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- *with information concerning one or more priority claims considered void*

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A replaceable cutting insert and a milling tool.

5

BACKGROUND OF THE INVENTION

The present invention relates to a cutting insert, a milling tool and a milling body according to the preambles of the appended independent claims.

10 At slot-milling cutters, the periphery of the milling body is equipped with a number of cutting inserts, every second one of which protrudes in relation to one side of the milling body and every second from the opposite side of the milling body. The relative displacement of the cutting inserts is made in order to obtain clearance and in order to obtain slots having perpendicular or parallel bordering surfaces. The
15 bottom surface of the slot is cut by means of the major cutting edges of the cutting inserts while the side surfaces of the slot are cut by means of the minor cutting edges extending substantially perpendicularly to the major cutting edges. Radii between the bottom surface and the side surfaces are obtained by means of more or less rounded cutting corners at a transition between associated pairs of major and
20 minor cutting edges of each cutting insert. The relative displacement requires that the cutting inserts are formed in particular right hand and left hand embodiments in order to guarantee the requisite clearance between the side wall and the portion of the cutting insert following after the minor cutting edge.

Through EP-A-0 873 808 a single sided cutting insert is previously known,
25 which comprises only two, but different, cutting edges, which should not be possible mix-up by the operator. The known cutting insert means poor utilization of the possibilities of the cutting material. In US-A-5,454,671, another single sided cutting insert is shown. A double sided slot milling insert is shown in US-A-5,004,380 having wear reducing lands.

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OBJECTS OF THE INVENTION

One object of the present invention is to provide a single sided cutting insert for a wide variety of widths of the slots.

Another object of the present invention is to provide an easy-cutting single

sided cutting insert.

Another object of the present invention is to provide a cutting insert, the geometry of which permits that varying corner shapes such as radius, chamfer, wiper or other shapes can be formed thereon.

5 Another object of the present invention is to provide a milling tool and a cutting insert providing a planar bottom surface in the slot.

Another object of the present invention is to provide a milling body and a cutting insert directing the chips away from the generated surface of the slot.

10 BRIEF DESCRIPTION OF THE DRAWINGS

Preferred embodiments of the present invention are described more closely in the following in connection with the accompanying drawing figures, in which;

FIG. 1A is a perspective view of a part of a milling tool according to the present invention and one embodiment of an insert according to the present invention;

15 FIG. 1B partially shows the milling insert according to the present invention mounted to the milling tool.

FIG. 1C shows an enlarged portion of the milling insert as shown by the dashed circle in Fig. 1B.

FIG. 2A is a perspective view of the milling insert shown in Fig. 1A.

20 FIG. 2B is a plan view of the insert according to the invention;

FIG. 2C is a cross-sectional view along the line C-C in Fig. 2B;

FIG. 2D is a front view of the insert shown in Fig.2B;

FIG. 2E shows an enlarged portion of the milling insert as shown by the dashed circle in Fig. 2D.

25 FIG. 2F shows an enlarged portion of the milling insert as shown by the dashed circle in Fig. 2A.

FIG. 2G shows a rear view of the milling insert.

FIG. 3A is a perspective view of a milling insert according to an alternative embodiment of the present invention.

30 FIG. 3B shows an enlarged corner portion of the milling insert as shown by the dashed circle in Fig. 3A.

FIG. 3C shows an enlarged corner portion of the milling insert in a front view.

Fig. 4A shows another alternative embodiment of a milling insert according to

the invention in a perspective view.

FIG. 4B shows an enlarged corner portion of the milling insert as shown by the dashed circle in Fig. 4A.

FIG. 4C shows an enlarged corner portion of the milling insert in a front view.

5 FIGS. 5A and 5B show two alternative shoulder milling tools according to the present invention.

FIG. 6 shows another alternative milling tool according to the present invention.

DETAILED DESCRIPTION OF EMBODIMENTS OF THE INVENTION

10 Figs. 1A–1C shows a part of a slot-milling tool 10 according to the present invention and Figs. 2A-2G shows a slot-milling or cutting insert 11 according to the present invention. The replaceable cutting insert 11 is on-edge mounted in a pocket at the periphery of a slot-milling body 32. The cutting insert 11 comprises a polygonal body of wear resistant material. The body includes a first side surface 12 and a second side surface 13 opposing one another and a number of end surfaces 14A-14D
15 extending therebetween. The intersection of two of said end surfaces forms a cutting edge. The cutting corners 14 of the cutting insert 11 are all identical in this embodiment. The insert 11 is provided with a central hole to receive a clamping screw. The hole intersects the first side surface 12 and the second side surface 13.
20 Each cutting corner is provided with a first cutting edge 16 and a second cutting edge 17. The cutting insert 11 may be comprised of a polygonal body of wear-resistant material of a plate of sintered, preferably coated, cemented carbide, in this case a square basic shape in the view according to Fig. 2B. The two side surfaces 12, 13 are substantially parallel and both extend to end surfaces 14A-14D. The first side
25 surface 12 is substantially planar while the second side surface 13 connects to raised portions 15A-15D at corner portions 14. The raised portions protrude laterally with respect to an imaginary plane P1 containing the second side surface 13 and thus the cutting edge 16 or 17 intersects the plane P1. The raised portions form a relatively small part of the total area of the second side surface 13, i.e. less than
30 30%. The lateral distance between the second side surface 12 and the raised portions 15A-15D determines the greatest width W of the cutting insert 11. A typical value of the width W is 3 to 4 mm. The cutting insert 11 has a negative basic shape since the end surfaces 14A-14D are substantially perpendicular to the side surfaces

