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(54) **BRUSH FOR APPLYING PRODUCT TO KERATINOUS FIBERS**

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(57) **ABSTRACT**

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A device for applying a product to keratinous fibers may comprise a stem having two opposite ends and a brush portion connected to one end portion of the stem. The one end portion of the stem may have a longitudinal axis and the brush portion may have a free end that is not aligned with the longitudinal axis of the one end portion of the stem. The brush portion may comprise a core and at least part of the core may be curved such that a line tangent to the core at any axial position along the core is not perpendicular to the longitudinal axis of the one end portion of the stem. The brush portion may further comprise bristles connected to the core. The bristles may comprise ends defining an envelope surface having a varying cross-section along at least a part of its length. The envelope surface may be asymmetrical about a midplane of the envelope surface, the midplane being oriented perpendicular to the core.

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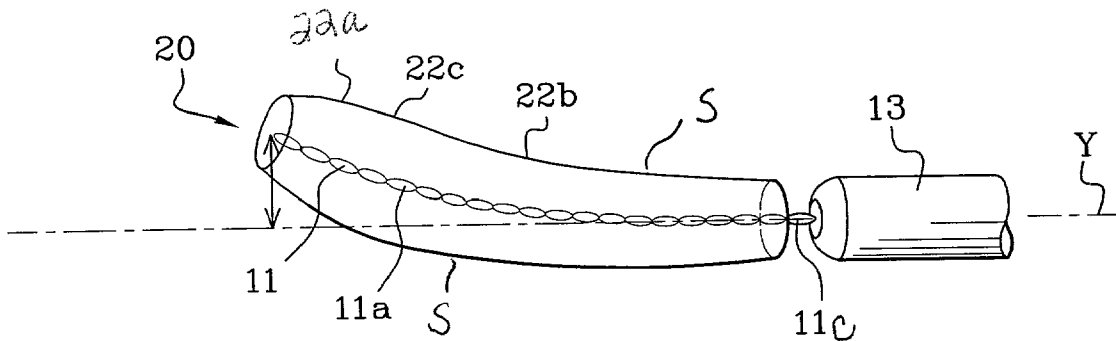
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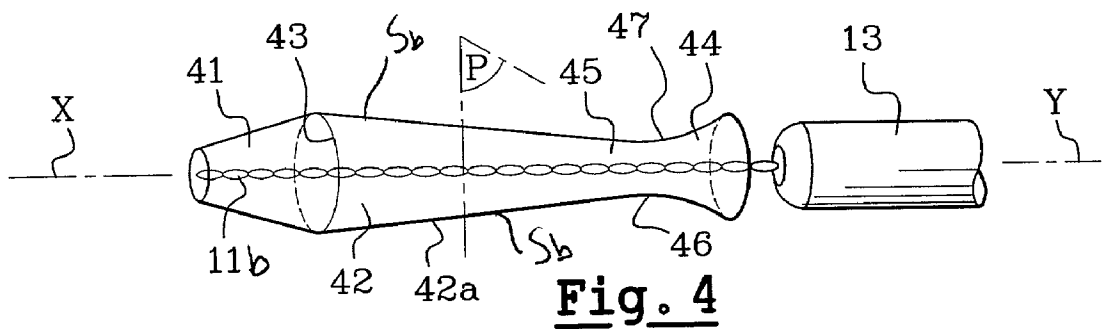
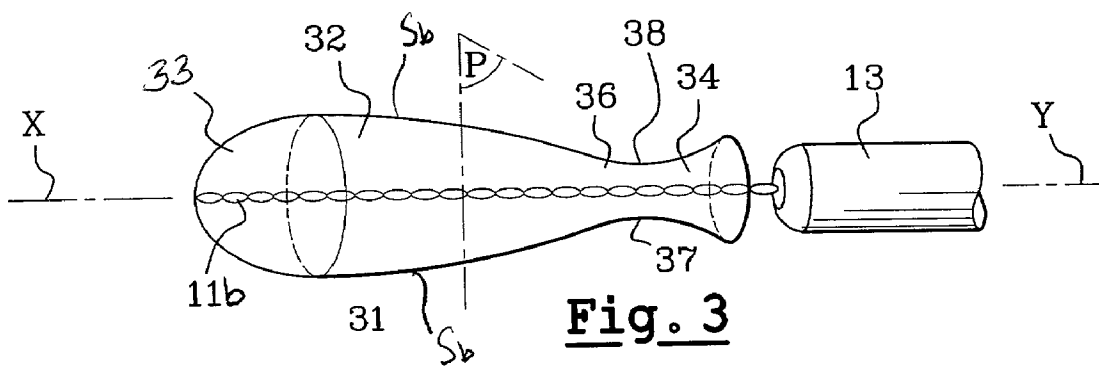
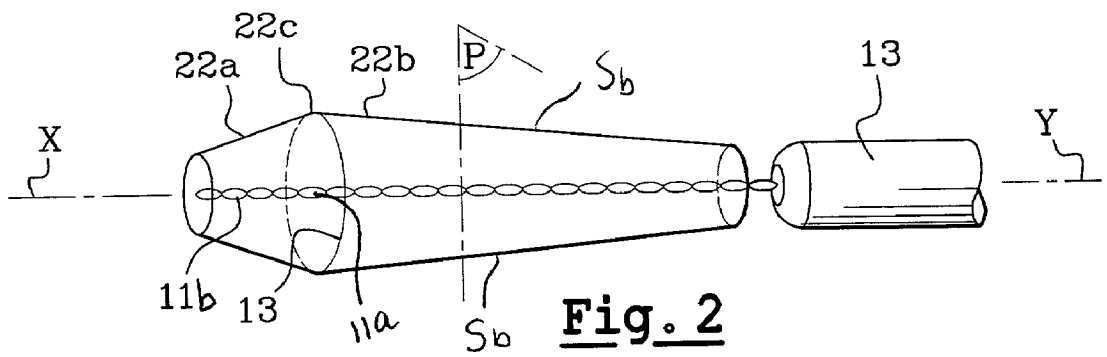
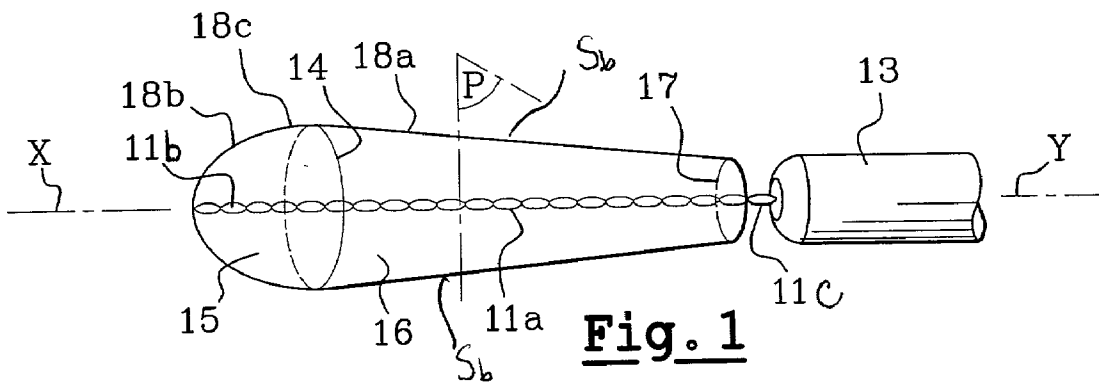
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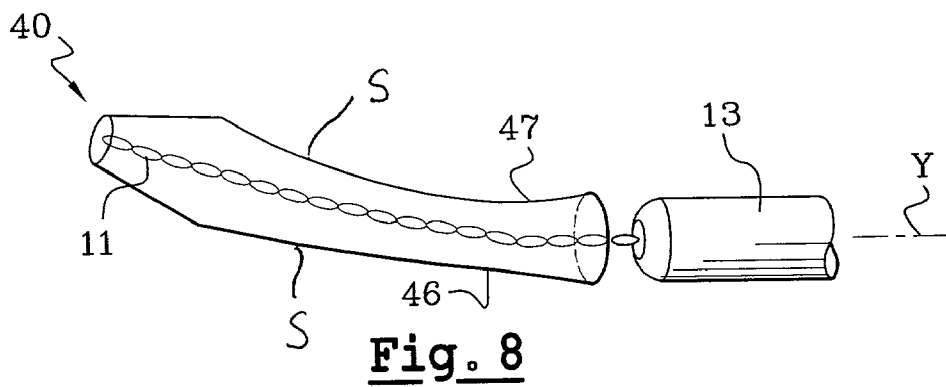
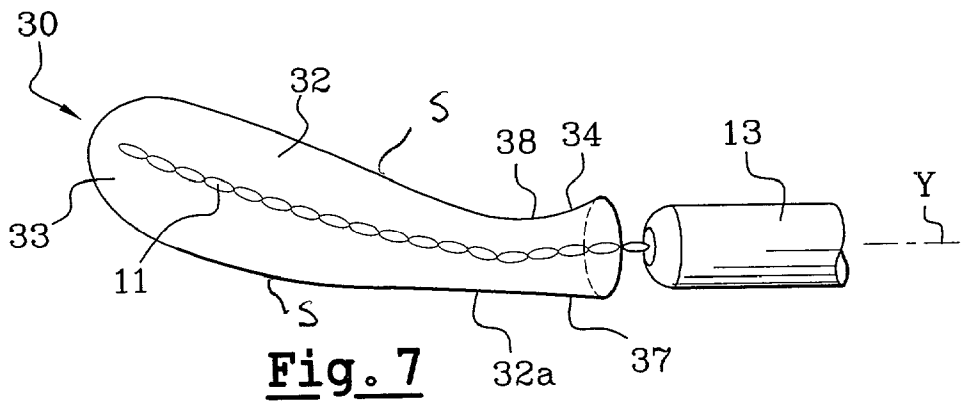
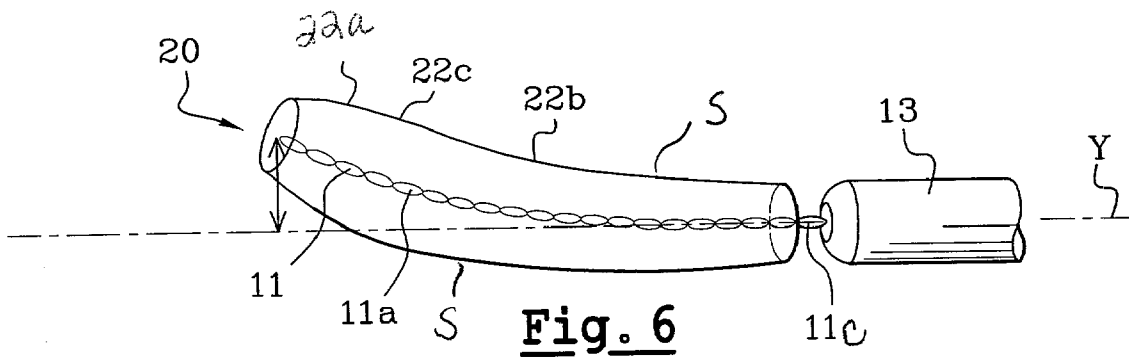
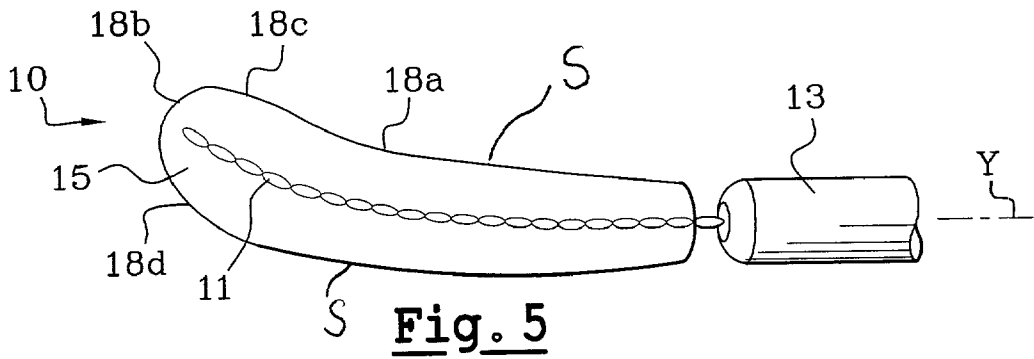
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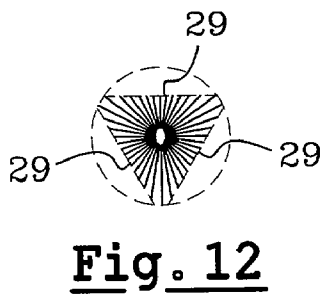
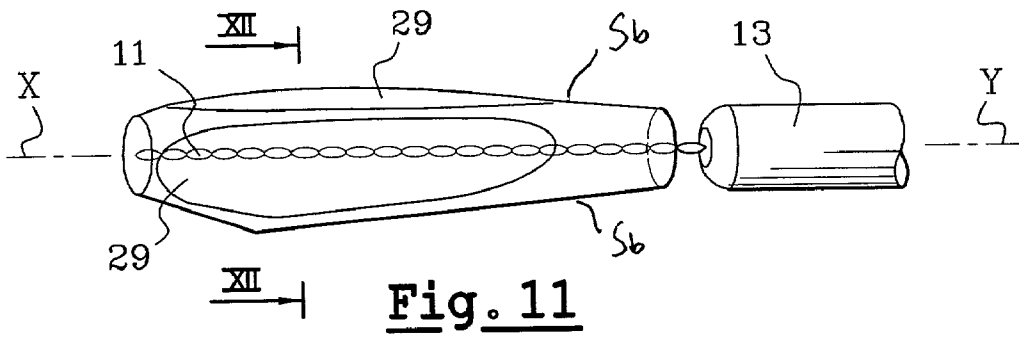
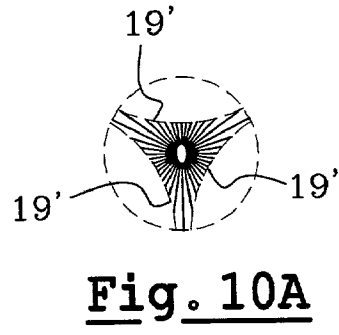
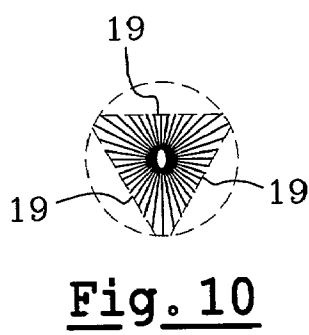
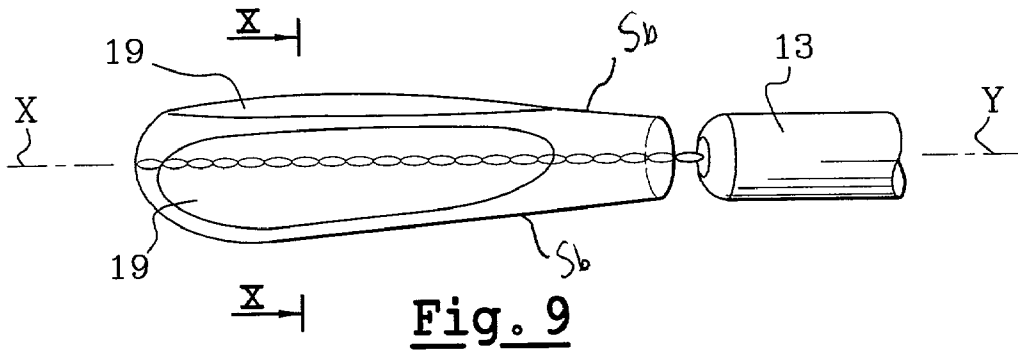
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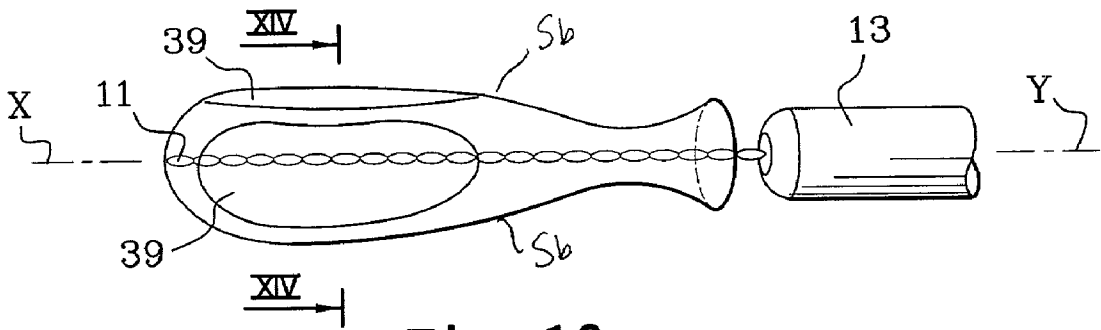
(51) **Int. Cl.<sup>7</sup> ..... A45D 40/26**



