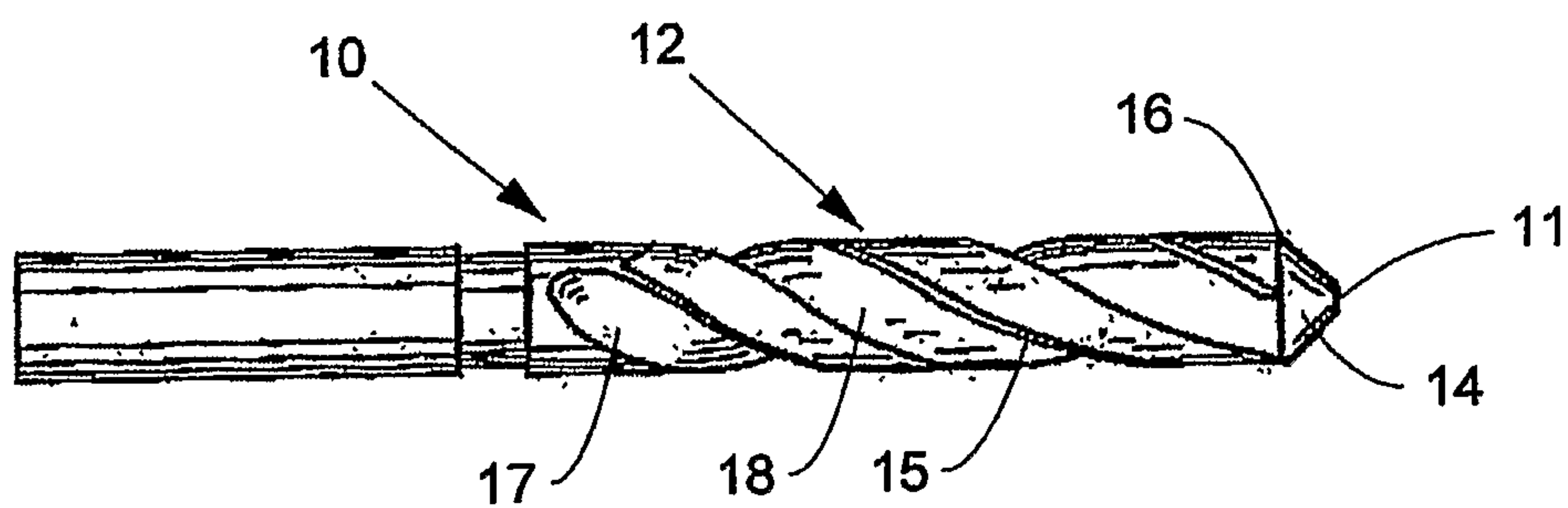


FIGURE 1(a)

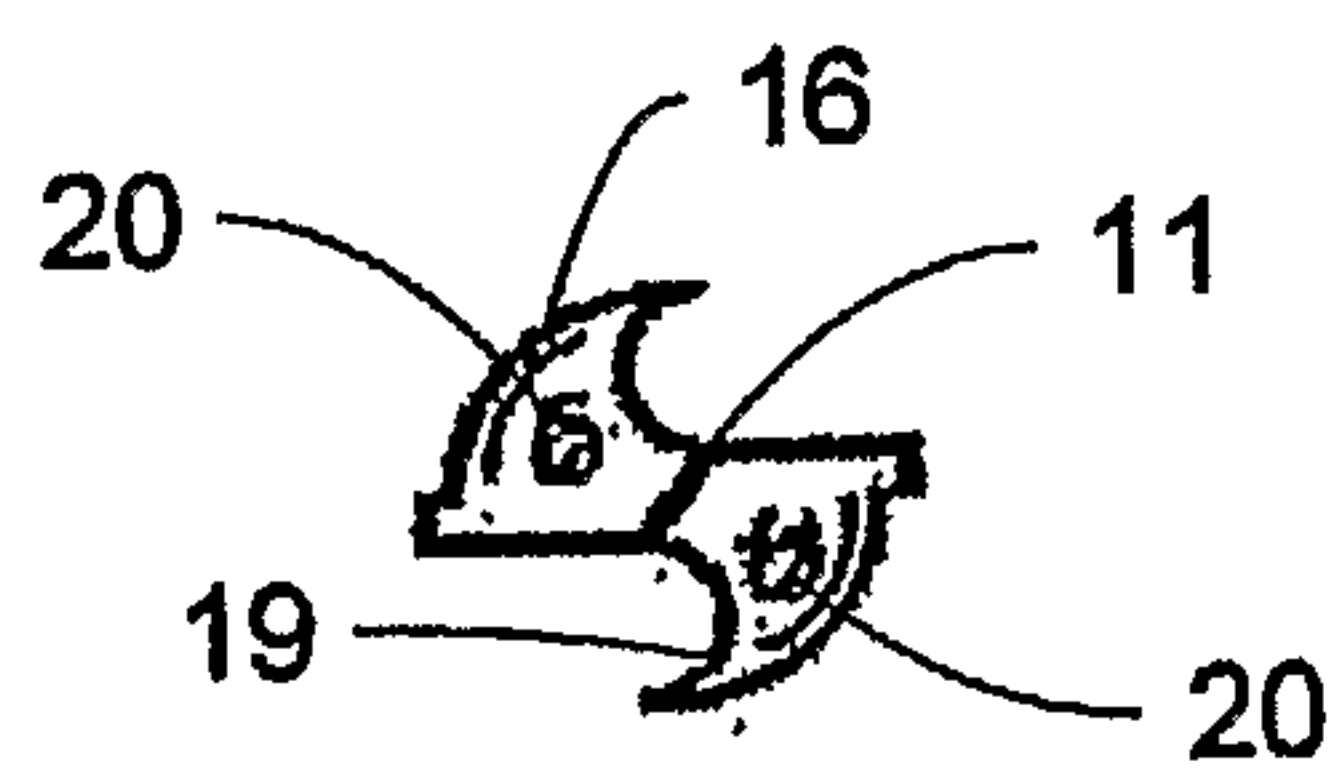


FIGURE 1(b)

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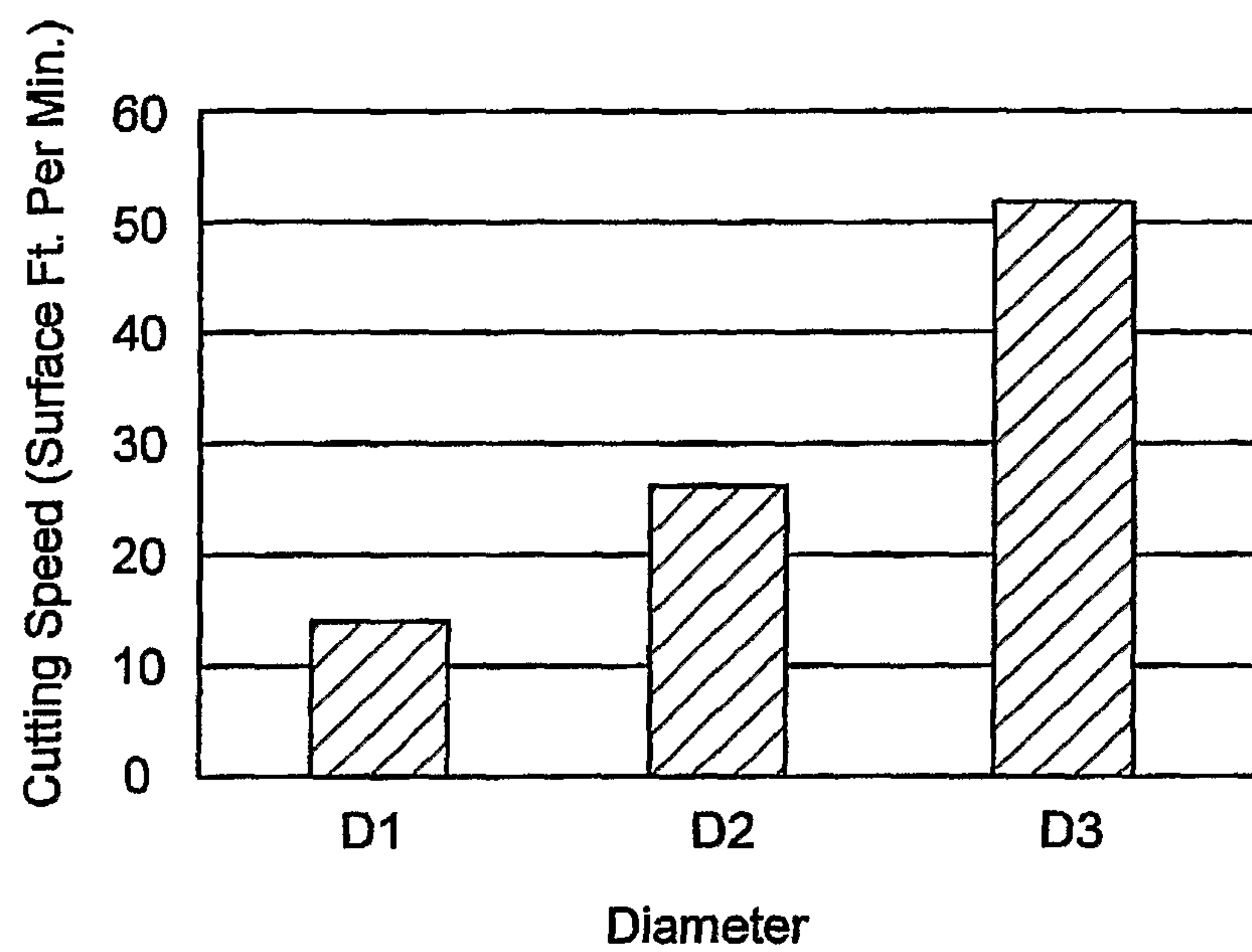