12, 13. All corners portions are identical and all raised portions 15A-15D are identical in this embodiment, and therefore substantially only one of the corner portions is discussed hereinafter. The corner portion comprises the first cutting edge 16 and the second cutting edge 17. The first cutting edge 16 extends at an acute angle β to a line perpendicular to the first side surface 12 or to a plane P2 containing the end surface 14B (as illustrated by Fig. 2D). The angle β is chosen within the interval 3 to 9°, such as 4 to 5°. The first cutting edge 16 transits mathematically smooth into the second cutting edge 17. The second cutting edge 17 substantially follows a curved convex path from where it is connected to the first cutting edge 16. The path of the second cutting edge 17 is defined by a radius R1, the origin of which is situated on a line parallel to the first side surface 12. The second cutting edge is defined by the radius R1 in a circle segment about 90°. In this embodiment the second cutting edge 17 tangentially joins a third cutting edge 22 (as illustrated by Fig. 2E) that diverges from the plane P1 at a small angle and that extends to the greatest width W of the insert 11. Then the third cutting edge 22 connects to the second side surface 13 via two steps. The cutting edges 16, 17 connects to a rake face 18. The rake face 18 in this embodiment is positioned at least partly in a plane that slopes downwardly and inwardly from the first cutting edge 16 at an acute angle of about 20° to reduce cutting forces. The rake face 18 slopes from at least the forward part of the second cutting edge 17 in a similar manner. The rake face 18 forms a part of a concave recess 19 in the end surface. The recess 19 directs chips away from the generated surface. A clearance face 20 trails the cutting edges 16,17 when considering the working direction of the slot-milling tool. The clearance face 20 has a generally greater extension behind the second cutting edge 17 than behind the first cutting edge 16. In this embodiment the clearance face 20 extends a distance towards a trailing protrusion.

The cutting edges 16, 17 of each cutting insert 11 at one side of the slot milling tool are provided to cut away about one half of the material in the slot.

Referring especially to Figs. 1A, 1B and 1C each cutting insert 11 is positioned in a pocket 30 having three shoulders and a base surface. The cutting insert 11 rests with its first side surface 12 against the base surface. The base surface is angled within the interval 3 to 9°, such as 4 to 5°, such that its axial depth increases in direction radially inwardly. Thereby the cutting edge 16 and a trailing cutting edge 16'

of another insert (as illustrated by a dashed line in Figs. 1B and 1C) will become parallel to the rotational axis of the slot-milling tool to achieve a smooth or straight slot bottom. As illustrated in Fig. 1C the cutting edge 16 connects to the lower surface 12 via a curved edge portion 16A, 16A' so as to provide smooth transfers
5 between the edges 16 and 16' during slotting.

The shoulders of the pocket in this embodiment are substantially perpendicular to the base surface. Each shoulder is substantially perpendicular to the adjacent shoulder. Adjacent shoulders are separated by a recess fulfilling the objects of providing clearance for a pocket milling tool and subsequently providing clearance for
10 the cutting edges 16, 17 and 22. The shoulder 31 that is closest to the active cutting corner 14 usually does not have a supporting function but rather is provided to deflect chips and debris to avoid damage to a passive cutting corner 14'.

Figs. 3A-3C show an alternative embodiment of a milling insert 111 according to the invention. This embodiment differs from the one previously presented above
15 substantially regarding the periphery of the raised portions 115 and regarding the extension of the clearance faces 120. The first cutting edge 116 here extends over the major part of the width of the cutting insert 111. The second cutting edge 117 is situated beyond the plane P1 with respect to an imaginary midline of the insert 111 and is defined by a small radius in comparison with the radius R1. The clearance
20 face 120 has a generally greater extension behind the second cutting edge 117 than behind the first cutting edge 116 but each clearance face is spaced from the adjacent trailing raised portion 115. In this embodiment the second cutting edge 117 joins a slightly convex third cutting edge 122 (as illustrated by Fig. 3C) that diverges from the plane P1 and that extends to the greatest width W of the insert 111. Then
25 the third cutting edge 122 connects to the second side surface 113 via a substantially straight transition.

Figs. 4A-4C show an another alternative embodiment of a milling insert 211 according to the invention. This embodiment differs from the previously presented
30 embodiments substantially regarding the periphery of the raised portions 215 and regarding the extension of the clearance faces 220. The first cutting edge 216 here extends over a minor part of the width of the cutting insert 211. The second cutting edge 217 extends over the major part of the width of the cutting insert 211 and intersects the plane P1. The second cutting edge 217 is defined by a larger radius in

comparison with the radius R1 and greater than the radius disclosed in Fig. 2E. The clearance face 220 has a generally greater extension behind the second cutting edge 217 than behind the first cutting edge 216. The clearance face 220 reaches into the adjacent trailing raised portion 215. In this embodiment the second cutting edge 217 joins a third cutting edge 222 that diverges from the plane P1 and that extends to the greatest width W of the insert 211. Then the third cutting edge 222 connects to the second side surface 213 via a concave transition.

Milling of narrow slots with an insert according to the present invention has the advantages of providing a single sided cutting insert for a wide variety of widths of slots and having four cutting corners, providing an easy-cutting single sided cutting insert, providing a cutting insert, the basic geometry of which permits that varying corner shapes such as radius, chamfer, wiper edges or other shapes can be formed thereon, providing a milling tool that cuts a straight bottom surface in the slot, and providing a milling body and a cutting insert directing the chips away from the generated surface of the slot. It should be understood that the shown insert embodiments are to be mounted on one side of the mid plane of the milling tool and that a mirror-imaged milling insert is positioned at the other side of the mid plane.

According to another aspect of the present invention each of the disclosed cutting insert according to the present invention can be used for face and/or shoulder milling. Figs. 5A and 5B show two alternative shoulder milling tools according to the present invention, each having a setting angle being about 90°.

According to yet another aspect of the present invention each of the disclosed cutting inserts according to the present invention can be used for face milling. Fig. 6 shows a milling tool according to the present invention having a setting angle being not 90°, e.g. 45°.

Milling surfaces by using an insert according to the present invention has the advantages of providing a single sided cutting insert for a wide variety of widths of slots and having four cutting corners, providing an easy-cutting single sided cutting insert, providing a cutting insert, the basic geometry of which permits that varying corner shapes such as radius, chamfer, wiper edges or other shapes can be formed thereon, and providing a cutting insert directing the chips away from the generated work piece surface.

The lower surface 12, 112 and 212, respectively, of the cutting insert according

to the present invention is substantially identical in all shown embodiments. All shown insert embodiments can for example be ground from a single blank.

