



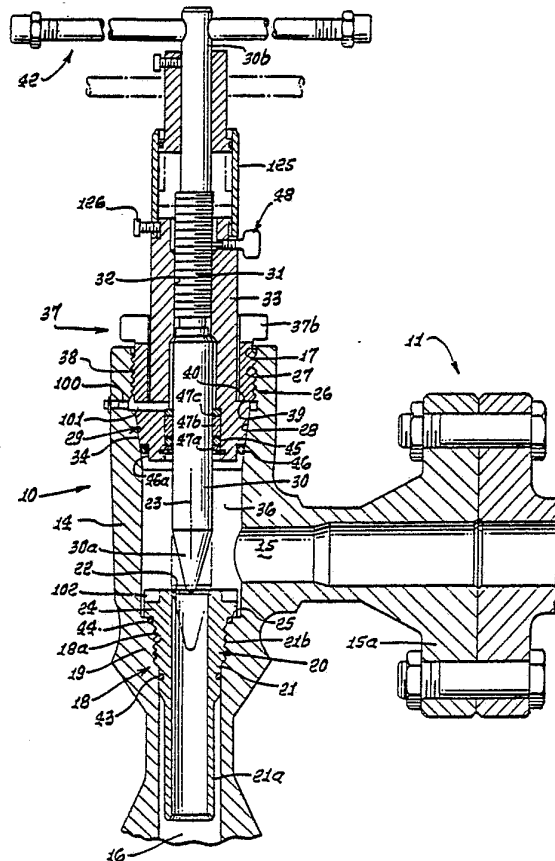
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<p>(21) International Application Number: PCT/US84/00544 (22) International Filing Date: 11 April 1984 (11.04.84) (31) Priority Application Number: 487,457 (32) Priority Date: 22 April 1983 (22.04.83) (33) Priority Country: US (71) Applicant: HYDRIL COMPANY [US/US]; 714 West Olympic Boulevard, Los Angeles, CA 90015 (US). (72) Inventor: MUCHOW, John, D. ; 2532 Jefferson, Long Beach, CA 90810 (US). (74) Agent: CHRYSTAL, John, J.; Ladas & Parry, 104 S. Michigan Avenue, Chicago, IL 60603 (US). (81) Designated States: AT (European patent), BE (European patent), BR, CH (European patent), DE (European patent), FR (European patent), GB (European patent), JP, LU (European patent), NL (European patent), NO, SE (European patent).</p>		<p>Published <i>With international search report.</i></p>

(54) Title: VALVE BODY FOR MULTIPLE VALVE INSERT PACKAGES

(57) Abstract

A choke valve apparatus is accommodated to different conditions of fluid flow (to or from a well, for example) by providing multiple flow control packages each having two flow control units, each package being readily connectible in the same valve body.



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VALVE BODY FOR MULTIPLE VALVE INSERT PACKAGES

This invention relates generally to control valves, and more particularly to chokes which serve to dissipate the energy of high pressure fluid, as for example fluid rising from a well.

5 Choke valves are commonly connected to the well annulus at the well surface to dissipate the energy of high pressure fluid. During drilling, such fluid may entrain small particles including drill cuttings loosened from the underground formation. During well
10 production the produced fluid may consist of petroleum, or gas under pressure, and containing smaller amounts of abrasive. The fluid may under other conditions consist of high pressure steam, as during a period of steam injection into the well to increase hydrocarbon
15 flow. These and other varied conditions of fluid flow require the use of different types of chokes, i.e. choke valves especially adapted to best handle the particular fluids rising from the well.

In the past, it was necessary to disconnect
20 the choke valve including the valve body from the well head riser pipe, and replace it with the different choke valve selected for the type of fluid flow encountered. This required an inventory of several choke valves, at or near the well site, which was relatively expensive. Also,
25 the disconnection and connection of the choke valve bodies from and to the well riser pipes, as well as to and from fluid discharge piping, was time consuming, unwieldy and sometimes dangerous.

The object of the invention is to provide a



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solution to the above problems and difficulties, including the elimination of need to disconnect the choke valve body from the riser pipe and discharge pipe each time a different choke valve is to be employed.

5 Basically, the method of the invention involves accommodating valve apparatus to different flow conditions, and includes the following steps:

10 a) providing an axially elongated and tubular valve body having a side fluid inlet port, a fluid outlet port at one end of the body, and a control entrance at the opposite end of the body, there being provided first attachment structure on the body at a first tubular interior region generally between said ports, and there being provided second attachment structure on the body at a second tubular region generally between said entrance and said ports,

15 b) providing multiple flow control packages and sequentially installing said packages into said body via said entrance and removing said packages from said valve body via said entrance,

20 c) each of said packages including first and second flow control units and said installation including attaching said first unit to said first attachment structure and then attaching said second flow control unit to said second attachment structure so that said units are positioned to control flow passing from the fluid inlet port to the fluid outlet port,

25 d) said multiple flow control packages being provided to have different flow control unit constructions.

30 As will appear, the flow control packages take different forms; however, they are each installable in like manner into the valve body and removable in like manner from that body which remains in place with its side inlet connected to the riser pipe at the well head, and its end outlet connected to discharge piping.



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The valve apparatus itself basically comprises:

- a) an axially elongated and tubular valve body having a side fluid inlet port, a fluid outlet port at one end of the body, and a control entrance at the opposite end of the body,
- b) first attachment structure including first internal threading on the body at a first tubular interior region generally between said ports, said first attachment structure being adapted to threadably receive a first flow control unit of a selected flow control package inserted into said body via said entrance,
- c) and second attachment structure including second threading on the body at a second tubular region generally between said entrance and said ports, said second attachment structure being adapted to receive a second flow control unit of said selected package inserted into said body via said entrance, for retention by said second threading,
- d) said second attachment structure also including an internal conical surface on the body between said entrance and said ports, said internal conical surface adapted to receive clamping thereagainst of an external conical surface of the second flow control unit,
- e) whereby said first and second flow control units are then positioned to control flow passing from said fluid inlet port to the fluid outlet port.

In accordance with the preferred embodiments, the internal conical surface on the body is located between the second threading and the body side inlet port; the first internal threading has a root diameter less than the smallest diameter of the internal conical surface; and a retainer ring is provided to have external threading for rotary make-up with the body internal threading for holding the second flow control unit clamped to the body internal conical surface, the



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retainer ring being easily and quickly removable to permit rapid endwise withdrawal of the flow control units from the valve body, and replacement insertion of other units, best accommodated to the flow conditions encountered.