FIGURE 2(a)

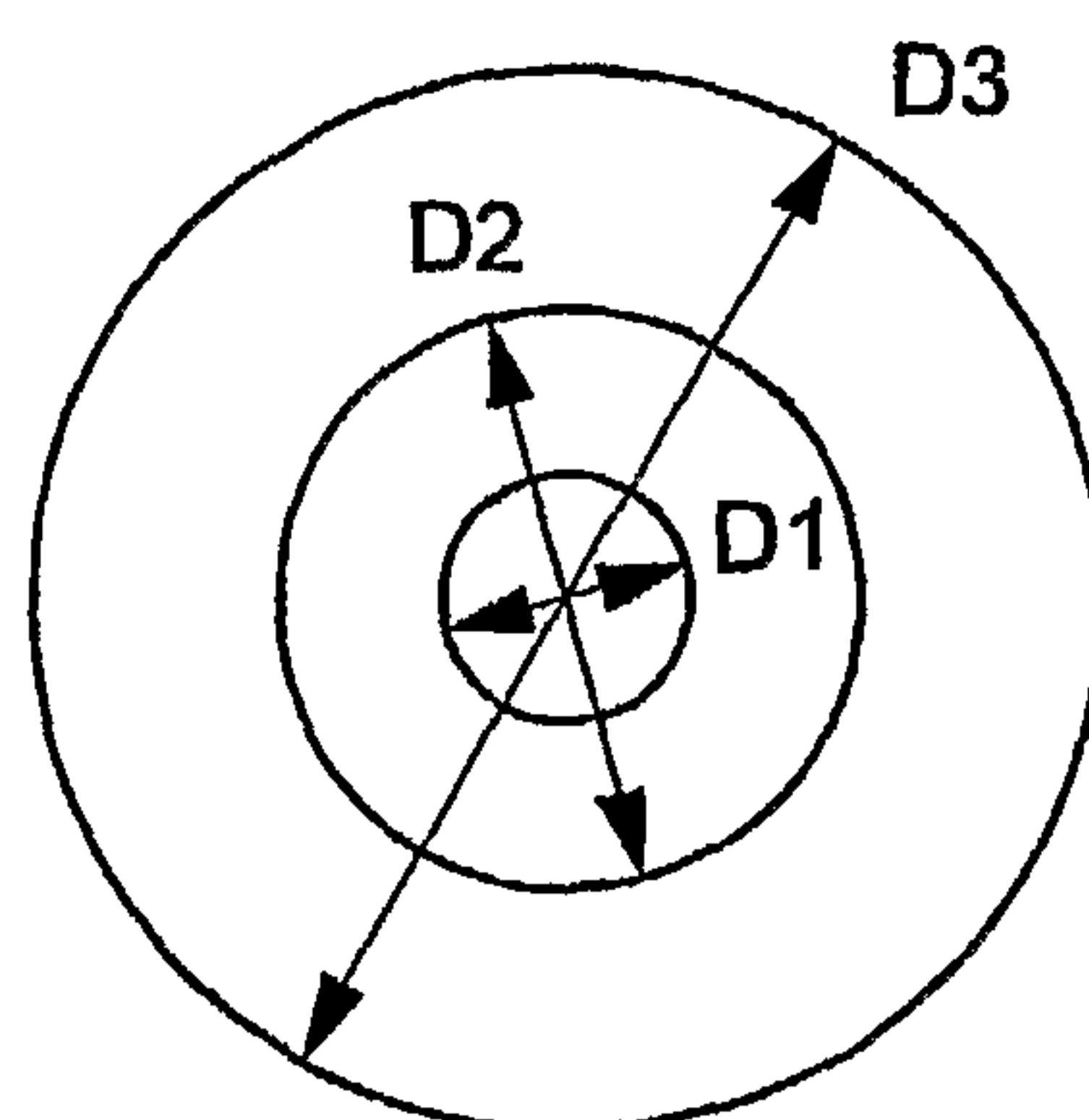
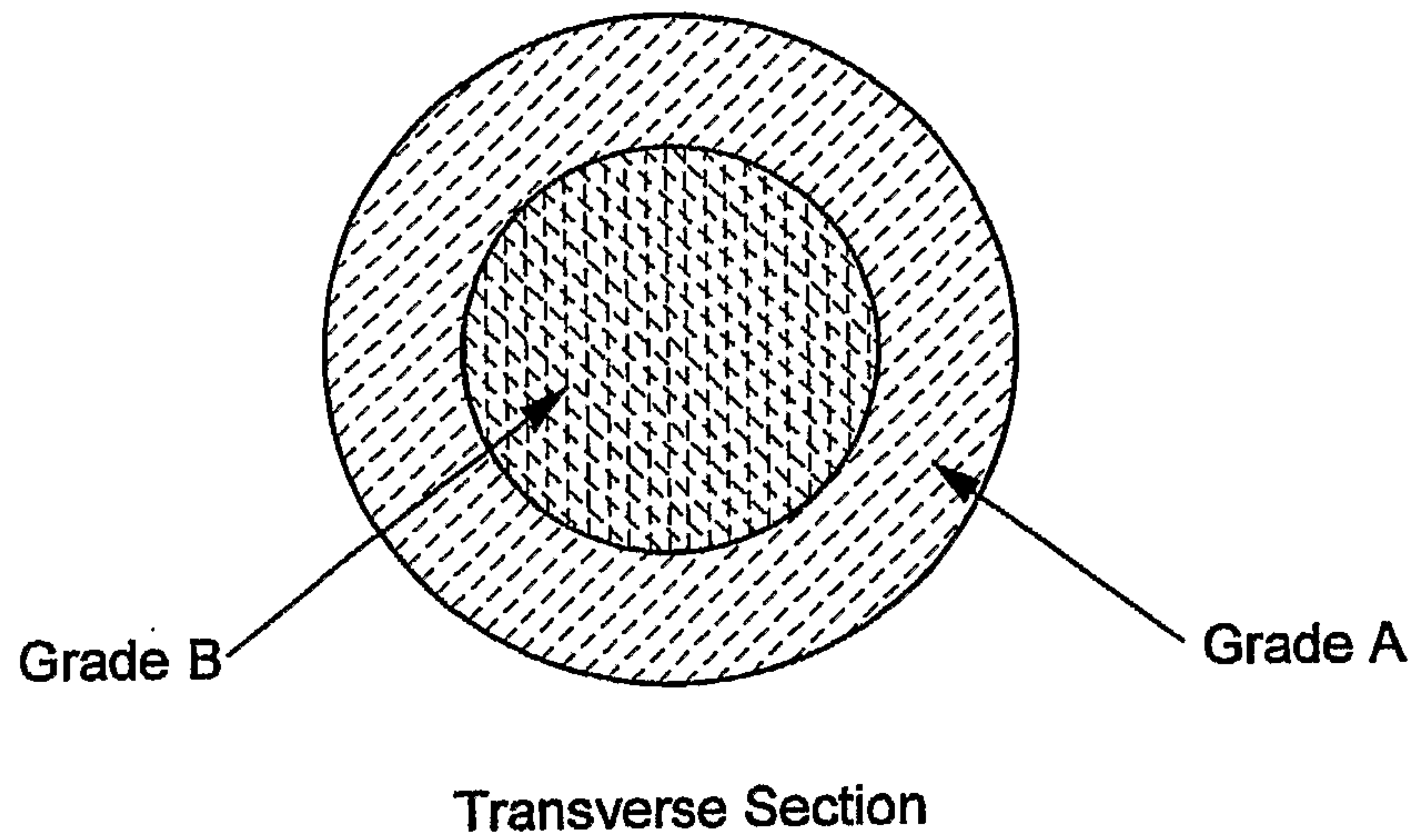
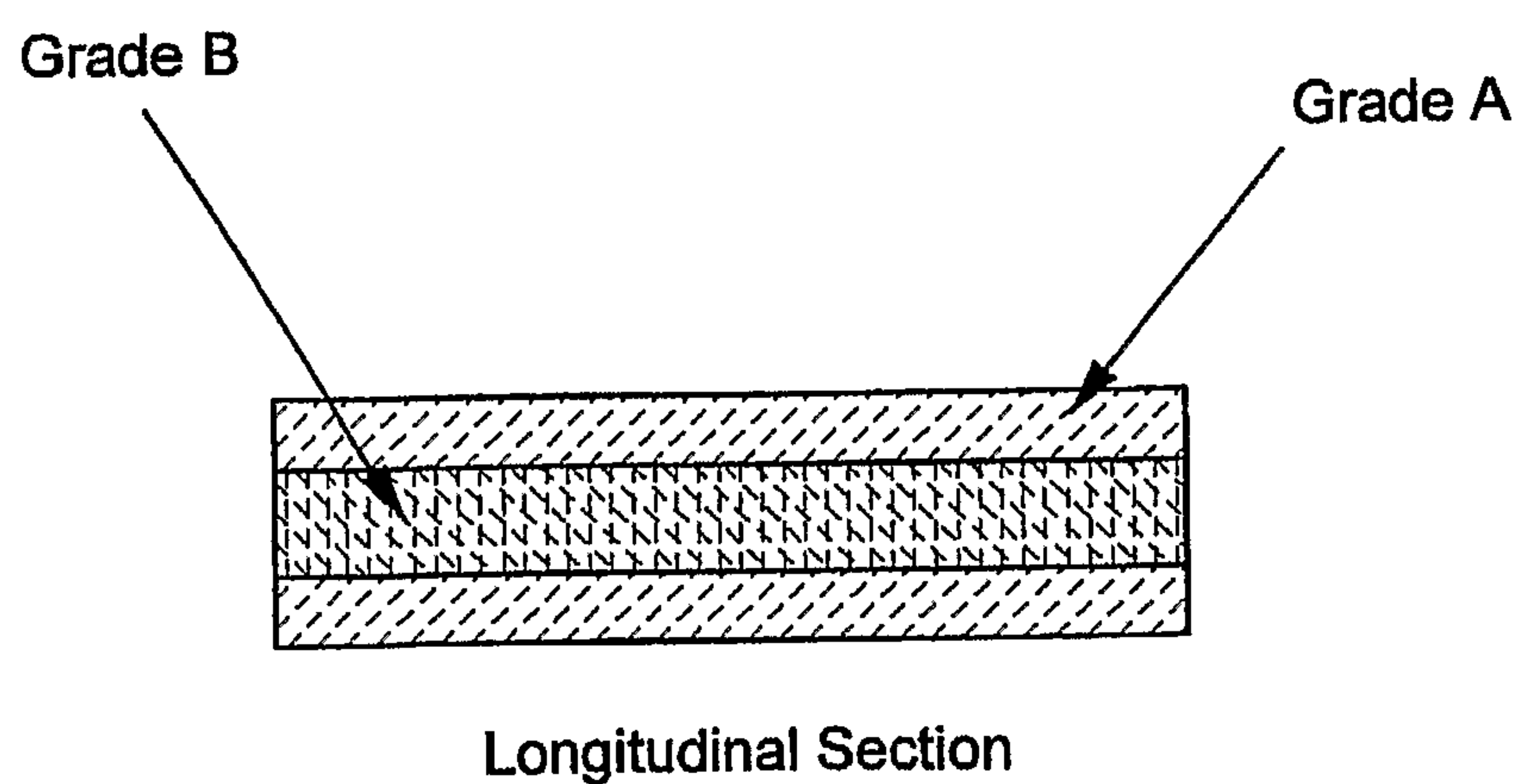


