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(54) **DIAMOND TIPPED UNITARY HOLDER/BIT**

(57) A unitary diamond bit/holder, tool, and/or pick assembly that includes a forward extension axially extending from a body of the bit/holder and a tungsten carbide ring mounted in an annular trough at a forward end of the body around the forward extension. An axially shortened diamond tipped bit tip insert is brazed to the forward extension, within a bore of the forward extension, and/or to a tungsten carbide plug which is then seated within a bore of the forward extension.

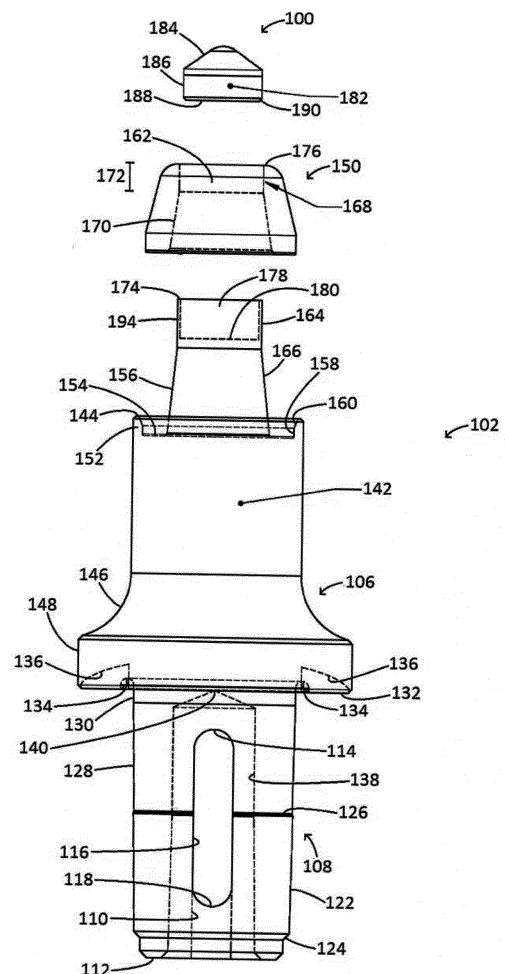


FIG. 12

Description

TECHNICAL FIELD

[0001] This invention relates to combination bit/holders used in road milling, mining and trenching and, more particularly, to diamond coated tungsten carbide inserts and structure for mounting them as part of a unitary bit/holder combination, tool, and/or pick assembly.

BACKGROUND

[0002] Road milling bits and bit holders, the design of which, when made in differing sizes, can also be used for trenching machines and mining machines, have benefited greatly from what has been termed a quick change shank, found in the instant inventor's prior patents 6,371,567; 6,685,273 and 7,883,155. Additionally, the construction features of the forward end of the advanced bit design found in applicant's patent 6,739,327 has been cited in over 70 later issued patents. The Burkett patent 5,161,627 disclosed that one could mount a diamond coated insert in a one-piece bit/bit holder body. A similar structure with a diamond coated tip is found at the Sionett patent 4,944,559. These diamond coatings have heretofore been formed in a standard process that includes high temperature, high pressure forming of same on a tungsten carbide high impact substrate.

[0003] A later version of the present applicant's prior invention of a quick change shank such as found in the 6,371,567 patent is provided in combination with a diamond tip and found at the Hall et al patent 8,118,371.

[0004] With diamond coated tips of road milling machinery, it has been found that the working life of the tip has been greatly increased. As such, it is no longer necessary to provide changeable bits in bit holders. The operating life of bits and bit holders are such that they can be physically combined in a unitary structure.

[0005] A need has developed for a lower cost combination diamond coated tip and front portion, formerly used on a removable bit, with a quick change bit holder and improvements in tools for inserting and removing same in their working mountings.

SUMMARY

[0006] This disclosure relates generally to unitary bit/bit holder combination, tool, and/or pick assemblies for road milling, mining, and trenching equipment. One implementation of the teachings herein is a tool that includes a body comprising an annular trough and a forward extension axially extending from the annular trough to a forward end of the body; a shank extending axially from a bottom of the body; and an annular tungsten carbide ring comprising a ring bore, the forward extension extending through the ring bore, and the annular tungsten carbide ring adapted to be seated and brazed in the annular trough of the body.

[0007] These and other aspects of the present disclosure are disclosed in the following detailed description of the embodiments, the appended claims and the accompanying figures.

BRIEF DESCRIPTION OF THE DRAWINGS

[0008] The features of the present invention which are believed to be novel are set forth with particularity in the appended claims. The invention may best be understood from the following detailed description of currently preferred embodiments thereof taken in conjunction with the accompanying drawings wherein like numerals refer to like parts, and in which:

Fig. 1 is an exploded perspective view of a combination diamond coated bit/bit holder, shown together with a drift pin and cup portion of a tool useful for inserting the bit holder in its bit block (not shown), in accordance with implementations of this disclosure; Fig. 2 is a front elevational view of the combination diamond coated tip bit/bit holder of Fig. 1 together with two alternate shape diamond coated tip inserts, showing invisible internal elements in dotted lines, in accordance with implementations of this disclosure;

Fig. 3 is a side elevational view of the combination diamond coated tip/bit holder of Fig. 2, showing invisible internal elements in dotted lines, in accordance with implementations of this disclosure;

Fig. 4 is a side elevational view of the combination diamond coated bit/bit holder of Fig. 3, with a cross section of the female end of the holder insertion tool of Fig. 1 shown as mounted over the forward end of the bit/holder, showing invisible internal elements in dotted lines, in accordance with implementations of this disclosure;

Fig. 5 is a front elevational view of the bit/holder of Fig. 4 with a cross section of the female end of the bit/holder insertion tool of Fig. 4 having the drift pin positioned through both the removal tool and the combination bit/holder, showing invisible internal elements in dotted lines, in accordance with implementations of this disclosure;

Fig. 6 is an exploded perspective view of a first modification of the combination bit/holder of Figs. 1-5 further including an added steel cup into which the tungsten carbide diamond coated tip is inserted which, in turn is inserted in the forward end of the reverse taper tungsten carbide insert, in accordance with implementations of this disclosure;

Fig. 6a is an elevational view of the tip receiving cup including the bottom pad shown in Fig. 6 in accordance with implementations of this disclosure;

Fig. 6b is a top plan view of the cup of Fig. 6 in accordance with implementations of this disclosure;

Fig. 7 is a top ¼ perspective view of a complete bit/holder removal tool for removing the bit/holder

from a bit block in accordance with implementations of this disclosure;

Fig. 8 is a top $\frac{3}{4}$ perspective view of the female cup of the bit/holder removal tool showing the Acme threaded top bore therein in accordance with implementations of this disclosure;

Fig. 9 is a top $\frac{1}{4}$ perspective view of a second modification of the bit/holder incorporating an annular steel front end of the bit holder adapted to receive the tungsten carbide diamond coated tip insert therein in accordance with implementations of this disclosure;

Fig. 10 is an exploded elevation view of the second modification of the bit/holder of Fig. 9 with the annular tungsten carbide ring exploded out of its annular pocket more clearly showing the steel front end of the bit holder of Fig. 9 adapted to receive the tungsten carbide diamond coated insert therein to provide added ductility and shock absorption to the assembly in accordance with implementations of this disclosure;

