



(12) **EUROPEAN PATENT APPLICATION**

(43) Date of publication:
19.09.2018 Bulletin 2018/38

(51) Int Cl.:
B26B 21/56 (2006.01) **B26B 21/22 (2006.01)**
B26B 21/40 (2006.01)

(21) Application number: **18169778.0**

(22) Date of filing: **08.10.2012**

(84) Designated Contracting States:
AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

(30) Priority: **06.10.2011 PCT/EP2011/067451**

(62) Document number(s) of the earlier application(s) in accordance with Art. 76 EPC:
12769444.6 / 2 763 823

(71) Applicant: **BIC-Violex S.A.**
145 69 Anixi, Attiki (GR)

(72) Inventors:
• **DAVOS, Vasileios**
131 21 Ilion (GR)
• **PAPACHRISTOS, Vassilis**
157 73 Athens (GR)
• **EFTHIMIADIS, Dimitrios**
114 76 Nea Kypseli (GR)

• **ZAFIROPOULOS, Panagiotis**
115 24 Nea Philothei Athens (GR)
• **SKOUNAKIS, Nikolaos**
142 33 Perissos (GR)
• **KOMIANOS, Ioannis**
121 35 Peristeri (GR)
• **KARO USSIS, Michalis**
141 22 Athens (GR)
• **PAPAGEORGIU, Anastasios**
121 36 Peristeri (GR)

(74) Representative: **Peterreins Schley**
Patent- und Rechtsanwälte
Hermann-Sack-Strasse 3
80331 München (DE)

Remarks:

This application was filed on 27-04-2018 as a divisional application to the application mentioned under INID code 62.

(54) **RAZOR BLADE AND RAZOR HEAD**

(57) An integrally formed rigid razor blade (24) having a body with: - a cutting edge portion (39) extending about a cutting edge portion plane, and having a cutting edge (26) at one end, - a base portion (35) extending along a base portion plane, - a bent portion (53) intermediate the cutting edge portion and the base portion, and wherein the body is made of martensitic stainless steel comprising mainly iron and between 0.62% and 0.75% of carbon in weight.

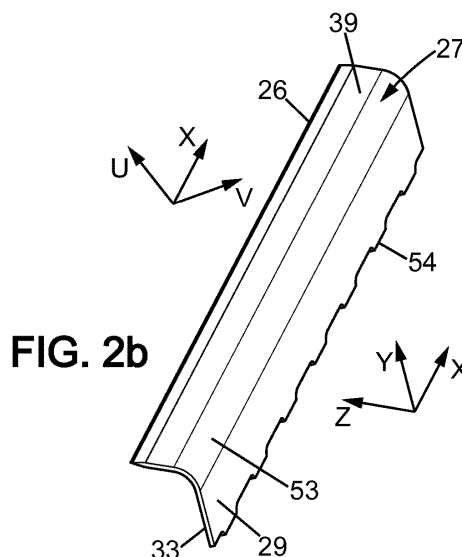
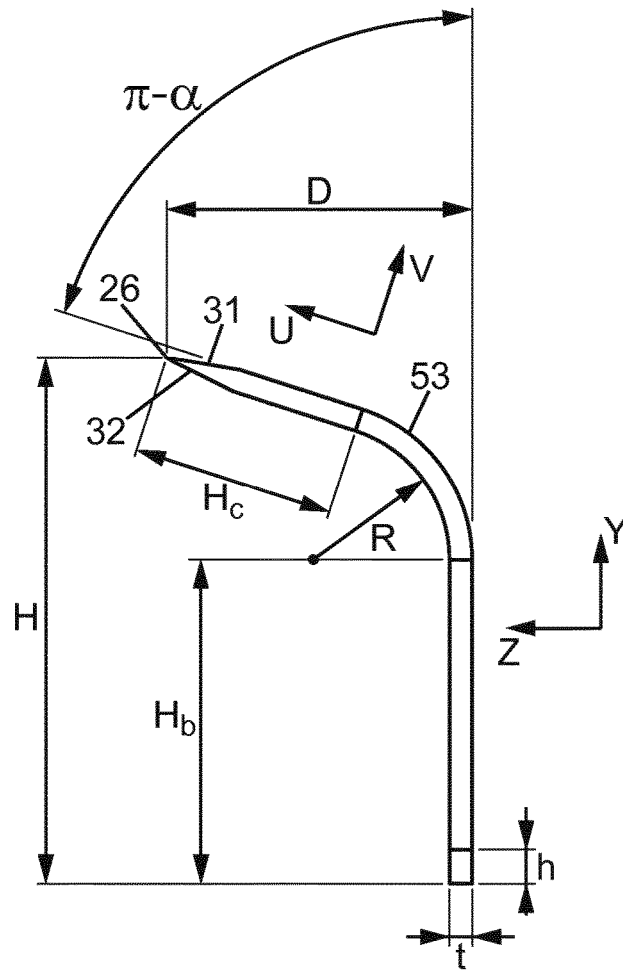


FIG. 3b



Description

FIELD OF THE INVENTIONS

5 **[0001]** The instant inventions relate to integrally formed rigid razor blades, razor heads having such blades, and their methods of manufacture.

BACKGROUND OF THE FIRST INVENTION

10 **[0002]** In particular, a first invention is related to integrally formed rigid razor cutting members.

[0003] In the field of mechanical wet shavers, it has long been provided with a shaver which has a head receiving one or more cutting members.

[0004] Recently, the trend has been to provide cutting members which have a sensibly L-shaped cross-section, with a cutting edge portion and a base portion which is angled with respect thereto in cross-section transverse to the length direction of the cutting members.

15 **[0005]** An example of a commercially successful such product can be found in WO 2007/147,420. Such cutting members are so-called 'supported blades', in that the so-called 'cutting part', which has the cutting edge, is assembled to a planar portion of a different part, called 'support part' which has the L-shaped cross-section. WO 2011/008851 also describes such a supported blade.

20 **[0006]** Yet, the assembly of these two parts raises the following problems: It is logistically difficult to handle these two different parts; it is difficult to technically handle these very tiny parts in a manufacturing apparatus operating at speeds suitable to reach the demand; it is difficult to guarantee precision of this assembly at these operating speeds, and these assemblies may corrode at the location of the attachment, thereby reducing life expectancy of the overall product.

[0007] Therefore, efforts have been made to replace these so-called 'supported blades' by integral bent blades. An example of such efforts can be found for example in US 2007/234,577. However, development of such an integral bent blade is very difficult. Indeed, in supported blades, it is possible to tailor the support part to its specific function, i.e. accurately providing the L-shape, and to separately tailor the cutting part to its specific function, i.e. optimized shaving performance. However, for integral bent blades, there is a need to provide a product with both excellent formability and cutting performance, while still considering the manufacturing process and cost issues.

30 **[0008]** US 2007/234,577 proposed to use a material having a composition comprised of 0.35 to about 0.43 percent carbon, about 0.90 to about 1.35 percent molybdenum, about 0.40 to about 0.90 percent manganese, about 13 to about 14 percent chromium, no more than about 0.030 percent phosphorus, about 0.20 to about 0.55 percent silicon, and no more than 0.025 percent sulfur. However, this only defines at most 18% of the material composition. According to an example, US 2007/234,577 recommends the use of a stainless steel having a carbon content of about 0.4 percent by weight, and other constituents. However, US 2007/234,577 needs to apply a local heat treatment to increase the ductility of the portion of the blade to be bent. However, this additional step is complex to implement on an industrial scale.

35 **[0009]** Another example of such efforts can be found in US 2007/124,939. However, this document defines a very general class of steels for their razor blades, namely with a very broad range of carbon content, between 0.50%-1.25%. The properties of these materials will extend in a very broad range.

40 **[0010]** The instant invention has notably for object to mitigate those drawbacks.

SUMMARY OF THE FIRST INVENTION

45 **[0011]** To this aim, it was surprisingly discovered that a razor blade of martensitic stainless steel with a higher carbon content would provide an optimal response to the competing requirements of formability of the bent portion and strength of the blade edge, while still being manufacturable with all the other listed requirements.

[0012] In particular, it is provided an integrally formed rigid razor blade having a body with:

- a cutting edge portion extending about a cutting edge portion plane, and having a cutting edge at one end,
- 50 - a base portion extending along a base portion plane,
- a bent portion intermediate the cutting edge portion and the base portion,

and wherein the body is made of martensitic stainless steel comprising mainly iron and between 0.62% and 0.75% of carbon in weight.

55 **[0013]** In some embodiments, one might also use one or more of the features defined in the dependant claims.

BACKGROUND OF THE SECOND INVENTION

[0014] A second invention is related to razor heads with movable integrally formed rigid razor blades.

[0015] In the field of mechanical wet shavers, it has long been provided with a shaver which has a head receiving one or more cutting members. The cutting members are mounted to move (mainly translate) inside the head when shaving.

[0016] Recently, the trend has been to provide cutting members which have a sensibly L-shaped cross-section, with a cutting edge portion and a base portion which is angled with respect thereto in cross-section transverse to the length direction of the cutting members.

[0017] An example of a commercially successful such product can be found in WO 2007/147,420. Such blades are so-called 'supported blades', in that the so-called 'cutting part', which has the cutting edge, is assembled to a planar portion of a different part, called 'support part' which has the L-shaped cross-section.

[0018] In particular, the base portion is oriented along a base portion axis which defines the direction of movement of the cutting members in the head.

[0019] Yet, the assembly of these two parts raises the following problems: It is logistically difficult to handle these two different parts; it is difficult to technically handle these very tiny parts in a manufacturing apparatus operating at speeds suitable to reach the demand; it is difficult to guarantee precision of this assembly at these operating speeds, and these assemblies may corrode at the location of the attachment, thereby reducing life expectancy of the overall product.

[0020] Therefore, efforts have been made to replace these so-called 'supported blades' by integral bent blades. Although some patent documents show some drawings of razor heads with integral movable bent blades, it is believed that no commercial product is yet available with such features. It is believed to be due to the difficulty of designing such a product. Indeed, such drawings can for example be found in US 4,621,424, filed as early as 1984.

[0021] An issue with a product which would be designed according to the above drawing is that, during shaving, the blade might not remain sufficiently straight, and would be submitted to bending, thus deteriorating shaving performance, and/or would witness the apparition of microcracks, thus favorizing corrosion. In 1990, US 5,010,646 proposed to solve these problems by providing corrugations on the blade. However, this product was probably difficult to manufacture, and the effect on shaving performance appears doubtful, so that further research on such products have then be abandoned.

[0022] The instant invention has notably for object to provide a head with integral bent blades.

SUMMARY OF THE SECOND INVENTION

[0023] To this aim, it is provided razor head comprising:

- a housing having a top face defining a shaving window, and an opposed stopping face, the housing further comprising at least one guide,
- at least one integrally formed rigid razor blade, each freely mounted in the housing, and having:
 - a cutting edge portion extending along a cutting edge portion axis, and having a cutting edge accessible through the shaving window,
 - a guided portion extending along a guided portion axis, and
 - a bent portion intermediate the cutting edge portion and the guided portion,

wherein the cantilever dimension, measured as the distance between the cutting edge and the guided portion axis, is between 1.1 millimeter and 1.8 millimeter,

wherein the guided portion cooperates with the guide so that each blade is independently translatable with respect to the housing along a sliding direction parallel to the guided portion axis, under the effect of shaving forces applied to the blade during shaving.