These and other features and advantages of the invention, as well as the details of an illustrative embodiment, will be more fully understood from the following description and drawings, in which:

10 Figure 1 is an elevation showing a choke valve connected with a well installation;

 Figure 2 is an enlarged view, in section, showing the choke valve body, and a first flow control package connected in that body;

15 Figure 3 is a view like Figure 2, but showing a second flow control package connected in that body;

 Figure 3a is a view like Figure 3, showing the valve closed;

20 Figure 3b is an enlarged view, showing the Figure 3 valve in open condition;

 Figure 3c is a section taken on lines 3c-3c of Figure 3b;

25 Figure 4 is another view like Figure 2, illustrating a third flow control package installed in the valve body; and

 Figure 5 is yet another view like Figure 2, showing a fourth flow control package installed in the valve body.

30 Referring first to Figure 1, a choke valve 10 is shown as sidewardly connected at 11 to well casing 12, to receive pressurized well fluid from the annulus region 13. Examples of such fluid are drilling mud, steam (as produced by secondary recovery steam injection); and oil and gas possibly containing abrasive particulate. Well tubing appears at 12a.

 Extending the description to Figure 2, the valve 10 is shown to include an axially elongated tubu-



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lar body 14 having a side inlet port 15 for well fluid, a fluid outlet port 16 at one end of the body, and a control entrance 17 at the opposite end of the body through which selected control packages are inserted and withdrawn, for adapting the valve to different flow conditions. Ports 15 and 16 have associated flanges 15a and 16a.

Referring to the body itself, it basically includes first attachment structure, designated at 18, located at a first tubular interior region generally between the ports 15 and 16. The structure 18 is shown to include internal threading 18a formed in body wall extent 19, and adapted to receive a first flow control unit 20 of a selected flow control package inserted into the body via entrance 17. As shown, unit 20 comprises a tubular insert 21 having a tubular and frusto-conical seat 22 presented upstream, toward entrance 17, coaxial with respect to axis 23 of the body 14. A flange 24 on the insert engages stop shoulder 25 on the body to position the insert, in response to rotary make-up of external thread 21b on the insert within internal thread 18a. The insert is elongated, and terminates at 21a, near outlet port 16.

Second attachment structure 26 is provided on the body 14, located at a second tubular interior region between entrance 17 and port 15. The second attachment structure is shown to include internal threading 27 near entrance 17, and an internal frusto-conical surface 28 on the body between threading 27 and port 15. (Threading 27 may be external, on the body). Structure 26 is adapted to receive a second flow control unit 29 of the selected package inserted endwise into the body via entrance 17, for retention by the second threading. As shown, unit 29 includes a needle or stem 30, and mechanism for moving the needle tapered end 30a axially toward and away from the seat 22, whereby flow through the seat may be controlled. In this regard, stem 30 is externally threaded at 31 for rotary



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meshing engagement with internal thread 32 on a tubular insert 33, and a handle 42 on the end 30_b of the stem is rotatable to advance or retract the stem. Note also thread protective jacket 125 fastened at 126 to insert 5 33.

Insert 33 has an external frusto-conical surface 34 that seats against corresponding internal surface 28 on the body, axially positioning the insert and the stem in the valve body chamber 36, coaxially with the seat 10 22. An annular retainer 37 extending about the insert 33 has an the external thread 38 meshing with body thread 27, and a nose 39 engaging shoulder 40 on the insert to clamp the insert in position with conical surfaces 28 and 34 interengaged.

15 In regard to the above, note annular seals 43-46. Retention elements for seal 45 appear at 47_a, 47_b, and 47_c. Seal 46 is retained in recess 46_a and against taper 28. Also, a set screw 48 is provided on the insert to engage the stem thread 31 and lock it in position, 20 axially.

When it is desired to change valve control packages, retainer 37 is rotatably removed, and inserts 33 and 21 withdrawn, in sequence, via entrance 17, whereby the described package, that includes units 20 25 and 29, is removed. That package is adapted to low erosion application, i.e. fluids which contain few if any abrasive particles. A typical example would be hydrocarbon gas, such as methane, containing few if any abrasive particles. Grasable protruding end 37_b of the 30 retainer 37 facilitates rapid removal of the retainer. Note also lubricant porting 100 and 101. Flange 24 on insert 20 has notches 102 for reception of a tool to rotatably advance or retract that insert.

Referring now to Figures 3, 3_a and 3_b, the same 35 body 14 is shown receiving a first flow control unit



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50 of another selected valve control package inserted into the body via entrance 17. As shown, unit 50 comprises a first tubular sleeve 51; with side wall through openings 51a for controllably passing well fluid 5 from the exterior 52 of the sleeve to the sleeve bore 53. The sleeve is carried by a tubular insert 54, there being annular mounting ring 55 positioned between a flange 56 on the sleeve and a flange 58 on the insert. Flange 58 engages stop shoulder 25 on the body to position the insert in response to rotary make-up of external thread 59 on the insert within internal thread 18a. The insert is elongated, and the sleeve end 51b remote from flange 58 protrudes from the insert, as shown, and a seal 60 on the insert, retained at 61, 15 engages the body bore 62. Note also seals 63 and 64. In closed position, seal 56 is pressurized axially to seal against bore 66a of sleeve 66, as shown in Figure 3a.

A second flow control unit 65 of the selected 20 package is inserted endwise into the body via entrance 17, for retention by the second threading 27. As shown, unit 65 includes the above referenced second tubular sleeve 66, together with mechanism for moving that sleeve axially in telescopic relation with the 25 first sleeve 51 to control flow through openings 51a and sleeve bore 53. In the example, sleeve 66 has a bore 66a in sliding interfit with the cylindrical surface 51d of sleeve 51. In this regard, the sleeve 66 is carried at the end of a stem 68 which is externally 30 threaded at 69 for meshing engagement with internal thread 70 on tubular insert 71; and a handle 110 on the end 68a of the stem is rotatable to advance or retract the stem. Note also the external flange 72 on the end of the stem engaging one end of the internal flange 73 35 on the sleeve 66, and the retainer ring 74 on the stem engaging the opposite end of the flange 73.