Fig. 11 is a top $\frac{3}{4}$ perspective of the second modification of the bit/holder of Fig. 9 as it appears when the bit/holder has been in use a short time with an upper distal annular end worn away in accordance with implementations of this disclosure;

Fig. 12 is an exploded elevation view of a third embodiment of a combination diamond coated bit/holder, showing invisible internal elements in dotted lines, in accordance with implementations of this disclosure;

Fig. 13 is an elevation view of the third embodiment of the combination diamond coated bit/holder, showing invisible internal elements in dotted lines, in accordance with implementations of this disclosure;

Fig. 14 is an exploded elevation view of a fourth embodiment of a combination diamond coated bit/holder, showing invisible internal elements in dotted lines, in accordance with implementations of this disclosure;

Fig. 15 is an elevation view of the fourth embodiment of the combination diamond coated bit/holder, showing invisible internal elements in dotted lines, in accordance with implementations of this disclosure;

Fig. 16 is an exploded elevation view of a fifth embodiment of a combination diamond coated bit/holder, showing invisible internal elements in dotted lines, in accordance with implementations of this disclosure;

Fig. 17 is an elevation view of the fifth embodiment of the combination diamond coated bit/holder, showing invisible internal elements in dotted lines, in accordance with implementations of this disclosure;

Fig. 18 is an exploded elevation view of a sixth embodiment of a combination diamond coated bit/holder, showing invisible internal elements in dotted lines, in accordance with implementations of this disclosure; and

Fig. 19 is an elevation view of the sixth embodiment of the combination diamond coated bit/holder, showing invisible internal elements in dotted lines, in accordance with implementations of this disclosure.

DETAILED DESCRIPTION

[0009] Referring to Fig. 1, a combined diamond coated bit/holder is shown, generally at 15, in its completed form together with a female cup insertion-removal member 16 and its accompanying drift pin 17, which extends through the hollow open bottom 18 of the female cup member through aperture 20 and through a body 21 of the combined bit/holder at bore 22 for insertion into a bit block (not shown) which, in turn, is mounted on a rotatable drum (not shown).

[0010] Referring to Figs. 1-3, a first embodiment of the combination diamond coated bit/holder 15 includes a holder base 21 having an upper body portion 23 and a lower shank portion 24. The upper and lower shank portion are both made of 4140, 4340, or similar steel. The lower shank portion 24 is a hollow, generally cylindrical member having at least one slot 25 extending axially through the side of the hollow shank from the distal end upwardly toward the top of the shank portion. Alternately, a second, wholly internal slot 26, may be positioned preferably 180 degrees around the shank from the first slot 25, extending in an axial direction similar to the first slot 25, however, starting from a position in spatial relation upwardly from the bottom distal end of the shank as shown at 26 in Fig. 2.

[0011] In the preferred embodiment 15, the shank 24 includes a lower resilient bit block bore engaging portion 27, and a millable shank portion 28 which may in this embodiment be a few thousandths of an inch. An uppermost part of the shank 30 immediately adjacent the larger body portion 21 includes a generally cylindrical portion having an annular outer surface sized to be press fit into the top of the bit block bore (not shown). As noted previously in U.S. Patents 7,883,155, 6,685,273 and 6,371,567, the interference fit between the bottom shank portion 27 and a bit holder bore is substantially larger than a standard interference fit (.001 - .003) for a solid shank, extending approximately .012 to .030 inches for a nominal 1-1/2 inch diameter shank for use in road milling.

[0012] The upper or body portion 21 of the holder 15 includes a radially extending annular flange 31 defining the bottom of what is termed in the industry as a tire portion, diametrically the widest segment of a holder (about 2-5/8 inch for a road milling holder). The height of the tire portion may approximate $\frac{1}{2}$ inch and includes a pair of opposing wedge shape cutouts or wedge extraction notches 19-19. From the top of the tire portion, the body generally slopes radially inwardly at 32 and upwardly to perform a ramp-like function with the aim of moving material, macadam, concrete, etc. outwardly from the forward tip of the diamond covered leading portion 33 of the

bit/holder. In this preferred embodiment, the mid section of the upper body portion of the holder 23 includes a generally cylindrical segment having at the bottom thereof a cross or through hole 22 substantially perpendicular to the longitudinal axis of the holder. This cross hole 22 extends horizontally through the body portion and forms a receiver for a drift pin 17, shown most clearly in Fig. 1 used in connection with the cup portion of a bit/holder insertion tool 16, a part of which is also shown in Fig. 1, and which will be discussed in more detail below.

[0013] This upper cylindrical segment 23 of the preferred holder body 21 is, with the exception of the through hole 22 mentioned previously, generally solid and provides a substantial portion adding bulk and toughness to the combination bit/holder 15. As shown most clearly in Figs. 2 and 3, the upper surface 34 of the holder is also made of the same steel as the remainder of the holder and includes an annular trough 35 in which an annular tungsten carbide sleeve 36 is positioned and brazed in place. The trough provides a retainer for an annular braze disk (not shown) which when melted adheres the base of the annular tungsten carbide ring 36 to the trough bottom. Radially inwardly of the tungsten carbide ring is an annular steel axially extending flange 37 that includes a central tapered cutout portion 38. A reverse taper tungsten carbide insert 40 is fitted into that tapered bore 38 and brazed therein. The top 41 of the tungsten carbide insert 40 extends substantially beyond the top 42 of the steel annular ring 37 and with the exception of a generally cylindrical recess 43 in the top surface thereof is constructed substantially similar to the cutting tool bit shown and disclosed in the present inventor's issued patent 6,739,327. The tungsten carbide reverse taper insert 40 provides a toughened insert for holding a commercially available diamond coated tip 44 which has a generally cylindrical tungsten carbide base 45 and a diamond coated tip which may be conical 33, flat 46 or oval 47 in cross section as shown in Fig. 2. Similarly to the tungsten carbide members previously mentioned, the base 45 of the tip insert 33 is brazed into the tungsten carbide reverse tapered insert member 40.

[0014] It should be noted that during assembly, only the top part of the bit body 23 is heated by a inductance coil surrounding same to a temperature just slightly over the melting point of the brazing discs used, i.e., about 1300 degrees F. The careful positioning of the inductance coils provides for heating a minimal area of the upper portion 21 of the bit/holder 15, thus minimally affecting the grain structure, hardness, toughness etc. of the holder itself.

[0015] Referring to Figs. 4 and 5, the combination diamond tip bit/holder 15 shown in Figs. 4 and 5 is exactly the same as that described in Figs. 1-3. What is shown in Figs. 4 and 5 is the mounting of the female or cup shape bit portion 16 of a bit insertion/removal tool, generally at 49, (Fig. 7) as it appears mounted on the top or holder body 21 of the combination bit/holder 15 together with the drift pin 17 positioned through the central portion

21 of the holder body and the outer annular wall of the cup or female insertion-removal member 16.

[0016] As shown in Figs. 1, 4 and 5, the female member 16 is generally cup shaped, having an outer cylindrical wall 50 and an inner, generally cylindrical bore 51 or hollow portion sized to rather loosely fit over the outside of the top 21 of the holder body 15 with a generally flared distal portion 18 sized to fit over the sloped segment 32 of the bottom of the holder body upwardly adjacent the tire portion thereof.