[0024] It was discovered that the above-defined parameter was a key factor for the shaving performance of such a razor head. Keeping this parameter in the defined limits enables to optimize shaving performance. Indeed, for razor heads with razor blades having this dimension greater than 1.8, there is a risk to have a bigger head in order to have sufficient rinsability.

[0025] Further, blade deflection would be difficult to control.

[0026] For blades having this dimension lower than 1.1, handling and assembling becomes strenuous. Further, the probability of damaging the blade cutting edge during manufacturing increased dramatically. Also, controlling the spring force applied by lateral spring arms in heads with movable blades proved more difficult.

[0027] In some embodiments, one might also use one or more of the features defined in the dependant claims.

BACKGROUND OF THE THIRD INVENTION

[0028] In particular, a third invention is related to integrally formed rigid razor blades.

[0029] In the field of mechanical wet shavers, it has long been provided with a shaver which has a head receiving one or more cutting members.

[0030] Recently, the trend has been to provide cutting members which have a sensibly L-shaped cross-section, with a cutting edge portion and a base portion which is angled with respect thereto in cross-section transverse to the length direction of the cutting member.

[0031] An example of a commercially successful such product can be found in WO 2007/147,420. Such cutting members are so-called 'supported blades', in that the so-called 'cutting part', which has the cutting edge, is assembled to a planar portion of a different part, called 'support part' which has the L-shaped cross-section.

[0032] Yet, the assembly of these two parts raises the following problems: It is logistically difficult to handle these two different parts; it is difficult to technically handle these very tiny parts in a manufacturing apparatus operating at speeds suitable to reach the demand; it is difficult to guarantee precision of this assembly at these operating speeds, and these assemblies may corrode at the location of the attachment, thereby reducing life expectancy of the overall product.

[0033] Therefore, efforts have been made to replace these so-called 'supported blades' by integral bent blades. An example of such efforts can be found for example in US 2007/234,577. However, development of such an integral bent blade is very difficult. Indeed, in supported blades, it is possible to tailor the support part to its specific function, i.e. accurately providing the L-shape, and to separately tailor the cutting part to its specific function, i.e. cutting hair. However, for integral bent blades, there is a need to provide a product both with excellent formability and cutting performance, while still considering the manufacturing process and cost issues.

[0034] US 2007/234,577 proposed a very short bent portion. In particular, the radius of curvature R of the inner face of the bent portion is to be set to 0.45 millimeter or lower.

[0035] As recognized later in WO 2011/06760 by the same applicant, the stringent material requirements for the blade edges limit the amount blades can be bent consistently and accurately. WO 2011/06760 teaches to reduce the bending angle with, as visible on the drawings, a radius of curvature close to 0.

[0036] However, it is rather believed that reducing the radius of curvature would favorize unwanted apparition of cracks during manufacture. These cracks ought to be avoided, because they may cause permanent deformation to occur when shaving, thereby reducing shaving performance, or corrosion to start.

[0037] The instant invention has notably for object to mitigate those drawbacks.

SUMMARY OF THE THIRD INVENTION

[0038] To this aim, it is provided an integrally formed rigid razor blade made of martensitic stainless steel and having in cross-section :

- a cutting edge portion extending along a cutting edge portion axis, and having a cutting edge at one end,
- a base portion extending along a base portion axis,
- a bent portion intermediate the cutting edge portion and the base portion,

said blade having a concave face and an opposed convex face,

and wherein the average radius of curvature of the bent portion at its concave face is between 0.5 and 1 millimeter.

[0039] By increasing the radius of curvature of the inner face of the bent portion, the product can be manufactured by a rather mild manufacturing process, which would respect the constitutive material, and occurrence of cracks during this manufacture would be reduced.

[0040] In some embodiments, one might also use one or more of the features defined in the dependant claims.

BACKGROUND OF THE FOURTH INVENTION

[0041] In particular, a fourth invention is related to methods of manufacture of integrally formed rigid razor blades.

[0042] In the field of mechanical wet shavers, it has long been provided with a shaver which has a head receiving one or more cutting members.

[0043] Recently, the trend has been to provide cutting members which have a sensibly L-shaped cross-section, with a cutting edge portion and a base portion which is angled with respect thereto in cross-section transverse to the length direction of the blade.

[0044] An example of a commercially successful such product can be found in WO 2007/147,420. Such cutting members are so-called 'supported blades', in that the so-called 'cutting part', which has the cutting edge, is assembled to a planar portion of a different part, called 'support part' which has the L-shaped cross-section.

[0045] Yet, the assembly of these two parts raises the following problems: It is logistically difficult to handle these two different parts; it is difficult to technically handle these very tiny parts in a manufacturing apparatus operating at speeds suitable to reach the demand; it is difficult to guarantee precision of this assembly at these operating speeds, and these assemblies may corrode at the location of the attachment, thereby reducing life expectancy of the overall product.

[0046] Therefore, efforts have been made to replace these so-called 'supported blades' by integral bent blades. An example of such efforts can be found for example in US 2007/234,577. However, development of such an integral bent blade is very difficult. Indeed, in supported blades, it is possible to tailor the support part to its specific function, i.e. accurately providing the L-shape, and to separately tailor the cutting part to its specific function, i.e. optimized shaving performance. However, for integral bent blades, there is a need to provide a product both with excellent formability and cutting performance, while still considering the manufacturing process and cost issues.

[0047] In particular, it is necessary to limit as much as possible the degree of deformations applied to the blades during their manufacture, so as to not introduce permanent deformations which would affect shaving performance.

[0048] US 2007/234,577 proposed slots between to-be adjacent cutting members. However, it is still difficult to handle such tiny strips, or parts separated therefrom, at high speed.

[0049] The instant invention has notably for object to improve the efficiency of the manufacturing process, while not adversely affecting the characteristics of the final product.

SUMMARY OF THE FOURTH INVENTION

[0050] To this aim, it is provided a method of manufacturing an integrally formed razor blade comprising:

- providing a strip having, in cross-section transverse to a long axis, a blade portion and a removable portion, wherein weakening holes are provided along the long axis between the blade portion and the removable portion,
- separating the blade portion from the removable portion by breaking the strip at the weakening holes,
- providing the razor blade with a profile having:
 - a cutting edge portion extending along a cutting edge portion axis, and having a cutting edge at one end,
 - a base portion extending along a base portion axis, and having an abutment edge at one end,
 - a bent portion intermediate the cutting edge portion and the guided portion,

wherein the abutment edge is corrugated along the long axis, with corrugations with a height of at most 0.3 millimeters.

[0051] Thereby, the handled strip can be made longer, and easier to handle. Further, by using a pre-perforated strip, separation of the blade from the strip is performed by imparting minimal deformation to the strip, thereby improving the overall consistency of the manufactured product.

BACKGROUND OF THE FIFTH INVENTION

[0052] In particular, a fifth invention is related to methods of manufacture of integrally formed rigid razor blades.

[0053] In the field of mechanical wet shavers, it has long been provided with a shaver which has a head receiving one or more cutting members.

[0054] Recently, the trend has been to provide cutting members which have a sensibly L-shaped cross-section, with a cutting edge portion and a base portion which is angled with respect thereto in cross-section transverse to the length direction of the cutting members.

[0055] An example of a commercially successful such product can be found in WO 2007/147,420. Such cutting members are so-called 'supported blades', in that the so-called 'cutting part', which has the cutting edge, is assembled to a planar portion of a different part, called 'support part' which has the L-shaped cross-section.

[0056] Yet, the assembly of these two parts raises the following problems: It is logistically difficult to handle these two different parts; it is difficult to technically handle these very tiny parts in a manufacturing apparatus operating at speeds suitable to reach the demand; it is difficult to guarantee precision of this assembly at these operating speeds, and these assemblies may corrode at the location of the attachment, thereby reducing life expectancy of the overall product.

[0057] Therefore, efforts have been made to replace these so-called 'supported blades' by integral bent blades. An example of such efforts can be found for example in US 2007/234,577. However, development of such an integral bent blade is very difficult. Indeed, in supported blades, it is possible to tailor the support part to its specific function, i.e. accurately providing the L-shape, and to separately tailor the cutting part to its specific function, i.e. cutting hair. However, for integral bent blades, there is a need to provide a product both with excellent formability and cutting performance, while still considering the manufacturing process and cost issues.

[0058] One attempt at manufacturing bent blades can be found in US 2007/234,577. In this document, the blades are shaped by coining. However, it is believed that this process still provides with a wide dispersion of resulting geometries.

[0059] The instant invention has notably for object to improve the consistency of the products existing from manufacturing process, i.e. to reduce the dispersion in geometry of the manufactured products.

SUMMARY OF THE FIFTH INVENTION

[0060] A method of manufacture of an integral bent blade for a mechanical shaver, comprises :

- providing a flat strip of metal extending from a first edge to an opposite edge,
- bending the flat strip along a bending axis parallel to the first edge to result in an integrally bent product having opposed inner and outer faces, and comprising :
 - a cutting edge portion extending along a cutting edge portion axis, and having the first edge at one end,
 - a base portion extending along a base portion axis, and having the opposite edge at one end,
 - a bent portion intermediate the cutting edge portion and the base portion,
- after bending, applying a mechanical stress on the inner face of the bent portion.

[0061] It has been discovered that application of this mechanical stress after bending straightens the bent blade, and thus reduced the amount of products which did not meet the requested geometrical specifications.

BRIEF DESCRIPTION OF THE DRAWINGS

[0062] Other characteristics and advantages of the invention will readily appear from the following description of some of its embodiments, provided as a non-limitative examples, and of the accompanying drawings.

[0063] On the drawings :

- Fig. 1 is an exploded perspective view of a razor head according to an embodiment,
- Figs 2a and 2b are two opposed perspective views of an embodiment of an integral bent blade,
- Fig. 3a is a rear view of the blade of Figs. 2a and 2b,
- Fig. 3b is a lateral view of the blade of Fig. 3a,
- Figs. 4a and 4b are views corresponding respectively to Figs. 3a and 3b for a second embodiment of a bent blade,
- Fig. 5 is a view corresponding to Fig. 3a for a third embodiment of a bent blade,
- Figs. 6a and 6b are views corresponding respectively to Figs. 3a and 3b for a fourth embodiment of a bent blade,
- Fig. 7 is a schematic sectional view along line VII-VII on Fig. 1,
- Figs. 8a and 8b are schematic views of intermediate products of the manufacture of a razor blade,
- Fig. 9 is a lateral view of an embodiment of a forming tool used for the manufacture of a bent blade,
- Fig. 10 is a chart of a manufacturing process for a bent blade,
- Fig. 11 is a perspective schematic view of a holding tool for a bent blade.

[0064] On the different Figures, the same reference signs designate like or similar elements.

DETAILED DESCRIPTION

[0065] Figure 1 shows a head 5 of a safety razor (also called wet shaver), a shaver the blades of which are not driven by a motor relative to the blade unit.

