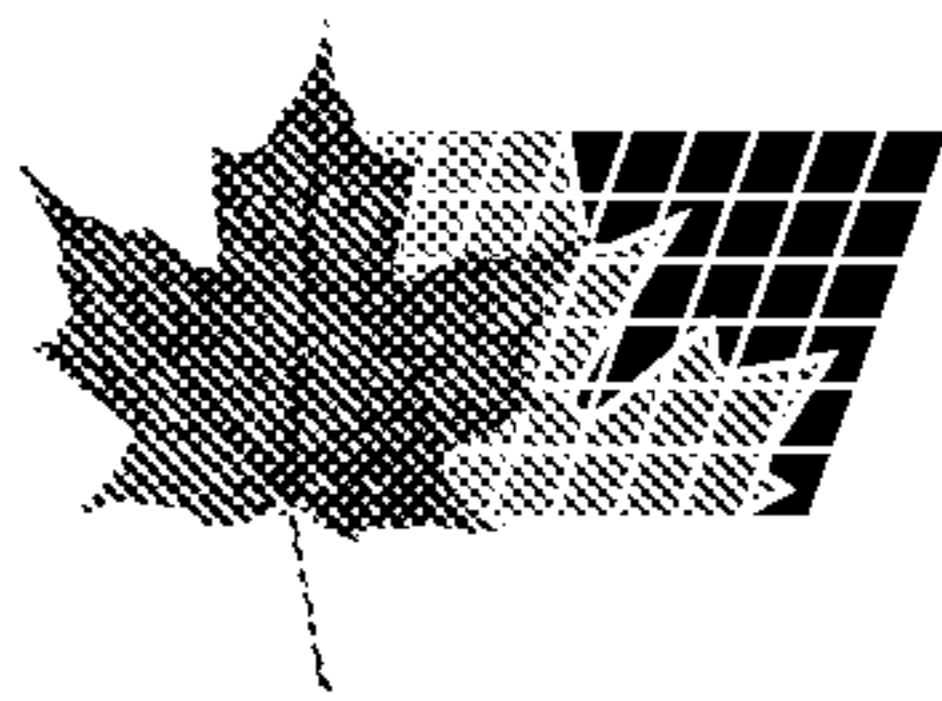
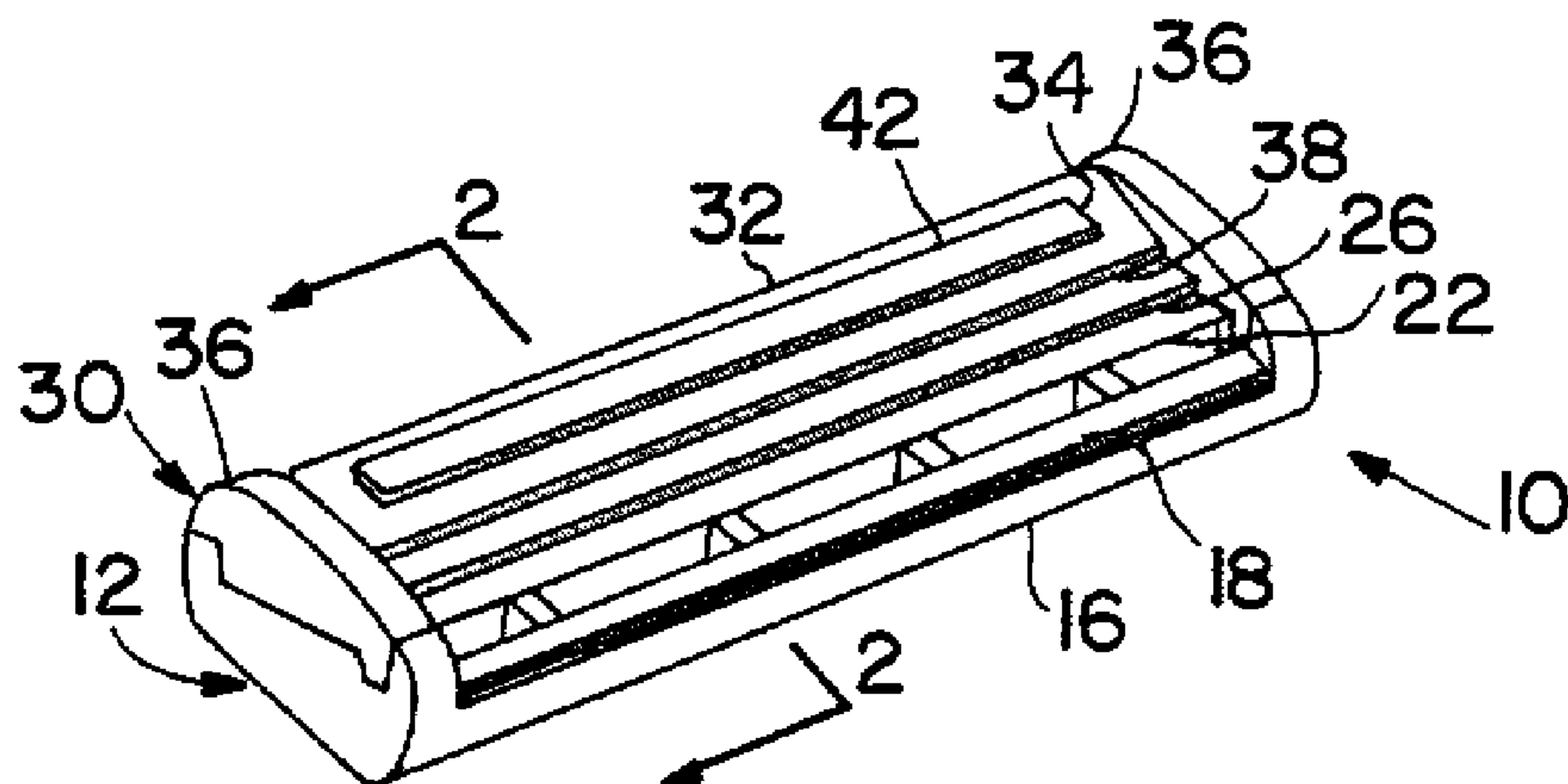




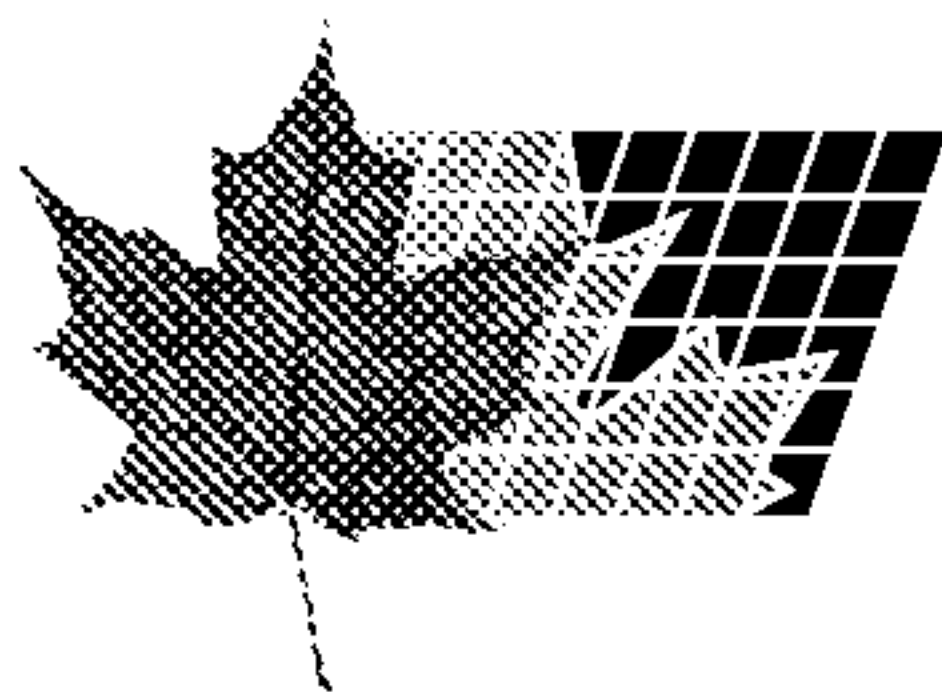
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(72) Tseng, Mingchih M., US
(73) THE GILLETTE COMPANY, US
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(30) 1995/06/20 (461,318) US
(54) **SYSTEME DE RASAGE**
(54) **SHAVING SYSTEM**