[0017] A bore 20-20 horizontally through the walls of the female cup member 16 is sized and positioned to align with the through or cross bore 22 in the holder body 16 to allow a drift pin 17 to be loosely (slidably) positioned therethrough. The upper hollow or bored out portion of the cup member body fits over the diamond coated bit 33, tungsten carbide insert 40, and the tungsten annular ring 36 at the recess 35 in the top wall 34 of the holder body 21. The upper portion of the cup is, in this embodiment, tapered to a frustoconical shape 53 having a generally flat upper surface 54.

[0018] Referring to Figs. 7 and 8, the female or cup portion 16, as mentioned previously, includes an upper threaded bore 55 centrally therethrough which is adapted to receive an Acme threaded rod 56 therein as a part of a bit insertion/removal tool 50. In order to maintain the cup 16 on the Acme threaded rod 56, a nut 57 is threaded on the rod and tightened against the upper annular wall of the cupped member 16 to secure same thereon. The Acme threaded rod 56 extends from the female cup member 16 to a distal stop 58 on the opposite end of the Acme threaded rod. In between is slidably mounted a dual handle hammer member 60 having a central annular portion 61 with a central bore 62 therethrough slightly larger than the outer dimension of the Acme thread for sliding along the threaded rod 56. 180 degrees apart on opposite sides of the annular central member are mounted hand holds 63-64 perpendicularly to the bore through the central member 61, each having a form fitting grip on its distal end. In operation, once the female cup member 16 is fitted over the top 21 of the bit/holder 15 and the drift pin 17 positioned therethrough, the double hand hold slider 60 may be quickly moved axially along the Acme threaded rod 56 and rammed onto the stop 58 at the distal end thereof to provide axial hammer type outward force to enable the removal of the bit holder 15 from its respective bit block bore (not shown).

[0019] Referring to Figs. 6, 6a, and 6b, a first modification of the diamond coated bit/holder 15 of the present invention shown in Figs. 1-5 is substantially identical to the holder 21, tungsten carbide ring 36, and tip 33 of that embodiment. The only difference being the mounting of a steel receiving cup 65 being about 3/8 - 1 inch, in height, that is brazed into the forward recess 43 of the reverse taper insert 40.

[0020] The diamond coated tip 33, 33a, 46 and 47 is brazed into the hollow cup forward portion 66 of the steel cup insert 65. The reasoning behind the addition of the

cup shaped thick bottom 67 of the steel insert 65 relates to the ductility of the steel vs. the non-ductility of the tungsten carbide insert 40. The use of a solid bottomed 67 steel cup 65 member allows the ductility of that thick cylindrical bottom pad to cushion the repeated hammer blows received at the diamond coated tip 33a. This added ductility to the tip end 33a of the bit allows that bit/holder 15 to be used not only in removing MacAdam, but also in removing a concrete and other hardened and non-homogenous materials, thus giving added life and a widened field of use for the bit/holder combination 15 over previously known diamond coated bits. Further, the tungsten carbide to steel to tungsten carbide sequence of the disclosed modification yields substantially stronger bonds than brazing tungsten carbide to tungsten carbide.

[0021] Referring to Figs. 9 and 10, a second modification 15a of the present invention is generally shown. As with the previous modification, the portion of the holder including the shank 24a, tire portion 31a, mid and most of the upper body portion 23a of the holder 15a are identical to that shown in the first embodiment. However, the axially extending upper annular flange 68 of the holder 15a immediately inwardly adjacent the tungsten carbide protective ring 36a is substantially solid with the exception of a generally cylindrical recess 64 sized for the fitting of the diamond covered commercial insert 33a which may be brazed therein. This modification of the uppermost portion of the holder body provides a substantial steel mounting for the diamond coated tungsten carbide body tip 33a. This substantial steel upper portion 68 provides added ductility, even more so than the steel thick bottomed cup 65 shown in Fig. 6. This increased ductility acts as a shock absorber for the diamond coated tungsten carbide tip 33, 33a, 46 and 47 enabling same to be used in more than just the asphalt or macadam removal, which was a limitation to the use of previously known diamond coated bit tips in road milling. Additionally, the steel to tungsten carbide braze joint between the tip and the holder body is stronger than a tungsten carbide to tungsten carbide braze joint.

[0022] Referring to Fig. 11, the bit/holder 15a shown in Figs. 9 and 10 is shown as it appears after use in the field has started. In use, the bit/holder 15a wears adjacent its tip insert 33a. The steel annular ring 68 which forms the top of the upper body 23a of the bit/holder wears away quickly during use, as shown at 68a in Fig. 11, somewhat similarly to upper portion 66 of cup 65 shown in Figs. 6, 6a, and 6b, to the extent where it generally coincides with the top surface of the tungsten carbide annular ring 36a after use.

[0023] The purpose of the extended initial portion of the steel annular ring 68 shown in Figs. 9 and 10 is to seat the diamond tipped insert 33a in its recess 64 as shown in Fig. 10. Initially, the tungsten carbide annular ring 36a is seated in its recess 69 at the top of the body portion 23a with a ring of brazing material between that recess and the bottom of the annular ring 36a. A combination of the holder and tungsten carbide annular ring

are heated to between 1,650-2,000 degrees F. in the first operation to join those parts of the bit holder together into a unitary structure. The tungsten carbide ring and holder are quenched and tempered to a hardness of RC 40-48, in a separate heat treatment process.

[0024] Next, the PCD or diamond insert 33a is positioned in recess 64 preferably over a silver brazing disc (not shown). This combination is then heated between 1,000-1,300 degrees F. by an induction heater (not shown) which encircles the upper tip portion of the bit holder 15a. The flow of heat through the annular steel ring 68 more effectively magnetically couples to the iron in the steel in the ring 68 to transfer heat to the tungsten carbide. The heat more efficiently goes through the steel to melt the flux and braze material between the insert 33a and the recess 64 of the forward tubular portion of the steel ring body 68. These two processes that join both the tungsten carbide annular ring 36a and the diamond tip insert 33a to the upper body 23a and recesses 69 and 64, respectively, of the inner annular ring 68 are made at two differing temperatures to provide a more stable unitary structure in the end-finished bit holder of the present invention.

[0025] Referring to FIGS. 12 and 13, a third embodiment of a combination diamond coated axially shortened bit 100 and bit holder 102 of the present disclosure forms a unitary structure bit and bit holder construction of a bit/holder, tool, and/or pick 104 (FIG. 13). The third embodiment of the bit holder 102 comprises a body 106 and a generally cylindrical hollow shank 108 depending from a bottom of the body 106. The shank 108 includes an elongate first slot 110 extending from a generally annular distal end 112 of the shank 108 axially upward or forward to an upper termination 114, which in this embodiment is adjacent the upper or forward end of the shank 108. In this illustrated embodiment, the shank 108 also includes an internally oriented second slot 116 located approximately 180 degrees around the annular shank 108 from the first slot 110. The second slot 116 is generally parallel to the first slot 110 and is an internal slot including a rearward semicircular termination 118 inwardly adjacent the distal end 112 of the shank 108 and a forward semicircular termination 120 (not shown) generally coinciding longitudinally and axially with the upper termination 114 of the first slot 110.