[0066] The shaving head 5 is to be borne by a handle extending in a longitudinal direction between a proximal portion and a distal portion bearing the blade unit 5 or shaving head. The longitudinal direction may be curved or include one or several straight portions.

[0067] The blade unit 5 includes an upper face 6 defining a shaving window, and equipped with one or several cutting members and a lower face 7 which is to be connected to the distal portion of the handle by a connection mechanism. The connection mechanism may for instance enable the blade unit 5 to pivot relative to a pivot axis X which is substantially perpendicular to the longitudinal direction. Said connection mechanism may further enable to selectively release the blade unit for the purpose of exchanging blade units. One particular example of connection mechanism usable in the present invention is described in document WO-A-2006/027018, which is hereby incorporated by reference in its entirety for all purposes.

[0068] The blade unit 5 includes a frame 10 which is made solely of synthetic materials, i.e. thermoplastic materials (polystyrene or ABS, for example) and elastomeric materials.

[0069] More precisely, the frame 10 includes a plastic platform member 11 connected to the handle by the connection

mechanism and having:

- a guard bar 12 extending parallel to the pivot axis X,
- a blade receiving section 13 situated rearward of the guard 12 in the direction of shaving,
- a rear portion 14 extending parallel to the pivot axis X and situated rearward of the blade receiving section 13 in the direction of shaving,
- and two side portions 15 joining the longitudinal ends of the guard bar 12 and of the rear portion 14 together.

[0070] In the example shown in the figures, the guard bar 12 is covered by an elastomeric layer 16 forming a plurality of fins 17 extending parallel to the pivot axis X.

[0071] Further, in this particular example, the underside of the platform member 11 includes two shell bearings 18 which belong to the connection mechanism 8 and which may be for example as described in the above-mentioned document WO-A-2006/027018.

[0072] The frame 10 further includes a plastic cover 19 having a top face and an opposite bottom face, which faces the top face of the components of the platform 11. The cover 19 exhibits a general U shape, with a cap portion 20 partially covering the rear portion 14 of the platform and two side members 21 covering the two side members 15 of the platform. In this embodiment, the cover 19 does not cover the guard bar 12 of the platform.

[0073] The cap portion 20 of the cover 19 may include a lubricating strip 23 which is oriented upward and comes into contact with the skin of the user during shaving. This lubricating strip may be formed for instance by co-injection with the rest of the cover. The cover 19 is assembled to the platform 11 by any suitable means, such as, for example, by ultra-sonic welding, as explained in WO 2010/06,654, hereby incorporated here in its entirety for all purposes.

[0074] The present description of a housing is exemplary only.

[0075] At least one cutting member 24 is movably mounted in the blade receiving section 13 of the platform. The blade receiving section 13 may include several cutting members 24, for instance four cutting members as in the example shown in the drawings.

[0076] Each cutting member 24 is made of a blade which is integrally formed from a flat steel strip.

[0077] In particular, one may use a martensitic stainless steel with the following composition (in weight):

Carbon : between 0.62% and 0.75%,
Chromium : between 12.7% and 13.7%,
Manganese : between 0.45% and 0.75%,
Silicon : between 0.20% and 0.50%,
Iron: Balance

[0078] Such an alloy has no more than traces of other components, and notably no more than traces of Molybdenum.

[0079] The razor blade has a cutting edge 26 oriented forward in the direction of shaving and an opposed rear edge 54. The cutting edge 26 is accessible through the shaving window of the blade-receiving section 13, to cut hair. Each blade 25 has an outer face 27 oriented towards the skin to be shaved and an opposed inner face 28. The outer and inner faces 27, 28 of the blade include respectively two parallel main surfaces 29, 30 and two tapered facets 31, 32 which taper towards the cutting edge 26.

[0080] Each blade 25 extends longitudinally, parallel to the pivot axis X, between two lateral sides 33, 33'. For example, the lateral sides are straight.

[0081] Each blade 25 has a bent profile including:

- a substantially flat base portion 35 (for example substantially perpendicular to the shaving plane) having a periodically serrated edge 54,
- a substantially flat cutting edge portion 39 comprising the cutting edge 26,
- a bent portion 53 extending between the base portion and the cutting edge portion. The bent portion has a concave face 28 and an opposed convex face 27. The face of the blade having the concave face is called inner face, and the other one the outer face.

[0082] When the blade is mounted to slide in the head, the base portion is also sometimes called "guided portion".

[0083] As shown in figure 1, each cutting member 24 is borne by two elastic fingers 44 which are molded as a single piece with the platform 11 and which extend towards each other and upwardly from both side members 15 of the platform. For example, all the fingers 44 extending from a given side member are identical.

[0084] Besides, as shown in figure 2, the base portions 35 of the blades are slidably guided in slots 45 provided in the inner face of each side member 15 of the platform. The slots are, for example, substantially perpendicular to the shaving plane.

[0085] The blades 24 are elastically biased by the elastic arms 44 toward a nominal position. In this nominal position, the outer faces 27 of the blades, at each lateral end of the blades, bear against corresponding upper stop portions 52 which are provided on the bottom stopping face of each side member 21 of the cover, said side member 21 covering the slots 45.

[0086] Therefore, the nominal position of the blades 24 is well defined, therefore enabling a high shaving precision.

[0087] In this nominal position, the inner faces 28 of the blades, at each lateral end of the blades, are borne by corresponding top portions 55 of the elastic arms. The distance between the two top portions is for example of 22 to 30 mm, preferably between 25 and 27 mm.

[0088] The guiding slots 45 define a direction Y for the razor head. The direction Z is the normal to the X-Y plane. The base portion 35 extends in a base portion plane. The base portion axis is the main axis of the base portion other than its profile axis, i.e. other than the X axis. In the present embodiment, it is the Y axis. In other words, the main axis along which the base portion extends is the same as the axis defined by the slots 45 in the razor head.

[0089] The cutting edge portion 39 extends in a cutting edge portion plane. The cutting edge portion axis is the main axis of the cutting edge portion other than its profile axis, i.e. other than the X axis. In the present embodiment, it is a U axis. In other words, the cutting edge portion axis extends in an X-U plane. A V axis is defined normal to the X-U plane.

[0090] A first embodiment of a bent blade is shown on Figs 3a and 3b. Below, some geometrical characteristics of the blade are given. The geometrical characteristics of the blade are here nominal characteristics, which do not take into account the actual geometry of the blade due to the manufacturing process or dispersion. In particular, due to the manufacturing process, thickness variations and/or bow, sweep, camber of some blade portions are possible, and are even intrinsic to the product.

[0091] Following parameters are defined:

t: thickness of the blade;

L: length of the blade from one lateral side 33 to another 33';

H: height of the blade, measured along direction Y, from the rear edge 54 to the cutting edge 26;

D: cantilever dimension, measured along direction Z, from the cutting edge 26 to the plane of the base portion (X-Y);

α : included angle, measured between the base portion plane and the cutting edge portion plane;

Hb: height of the blade base portion, measured along direction Y, from the rear edge 54 to the bent portion 53;

R: radius of curvature of the inner face of the bent portion;

Hc: Extent of the cutting edge portion, measured along direction U, from the cutting edge 26 to the bent portion 53;

T: period of the serrated edge;

T1: extent of the protrusion of the serration;

h: height of the serrated end.

[0092] According to the first embodiment, a suitable razor blade shows the following geometric properties:

Parameter	Nominal value	Dispersion	Parameter	Nominal value	Dispersion
T	0.1 mm		Hb	1.43 mm	
L	37.1 mm		R	0.6 mm	
H	2.33 mm		Hc	0.28-1.14 mm	
D	1.35 mm	+/-0.05 mm	T	5.3 mm	± 0.003 mm
A	108°	+/- 2°	h	0.13-0.32 mm	
			T1	2 mm	

[0093] This value indicated for Hc is in fact an average between the value measured for Hc on both lateral sides of the blade. Due to the deformation of the blade, these two values were different, amounting in average to 0.81 mm and 0.85 mm, respectively. Hc might extend between 0.28 and 1.14 mm, preferably between 0.4 and 1 mm.

[0094] Other embodiments were successfully manufactured, which showed satisfactory. According to a second embodiment, shown on Figs. 4a and 4b, the other parameters are alike, apart from $\alpha=112^\circ$, H = 2.4 mm, Hc = 0.96 mm.

[0095] Yet another embodiment is shown on Fig. 5. This embodiment differs from the second embodiment mainly by different values for T and T₁.

[0096] According to yet another embodiment, as shown on Figs. 6a and 6b, the rear edge is not serrated. The geometric datas for this embodiment are:

Parameter	Nominal value	Parameter	Nominal value
t	0.1 mm	Hb	1.57 mm
L	37.1 mm	R	0.6
H	2.58 mm	Hc	1.07
D	1.45 mm	α	112°

[0097] As shown on Fig. 7 below, a cutting plane (P) is defined for the head from the tangents to guard bar before the window receiving the blades and the cap behind it. Hence, upon shaving, a force will be applied to the blade by the user, along a direction F which is sensibly normal to the plane (P). The blades 24 are oriented in the head 5 such that the cutting edge portion forms an angle with the cutting plane (P). In other words, the force F is applied sensibly in the Y direction at approximately $\pm 5^\circ$.

[0098] According to the first invention, tests have shown that, surprisingly, the above material provided a bent blade providing the best compromise between formability and cutting edge performance. In particular, the above material can be formed as a successful cutting edge of a razor blade, provided with current cutting edge processing including grinding, coating with a strengthening material and coating with a telomere layer. In addition, the above material can be formed as a successful bent region with enhanced consistency, high reproducibility, and without producing too much corrosion prone macro-cracks during manufacturing.

[0099] These tests were performed both for a head with a blade according to the first embodiment above, and for another blade with an angle α of 112°. It is expected that this material would provide improved behavior even when modifying other parameters of the blade. In particular, it is believed to be verified for α taken between 95° and 140°; preferably between 108° and 112°, R over 0.4 mm, preferably between 0.5 mm and 1 mm, t between 0.07 mm and 0.12 mm, preferably between 0.095 mm and 0.105 mm, Hc between 0.28 mm and 1.14 mm, preferably between 0.4 mm and 1.0 mm. The thus obtained blade may also be used fixed in a razor head, if necessary.

[0100] According to the second invention, with the blade edge portion 39 being supported only by the two springs 44, the shaving force being applied along direction F therebetween, and the base portion constrained to move parallel to the X-Y plane, the dimension D has proven to be a critical dimension of the blade.

[0101] Tests have shown that an optimum can be reached when the D dimension is selected between 1.1 mm and 1.8 mm. If D exceeded 1.8 mm, the blade would be submitted to large deflection during shaving, thereby reducing shaving performance. Head rinsability would also be reduced. Further, there would be a risk of appearance of macro-cracks in the blade, notably in the inner face of the bent region, and/or permanent deformation of the blade. Macro-cracks ought to be avoided, because they are a preferred site for the corrosion of the blade. Permanent deformation ought to be avoided, because it would negatively affect shaving performance. When D becomes lower than 1.1 mm handling and manufacturability are dramatically impaired. There is a risk of damaging the cutting edge during handling and head manufacture. Further, applying a suitable spring force on the blade becomes difficult.