While specific embodiments of the invention have been described in detail, it will be appreciated by those skilled in the art that various modifications and
5 alternatives to those details could be developed in light of the overall teachings of the disclosure. The presently preferred embodiments described herein are meant to be illustrative only and not limiting as to the scope of the invention which is to be given the full breadth of the appended claims and any and all equivalents thereof.

CLAIMS

1. A replaceable cutting insert to be on-edge mounted to a tool, said cutting insert (11;111;211) comprising a polygonal body of wear resistant material, said body including a first side surface (12;112;212) and a second side surface (13;113;213) opposing one another and therebetween a number of end surfaces (14A-14D), the intersection of two end surfaces forming a cutting edge (16,17;116,117;216,217) at a corner portion (14), said cutting insert being provided with a central hole to receive a clamping device, said hole intersecting the first side surface and the second side surface,
- characterized in that the first side surface (12;112;212) is substantially planar and in that the second side surface (13;113;213) connects to raised portions (15;115;215) at corner portions (14) and in that the first side surface (12;112;212) is greater than the second side surface (13;113;213).
2. The insert according to claim 1, wherein the raised portions (15;115;215) determines the greatest width (W) of the cutting insert (11;111;211) and in that the cutting edge (16,17;116,117;216,217) intersects a plane (P1) containing the second side surface (13;113;213).
3. The insert according to claim 1 or 2, wherein the corner portion (14) comprises a first cutting edge (16;116;216) and a second cutting edge (17;117;217) and in that the first cutting edge (16;116;216) extends at an acute angle (β) to a line perpendicular to the first side surface (12;112;212) or to a plane (P2) containing an end surface (14C).
4. The insert according to claim 3, wherein the acute angle (β) is chosen within the interval 3 to 9°, such as 4 to 5°.
5. The insert according to claim 1, 2 or 3, wherein the first cutting edge (16;116;216) transits mathematically smooth into the second cutting edge (17;117;217).
6. The insert according to any one of the preceding claims, wherein a clearance face

(20;120;220) trails the cutting edges (16,17), said clearance face (20;120;220) having a generally greater extension behind the second cutting edge (17;117;217) than behind the first cutting edge (16;116;216).

- 5 7. The insert according to any one of the preceding claims, wherein the cutting edges (16,17;116,117;216,217) connects to a rake face (18), said rake face (18) being positioned at least partly in a plane that slopes downwardly and inwardly from the first cutting edge (16;116;216) at an acute angle.
- 10 8. The insert according to any one of the preceding claims, wherein the rake face (18) forms a part of a concave recess (19) in the end surface (14A-14D).
9. A milling tool having a milling body, the periphery of said milling body being equipped with a number of cutting inserts (11;111;211), c h a r a c t e r i z e d i n
15 that the tool has pockets, each carrying an on-edge mounted cutting insert according to anyone of claims 1-8.