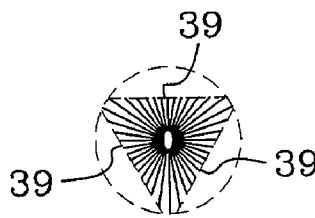




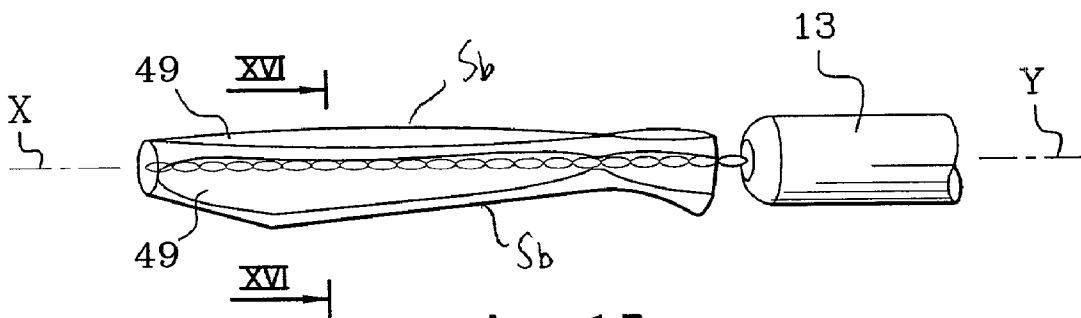




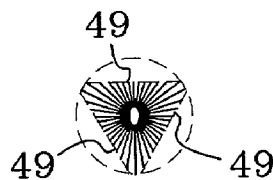
**Fig. 13**



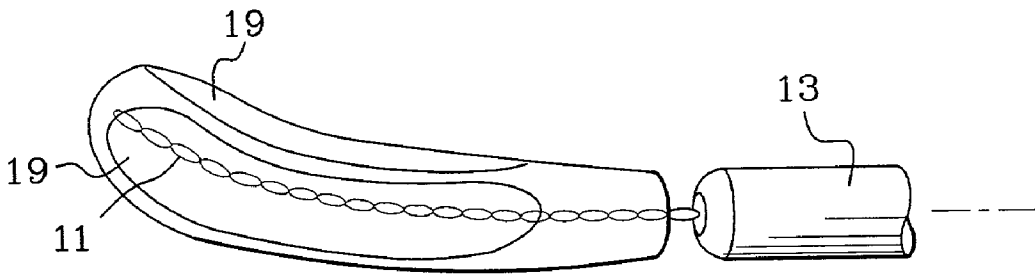
**Fig. 14**



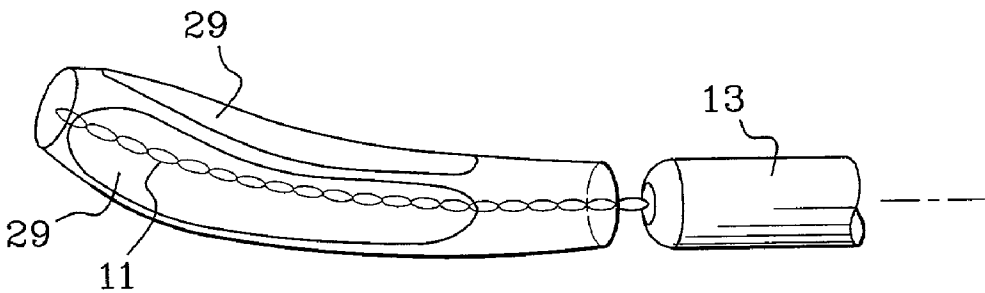
**Fig. 15**



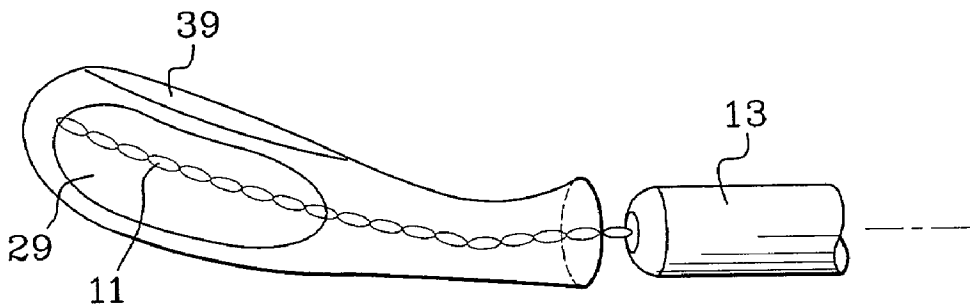
**Fig. 16**



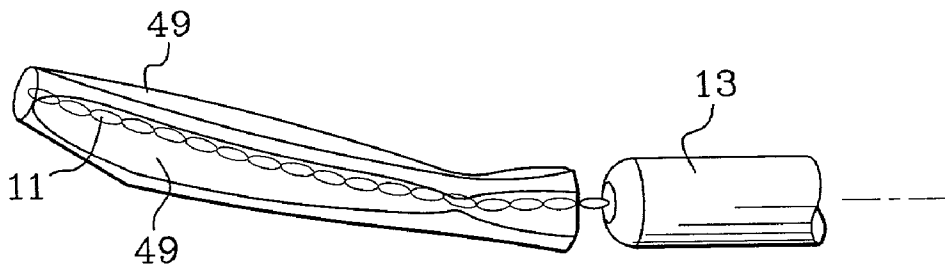
**Fig. 17**



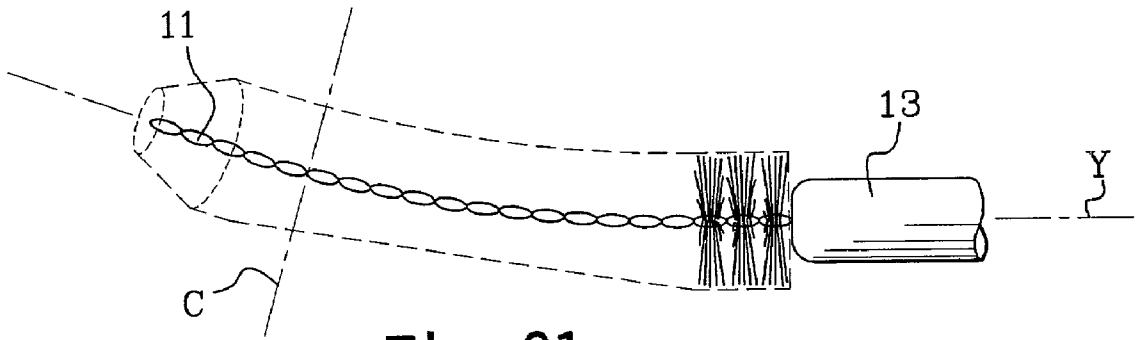
**Fig. 18**



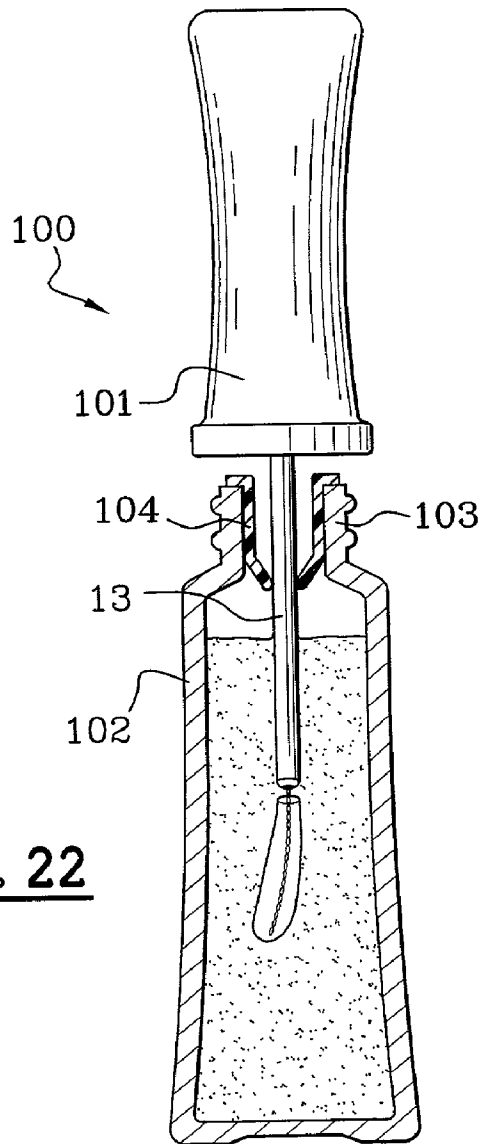
**Fig. 19**



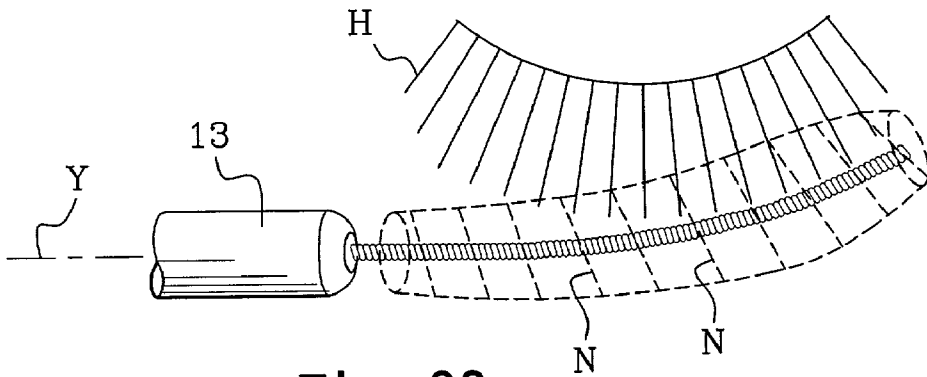
**Fig. 20**



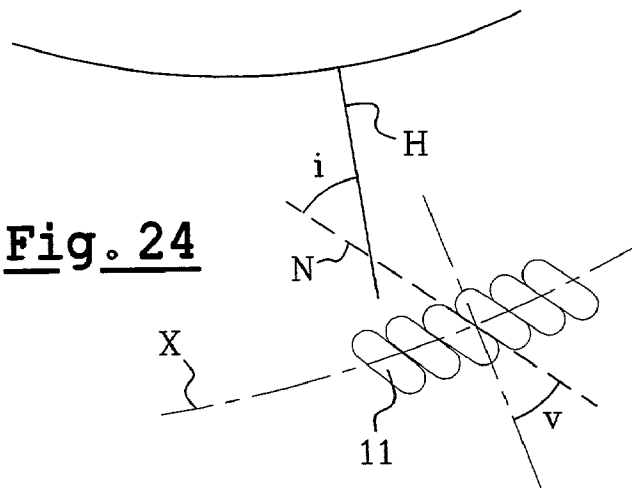
**Fig. 21**



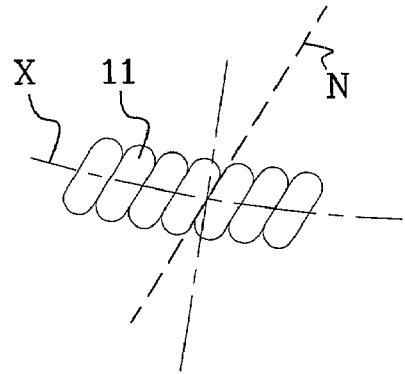
**Fig. 22**



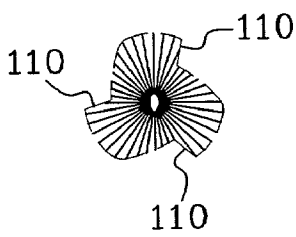
**Fig. 23**



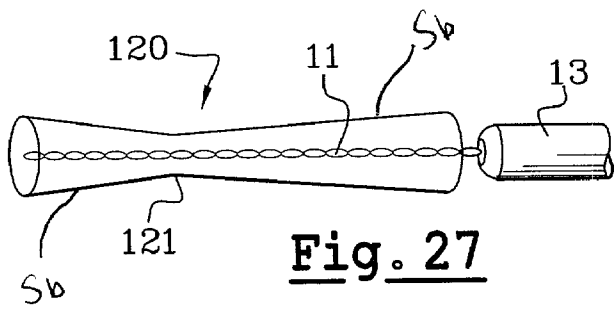
**Fig. 24**



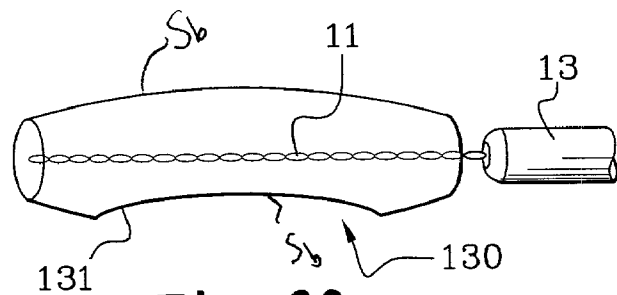
**Fig. 25**



**Fig. 26**



**Fig. 27**



**Fig. 28**

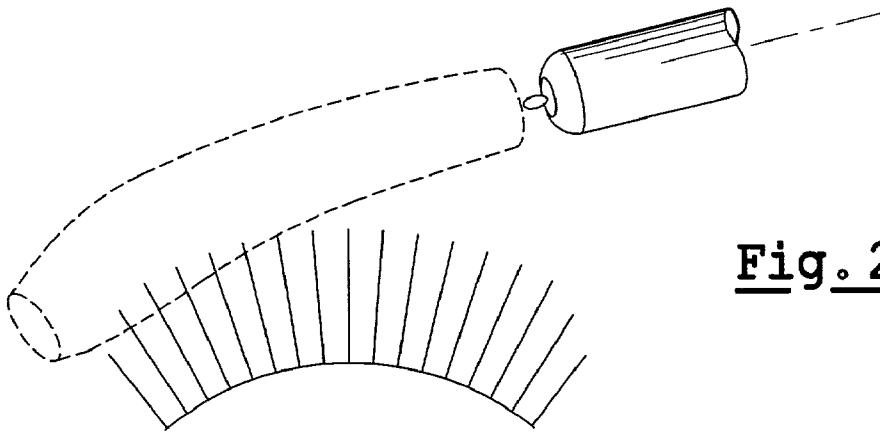


Fig. 29

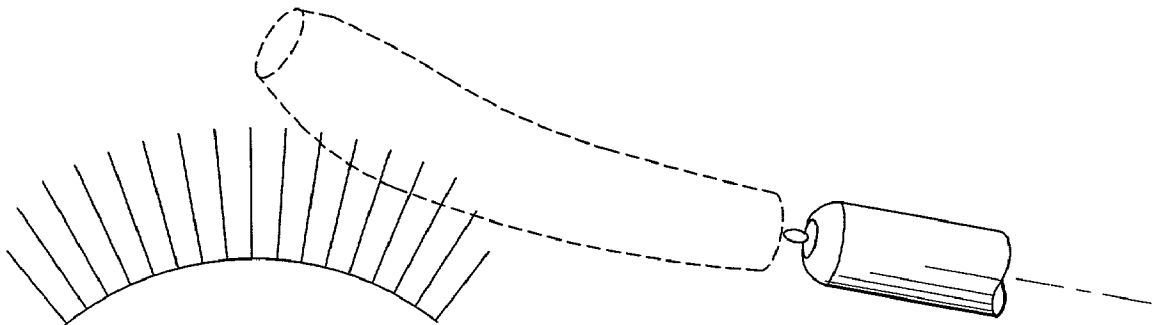


Fig. 30

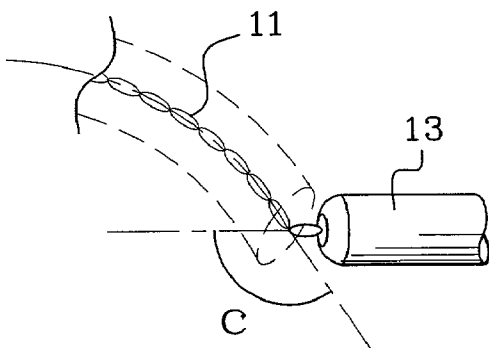


Fig. 31

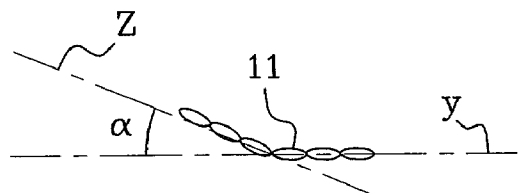
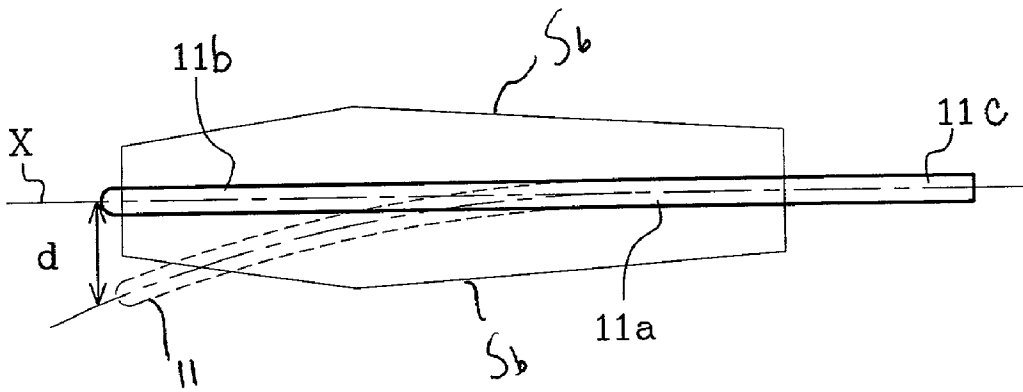
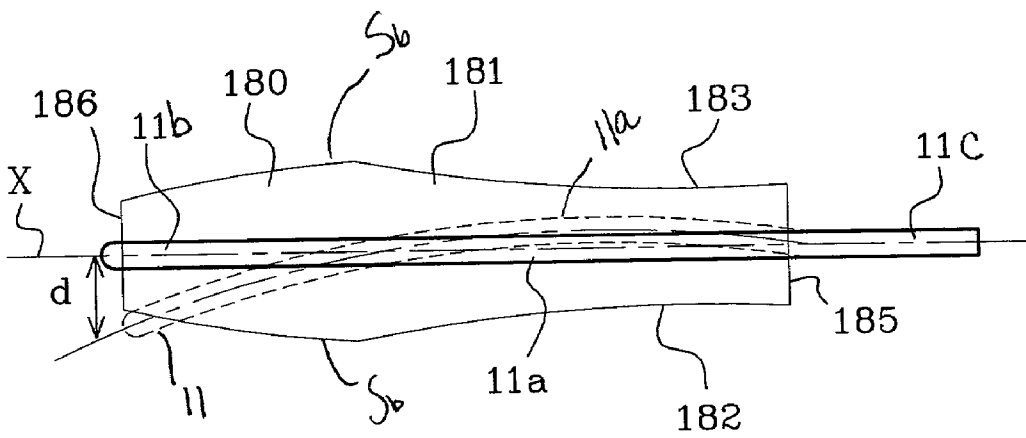


Fig. 32



**Fig. 33**



**Fig. 34**

### BRUSH FOR APPLYING PRODUCT TO KERATINOUS FIBERS

[0001] The present invention relates to an applicator for applying a product, such as a cosmetic or a care product, for example, to keratinous fibers. In particular, the invention relates to an applicator for applying mascara to the eyelashes. The invention also relates to a device including such an applicator.

[0002] Numerous applicator brushes are known that are formed by helically twisting two branches of a metal wire so as to hold bristles extending radially from the twisted wire. The branches may be fixed in a stem made of plastic material, for example, and secured to a cap for closing a container containing the product to be applied with the brush. The free ends of the bristles may define an envelope surface, which may define numerous of shapes.

[0003] It may be desirable to further improve existing brushes and to improve the quality of the makeup obtained therewith, for example, in terms of product takeup, and/or eyelash elongation, and/or eyelash curling, and/or penetration of bristles, for example, between the eyelashes, and/or separation of the eyelashes.

[0004] It should be understood that the invention could be practiced without performing one or more of the aspects described herein. Certain aspects will become apparent from the detailed description which follows. As embodied and broadly described herein, the invention includes a device for applying a product to keratinous fibers comprising a stem having two opposite ends and a brush portion connected to one end portion of the stem. The one end portion of the stem may have a longitudinal axis and the brush portion may have a free end that is not aligned with the longitudinal axis of the one end portion of the stem. The brush portion comprises a core and at least part of the core may be curved such that a line tangent to the core at any axial position along the core is not perpendicular to the longitudinal axis of the one end portion of the stem. The brush portion may further comprise bristles connected to the core. The bristles may comprise ends defining an envelope surface having a varying cross-section along at least a part of its length. The envelope surface may be asymmetrical about a midplane of the envelope surface, and the midplane may be oriented perpendicular to the core.

[0005] As used herein, the term "cross-section" relates to a cross-section taken in a plane perpendicular to the axis of the core. The term "envelope surface" as used herein refers to an imaginary surface defined by ends of at least some of the bristles extending from the core of the applicator brush portion or blank. For example, the envelope surface could be considered to be the three dimensional image seemingly formed by the bristle ends when the applicator/blank is viewed by an observer. When there are a mixture of shorter bristles and longer bristles extending in substantially the same direction at substantially the same axial position on the core, the ends of the longer bristles may define the envelope surface, while the ends of the shorter bristles may be beneath that surface.

[0006] The brush portion may be formed from a blank comprising a blank core and blank bristles having ends defining a blank envelope surface. The blank envelope surface may be asymmetrical about a midplane of the blank envelope surface oriented perpendicular to the blank core.