[0102] These tests were performed for a head with a blade according to the first embodiment above, but it is expected that heads provided with movable blades guided along their base portion axis, and with the selected D dimension would provide improved performance, even when modifying other parameters of the blade, such as its material, or other geometrical parameters. In particular, it is believed to be verified when the distance between the two contact points of the blade to the springs is between 22 and 30 mm, preferably between 25 and 27 mm, when α is taken between 95° and 140°, preferably between 108° and 112°, R over 0.4 mm, preferably between 0.5 mm and 1 mm, t between 0.07 mm and 0.12 mm, preferably between 0.095 and 0.105 mm, Hc between 0.4 mm and 1.0 mm, preferably between 0.81 mm and 0.85 mm. Such a preferential behaviour is also expected to be met for bent blades with lower carbon range, for example from 0.5% carbon in weight.

[0103] According to the third invention, tests have shown that an optimum can be reached when the R dimension is selected over 0.5 mm, preferably over 0.55 mm. The R dimension is preferably lower than 1 mm. In other words, the radius of curvature of the outer face at the bent portion is at least 0.57 mm. The median radius of curvature at the bent portion is at least 0.535 mm. Indeed, when the radius of curvature is lower than that, it is difficult to manufacture the blade without generating high stresses which would cause the appearance of macro-cracks in the bent region.

[0104] These tests were performed for a blade according to the first embodiment above, but it is expected that the above would remain true even when modifying other parameters of the blade. In particular, it is believed to be verified for α taken between 95° and 140°, preferably between 108° and 112°, t between 0.07 mm and 0.12 mm, preferably between 0.095 and 0.105 mm. The thus obtained blade may also be used fixed in a razor head, if necessary.

[0105] Fig. 10 now schematically shows an example of a process for the manufacture of the above bent blades.

[0106] At step 101, one provides a strip of suitable material. The material is for example stainless steel in ferritic form

with secondary carbides, and having the above composition. A strip is any kind of product suitable to be manufactured into a bent blade as above. For example, the strip 56 is shown on Fig. 8a. It is substantially straight. It has the thickness of the future razor blade. It has the length L of the future razor blade. Along the transverse height direction, it comprises, from top to bottom on Fig. 8a, a cutting edge portion 57, a to-be-bent portion 58, a base portion 59, and a removable portion 60. The cutting edge portion 57, the to-be-bent portion 58 and base portion 59 together define a blade portion of the strip. Notches 61 are provided, which extend oblongly along the long direction, between the base portion 59 and the removable portion 60.

[0107] In particular, the notches 61 are shaped to receive transport fingers of the manufacture apparatus, in order to transport the strip from one station to another, along the manufacturing line, and to hold the strip in respective stations, as will be explained below in relation to Fig. 11.

[0108] At step 102, a metallurgical hardening process 102 is performed on the strip. This process initiates martensitic transformation of the steel.

[0109] At step 103, the top edge of the strip, which is to become the cutting edge, i.e. the edge of the strip which belongs to the cutting edge portion 57, is shaped as the cutting edge of a razor blade. This shaping is a sharpening process performed by grinding the edge to the acute required geometry. The cutting edge is defined by convergent faces which taper toward a tip having an angle of about 10° - 30° .

[0110] At step 104, a strengthening coating is applied on the ground cutting edge. For example, the ground blades are stacked in a stack, with their cutting edges all oriented in the same direction, and a strengthening coating is applied thereto. The strengthening coating will comprise one or more layers with different characteristics. The layers may comprise one or more of metal(s) (notably chromium or platinum) and carbon (possibly in DLC form). This coating is for example deposited by sputtering. Sputtering may also be used to precisely shape the geometry of the cutting edge before or after coating. The global geometry of the cutting edge is maintained at this step.

[0111] At step 105, a telomere coating is applied on the blade edge. A suitable telomere is for example a PTFE. A suitable deposition method is spraying.

[0112] What is referred to as being the blade body is the part of the blade which is made of steel, exclusive the coatings.

[0113] At step 106, a bending step is applied on the up-to-now straight strip. At the bending step 106, one part of the strip is held, and a force is applied on the other part, so as to provide the strip with a bent portion 63, as shown on Fig. 8b. After this step, the cutting edge portion 57 is angled with respect to the base portion by sensibly the above angle α . Permanent deformation is imparted on the bent portion. Bending could for example be performed by stamping. Alternately, bending could be done by a number of other suitable methods. A method which reduces the generation of macro-cracks in the strip, notably to its bent portion, is preferred.

[0114] Due to the natural characteristics of the material, the bent strip exiting from this step will not have the nominal geometry described above. In particular, it will exhibit some degree of camber, bow or sweep. Further, due to the material's mechanical properties, the dispersion of the geometry of the products can be large. This is particularly the case when the process used for applying the bending is only mildly severe to the strip (in order to avoid appearance of cracks). In such case, the amount of spring-back of the material after deformation is high and hardly predictable.

[0115] According to the fifth invention, at step 107, a straightening step is performed. At this step, a forming process is used in order to reduce the dispersion in the geometry of products. In particular, permanent deformation is applied on the inner face of the bent portion of the strip. This permanent deformation straightens the overall blade, and reduces the dispersion in blade geometry among the products.

[0116] As an example, as shown on Fig. 9, a straightening station 70 comprises a support 71 to receive the bent strip 72. For example, the support 71 has a V-shaped groove 73 having an included angle corresponding to the nominal angle for the bent blade. The bent strip is placed in the groove 73 with its outer surface resting on the arms of the V-shaped groove. It may be maintained there by any suitable means, such as by vacuum suction or the like. A deformation tool 74 is placed above the groove 73. The deformation tool 74 has a base 75 receiving a carriage 76 movably mounted with respect to the base 75 along the length direction of the strip (transverse to the plane of Fig. 9). The carriage 76 bears a pressure-application tip 77. The position of the pressure-application tip 77 with respect to the carriage 76 is settable, so as to bring the pressure-application tip at controlled distance to the base 71. The distance between the edge of the tip 77 and the groove 73 will determine the level of pressure applied by the tip to the strip.

[0117] The pressure-application tip may comprise a support 78 receiving a spring-loaded ball 79 at its edge. The ball has dimensions of the order of the bent portion of the strip. The support 78 allows rotation of the ball 79 therein.

[0118] Upon use, the tip 77 is held in an upper position until a strip is placed in the groove 73. The tip 77 is moved down until the ball 79 contacts the bent portion of the strip with suitable pressure. The ball 79 does not contact the straight portions of the strip. The contact is made at one lateral side of the strip. Then, the carriage 76 is moved with respect to the base 75 along the length of the strip until the other lateral side, to form the bent portion of the strip. The ball rolls during this movement. Possibly, this movement is performed back-and-forth. The tip 77 is then moved again to its up position, to remove the straightened strip from the straightening station 70.

[0119] The formed strip is controlled. For example, its geometry is measured with a suitable measurement apparatus.

These measurements enable to set the level of pressure applied by the tip for straightening steps on future products.

[0120] Back to Fig. 10, a cutting step 108 is performed. At this step, the removable portion 60 is removed, to result in the final bent blade. According to a fourth invention, it is made use of the notches 61 which are provided between the base portion and the removable portion of the blade, to remove the removable portion. It enables to remove the removable portion by imparting minimal stress on the bent blade, thus minimizing the level of permanent deformation applied to the bent blade, and potentially affecting its geometry. Further, as the cut part surface is minimized, initiation of corrosion is also reduced to the small cut area.

[0121] Cutting can be performed in a cutting station 80 partially shown on Fig. 11. The station 80 has a base 81 from which two lateral pins 82 extend. The pins 82 are shaped to enter in corresponding notches 61 of the strip, and together precisely locate the strip in the station. Vacuum may additionally be used to retain the strip in the station by suction. The strip, at various stages of its manufacture, can be held in manufacturing stations, and/or moved from one station to the next, using similar principles.

[0122] In various embodiments, the order in which some of the above steps are implemented may be changed.

EMBODIMENTS

[0123] Although the present invention is defined in the attached claims, it should be understood that the present invention can also (alternatively) be defined in accordance with the following embodiments:

1. An integrally formed rigid razor blade having a body with:

- a cutting edge portion extending about a cutting edge portion plane, and having a cutting edge at one end,
- a base portion extending along a base portion plane,

- a bent portion intermediate the cutting edge portion and the base portion,

and wherein the body is made of martensitic stainless steel comprising mainly iron and between 0.62% and 0.75% of carbon in weight.

2. Razor blade according to embodiment 1, further having at least one of the following components, in weight:

between 12.7% and 13.7% Chromium,
between 0.45% and 0.75% Manganese,

- between 0.20% and 0.50% silicon.

3. Razor blade according to embodiment 1 or 2 having no more than traces of Molybdenum.

4. Razor blade according to any of embodiments 1 to 3, further having at least one of the following geometrical parameters:

an included angle measured between the cutting edge portion plane and the base portion plane is between 95° and 140°, preferably between 108° and 112°;

the blade has an inner face and an opposed outer face which are not corrugated;

the blade has an inner face and an opposed outer face, and extends between a first lateral side and a second lateral side along a long axis, and the bent portion has, in cross-section transverse to the long axis, a radius of curvature over 0.4 mm, preferably between 0.5 mm and 1 mm;

the blade has an inner face and an opposed outer face, and a thickness, measured between said faces, between 0.7 mm and 0.12 mm, preferably between 0.095 mm and 0.105 mm.

5. Razor blade according to any of embodiments 1 to 4, wherein the cutting edge further has convergent faces which taper toward a tip having an included angle between 10° and 30°.

6. Razor blade according to any of embodiments 1 to 5, wherein the cutting edge of the body further supports a hardening coating and a lubricating coating.

7. A razor head comprising:

a housing having a top face defining a shaving window, and an opposed stopping face, the housing further comprising two lateral sides each provided with at least one slot and at least one biasing support,

- at least one razor blade according to any of embodiments 1 to 6, each freely mounted in the housing,

wherein the base portion cooperates with the slot so that each blade is independently translatable with respect to the housing along a sliding direction, under the effect of shaving forces applied to the blade during shaving, wherein the biasing device cooperates with the blade to bias the blade until the cutting edge portion abuts on the stopping face of the housing, and in opposition to the shaving forces.

8. A razor head comprising:

a housing having a top face defining a shaving window, and an opposed stopping face, the housing further comprising at least one guide,

at least one integrally formed rigid razor blade, each freely mounted in the housing, and having:

- a cutting edge portion extending along a cutting edge portion axis, and having a cutting edge accessible through the shaving window,
- a guided portion extending along a guided portion axis, and
- a bent portion intermediate the cutting edge portion and the guided portion,

wherein the cantilever dimension, measured as the distance between the cutting edge and the guided portion axis, is between 1.1 millimeter and 1.8 millimeter,

wherein the guided portion cooperates with the guide so that each blade is independently translatable with respect to the housing along a sliding direction parallel to the guided portion axis, under the effect of shaving forces applied to the blade during shaving.