FIGURE 2(b)

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**FIGURE 3(a)****FIGURE 3(b)**

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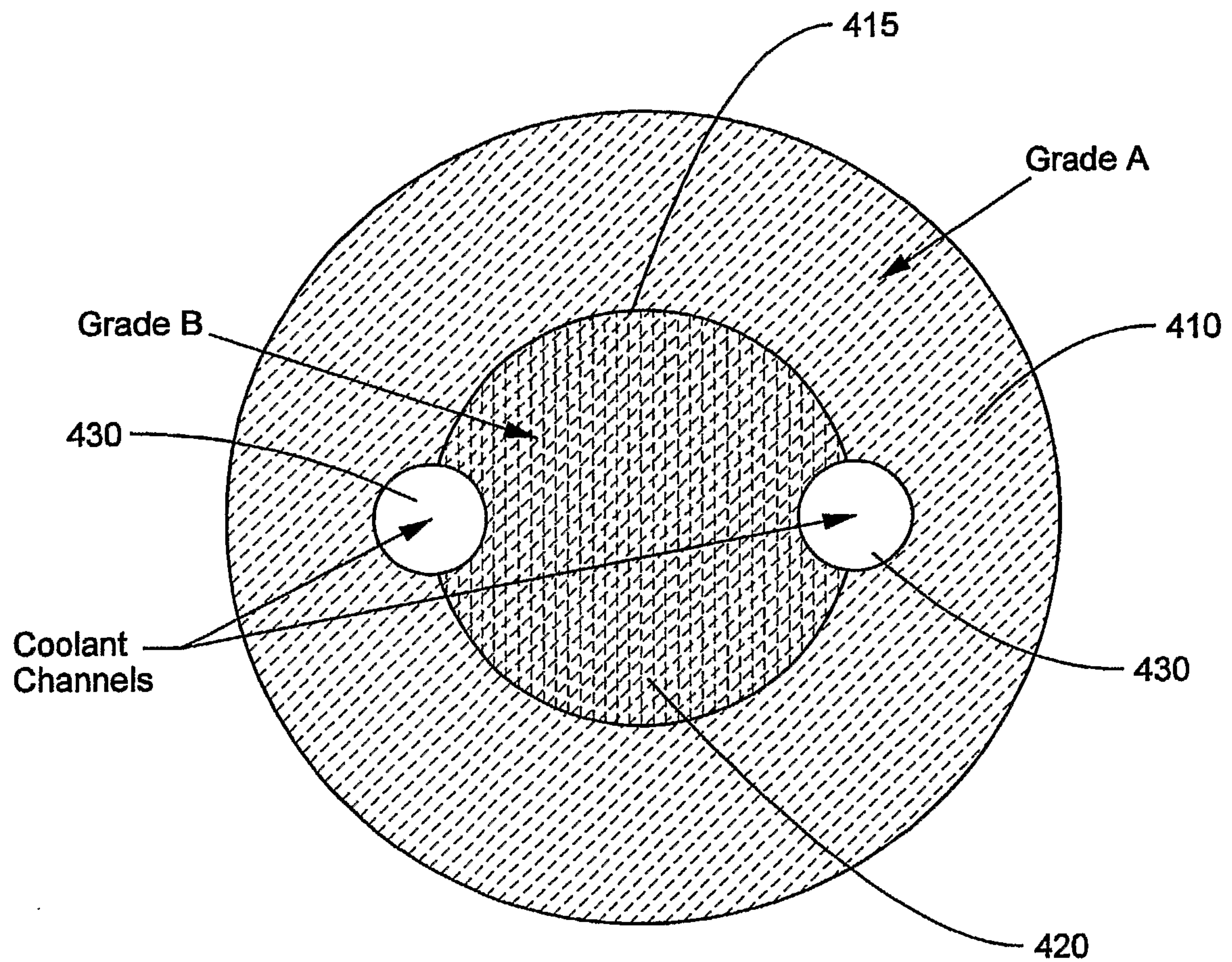


FIGURE 4(a)