[0026] In this third embodiment of the bit holder 102, the shank 108 includes a lower or first tapered portion 122 running axially from a stepped shoulder 124 adjacent the distal end 112 of the shank 108. The stepped shoulder 124 is disposed between the lower tapered portion 122 and the distal end 112. A diameter of the stepped shoulder 124 increases, or steps up, in this embodiment, as it axially extends from the distal end 112 to the lower tapered portion 122. The first tapered portion 122 runs upwardly or axially from the stepped shoulder 124 of the shank 108 and terminates generally mid first slot 110 longitudinally. The shank 108 also includes an annular shoulder 126 separating the lower tapered portion 122

from an upper or second tapered portion 128 which extends from the shoulder 126 to generally adjacent to the top of the shank 108 or forward terminations 114, 120 of slots 110, 116, respectively. The annular shoulder 126 is disposed between the lower tapered portion 122 and the upper tapered portion 128. A diameter of the annular shoulder 126 decreases, or steps down, in this embodiment, as it axially extends from the lower tapered portion 122 to the upper tapered portion 128. In other embodiments, the lower portion 122 and/or the upper portion 128 of the shank 108 may comprise a generally cylindrical shape, a slight draw angle, or a slight draft angle. In yet other embodiments, the shank 108 can comprise many different configurations.

[0027] A generally cylindrical top portion 130 of the shank 108 extends from a position adjacent the top or upper terminations 114, 120 of slots 110, 116, respectively, towards a generally annular back flange 132 that denotes the base or the bottom of the body 106 of the bit holder 102. The top of the shank 108 may include a rounded junction 134 between the top portion 130 of the shank 108 and the generally annular flange 132 of the body 106 of the bit holder 102, which is provided to avoid sharp corners which may provide an area for stress cracks to begin. The generally annular flange 132 includes a pair of horizontal slots or wedge extraction notches 136-136 generally perpendicular to the longitudinal axis of the combination bit/holder, one on either side of the generally annular flange 132. The horizontal slots 136-136 are configured to receive a pair of bifurcated fork tines that may be inserted between the base of the body 106 of the bit holder 102 and a base block (not shown) into which the shank 108 of the unitary bit/holder 104 is inserted and retained by outward radial force in use.

[0028] A central bore 138 longitudinally and axially extending through the shank 108 of the bit holder 102 terminates at bore termination 140, which in this illustrated embodiment has a conical shape, which is approximately at the upper end of the shank 108. This allows the generally C-shaped annular sidewall of the shank 108 to radially contract when the shank 108 is mounted in a tapered and/or cylindrical bore in a base block (not shown).

[0029] In this third illustrated embodiment of the bit holder 102, the bit holder body 106 includes a generally cylindrical or annular upper body portion 142 depending from a forward end 144 of the upper body portion 142. A mediate body portion 146 subjacent the upper body portion 142 generally slopes axially and radially outwardly to a radially extending generally cylindrical tire portion 148.

[0030] The bit holder body 106, in order to provide superior brazing of a tungsten carbide ring 150 to the forward end 144 of the upper body portion 142, includes a forwardly extending annular collar 152 that is created on the bit holder body 106 to provide an annular trough 154 around a forward extension 156 of the bit holder body 106 onto which the annular ring 150 is mounted. In this

illustrated embodiment, the annular collar 152 includes a cylindrical bottom inner wall 158 and a tapered top inner wall or countersink 160. The vertical outer wall of the collar 152 will keep brazing material from flowing outwardly of the joint between the base of the ring 150 and the annular trough 154 on which the ring 150 is positioned. The annular trough 154 is therearound positioned perpendicular to the axis of the bit holder 102 from the smaller radially oriented annular upper or forward extension 156 (FIG. 12). Around this forward extension 156 is fitted the annular tungsten carbide ring 150, the forward extension 156 extending through a bore 162 that extends through the annular tungsten carbide ring 150 allowing a bottom of the ring 150 to be seated in the annular trough 154, which may be brazed into unitary construction with the remainder of the bit holder 102. In one exemplary implementation, the bore 162 of the annular tungsten carbide ring 150 may comprise a cylindrical upper section 168 and an outwardly tapered bottom section 170, as shown in FIGS. 12 and 13. An axial length 172 of the ring 150, corresponding to the generally cylindrical top inner portion 168 of the bore 162 of the ring 150, is designed to maintain radial support after being brazed. The clearance between the inner diameter of the bore 162 of the annular tungsten carbide ring 150 and the outer diameter of a cylindrical top portion 164 of the forward extension 156 is, in the exemplary implementation, approximately in the range of 0.003 to 0.012 inch per side depending on where the measurement is axially taken. The top or forwardmost portion of the forward extension 156 of the bit holder body 106 terminates generally at a forward end 174 of the bit holder body 106 of the bit holder 102, located above the forward portion 176 of the annular tungsten carbide ring 150. In another exemplary implementation, the bore 162 of the annular tungsten carbide ring 150 may comprise a continuous taper (not shown) from the bottom of the bore 162 to the forward portion of the annular tungsten carbide ring 150. In other implementations, the forward extension 156 and the bore 162 of the ring 150 can have complementary shaped surfaces. The bit holder 102 may be machined and hardened, or hardened and then machined. The annular tungsten carbide ring 150 may be brazed before or after hardening of the bit holder 102.

[0031] In this exemplary implementation of the third embodiment of the bit holder 102, the forward extension 156 includes a generally cylindrical top portion 164 and an outwardly tapered bottom portion 166. The generally cylindrical top portion 164, which forms the unitary steel forward end of the tubular portion of the diamond tool body, includes a bore 178 that axially extends from the forward end 174 to a bore termination 180, which in this exemplary implementation is flat, adjacent the outwardly tapered bottom portion 166. The bore 178 provides a space for receiving the complementary shaped bit 100. The bit tip insert 100 comprises a base 182 and a tip 184 adjacent the base 182 that includes a parabolic curved section below an apex of the bit tip insert 100. This tip

184 can have a frustoconical shape, a flat generally cylindrical puck shape, a parabolic ballistic shape, a conical shape, and/or an arcuate shape. In this third embodiment, the base 182 includes a generally cylindrical sidewall 186 and a tapered section 190 that extends from the cylindrical sidewall 186 to a generally flat distal end 188 of the bit tip insert 100. In an alternate embodiment, the base 182 can include a tapered sidewall and the distal end 188 of the bit tip insert 100 can be conical, frustoconical, arcuate, or have a different configuration. In one exemplary implementation of the third embodiment, the bit tip insert 100 can have a diameter in the range of 1/2 inch to 1-3/8 inches. The bit tip insert 100 may be a tungsten carbide insert or may be a tungsten carbide insert that includes an overlay 192 (FIG. 16) of a polycrystalline diamond structure that is applied to an outer surface of the tip 184. The overlay 192 may be a single coating or outer layer or multiple coatings or outer layers of such industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material.

[0032] To assemble the combination diamond coated axially shortened bit 100 and bit holder 102 of the present disclosure and to form a unitary structure of a bit and bit holder construction of a bit/holder, tool, and/or pick 104, the annular tungsten carbide ring 150 is positioned around the forward extension 156 and brazed in the annular trough 154 of the bit holder body 106. The base 182 and the sidewall 186 of the bit tip insert 100 is brazed in the bore 178 of the forward extension 156 at the same time as the carbide ring 150 is brazed, using, for example, a disc shaped or ring shaped braze material, and also creating a high strength braze joint 196 (FIG. 13), which may then be optionally hardened. This braze joint secures the bottom of the tungsten carbide base 182 of the bit tip insert 100 to the bore termination 180 of the bore 178 of the cylindrical top portion 164 of the forward extension 156, at the forward end 174 of the diamond tool body 106. In this third embodiment, the annular sidewall 194 of the cylindrical top portion 164 of the forward extension 156 remains in place, as shown in FIG. 13, after brazing the bit tip insert 100 in the bore 178, however, the annular sidewall 194 will be quickly worn away by the abrasive action of the cut material.