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Insert 71 has an external frusto-conical surface 76 that seats against corresponding internal surface 28 on the body, axially positioning the insert and the stem in the valve body chamber 36, coaxially with the sleeve 66. An annular retainer 77 extending about the insert 71 has an the external thread 78 meshing with body thread 27, and a nose 79 engaging shoulder 80 on the insert to clamp the insert in position, with conical surfaces 28 and 76 interengaged.

10 In the above, note annular seals 81-83. Also, a set screw 84 is provided on the insert 71 to engage stem thread 69 to lock that thread, the stem, and sleeve 66 in position, axially.

When it is desired to change valve control 15 packages, retainer 77 is rotatably removed and inserts 71 and 54 withdrawn in sequence via entrance 17. This package (Figure 3) is especially adapted for control of liquid flow, as for example petroleum, and at the end of drilling operations, i.e. "clean-up", prior to 20 production of a well. Note tool graspable shoulders 112 and 113 on insert 54 and retainer 77.

Referring now to Figure 4, the same body 14 is shown receiving a first flow control unit 90 of yet another selected valve control package inserted into the 25 body via entrance 17. As shown, unit 90 comprises a first tubular sleeve 91 with side wall through openings 91a for controllably passing well fluid from the exterior 92 of the sleeve to the sleeve bore 93. The sleeve includes a tubular insert portion 91b positioned 30 between a flange 97 on that insert portion and outlet port 16. Flange 97 engages stop shoulder 25 on the body to position the sleeve in response to rotary make-up of external thread 99 on the insert within internal thread 18a. The insert is elongated, and the sleeve 35 91 protrudes into chamber 36 from the insert, as shown.



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A seal 100 on the insert engages the body bore 62.
Note also seal 102.

A second flow control unit 105 of the selected package is inserted endwise into the body via entrance 5 17, for retention by the second threading 27. As Shown, unit 105 includes a second tubular sleeve 106, together with mechanism for moving that sleeve axially in telescopic relation with the first sleeve 91 to control flow through openings 91a. In the example, sleeve 106 10 has a bore 106a in sliding interfit with the cylindrical surface 91c of sleeve 91. In this regard, the sleeve 106 is carried at the end of a stem 108 which is externally threaded at 109 for meshing engagement with internal thread 110 on tubular yoke 111; and a 15 handle 138 on the end 108a of the stem is rotatable to advance or retract the stem. Note also the external flange 112 on the end of the stem engaging one end of the retainer ring 113 on the sleeve 106.

An insert 114 has an external frusto-conical 20 surface 115 that seats against corresponding internal surface 28 on the body, axially positioning the tubular insert 114, the stem 108 and the sleeve 106 in the valve body chamber 36, coaxially with the sleeve 91. Yoke 111 is positioned axially relative to the insert 114 25 by retainer 128 (integral with yoke 111) and stuffing box seal elements 115-125 located axially between the collar and flange 127 on insert 114 are compressed by adjustable flange 126. The annular retainer 128 extending about the insert 114 has on the external 30 thread 129 meshing with body thread 27, and a nose 130 engaging flanged shoulder 131 on the insert to clamp the insert in position with conical surfaces 28 and 115 interengaged. Removable and adjustable fasteners 140 reatin part 126 to the retainer, to adjust the axial 35 compression exerted on seal elements 115-125. Note also seal ring 133 on insert 114 and engaging surface 28.



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A set screw 136 is provided on a thread protector collar 137 to engage stem end 108a to lock the collar 137 and handle 138 to the stem 108.

When it is desired to change the valve control package, retainer 128 is rotatably removed, and inserts 114 and 91 withdrawn in sequence via entrance 17. Removal of retainer 114 also removes stem 108 and sleeve 106. This package (Figure 4) is especially adapted for control of steam flow, as for example during secondary recovery of petroleum from oil wells, the steam being injected into the well through the choke, as via ports 15 and 16 in sequence.

Referring finally to Figure 5, body 14 is shown receiving a first flow control unit 150 of a further selected valve control package inserted into the body via entrance 17. Unit 150 comprises a tubular part 151 in the form of a flow bean, having an entrance end 151a for controllably passing well fluid from the inlet 15 to outlet 16, via chamber 36. Tubular part 151 is carried by a tubular insert 153, and elements 55, 56, 60 and 61 correspond to those shown in Fig. 3b. A flange 155 on the insert 153 engages stop shoulder 25 on the body, to axially position the insert, and part 151, in response to rotary make-up of exterior thread 156 on the insert within internal thread 18a. Flange 155 is notched at 155a for reception of a tool, inserted via entrance 17, for rotatably advancing or retracting the insert.

The tubular part 151 protrudes beyond the insert, in both axial directions to protect the metallic insert from abrasive wear. Part 151 typically consists of wear resistant material, as for example silicon carbide, and it may become abraded substantially over time by abrasive particles in the flow, without damage to insert 153.

A second flow control unit 160 includes a plug



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- 161 closing entrance 17. Plug 161 has a conical surface 161a engaging body conical surface 28, and a retainer 162 clamps the plug in position, with sealing and centering surfaces 161a and 28 interengaged.
- 5 Retainer 162 has external thread 162a made-up to body thread 27, and has a protruding nut end 162c accessible exteriorly for retainer turning purposes. A nose 162b on the retainer engages flanged shoulder 163 on the plug to urge the latter downwardly, as shown.
- 10 A closure 164 has threaded fit at 165 with the plug to close axial opening 166 therethrough. Opening 166 serves as an access port, as for pressure gages, or bleeder valves. The Figure 5 package is useful for non-changing flow control "choke" requirements, and is
- 15 inexpensive.

It will be noted in the above figures, that the first threading 18a has a root diameter less than the smallest diameter of conical surface 28; and that the largest diameter of surface 28 is less than the thread

20 internal tip diameter of the second threading 27. As a result, the different flow control packages can easily be inserted into the valve body via entrance 17, and withdrawn for replacement or for substitution of other packages. Note also the discharge piping 175 downward

25 of port 16.



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CLAIMS

1. The method of accommodating valve apparatus to different fluid flow conditions, comprising providing an axially elongated and tubular valve body having a side fluid inlet port, a fluid outlet port at one end of the body, and a control entrance at the opposite end of the body, characterized by there being provided first attachment structure on the body at a first tubular interior region generally between said ports, and there being provided second attachment structure on the body at a second tubular region, generally between said entrance and said ports, providing multiple flow control packages and sequentially installing said packages into said body via said entrance and removing said packages from said valve body via said entrance, each of said packages including first and second flow control units and said installation including attaching said first unit to said first attachment structure and then attaching said second flow control unit to said second attachment structure so that said units are positioned to control flow passing from the fluid inlet port to the fluid outlet port, said multiple flow control packages being provided to have different flow control unit constructions.