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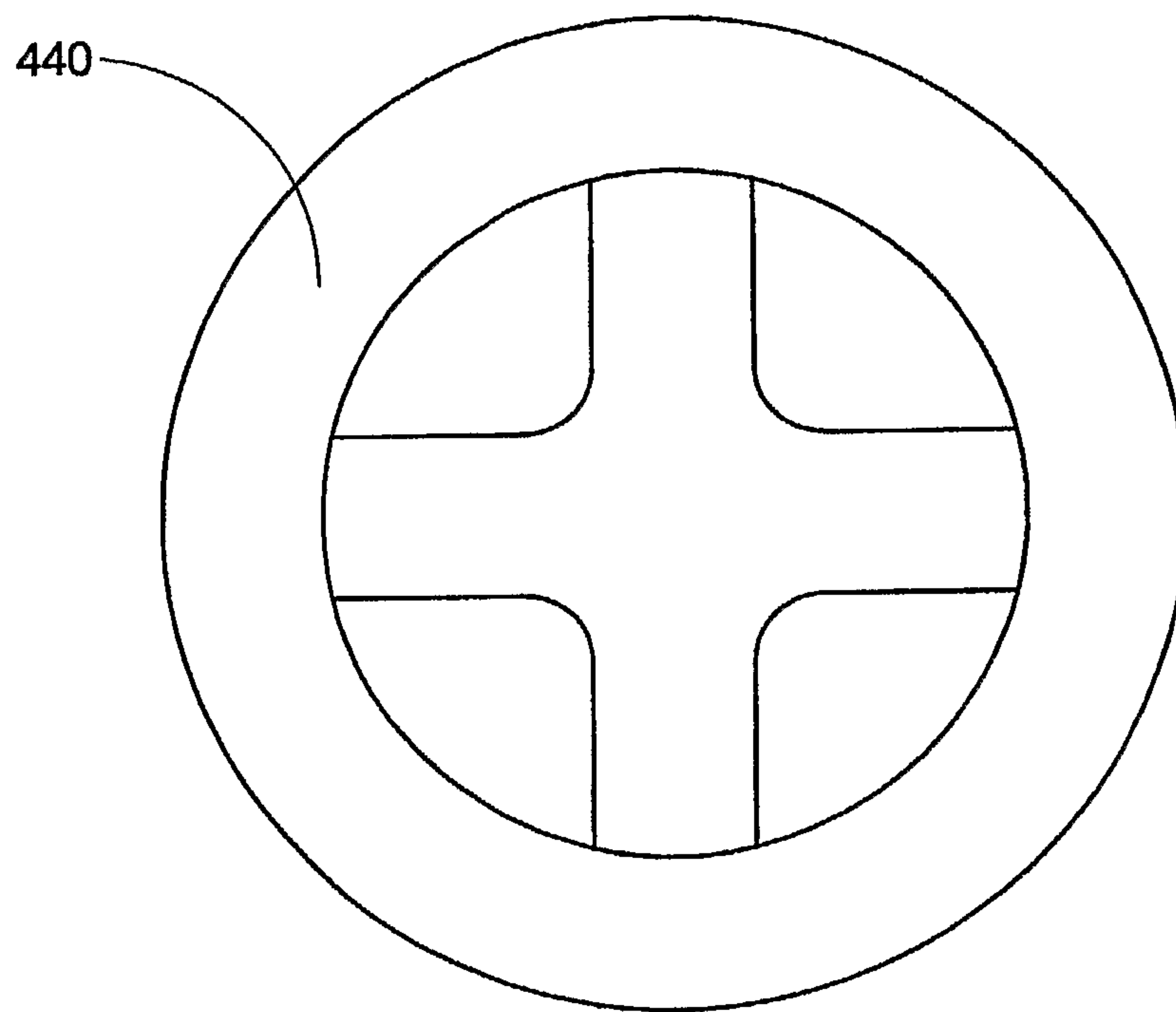
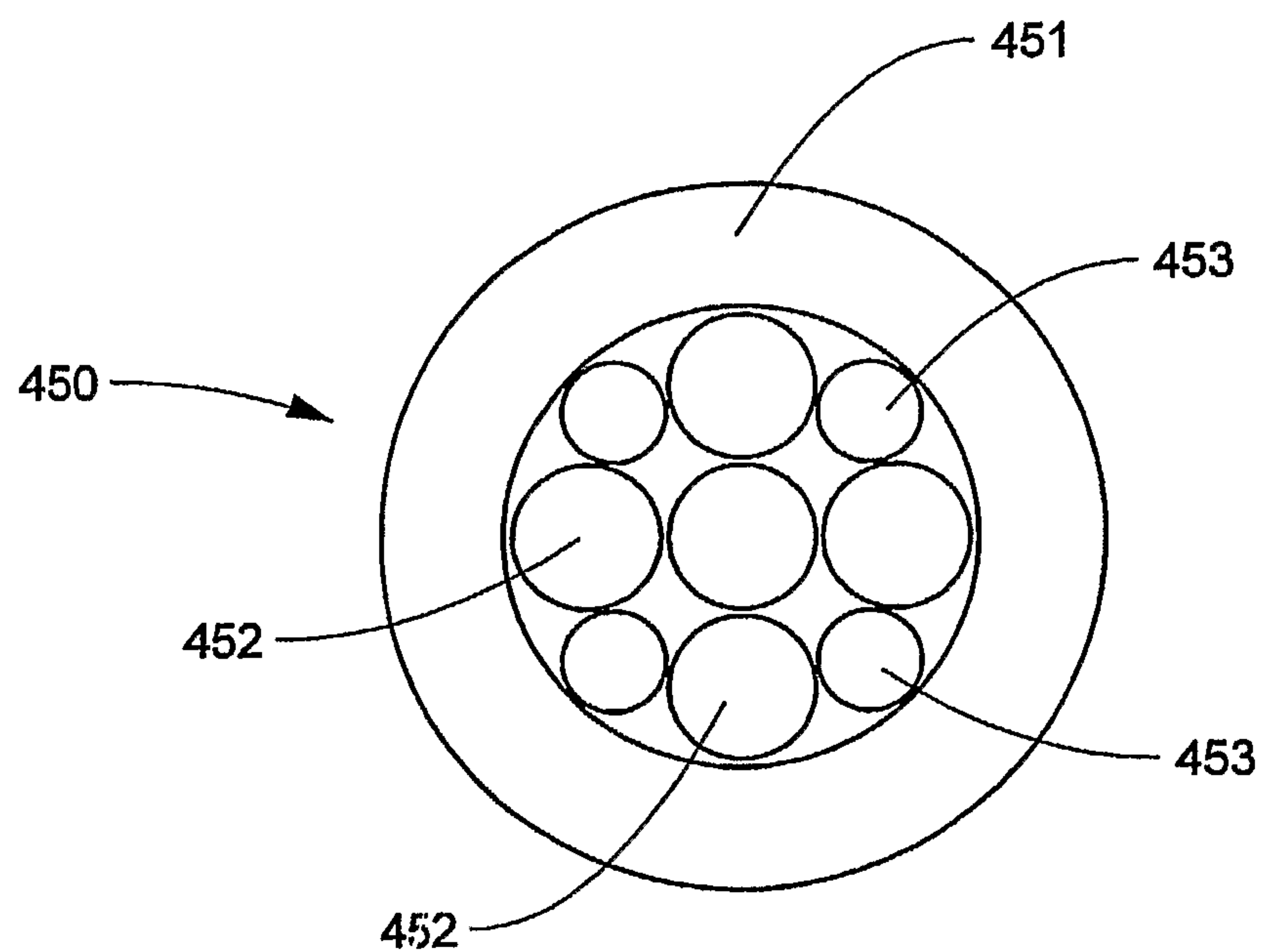
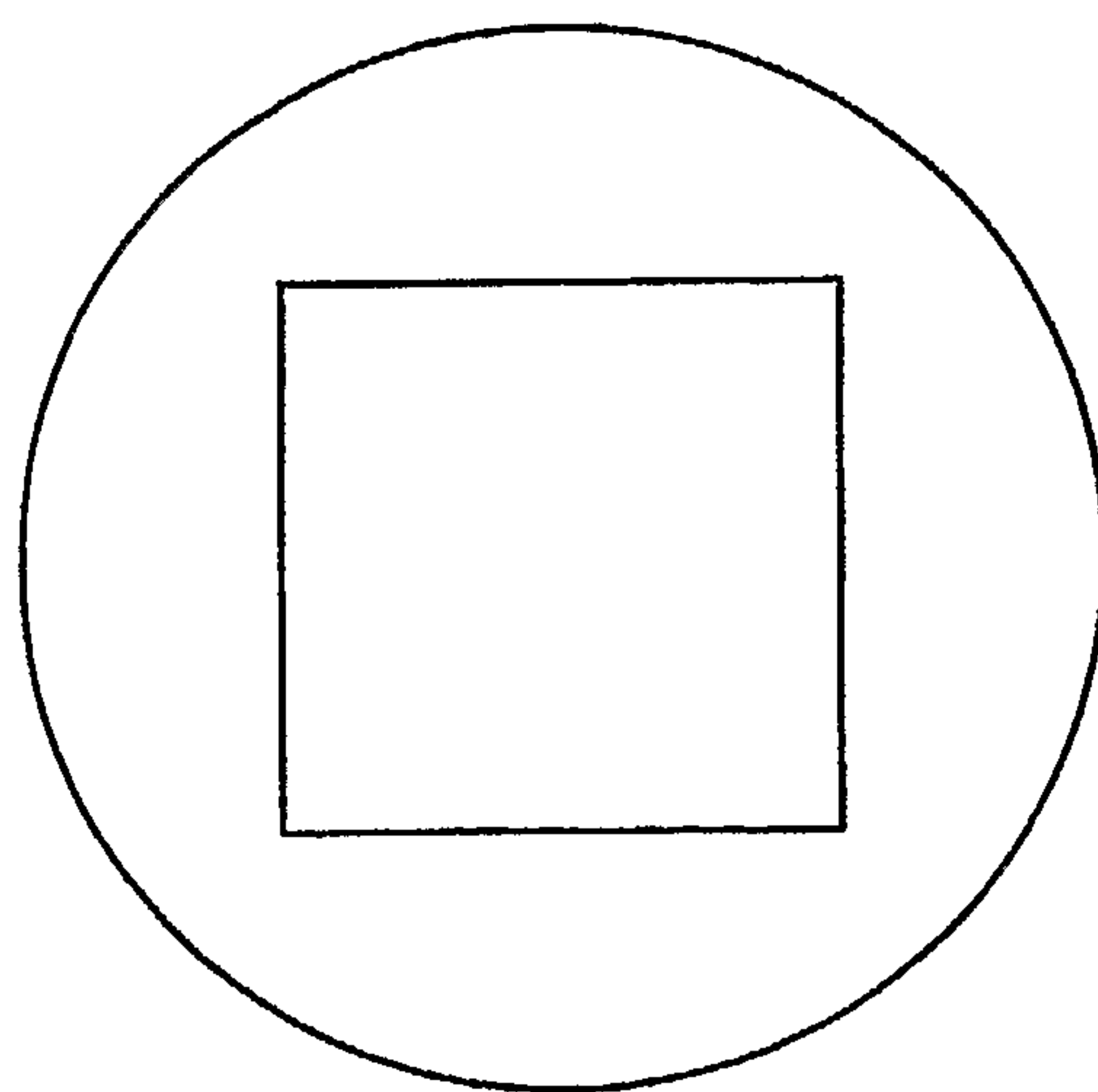