[0033] Referring to FIGS. 14 and 15, a fourth embodiment of a combination diamond coated axially shortened bit 100 and bit holder 200 of the present disclosure forms a unitary structure bit and bit holder construction of a bit/holder, tool, and/or pick 104 (FIG. 15). The fourth embodiment of the bit holder 200 comprises a body 106 and a generally cylindrical hollow shank 108 depending from a bottom of the body 106. The shank 108 includes an elongate first slot 110 extending from a generally annular distal end 112 of the shank 108 axially upward or forward to an upper termination 114, which in this embodiment is adjacent the upper or forward end of the shank 108. In this illustrated embodiment, the shank 108 also includes an internally oriented second slot 116 located ap-

proximately 180 degrees around the annular shank 108 from the first slot 110. The second slot 116 is generally parallel to the first slot 110 and is an internal slot including a rearward semicircular termination 118 inwardly adjacent the distal end 112 of the shank 108 and a forward semicircular termination 120 (not shown) generally coinciding longitudinally and axially with the upper termination 114 of the first slot 110.

[0034] In this fourth embodiment of the bit holder 200, the shank 108 includes a lower or first tapered portion 122 running axially from a stepped shoulder 124 adjacent the distal end 112 of the shank 108. The stepped shoulder 124 is disposed between the lower tapered portion 122 and the distal end 112. A diameter of the stepped shoulder 124 increases, or steps up, in this embodiment, as it axially extends from the distal end 112 to the lower tapered portion 122. The first tapered portion 122 runs upwardly or axially from the stepped shoulder 124 of the shank 108 and terminates generally mid first slot 110 longitudinally. The shank 108 also includes an annular shoulder 126 separating the lower tapered portion 122 from an upper or second tapered portion 128 which extends from the shoulder 126 to generally adjacent to the top of the shank 108 or forward terminations 114, 120 of slots 110, 116, respectively. The annular shoulder 126 is disposed between the lower tapered portion 122 and the upper tapered portion 128. A diameter of the annular shoulder 126 decreases, or steps down, in this embodiment, as it axially extends from the lower tapered portion 122 to the upper tapered portion 128. In other embodiments, the lower portion 122 and/or the upper portion 128 of the shank 108 may comprise a generally cylindrical shape, a slight draw angle, or a slight draft angle. In yet other embodiments, the shank 108 can comprise many different configurations.

[0035] A generally cylindrical top portion 130 of the shank 108 extends from a position adjacent the top or upper terminations 114, 120 of slots 110, 116, respectively, towards a generally annular back flange 132 that denotes the base or the bottom of the body 106 of the bit holder 200. The top of the shank 108 may include a rounded junction 134 between the top portion 130 of the shank 108 and the generally annular flange 132 of the body 106 of the bit holder 102, which is provided to avoid sharp corners which may provide an area for stress cracks to begin. The generally annular flange 132 includes a pair of horizontal slots or wedge extraction notches 136-136 generally perpendicular to the longitudinal axis of the combination bit/holder, one on either side of the generally annular flange 132. The horizontal slots 136-136 are configured to receive a pair of bifurcated fork tines that may be inserted between the base of the body 106 of the bit holder 200 and a base block (not shown) into which the shank 108 of the unitary bit/holder 104 is inserted and retained by outward radial force in use.

[0036] A central bore 138 longitudinally and axially extending through the shank 108 of the bit holder 200 ter-

minates at bore termination 140, which in this illustrated embodiment has a conical shape, which is approximately at the upper end of the shank 108. This allows the generally C-shaped annular sidewall of the shank 108 to radially contract when the shank 108 is mounted in a tapered and/or cylindrical bore in a base block (not shown).

[0037] In this fourth illustrated embodiment of the bit holder 200, the bit holder body 106 includes a generally cylindrical or annular upper body portion 142 depending from a forward end 144 of the upper body portion 142. A mediate body portion 146 subjacent the upper body portion 142 generally slopes axially and radially outwardly to a radially extending generally cylindrical tire portion 148.

[0038] The bit holder body 106, in order to provide superior brazing of a tungsten carbide ring 150 to the forward end 144 of the upper body portion 142, includes a forwardly extending annular collar 152 that is created on the bit holder body 106 to provide an annular trough 154 around a forward extension 156 of the bit holder body 106 onto which the annular ring 150 is mounted. In this illustrated embodiment, the annular collar 152 includes a cylindrical bottom inner wall 158 and a tapered top inner wall or countersink 160. The vertical outer wall of the collar 152 will keep brazing material from flowing outwardly of the joint between the base of the ring 150 and the annular trough 154 on which the ring 150 is positioned. The annular trough 154 is therearound positioned perpendicular to the axis of the bit holder 200 from the smaller radially oriented annular upper or forward extension 202 (FIG. 14). Around this forward extension 202 is fitted the annular tungsten carbide ring 150, the forward extension 202 extending through a bore 162 that extends through the annular tungsten carbide ring 150 allowing a bottom of the ring 150 to be seated in the annular trough 154, which may be brazed into unitary construction with the remainder of the bit holder 200. In one exemplary implementation, the bore 162 of the annular tungsten carbide ring 150 may comprise a cylindrical upper section 168 and an outwardly tapered bottom section 170, as shown in FIGS. 14 and 15. An axial length 172 of the ring 150, corresponding to the generally cylindrical top inner portion 168 of the bore 162 of the ring 150, is designed to maintain radial support after being brazed. The clearance between the inner diameter of the bore 162 of the annular tungsten carbide ring 150 and the outer diameter of the cylindrical top portion 164 of the forward extension 202 is, in the exemplary implementation, approximately in the range of 0.003 to 0.012 inch per side depending on where the measurement is axially taken. The top or forwardmost portion of the forward extension 202 of the bit holder body 106 terminates generally at a forward end 174 of the bit holder body 106 of the bit holder 200, located above the forward portion 176 of the annular tungsten carbide ring 150. In another exemplary implementation, the bore 162 of the annular tungsten carbide ring 150 may comprise a continuous taper (not shown) from the bottom of the bore 162 to the forward portion of the

annular tungsten carbide ring 150. In other implementations, the forward extension 202 and the bore 162 of the ring 150 can have complementary shaped surfaces. The bit holder 200 may be machined and hardened, or hardened and then machined. The annular tungsten carbide ring 150 may be brazed before or after hardening of the bit holder 200.

[0039] In this exemplary implementation of the fourth embodiment of the bit holder 200, the forward extension 202 includes a generally cylindrical top portion 204 and an outwardly tapered bottom portion 206. The generally cylindrical top portion 204 forms the unitary steel forward end of the tubular portion of the diamond tool body and provides a forward surface 208 for receiving the complementary shaped bit 100. The bit tip insert 100 comprises a base 182 and a tip 184 adjacent the base 182 that includes a parabolic curved section below an apex of the bit tip insert 100. This tip 184 can have a frustoconical shape, a flat generally cylindrical puck shape, a parabolic ballistic shape, a conical shape, and/or an arcuate shape. In this fourth embodiment, the base 182 includes a generally cylindrical sidewall 186 and a tapered section 190 that extends from the cylindrical sidewall 186 to a generally flat distal end 188 of the bit tip insert 100. In an alternate embodiment, the base 182 can include a tapered sidewall and the distal end 188 of the bit tip insert 100 can be conical, frustoconical, arcuate, or have a different configuration. In one exemplary implementation of the fourth embodiment, the bit tip insert 100 can have a diameter in the range of 1/2 inch to 1-3/8 inches. The bit tip insert 100 may be a tungsten carbide insert or may be a tungsten carbide insert that includes an overlay 192 (FIG. 16) of a polycrystalline diamond structure that is applied to an outer surface of the tip 184. The overlay 192 may be a single coating or outer layer or multiple coatings or outer layers of such industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material.