9. Razor head according to embodiment 8, wherein the housing further comprises at least one biasing device, wherein the cutting edge portion has a top face, wherein the biasing device cooperates with the blade to bias the blade until the top face of the cutting edge portion abuts on the stopping face of the housing, and in opposition to the shaving forces.

10. Razor head according to embodiment 9, wherein the housing has two lateral sides, wherein the biasing device comprises an elastic support provided in each lateral side, wherein each elastic support has a contact portion contacting the blade, wherein a distance between the two contact portions is between 22 mm and 30 mm, preferably between 25 mm and 27 mm.

11. Razor head according to any of embodiments 8 to 10, wherein each blade is made of martensitic stainless steel.

12. Razor head according to any of embodiments 8 to 11, wherein the blade further has at least one of the following geometrical parameters:

an included angle measured between the cutting edge portion axis and the base portion axis is between 95° and 140°, preferably between 108° and 112°;

the blade has an inner face and an opposed outer face which are not corrugated;

the blade has an inner face and an opposed outer face, and extends between a first lateral side and a second lateral side along a long axis, and the bent portion has, in cross-section transverse to the long axis, a radius of curvature over 0.4 mm, preferably between 0.5 mm and 1 mm

- the blade has an inner face and an opposed outer face, and a thickness, measured between said faces, between 0.07 mm and 0.12 mm, preferably between 0.095 mm and 0.105 mm;

the extent of the cutting edge portion along the cutting edge portion axis is between 0.4 mm and 1.0 mm, preferably between 0.81 millimeter and 0.85 mm.

13. Razor head according to any of embodiments 8 to 12, wherein the top face comprises a guard bar before said at least one blade and a cap beyond said at least one blades, wherein said guard bar and cap define a shaving plane, and wherein an angle between the shaving plane and the guided portion axis is between 85° and 95°.

14. Razor head according to any of embodiments 8 to 13, wherein wherein the cantilever dimension is between 1.3 millimeter and 1.4 millimeter.

15. An integrally formed rigid razor blade made of martensitic stainless steel and having in cross-section:

a cutting edge portion extending along a cutting edge portion axis, and having a cutting edge at one end,
a base portion extending along a base portion axis,
a bent portion intermediate the cutting edge portion and the base portion,
said blade having a concave face and an opposed convex face,
and wherein the average radius of curvature of the bent portion at its concave face is between 0.5 millimeter and 1 mm.

16. A blade according to embodiment 15, further having at least one of the following geometrical parameters:

- an included angle measured between the cutting edge portion axis and the base portion axis is between 95° and 140°, preferably between 108° and 112°;

the blade has an inner face and an opposed outer face which are not corrugated;

- the blade has an inner face and an opposed outer face, and a thickness, measured between said faces, between 0.07 mm and 0.12 mm, preferably between 0.095 mm and 0.105 mm.

17. A blade according to embodiments 15 or 16, wherein the average radius of curvature of the bent portion at its inner face is over 0.55 millimeter.

18. A blade according to any of embodiments 15 to 17, wherein the average radius of curvature of the bent portion at its outer face is over 0.57 millimeter.

19. A blade according to any of embodiments 15 to 18, wherein the average medial radius of curvature of the bent portion is over 0.535 millimeter.

20. A blade according to any of embodiments 15 to 19, wherein the martensitic stainless steel comprises, in weight:

between 0.50% and 0.75% of carbon, preferably between 0.62% and 0.75% of carbon,
between 12.7% and 13.7% Chromium,
between 0.45% and 0.75% Manganese,

- between 0.20% and 0.50% silicon,

traces of other components,
balance iron.

21. A method of manufacturing an integrally formed razor blade comprising:

- providing a strip having, in cross-section transverse to a long axis, a blade portion and a removable portion, wherein weakening holes are provided along the long axis between the blade portion and the removable portion,
- separating the blade portion from the removable portion by breaking the strip at the weakening holes,

providing the razor blade with a profile having:

a cutting edge portion extending along a cutting edge portion axis, and having a cutting edge at one end,
a base portion extending along a base portion axis, and having an abutment edge at one end, a bent portion intermediate the cutting edge portion and the guided portion,
wherein the abutment edge is corrugated along the long axis, with corrugations with a height of at most 0.32 millimeters.

22. Method according to embodiment 21, wherein the blade portion of the strip is provided with said geometry.

23. Method according to embodiment 21 or 22 wherein, before separating, the strip is held in a processing station having a fixed base, a tool movable with respect to the fixed base for processing the strip, and locating pins movable with respect to the fixed base between a holding position where the pins pass through the holes to hold the strip in the station, and a release position where the pins do not cooperate with the strip, thereby allowing the strip to be removed from the station.

24. An integrally formed rigid razor blade having in cross-section transverse to a long axis:

- a cutting edge portion extending along a cutting edge portion axis, and having a cutting edge at one end,
- a base portion extending along a base portion axis, and having an abutment edge at one end,
- a bent portion intermediate the cutting edge portion and the guided portion,

wherein the abutment edge is corrugated along the long axis, with corrugations with a height of at most 0.32 millimeters.

25. An integrally formed rigid razor blade strip having in cross-section transverse to a long axis:

- a cutting edge portion extending along a cutting edge portion axis, and having a cutting edge at one end,
- a base portion extending along a base portion axis,
- a bent portion intermediate the cutting edge portion and the guided portion,
- a removable portion having a back edge, wherein the base portion is intermediate between the bent portion and the removable portion,
- wherein weakening holes are provided along the long axis between the base portion and the removable portion.

26. A method of manufacture of an integral bent blade for a mechanical shaver, comprising:

- providing a flat strip of metal extending from a first edge to an opposite edge,

bending the flat strip along a bending axis parallel to the first edge to result in an integrally bent product having opposed inner and outer faces, and comprising :

- a cutting edge portion extending along a cutting edge portion axis, and having the first edge at one end,
- a base portion extending along a base portion axis, and having the opposite edge at one end,
- a bent portion intermediate the cutting edge portion and the base portion,
- after bending, applying a mechanical stress on the inner face of the bent portion.

27. Method according to embodiment 26, wherein the bent blade has two opposed lateral sides, and wherein applying a mechanical stress comprises moving a forming tool from one lateral side to the other.

28. Method according to embodiment 27, wherein the forming tool has a base and a tip, and wherein the tip rolls with respect to the base as the forming tool is moved from one lateral side to the other.

29. Method according to any of embodiments 26 to 28, wherein applying a mechanical stress comprises retaining the outer face in a retention station.

Claims

1. An integrally formed rigid razor blade made of martensitic stainless steel and having in cross-section:

- a cutting edge portion extending along a cutting edge portion axis, and
- having a cutting edge at one end,
- a base portion extending along a base portion axis,
- a bent portion intermediate the cutting edge portion and the base portion,
- said blade having a concave face and an opposed convex face,
- and wherein the average radius of curvature of the bent portion at its concave face is over 0.5 millimeter and

lower or equal than 0.6 mm.

- 5
2. A blade according to claim 1, wherein the average radius of curvature of the bent portion at its concave face is lower or equal than 0.55 mm.
- 10
3. A blade according to claim 1 or claim 2, wherein an included angle measured between the cutting edge portion axis and the base portion axis is between 95° and 140°.
4. A blade according to claim 3, wherein the included angle measured between the cutting edge portion axis and the base portion axis is between 108° and 112°.
- 15
5. A blade according to any one of the preceding claims, wherein the blade has an inner face and an opposed outer face which are not corrugated.
6. A blade according to any one of the preceding claims, wherein the blade has an inner face and an opposed outer face, and a thickness, measured between said faces, between 0.07 mm and 0.12 mm.
- 20
7. A blade according to any of claims 1 to 6, wherein the average medial (median?) radius of curvature of the bent portion is over 0.535 millimeter.
8. A blade according to any of claims 1 to 6, wherein the median radius at the bent portion is 0.535 mm.
9. A blade according to any of claims 1 to 8, wherein an extent of the cutting edge portion is between 0.4 mm and 1 mm.
- 25
10. A razor head comprising at least one integrally formed rigid razor blade according to any one of claims 1 to 9.

