



- (51) International Patent Classification:
B23B 27/04 (2006.01) B23B 29/04 (2006.01)
- (21) International Application Number:
PCT/IL2012/050507
- (22) International Filing Date:
5 December 2012 (05.12.2012)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data:
61/582,756 3 January 2012 (03.01.2012) US
- (71) Applicant: ISCAR LTD. [IL/IL]; P.O. Box 11, 24959 Tefen (IL).
- (72) Inventor: HECHT, Gil; 30/18 Ahad Ha'am Street, 22443 Nahariya (IL).
- (74) Agent: ISCAR LTD.; Patent Department, P.O. Box 11, 24959 Tefen (IL).
- (81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM,

AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:
— with international search report (Art. 21(3))

(54) Title: CUTTING INSERT HAVING CURVED RAMPS FOR INSERTION INTO A TOOL HOLDER, CUTTING TOOL AND METHOD OF ASSEMBLY

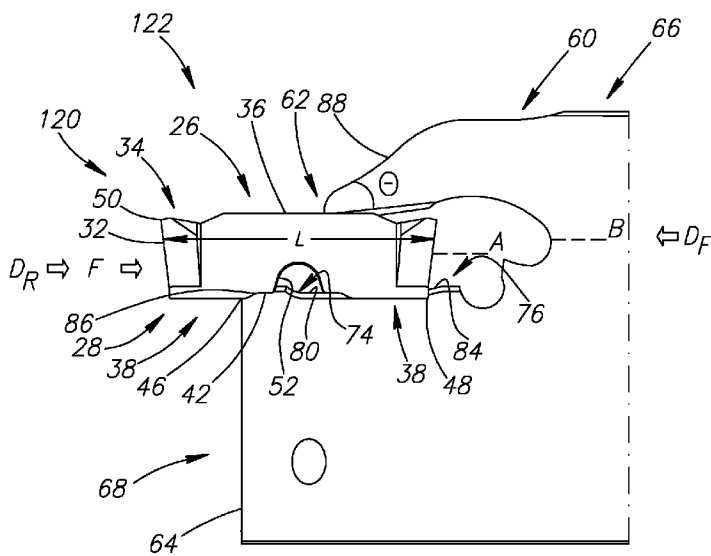


FIG.12

(57) Abstract: A cutting tool (20,120) used for grooving and turning operations where a cutting insert (22,122) is resiliently securable in a holder blade (24). The cutting insert (22,122) includes an insert central lower surface (42) located between, and recessed with respect to, two insert lower component surfaces (38), each having an insert lower abutment surface (40). At least one of the two insert lower component surfaces (38) includes an insert inner curved ramp (46) extending from its insert lower abutment surface (40) to the adjacent insert lower intermediate surface (44) and at least the other of the two insert lower component surfaces (38) includes an insert outer curved ramp (48) extending from its insert lower abutment surface (40) to an adjacent end surface (32).

WO 2013/105080 A1

**CUTTING INSERT HAVING CURVED RAMPS FOR INSERTION INTO A TOOL
HOLDER, CUTTING TOOL AND METHOD OF ASSEMBLY**

FIELD OF THE INVENTION

[001] The subject matter of the present application relates to grooving and parting cutting tools of the type in which a cutting insert is retained in a holder blade by means of a clamping force.

BACKGROUND OF THE INVENTION

[002] Cutting tools for grooving and parting can be provided with a clamping mechanism for securely retaining a cutting insert within a holder blade.

[003] The holder blade can consist of a base jaw and clamping jaw where the cutting insert is clamped within the base jaw and clamping jaw.

[004] A key can be provided to aid the insertion and removal of the cutting insert into, and out of, the holder blade.

[005] Examples of such cutting inserts are disclosed in US 4,573,832 and WO 2004/048020.

[006] An example of such a holder blade is disclosed in US 5,795,109.

[007] Examples of such cutting tools are disclosed in US 4,588,333, US 6,234,727, US 7,329,072 and US 7,331,096.

[008] In addition, various keys are disclosed in US 5,697,271 and EP 1007254.

[009] It is an object of the subject matter of the present application to provide a cutting tool having an improved means of resiliently clamping a cutting insert in an insert receiving pocket of a holder blade.

[0010] It is also an object of the subject matter of the present application to provide an improved cutting tool where an upper clamping jaw of the insert receiving pocket is resiliently displaced relative to an opposing lower base jaw solely by the action of urging the cutting insert into the insert receiving pocket.

SUMMARY OF THE INVENTION

[0011] In accordance with the subject matter of the present application, there is provided a cutting insert, longitudinally elongated in a direction defining an insert longitudinal axis, comprising:

opposing insert upper and lower surfaces and a peripheral surface extending therebetween, the peripheral surface comprising two opposing end surfaces, at least one of the end surfaces having an integral cutting portion; wherein

the insert upper surface comprises an insert upper abutment surface;

the insert lower surface comprises:

two longitudinally spaced apart insert lower component surfaces, each insert lower component surface having an insert lower abutment surface;

an insert central lower surface located between, and recessed with respect to, the two insert lower component surfaces;

an insert lower intermediate surface extending between the insert central lower surface and each insert lower component surface; wherein

at least one of the two insert lower component surfaces includes an insert inner curved ramp extending from its insert lower abutment surface to the adjacent insert lower intermediate surface and at least the other of the two insert lower component surfaces includes an insert outer curved ramp extending from its insert lower abutment surface in a direction of the adjacent end surface.

[0012] Also in accordance with the subject matter of the present application, there is provided a cutting tool, comprising:

a holder blade, having a holder longitudinal axis extending in a forward to rearward direction, comprising:

a body portion and a clamping portion;

the clamping portion having an insert receiving slot opening out to a holder front end surface of the holder blade, the insert receiving slot comprising:

an upper clamping jaw having a clamping jaw abutment surface and a lower base jaw having a base jaw lower surface, the upper clamping jaw being resiliently displaceable relative to the lower base jaw;

the base jaw lower surface comprising:

a front base jaw component surface adjacent the holder front end surface and a rear base jaw component surface rearwardly spaced apart from the front base jaw component surface, the front and rear base jaw component surfaces each comprising a holder lower abutment surface;

a base jaw central surface located between, and recessed with respect to, the front and rear base jaw component surfaces;

a holder lower intermediate surface, extending between the base jaw central surface and each base jaw component surface;

a cutting insert resiliently clamped between the upper clamping jaw and the lower base jaw; wherein

the insert upper abutment surface abuts the clamping jaw abutment surface, the insert lower abutment surface of the insert lower component surface closest to the operative cutting portion abuts the holder lower abutment surface of the front base jaw component surface, and the insert lower abutment surface of the insert lower component surface furthest from the operative cutting portion abuts the holder lower abutment surface of the rear base jaw component surface; and

at least the insert lower component surface closest to the operative cutting portion has an insert inner curved ramp, and at least the insert lower component surface furthest from the operative cutting portion has an insert outer curved ramp.

[0013] Also in accordance with the subject matter of the present application, there is provided a method for assembling a longitudinally elongated cutting insert in a holder blade, the holder blade, having a holder longitudinal axis extending in a forward to rearward direction, comprising;

a body portion and a clamping portion;

the clamping portion having an insert receiving slot opening out to a holder front end surface of the holder blade, the insert receiving slot comprising:

an upper clamping jaw and a lower base jaw;

the upper clamping jaw being resiliently displaceable relative to the lower base jaw,

the lower base jaw having a base jaw lower surface, the base jaw lower surface including a front base jaw component surface longitudinally spaced apart from a rear base jaw component

surface, with a base jaw central surface located between and recessed with respect to the front and rear base jaw component surfaces;

the cutting insert comprising:

opposing insert upper and lower surfaces extending substantially parallel to an insert longitudinal axis and a peripheral surface extending therebetween;

the insert lower surface having two longitudinally spaced apart insert lower component surfaces, with an insert central lower surface located between and recessed with respect to the two insert lower component surfaces; and

the peripheral surface having two opposing end surfaces defining a longitudinal insert length, at least one of the end surfaces having an integral cutting portion,

the method comprising the steps of:

positioning the cutting insert relative to the holder blade so that the insert longitudinal axis and the holder longitudinal axis are contained in a mutual main plane and the insert lower surface is in contact the base jaw lower surface;

sliding the cutting insert rearwardly until the upper clamping jaw undergoes resilient displacement; and

applying an urging force F to the cutting insert in the rearward direction D_R until the insert lower abutment surface of the insert lower component surface closest to the operative cutting portion abuts the holder lower abutment surface of the front base jaw component surface and the insert lower abutment surface of the insert lower component surface furthest from the operative cutting portion abuts the holder lower abutment surface of the rear base jaw component surface.

BRIEF DESCRIPTION OF THE FIGURES

[0014] For a better understanding of the present application and to show how the same may be carried out in practice, reference will now be made to the accompanying drawings, in which:

Fig. 1 is a perspective view of a cutting tool in accordance with a first embodiment of the present application;

Fig. 2 is an exploded perspective view of the cutting tool shown in Fig. 1;

Fig. 3 is a side view of the cutting insert shown in Fig. 2;

Fig. 4 is a detailed view of the cutting insert shown in Fig. 3;

Fig. 5 is an end view of the cutting insert shown in Fig. 2;

Fig. 6 is a side view of a cutting insert in accordance with a second embodiment of the present application;

Fig. 7 is a side view of another cutting insert in accordance with the first embodiment of the present application;

Fig. 8 is a side view of a holder blade shown in Fig. 2;

Fig. 9 is a detailed view of the holder blade shown in Fig. 8;

Fig. 10 is a side view of another holder blade suitable for clamping the cutting insert shown in Fig. 7;

Fig. 11 is a side view of the cutting tool with the cutting insert in a first position in accordance with the second embodiment of the present application;

Fig. 12 is a side view of the cutting tool with the cutting insert in a second position in accordance with the second embodiment of the present application;

Fig. 13 is a side view of the cutting tool with the cutting insert in a clamped position in accordance with the second embodiment of the present application;

Fig. 14 is a front view of the cutting tool with the cutting insert in a clamped position in accordance with the second embodiment of the present application; and

Fig. 15 is a side view of the cutting tool in accordance with the second embodiment of the present application, with a key positioned in an insert central lower recess.