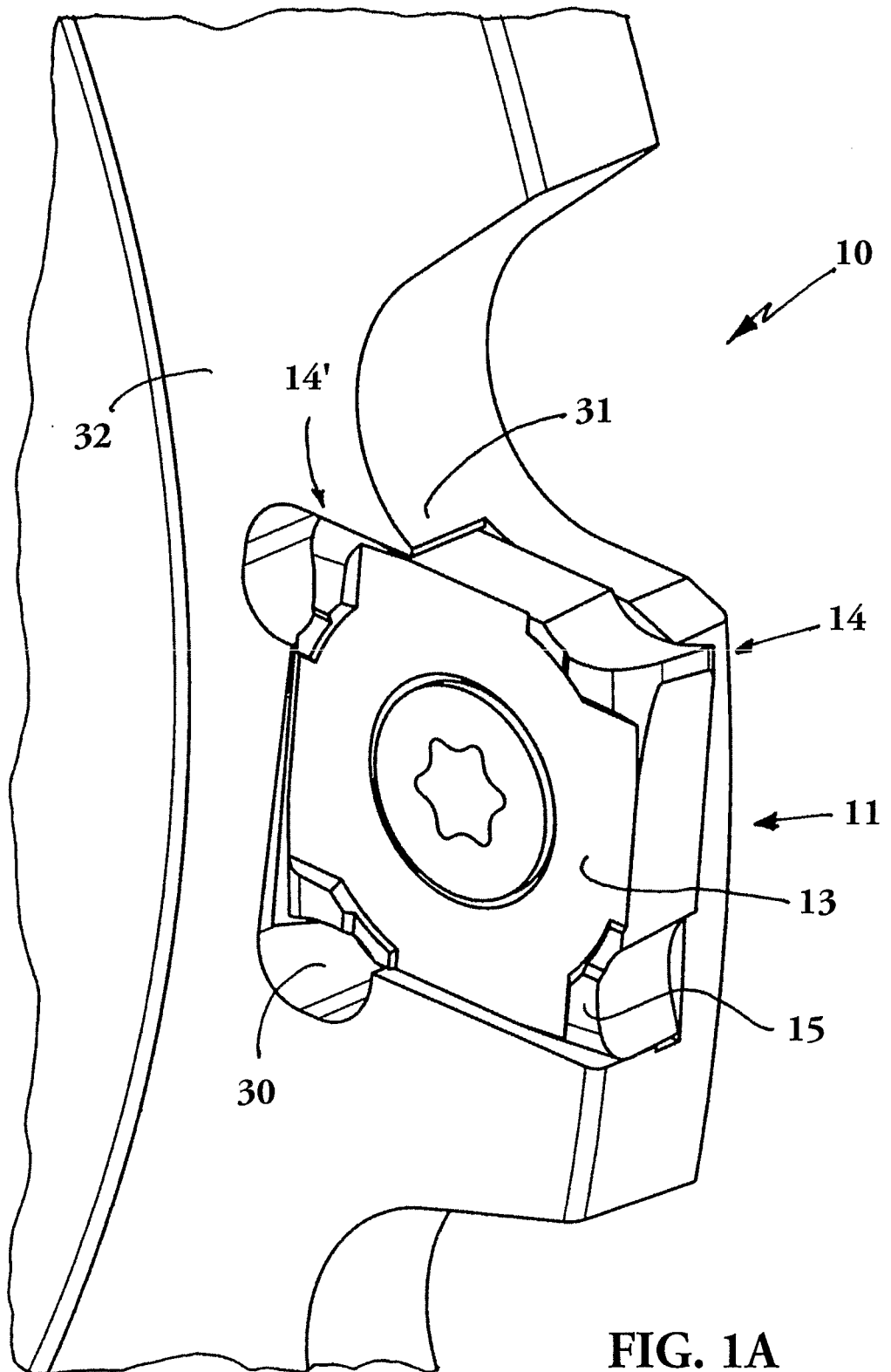


FIG. 1A

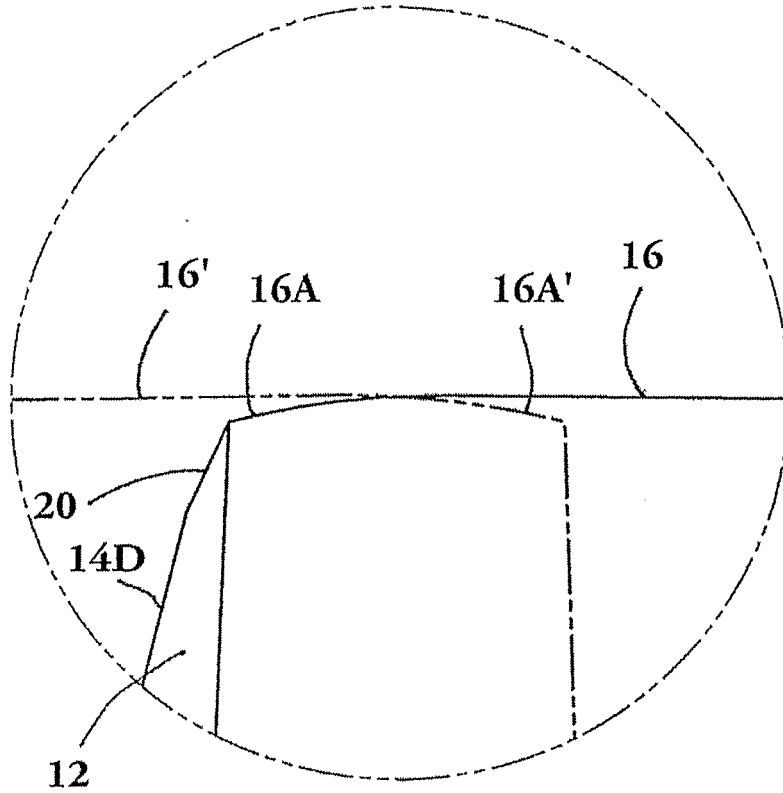


FIG. 1C

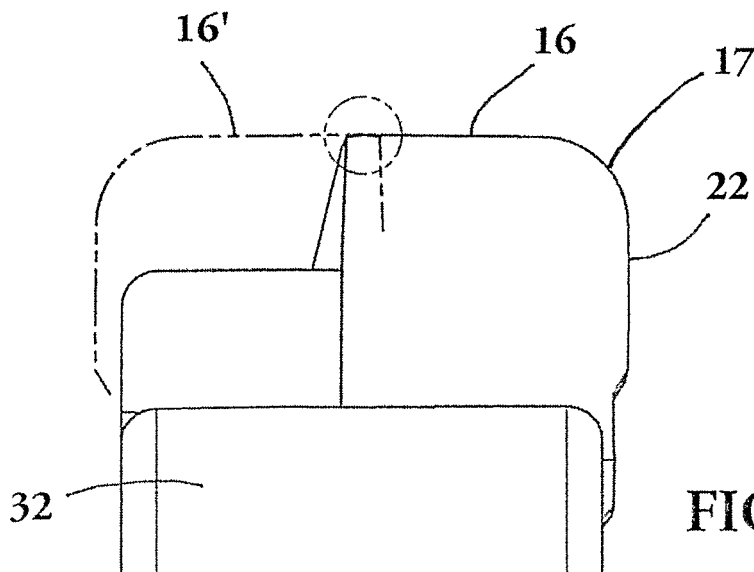


FIG. 1B

3/8