[0007] As used herein, the term "blank" refers to a partially-manufactured applicator or a partially manufactured part of an applicator, such as the brush portion, for example, that may be subjected to one or more additional manufacturing steps before becoming a completed applicator. For example, the term "blank" may be used herein to refer to an applicator that has a core that has not yet been curved.

[0008] An edge portion may partially define the blank envelope surface and may be nonrectilinear when observed in profile in a direction perpendicular to the blank core. The edge portion may become at least partially straightened by curving at least the part of the blank core.

[0009] The envelope surface may have at least one extreme cross-section chosen from a maximum cross-section and a minimum cross-section located axially between axial ends of the envelope surface. The brush portion may have a maximum cross-section located axially between axial ends of the envelope surface. The envelope surface may have a minimum cross-section located axially between axial ends of the envelope surface. As an alternative, the brush portion may have a maximum cross-section and a minimum cross-section located axially between axial ends of the envelope surface.

[0010] According to an exemplary embodiment, the nonrectilinear edge portion may be located in one of a first third and a last third of the length of the blank envelope surface. The nonrectilinear edge portion may be outwardly concave.

[0011] According to another exemplary embodiment, the nonrectilinear edge portion may be located in the last third of the length of the blank envelope surface, as measured in a direction facing away from a free end of the blank.

[0012] The nonrectilinear edge portion may be outwardly convex. The nonrectilinear edge portion may be located in the first third of the length of the blank envelope surface, as measured in a direction facing away from a free end of the blank.

[0013] In yet another exemplary embodiment, the nonrectilinear edge portion may be defined at least in part by a substantially bullet-shaped part of the blank envelope surface. The bullet-shaped part may comprise a free end of the blank, and a cross-section of a remainder of the blank envelope surface may taper over at least a part of the length of the blank envelope surface in a direction from the bullet-shaped part toward an end of the blank opposite the free end of the blank.

[0014] The nonrectilinear edge portion further may be defined by an intersection of a frustoconical-shaped zone of the blank and a frustoconical-shaped body portion of the blank, with the frustoconical-shaped zone being proximate a free end of the blank and converging toward the free end of the blank, and the frustoconical-shaped body portion extending from the intersection and converging toward an end of the blank opposite the free end of the blank.

[0015] The blank envelope surface may have a fish-like shape, and the nonrectilinear edge portion may be defined by a zone proximate a junction between an end portion of the blank envelope surface opposite a free end of the blank and a remainder of the blank envelope surface. The end portion may form a tail of the fish-like shape.

[0016] The blank envelope surface may have an hourglass-like shape, and the nonrectilinear edge portion may be defined by a reentrant angle at a junction between two truncated cone shapes forming the hourglass-like shape.

[0017] According to yet another exemplary embodiment, the blank envelope surface may define a football-like shape having at least one cut-out. The nonrectilinear edge portion may be one of defined by the cut-out and lie in a vicinity of an end of the cut-out. The cut-out may be chosen from a notch and a facet.

[0018] In yet another exemplary embodiment, the nonrectilinear edge portion may be deformed by curving at least part of the blank core so as to cause at least part of the nonrectilinear edge portion to lie substantially on an axis of an edge of a remainder of the blank envelope surface adjacent the nonrectilinear edge portion.

[0019] The brush portion may be formed from a blank comprising a blank core and blank bristles comprising ends defining a blank envelope surface and the blank envelope surface may be substantially circularly symmetrical.

[0020] As used herein, the term “circularly symmetrical” refers to a configuration having a circular shaped cross-section, wherein the axis of the core passes through the center of the circular shaped cross-section.

