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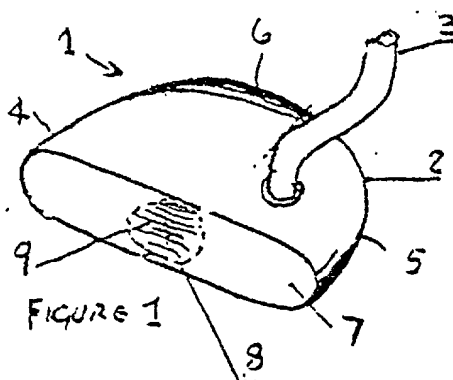
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(54) **Putter head with pre-machined insert**

(57) The invention provides a head (2) for a putter. The face (7) of the putter head (2) includes very shallow markings (9) having a depth of the order of 50 microns (0.05mm). The markings (9) are formed on an insert (19) defining the sweet spot (26) of the putter face (7) by an end milling process with the insert (19) being resiliently

supported and fixed within a cavity in the head (2) by means of resilient O-rings (28,29). Since the resilient O-rings (28,29) take up any clearance the insert (19) does not need to be made to tight tolerance and can be machined outwith the head (2) prior to insertion within the head cavity. The markings (9) produced are radial and non-concentric grooves.





European Patent
Office

EUROPEAN SEARCH REPORT

Application Number
EP 02 25 1837

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.7)
X	US 4 964 641 A (MIESCH GARY D ET AL) 23 October 1990 (1990-10-23) * column 3, line 15 - line 21; figures 1,2,4 *	1-4, 7-11, 13-15	A63B53/04
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A	--- US 3 387 844 A (WINSOR SHIPPCE) 11 June 1968 (1968-06-11) * column 3, line 1 - line 17 * * column 4, line 3 - line 6; figures 1-5 *	7-11	
A	--- JP 2000 296191 A (DAIWA SEIKO INC) 24 October 2000 (2000-10-24) * abstract *	1-15	
			TECHNICAL FIELDS SEARCHED (Int.Cl.7)
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The present search report has been drawn up for all claims			
Place of search MUNICH		Date of completion of the search 6 June 2003	Examiner Jekabsons, A
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document</p>			

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

EP 02 25 1837

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
The members are as contained in the European Patent Office EDP file on
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