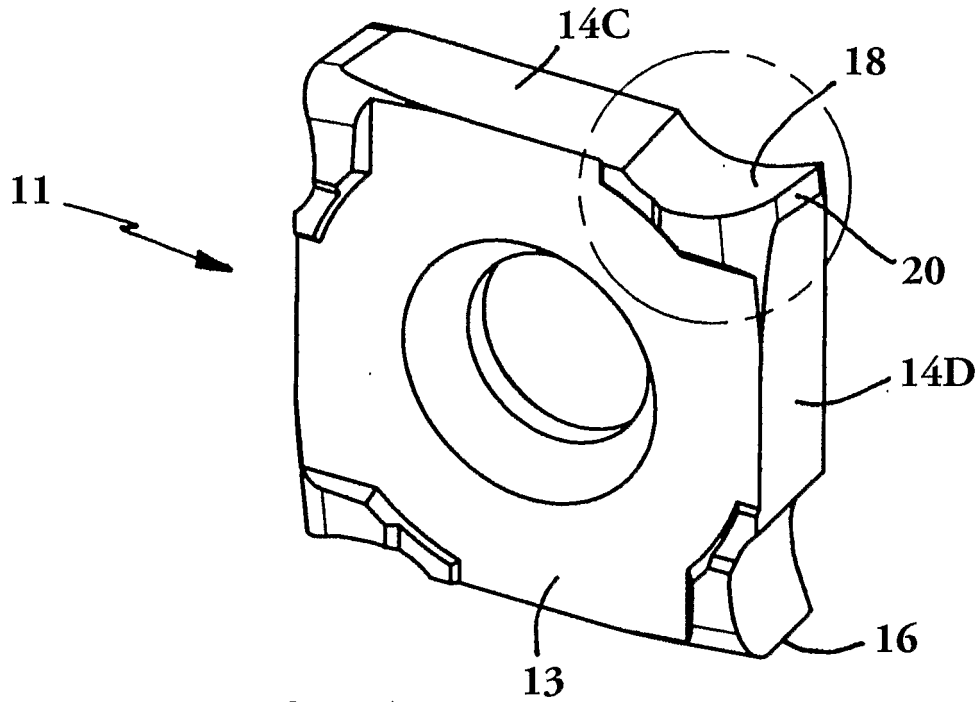


FIG. 2A

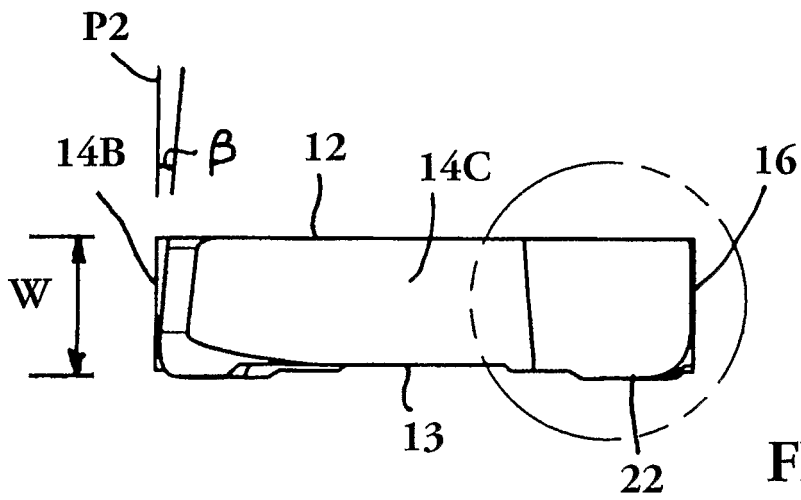
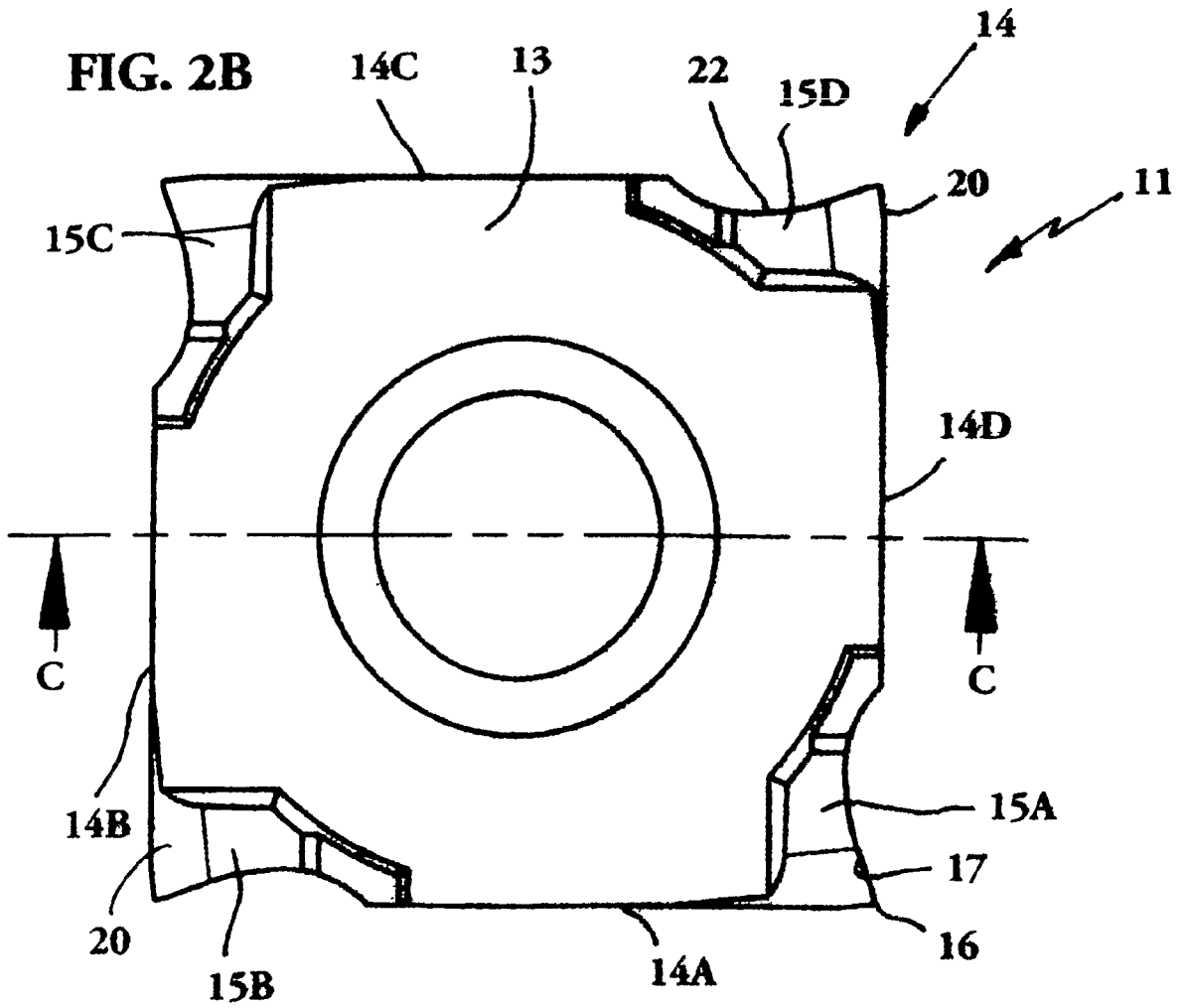
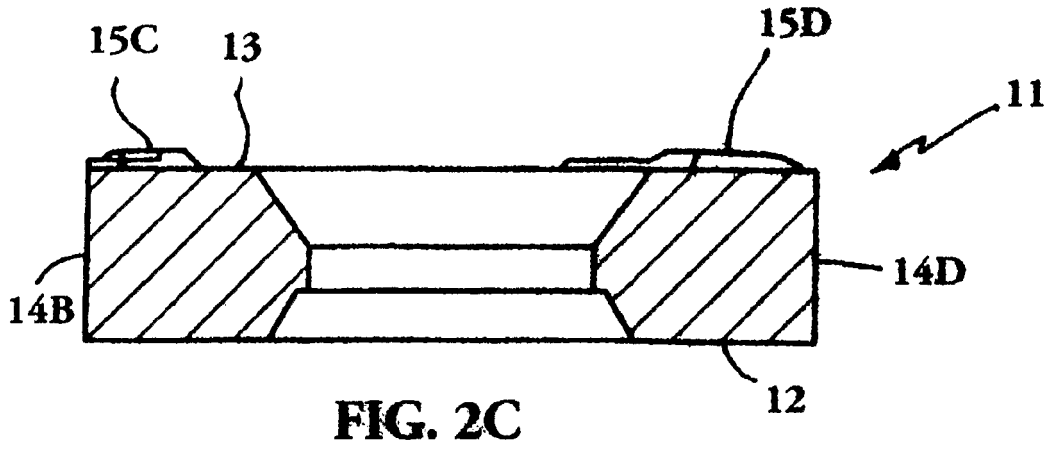