30

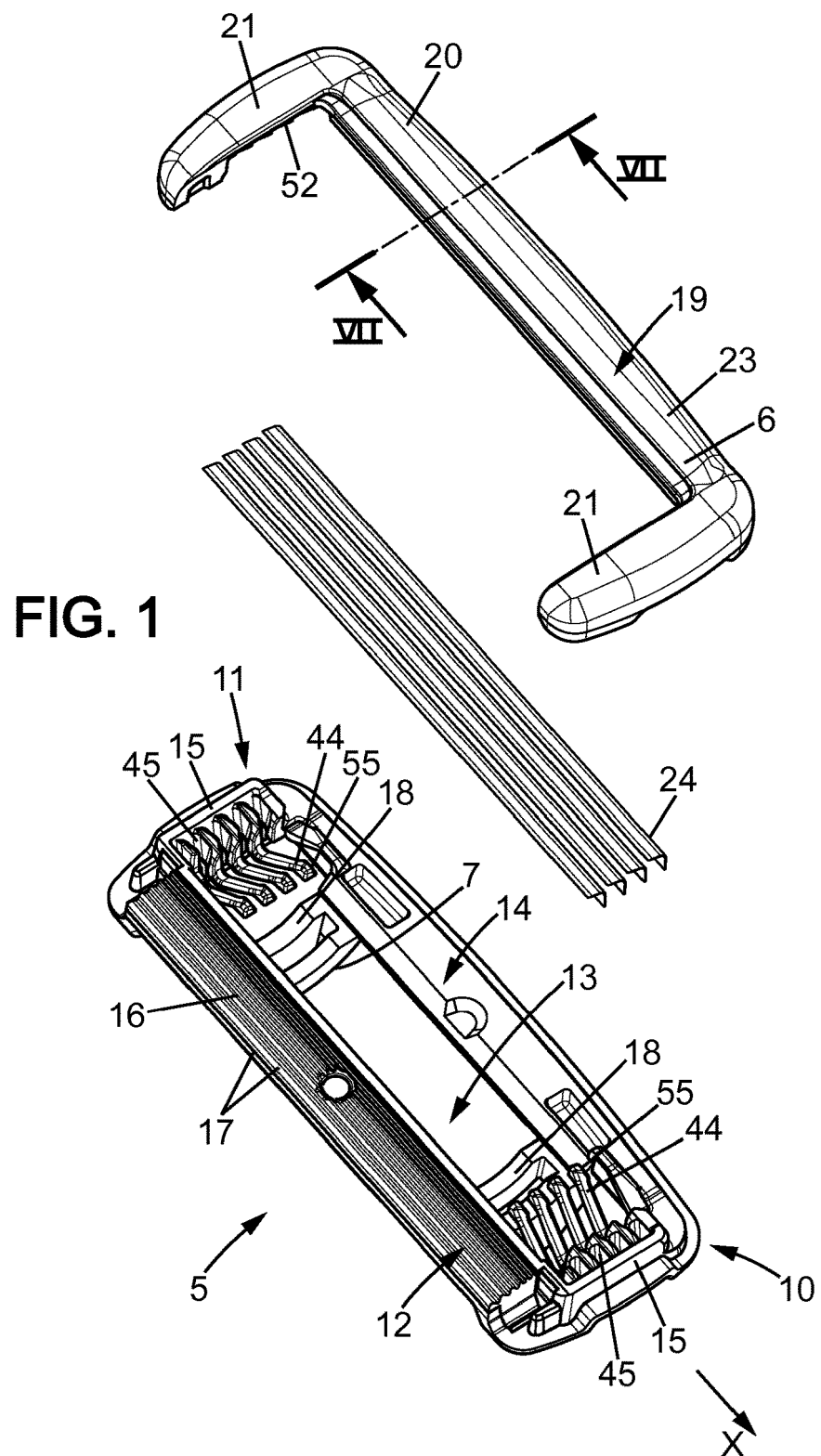
35

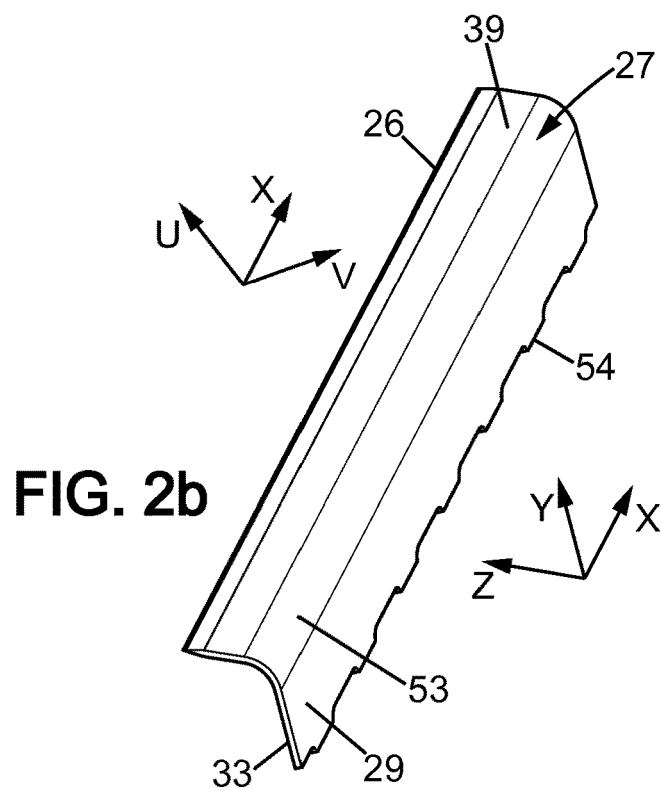
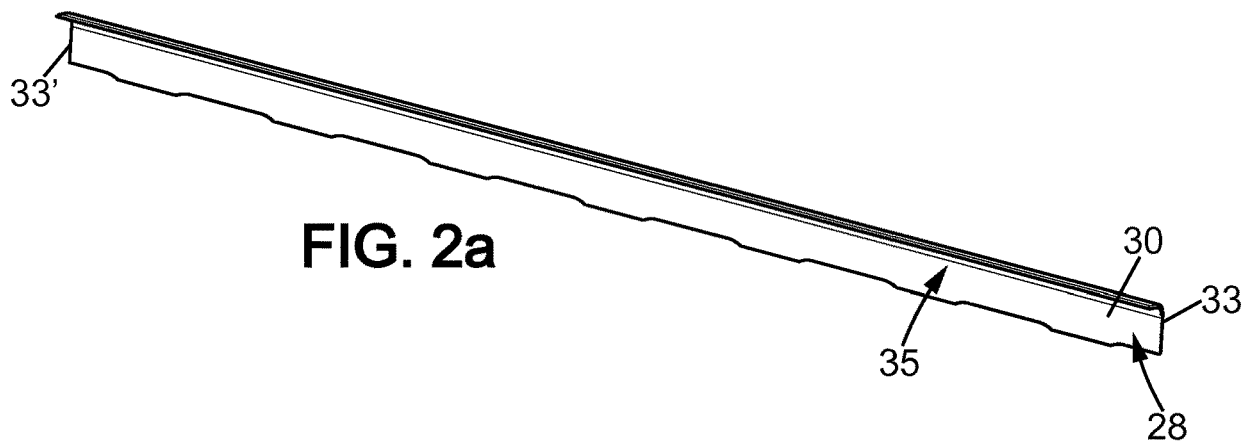
40

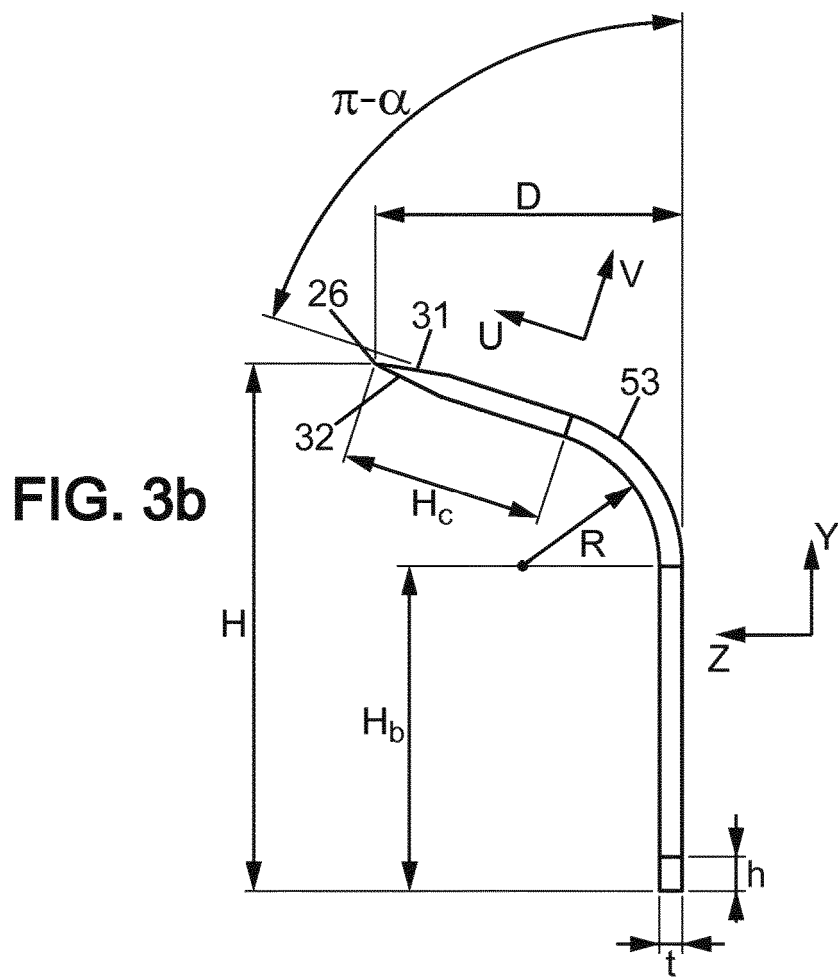
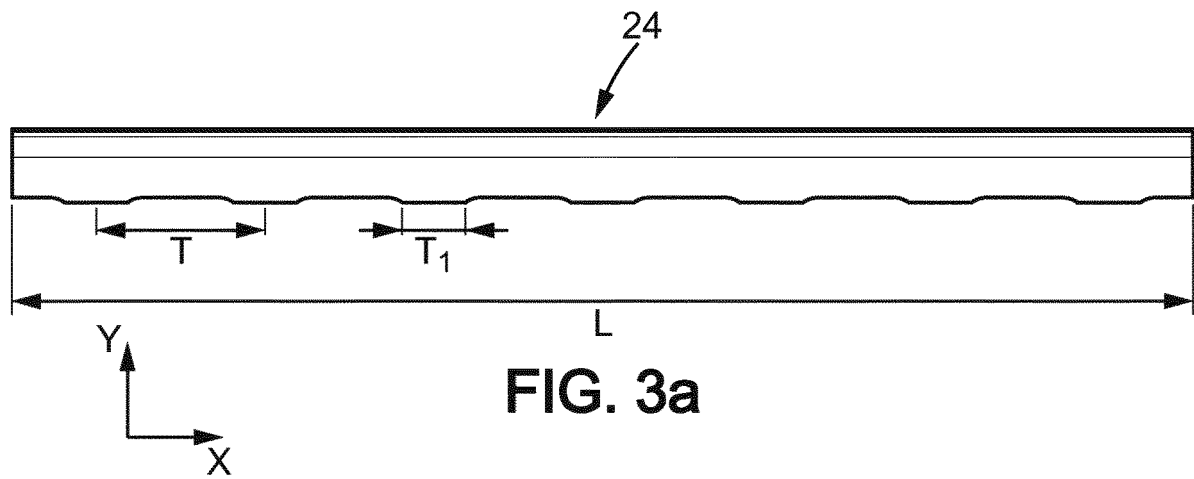
45

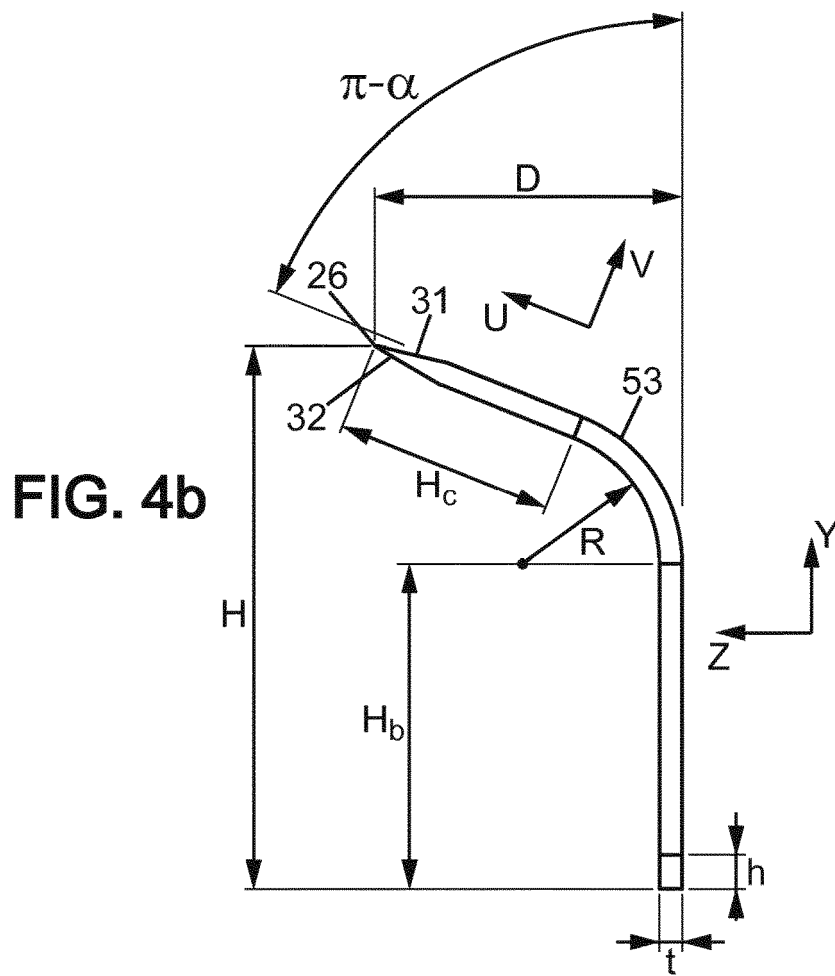
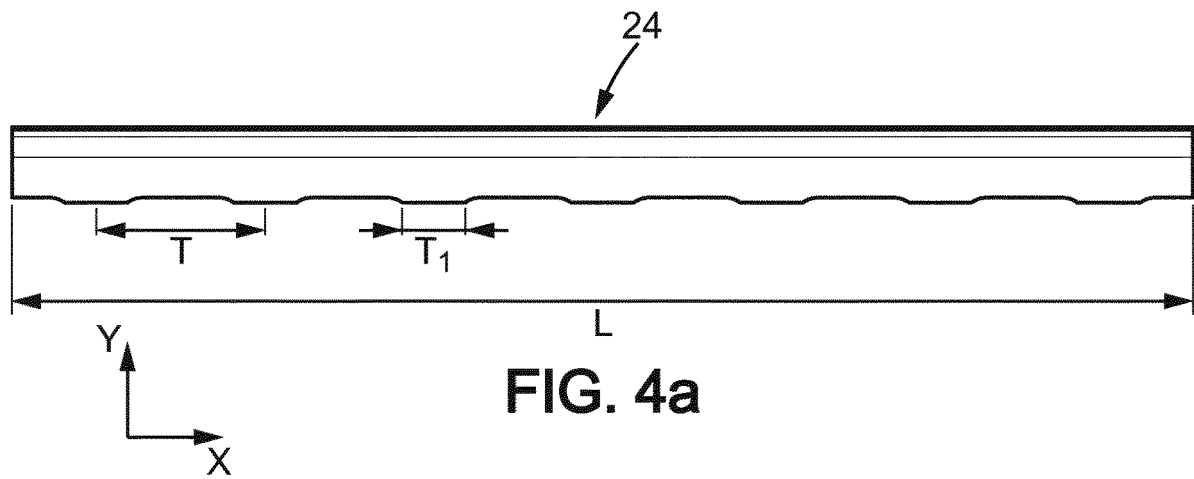
50