2. The method of claim 1, characterized in that one of said flow control packages is provided to have a first flow control unit that includes a tubular seat, and a second flow control unit that includes a tubular needle, and including the step of moving said needle axially toward and away from said seat.

3. The method of claim 1, characterized in that one of said flow control packages is provided to have a first flow control unit that includes a first tubular sleeve with side wall through openings, and a second flow control unit that includes a second tubular sleeve, and including the step of moving said second sleeve in telescopic relation with said first sleeve to control the flow



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through said openings.

4. The method of claim 1, characterized in that one of said flow control packages is provided to have a first flow control unit that includes a flow bean, and a second flow control unit that includes a stopper closing said entrance, and including the step of maintaining said entrance closed by the stopper during fluid flow through said bean.

5. The method of any of claims 1 to 4, characterized in that said attachment of the first unit to the first attachment structure is effected by rotating an exteriorly threaded part of the first unit in thread make-up relation to the first attachment structure, and said attachment of the second unit to the second attachment structure is effected by rotating an exteriorly threaded part of the second unit in thread make-up relation to the second attachment structure.

6. The method of claim 5, characterized in that said attachment of the second unit to the second attachment structure also includes clamping an external conical surface of the second unit into an internal conical surface of the second attachment structure in response to said thread make-up of said exteriorly threaded part of the second unit to the second attachment structure.

7. The method of claim 1, characterized in that said packages include at least two of the following:

- i) relatively movable needle and seat elements;
- ii) telescopically interfitting sleeve elements;

and

- iii) flow bean and stopper elements, and

said two packages are selectively installed into and removed from said body.

8. The method of claim 7, characterized in that said packages include all three of i), ii), and iii), and said three packages are selectively installed into



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and removed from said body.

9. The method of one of claims 1 to 8, characterized in that said valve body is attached to a fluid producing or receiving well head, and including the step of flowing said fluid under pressure into said body between said inlet and outlet ports; and including removing one of said packages and installing another of said packages with said body attached to the well head.

10. The valve apparatus adapted for use with different fluid flow conditions, comprising an axially elongated and tubular valve body having a side fluid inlet port, a fluid outlet port at one end of the body, and a control entrance at the opposite end of the body, characterized by first attachment structure including first internal threading on the body at a first tubular interior region generally between said ports, said first attachment structure being adapted to threadably receive a first flow control unit of a selected flow control package inserted into said body via said entrance, and second attachment structure including second threading on the body at a second tubular region generally between said entrance and said ports, said second attachment structure being adapted to receive a second flow control unit of said selected package inserted into said body via said entrance, for retention by said second threading, said second attachment structure also including an internal conical surface on the body between said entrance and said ports, said internal conical surface adapted to receive clamping thereagainst of an external conical surface of the second flow control unit, whereby said first and second flow control units are then positioned to control flow passing from said fluid inlet port to the fluid outlet port.



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11. The valve apparatus of claim 10, characterized in that said first flow control unit is attached to said first threading and said second flow control unit is attached to said second threading and clamped to said interior conical surface.

12. The valve apparatus of claim 11, characterized in that said first flow control unit includes a tubular seat and said second flow control unit includes a needle and mechanism for moving the needle axially toward and away from the seat.

13. The valve apparatus of claim 11, characterized in that said first flow control unit includes a first tubular sleeve with side wall through openings and said second flow control unit includes a second tubular sleeve and mechanism for moving said second sleeve axially in telescopic relation with said first sleeve to control the flow through said openings.

14. The valve apparatus of claim 11, characterized in that said first flow control unit includes a flow bean consisting of abrasive wear resistant material, and said second flow control unit includes a plug closing said entrance.

15. The valve apparatus of any of claims 10 to 15, characterized in that said internal conical surface is located between said second threading and said ports.

16. The valve apparatus of claim 15, characterized in that said first threading has a root diameter less than the smallest diameter of said internal conical surface.

17. The valve apparatus of claim 15 or 16, characterized by a stop shoulder on the body to limit threaded make-up of said first flow control unit to said first internal threading and a flow passage defined by said first flow control unit located between said ports.



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18. The valve apparatus of one of claims 11 to 15, characterized by a retainer ring meshing with said second internal threading and holding said second flow control unit clamped to said internal conical surface.



FIG. 1.

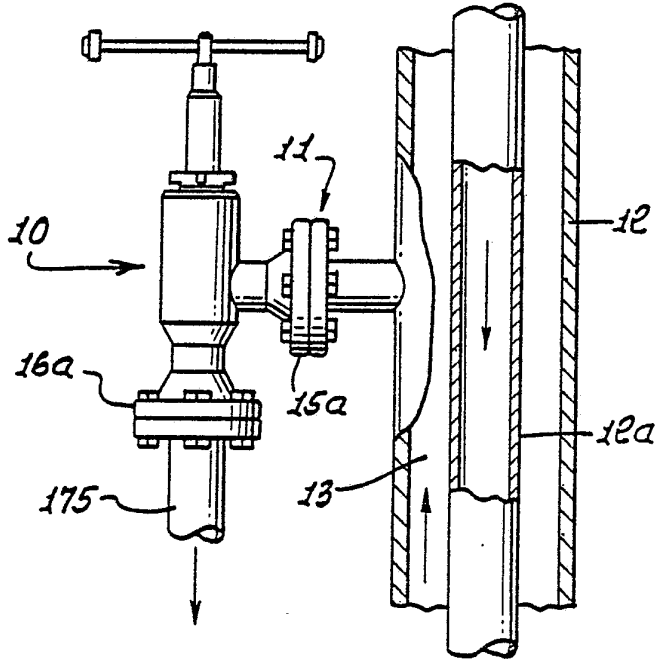


FIG. 3b.