[0021] In an exemplary embodiment, the brush portion may be formed from a blank comprising a blank core and blank bristles comprising ends defining a blank envelope surface. The blank envelope surface may be substantially axially symmetrical about a longitudinal axis of the core.

[0022] The brush portion may be formed from a blank having a blank core curved about at least one axis disposed outside the midplane of the blank.

[0023] In an exemplary embodiment, the core may comprise a twisted wire core. The twisted wire core may have a left-hand pitch or a right-hand pitch. The bristles may be held between wires of the twisted wire core. In yet another exemplary embodiment, the twisted wire core may have a left-hand pitch and at least part of the core may be curved so as to decrease an inclination of helical turns formed by free ends of the bristles relative to the longitudinal axis of the end portion of the stem in a direction facing away from the stem. This may make it possible to improve the separation of eyelashes at the ends of an eyelid, by increasing the angle between the eyelashes and said sheets.

[0024] According to another exemplary embodiment, the bristles comprise bristles of differing lengths. The bristles may comprise longer bristles defining the envelope surface of the brush portion and shorter bristles contained within a space defined by the envelope surface.

[0025] Yet another exemplary embodiment includes a brush portion formed from a blank comprising a blank core and blank bristles having ends defining a blank envelope surface. The blank envelope surface may have at least one substantially planar facet formed thereon. The at least one substantially planar facet may comprise three substantially planar facets and the blank envelope surface may have a cross-section that is substantially triangular in shape, at least over a fraction of its length.

[0026] The core may be curved about at least two axes that are not mutually parallel.

[0027] The brush portion may have a stepped cross-section over at least part of its length.

[0028] The core may have a nonuniform curvature. For example, the core may comprise a curved portion and a rectilinear portion, the rectilinear portion being attached to the stem.

[0029] According to an exemplary embodiment, the device may further comprise a container configured to contain the product to be applied to the keratinous fibers. The device also may comprise a wiper configured to wipe excess product from the brush portion. Further, the device may comprise a handle member attached to an end of the stem opposite the end to which the brush portion is connected.

[0030] In yet another aspect, the device may further comprise the product and the container may contain the product. The product may comprise a mascara product. The brush portion may be configured to apply product to eyelashes.

[0031] In an exemplary embodiment, the cross-section of the envelope surface may vary in a nonmonotonic manner.

[0032] As used herein, the expression “the cross-section of the brush varies in a nonmonotonic manner” means that the cross-section of the brush is not constant over the whole length of the brush and does not vary in a strictly increasing or decreasing manner from one end of the brush to the other. For example, the cross-section may vary in a nonmonotonic manner because of the shape of a blank from which the brush is made, such a blank having, for example, a maximum and/or minimum cross-section spaced from each end of the brush, or because of the presence of one or more facets or notches formed in an outer envelope surface of the brush, for example.

[0033] An entire length of the core of the brush portion to which the bristles are connected may be curved.

[0034] In yet another aspect, the invention may include a method of making an applicator for applying a product to keratinous fibers comprising providing a blank comprising a blank core and bristles connected to the blank core. The bristles may comprise ends defining a blank envelope surface having a varying cross-section over at least a part of its length and being asymmetrical about a midplane of the blank envelope surface. The midplane may be perpendicular to the blank core. The method may further comprise curving at least a part of the blank core so as to form a brush portion comprising a core and a free end not aligned with a longitudinal axis of an end portion of a stem to which the brush portion is adapted to be connected. A line tangent to the core at any axial position along the core may be nonperpendicular to the longitudinal axis of the end portion of the stem when the brush portion is connected to the end portion of the stem.

[0035] The term “providing” is used broadly, and refers to, but is not limited to, making available for use, giving, supplying, obtaining, getting a hold of, acquiring, purchasing, selling, distributing, possessing, making ready for use, and/or placing in a position ready for use.

[0036] The method may further comprise shaving free ends of at least some bristles to form the variable cross-section of the blank envelope surface. The bristles may be configured to apply a product to eyelashes.

[0037] The curving of the blank core may comprise curving the blank core in such a manner so as to reduce a curvature of the nonrectilinear edge portion.

[0038] The blank envelope surface may have a substantially bullet-like shape, a substantially buoy-like shape, a substantially fish-like shape, a substantially hourglass-like shape, or a substantially football-like shape.

[0039] The blank may comprise at least one facet on the blank envelope surface and the method may further comprise forming the at least one facet prior to curving the blank core.

[0040] According to an exemplary embodiment, the curving of the blank core may comprise curving the blank core about two axes that are not mutually parallel. Under such circumstances, the axis of the core may no longer entirely be contained in a single plane of curvature. The axes about which the core is curved may extend in directions that are optionally perpendicular, and that optionally intersect.

[0041] As used herein, the term “plane of curvature” means a plane that is perpendicular to an axis about which the core of a blank/brush portion is curved and that contains at least the curved portion of the axis of the core. When a core is curved about two or more axes not parallel to one another, the core will have multiple planes of curvature.

[0042] The blank core may be rectilinear.

[0043] The curving of at least the part of the blank core may comprise curving an entire length of the blank core to which the bristles are connected.

[0044] In an exemplary embodiment, the brush may be made from a blank having a rectilinear core, that is not symmetrical about a midplane perpendicular to the core, and has an edge that is not rectilinear when observed in profile in a direction perpendicular to the core, said edge being straightened out at least in part by the curvature imparted to the core during manufacture of the brush.

[0045] It also may be possible, for example, to provide the core with maximum curvature in a narrower portion of the blank envelope surface when the blank envelope surface is substantially fish-shaped or hourglass-shaped. This may raise the proximal end portion of the blank envelope surface and may have the effect of further deepening the upwardly concave top edge of the blank while flattening out its downwardly concave and diametrically opposite bottom edge.

[0046] In general, the curvature given to the core may have the effect of moving the convex or concave face of the blank envelope surface, e.g., so as to make it substantially rectilinear, and in particular substantially parallel to the axis of the stem. When the curvature given to the core has the effect of straightening a concave or convex face so as to make it substantially rectilinear, this curving can be performed about an axis contained in a midplane for said face.

[0047] A brush of the type described above may make it possible to obtain makeup of very satisfactory quality because the core is curved and because, when observed from the side in a direction perpendicular to the axis of the stem, it presents a profile that varies on the brush being turned about the axis of the stem.

[0048] For example, the brush may make it possible to take charge of the eyelashes better and it also may enable nonuniform wiping to be obtained, thereby leading to different zones of the brush taking up different amounts of product.

[0049] Thus, the user may have both a larger quantity of product available so as to be able to apply product locally to the eyelashes if that should turn out to be desirable during making up the lashes. At the same time, the user may not have to dip the brush back in the container to reload it with product. Further, bristles that carry relatively little product may be used for separating the eyelashes, in particular the small eyelashes at the end of an eyelid.

[0050] One exemplary methodology for determining whether a brush portion of the invention has been formed from one of the blanks described above may involve straightening the curved part of the brush portion core so as to place it in a rectilinear configuration and then observing the resulting configuration of the envelope surface as well as the asymmetry about a midplane of the envelope surface oriented perpendicularly to the now rectilinear core. This methodology may provide one exemplary way in which to determine the configuration of the blank that was used to form the brush portion of the final applicator.

[0051] The term “curved” as used herein should be understood as “nonrectilinear” and includes both a curved line or a line that is bent at an angle.

[0052] “Nonuniform curvature” of the core as used herein means that there may be at least two different points along the core where the radius of curvature (which can be infinite) differs. The core having a nonuniform curvature may have greater curvature closer to its free end than to the end attached to the stem, for example. Alternatively, it can include a rectilinear or substantially rectilinear portion together with a curved portion, which is the case in particular when the core of the brush portion has a rectilinear part fixed to the end portion of the stem and when the bristles are supported by a curved part, the curvature of the curved part itself being either uniform or nonuniform.

[0053] The cross-section of the envelope surface of the blank may be of a shape that varies in geometrically similar manner over at least a fraction of the length of the envelope surface, for example, over more than one-third of its length. In other words, if two differently sized cross-sections of the envelope surface taken at two different locations along the length thereof are geometrically similar, then one of those sections is a scale magnification or scale demagnification of the other cross-section (e.g., the cross-sections may be shaped analogous to homothetic figures).

[0054] The core can be a twisted core having a left-hand or a right-hand pitch, and in particular a left-hand pitch as described in French patent application FR-A-2 701 198.

[0055] In a left-hand pitch brush, the strands of the core are twisted by being turned to the left so as to form turns which, when viewed along the axis of the core from the end which is fixed to the stem, turn clockwise on going away from the stem towards the free end of the brush. In a right-hand pitch brush, the strands of the core are twisted in an opposite manner.

[0056] It is also possible to act on the curvature imparted to the core, when the core has a right-hand pitch, so as to orient the bristles in a desired direction.

[0057] The core can be made other than by twisting together two strands of a metal wire, for example the bristles could be implanted or molded on a support in the form of a core-like structure.

[0058] The bristles may be natural or synthetic, and their ends can be subjected to any known type of treatment, for example to give them rounded tips or forked ends. The brush can have a mixture of bristles. For example, the bristles used can be of any kind, in particular they can be hollow, they can have capillary grooves, they can be flat or corkscrew-shaped, or indeed each of them can have a zone for preferential deformation.