[0040] To assemble the combination diamond coated axially shortened bit 100 and bit holder 200 of the present disclosure and to form a unitary structure of a bit and bit holder construction of a bit/holder, tool, and/or pick 104, the annular tungsten carbide ring 150 is positioned around the forward extension 202 is brazed in the annular trough 154 of the bit holder body 106. The distal end 188 and the sidewall 186 of the bit tip insert 100 is brazed to the forward surface 208 (FIG. 14) of the forward extension 202 at the same time as the carbide ring 150 is brazed, using, for example, a disc shaped or ring shaped braze material, and also creating a high strength braze joint 209 (FIG. 15), which may then be optionally hardened. This braze joint secures the bottom of the tungsten carbide base 182 and distal end 188 (FIG. 14) of the bit tip insert 100 to the forward surface 208 and cylindrical top portion 204 of the forward extension 202 of the diamond tool body 106.

[0041] Referring to FIGS. 16 and 17, a fifth embodi-

ment of a combination diamond coated axially shortened bit 100 and bit holder 210 of the present disclosure forms a unitary structure bit and bit holder construction of a bit/holder, tool, and/or pick 104 (FIG. 17). The fifth embodiment of the bit holder 210 comprises a body 106 and a generally cylindrical hollow shank 108 depending from a bottom of the body 106. The shank 108 includes an elongate first slot 110 extending from a generally annular distal end 112 of the shank 108 axially upward or forward to an upper termination 114, which in this embodiment is adjacent the upper or forward end of the shank 108. In this illustrated embodiment, the shank 108 also includes an internally oriented second slot 116 located approximately 180 degrees around the annular shank 108 from the first slot 110. The second slot 116 is generally parallel to the first slot 110 and is an internal slot including a rearward semicircular termination 118 inwardly adjacent the distal end 112 of the shank 108 and a forward semicircular termination 120 (not shown) generally coinciding longitudinally and axially with the upper termination 114 of the first slot 110.

[0042] In this fifth embodiment of the bit holder 210, the shank 108 includes a lower or first tapered portion 122 running axially from a stepped shoulder 124 adjacent the distal end 112 of the shank 108. The stepped shoulder 124 is disposed between the lower tapered portion 122 and the distal end 112. A diameter of the stepped shoulder 124 increases, or steps up, in this embodiment, as it axially extends from the distal end 112 to the lower tapered portion 122. The first tapered portion 122 runs upwardly or axially from the stepped shoulder 124 of the shank 108 and terminates generally mid first slot 110 longitudinally. The shank 108 also includes an annular shoulder 126 separating the lower tapered portion 122 from an upper or second tapered portion 128 which extends from the shoulder 126 to generally adjacent to the top of the shank 108 or forward terminations 114, 120 of slots 110, 116, respectively. The annular shoulder 126 is disposed between the lower tapered portion 122 and the upper tapered portion 128. A diameter of the annular shoulder 126 decreases, or steps down, in this embodiment, as it axially extends from the lower tapered portion 122 to the upper tapered portion 128. In other embodiments, the lower portion 122 and/or the upper portion 128 of the shank 108 may comprise a generally cylindrical shape, a slight draw angle, or a slight draft angle. In yet other embodiments, the shank 108 can comprise many different configurations.

[0043] A generally cylindrical top portion 130 of the shank 108 extends from a position adjacent the top or upper terminations 114, 120 of slots 110, 116, respectively, towards a generally annular back flange 132 that denotes the base or the bottom of the body 106 of the bit holder 210. The top of the shank 108 may include a rounded junction 134 between the top portion 130 of the shank 108 and the generally annular flange 132 of the body 106 of the bit holder 210, which is provided to avoid sharp corners which may provide an area for stress

cracks to begin. The generally annular flange 132 includes a pair of horizontal slots or wedge extraction notches 136-136 generally perpendicular to the longitudinal axis of the combination bit/holder, one on either side of the generally annular flange 132. The horizontal slots 136-136 are configured to receive a pair of bifurcated fork tines that may be inserted between the base of the body 106 of the bit holder 210 and a base block (not shown) into which the shank 108 of the unitary bit/holder 104 is inserted and retained by outward radial force in use.

[0044] A central bore 138 longitudinally and axially extending through the shank 108 of the bit holder 210 terminates at bore termination 140, which in this illustrated embodiment has a conical shape, which is approximately at the upper end of the shank 108. This allows the generally C-shaped annular sidewall of the shank 108 to radially contract when the shank 108 is mounted in a tapered and/or cylindrical bore in a base block (not shown).

[0045] In this fifth illustrated embodiment of the bit holder 210, the bit holder body 106 includes a generally cylindrical or annular upper body portion 142 depending from a forward end 144 of the upper body portion 142. A mediate body portion 146 subjacent the upper body portion 142 generally slopes axially and radially outwardly to a radially extending generally cylindrical tire portion 148.

[0046] The bit holder body 106, in order to provide superior brazing of a tungsten carbide ring 150 to the forward end 144 of the upper body portion 142, includes a forwardly extending annular collar 152 that is created on the bit holder body 106 to provide an annular trough 154 around a forward extension 156 of the bit holder body 106 onto which the annular ring 150 is mounted. In this illustrated embodiment, the annular collar 152 includes a cylindrical bottom inner wall 158 and a tapered top inner wall or countersink 160. The vertical outer wall of the collar 152 will keep brazing material from flowing outwardly of the jointer between the base of the ring 150 and the annular trough 154 on which the ring 150 is positioned. The annular trough 154 is therearound positioned perpendicular to the axis of the bit holder 210 from the smaller radially oriented annular upper or forward extension 212 (FIG. 16). Around this forward extension 212 is fitted the annular tungsten carbide ring 150, the forward extension 212 extending through a bore 162 that extends through the annular tungsten carbide ring 150 allowing a bottom of the ring 150 to be seated in the annular trough 154, which may be brazed into unitary construction with the remainder of the bit holder 210. In one exemplary implementation, the bore 162 of the annular tungsten carbide ring 150 may comprise a cylindrical upper section 168 and an outwardly tapered bottom section 170, as shown in FIGS. 16 and 17. An axial length 172 of the ring 150, corresponding to the generally cylindrical top inner portion 168 of the bore 162 of the ring 150, is designed to maintain radial support after being brazed. The clearance between the inner diameter of the bore 162 of the

annular tungsten carbide ring 150 and the outer diameter of a cylindrical top portion 214 of the forward extension 212 is, in the exemplary implementation, approximately in the range of 0.003 to 0.012 inch per side depending on where the measurement is axially taken. The top or forwardmost portion of the forward extension 212 of the bit holder body 106 terminates generally at a forward end 174 of the bit holder body 106 of the bit holder 210, located above the forward portion 176 of the annular tungsten carbide ring 150. In another exemplary implementation, the bore 162 of the annular tungsten carbide ring 150 may comprise a continuous taper (not shown) from the bottom of the bore 162 to the forward portion of the annular tungsten carbide ring 150. In other implementations, the forward extension 212 and the bore 162 of the ring 150 can have complementary shaped surfaces. The bit holder 210 may be machined and hardened, or hardened and then machined. The annular tungsten carbide ring 150 may be brazed before or after hardening of the bit holder 210.