[0015] It will be appreciated that for simplicity and clarity of illustration, elements shown in the figures have not necessarily been drawn to scale. For example, the dimensions of some of the elements may be exaggerated relative to other elements for clarity, or several physical components may be included in one functional block or element. Further, where considered appropriate, reference numerals may be repeated among the figures to indicate corresponding or analogous elements.

DETAILED DESCRIPTION OF THE INVENTION

[0016] In the following description, various aspects of the subject matter of the present application will be described. For purposes of explanation, specific configurations and details are set forth in sufficient detail to provide a thorough understanding of the subject matter of the present application. However, it will also be apparent to one skilled in the art that the subject matter of the present application can be practiced without the specific configurations and details presented herein.

[0017] Attention is first drawn to Figs. 1 and 2 showing a cutting tool **20**, of the type used for grooving or parting, in accordance with a first embodiment of the subject matter of the present application. The cutting tool **20** has a cutting insert **22** and a holder blade **24** where the cutting insert **22** is resiliently clamped within the holder blade **24**.

[0018] Referring now to Fig. 3, the cutting insert **22** has an insert longitudinal axis **A** and is elongated in the same direction as said insert longitudinal axis **A**. The cutting insert **22** has an insert upper surface **26** and an opposing insert lower surface **28**. There is a peripheral surface **30** that extends between the insert upper surface **26** and the insert lower surface **28**. The peripheral surface **30** has two opposing end surfaces **32** that extend between the insert upper surface **26** and the insert lower surface **28**, defining a longitudinal insert length **L**. In accordance with some embodiments of the subject matter of the present application, the insert upper and lower surfaces **26**, **28** can extend substantially parallel to the insert longitudinal axis **A**. Located at, and formed integrally with (i.e., having unitary one-piece construction with), at least one of the end surfaces **32** is a cutting portion **34**. At least one of the cutting portions **34** can have a cutting edge **50** associated with the insert upper surface **26**. In accordance with some embodiments of the subject matter of the present application there can be two cutting portions **34**. In such a configuration, the cutting insert **22** can be double-ended and indexable and exhibit mirror symmetry about a median plane **P1**, where the median plane **P1** is oriented perpendicular to the insert longitudinal axis **A** and is located midway between the end surfaces **32**. Alternatively, one of the cutting portions **34** can be associated with the insert lower surface **28** (not shown), in which case the cutting insert **22**, does not exhibit mirror symmetry about the median plane **P1**, although it may instead exhibit 180° rotational symmetry about a central axis passing perpendicularly to the sides of the insert.

[0019] The insert upper surface **26** has an insert upper abutment surface **36** that is located between the end surfaces **32**. The purpose of the insert upper abutment surface **36** is to provide an upper abutment zone between the cutting insert **22** and the holder blade **24** to ensure resilient clamping of the cutting insert **22**. In a side view of the cutting insert **22**, the insert upper abutment surface **36** can form an insert upper imaginary line L_{IU} that is parallel to the insert longitudinal axis **A** of the cutting insert **22**.

[0020] The insert lower surface **28** has two longitudinally spaced apart insert lower component surfaces **38**. Additionally, each insert lower component surface **38** has an insert lower abutment surface **40**. The purpose of the insert lower abutment surfaces **40** is to provide two lower spaced apart abutment zones between the cutting insert **22** and the holder blade **24** to ensure resilient clamping of the cutting insert **22**. In a side view of the cutting insert **22**, the spaced apart insert lower abutment surfaces **40** can form sections of an insert lower imaginary line L_{IL} which is parallel to the insert longitudinal axis **A**. The insert lower surface **28** also has a non-abutting insert central lower surface **42** which is located between, and recessed with respect to, the insert lower component surfaces **38**. The non-abutting insert central lower surface **42** is formed in a single, elongated lower insert cutout **29** which is visible in a side view of the cutting insert **22** and is bounded on one side by the insert lower imaginary line L_{IL} . In at least some embodiments, the elongated lower insert cutout **29** extends for at least one-third the length of the insert lower surface **28**.

[0021] Referring now to Fig. 4, showing a detailed view of a lower part of the cutting insert **22**, the insert lower surface **28** has two insert lower intermediate surfaces **44**, which extend between the insert central lower surface **42** and each insert lower component surface **38**. At least one of the two insert lower component surfaces **38** includes an insert inner curved ramp **46** extending from its insert lower abutment surface **40** to the adjacent insert lower intermediate surface **44**. Thus, as seen in the figures, the insert inner curved ramp **46** extends from the insert lower abutment surface **40** in a direction of the lower insert cutout **29**. Each insert inner curved ramp **46** can have an insert inner radius of curvature R_{II} , which subtends an insert inner angle of curvature δ_{II} , where δ_{II} can be greater than or equal to 20° and less than or equal to 40° . For example, the insert inner angle of curvature δ_{II} can have a value of 30° .

[0022] At least one of the two insert lower component surfaces **38** includes an insert outer curved ramp **48** extending from its insert lower abutment surface **40** in a direction of the adjacent end surface **32**. Each insert outer curved ramp **48** can have an insert outer radius of curvature R_{IO} , which subtends an insert outer angle of curvature δ_{IO} , where δ_{IO} can be greater or equal to 5° and less than or equal to 25° . For example, the insert outer angle of curvature δ_{IO} can have a value of 15° .

[0023] In accordance with some embodiments of the subject matter of the present application the insert outer radius of curvature R_{II} can be equal to the insert outer radius of curvature R_{IO} .

[0024] When the cutting insert **22** exhibits mirror symmetry about the median plane **P1** there are exactly two insert inner curved ramps **46** and two insert outer curved ramps **48**. That is to say, both the insert lower component surfaces **38** have an insert inner curved ramp **46** and an insert outer curved ramp **48**.

[0025] Further in accordance with some embodiments of the subject matter of the present application, the at least one insert inner curved ramp **46** can be tangential to its adjacent insert lower abutment surface **40** at the intersection thereof. Also, the at least one insert outer curved ramp **48** can be tangential to its adjacent insert lower abutment surface **40** at the intersection thereof. In accordance with other embodiments of the subject matter of the present application, the at least one insert inner curved ramp **46** can also be tangential to its adjacent insert lower intermediate surface **44** at the intersection thereof.

[0026] Referring now to Fig. 5, the insert upper abutment surface **36** and the insert lower surface **28** can be generally V-shaped in an end view of the cutting insert **22**. In accordance with some embodiments of the present application, the insert upper abutment surface **36** and the insert lower surface **28** can be of a female groove type. This configuration, which provides a clamping mechanism whereby lateral displacement of the cutting insert **22**, **122** is restricted when clamped within the holder blade **24**, is well known and is not part of the invention.

[0027] Referring to Fig. 6, in accordance with a second embodiment of the present application, the insert central lower surface **42** of the cutting insert **122** can have a substantially semi-circular insert central lower recess **52**. It should be noted that the substantially semi-circular insert central lower recess **52** is provided for the insertion of a protrusion **54** of a key **56** (see Fig. 15) that can

be pivoted in order to apply an urging force for the purpose of positioning the cutting insert **122** into its clamped position, relative to the holder blade **24**.

[0028] Attention is drawn to Fig. 7, which shows an example of a single-ended cutting insert **22** in accordance with the present application having a single cutting portion **34**. In this non-limiting example of the present application, the insert longitudinal axis **A** is not parallel to the feed direction **FD** of the cutting insert **22** when the cutting insert **22** is clamped in a blade holder **24** and engaging a workpiece. However, in other examples, the insert longitudinal axis **A** can be parallel to the feed direction **FD** of the cutting insert **22** when the cutting insert **22** is clamped in a blade holder **24** and engaging a workpiece.

[0029] When the cutting insert **22** is single-ended then there is exactly one insert inner curved ramp **46** and one insert outer curved ramp **48**. That is to say, only the insert lower component surface **38** closest to the single cutting portion **34** has an insert inner curved ramp **46**, and only the insert lower component surface **38** furthest from the single cutting portion **34** has an insert outer curved ramp **48**.

[0030] Attention is now drawn to Fig. 8 showing the holder blade **24**, for resiliently retaining the cutting insert **22**, **122** described herein. The holder blade **24** has a holder longitudinal axis **B** that defines a forward to rearward direction **D_F**, **D_R**. It should be appreciated that use of the terms "forward" and "rearward" throughout the description and claims refer to a relative position in a direction of the holder longitudinal axis **B** towards the left and right, respectively, in Figs. 8 to 13 and 15. The holder blade **24** has a body portion **58** and a clamping portion **60** integrally formed with the body portion **58**. The clamping portion **60** has an insert receiving slot **62** opening out to a holder front end surface **64** of the holder blade **24**. The insert receiving slot **62** has an upper clamping jaw **66** and a lower base jaw **68**, where the upper clamping jaw **66** is resiliently displaceable with respect to the lower base jaw **68**. The upper clamping jaw **66** has a clamping jaw abutment surface **70**. The lower base jaw **68** has a base jaw lower surface **72**.

[0031] The base jaw lower surface **72** has two spaced apart base jaw component surfaces, a front base jaw component surface **74** adjacent the holder front end surface **64** and a rear base jaw component surface **76** rearwardly spaced apart from the front base jaw component surface **74**. In accordance with some embodiments of the subject matter of the present application the front and rear base jaw component surfaces **74**, **76** each have a holder lower abutment surface **78**. In a side

view of the holder blade 24, the two spaced apart holder lower abutment surfaces **78** can form sections of a holder lower imaginary line L_{HL} which is parallel to the holder longitudinal axis **B**.