[0059] Besides the structural and procedural arrangements set forth above, the invention could include a number of other arrangements, such as those explained hereinafter. It is to be understood that both the foregoing description and the following description are exemplary. The accompanying drawings are included to provide a further understanding of the invention and are incorporated in and constitute a part of this specification. The drawings illustrate exemplary embodiments of the invention and, together with the description, serve to explain certain principles. In the drawings,

[0060] FIG. 1 is a side view of an exemplary embodiment of a blank used for making an applicator according to an aspect of the invention;

[0061] FIG. 2 is a side view of another exemplary embodiment of a blank used for making an applicator according to an aspect of the invention;

[0062] FIG. 3 is a side view of another exemplary embodiment of a blank used for making an applicator according to an aspect of the invention;

[0063] FIG. 4 is a side view of another exemplary embodiment of a blank used for making an applicator according to an aspect of the invention;

[0064] FIG. 5 is a side view of an applicator formed from the blank of FIG. 1;

[0065] FIG. 6 is a side view of an exemplary embodiment of an applicator formed from the blank of FIG. 2.;

[0066] FIG. 7 is a side view of an exemplary embodiment of an applicator formed from the blank of FIG. 3;

[0067] FIG. 8 is a side view of an exemplary embodiment of an applicator formed from the blank of FIG. 4

[0068] FIG. 9 is a side view of a blank like that of FIG. 1, with facets formed on sides of the brush portion;

[0069] FIG. 10 is a cross-sectional view taken along line X-X of FIG. 9;

[0070] FIG. 10A is a cross-sectional view similar to FIG. 10 showing a variant embodiment of the blank of FIG. 9 with notches;

[0071] FIG. 11 is a side view of a blank like that of FIG. 2, with facets formed on its sides;

[0072] FIG. 12 is a cross-section taken along line XII-XII of FIG. 11;

[0073] FIG. 13 is a side view of a blank like that of FIG. 3, with facets formed on its sides;

[0074] FIG. 14 is a cross-section taken along line XIV-XIV of FIG. 13;

[0075] FIG. 15 is a side view of a blank like that of FIG. 4, with facets formed on its sides;

[0076] FIG. 16 is a cross-section taken along line XVI-XVI of FIG. 15;

[0077] FIG. 17 is a side view of an applicator embodiment formed from the blank of FIG. 9 after the blank core has been curved;

[0078] FIG. 18 is a side view of an applicator embodiment formed from the blank of FIG. 11 after the blank core has been curved;

[0079] FIG. 19 is a side view of an applicator embodiment formed from the blank of FIG. 13 after the blank core has been curved;

[0080] FIG. 20 is a side view of an applicator embodiment formed from the blank of FIG. 15 after the blank core has been curved;

[0081] FIG. 21 is a side view of the brush of an applicator embodiment formed by curving the core of the applicator of FIG. 8 a second time;

[0082] FIG. 22 is a cross-sectional view of a system embodiment including a container and an applicator according to an aspect of the invention;

[0083] FIG. 23 is a schematic view of the brush of FIG. 6 being used for applying product to the eyelashes;

[0084] FIG. 24 shows the various angles between a helical sheet, an eyelash, and the axis of the core during application of product to the eyelashes using an exemplary embodiment of an applicator;

[0085] FIG. 25 is a view analogous to FIG. 24, showing a partial view of an exemplary embodiment of a core with a right-hand twist;

[0086] FIG. 26 is a cross-sectional view of an exemplary embodiment of a brush portion having an envelope surface with steps;

[0087] FIG. 27 is a side view of an exemplary embodiment of a blank envelope surface that is generally hourglass-shaped;

[0088] FIG. 28 is a side view of an exemplary embodiment of a blank that is generally football-shaped, including a notch;

[0089] FIG. 29 is a side view of an outline of the applicator of FIG. 6 in use for making up the eyelashes;

[0090] FIG. 30 is a side view of an outline of the applicator of FIG. 6 in use for making up the eyelashes;

[0091] FIG. 31 is a partial side view of an exemplary embodiment of an applicator having an angled bend made in the core close to the end portion of the stem;

[0092] FIG. 32 is a partial view of the core of FIG. 33 showing the angle between the direction of the core and the axis of the stem;

[0093] FIG. 33 is a side view of an exemplary embodiment of a blank shown in solid lines and the curvature

imparted to the core shown in dotted lines to form an applicator embodiment according to an aspect of the invention; and

[0094] FIG. 34 is a side view of another exemplary embodiment of a blank shown in solid lines and the curvature imparted to the core shown in dotted lines to form an applicator embodiment according to an aspect of the invention.

[0095] Reference will now be made in detail to exemplary embodiments of the invention, examples of which are illustrated in the accompanying drawings. Wherever possible, the same reference numbers are used in the drawings and the description to refer to the same or like parts, and the same reference numbers with alphabetical suffixes are used to refer to similar parts.

[0096] FIG. 5 shows an exemplary embodiment of an applicator 10. The applicator 10 may comprise a core 11, which may be made by twisting together two strands of metal wire, for example. Bristles (not shown) may be held in conventional manner between the turns of the core 11 so as to form a brush portion of the applicator. For the sake of clarity, FIG. 5 shows only the envelope surface S defined by the free ends of the longest bristles held by core 11.

[0097] The core 11 may be fixed at one end to a stem 13 having a longitudinal axis Y. By way of example, the stem 13 may be made of plastic and the core 11 may be inserted as a force-fit into a housing situated at an end portion of the stem 13.

[0098] To make the applicator 10, the starting structure may be in the form of a blank, as shown in FIG. 1. In the exemplary embodiment of FIG. 1, the blank comprises a blank core 11b and blank bristles connected to the blank core 11b. Rather than illustrating these blank bristles individually, the blank envelope surface S<sub>b</sub> defined by the free ends of the longest blank bristles is shown. In FIG. 1, this envelope surface S<sub>b</sub> is substantially bullet-shaped.

[0099] The blank of FIG. 1 also may be substantially circularly symmetrical about the axis X of the blank core 11b. Further, the blank core 11b may be rectilinear, and the blank envelope surface S<sub>b</sub> may be asymmetrical about a midplane P of the blank envelope surface S<sub>b</sub> perpendicularly intersecting the blank core 11b.

[0100] The blank envelope surface S<sub>b</sub>, as shown in FIG. 1, may have a maximum traverse cross-section defined by a maximum diameter circle 14.

[0101] The free end portion (i.e., distal end portion) 15 of the blank envelope surface S<sub>b</sub> may be bullet-shaped and the remaining body portion 16 of the blank envelope surface S<sub>b</sub> may be frustoconical, with the diameter of the body portion 16 tapering in a direction facing away from the free end portion 15 (i.e., toward the stem 13 as shown in FIG. 1) so as to reach a minimum diameter at an end circle 17 of the blank envelope surface S<sub>b</sub>.

[0102] In the plane of FIG. 1, the top edge of the blank envelope surface S<sub>b</sub> may comprise a rectilinear first portion 18a extending along the body portion 16 between the circles 14 and 17. The top edge may further comprise a rounded second portion 18b defining the top of the free end portion 15 which may be substantially in the form of one-fourth of an ellipse, as in the exemplary embodiment shown. The

regions of the edge portions 18a and 18b in the vicinity of the circle 14 may constitute a non-rectilinear edge 18c.

[0103] To make the applicator 10, the blank core 11b carrying the bristles may be subjected to curving about an axis perpendicular to the plane of FIG. 1, so as to straighten out the edges of free end portion 15 of the blank envelope surface S<sub>b</sub>, thereby tending to flatten the edge 18c. By curving the blank core 11b in this manner, the edge 18c may become substantially rectilinear and in line with the portion 18a, as can be seen in FIG. 5, for example.

[0104] The brush portion of the applicator 10 may then not be circularly symmetrical about the axis Y of the stem 13.

[0105] The ends of the bristles of the brush portion situated beside the edge 18c may be further off-center from the axis Y of the stem 13 as compared to the ends of the bristles on the diametrically opposite side. Thus, after the brush portion of the applicator 10 has been withdrawn from a container containing product and wiped, it may be loaded with a larger quantity of product on its edge 18d situated substantially on the axis Y of the stem 13, while being wiped more thoroughly and thereby loaded with less product on its edge 18c. This may facilitate product application since a user may be able to apply more product locally to the eyelashes where necessary by taking that product from the region of the brush portion that is wiped less thoroughly. The user also may be able to separate the eyelashes by using the bristles that carry less product.

[0106] The angle  $\alpha$  between a line tangent to the core 11 at any axial position of the core 11 and the axis Y of the stem may be less than 90°, as shown in FIG. 32. In other words, a line tangent to the core 11 at any axial position of the core and the axis Y of the stem may intersect so as not to be perpendicular to one another.

[0107] The core 11 may carry bristles only in a fraction of its length or along its entire length up to the stem 13. Thus, the core 11b may comprise, as shown in FIG. 1, a portion 11a that supports the bristles and that is separated from the stem by a rectilinear portion 11c without any bristles. The portion 11c may be inserted at least in part in the stem 13. Thus, the core 11b may have a nonuniform curvature. Moreover, the curved portion 11a may have a uniform curvature or a nonuniform curvature.

[0108] FIG. 6 shows an exemplary embodiment of an applicator 20 which is obtained from the blank of FIG. 2. The blank of FIG. 2 may have a blank envelope surface S<sub>b</sub> that is substantially buoy-shaped.

[0109] The blank envelope surface S<sub>b</sub> may be substantially circularly symmetrical about the axis X of the rectilinear core 11b and the envelope surface S<sub>b</sub> may comprise the combination of two truncated cones joined via their largest faces. The junction of those two faces constituting a maximum diameter circle 13.

[0110] The top edge of the FIG. 2 blank envelope surface S<sub>b</sub> may be defined by generator lines 22a and 22b of the truncated cones, and the region in the vicinity of the maximum diameter circle 13 may define a nonrectilinear edge 22c. The blank envelope surface S<sub>b</sub> of FIG. 2 also may be asymmetrical about a midplane P perpendicularly intersecting the blank core 11b.

[0111] To make the applicator **20** of **FIG. 6** from the blank of **FIG. 2**, the blank core **11b** may be curved in such a manner as to bring the portions **22a** and **22b** substantially into alignment with each other, thereby also having the effect of increasing the curvature of the diametrically opposite bottom edge, as shown in **FIG. 6**.

[0112] The core **11b** may be curved, for example, with a substantially constant curvature radius on the portion **11a** about an axis substantially perpendicular to the plane of **FIG. 2** and situated beside the top edge of the blank. The core **11** of the applicator **20** of **FIG. 5** presents, in its total length, a nonconstant curvature, the portion **11c** being rectilinear.

[0113] It can be seen in **FIG. 6** that the edge **22c** may become substantially rectilinear by curving the portion **11a** of the blank core **11b**.

[0114] **FIG. 7** shows another exemplary embodiment of an applicator **30** made from the blank of **FIG. 3** having a fish-shaped blank envelope surface  $S_b$ .

[0115] The blank envelope surface  $S_b$  may be circularly symmetrical about the axis  $X$  of the rectilinear blank core **11b**, and asymmetrical about a midplane  $P$  of the blank envelope surface  $S_b$  perpendicularly intersecting the blank core **11**.

[0116] The blank envelope surface  $S_b$  of **FIG. 3** comprises a body portion **32** having a maximum cross-section at a maximum diameter circle **31**. The free end portion **33** of the blank envelope surface  $S_b$  that extends in front of the maximum diameter circle **31** may be substantially bullet-shaped. The proximal end portion **34** of the blank envelope surface  $S_b$  may be connected to the body portion **32** via a narrowed portion **36**.

[0117] The bottom edge **37** of the blank defined by the narrowed brush portion **36** may form a downwardly concave indentation.