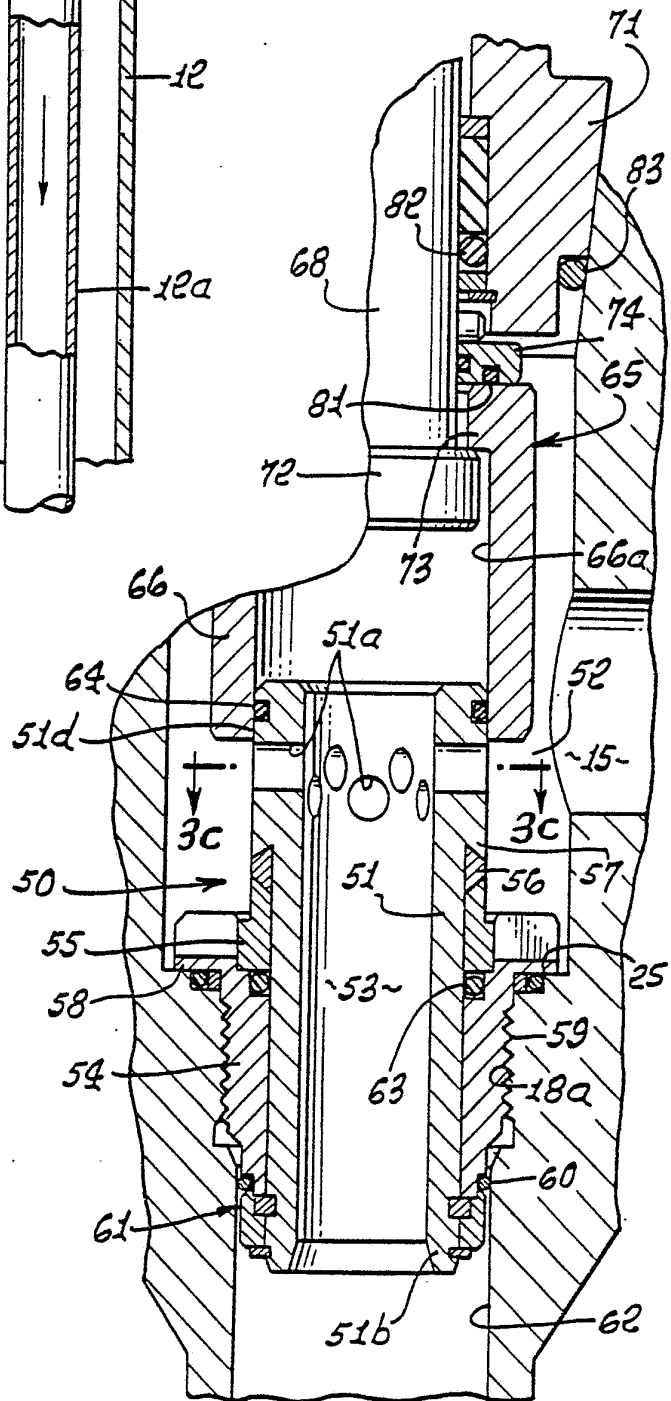
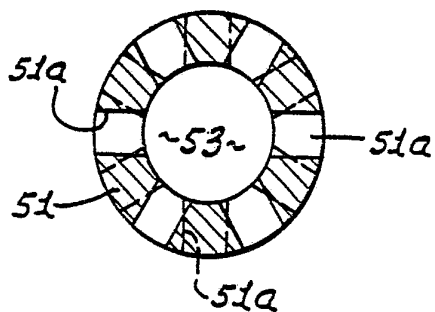
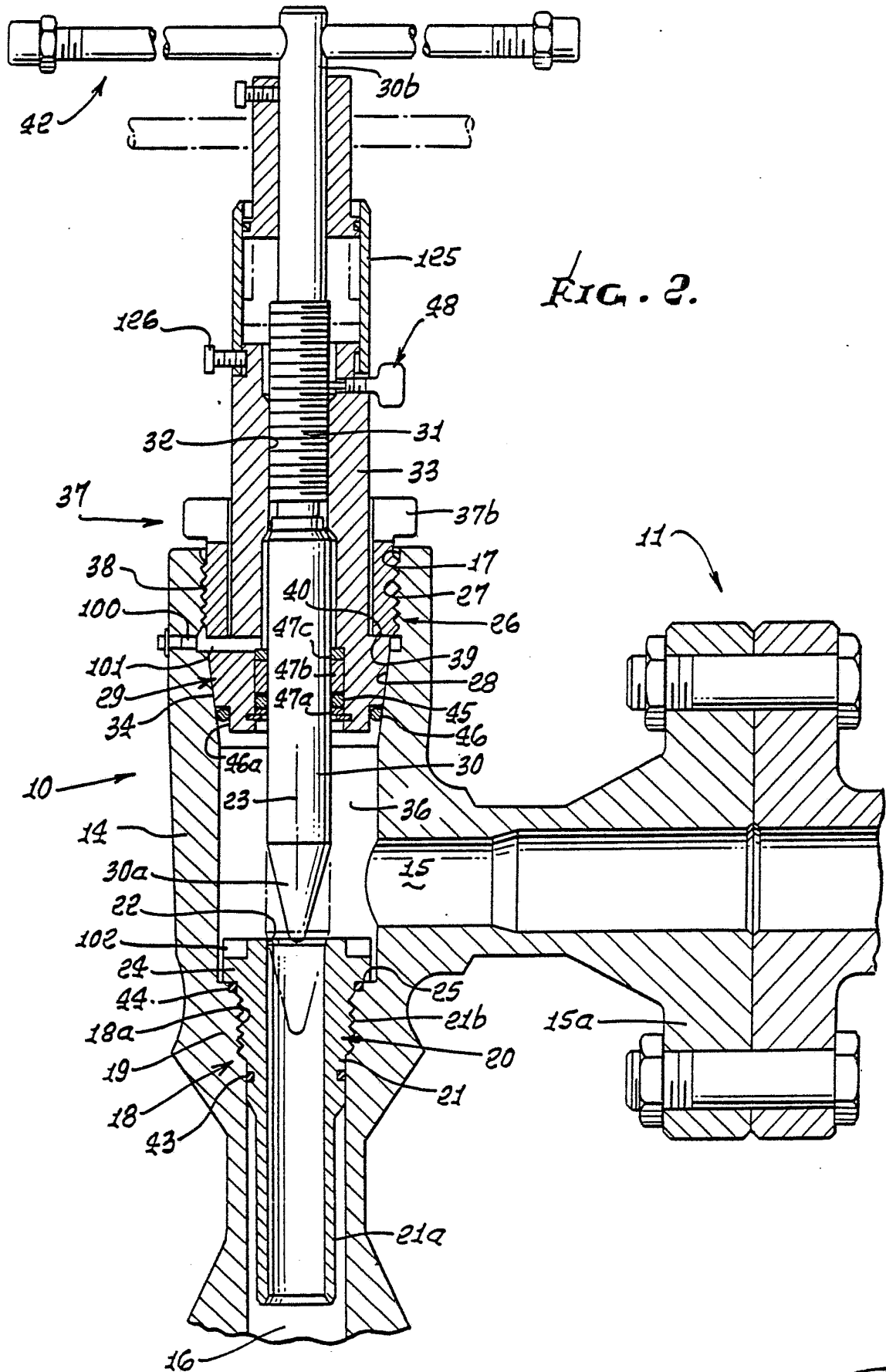


FIG. 3c.