[0032] Referring to Fig. 9, the base jaw lower surface **72** has a non-abutting base jaw central surface **80** located between, and recessed with respect to, the front and rear base jaw component surfaces **74**, **76**. The non-abutting base jaw central surface **80** is formed in a single, elongated base jaw cutout **73** which is visible in a side view of the holder blade **24** and is bounded on one side by the holder lower imaginary line L_{HL} . In at least some embodiments, the elongated base jaw cutout **73** extends for at least one-third the length of the base jaw lower surface **72**. The base jaw lower surface **72** has two spaced apart holder lower intermediate surfaces **82**, which extend between the base jaw central surface **80** and its adjacent front and rear base jaw component surfaces **74**, **76**. Each of the front and rear base jaw component surfaces **74**, **76** can include a holder inner curved ramp **84** extending from its holder lower abutment surface **78** to the adjacent holder lower intermediate surface **82**. Each holder inner curved ramp **84** can have a holder inner radius of curvature R_{HI} , which subtends a holder inner angle of curvature δ_{HI} , where δ_{HI} can be greater or equal to 20° and less than or equal to 40° . For example, the holder inner angle of curvature δ_{HI} can have a value of 30° .

[0033] The front base jaw component surface **74** can include a holder outer curved ramp **86** extending from its holder lower abutment surface **78** to the adjacent holder front end surface **64**. The holder outer curved ramp **86** can have a holder outer radius of curvature R_{HO} , which subtends a holder outer angle of curvature δ_{HO} , where δ_{HO} can be greater or equal to 5° and less than or equal to 25° . For example, the insert outer angle of curvature δ_{HO} can have a value of 15° .

[0034] In accordance with some embodiments of the subject matter of the present application the holder outer radius of curvature R_{HI} can be equal to the holder outer radius of curvature R_{HO} .

[0035] Further in accordance with some embodiments of the subject matter of the present application, the two holder inner curved ramps **84** can be tangential to their adjacent holder lower abutment surface **78** at the intersection thereof. Also, the one holder outer curved ramp **86** can be tangential to its adjacent holder lower abutment surface **78** at the intersection thereof. Also, the two holder inner curved ramps **84** can be tangential to their adjacent holder lower intermediate surfaces **82** at the intersection thereof.

[0036] The clamping jaw abutment surface **70** and the base jaw lower surface **72** can be generally V-shaped, in a front end view. In accordance with some embodiments, the clamping jaw abutment surface **70** and the base jaw lower surface **72** can be of a male groove type. This configuration, which provides a clamping mechanism where the cutting insert **22, 122** can not be displaced laterally when clamped within the holder blade **24** is well known and is not part of the invention.

[0037] Attention is drawn to Fig. 10, which shows an example the holder blade **24** in accordance with the present application which is suitable for the single-ended cutting insert **22, 122** that is shown in Fig. 7.

[0038] Referring back to Fig. 1, the cutting tool **20** has a cutting insert **22** resiliently clamped between the upper clamping jaw **66** and the lower base jaw **68**. The insert upper abutment surface **36** abuts the clamping jaw abutment surface **70**, the insert lower abutment surface **40** of the insert lower component surface **38** closest to the operative cutting portion **34** abuts the holder lower abutment surface **78** of the front base jaw component surface **74**, and the insert lower abutment surface **40** of the insert lower component surface **38** furthest from the operative cutting portion **34** abuts the holder lower abutment surface **78** of the rear base jaw component surface **76**. At least the insert lower component surface **38** closest to the operative cutting portion **34** has an insert inner curved ramp **46**, and at least the insert lower component surface **38** furthest from the operative cutting portion **34** has an insert outer curved ramp **48**.

[0039] Another aspect of the present application also includes a method of assembling the cutting tool **20, 120**. Reference is first made to Fig. 11, showing the cutting insert **22** of the first embodiment, although the method is also applicable for the second embodiment of the cutting insert **122**. The cutting insert **22, 122** is positioned relative to the holder blade **24** so that the insert longitudinal axis **A** and the holder longitudinal axis **B** are contained in a mutual main plane **P2** and the insert lower surface **28** is in contact the base jaw lower surface **72** (see Fig. 14).

[0040] Referring now to Fig. 12, the cutting insert **22, 122** is slid rearwardly until the upper clamping jaw **66** undergoes resilient displacement. It should be noted that greater than half the longitudinal insert length **L** can be rearward of the holder front end surface **64** before the upper clamping jaw **66** undergoes resilient displacement. This has the beneficial effect of reducing the

remaining insertion distance for the cutting insert **22, 122** to reach a clamped position, whilst the upper clamping jaw **66** is resiliently displaced.

[0041] Referring now to Fig. 13, an urging force **F** is applied to the cutting insert **22, 122** in the rearward direction **D_R** until the insert lower abutment surface **40** of the insert lower component surface **38** closest to the operative cutting portion **34** abuts the holder lower abutment surface **78** of the front base jaw component surface **74** and the insert lower abutment surface **40** of the insert lower component surface **38** furthest from the operative cutting portion **34** abuts the holder lower abutment surface **78** of the rear base jaw component surface **76**. In this clamped position, the elongated lower insert cutout **29** opposes the elongated base jaw cutout **73**, and the recessed insert central lower surface **42** opposes the recessed base jaw central surface **80**, thereby forming a pass-through **93** between the cutting insert and base jaw lower surface **72**, said pass-through **93** being visible in a side view of the assembled cutting tool.

[0042] The method for assembling a longitudinally elongated cutting insert **22, 122** in a holder blade **24** requires no additional means for resiliently displacing the upper clamping jaw **66** relative to the lower base jaw **68**.

[0043] Thus in contrast to US 5,697,271, for example, the upper clamping jaw **66** is devoid of a throughbore for the key **56** to engage with and widen the insert receiving slot **62**. This allows, *inter alia*, the upper clamping jaw **66** to be formed with a shape that is advantageous for the evacuation of metal chips and other debris. For example, the internal angle **θ** formed between an upper clamping jaw top surface **88** of the upper clamping jaw **66** and the clamping jaw abutment surface **70** can be reduced. This has the effect of causing the metal chips, formed from the metal working of the work piece, to be deflected with less impact on the upper clamping jaw top surface **88** of the upper clamping jaw **66** and will thus cause less damage to said upper clamping jaw **66**, thereby extending its life.

[0044] Another advantage of the absence of a throughbore is the possibility to include a cooling system (not shown) in the upper clamping jaw **66** of the cutting tool **20, 120** whereby a cooling duct, for the provision of a cooling fluid, can extend through the upper clamping jaw **66**. Clearly, the existence of a throughbore in the upper clamping jaw **66** would significantly limit the path of such a cooling duct making it difficult for such a cooling system to be implemented.

[0045] The ability to urge the cutting insert **22, 122** into a clamped position within the insert receiving slot **62**, with no additional means for resiliently displacing the upper clamping jaw **66** relative to the lower base jaw **68**, is achieved by having the insert central lower surface **42** and the base jaw central surface **80** recessed, which has the effect that the insert upper abutment surface **36** can slide freely relative to the clamping jaw abutment surface **70** and insert lower component surface **38** closest the operative cutting portion **34** can slide freely relative to the base jaw central surface **80** until at least one of the insert inner or outer curved ramps **46, 48** comes into contact with its respective front or rear base jaw component surfaces **74, 76**. That is to say, until the upper clamping jaw **66** undergoes resilient displacement. This allows a significant longitudinal portion of the cutting insert **22, 122** to be inserted into the insert receiving slot **62** before the necessity of providing any substantial force. That is to say that more than half the longitudinal insert length **L** is rearward of the holder front end surface **64** before the upper clamping jaw **66** undergoes resilient displacement. At such a defined point the cutting insert **22, 122** is in a stable position within the holder blade **24** and a mechanism to apply a urging force **F** to urge the cutting insert **22, 122** into a clamped position (for example with the aid of the key **56**), can be applied more easily than if the cutting insert **22, 122** was in an unstable position, and liable to be inadvertently 'knocked' out of position before the urging force **F** could be applied.

[0046] It will also be understood that the curved properties of the insert inner and outer curved ramps **46, 48** allow the cutting insert **22, 122** to be positioned in the clamping position in a smooth manner. The curved ramps also ensure there is a gradual increase in resistance to the insertion of the cutting insert **22, 122**, caused by the resilient displacement of the upper clamping jaw **66**, to the final clamping position, which allows the insertion of the cutting insert **22, 122** to be performed in a controlled and fluid fashion.

[0047] Yet another feature of the subject matter of the present application is that the resilient clamping force provided by the upper clamping jaw **66** and the lower base jaw **68** is improved. In the present application, in order to position the cutting insert **22, 122** into a clamping position, the upper clamping jaw **66** is displaced, relative to the lower base jaw **68**, by a minimum distance. That is to say, the upper clamping jaw **66** is displaced only by the cutting insert **22, 122**, and no additional space between the cutting insert **22, 122** and the upper clamping jaw **66**

needs to be provided. Therefore, the resilience in the upper clamping jaw **66** is maximized to provide a greater clamping force.

[0048] It should further be noted that another feature in the second embodiment of the present application having a cutting insert **122** with an insert central lower recess **52** is that there is no requirement for a recess at the rear of the insert receiving slot **62** to accommodate the protrusion **54** of the key **56** when removing the cutting insert **122** from the holder blade **24**. The absence of the recess allows the upper clamping jaw **66** to have increased resilience with respect to the lower base jaw **68**, thereby providing clamping forces of a greater magnitude.