(57) Selon un aspect de l'invention, une unité de rasage (10) comprend au moins une lame (20, 24) et un élément (64), entrant en contact avec la peau, qui comporte une surface (74) destinée à entrer en contact avec la peau de l'utilisateur à proximité du tranchant de la lame. Cette unité de rasage peut être du type tête porte-lame jetable conçue pour s'adapter à un manche de rasoir et en être détachée, ou peut être solidaire d'un manche de sorte que le rasoir entier soit jeté lorsque la ou les lames sont émoussées. Le ou les tranchants de lame coopèrent avec

(57) In accordance with one aspect of the invention there is provided a shaving unit (10) that comprises at least one blade (20, 24) and a skin engaging member (64) that has a surface (74) for engaging the user's skin adjacent the blade edge. The shaving unit may be of a disposable cartridge type adapted for coupling to and uncoupling from a razor handle or may be integral with a handle so that the complete razor is discarded as a unit when the blade or blades become dulled. The blade edge (or edges) cooperate with skin engaging surfaces to define structure



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(45) 2000/12/12

les surfaces entrant en contact avec la peau afin de définir une structure présentant la géométrie requise. L'élément (64) entrant en contact avec la peau se présente sous la forme d'une enveloppe allongée (72) composée d'un mélange d'un matériau formant matrice, insoluble dans l'eau, et d'une quantité efficace d'une substance facilitant le rasage, ainsi que d'un matériau central rigide (70) s'étendant axialement à travers toute l'enveloppe (72). Le matériau central (70), dans sa position axiale, ne passe pas nécessairement par l'axe médian de l'enveloppe.

having a desired geometry. The skin engaging member (64) is comprised of an elongated sheath (72) made of a mixture of water insoluble matrix material and an effective amount of shaving aid material and rigid core (70) material extending axially throughout said sheath (72). The axial position of the core (70) need not be through the central axis.



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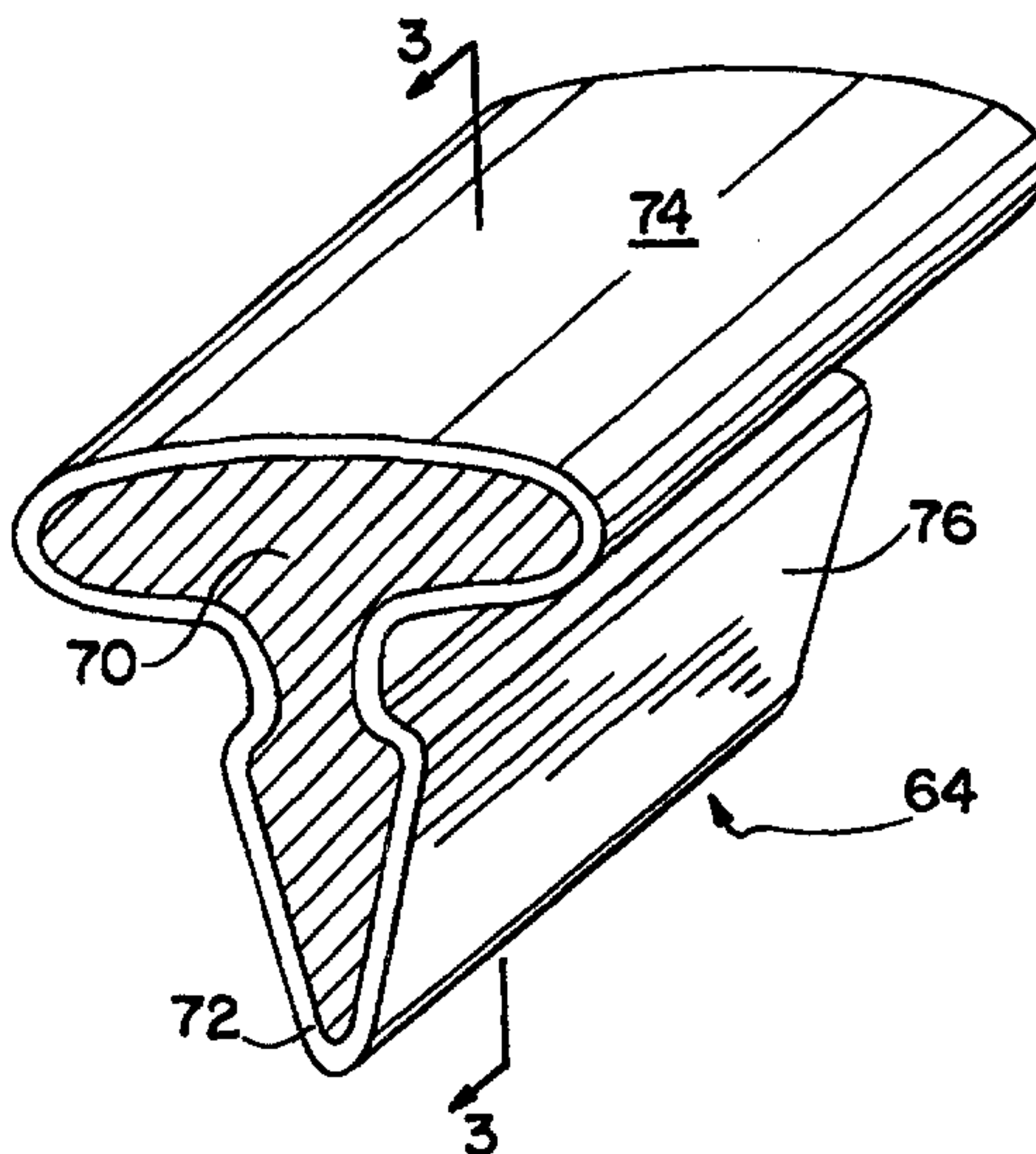
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(71) Applicant (for all designated States except US): THE GILLETTE COMPANY [US/US]; Prudential Tower Building, Boston, MA 02199 (US).			
(72) Inventor; and (75) Inventor/Applicant (for US only): TSENG, Mingchih, M. [US/US]; 4 Partridge Drive, Hingham, MA 02043 (US).			
(74) Agents: HANDELMAN, Joseph, H.; Ladas & Parry, 26 West 61st Street, New York, NY 10023 (US) et al.			

(54) Title: SHAVING SYSTEM

(57) Abstract

In accordance with one aspect of the invention there is provided a shaving unit (10) that comprises at least one blade (20, 24) and a skin engaging member (64) that has a surface (74) for engaging the user's skin adjacent the blade edge. The shaving unit may be of a disposable cartridge type adapted for coupling to and uncoupling from a razor handle or may be integral with a handle so that the complete razor is discarded as a unit when the blade or blades become dulled. The blade edge (or edges) cooperate with skin engaging surfaces to define structure having a desired geometry. The skin engaging member (64) is comprised of an elongated sheath (72) made of a mixture of water insoluble matrix material and an effective amount of shaving aid material and rigid core (70) material extending axially throughout said sheath (72). The axial position of the core (70) need not be through the central axis.



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SHAVING SYSTEM

This invention relates to an improved skin engaging member for use in razor blade cartridge assemblies and shaving systems of the wet shave type. The present invention resides broadly in providing the skin engaging cap and/or guard surfaces with configurations which reduce frictional drag of the razor across the skin. This invention also relates to a novel method of manufacturing the skin engaging member of the present invention.

In shaving systems of the wet shave type, factors such as the frictional drag of the razor across the skin, the force needed to sever hairs, and irritation of pre-existing skin damage can create a degree of shaving discomfort. Discomfort, and other problems accompanying wet shaving systems, can be alleviated by the application of shaving aids to the skin. Shaving aids may be applied prior to, during, or after shaving. A number of problems accompany the use of pre- and post-applied shaving aids. Pre-applied shaving aids can evaporate or can be carried away from the site of application by repeated strokes of the razor. Post-applied shaving aids are not present on the skin during shaving and thus their application

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may be too late to prevent an unwanted affect. Both pre-applied and post-applied shaving aids add additional steps to the shaving process.