FIGURE 4(b)

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**FIGURE 4(c)****FIGURE 4(d)**

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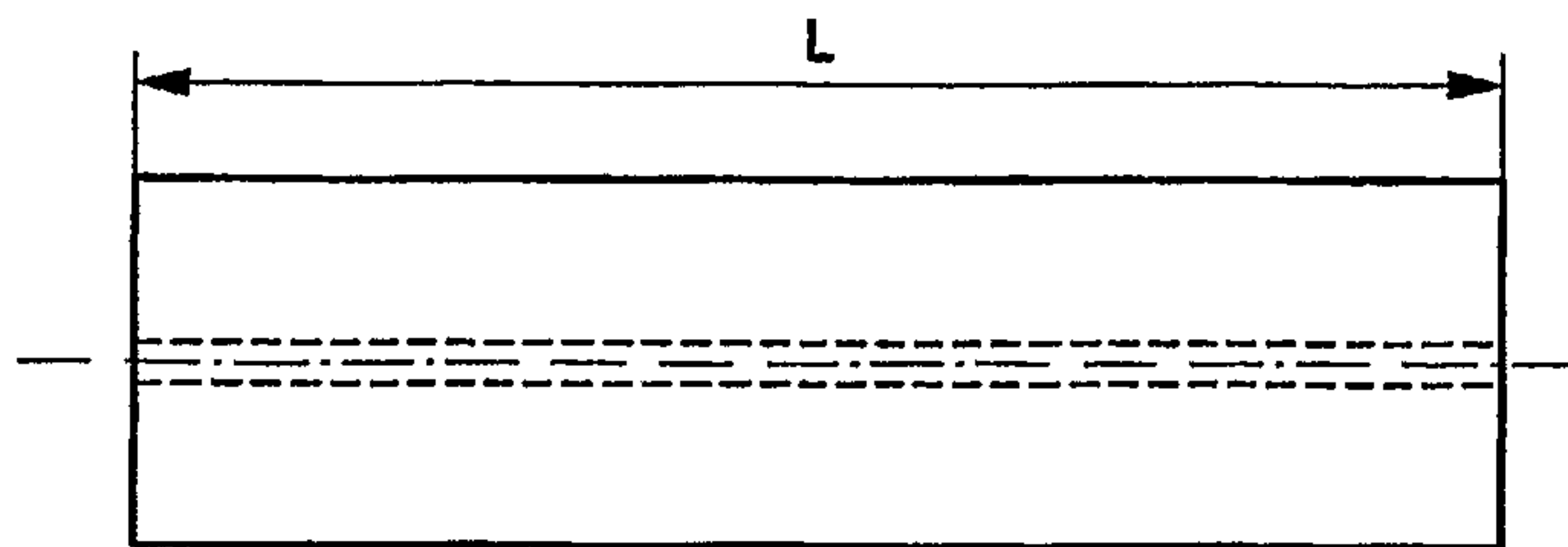


FIGURE 5(a)
Straight Single Hole

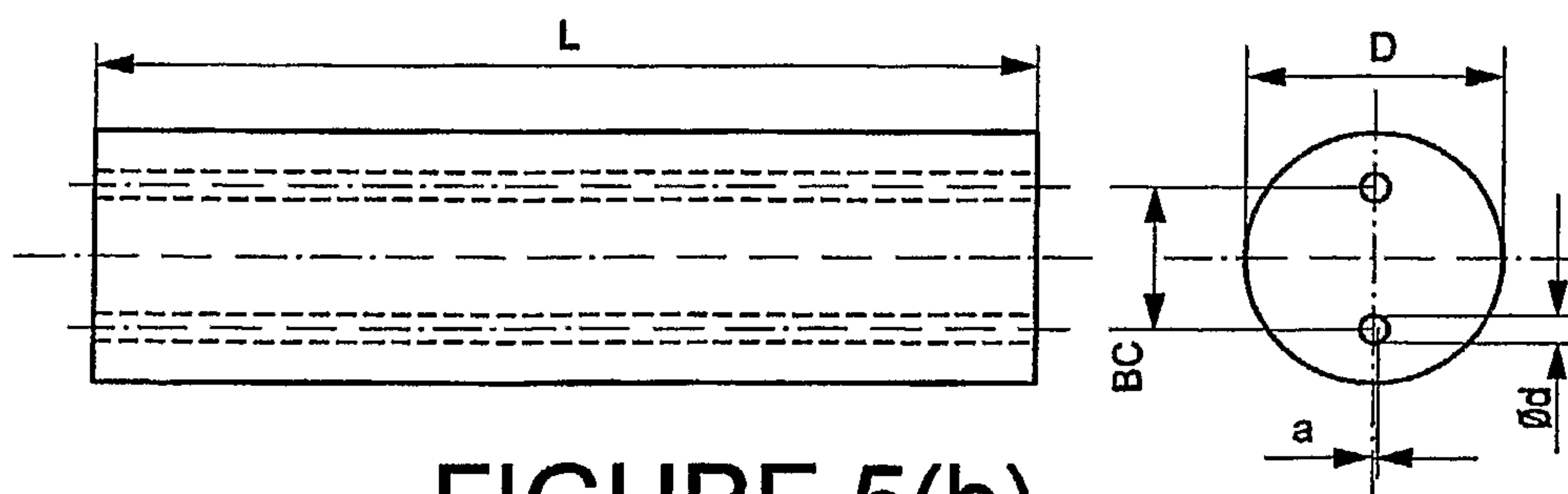


FIGURE 5(b)
Straight Two Hole

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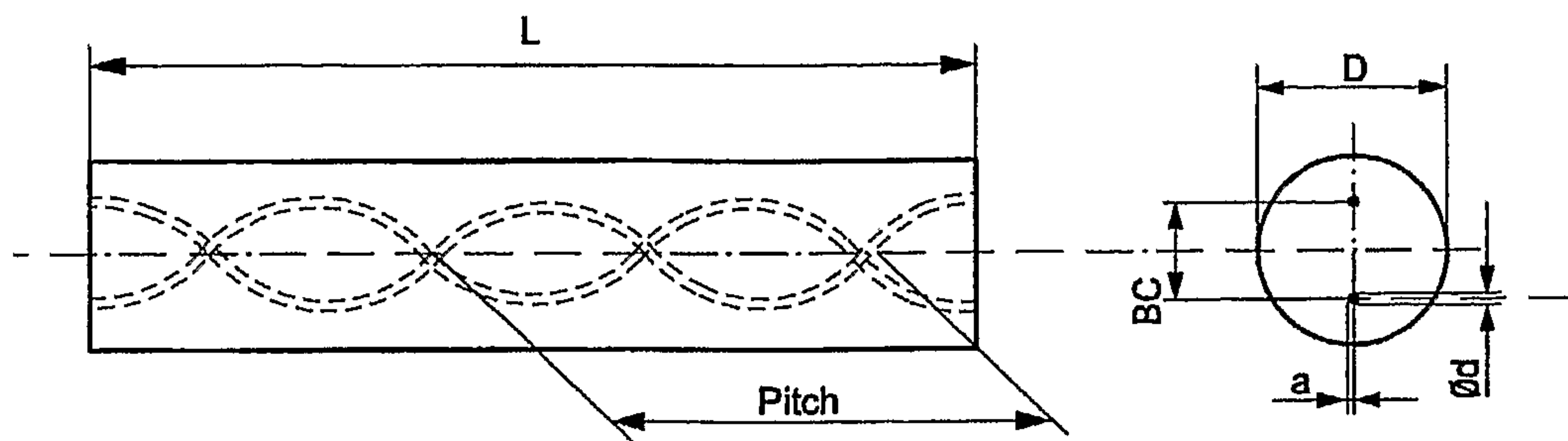