[0049] Another feature in accordance with the second embodiment of the present application having the cutting insert **122** with the insert central lower recess **52** is that, when removing the cutting insert **122** from the holder blade **24** with the key **56** and applying an extraction force F_E on the insert central lower recess **52**, the cutting insert **122** can be ejected from the insert receiving slot **62** in a controlled manner. This is achieved since, when pivoting the key **56** in a forward direction D_F in order to remove the cutting insert **122**, the protrusion **54** of the key **56** comes into contact with the front base jaw component surface **74** (see Fig. 15). This contact prevents the key **56** being pivoted further and occurs while the cutting insert **122** is still partially located in the insert receiving slot **62**. At this point, the protrusion **54** of the key **56** can be removed from the insert central lower recess **52** so that the cutting insert **122** can be completely removed from the holder blade **24** in a controlled manner. If, for example, the extraction force F_E is applied to the end surface **32** furthest from the operative cutting portion **34**, the cutting insert **22** would be liable to be fully displaced from the insert receiving slot **62**. In such a scenario, for a double-ended cutting insert for example, the tool operator may not know which cutting portion **34** has been used and which cutting portion is unused **34**.

[0050] Although the subject matter of the present application has been described to a certain degree of particularity, it should be understood that various alterations and modifications could be made without departing from the spirit or scope of the invention as hereinafter claimed.

CLAIMS

1. A cutting insert (22, 122), longitudinally elongated in a direction defining an insert longitudinal axis (A), comprising:

opposing insert upper and lower surfaces (26, 28) and a peripheral surface (30) extending therebetween, the peripheral surface (30) comprising two opposing end surfaces (32), at least one of the end surfaces (32) having an integral cutting portion (34); wherein

the insert upper surface (26) comprises an insert upper abutment surface (36);

the insert lower surface (28) comprises:

two longitudinally spaced apart insert lower component surfaces (38), each insert lower component surface (38) having an insert lower abutment surface (40);

an insert central lower surface (42) located between, and recessed with respect to, the two insert lower component surfaces (38);

an insert lower intermediate surface (44) extending between the insert central lower surface (42) and each insert lower component surface (38); wherein

at least one of the two insert lower component surfaces (38) includes an insert inner curved ramp (46) extending from its insert lower abutment surface (40) to the adjacent insert lower intermediate surface (44) and at least the other of the two insert lower component surfaces (38) includes an insert outer curved ramp (48) extending from its insert lower abutment surface (40) in a direction of the adjacent end surface (32).

2. The cutting insert (22, 122), according to claim 1; wherein

the at least one insert inner curved ramp (46) is tangential to its adjacent insert lower abutment surface (40) at an intersection thereof, and

the at least one insert outer curved ramp (48) is tangential to its adjacent insert lower abutment surface (40) at an intersection thereof.

3. The cutting insert (22, 122), according to claims 1 or 2; wherein

the at least one insert inner curved ramp (46) has an insert inner radius of curvature (R_{II}) subtending an insert inner angle of curvature δ_{II} , wherein $20^\circ \leq \delta_{II} \leq 40^\circ$, and

the at least one insert outer curved ramp (48) has an insert outer radius of curvature (R_{IO}) subtending an insert outer angle of curvature δ_{IO} , wherein $5^\circ \leq \delta_{IO} \leq 25^\circ$.

4. The cutting insert (22, 122), according to claim 3, wherein the insert inner radius of curvature (R_{II}) is equal to the insert outer radius of curvature (R_{IO}).

5. The cutting insert (22, 122), according to any one of claims 1 to 4; wherein in a side view of the cutting insert,

the two insert lower abutment surfaces (40) form sections of an insert lower imaginary line (L_{IL}) parallel to the insert longitudinal axis (A); and

the insert upper abutment surface (36) forms an insert upper imaginary line (L_{IU}) parallel to the insert longitudinal axis (A).

6. The cutting insert (22, 122), according to any one of claims 1 to 5; wherein

the at least one insert inner curved ramp (46) is tangential to its adjacent insert lower intermediate surface (44) at the intersection thereof.

7. The cutting insert (22, 122), according to any one of claims 1 to 6, wherein the insert upper abutment surface (36) and the insert lower surface (28) are generally V-shaped, in an end view of the cutting insert (22, 122).

8. The cutting insert (22, 122), according to claim 7, wherein the generally V-shaped insert upper abutment surface (36) and the insert lower surface (28) are of a female groove type.

9. The cutting insert (22, 122), according to any one of claims 1 to 8, having two cutting portions (34); wherein

the cutting insert (22, 122) exhibits mirror symmetry about a median plane (P1) perpendicular to the insert longitudinal axis (A) and located midway between the end surfaces (32).

10. The cutting insert (22, 122), according to any one of claims 1 to 8, having a single cutting portion (34); wherein
- only the insert lower component surface (38) closest to the single cutting portion (34) has an insert inner curved ramp (46), and
 - only the insert lower component surface (38) furthest from the single cutting portion (34) has an insert outer curved ramp (48).
11. The cutting insert (22, 122), according to any one of claims 1 to 10; wherein
- at least one of the at least one cutting portions (34) has a cutting edge (50) associated with the insert upper surface (26).
12. The cutting insert (122), according to any one of claims 1 to 11, wherein the insert central lower surface (42) comprises a substantially semi-circular insert central lower recess (52).
13. A cutting tool (20,120), comprising:
- a holder blade (24), having a holder longitudinal axis (B) extending in a forward to rearward direction, comprising:
 - a body portion (58) and a clamping portion (60);
 - the clamping portion (60) having an insert receiving slot (62) opening out to a holder front end surface (64) of the holder blade (24), the insert receiving slot (62) comprising:
 - an upper clamping jaw (66) having a clamping jaw abutment surface (70) and a lower base jaw (68) having a base jaw lower surface (72), the upper clamping jaw (66) being resiliently displaceable relative to the lower base jaw (68);
 - the base jaw lower surface (72) comprising:
 - a front base jaw component surface (74) adjacent the holder front end surface (64) and a rear base jaw component surface (76) rearwardly spaced apart from the front base jaw component surface (74), the front and

rear base jaw component surfaces (74, 76) each comprising a holder lower abutment surface (78);

a base jaw central surface (80) located between, and recessed with respect to, the front and rear base jaw component surfaces (74, 76);

a holder lower intermediate surface (82), extending between the base jaw central surface (80) and each base jaw component surface (74, 76);

a cutting insert (22, 122) resiliently clamped between the upper clamping jaw (66) and the lower base jaw (68); wherein

the cutting insert (22, 122) is in accordance with any one of claims 1 to 12;

the insert upper abutment surface (36) abuts the clamping jaw abutment surface (70), the insert lower abutment surface (40) of the insert lower component surface (38) closest to the operative cutting portion (34) abuts the holder lower abutment surface (78) of the front base jaw component surface (74), and the insert lower abutment surface (40) of the insert lower component surface (38) furthest from the operative cutting portion (34) abuts the holder lower abutment surface (78) of the rear base jaw component surface (76); and

at least the insert lower component surface (38) closest to the operative cutting portion (34) has an insert inner curved ramp (46), and at least the insert lower component surface (38) furthest from the operative cutting portion (34) has an insert outer curved ramp (48).

14. The cutting tool (20, 120), according to claim 13; wherein

each of the front and rear base jaw component surfaces (74, 76) includes a holder inner curved ramp (84) extending from its holder lower abutment surface (78) to the adjacent holder lower intermediate surface (82) and the front base jaw component surface (74) includes a holder outer curved ramp (86) extending from its holder lower abutment surface (78) to the holder front end surface (64).

15. The cutting tool (20, 120), according to claim 14; wherein

each holder inner curved ramp (84) is tangential to its adjacent holder lower abutment surface (78) at the intersection thereof, and

the holder outer curved ramp (86) is tangential to its adjacent holder lower abutment surface (78) at the intersection thereof.

16. The cutting tool (20, 120), according to claim 15; wherein
each holder inner curved ramp (84) has a holder inner radius of curvature (R_{HI}) subtending an holder inner angle of curvature δ_{HI} , wherein $20^\circ \leq \delta_{HI} \leq 40^\circ$, and
the holder outer curved ramp (86) has a holder outer radius of curvature (R_{HO}) subtending a holder outer angle of curvature δ_{HO} , wherein $5^\circ \leq \delta_{HO} \leq 25^\circ$.

17. The cutting tool (20, 120), according to claim 16, wherein the holder inner radius of curvature (R_{HI}) is equal to the holder outer radius of curvature (R_{HO}).

18. The cutting tool (20, 120), according to any one of claims 13 to 17; wherein, in a side view of the cutting tool,
the two holder lower abutment surfaces (78) form sections of a holder lower imaginary line (L_{HL}) parallel to the holder longitudinal axis (B).

19. The cutting tool (20, 120), according to any one of claims 13 to 17; wherein, in a side view of the cutting tool,
the two insert lower abutment surfaces (40) form sections of a lower imaginary line (L_{IL}) parallel to the insert longitudinal axis (A); and
the insert upper abutment surface (36) forms an insert upper imaginary line (L_{IU}) parallel to the insert longitudinal axis (A).

20. The cutting tool (20, 120), according to any one of claims 13 to 19; wherein
each holder inner curved ramp (84) is tangential to its adjacent holder lower intermediate surface (82) at the intersection thereof.

21. The cutting tool (20, 120), according to any one of claims 13 to 20, wherein the clamping jaw abutment surface (70) and the base jaw lower surface (72) are generally V-shaped, in a front end view of the cutting tool (20, 120).

22. The cutting tool (20, 120), according to claim 21, wherein the generally V-shaped clamping jaw abutment surface (70) and the base jaw lower surface (72) are of a male groove type.