FIG. 2D



5/8

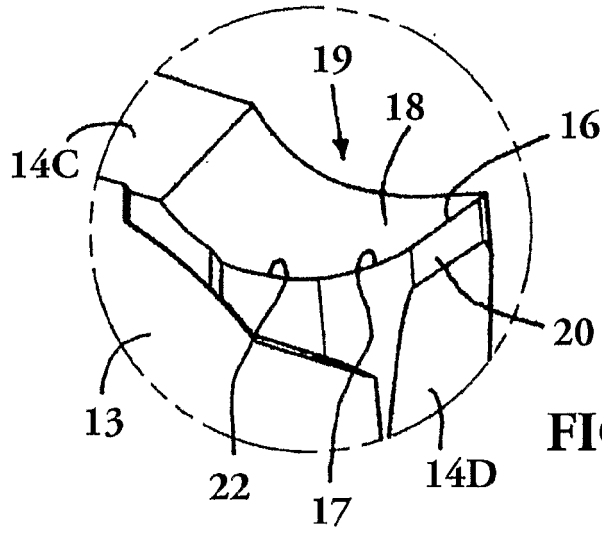


FIG. 2F

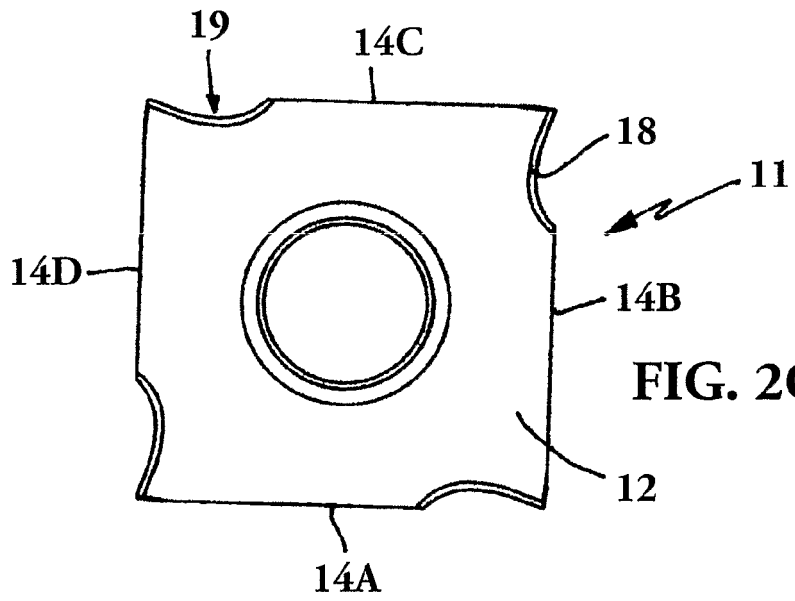


FIG. 2G

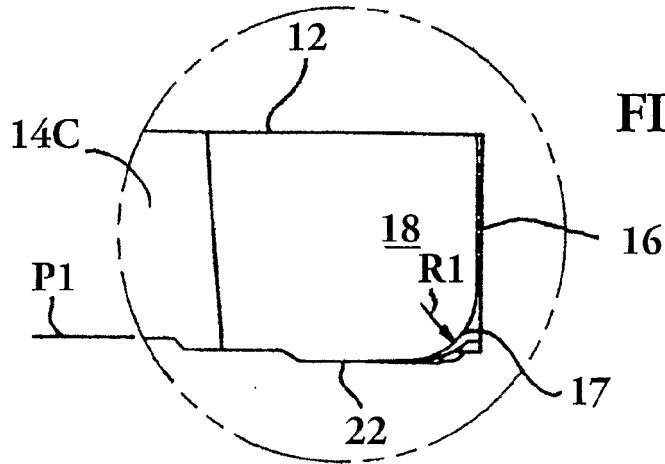


FIG. 2E

6/8

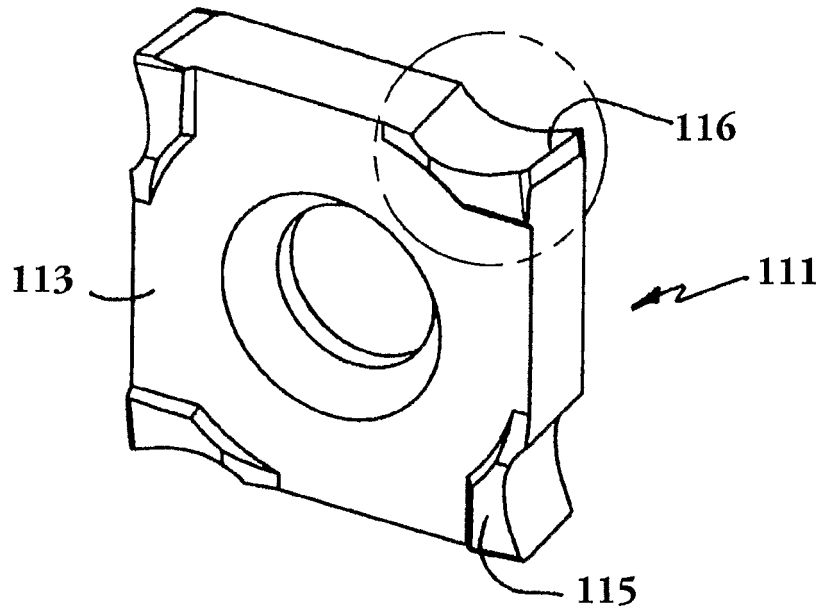