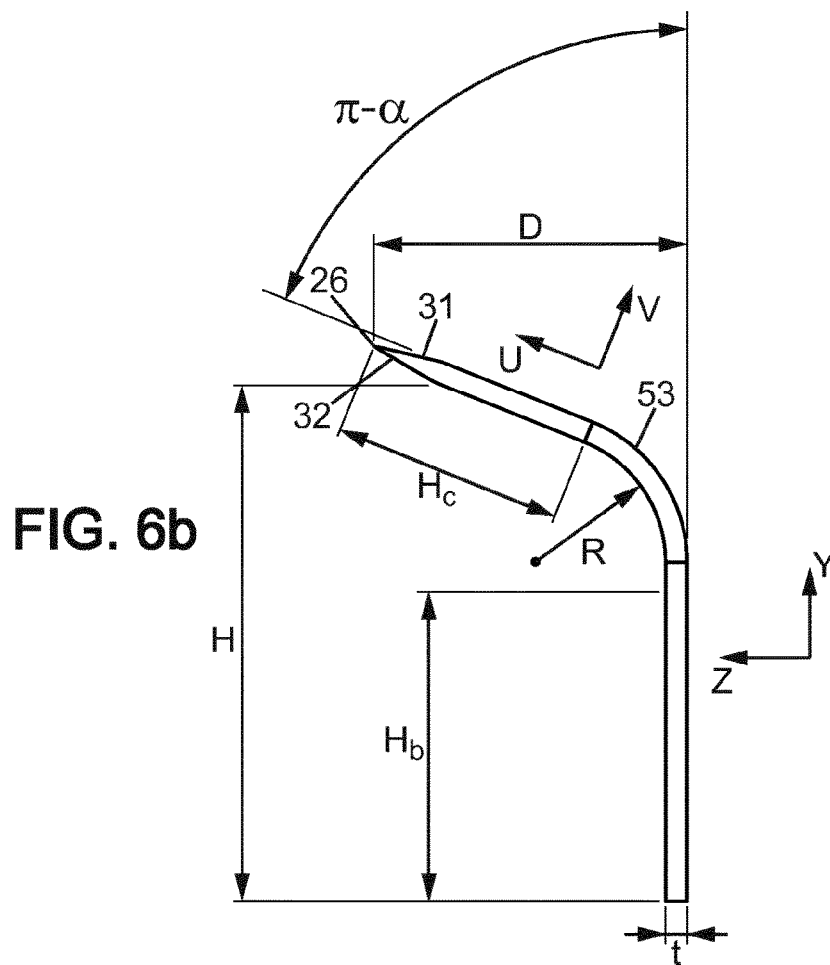
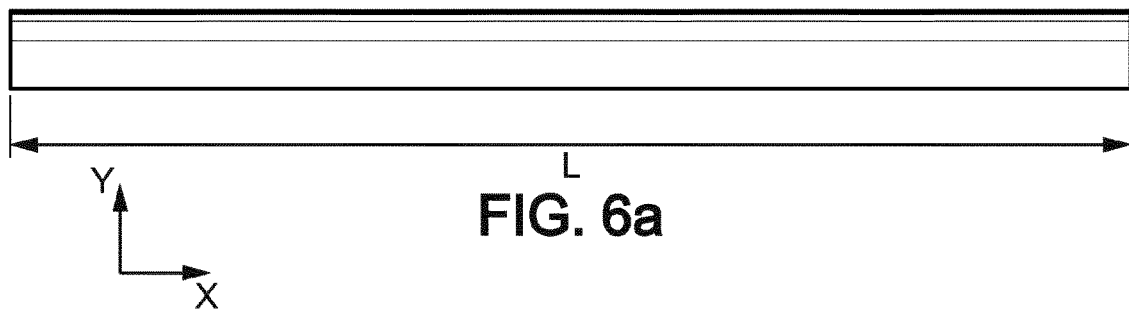
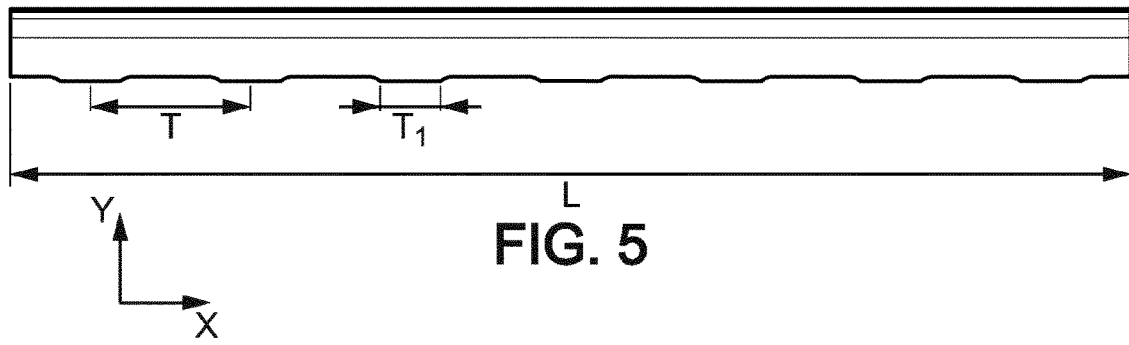
55

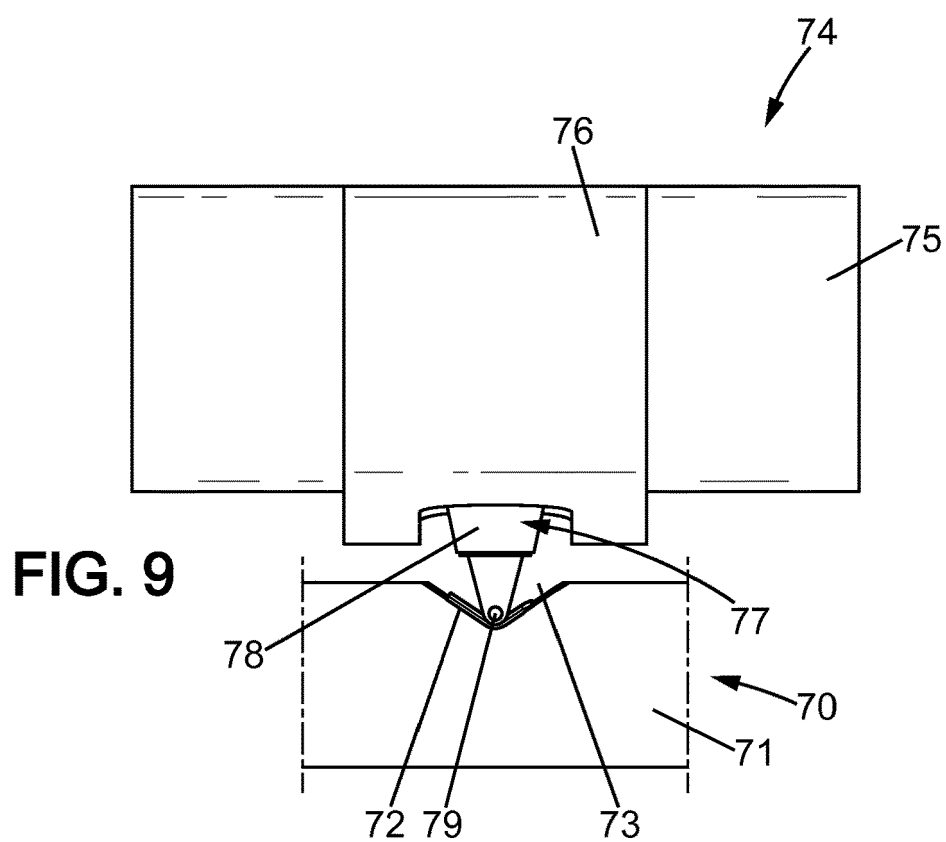
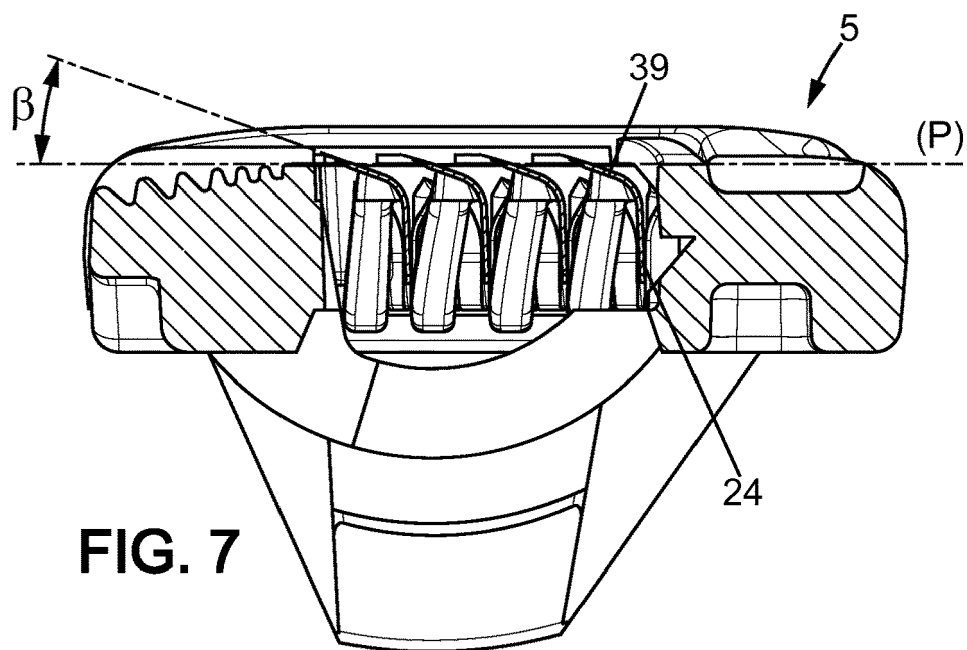