Proposals have been made to

5 incorporate a shaving aid e.g., lubricant, whisker softener, razor cleanser, medicinal agent, cosmetic agent or combination thereof, into a razor, e.g., by depositing a shaving aid in a recess on the razor, by incorporating a

10 shaving aid directly into one or more molded polymeric components of the razor, by adhesively securing a shaving aid composite to the razor, and by use of a mechanical connection between a shaving aid composite and the razor. A water-

15 soluble shaving aid, e.g. polyethylene oxide, has been mixed with non-water-soluble material, e.g., a polystyrene polymer, to form an insoluble polymer/soluble shaving aid composite. The composite has been mounted on razor and

20 shaving cartridge structures, adjacent the shaving edge or edges, of single or multiple blade shaving system. Upon exposure to water, the water-soluble shaving aid leaches from the composite onto the skin.

25 Extruded composites with relatively large amounts of shaving aid (up to 80% by weight) and relatively low amounts of water insoluble matrix material (as little as 20% by weight) are relatively weak and have a tendency

30 towards mechanical failure, both in assembly and in use. Increase in mechanical strength can be obtained with increased amounts of the matrix material. However, such increase reduces the releasability of the shaving aid.

35 In accordance with one aspect of the invention, there is provided a shaving unit that

comprises at least one blade and a skin engaging member that has a surface for engaging the user's skin adjacent the blade edge. The shaving unit may be of a disposable cartridge type adapted for coupling to and uncoupling from a razor handle or may be integral with a handle so that the complete razor is discarded as a unit when the blade or blades become dulled. The blade edge (or edges) cooperate with skin engaging surfaces to define structure having a desired geometry. The skin engaging member comprises an outer layer and an inner layer which are disparately coloured, the outer layer comprising polyethylene oxide and a water insoluble matrix. The inner layer comprises a water insoluble polymer. The outer layer is adapted to erode at a skin engaging surface during use to expose the inner layer to provide a user with an indication that the shaving unit and/or skin engaging member have reached their effective life.

Fig. 1 is a perspective view of a razor unit in accordance with the invention;

Fig. 2 is a sectional view taken along the line 2-2 of Fig. 1;

Fig. 3 is a perspective view of another razor unit in accordance with the invention;

Fig. 4 is an enlarged perspective view of a skin engaging member of the present invention;

Fig. 5 is a sectional view taken along the line 5-5 of Fig. 4;

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FIG. 6-7 are sectional views in accordance with FIG. 5 wherein alternate core geometry's are depicted;

5 FIG. 8 is yet another cross-sectional depiction;

FIG. 9 is a schematic cross-section diagram of an extrusion die suitable for manufacturing the skin engaging member of FIG. 4.

10 The shaving unit 10 shown in FIGS. 1 and 2 includes base or platform member 12 molded of high impact polystyrene that includes integral coupling groove structure 14 for attachment to a razor handle and guard structure
15 16 that defines a transversely extending forward skin engaging surface 18. On the upper surface of platform 12 are disposed steel leading blade 20 having a sharpened edge 22, steel following blade 24 having sharpened edge 26, and aluminum
20 spacer member 28 that maintains blades 20 and 24 in spaced relation. Cap member 30 is molded of high impact polystyrene and has body portion 32 that defines skin engaging surface 34 that extends transversely between forwardly
25 projecting end walls 36 and has a front edge 38 that is disposed rearwardly of blade edge 26. Integral rivet portions 40 extend downwardly from transversely extending body portion 32 and pass through holes in blades 20 and 24, spacer
30 28, and platform 12 to secure cap 30, blades 20, 24 and spacer 28 on platform 12. Adhesively affixed to skin engaging surface 34 is skin engaging member 42.

35 The shaving unit 50 shown in FIG. 3 is of the type shown in Jacobson U.S. Patent 4,586,255 and includes body 52 with front portion 54 and rear portion 56. Resiliently

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secured in body 52 are guard member 58, leading blade unit 60 and trailing blade unit 62. A shaving aid composite in the form of elongated insert member 64 is frictionally locked in opening 66 of rear portion 56.

FIG's. 4-9 generally depict variations on the present invention. As used herein, the term "core" refers to an internal portion of a skin engaging member as examined at the cross-section. The core typically runs throughout the skin engaging member along an axis. The axis need not be the central axis. The FIG's. designate the core as 70. Embodiments of the present invention have at least one core element. As used herein, the term "sheath" refers to an outer coating layer(s) over the core. The FIG's. designate the sheath as 72.

Referring now to the drawings, and in particular to FIG. 4, there is shown an elongated skin engaging member 64. The member 64 has a skin engaging surface 74 and an elongated insert member 76. The insert member 76 is designed to frictionally lock in an opening 66 as shown in FIG. 3. The skin engaging member further comprises a rigid core 70 which is surrounded by a sheath 72 made of a mixture of water insoluble matrix and an effective amount of a shaving aid.

The sheath includes from about 0% to about 30% by weight, preferably from about 5% to about 15%, of the water insoluble matrix and from about 70% to about 100% by weight of the water soluble shaving aid, preferably from about 85% to about 95% shaving aid. Suitable water insoluble polymers for the matrix include, for example, nylon, ethylene-vinyl acetate copolymer,

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polyethylene, polypropylene, polystyrene,
polyacetal and combinations. Suitable shaving
aid materials include, for example, polyethylene
oxide, polyvinyl pyrrolidone, polyacrylamide,
5 hydroxypropyl cellulose, polyvinyl imidazoline,
polyethylene glycol, polyvinyl alcohol,
methylcellulose, starch, water soluble vinyl
polymers (Carbopol® brand sold by B.F. Goodrich),
polyhydroxyethylmethacrylate, silicone copolymers,
10 sucrose stearate, vitamin E, panthenol, aloe,
essential oils such as menthol and combinations.
The examples illustrate sheaths comprising
from 65% to 82% polyethylene oxide.

The sheath may include additional
15 components such as: plastisizers, such as
polyethylene glycol; beard softeners; additional
lubricants, such as silicone oil, Teflon®
polytetrafluoroethylene powders (manufactured by
DuPont), and waxes; shaving aids, such as
20 menthol, eugenol, eucalyptol, safrol and methyl
salicylate; fillers, such as calcium carbonate,
mica and fibers; tackifiers such as Hercules
Regalrez 1094 and 1126; fragrances;
antipruritic/counterirritant materials;
25 antimicrobial/keratolytic materials such as
Resorcinol, anti-inflammatory agents such as
Candilla wax and glycyrrhetic acid;
astringents such as zinc sulfate; surfactants
such as pluronic and iconol materials;
30 compatibilizers such as styrene-b-EO copolymers;
and, blowing agents such as Uniroyal Celogen
Aznp 130. These additives may leach from the
surface to provide improved shaving. These com-
ponents could be dispersed throughout the sheath
35 or alternatively, a second, outer sheath con-
taining the additional element could be extruded
or merely coated over the primary sheath.

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The present skin engaging member is produced by a coextrusion process whereby a rigid core material displaces a portion of the sheath material. The nature and relative portions of the sheath and core polymeric materials are such that the skin engaging member has adequate mechanical strength, both as initially produced and after a significant amount of water soluble material has been leached out, the quantity of the water-soluble material being sufficient to provide effective shaving assistance, such as lubrication, for the entire expected life of the blade or blades. The function of the core is not only to provide additional rigidity but to displace trapped shaving aid. In conventional skin engaging members, such as those described in U.S. Pat. Nos. 5,063,667; 5,095,619; and 5,113,585, a significant amount of shaving aid is trapped within the insoluble matrix. By displacing it closer to the skin engaging surface 74, diffusional paths are reduced and more efficient delivery is achieved. Furthermore, the core provides additional mechanical strength for the attaching mechanism, if used.