23. A method for assembling a longitudinally elongated cutting insert (22, 122) in a holder blade (24), the holder blade (24), having a holder longitudinal axis (B) extending in a forward to rearward direction (D_F , D_R), comprising;

a body portion (58) and a clamping portion (60);

the clamping portion (60) having an insert receiving slot (62) opening out to a holder front end surface (64) of the holder blade (24), the insert receiving slot (62) comprising:

an upper clamping jaw (66) and a lower base jaw (68);

the upper clamping jaw (66) being resiliently displaceable relative to the lower base jaw (68),

the lower base jaw (68) having a base jaw lower surface (72), the base jaw lower surface (72) including a front base jaw component surface (74) longitudinally spaced apart from a rear base jaw component surface (76), with a base jaw central surface (80) located between and recessed with respect to the front and rear base jaw component surfaces (74, 76);

the cutting insert (22, 122) comprising:

opposing insert upper and lower surfaces (26, 28) extending substantially parallel to an insert longitudinal axis (A) and a peripheral surface (30) extending therebetween;

the insert lower surface (28) having two longitudinally spaced apart insert lower component surfaces (38), with an insert central lower surface (42) located between and recessed with respect to the two insert lower component surfaces (38); and

the peripheral surface (30) having two opposing end surfaces (32) defining a longitudinal insert length (L), at least one of the end surfaces (32) having an integral cutting portion (34),

the method comprising the steps of:

positioning the cutting insert (22, 122) relative to the holder blade (24) so that the insert longitudinal axis (A) and the holder longitudinal axis (B) are contained in a mutual main plane (P2) and the insert lower surface (28) is in contact the base jaw lower surface (72);

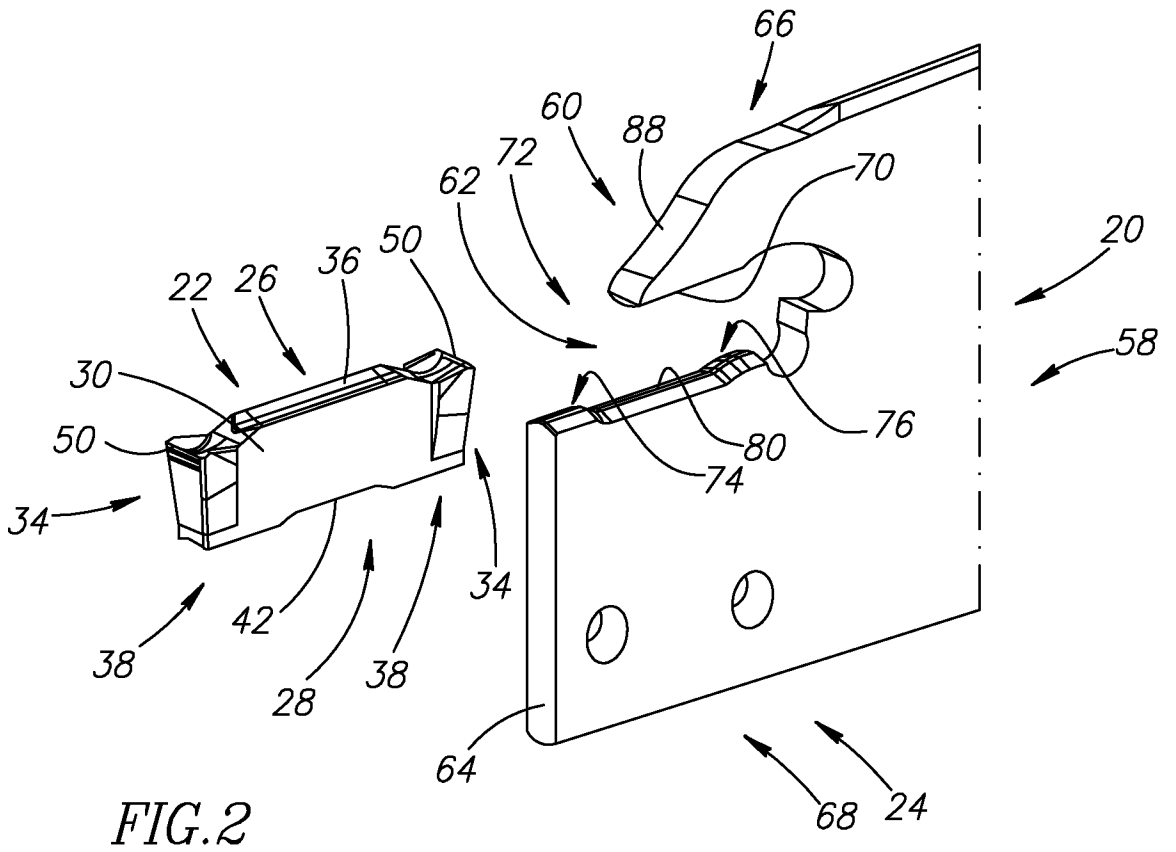
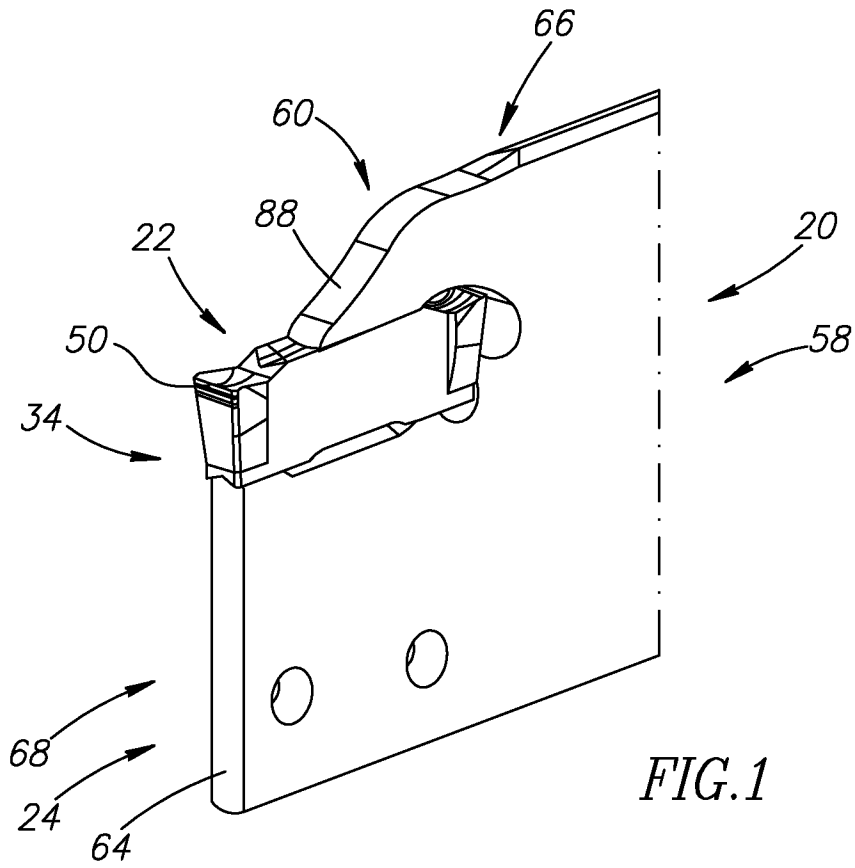
sliding the cutting insert (22, 122) rearwardly until the upper clamping jaw (66) undergoes resilient displacement; and

applying an urging force (F) to the cutting insert (22, 122) in the rearward direction (D_R) until the insert lower abutment surface (40) of the insert lower component surface (38) closest to the operative cutting portion (34) abuts the holder lower abutment surface (78) of the front base jaw component surface (74) and the insert lower abutment surface (40) of the insert lower component surface (38) furthest from the operative cutting portion (34) abuts the holder lower abutment surface (78) of the rear base jaw component surface (76).