FIG. 3A

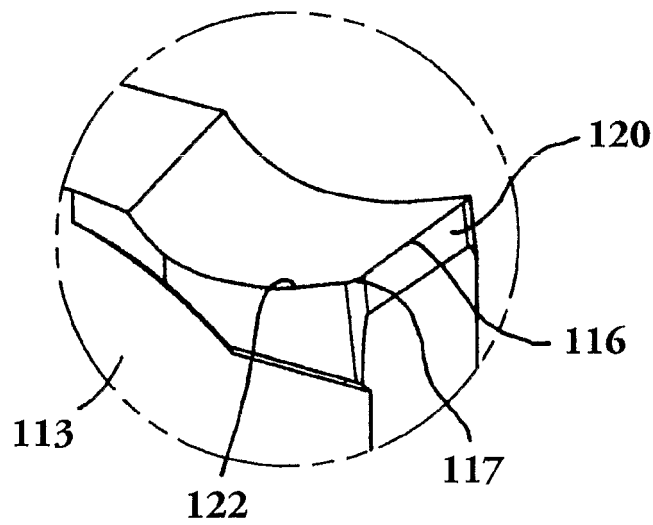


FIG. 3B

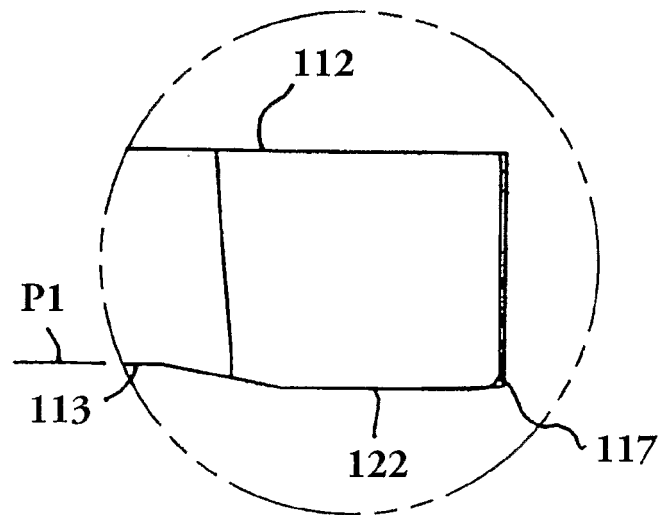
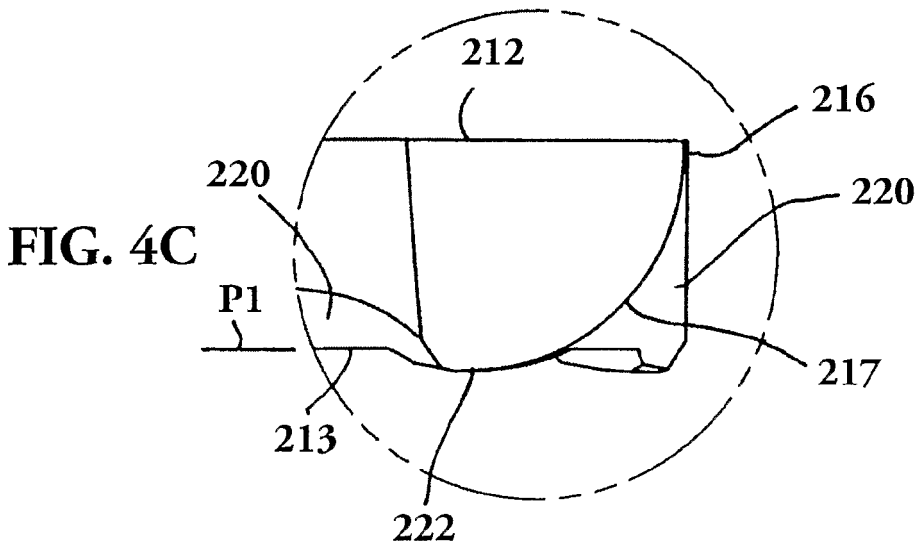
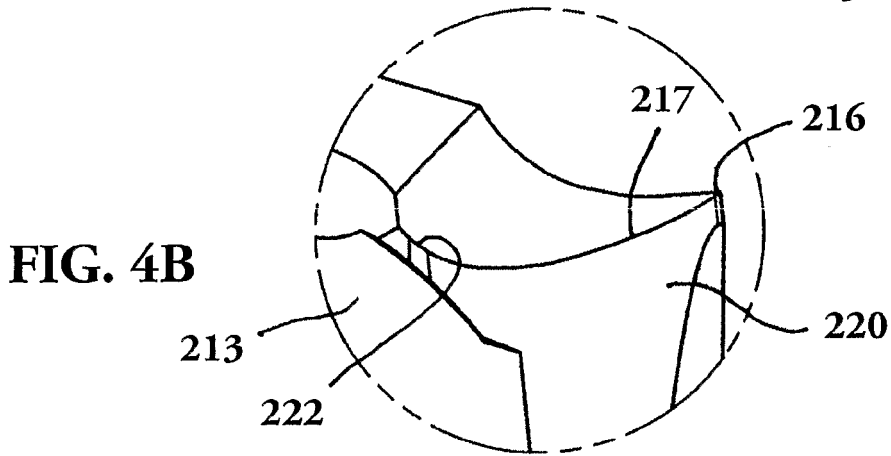
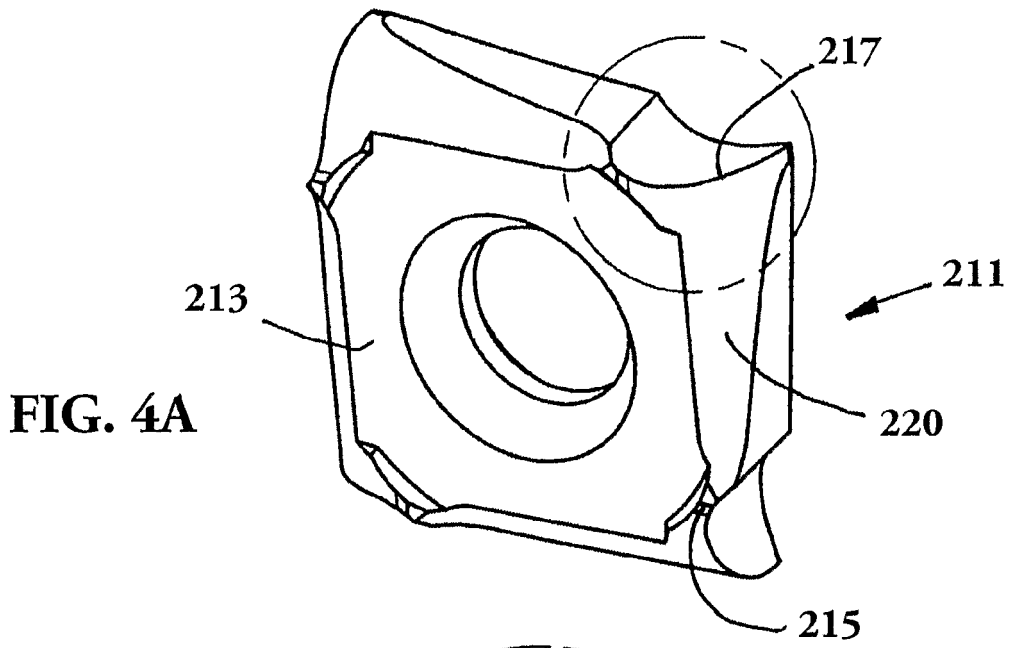