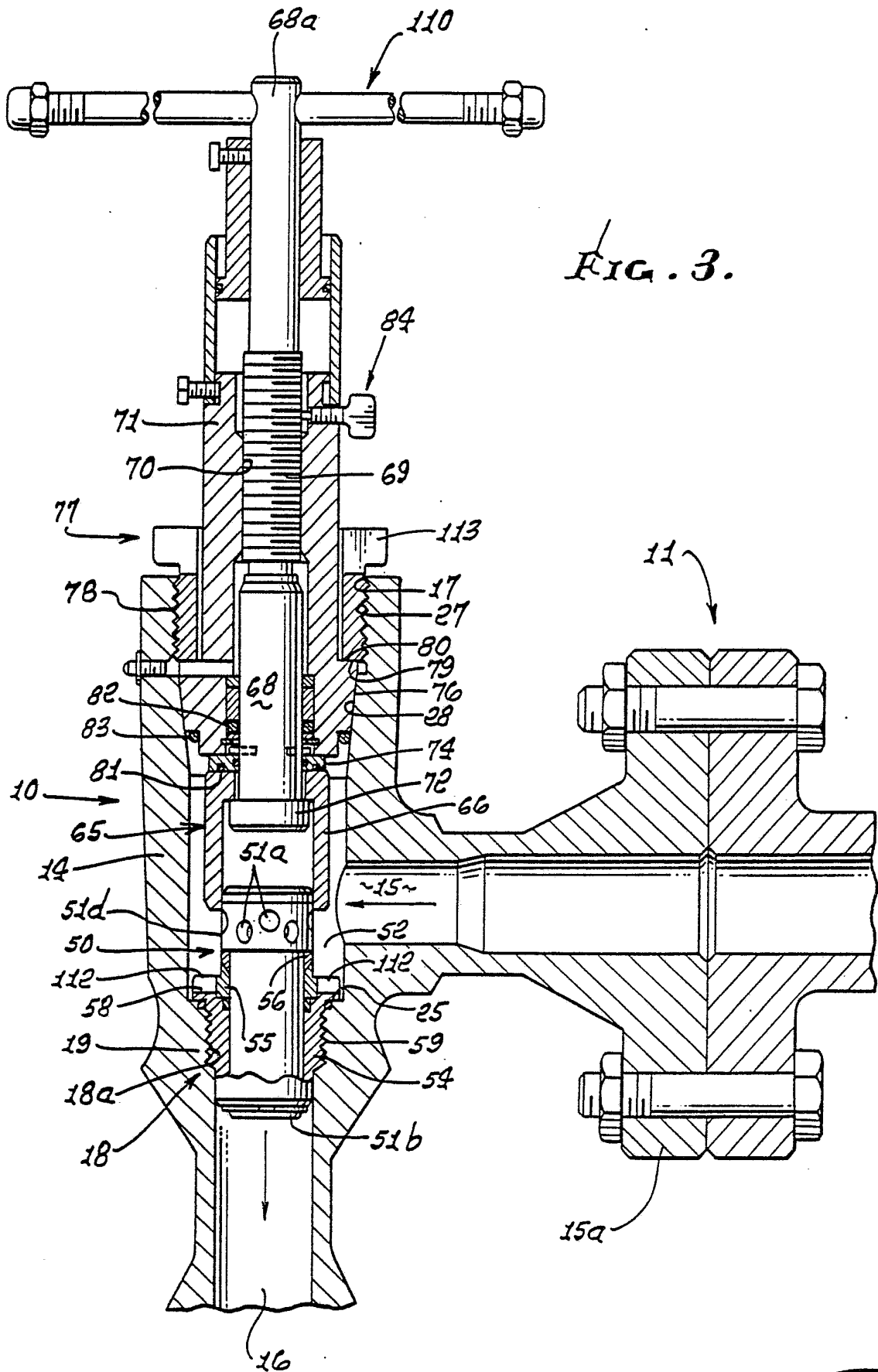
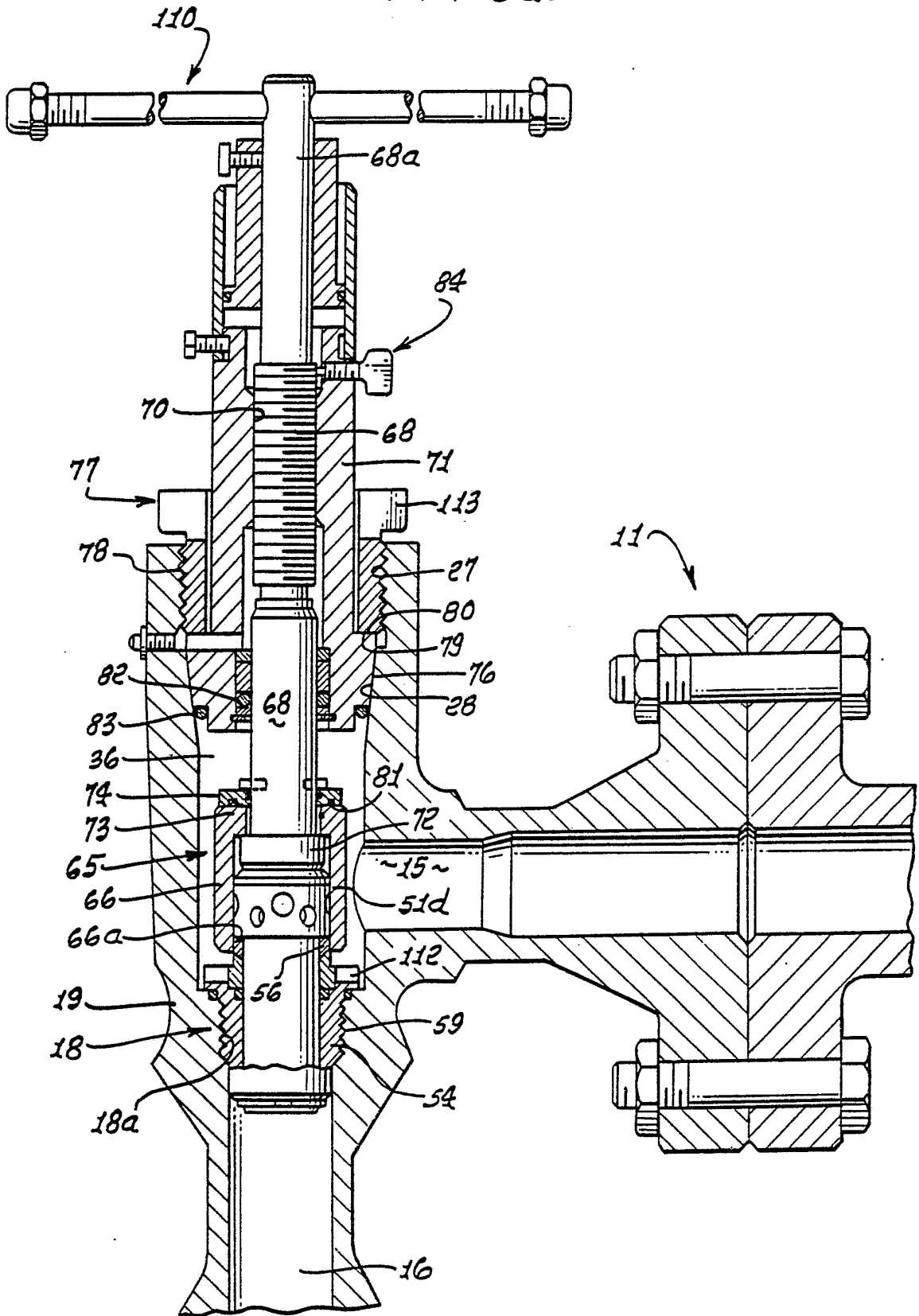