[0047] In this exemplary implementation of the fifth embodiment of the bit holder 210, the forward extension 212 includes the generally cylindrical top portion 214 and an outwardly tapered bottom portion 216. The forward extension 212, which forms the unitary steel forward end of the tubular portion of the diamond tool body, includes a bore 218 that axially extends from the forward end 174, through the generally cylindrical top portion 214 and partially through the tapered bottom portion 216, to a bore termination 220, which in this exemplary implementation is flat, adjacent the forward end 144 of the upper body portion 142. The bore 218 provides a space for receiving a generally cylindrical tungsten carbide extension plug 222 and the complementary shaped bit 100. The bit tip insert 100 comprises a base 182 and a tip 184 adjacent the base 182 that includes a parabolic curved section below an apex of the bit tip insert 100. This tip 184 can have a frustoconical shape, a flat generally cylindrical puck shape, a parabolic ballistic shape, a conical shape, and/or an arcuate shape. In this fifth embodiment, the base 182 includes a generally cylindrical sidewall 186 and a tapered section 190 that extends from the cylindrical sidewall 186 to a generally flat distal end 188 of the bit tip insert 100. In an alternate embodiment, the base 182 can include a tapered sidewall and the distal end 188 of the bit tip insert 100 can be conical, frustoconical, arcuate, or have a different configuration. In one exemplary implementation of the fifth embodiment, the bit tip insert 100 can have a diameter in the range of 1/2 inch to 1-3/8 inches. The bit tip insert 100 may be a tungsten carbide insert or may be a tungsten carbide insert that includes an overlay 192 (FIG. 16) of a polycrystalline diamond structure that is applied to an outer surface of the tip 184. The overlay 192 may be a single coating or outer layer or multiple coatings or outer layers of such industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material.

[0048] To assemble the combination diamond coated axially shortened bit 100 and bit holder 210 of the present disclosure to form a unitary structure bit and bit holder construction of a bit/holder, tool, and/or pick 104 (FIG. 17). The annular tungsten carbide ring 150 is positioned around the forward extension 212 and brazed in the annular trough 154 of the bit holder body 106. The base 182 and the sidewall 186 of the bit tip insert 100 is brazed to a forward end 224 of the tungsten carbide extension plug 222 at the same time as the carbide ring 150 is brazed, using, for example, a disc shaped or ring shaped braze material, and also creating a high strength braze joint 228 (FIG. 17) between the base 182 of the bit tip insert 100 and the forward end 224 of the tungsten carbide extension plug 222, which may then be optionally hardened. A distal end 226 of the tungsten carbide extension plug 222 is brazed in the bore 218 of the forward extension 212 at the same time as the bit tip insert 100 and the carbide ring 150 are brazed, using, for example, a disc shaped or ring shaped braze material, and also creating a high strength braze joint, which may then be optionally hardened. This braze joint secures the distal end 226 of the tungsten carbide extension plug 222 to the bore termination 220 and to the bore 218 of the forward extension 212, adjacent the forward end 174 of the diamond tool body 106. The three parts, the bit tip insert 100, the tungsten carbide ring 150, and the tungsten carbide extension plug 222, are brazed together in a one step brazing process. In this fifth embodiment, the annular sidewall 194 of the cylindrical top portion 214 of the forward extension 212 remains in place, as shown in FIG. 17, after brazing the combination bit tip insert 100 and tungsten carbide extension plug 222 in the bore 218, however, the annular sidewall 194 will be quickly worn away by the abrasive action of the cut material.

[0049] Referring to FIGS. 18 and 19, a sixth embodiment of a combination diamond coated axially shortened bit 100 and bit holder 230 of the present disclosure forms a unitary structure bit and bit holder construction of a bit/holder, tool, and/or pick 104 (FIG. 19). The sixth embodiment of the bit holder 230 comprises a body 106 and a generally cylindrical hollow shank 108 depending from a bottom of the body 106. The shank 108 includes an elongate first slot 110 extending from a generally annular distal end 112 of the shank 108 axially upward or forward to an upper termination 114, which in this embodiment is adjacent the upper or forward end of the shank 108. In this illustrated embodiment, the shank 108 also includes an internally oriented second slot 116 located approximately 180 degrees around the annular shank 108 from the first slot 110. The second slot 116 is generally parallel to the first slot 110 and is an internal slot including a rearward semicircular termination 118 inwardly adjacent the distal end 112 of the shank 108 and a forward semicircular termination 120 (not shown) generally coinciding longitudinally and axially with the upper termination 114 of the first slot 110.

[0050] In this sixth embodiment of the bit holder 230,

the shank 108 includes a lower or first tapered portion 122 running axially from a stepped shoulder 124 adjacent the distal end 112 of the shank 108. The stepped shoulder 124 is disposed between the lower tapered portion 122 and the distal end 112. A diameter of the stepped shoulder 124 increases, or steps up, in this embodiment, as it axially extends from the distal end 112 to the lower tapered portion 122. The first tapered portion 122 runs upwardly or axially from the stepped shoulder 124 of the shank 108 and terminates generally mid first slot 110 longitudinally. The shank 108 also includes an annular shoulder 126 separating the lower tapered portion 122 from an upper or second tapered portion 128 which extends from the shoulder 126 to generally adjacent to the top of the shank 108 or forward terminations 114, 120 of slots 110, 116, respectively. The annular shoulder 126 is disposed between the lower tapered portion 122 and the upper tapered portion 128. A diameter of the annular shoulder 126 decreases, or steps down, in this embodiment, as it axially extends from the lower tapered portion 122 to the upper tapered portion 128. In other embodiments, the lower portion 122 and/or the upper portion 128 of the shank 108 may comprise a generally cylindrical shape, a slight draw angle, or a slight draft angle. In yet other embodiments, the shank 108 can comprise many different configurations.

[0051] A generally cylindrical top portion 130 of the shank 108 extends from a position adjacent the top or upper terminations 114, 120 of slots 110, 116, respectively, towards a generally annular back flange 132 that denotes the base or the bottom of the body 106 of the bit holder 230. The top of the shank 108 may include a rounded junction 134 between the top portion 130 of the shank 108 and the generally annular flange 132 of the body 106 of the bit holder 230, which is provided to avoid sharp corners which may provide an area for stress cracks to begin. The generally annular flange 132 includes a pair of horizontal slots or wedge extraction notches 136-136 generally perpendicular to the longitudinal axis of the combination bit/holder, one on either side of the generally annular flange 132. The horizontal slots 136-136 are configured to receive a pair of bifurcated fork tines that may be inserted between the base of the body 106 of the bit holder 230 and a base block (not shown) into which the shank 108 of the unitary bit/holder 104 is inserted and retained by outward radial force in use.