[0118] To make the applicator **30**, the blank core **11b** of **FIG. 3** may be curved to a certain degree so as to flatten its bottom edge **37** and make it less indented, or even rectilinear as in the example shown in **FIG. 7**. The diametrically opposite top edge **38** of the narrowed brush portion **36** may in turn take on greater curvature because of the way the blank core **11b** is curved.

[0119] The portion **32a** of the bottom edge of the body portion **32** that is adjacent to the narrow portion **36** of the blank envelope surface  $S_b$  also may become straightened because of the curvature given to the blank core **11b**.

[0120] **FIG. 8** shows yet another exemplary embodiment of an applicator **40** obtained from the blank shown in **FIG. 4**. This blank envelope surface  $S_b$  may be substantially fish-shaped and may be substantially circularly symmetrical about the axis  $X$  of the rectilinear blank core **11b**.

[0121] The free end portion **41** of the blank envelope surface  $S_b$  may be frustoconical in shape. The body portion **42** of the blank envelope surface  $S_b$  may be frustoconical in its region adjacent to the maximum diameter circle **43**.

[0122] The body portion **42** may connect to the proximal end portion **44** of the blank envelope surface  $S_b$  via a

narrowed portion **45**. The bottom edge **46** of the narrowed portion **45** of the blank envelope surface  $S_b$  may be downwardly concave.

[0123] The **FIG. 4** blank may be converted into the applicator **40** by imparting a certain amount of curvature to the blank core **11b** so as to flatten the bottom edge **46** and cause it to be substantially less indented than it was initially, if not substantially rectilinear and in line with the generator line **42a** of the body portion **42**.

[0124] The effect of the curvature given to the blank core **11b** may be to cause the top edge **47** of the narrowed portion **45** where it is diametrically opposite to the bottom edge **46** to be indented even further.

[0125] Each of the blanks shown in **FIGS. 1 to 4** may have one or more facets or notches formed in the envelope surfaces prior to curving the core.

[0126] By way of example, **FIG. 9** shows a blank like the blank of **FIG. 1** with an envelope surface  $S_b$  having three substantially plane facets **19**. This may provide the cross-section of the body portion of the blank envelope surface  $S_b$  with a shape that is generally triangular, as shown in **FIG. 10**.

[0127] In the exemplary embodiment of **FIG. 9**, the facets **19** are substantially plane, and parallel to the axis  $X$  of the core.

[0128] In a variant, the facets of **FIG. 9** could be replaced by notches **19'** of outwardly concave cross-section as shown in **FIG. 10A**, or by notches having a profile that is outwardly concave when the brush is observed in a direction perpendicular to the axis of the stem, the profile of the notch being in the form of a circular arc, for example.

[0129] **FIG. 11** shows a blank like that of **FIG. 2**, with three substantially plane facets **29** formed on an outer surface of the brush portion. This provides the blank envelope surface  $S_b$  with a cross-section that is substantially triangular in shape at least over a part of its length.

[0130] **FIG. 13** shows a blank like that of **FIG. 3**, with three substantially plane facets **39** formed in the blank envelope surface  $S_b$ . This also may provide the blank envelope surface  $S_b$  a cross-section that is generally triangular in shape at least over a part of its length.

[0131] **FIG. 15** shows a blank like that of **FIG. 4** on which three substantially plane facets **49** have been made. Whereas in the exemplary embodiment of **FIG. 13**, the facets **39** extend only over the main body portion of the blank envelope surface  $S_b$ , in the exemplary embodiment of **FIG. 15**, the facets **49** may extend over the entire length of the blank envelope surface  $S_b$ , including over its proximal end portion, as shown.

[0132] **FIGS. 17-20** show the various applicator brushes that may be obtained by subjecting the blanks of **FIGS. 9, 11, 13, and 15** respectively to the same transformation as was used to convert the blanks of **FIGS. 1 to 4** into the brushes of **FIGS. 5 to 8**. That is, by curving at least part of the blank core **11b** of each of the blanks in **FIGS. 9, 11, 13, and 15**.

[0133] In the exemplary embodiments of **FIGS. 17 to 20**, the plane of curvature of the core **11** may be substantially perpendicular to the respective facet **19, 29, 39, or 49** that is

situated diametrically opposite to the nonrectilinear edge that has been straightened out as a result of curving the blank core **11b**. The plane of curvature of the core **11** also may be a midplane of symmetry for one of the facets.

[0134] In one or more of the examples described above, the blank core **11b** may be curved about a single axis.

[0135] Without going beyond the ambit of the present invention, it also may be possible to curve the core about two or more axes, that are optionally parallel, that are optionally perpendicular, or that optionally intersect at any angle.

[0136] By way of example, **FIG. 21** shows a brush like that of **FIG. 8**, wherein the core **11** has been curved a second time about a bending axis **C** parallel to the plane of **FIG. 21**, i.e. parallel to the plane of curvature of the **FIG. 8** brush. Due to this additional curving, the core **11** may no longer lie in a single plane of curvature, which may improve the ergonomics of the brush.

[0137] **FIG. 22** shows an exemplary embodiment of an application system **100** that comprises an applicator in accordance with an exemplary embodiment of the invention. The stem **13** of the applicator may be fixed to a cap **101** which may serve both as a handling member and as a substantially leaktight (as to air and/or product) closure of a container **102**. The container **102** may contain the product for application, such as a mascara product for application to eyelashes, for example.

[0138] The system **100** has a container **102** optionally including a neck portion **103** with an external threading configured to cooperate with internal threading provided on the cap **101**. A wiper **104** of any conventional type may be situated near an opening in the container. The wiper **104** may be adapted to wipe the stem **13** and the brush portion of the applicator as the applicator is removed from the container **102**.

[0139] The brush can have at least one outer applicator surface that is substantially parallel to the stem **13**, for example.

[0140] It should be noted that it may be desirable to form the brushes described herein from a blank core having a left-hand pitch, as explained below with reference to **FIGS. 23 and 24**. **FIG. 23** shows the **FIG. 6** brush with a core formed of two branches twisted together with a left-hand pitch. Dashed lines show the paths followed by the sheets **N** defined by the ends of the bristles held between the twisted branches. As shown, these sheets **N** may be at an angle  $\nu$  relative to a plane perpendicular to the core **11**.

[0141] On examining **FIG. 23**, it can be seen that the angle of the sheets **N** relative to the axis **Y** of the stem **13** may decrease on approaching the free end of the brush portion, thereby making it possible to retain a relatively large angle  $i$  between the sheets **N** and the eyelashes **H** at the end of the eyelid. This may permit good separation of the eyelashes.

[0142] Naturally, the invention is not limited to a core with a left-hand pitch and it is also possible to use a core with a right-hand pitch, as shown in part in **FIG. 25**.

[0143] In another exemplary embodiment, steps may be made in an envelope surface of the brush portion, as shown in **FIG. 26**. In this figure, it can be seen that the brush portion has been machined in such a manner as to form

setbacks **110** in its envelope surface over at least a fraction of its length. These setbacks may have flanks that are substantially radial, for example.

[0144] **FIG. 27** shows an exemplary embodiment of a blank **120** used to form a applicator brush according to an aspect of the invention. As shown, the blank envelope surface  $S_b$  may be substantially hourglass-shaped. The blank envelope surface  $S_b$ , when observed from the side, defines a nonrectilinear edge portion **121** that may be straightened by imparting curvature relatively locally to the blank core **11b**, for example in the vicinity of the smallest diameter of the blank envelope surface  $S_b$ .

[0145] **FIG. 28** shows another exemplary embodiment of a blank **130** having a blank envelope surface  $S_b$  that is substantially football-shaped with a notch-shaped **131** cut-out. This concave notch **131** may be made substantially plane by imparting curvature to the blank core **11b**.

[0146] **FIGS. 29 and 30** schematically illustrate how the **FIG. 6** applicator brush may be used for making up the eyelashes. One side of the brush portion can be used for making up eyelashes situated at one end of the eyelid, as shown in **FIG. 29**, while the opposite side of the brush can be used while making up the eyelashes situated at the opposite end of the eyelid, as shown in **FIG. 30**.

[0147] The core **11** of a brush as described above can have its curved part located very close to the stem **13**, as shown in **FIG. 31**, thus modifying the handling thereof, if desired.

[0148] **FIGS. 33 and 34** schematically illustrate two blanks for forming an applicator brush according to exemplary embodiments before a portion **11a** of the blank core **11b** has been curved and inserted in a stem. In both examples, the blank core **11b** is entirely rectilinear before it is fixed to the stem.

[0149] The core **11** of the brush portion can also be seen, in both **FIGS. 33 and 34**, in short dashes. In the example of **FIG. 33**, the blank envelope surface  $S_b$  is substantially bi-frustoconical about the axis **X** of the blank core **11b**. The total length of the portion **11a** that supports the bristles may be, for example, about 26 mm.

[0150] The greatest diameter of the blank may be slightly more than 7 mm, for example, and the end diameters may be about 4 mm, for example. The total length of the core **11** may be approximately 35 mm, for example.

[0151] The core **11** may be curved along the entire portion **11a**, and the portion **11c** may remain substantially rectilinear. The curvature radius of portion **11a** may be about 60 mm, for example. The portion **1a** of the core **11** may have either a uniform or nonuniform curvature.

[0152] The free end of the core **11** may be unaligned with the axis of the rectilinear part **11c** or with the axis of the stem (not shown) to which the brush is to be connected. The distance  $d$  between the free end before and after the core has been curved may be approximately 4.5 mm, for example.

[0153] **FIG. 34** shows another example of a blank before the blank core **11b** has been curved. The blank envelope surface  $S_b$  has a substantially fish-like shape, with a substantially frustoconical free end (distal end) portion **180** and a circularly-symmetrical portion **181** delimited in longitudinal cross-section by two concave circular longitudinal

sections **182** and **183**. The radius of curvature of these longitudinal sections **182** and **183** may be approximately 52 mm, for example. The diameter of the blank envelope surface  $S_b$  at its ends **185** and **186**, may be respectively about 7.5 mm and 5 mm.

[**0154**] The applicator may be made from the **FIG. 34** blank by curving the portion **11a** of the blank core **11b** supporting the bristles. As shown in **FIG. 34** by the dashed lines, the portion **11a** of the core **11** may have a substantially constant curvature radius over the entire length of the portion **11a**. There may be a small angle between the end of the portion **11a** adjacent to the portion **11c**.

[**0155**] The distance  $d$  between the end of the core before and after it has been curved may be about 2 mm to about 4 mm.

[**0156**] In the various figures, the curvature of the core has been exaggerated in order to facilitate understanding.

[**0157**] It would not go beyond the ambit of the present invention for the curvature to be less marked, for example for it to match that of an eyelid.