FIGURE 5(c)
Two Hole Spiral or Helical

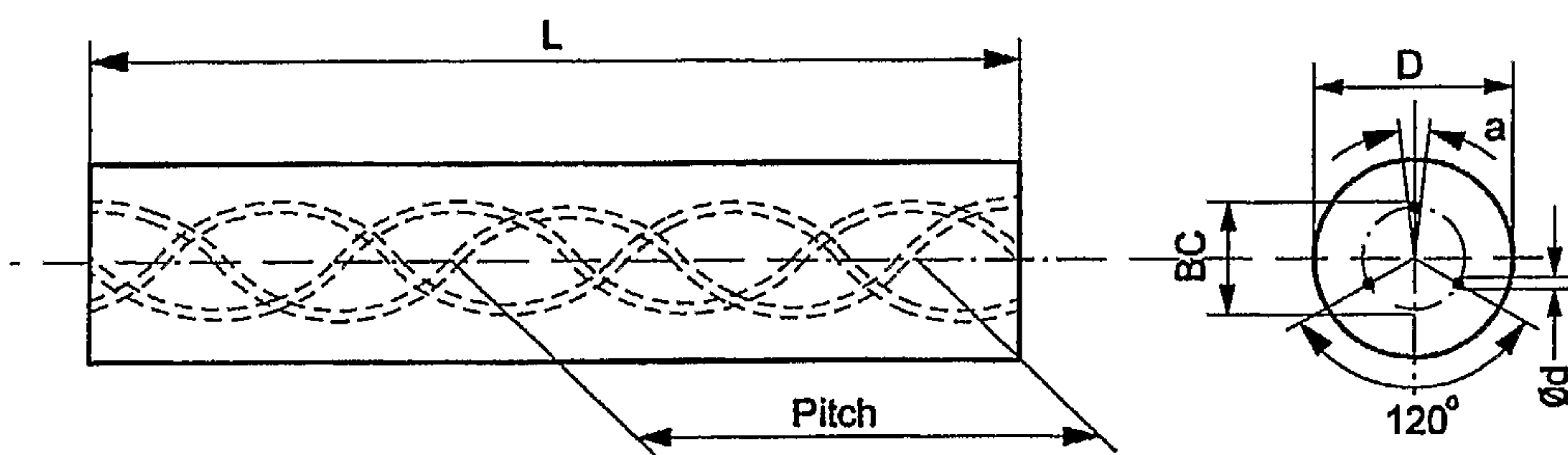


FIGURE 5(d)
Three Hole Spiral or Helical

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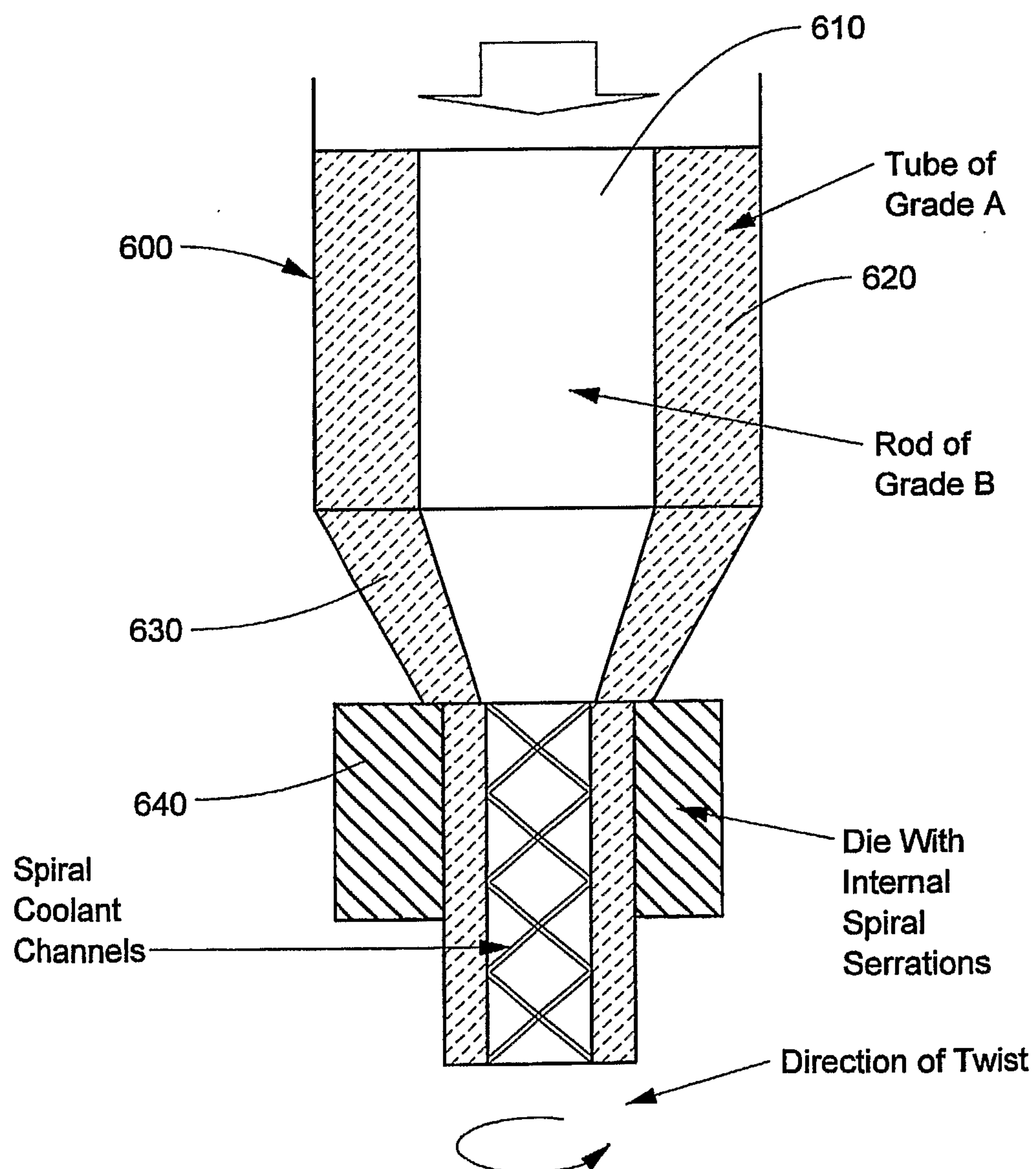


FIGURE 6(a)

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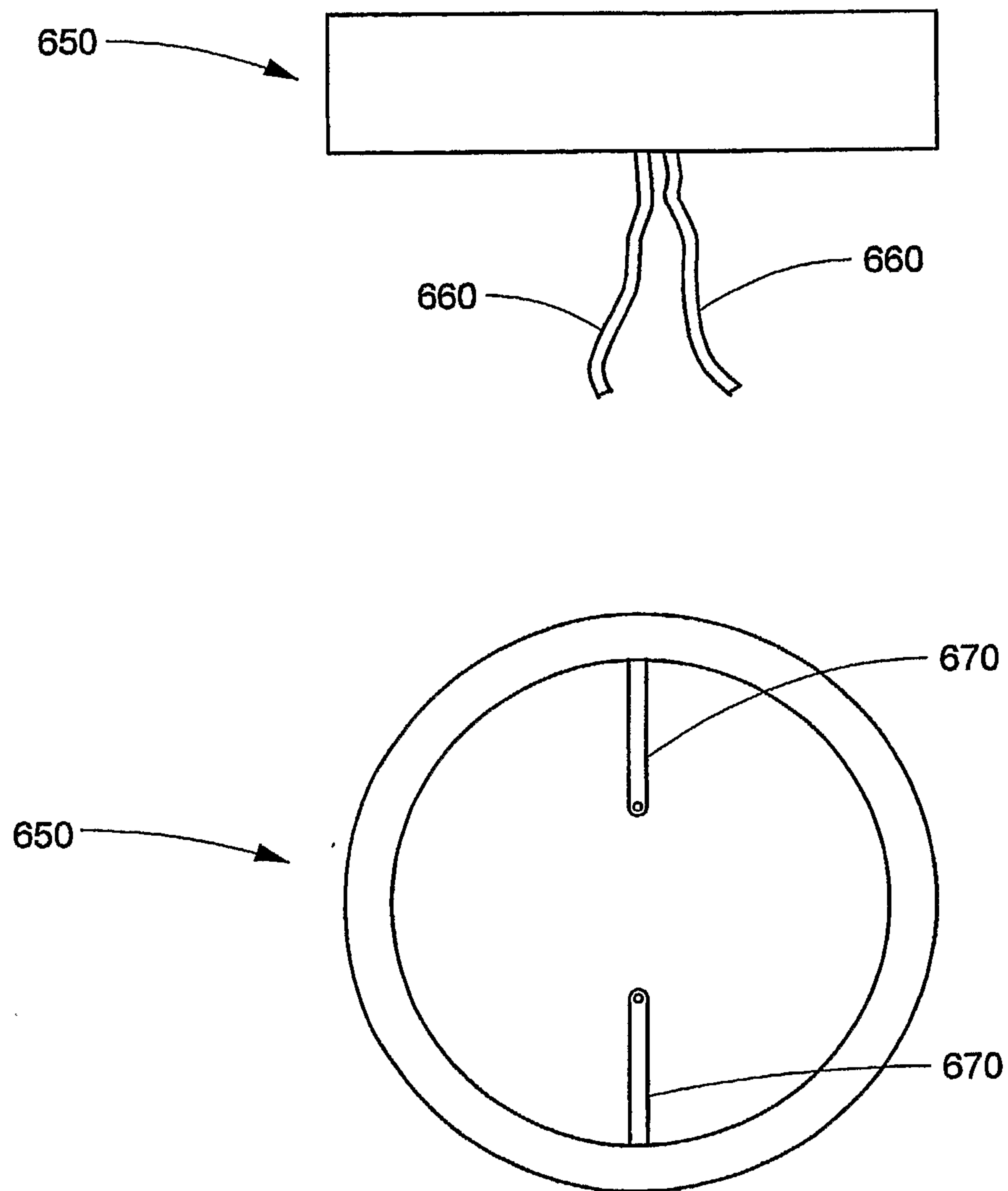