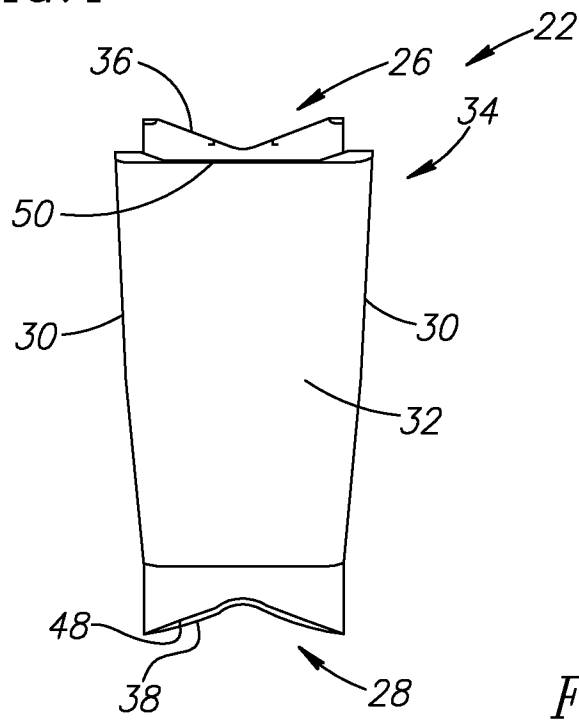
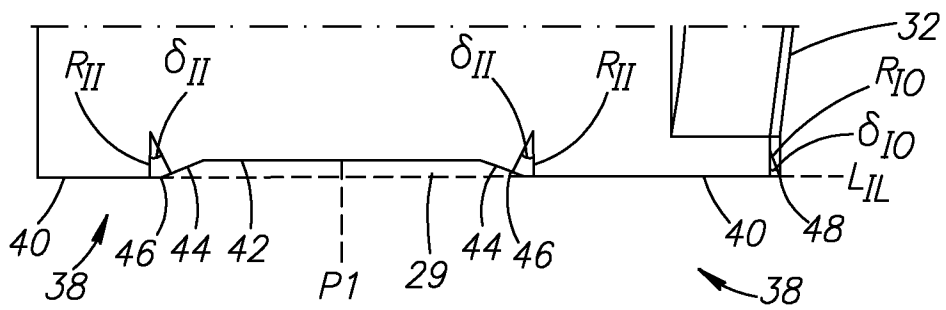
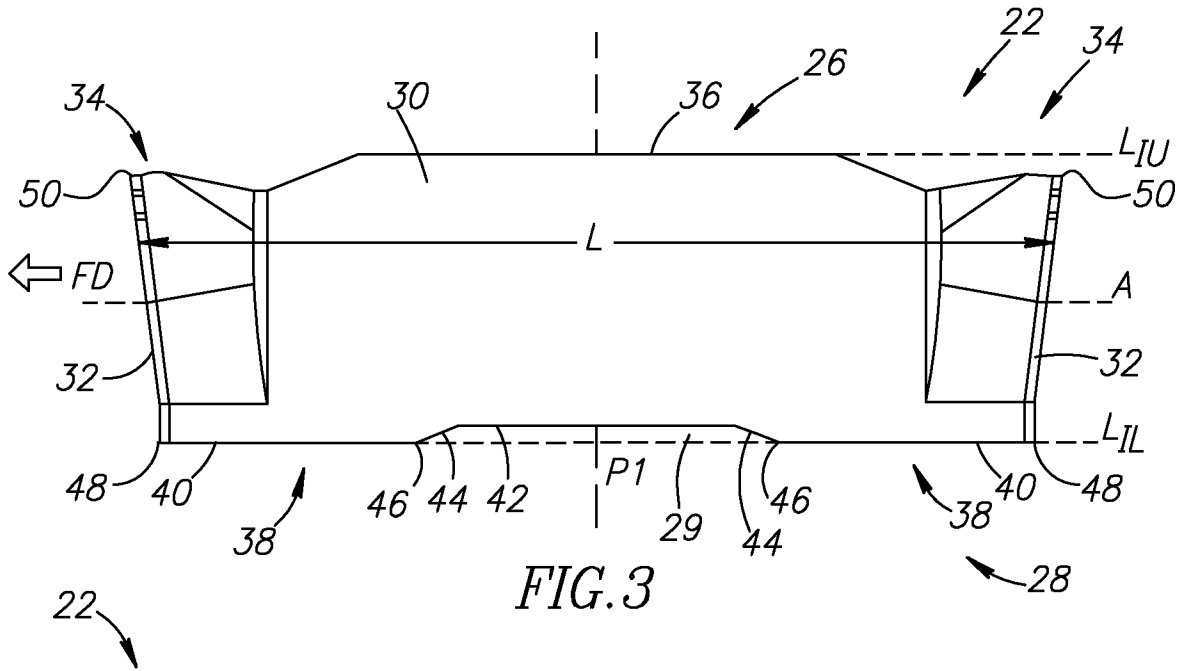
24. The method for assembling a longitudinally elongated cutting insert (22, 122) in a holder blade (24) according to claim 23, wherein no additional means for resiliently displacing the upper clamping jaw (66) relative to the lower base jaw (68) are employed.

25. The method for assembling a longitudinally elongated cutting insert (22, 122) in a holder blade (24) according to claims 23 or 24, wherein greater than half the longitudinal insert length (L) is rearward of the holder front end surface (64) before the upper clamping jaw (66) undergoes resilient displacement.

