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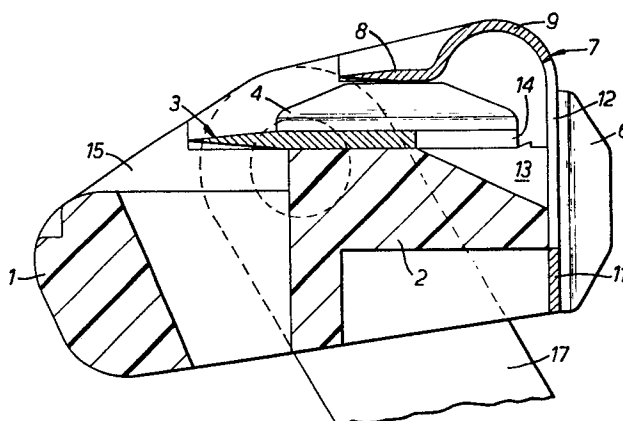
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54 **Safety razors.**

57 A tandem blade safety razor head consists of only three components: a moulded support structure defining a guard portion (1) and a blade platform (2); a primary blade (3) secured by integral rivets (4) to the platform; and a secondary blade member (7) formed from metal strip shaped to define a secondary blade (8), a curved cap portion (9) and a support leg (11) secured to the rear surface of the support structure.

Rinsing is facilitated by the provision of slots (13) in the platform and aligned perforations (12) in the support leg (11). (Fig. 2 refers)



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Safety Razors

This invention relates to safety razors of the type comprising a razor head including a blade support structure and a pair of tandem blades permanently secured to the structure so that the head is disposable as a unit when the cutting edges of the blades are dulled.

The present invention provides a razor head of this general form, of particularly simple construction.

In the particular embodiment described in detail below, the support structure consists of a unitary plastics moulding defining a guard portion and a blade platform positioned rearwardly of the guard portion and to which a planar primary blade is secured and the secondary blade is formed as part of metal strip shaped to define the

secondary blade, a cap portion, and a support leg secured to a rear surface of the support structure.

5 In accordance with a preferred feature of the invention, the support leg is perforated to provide for the clearance of shaving debris passing between the two blades.

This form of razor head will now be described in detail with reference to the accompanying drawings, in which:

10 Figure 1 is a rear view of the razor head also showing the upper portion of a razor handle in which the head is mounted;

Figure 2 is a section on the line AA in Figure 1; drawn to a larger scale and

15 Figure 3 is a plan view of the primary blade of the razor head

The razor head shown in the drawings consists of a unitary plastics moulding defining a guard portion 1 and a blade platform 2 having a blade support surface to which a planar primary blade 3 is secured by means of a number, 20 in this case three, of rivets 4 formed integrally with the platform 2, initially as pips which are subsequently deformed to secure the primary blade in position.

25 Similarly formed integral rivets 6 are also provided at the rear face of the platform 2 for securing a secondary blade member 7 in position.

30 The member 7 is formed (like the primary blade) of stainless steel but is shaped in cross-section to provide a secondary blade 8, a curved cap portion 9 and a depending support leg 11 by which the member is secured to the blade platform. Preferably, and as shown, three rivets 6 are provided for securing the blade member 7, and they are disposed in the same transverse planes as the rivets 4 for the primary blade. Between and beyond the rivets 6, the support leg is formed with elongate perforations 12, and in registry 35 with these perforations, the blade platform 2 is formed

with rinsing slots 13. As seen in Figure 3, which shows one half of the primary blade 3, the rear edge of the blade is relieved between lugs 14 within which rivet holes 16 are partially formed. Thus, the heads of rivets 4 are the only obstructions in the space between blades 3 and 8 so that shaving debris can pass through the space between the blades, to the rinsing slots 13 and perforations 12 and so to the exterior of the head at its rear. Shaving debris passing beneath the primary blade is discharged through the gap between the guard portion 1 and platform 2 in known manner.

This gap may run the full length of the guard portion but is preferably interrupted at intervals by narrow webs which serve to stiffen the guard portion.

At opposite ends of the head, the head moulding includes integral end walls 15 by which the head as a whole is conveniently attached to a razor handle comprising a main grip portion 16 and a yoke 17 in which the razor head is secured.

The razor head will thus be seen to be of very simple construction, comprising only three components and is particularly well adapted to the clearance of shaving debris. Rigidity is imparted to the secondary blade member by virtue of its section and the member may accordingly be made of relatively thin strip. For example, the secondary member may have a thickness of 0.1 mm while the primary blade has a thickness of 0.25 mm.

A razor head in accordance with the invention may be adapted for use as a replaceable cartridge for removable mounting on a handle or permanently secured to a handle to form a complete disposable razor. In either case, the razor head may be so mounted on the handle so as to pivot in use about an axis parallel to the blade edges.

CLAIMS:

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1. A safety razor head including a support structure and a pair of tandem blades permanently secured to the structure, wherein the support structure comprises a unitary moulding defining a guard portion and a blade platform positioned rearwardly of the guard portion and to which a planar primary blade is secured, characterised in that the secondary blade is formed as part of a metal strip (7) shaped to define a secondary blade (8), a cap portion (9), and a support leg (11) secured to a rear surface of the support structure (2).
2. A razor head in accordance with claim 1, characterised in that the support leg (11), is perforated to provide for the clearance of shaving debris passing between the two blades (3,8).
3. A razor head in accordance with claim 2, wherein the primary blade (3) is secured to the blade platform (2) by riveting (4), the rivet heads projecting into the space between the two blades (3,8), characterised in that the perforations (12) in the support leg (11) are aligned with spaces between the rivet heads (4).
4. A razor head in accordance with claims 2 or 3, characterised in that the blade platform (2) is formed to the rear of the primary blade (3) with slots (13) aligned with the perforations (12) in the support leg (11).
5. A razor head in accordance with claims 1, 2 or 3, characterised in that the support leg (11) is set substantially perpendicular to the planes of the secondary blade (3) and the blade platform (2).
6. A razor head in accordance with any preceding claim, characterised in that the cap portion (9) is arcuately curved.

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