FIG. 3C

7/8



8/8

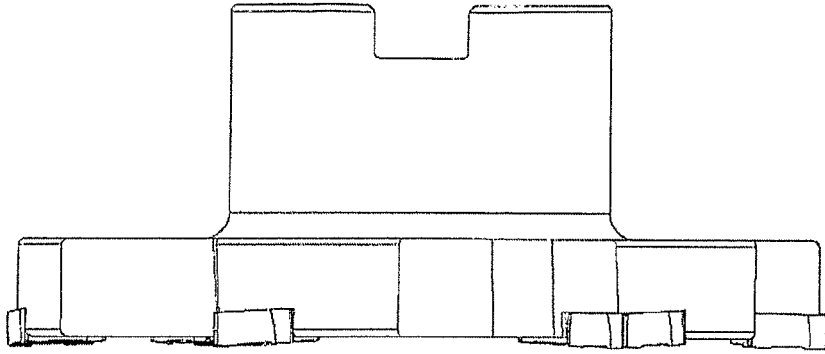


FIG. 5A

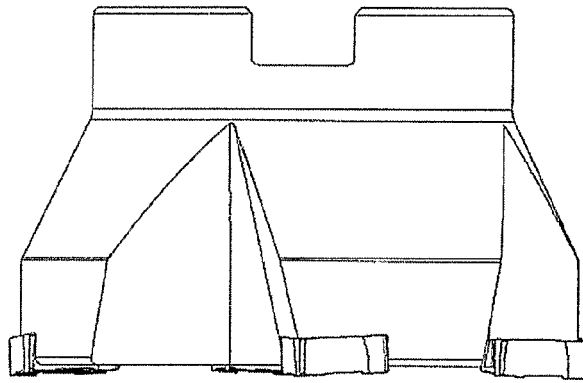


FIG. 5B

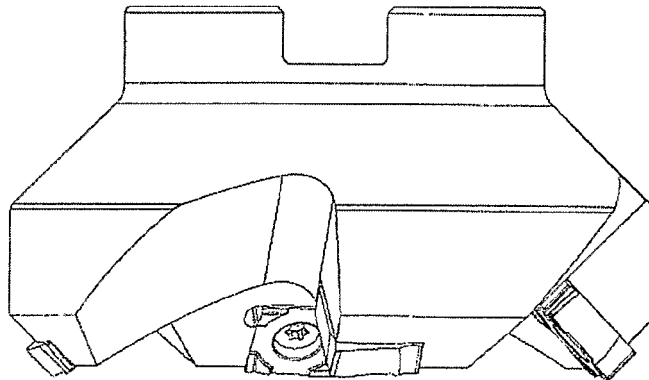


FIG. 6

INTERNATIONAL SEARCH REPORT

International application No.

PCT/SE2006/000777

A. CLASSIFICATION OF SUBJECT MATTER

IPC: see extra sheet

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)

IPC: B23C, B23B

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

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-INTERNAL, WPI DATA, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 6053672 A (A. SATRAN ET AL), 25 April 2000 (25.04.2000), column 4, line 37 - column 5, line 64, figures 1,2,8,9,11,13, abstract --	1-9
X	WO 0076707 A2 (SANDVIK GMBH), 21 December 2000 (21.12.2000), figures 2,5, abstract --	1-9
X	US 5046899 A (M. NISHI), 10 Sept 1991 (10.09.1991), figure 6, abstract --	1-9
X	US 20030005803 A1 (A. SATRAN ET AL), 9 January 2003 (09.01.2003), paragraph (0044), figure 1, abstract --	1-9

 Further documents are listed in the continuation of Box C. See patent family annex.

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Date of the actual completion of the international search

13 Sept 2006

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INTERNATIONAL SEARCH REPORT

International application No.
PCT/SE2006/000777

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 5947650 A (A. SATRAN ET AL), 7 Sept 1999 (07.09.1999), figures 1,2,10,21, abstract -----	1-9

International patent classification (IPC)

B23C 5/20 (2006.01)

B23B 27/16 (2006.01)

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Cited literature, if any, will be enclosed in paper form.

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

04/03/2006

PCT/SE2006/000777

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INTERNATIONAL SEARCH REPORT

Information on patent family members

04/03/2006

International application No.

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INTERNATIONAL SEARCH REPORT
Information on patent family members

04/03/2006

International application No.

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