1/7



2/7



3/7

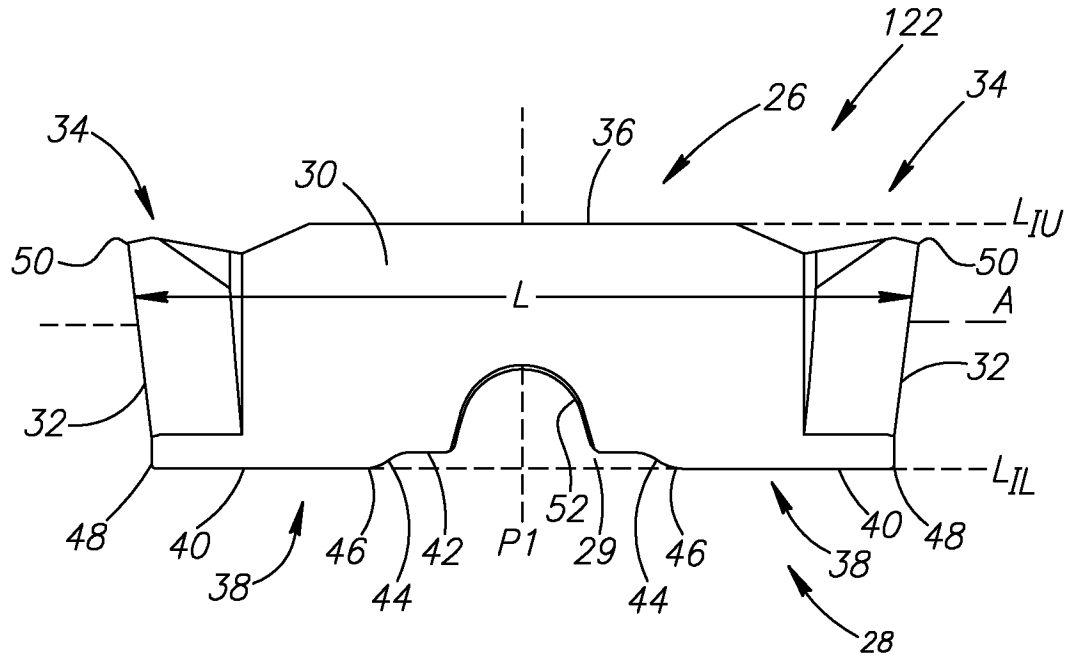


FIG. 6

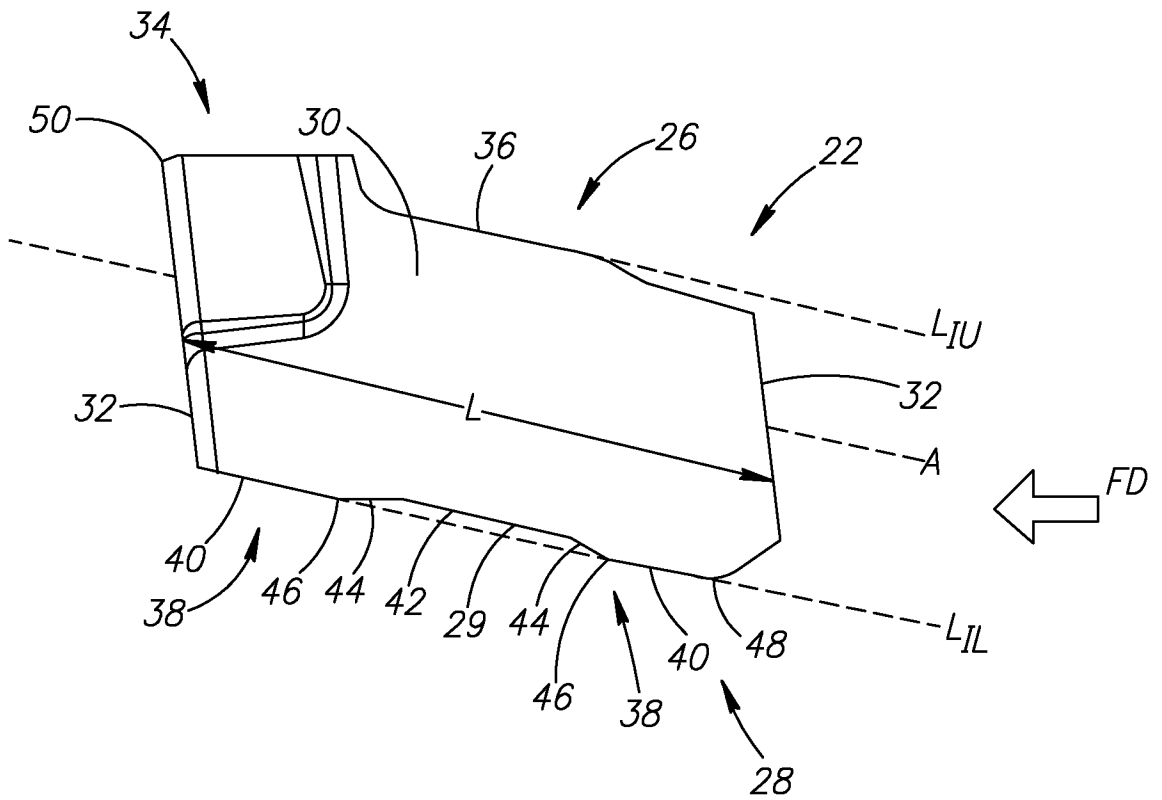


FIG. 7

4/7

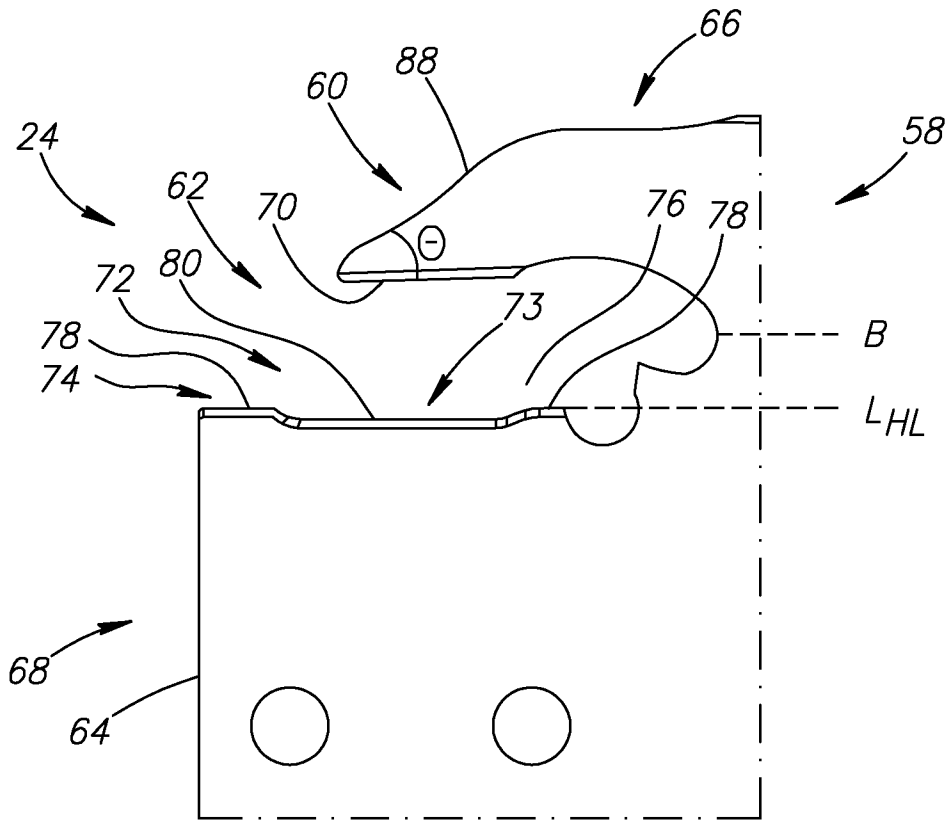


FIG. 8

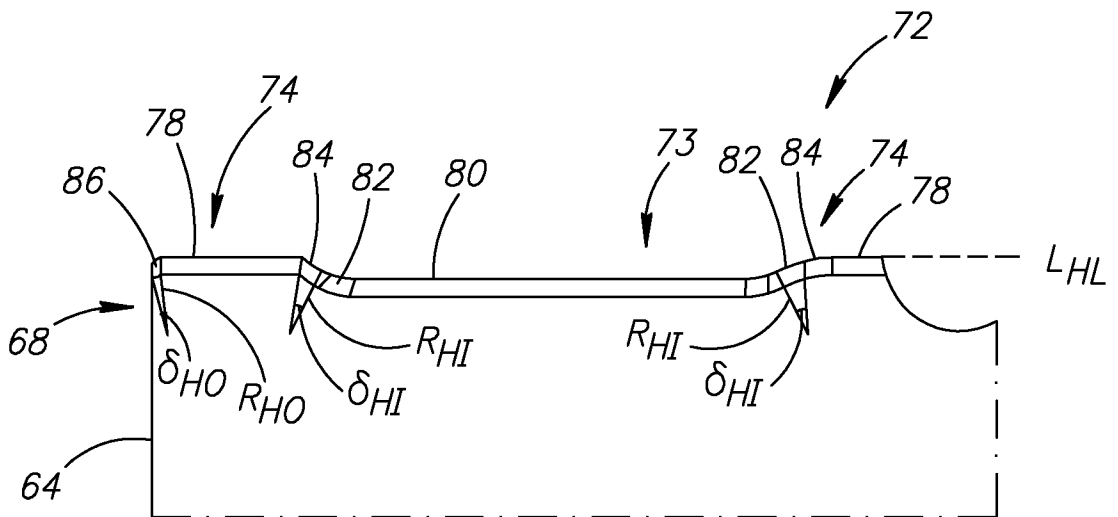


FIG. 9

5/7

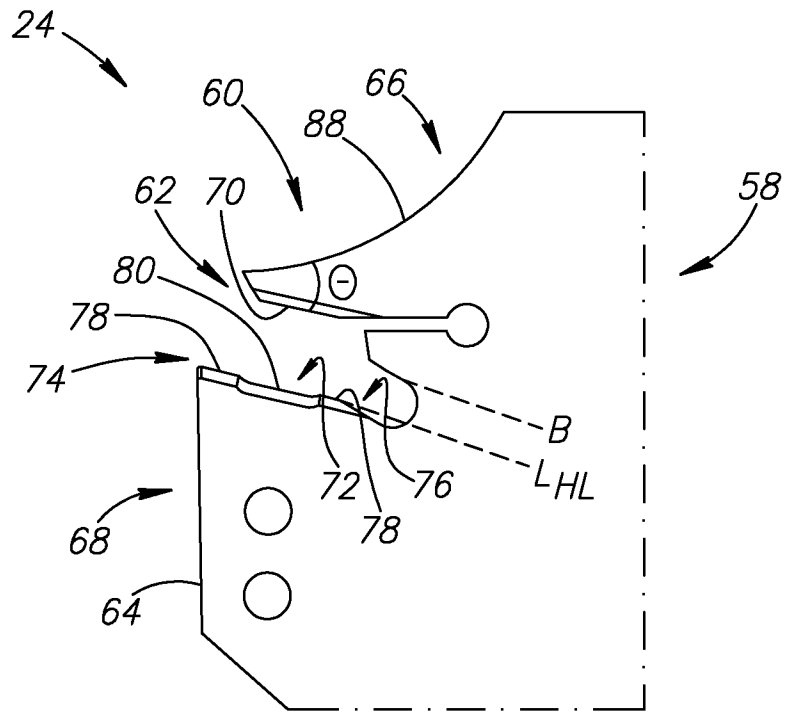


FIG.10

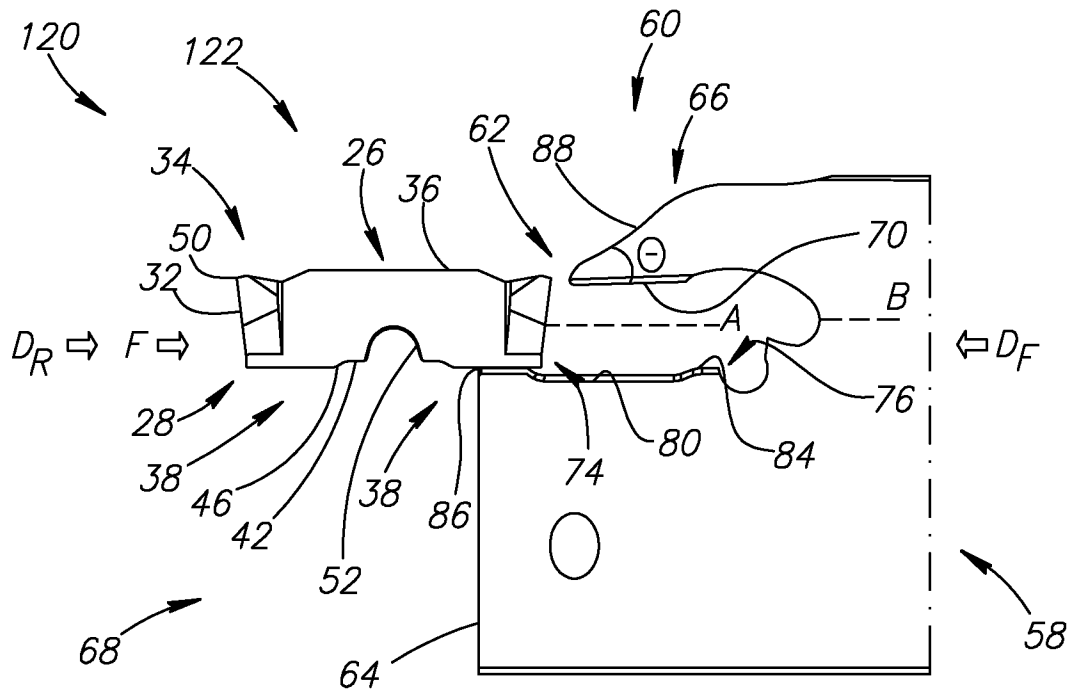


FIG.11

6/7

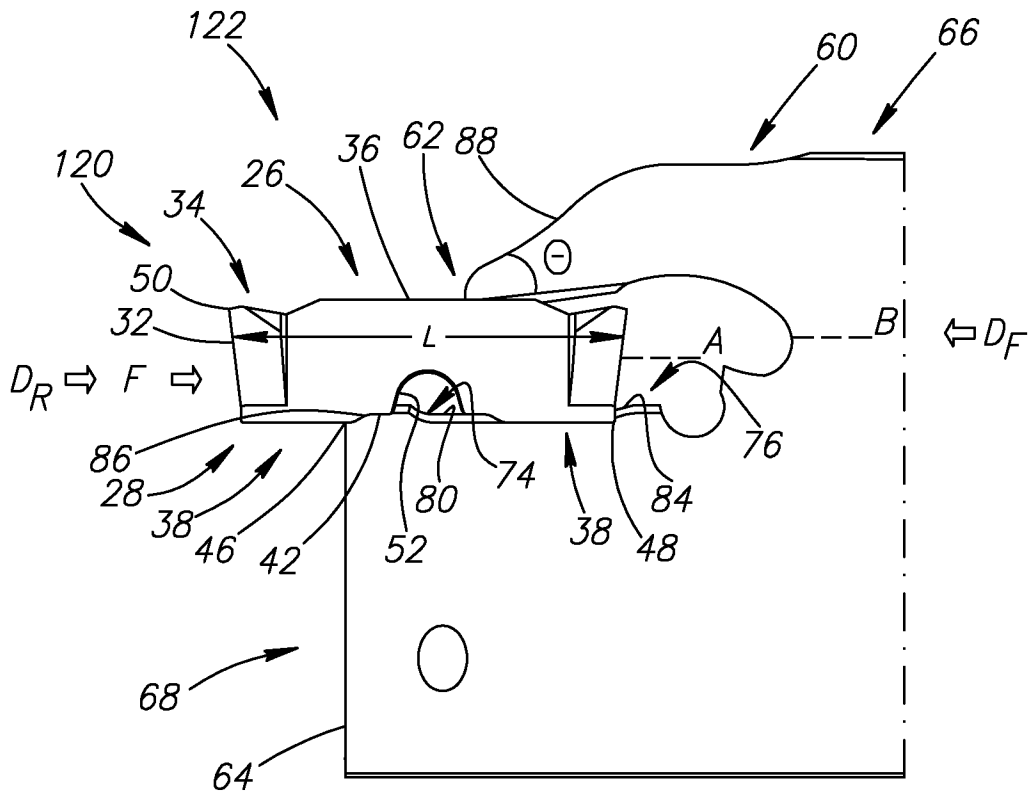


FIG.12

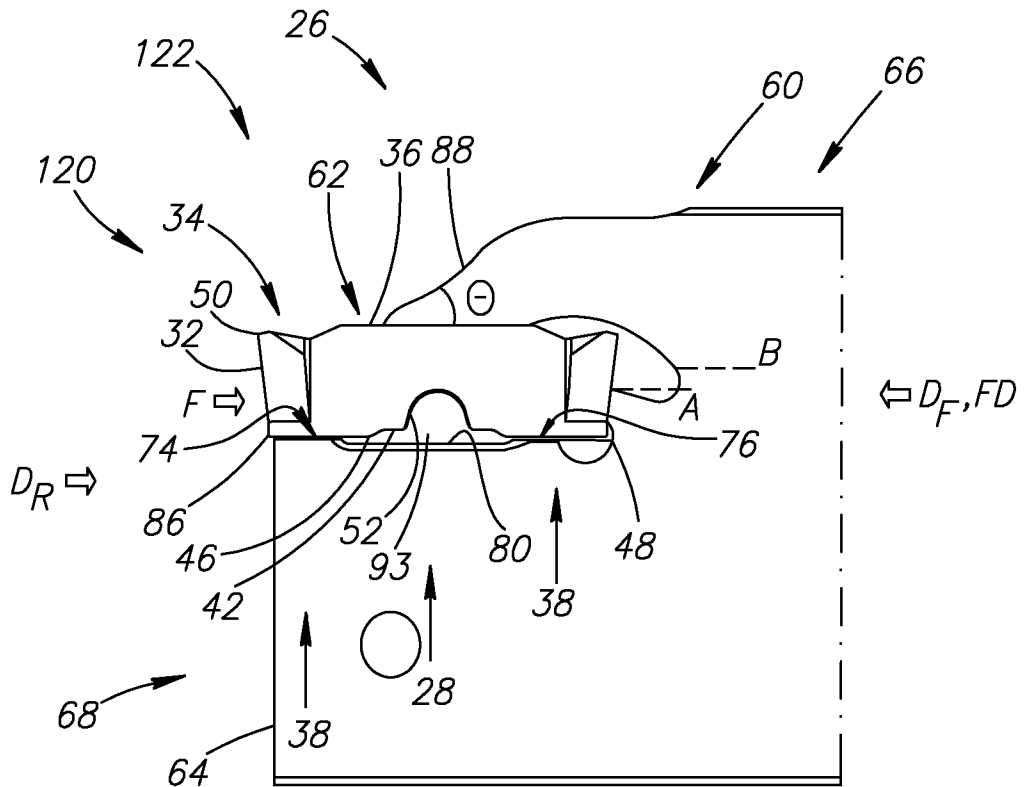


FIG.13

7/7

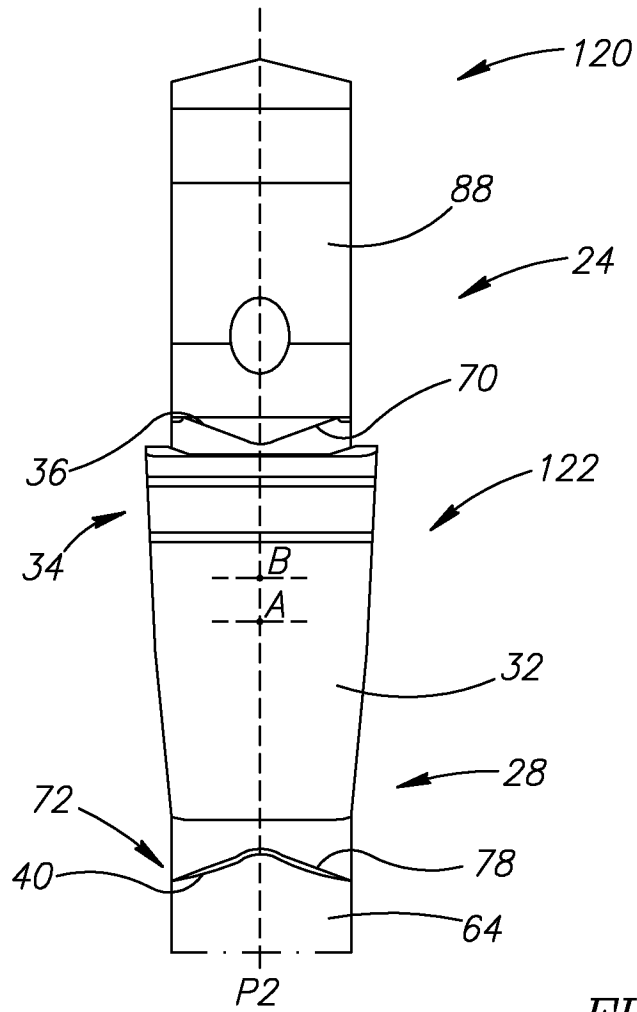


FIG.14

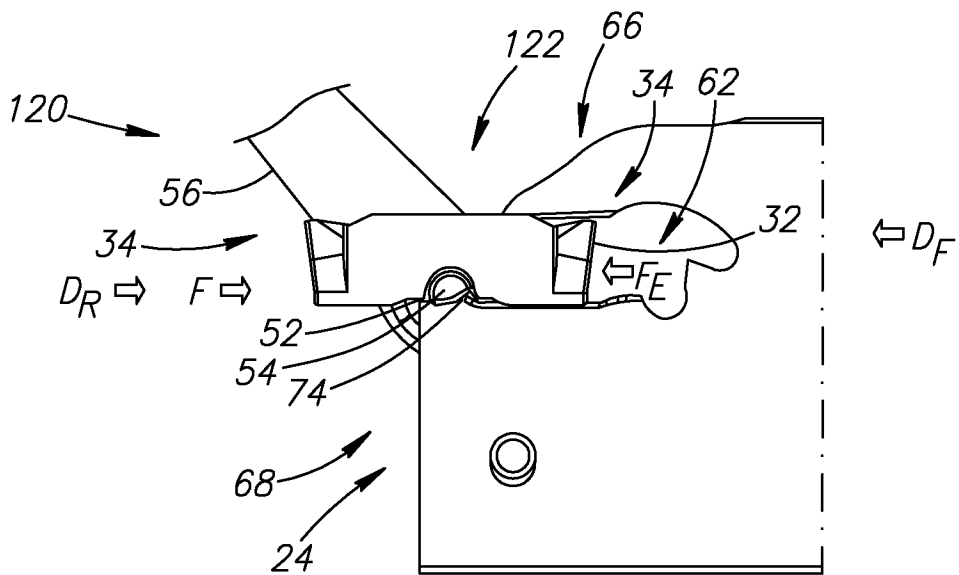


FIG.15

INTERNATIONAL SEARCH REPORT

International application No
PCT/IL2012/050507

A. CLASSIFICATION OF SUBJECT MATTER
INV. B23B27/04 B23B29/04
ADD.
According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED
Minimum documentation searched (classification system followed by classification symbols)
B23B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)
EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2010/061814 A1 (HECHT GIL [IL]) 11 March 2010 (2010-03-11) the whole document -----	1-25
X	US 5 803 675 A (VON HAAS RAINER [DE]) 8 September 1998 (1998-09-08) the whole document -----	1,23
X	EP 2 394 763 A1 (BOEHLERIT GMBH & CO KG [AT]; LIEZEN UND GIESEREI GES M B H MASCHF [AT]) 14 December 2011 (2011-12-14) paragraph [0024] - paragraph [0030] -----	1,23

Further documents are listed in the continuation of Box C.

See patent family annex.

* Special categories of cited documents :