FIGURE 6(b)

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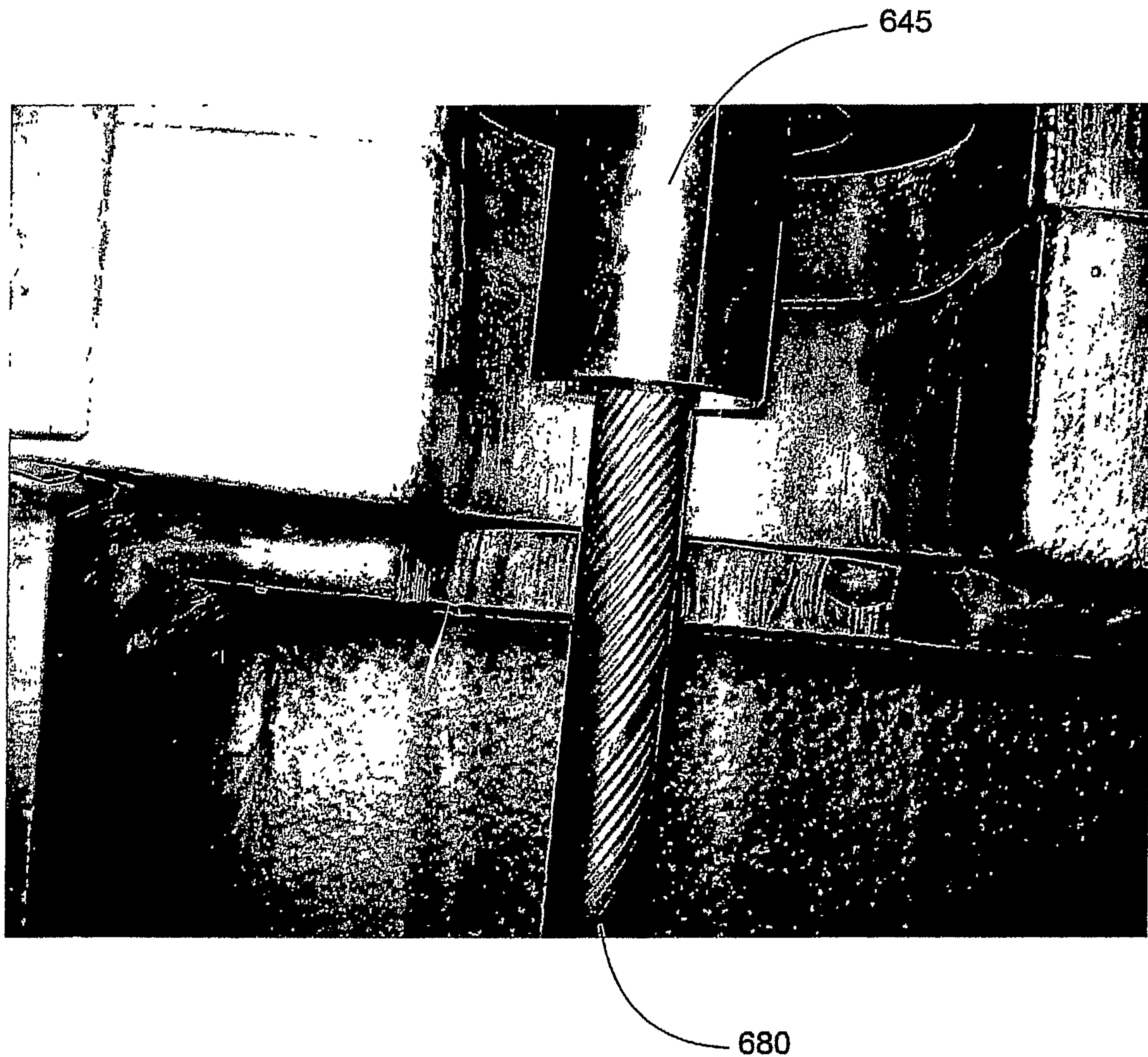


FIGURE 6(c)

Coextruded Composite Carbide Rod With Integral Coolant
Channels Exiting From Die With Spiral Serrations

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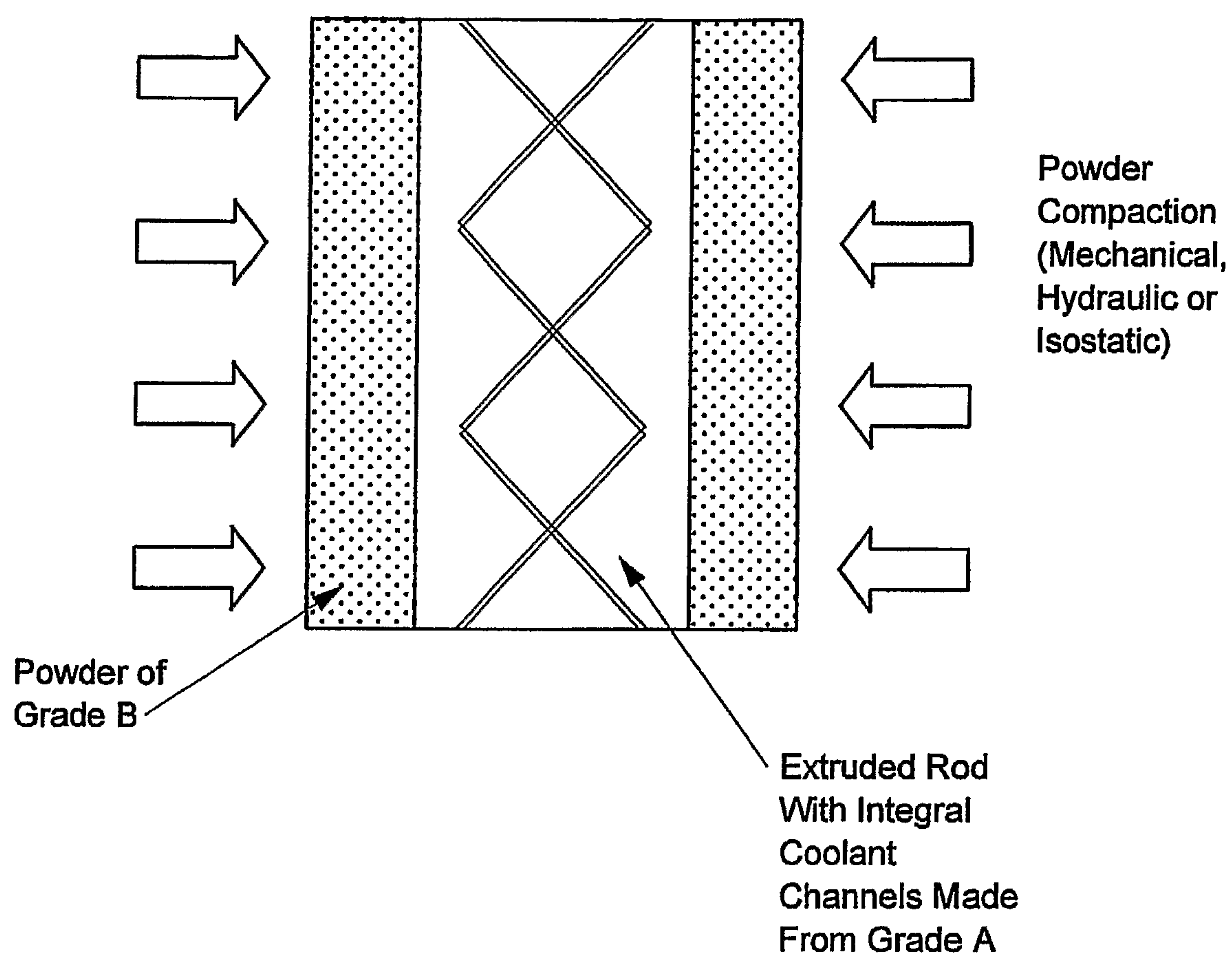