The core must have sufficient mechanical strength and rigidity to provide adequate mechanical strength to the entire skin engaging member, both as initially produced and after a significant amount of water soluble material has been leached out of the sheath. Preferably, the core can be made from a water insoluble polymer or a blend consisting of at least about 50% of water insoluble polymer to prevent the core from disintegrating. Water-soluble polymers for use in

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such blends include polyethylene oxide,
polyvinyl pyrrolidone; polyacrylamide,
hydroxypropyl cellulose, polyvinyl imidazoline,
polyethylene glycol, polyvinyl alcohol,
5 methylcellulose, starch, water-soluble vinyl
polymers (Carbopol® brand sold by B.F.
Goodrich), polyhydroxyethyl methacrylate, and
combinations thereof. Suitable water insoluble
polymers for use in the core include
10 polystyrene, high impact polystyrene,
polypropylene, filled polypropylene, nylon, and
blends thereof such as 70% nylon/30%
polyethylene oxide, 60% polystyrene/40%
polyethylene oxide.

15 Optionally, the core can include
additives such as lubricants foaming agents,
microspheres, baby powders, fillers such as
CaCO₃, colorants such as TiO₂ silicone
copolymers, sucrose stearate, vitamin E,
20 panthenol, aloe, essential oils, e.g. menthol,
and combinations thereof.

 In an embodiment of the present inven-
tion a wear indicating effect is produced when
the sheath (or outer layer) and the core (or inner
25 layer) are made of disparately colored materials
(e.g. white colored sheath and blue colored core).
Upon use, the sheath at the skin engaging surface
is typically worn off through use. With sufficient
use, a second colored region represented by the
30 core is exposed, thus, providing the user with an
indication that the shaving unit and/or skin
engaging surface have reached their effective life.
In a preferred embodiment, the sheath consists of a
polyethylene oxide/polystyrene mixture which is
35 white in color and the core consists of nylon
and/or styrene which has been colored with a FD&C
Blue #2 dye. Other suitable dyes or pigments

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include FD&C Red No. 40, Erythrosine (FD&C Red No. 3), Brilliant Blue FCF (FD&C Blue No. 1), Indigotine (FD&C Blue No. 2), Tartrazine (FD&C Yellow No. 5), Sunset Yellow FCF (FD&C Yellow No. 6) and Fast Green FCF (FD&C Green No. 3) and Titanium Dioxide.

Figure 5 depicts a cross section of an alternate skin engaging member. The core 70, follows the general contours of the surface defined by the outside of the sheath. Figure 6 depicts a slight variation on that theme where a thicker sheath layer is provided along the skin engaging surface 74. Still further, Figure 7 provides a cross-section wherein a very high degree of sheath material is present along the skin engaging surface.

Finally, Figure 8 depicts the skin engaging member depicted in Figures 1 and 2 with outer layer 72 and inner layer 70. It is interesting to note that the core (or inner layer) in this case provides mechanical strength to the unit yet is not vital to the mechanical locking of the unit. The skin engaging member of Figures 1 and 2 are affixed by adhesive. According to the present invention, the skin engaging members may be a affixed by adhesive such as Loctite Super Bonder 499, mechanical locking mechanism, thermal welds.

Figure 9 is a schematic cross section diagram of an extrusion die suitable for manufacturing the skin engaging member of the present invention. Core material 80 is fed into the intrusion die 81 by an extrusion screw, hot melt or other suitable means. In the core inlet port 82 the tight core orifice 83 encounters the sheath material 86, which has been fed into sheath inlet port 84, wherein the core becomes encapsulated by the sheath material when viewed in a transverse cross section to the flow of the

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die material. The encapsulated core then proceeds to the die outlet 85 wherein the continuous skin engaging members can be cured and/or drawn down to provide the appropriate dimensions. Also, it should be noted that the core material could consist of a solid wire or solid plastic material which is fed in through a conventional die to produce an encapsulated skin engaging member. For general discussion of coextrusion technology see Levi, *Plastics Extrusion Technology Handbook*, Industrial Press Inc., pages 168-188(1981).

After the continuous skin engaging members are produced, the strand is sent for further processing where it is typically drawn down to the correct size and cut to length suitable for implant into the body of a razor blade cartridge. This cutting can be achieved by knife edge cutting, lasers or water lasers. The skin engaging surfaces of the present invention typically are rectangular in shape with a width of from about 0.05 inches to about 0.1 inches and a length of about 1.2 inches.

Applicant considers equivalent embodiments to be part of the present invention. For example, non-rectangular skin engaging surface areas may be utilized (such as ovals) and non-flat surface patterns could be utilized. These and other equivalent embodiments are also contemplated by the present invention. The present invention and the manner of making and using the same should be evident from the following examples:

35

EXAMPLES

The following samples were coextruded with a cross-section as in FIG. 5.

No.	Core Material	Sheath Material
1	Nylon 70% blue pigment 0.5% polyethylene oxide 29.5%	10% polystyrene 76% polyethylene oxide 8% polyvinyl alcohol 5% polyethylene glycol 1% white pigment
2	25% polyethylene oxide 25% nylon	78% polyethylene oxide 14% polystyrene 3% polyethylene glycol 5% polyvinyl alcohol
3	100% polystyrene	82% polyethylene oxide 14% polystyrene 3% polyethylene glycol 1% polyvinyl alcohol
4	70% nylon 29.5% polyethylene oxide 0.5% blue dye	80% polyethylene oxide 16% polystyrene 4% polyvinyl alcohol
5	98% polystyrene 2% blue dye	73% polyethylene oxide 5% Salsorb 5% polyvinyl alcohol
6	100% polystyrene	74% polyethylene oxide 10% polystyrene 10% polyvinyl alcohol 5% polyethylene glycol 1% white TiO ₂ pigment

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No.	Core Material	Sheath Material
7	98% polystyrene 2% blue dye	68% polyethylene oxide 15% polyvinyl alcohol 10% polystyrene 5% polyethylene glycol 2% white TiO ₂ pigment
8	100% polystyrene	67% polyethylene oxide 4% Salsorb 14% polyvinyl alcohol 10% polystyrene 4% polyethylene glycol 1% white TiO ₂ pigment
9	99% polystyrene 1% blue dye	68% polyethylene oxide 20% polyvinyl alcohol 10% polystyrene 2% white TiO ₂ pigment

No.	Core Material	Sheath Material
10	99% polystyrene 1% blue dye	70% polyethylene oxide 13% polyvinyl alcohol 15% polystyrene 2% white TiO ₂ pigment
11	99% polystyrene 1% blue dye	65% polyethylene oxide 15% polyvinyl alcohol 15% polystyrene 3% Salsorb 2% white TiO ₂ pigment
12	99% polystyrene 1% blue dye	65% polyethylene oxide 10% polyvinyl alcohol 15% polystyrene 3% Salsorb 2% white TiO ₂ pigment

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Example 13

The following procedure can be used to produce a skin engaging member of the type depicted in Figure 4.

- 5 The extrusion equipment includes two single-screw extruders, a die cross-head, a cooling channel, and a puller. The strip extruded from the extruders is pulled through a cooling tunnel by a Farris puller (a take-off
10 machine) at a speed of approximately 10 feet per minute with minimum tension on the strip. The strip is air-cooled by blowing dry compressed air into the tunnel at approximately 10 CFM. The extrudate is kept in a cool, dry room.
- 15 The core blend (70% Zytel 330 brand amorphous nylon/blue pigment, 30% polyethylene oxide blend 60/40 is extruded through the first 3/4" Haake extruder (barrel pressure of 4,343 psi, and temperature of 180°C.). The sheath
20 blend (80% polyethylene oxide blend 60/40, 14% polystyrene/white color, 3% PEG, and 3% PVA 2025) is extruded through the second 3/4" Haake extruder (barrel pressure of 6,131 psi and temperature of 180°C.). The two materials are
25 then joined and are fed through a cross-head at a temperature of 180°C., die temperature of 180°C., and die pressure of 3,600 psi to form a continuous lubricating strip. The line speed is approximately 10 FPM.