FIG. 3a.



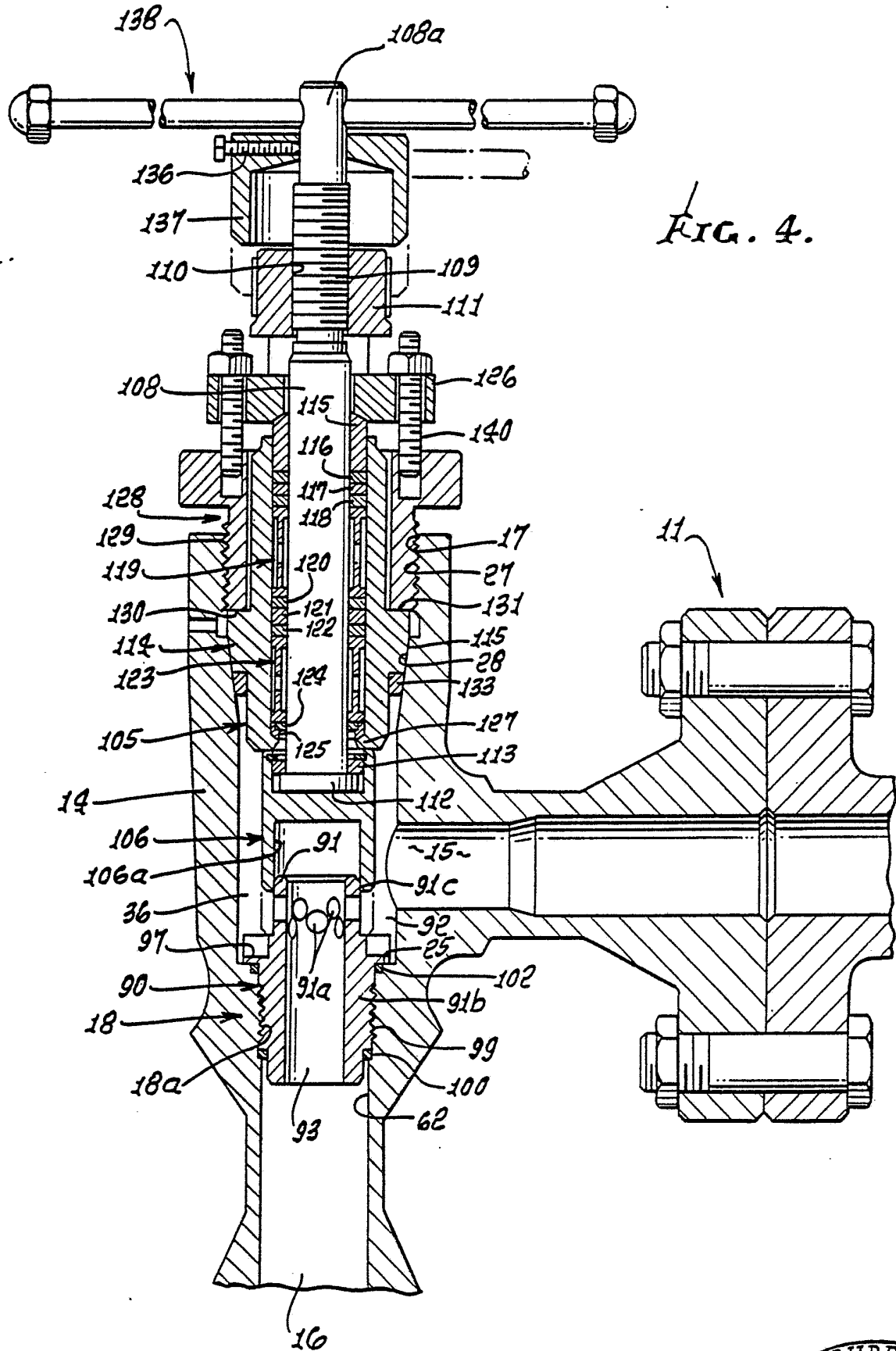
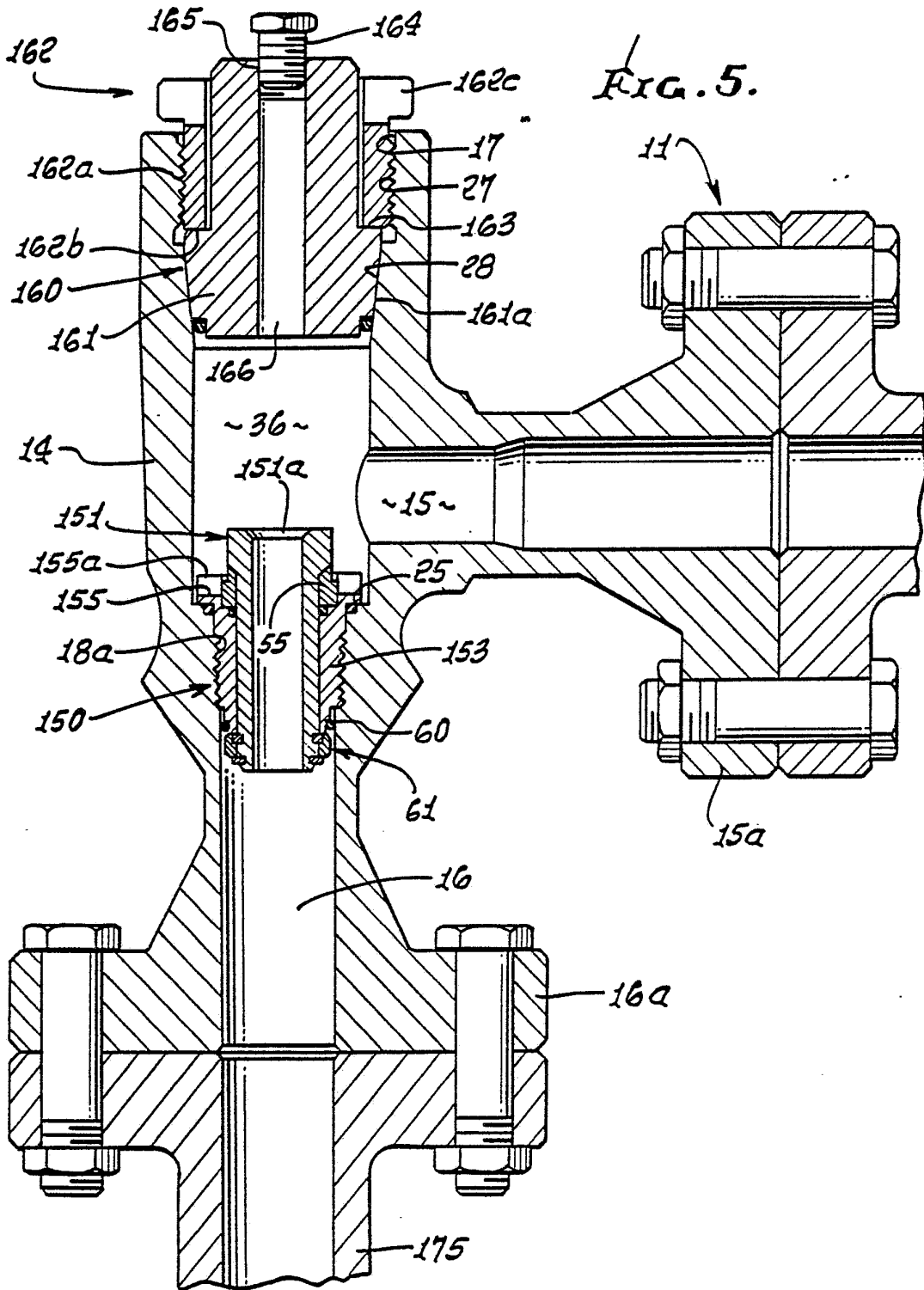