FIGURE 7

Powder Compaction of Outer Grade Onto an Extruded Rod With Integral Coolant Holes

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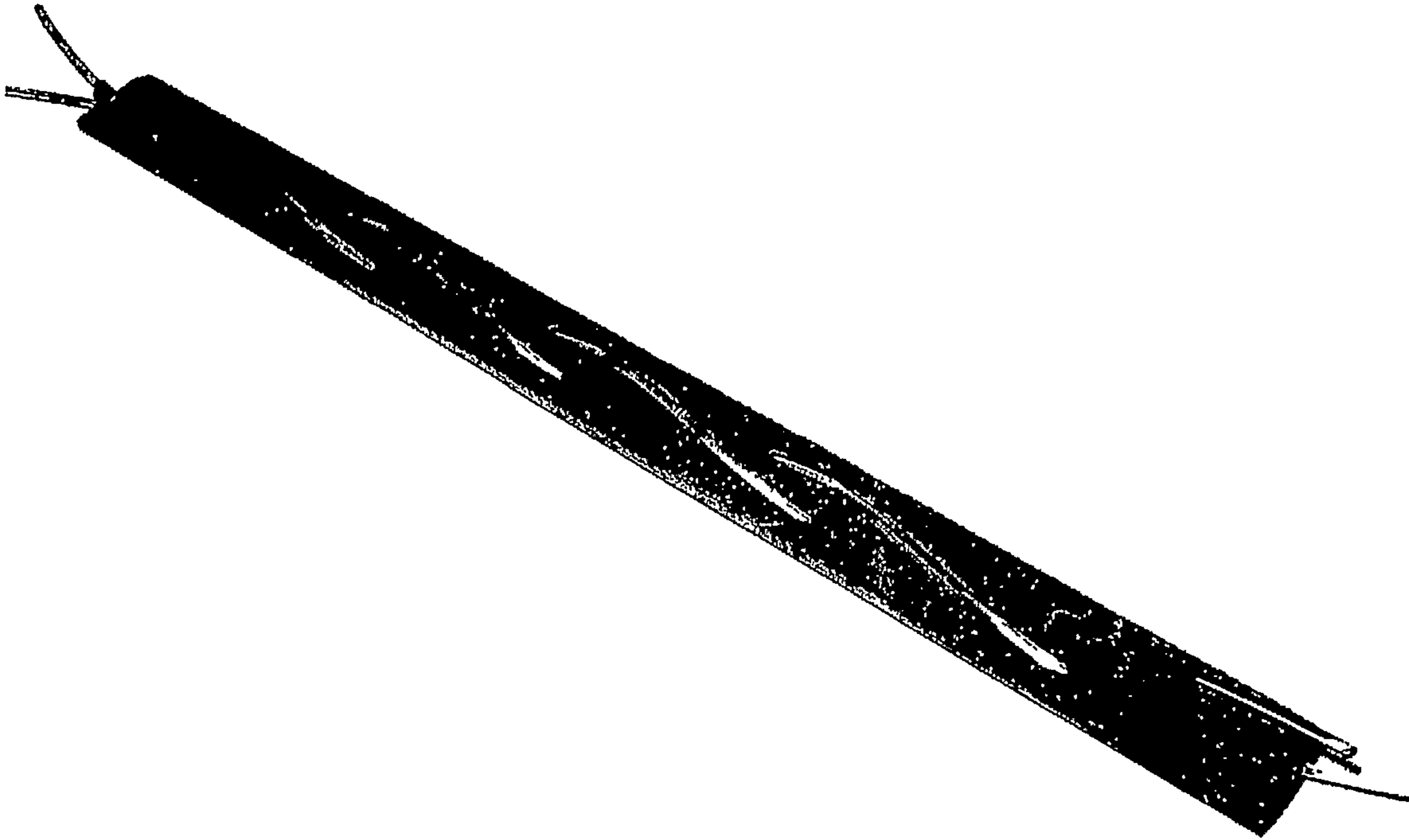


FIGURE 8(a)

Longitudinal Cross-Section of Composite Rod With Integral Coolant Channels
(Nylon Wires Inserted Into Channels to Show Their Location)

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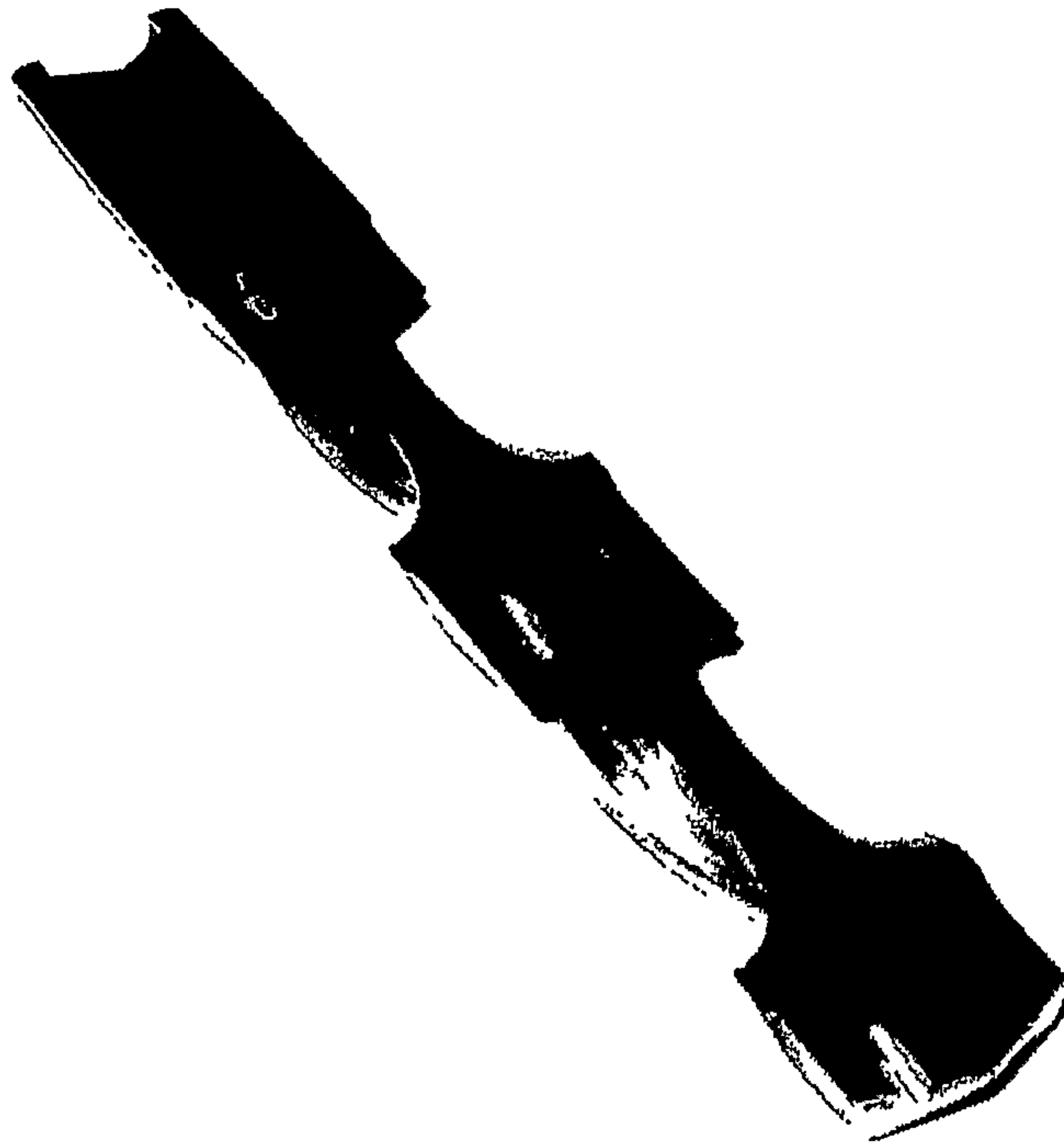


FIGURE 8(b)

Longitudinal Cross-Section of Drill Made From Composite
Cemented Carbide and Having Integral Coolant Channels