Claims

1. A wet shaving unit comprising a blade and a polymeric shaving aid strip affixed adjacent said blade, said shaving aid strip comprising an outer shaving aid layer and an inner layer which are disparately coloured, said outer shaving aid layer comprising polyethylene oxide, as a water soluble shaving aid, in a water insoluble matrix, and said inner layer comprising a water insoluble polymer, wherein, during use of said wet shaving unit in shaving, said outer shaving aid layer gradually leaches out said polyethylene oxide and erodes at a skin engaging surface to expose said inner layer to provide a user with a visual indication that the shaving unit and/or the shaving aid strip have reached their effective life.
2. The shaving unit of claim 1 wherein said polyethylene oxide is present in an amount of 65% to 82% by weight.
3. The shaving unit of claim 1 or 2 wherein said water insoluble matrix comprises nylon, ethylene vinyl acetate copolymer, polyethylene, polypropylene, polystyrene or polyacetal.
4. The shaving unit of claim 1, 2 or 3 wherein said water insoluble polymer comprises polystyrene, high impact polystyrene, polypropylene, filled polypropylene or nylon.
5. The shaving unit of claim 1, 2, 3 or 4 wherein said inner layer additionally comprises polyethylene oxide.

FIG. 1

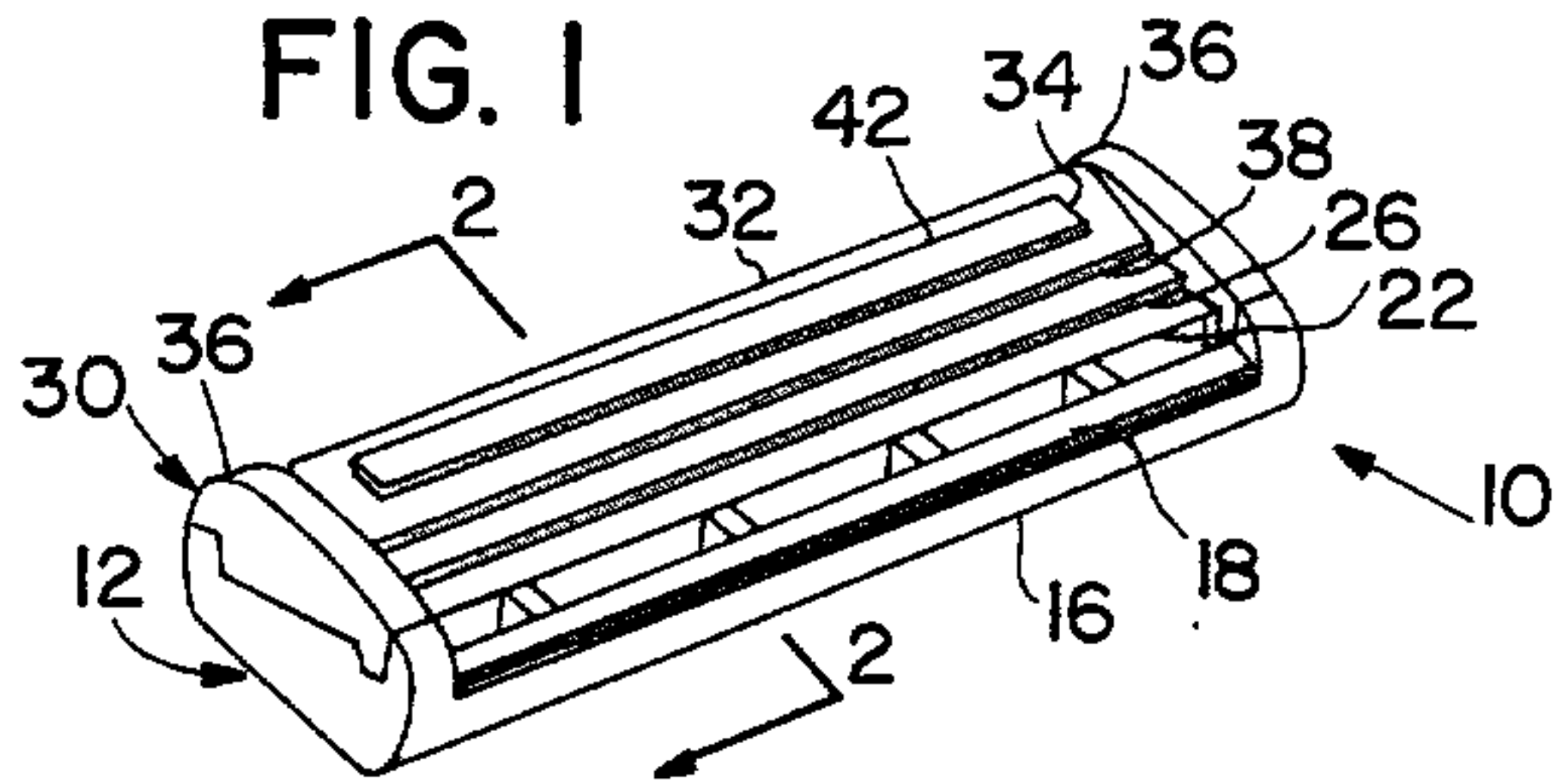


FIG. 2

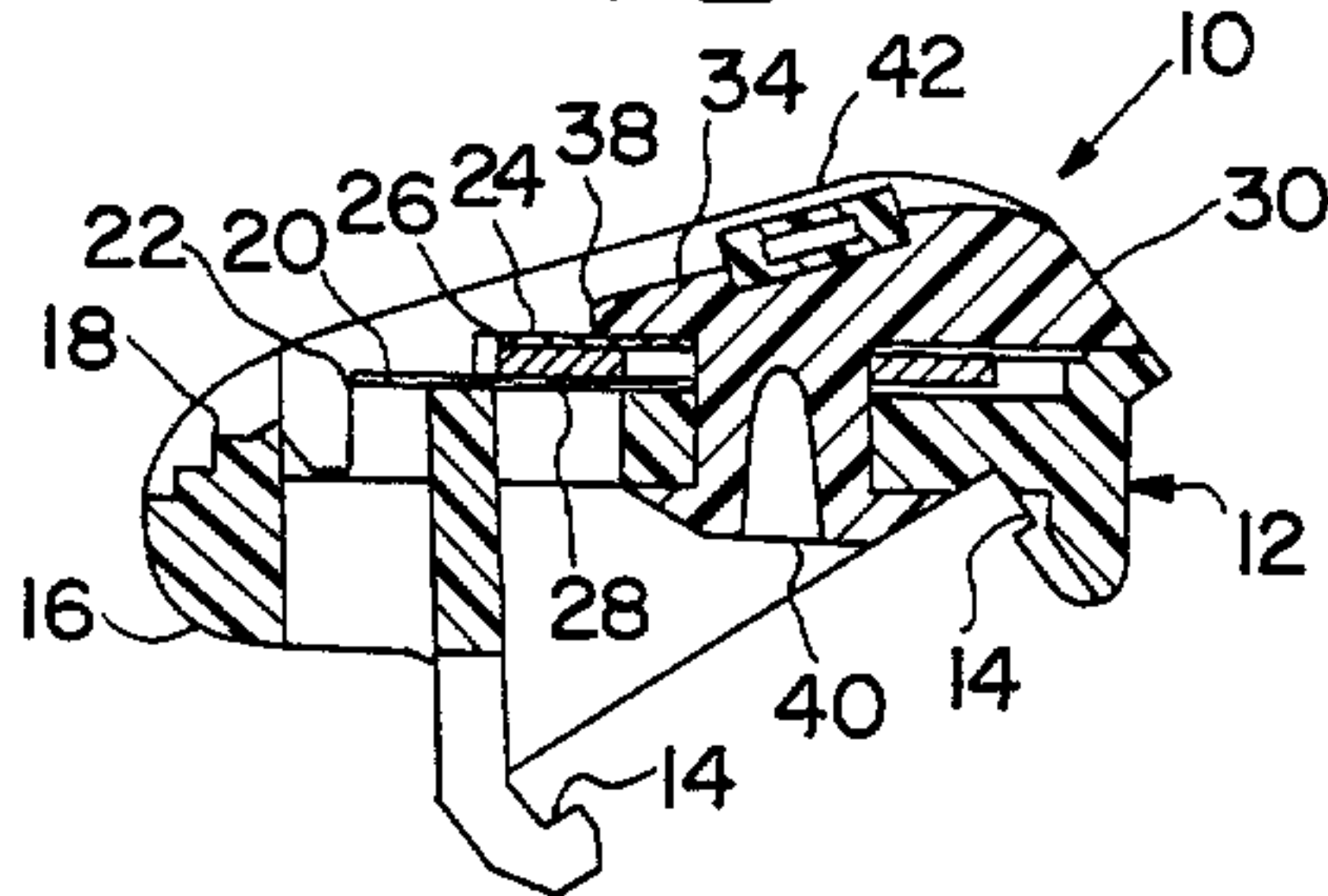


FIG. 3

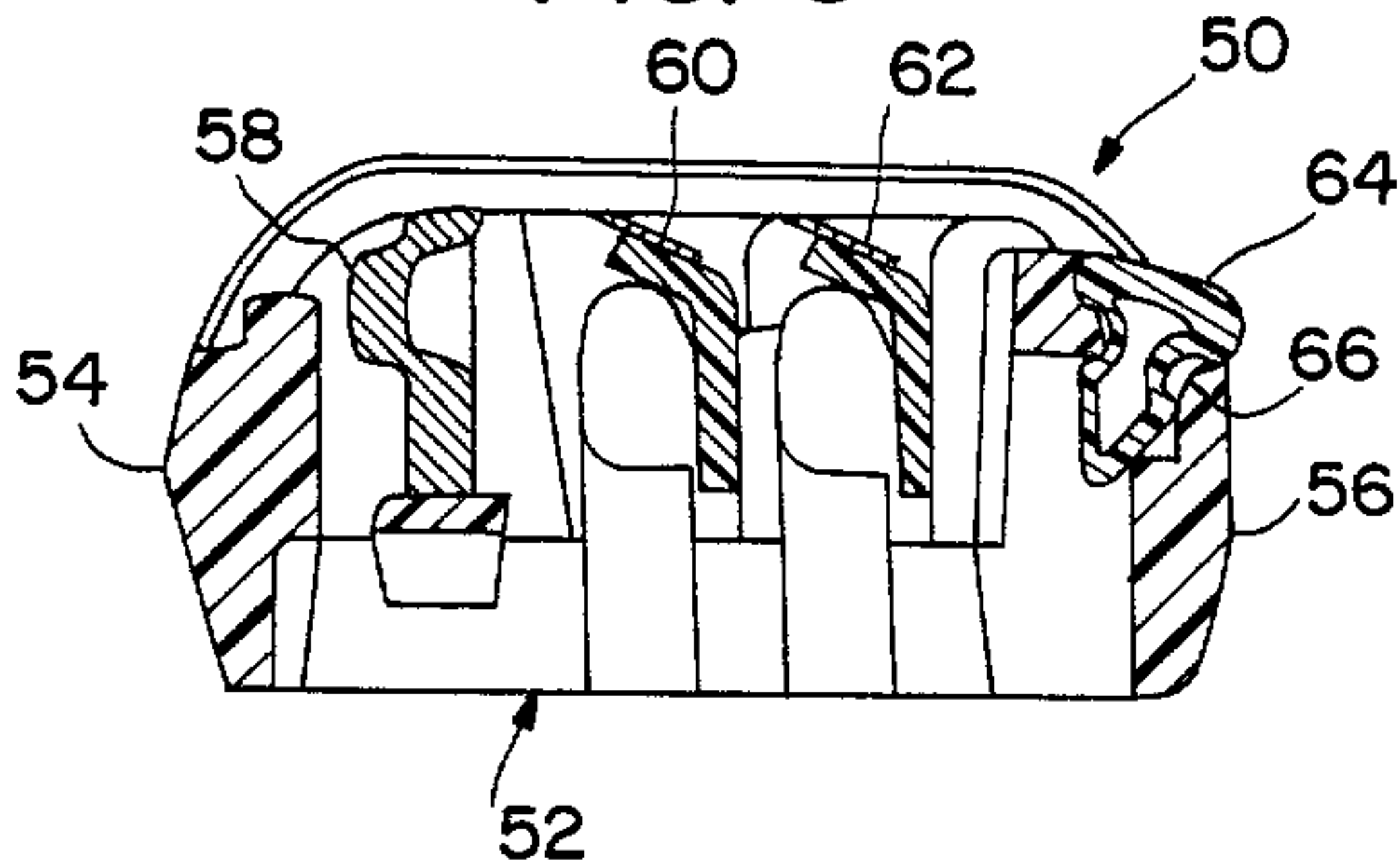


FIG. 4

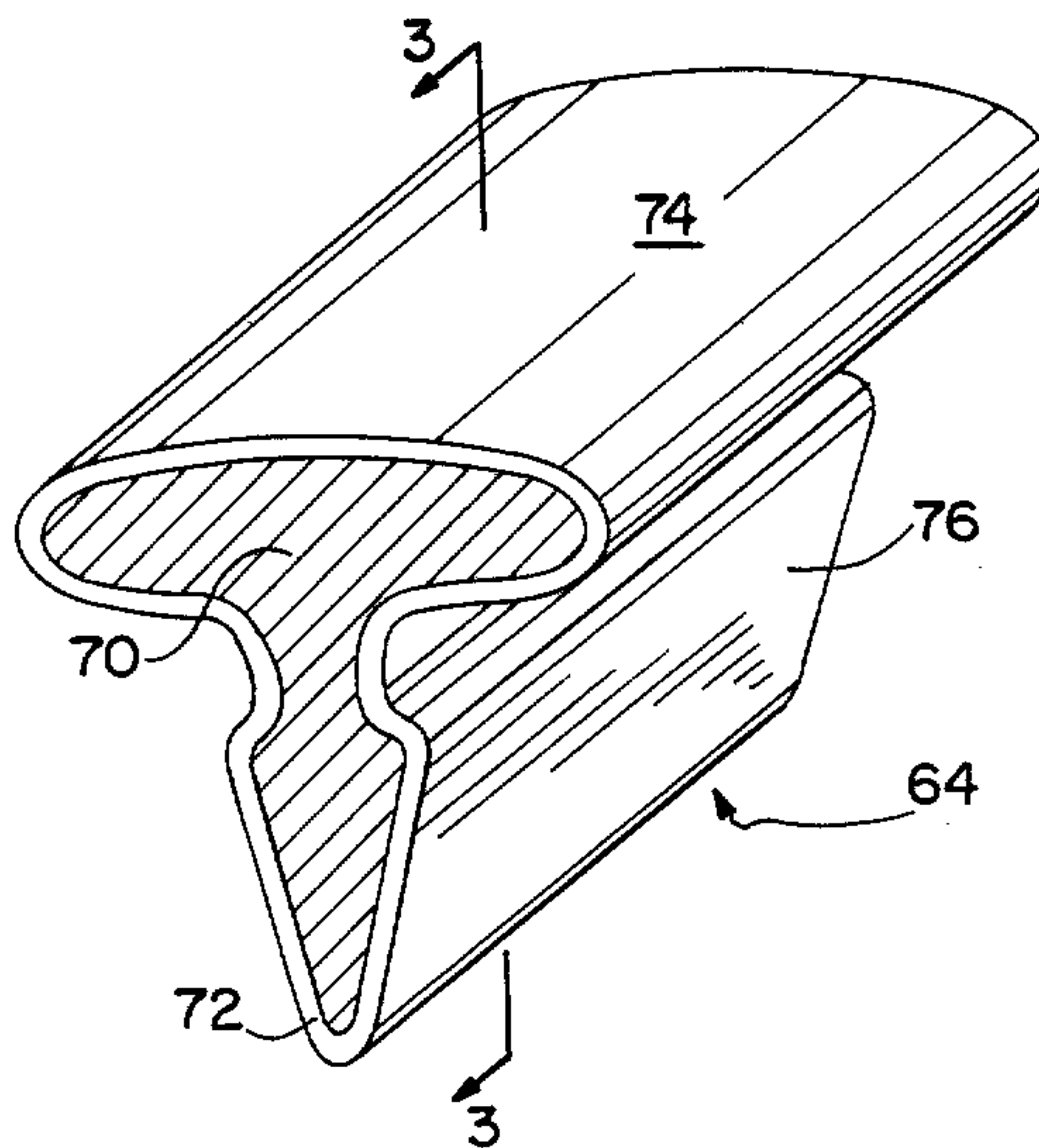


FIG. 5

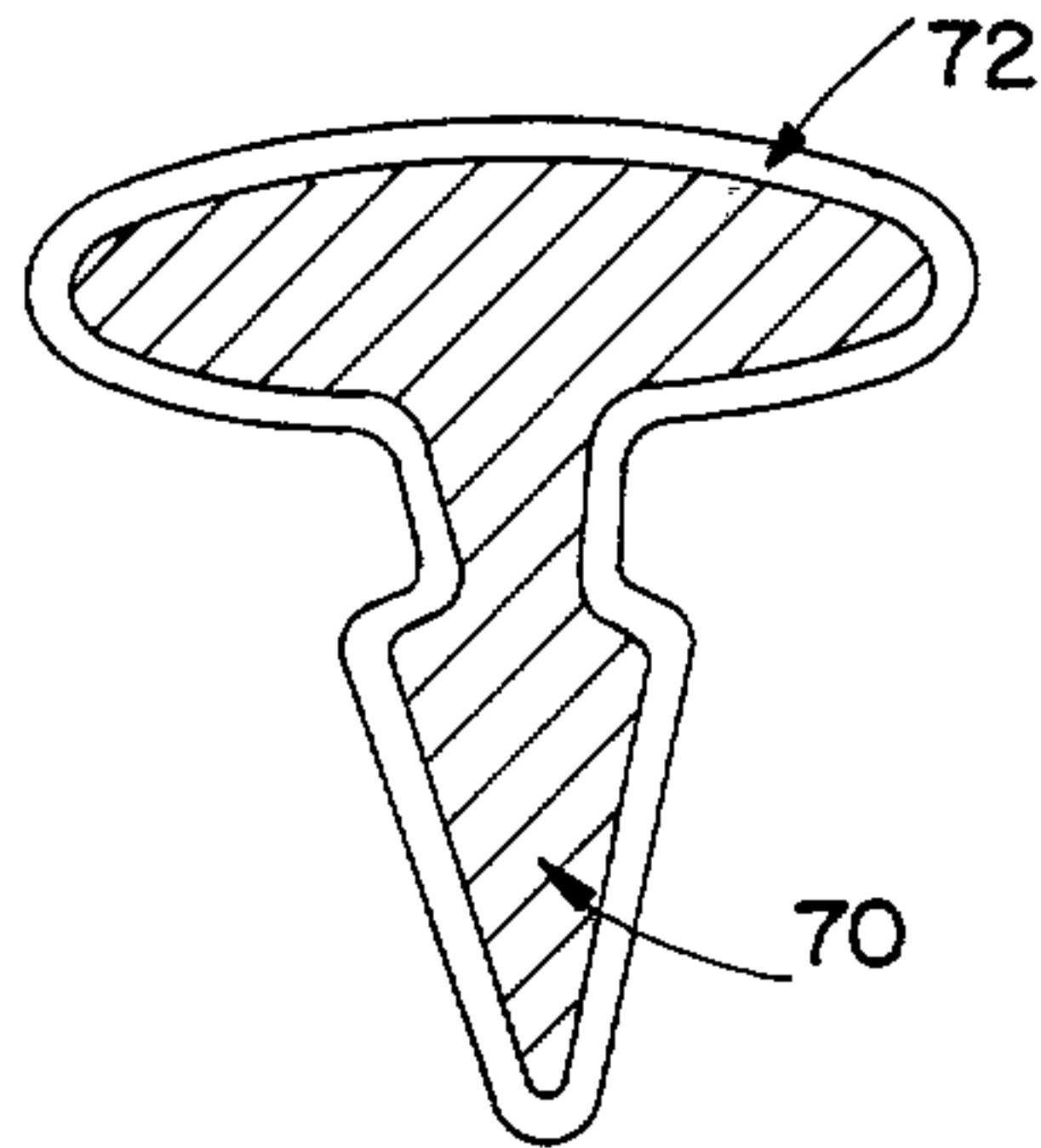


FIG. 6

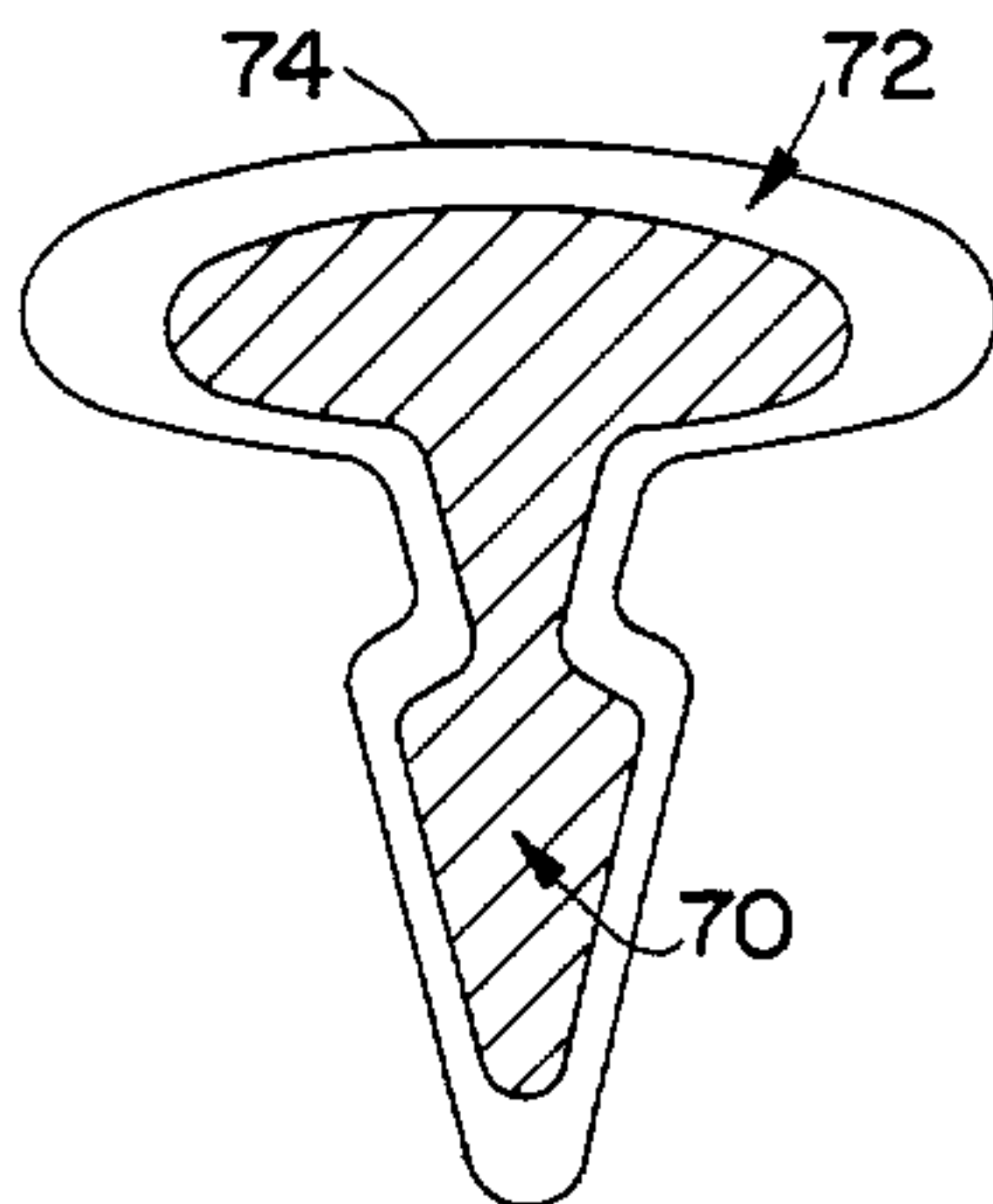


FIG. 7

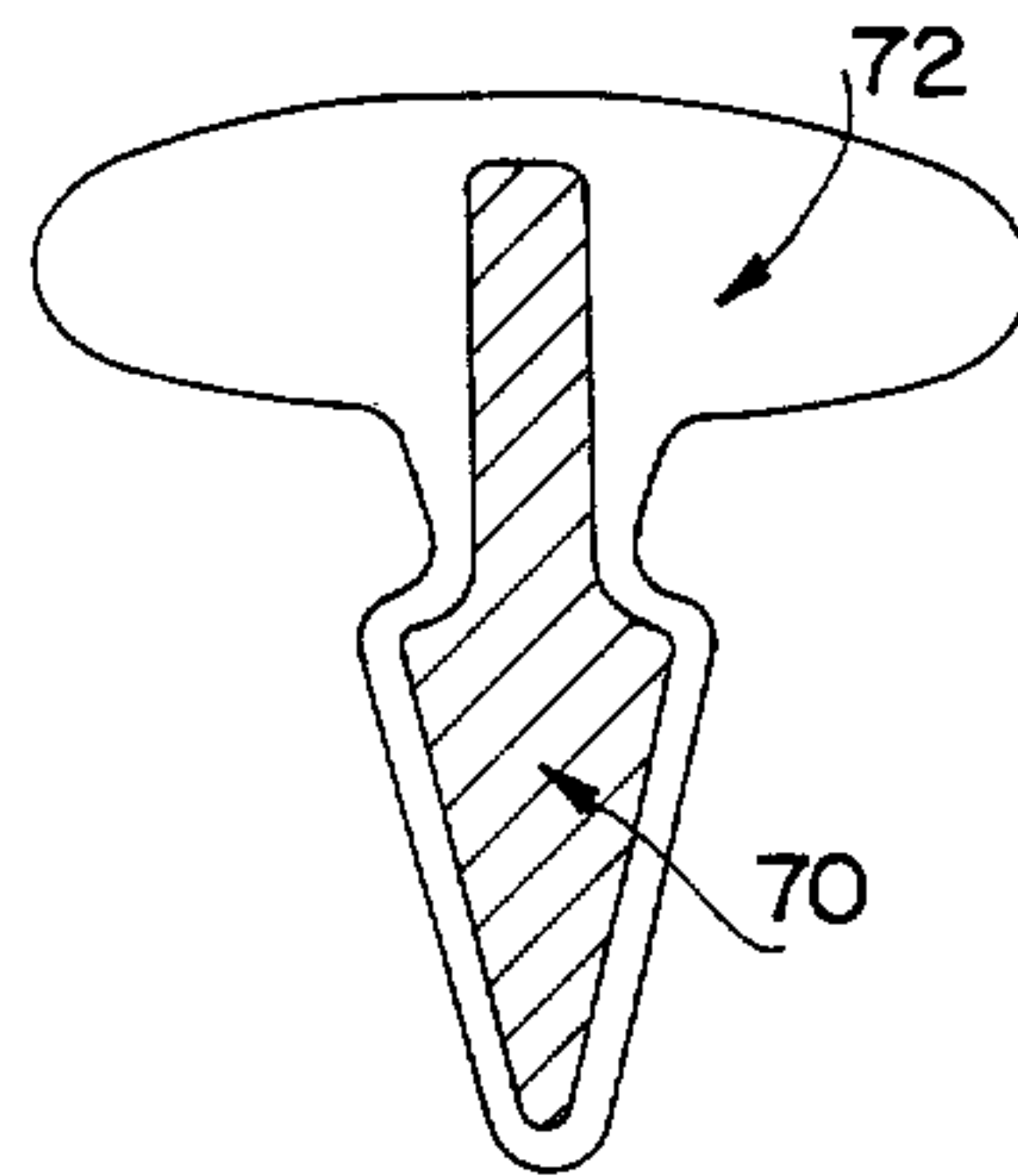


FIG. 8

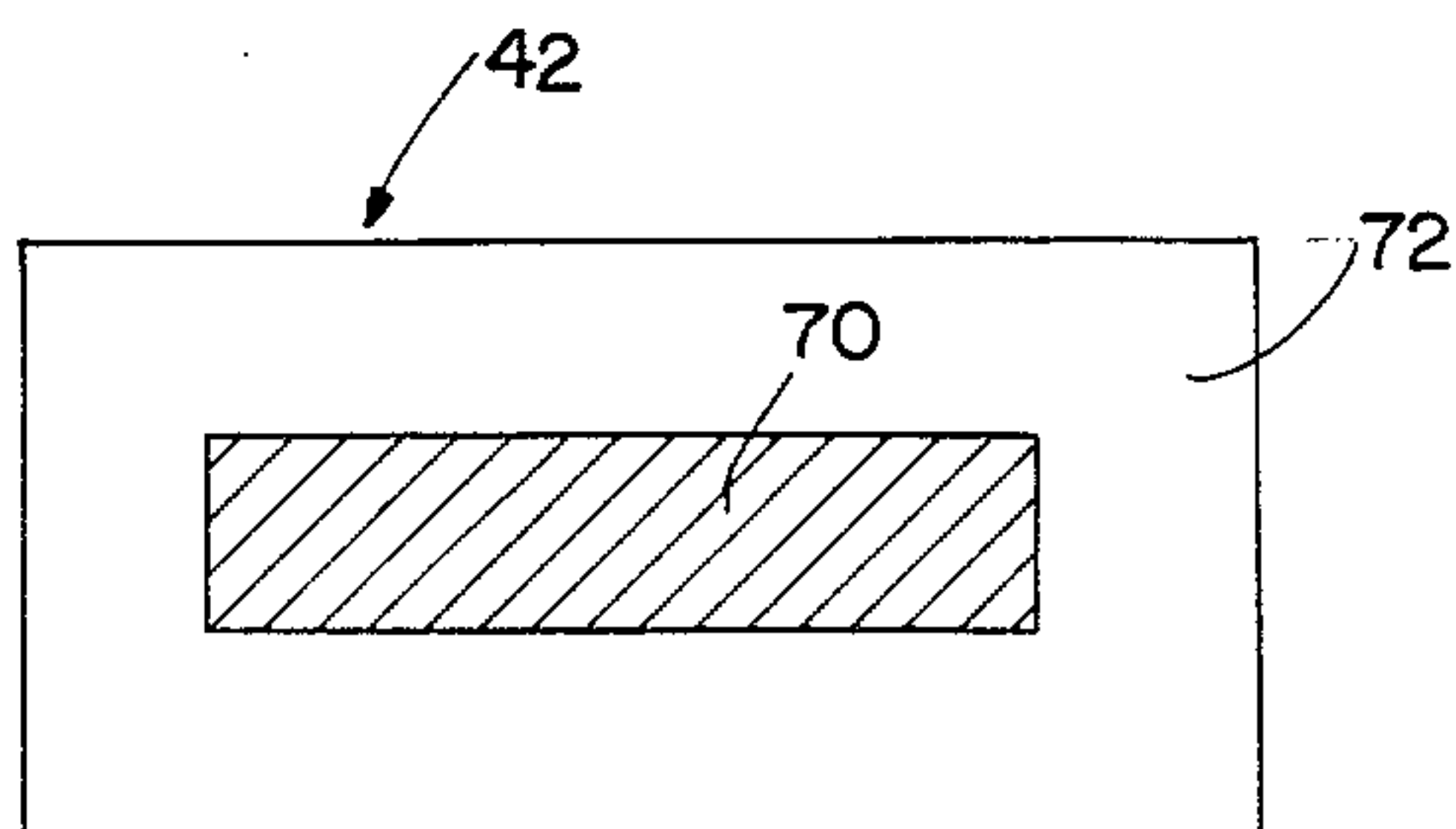


FIG. 9