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier application or patent but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

- "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
- "&" document member of the same patent family

Date of the actual completion of the international search
8 April 2013

Date of mailing of the international search report
15/04/2013

Name and mailing address of the ISA/
European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040,
Fax: (+31-70) 340-3016

Authorized officer
Mioc, Marius

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/IL2012/050507

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US 2010061814	A1	11-03-2010	AT 556800 T 15-05-2012
			CA 2731557 A1 18-03-2010
			CN 102149495 A 10-08-2011
			EP 2334458 A1 22-06-2011
			ES 2386871 T3 04-09-2012
			IL 194030 A 29-03-2012
			JP 2012501864 A 26-01-2012
			KR 20110063451 A 10-06-2011
			PT 2334458 E 10-07-2012
			RU 2011113973 A 20-10-2012
			TW 201012572 A 01-04-2010
			US 2010061814 A1 11-03-2010
			WO 2010029533 A1 18-03-2010

US 5803675	A	08-09-1998	AT 175371 T 15-01-1999
			DE 9317533 U1 10-02-1994
			EP 0729395 A1 04-09-1996
			ES 2125472 T3 01-03-1999
			JP H09505003 A 20-05-1997
			US 5803675 A 08-09-1998
			WO 9513892 A1 26-05-1995

EP 2394763	A1	14-12-2011	AT 509926 A1 15-12-2011
			BR PI1102933 A2 19-03-2013
			CN 102275014 A 14-12-2011
			EP 2394763 A1 14-12-2011
			US 2011303070 A1 15-12-2011