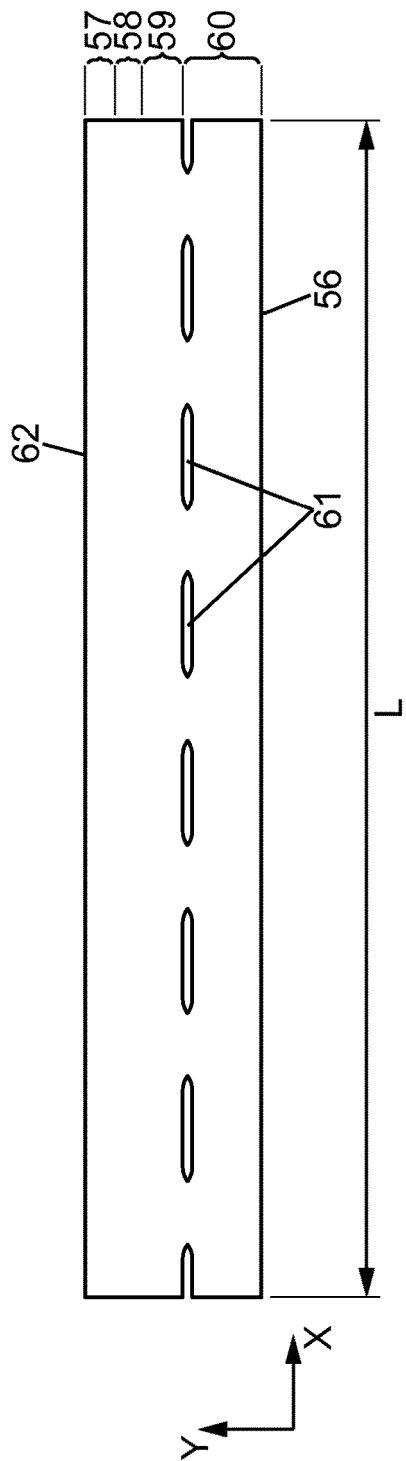












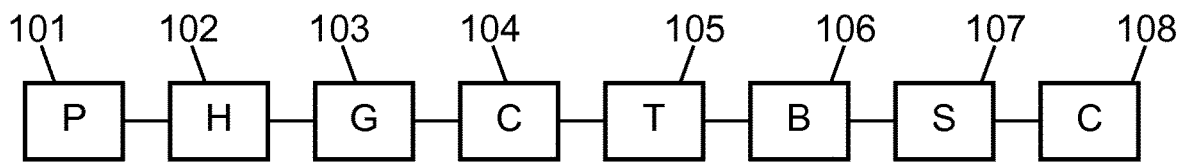


FIG. 10

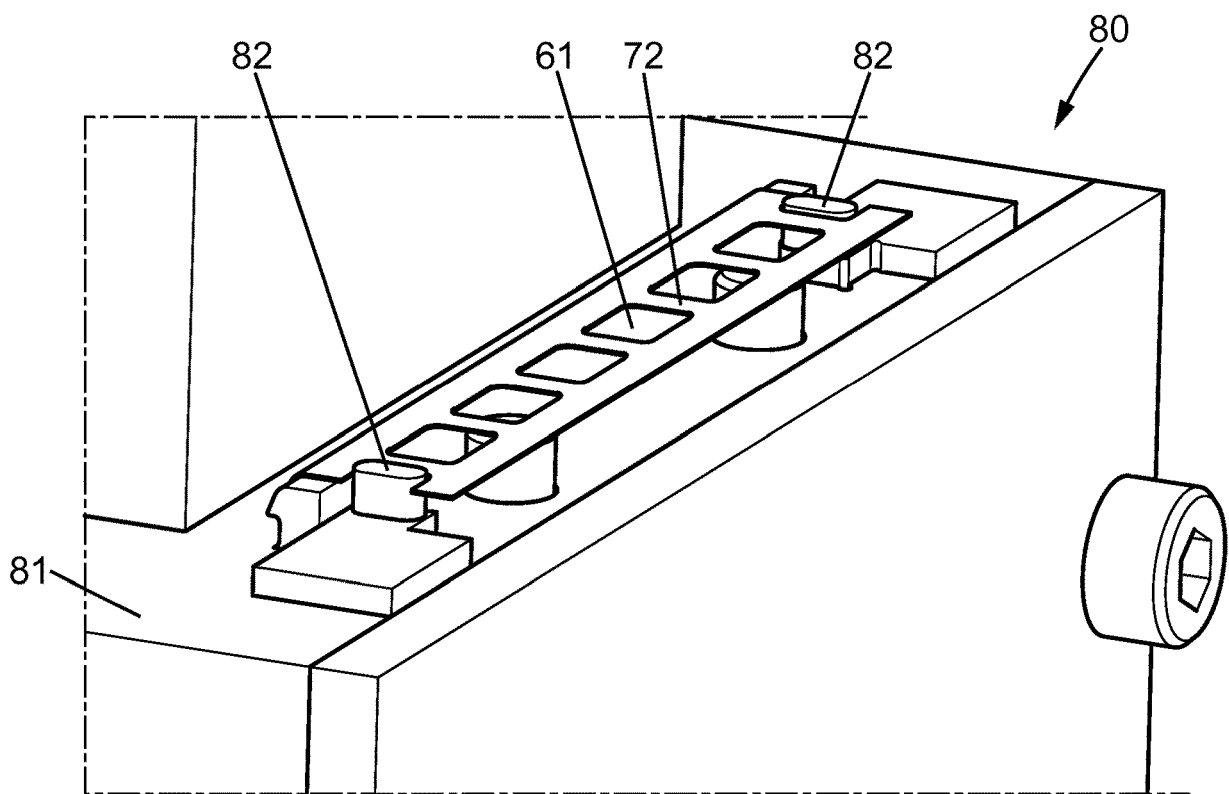


FIG. 11



EUROPEAN SEARCH REPORT

 Application Number
 EP 18 16 9778

5

10

15

20

25

30

35

40

45

50

55

1

EPO FORM 1503 03.82 (P04C01)

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
X	WO 2009/137389 A1 (EVEREADY BATTERY INC [US]; BYKOWSKI HENRYK [DE]; FISCHER STEPHAN [DE];) 12 November 2009 (2009-11-12)	1-8,10	INV. B26B21/56 B26B21/22 B26B21/40
Y	* page 5, line 19 - page 6, line 12; figures 1-3, 7 * * page 8, lines 19-24 *	9	
Y	US 5 010 646 A (NEAMTU NICOLAE [US]) 30 April 1991 (1991-04-30) * column 3, lines 9-14; figure 4 *	9	
X,P	WO 2012/006043 A1 (GILLETTE CO [US]; PETERSON MARK [GB]) 12 January 2012 (2012-01-12) * page 4, line 22 - page 5, line 27; figures 2-4 * * page 7, lines 20-21 * * page 9, lines 12-15 *	1-10	
A	US 5 275 672 A (ALTHAUS WOLFGANG [DE] ET AL) 4 January 1994 (1994-01-04) * column 1, lines 31-40 *	1-10	TECHNICAL FIELDS SEARCHED (IPC)
A	US 5 433 801 A (ALTHAUS WOLFGANG [DE] ET AL) 18 July 1995 (1995-07-18) * column 1, lines 35-44 *	1-10	B26B
The present search report has been drawn up for all claims			
Place of search Munich		Date of completion of the search 7 August 2018	Examiner Rattenberger, B
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

**ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.**

EP 18 16 9778

5

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
The members are as contained in the European Patent Office EDP file on
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

07-08-2018

10

15

20

25

30

35

40

45

50

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
WO 2009137389	A1	12-11-2009	AU 2009244489 A1	12-11-2009
			EP 2276591 A1	26-01-2011
			JP 5592875 B2	17-09-2014
			JP 2012525858 A	25-10-2012
			US 2010107425 A1	06-05-2010
			US 2012132036 A1	31-05-2012
			US 2016167104 A1	16-06-2016
			WO 2009137389 A1	12-11-2009

US 5010646	A	30-04-1991	AT 120999 T	15-04-1995
			BR 9104187 A	03-03-1992
			CA 2047171 A1	27-07-1991
			CN 1055690 A	30-10-1991
			DE 69108799 D1	18-05-1995
			DE 69108799 T2	23-11-1995
			DK 0465634 T3	08-05-1995
			EP 0465634 A1	15-01-1992
			ES 2071300 T3	16-06-1995
			GR 3015775 T3	31-07-1995
			JP 3214853 B2	02-10-2001
			JP H04506470 A	12-11-1992
			TR 25511 A	01-05-1993
			US 5010646 A	30-04-1991
			WO 9111300 A1	08-08-1991

WO 2012006043	A1	12-01-2012	BR 112012032115 A2	08-11-2016
			CN 102958626 A	06-03-2013
			EP 2588259 A1	08-05-2013
			RU 2012152272 A	10-08-2014
			US 2011314678 A1	29-12-2011
			WO 2012006043 A1	12-01-2012

US 5275672	A	04-01-1994	DE 69011118 D1	01-09-1994
			EP 0485641 A1	20-05-1992
			HK 78795 A	26-05-1995
			JP 2811511 B2	15-10-1998
			JP H05117805 A	14-05-1993
			US 5275672 A	04-01-1994
			US 5433801 A	18-07-1995

US 5433801	A	18-07-1995	DE 69011118 D1	01-09-1994
			EP 0485641 A1	20-05-1992
			HK 78795 A	26-05-1995
			JP 2811511 B2	15-10-1998
			JP H05117805 A	14-05-1993
			US 5275672 A	04-01-1994

EPO FORM P0459

For more details about this annex : see Official Journal of the European Patent Office, No. 12/82

55

07-08-2018

EPO FORM P0459

page 2 of 2

REFERENCES CITED IN THE DESCRIPTION

This list of references cited by the applicant is for the reader's convenience only. It does not form part of the European patent document. Even though great care has been taken in compiling the references, errors or omissions cannot be excluded and the EPO disclaims all liability in this regard.

Patent documents cited in the description

- WO 2007147420 A [0005] [0017] [0031] [0044] [0055]
- WO 2011008851 A [0005]
- US 2007234577 A [0007] [0008] [0033] [0034] [0046] [0048] [0057] [0058]
- US 2007124939 A [0009]
- US 4621424 A [0020]
- US 5010646 A [0021]
- WO 201106760 A [0035]
- WO 2006027018 A [0067] [0071]
- WO 201006654 A [0073]