[**0158**] The core can also be curved into an S-shape in a single plane of curvature.

[**0159**] It will be understood that the invention may permit the making of a brush that is capable of being wiped in non-uniform manner, having a distal end portion that is off-center relative to the axis of the stem to which the brush portion is attached.

[**0160**] A brush of the invention may be particularly ergonomic.

[**0161**] The invention also may make it possible to obtain a brush presenting faces on its envelope surface of differing shapes, which in turn may permit a wide variety of application and/or make-up effects to be obtained with a single applicator.

[**0162**] The various embodiments described above with reference to the figures related to an applicator for applying a product to keratinous fibers, such as mascara to eyelashes for example. However, in its broadest aspects the present invention could be used for the application of many other types of products. Furthermore, sizes of various structural parts and materials used to make these parts are illustrative and exemplary only and one of ordinary skill in the art would recognize that these materials and sizes can be changed as necessary to produce different effects or desired characteristics of the dispensing assembly.

[**0163**] It will be apparent to those skilled in the art that various modifications and variations can be made to the structure and methodology. Thus, it should be understood that the invention is not limited to the examples discussed in the specification. Rather, the present invention is intended to cover modifications and variations.

What is claimed:

1. A device for applying a product to keratinous fibers, the device comprising:

a stem having two opposite ends; and

a brush portion connected to one end portion of the stem, the one end portion of the stem having a longitudinal

axis and the brush portion having a free end that is not aligned with the longitudinal axis of the one end portion of the stem,

wherein the brush portion comprises a core, at least part of the core being curved such that a line tangent to the core at any axial position along the core is not perpendicular to the longitudinal axis of the one end portion of the stem, and

wherein the brush portion further comprises bristles connected to the core, the bristles comprising ends defining an envelope surface having a varying cross-section along at least a part of its length, the envelope surface being asymmetrical about a midplane of the envelope surface, the midplane being oriented perpendicular to the core.

2. The device of claim 1, wherein the brush portion is formed from a blank comprising a blank core and blank bristles having ends defining a blank envelope surface, the blank envelope surface being asymmetrical about a midplane of the blank envelope surface oriented perpendicular to the blank core.

3. The device of claim 2, wherein an edge portion partially defining the blank envelope surface is nonrectilinear when observed in profile in a direction perpendicular to the blank core, and wherein said edge portion becomes at least partially straightened by curving at least the part of the blank core.

4. The device of claim 1, wherein the envelope surface has at least one extreme cross-section chosen from a maximum cross-section and a minimum cross-section located axially between axial ends of the envelope surface.

5. The device of claim 4, wherein the brush portion has a maximum cross-section located axially between axial ends of the envelope surface.

6. The device of claim 4, wherein the envelope surface has a minimum cross-section located axially between axial ends of the envelope surface.

7. The device of claim 4, wherein the brush portion has a maximum cross-section and a minimum cross-section located axially between axial ends of the envelope surface.

8. The device of claim 3, wherein the nonrectilinear edge portion is located in one of a first third and a last third of the length of the blank envelope surface.

9. The device of claim 3, wherein said nonrectilinear edge portion is outwardly concave.

10. The device of claim 9, wherein the non rectilinear edge portion is located in the last third of the length of the blank envelope surface, as measured in a direction facing away from a free end of the blank.

11. The device of claim 3, wherein the nonrectilinear edge portion is outwardly convex.

12. The device of claim 11, wherein the nonrectilinear edge portion is located in the first third of the length of the blank envelope surface, as measured in a direction facing away from a free end of the blank.

13. The device of claim 3, wherein the nonrectilinear edge portion is defined at least in part by a substantially bullet-shaped part of the blank envelope surface, the bullet-shaped part comprising a free end of the blank, and wherein a cross-section of a remainder of the blank envelope surface tapers over at least a part of the length of the blank envelope surface in a direction from the bullet-shaped part toward an end of the blank opposite the free end of the blank.

14. The device of claim 3, wherein the nonrectilinear edge portion is defined by an intersection of a frustoconical-shaped zone of the blank and a frustoconical-shaped body portion of the blank, the frustoconical-shaped zone being proximate a free end of the blank and converging toward the free end of the blank, and the frustoconical-shaped body portion extending from the intersection and converging toward an end of the blank opposite the free end of the blank.

15. The device of claim 3, wherein the blank envelope surface has a fish-like shape, and wherein the nonrectilinear edge portion is defined by a zone proximate a junction between an end portion of the blank envelope surface opposite a free end of the blank and a remainder of the blank envelope surface, the end portion forming a tail of the fish-like shape.

16. The device of claim 3, wherein the blank envelope surface has an hourglass-like shape, and wherein the nonrectilinear edge portion is defined by a reentrant angle at a junction between two truncated cone shapes forming the hourglass-like shape.

17. The device of claim 3, wherein the blank envelope surface defines a football-like shape having at least one cut-out, and wherein the nonrectilinear edge portion is one of defined by the cut-out and lies in a vicinity of an end of the cut-out.

18. The device of claim 17, wherein the cut-out is chosen from a notch and a facet.

19. The device of claim 17, wherein the nonrectilinear edge portion is deformed by curving at least the part of the blank core so as to cause at least part of the nonrectilinear edge portion to lie substantially on an axis of an edge of a remainder of the blank envelope surface adjacent the nonrectilinear edge portion.

20. The device of claim 1, wherein the brush portion is formed from a blank comprising a blank core and blank bristles having ends defining a blank envelope surface, the blank envelope surface being substantially circularly symmetrical.

21. The device of claim 1, wherein the brush portion is formed from a blank comprising a blank core and blank bristles having ends defining a blank envelope surface, the blank envelope surface being substantially axially symmetrical about a longitudinal axis of the core.

22. The device of claim 1, wherein the brush portion is formed from a blank having a blank core curved about at least one axis disposed outside the midplane of the blank.

23. The device of claim 1, wherein the core comprises a twisted wire core.

24. The device of claim 23, wherein the twisted wire core has a left-hand pitch.

25. The device of claim 23, wherein the bristles are held between wires of the twisted wire core.

26. The device of claim 25, wherein the twisted wire core has a left-hand pitch and wherein at least the part of the core is curved so as to decrease an inclination of helical turns formed by free ends of the bristles relative to the longitudinal axis of the end portion of the stem in a direction facing away from the stem.

27. The device of claim 1, wherein the bristles comprise bristles of differing lengths.

28. The device of claim 27, wherein the bristles comprise longer bristles defining the envelope surface of the brush portion and shorter bristles contained within a space defined by the envelope surface.

29. The device of claim 1, wherein the brush portion is formed from a blank comprising a blank core and blank bristles having ends defining a blank envelope surface, the blank envelope surface having at least one substantially planar facet formed thereon.

30. The device of claim 29, wherein the at least one substantially planar facet comprises three substantially planar facets and wherein the blank envelope surface has a cross-section that is substantially triangular in shape, at least over a fraction of its length.

31. The device of claim 1, wherein the core is curved about at least two axes that are not mutually parallel.

32. The device of claim 1, wherein the brush portion has a stepped cross-section over at least part of its length.

33. The device of claim 1, wherein the core has a non-uniform curvature.

34. The device of claim 33, wherein the core comprises a curved portion and a rectilinear portion, the rectilinear portion being attached to the stem.

35. The device of claim 1, further comprising a container configured to contain the product to be applied to the keratinous fibers.

36. The device of claim 35, further comprising a wiper configured to wipe excess product from the brush portion.

37. The device of claim 35, further comprising a handle member attached to an end of the stem opposite the end to which the brush portion is connected.

38. The device of claim 34, further comprising the product, wherein the container contains the product.

39. The device of claim 38, wherein the product comprises a mascara product.

40. The device of claim 1, wherein the brush portion is configured to apply product to eyelashes.

41. The device of claim 1, wherein the cross-section of the envelope surface varies in a nonmonotonic manner.

42. The device of claim 1, wherein an entire length of the core of the brush portion to which the bristles are connected is curved.

43. A method of making an applicator for applying a product to keratinous fibers, the method comprising:

providing a blank comprising a blank core and bristles connected to the blank core, the bristles comprising ends defining a blank envelope surface having a varying crosssection over at least a part of its length and being asymmetrical about a midplane of the blank envelope surface, the midplane being perpendicular to the blank core; and

curving at least a part of the blank core so as to form a brush portion comprising a core and a free end not aligned with a longitudinal axis of an end portion of a stem to which the brush portion is adapted to be connected,

wherein a line tangent to the core at any axial position along the core is not perpendicular to the longitudinal axis of the end portion of the stem when the brush portion is connected to the end portion of the stem.

44. The method of claim 43, wherein the cross-section of the blank envelope surface varies in a nonmonotonic manner.

45. The method of claim 43, wherein the blank core is a twisted wire core.

**46.** The method of claim 43, further comprising shaving free ends of at least some bristles to form the variable cross-section of the blank envelope surface.

**47.** The method of claim 43, wherein the bristles are configured to apply a product to eyelashes.

**48.** The method of claim 47, wherein the product comprises a mascara product.

**49.** The method of claim 43, wherein the blank envelope surface, when observed in profile from a direction substantially perpendicular to the blank core, has a nonrectilinear edge portion over at least a part of its length.

**50.** The method of claim 49, wherein the curving of the blank core comprises curving the blank core in such a manner so as to reduce a curvature of the nonrectilinear edge portion.

**51.** The method of claim 43, wherein the blank envelope surface is substantially circularly symmetrical.

**52.** The method of claim 43, wherein the blank envelope surface has a substantially bullet-like shape.

**53.** The method of claim 43, wherein the blank envelope surface has a substantially buoy-like shape.

**54.** The method of claim 43, wherein the blank envelope surface has a substantially fish-like shape.

**55.** The method of claim 43, wherein the blank envelope surface has a substantially hourglass-like shape.

**56.** The method of claim 43, wherein the blank envelope surface has a substantially football-like shape.

**57.** The method of claim 56, wherein the blank comprises at least one facet on the blank envelope surface.

**58.** The method of claim 57, further comprising forming the at least one facet prior to curving the blank core.

**59.** The method of claim 58, wherein the at least one facet comprises three facets.

**60.** The method of claim 43, wherein the curving of the blank core comprises curving the blank core about two axes that are not mutually parallel.

**61.** The method of claim 43, wherein the blank core comprises a twisted wire core with a left-hand pitch.

**62.** The method of claim 43, wherein the blank core is rectilinear.

**63.** The method of claim 43, wherein the curving of at least the part of the blank core comprises curving an entire length of the blank core to which the bristles are connected.

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