FIG. 4.



INTERNATIONAL SEARCH REPORT

International Application No PCT/US 84/00544

I. CLASSIFICATION OF SUBJECT MATTER (if several classification symbols apply, indicate all) ³		
According to International Patent Classification (IPC) or to both National Classification and IPC		
IPC ³ : F 16 K 27/00; F 16 K 3/26; F 16 K 1/38		
II. FIELDS SEARCHED		
Minimum Documentation Searched ⁴		
Classification System	Classification Symbols	
IPC ³	F 16 K 27/00; F 16 K 3/00; F 16 K 1/00; F 16 K 47/00; F 16 K 25/00; E 21 B 34/00	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched ⁵		
III. DOCUMENTS CONSIDERED TO BE RELEVANT ¹⁴		
Category [*]	Citation of Document, ¹⁶ with indication, where appropriate, of the relevant passages ¹⁷	Relevant to Claim No. ¹⁸
X	GB, A, 923872 (INTERNATIONAL BASIC ECONOMY CORP.) 18 April 1963 see claim 1	1
Y	page 4, lines 85-99 ---	2,3
Y	US, A, 2614795 (CAMERON IRON WORKS) 21 October 1952 see column 2, lines 27-35 ---	2
Y	GB, A, 2022216 (E.O. LEE) 12 December 1979 see the abstract ---	3
A	US, A, 4356997 (QUALITY VALVE AND MACHINE WORKS) 2 November 1982 ---	
A	US, A, 3521853 (T.S. GILLIS Jr.) 28 July 1970 ---	
A	US, A, 2765143 (C.A. BEST) 2 October 1956 -----	
<p>[*] Special categories of cited documents: ¹⁵</p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"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)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> <p>"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</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step</p> <p>"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.</p> <p>"&" document member of the same patent family</p>		
IV. CERTIFICATION		
Date of the Actual Completion of the International Search ²	Date of Mailing of this International Search Report ³	
31st July 1984	23-AOCT 1984	
International Searching Authority ¹	Signature of Authorized Officer ²⁰	
EUROPEAN PATENT OFFICE	G.L.M. Kruidenberg	

ANNEX TO THE INTERNATIONAL SEARCH REPORT ON

INTERNATIONAL APPLICATION NO. PCT/US 84/00544 (SA 7014)

This Annex lists the patent family members relating to the patent documents cited in the above-mentioned international search report. The members are as contained in the European Patent Office EDP file on 13/08/84

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Patent document cited in search report	Publication date	Patent family member(s)	Publication date
GB-A- 923872		None	
US-A- 2614795		None	
GB-A- 2022216	12/12/79	CA-A- 1101823	26/05/81
US-A- 4356997	02/11/82	None	
US-A- 3521853	28/07/70	None	
US-A- 2765143		None	

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