[0052] A central bore 138 longitudinally and axially extending through the shank 108 of the bit holder 230 terminates at bore termination 140, which in this illustrated embodiment has a conical shape, which is approximately at the upper end of the shank 108. This allows the generally C-shaped annular sidewall of the shank 108 to radially contract when the shank 108 is mounted in a tapered and/or cylindrical bore in a base block (not shown).

[0053] In this sixth illustrated embodiment of the bit holder 230, the bit holder body 106 includes a generally cylindrical or annular upper body portion 142 depending

from a forward end 144 of the upper body portion 142. A mediate body portion 146 subjacent the upper body portion 142 generally slopes axially and radially outwardly to a radially extending generally cylindrical tire portion 148.

[0054] The bit holder body 106, in order to provide superior brazing of a tungsten carbide ring 150 to the forward end 144 of the upper body portion 142, includes a forwardly extending annular collar 152 that is created on the bit holder body 106 to provide an annular trough 154 around a forward extension 232 of the bit holder body 106 onto which the annular ring 150 is mounted. In this illustrated embodiment, the annular collar 152 includes a cylindrical bottom inner wall 158 and a tapered top inner wall or countersink 160. The vertical outer wall of the collar 152 will keep brazing material from flowing outwardly of the joint between the base of the ring 150 and the annular trough 154 on which the ring 150 is positioned. The annular trough 154 is therearound positioned perpendicular to the axis of the bit holder 230 from the smaller radially oriented annular upper or forward extension 232 (FIG. 18). Around this forward extension 232 is fitted the annular tungsten carbide ring 150, the forward extension 232 extending through a bore 162 that extends through the annular tungsten carbide ring 150 allowing a bottom of the ring 150 to be seated in the annular trough 154, which is be brazed into unitary construction with the remainder of the bit holder 230 in a one step process. In one exemplary implementation, the bore 162 of the annular tungsten carbide ring 150 may comprise a cylindrical upper section 168 and an outwardly tapered bottom section 170, as shown in FIGS. 18 and 19. An axial length 172 of the ring 150, corresponding to the generally cylindrical top inner portion 168 of the bore 162 of the ring 150, is designed to maintain radial support after being brazed. The clearance between the inner diameter of the bore 162 of the annular tungsten carbide ring 150 and the outer diameter of a cylindrical top portion 234 of the forward extension 232 is, in the exemplary implementation, approximately in the range of 0.003 to 0.012 inch per side depending on where the measurement is axially taken. The top or forwardmost portion of the forward extension 232 of the bit holder body 106 terminates generally at a forward end 174 of the bit holder body 106 of the bit holder 230, located above the forward portion 176 of the annular tungsten carbide ring 150. In another exemplary implementation, the bore 162 of the annular tungsten carbide ring 150 may comprise a continuous taper (not shown) from the bottom of the bore 162 to the forward portion of the annular tungsten carbide ring 150. In other implementations, the forward extension 232 and the bore 162 of the ring 150 can have complementary shaped surfaces. The bit holder 230 may be machined and hardened, or hardened and then machined. The annular tungsten carbide ring 150 may be brazed before or after hardening of the bit holder 230.

[0055] In this exemplary implementation of the sixth embodiment of the bit holder 230, the forward extension

232 includes the generally cylindrical top portion 234 and an outwardly tapered bottom portion 236. The forward extension 232, which forms the unitary steel forward end of the tubular portion of the diamond tool body, includes a bore 238 that axially extends from the forward end 174, through the generally cylindrical top portion 234 and partially through the tapered bottom portion 236, to a bore termination 240. In this illustrated exemplary embodiment, the bore 238 includes a generally cylindrical bore section 242 that axially extends from the forward end 174 through the generally cylindrical top portion 234 to a location adjacent the tapered bottom portion 236, a tapered bore section 244 that axially extends from a distal end 246 of the generally cylindrical bore section 242 to the bore termination 240, which in this exemplary implementation is conical, adjacent the forward end 144 of the upper body portion 142. The bore 238 provides a space for receiving a tapered tungsten carbide extension plug 248 and the complementary shaped bit 100. The bit tip insert 100 comprises a base 182 and a tip 184 adjacent the base 182 that includes a parabolic curved section below an apex of the bit tip insert 100. This tip 184 can have a frustoconical shape, a flat generally cylindrical puck shape, a parabolic ballistic shape, a conical shape, and/or an arcuate shape. In this sixth embodiment, the base 182 includes a generally cylindrical sidewall 186 and a tapered section 190 that extends from the cylindrical sidewall 186 to a generally flat distal end 188 of the bit tip insert 100. In an alternate embodiment, the base 182 can include a tapered sidewall and the distal end 188 of the bit tip insert 100 can be conical, frustoconical, arcuate, or have a different configuration. In one exemplary implementation of the sixth embodiment, the bit tip insert 100 can have a diameter in the range of 1/2 inch to 1-3/8 inches. The bit tip insert 100 may be a tungsten carbide insert or may be a tungsten carbide insert that includes an overlay 192 (FIG. 16) of a polycrystalline diamond structure that is applied to an outer surface of the tip 184. The overlay 192 may be a single coating or outer layer or multiple coatings or outer layers of such industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material.

[0056] To assemble the combination diamond coated axially shortened bit 100 and bit holder 230 of the present disclosure to form a unitary structure bit and bit holder construction of a bit/holder, tool, and/or pick 104, the annular tungsten carbide ring 150 is positioned around the forward extension 232 and brazed in the annular trough 154 of the bit holder body 106. The base 182 and the sidewall 186 of the bit tip insert 100 is brazed to a forward end 250 of the tungsten carbide extension plug 248 at the same time as the carbide ring 150, using, for example, a disc shaped or ring shaped braze material, and also creating a high strength braze joint 254 (FIG. 19) between the base 182 of the bit tip insert 100 and the forward end 250 of the tungsten carbide extension plug 248, which may then be optionally hardened. A distal end 252, which

in this illustrated embodiment is conical, of the tungsten carbide extension plug 248 is brazed in the bore 238 of the forward extension 232 at the same time as the bit tip insert 100 and the carbide ring 150 are brazed, using, for example, a disc shaped or ring shaped braze material, and also creating a high strength braze joint, which may then be optionally hardened. This braze joint secures the distal end 252 of the tungsten carbide extension plug 248 to the bore termination 240 and to the bore 238 of the forward extension 232, adjacent the forward end 174 of the diamond tool body 106. The three parts, the bit tip insert 100, the tungsten carbide ring 150, and the tungsten carbide extension plug 248, are brazed together in a one step brazing process. In this sixth embodiment, the annular sidewall 194 of the cylindrical top portion 234 of the forward extension 232 remains in place, as shown in FIG. 19, after brazing the combination bit tip insert 100 and tungsten carbide extension plug 248 in the bore 238, however, the annular sidewall 194 will be quickly worn away by the abrasive action of the cut material. This sidewall 194 can also be machined away after brazing.

[0057] As used in this application, the term "or" is intended to mean an inclusive "or" rather than an exclusive "or". That is, unless specified otherwise, or clear from context, "X includes A or B" is intended to mean any of the natural inclusive permutations. That is, if X includes A; X includes B; or X includes both A and B, then "X includes A or B" is satisfied under any of the foregoing instances. In addition, "X includes at least one of A and B" is intended to mean any of the natural inclusive permutations. That is, if X includes A; X includes B; or X includes both A and B, then "X includes at least one of A and B" is satisfied under any of the foregoing instances. The articles "a" and "an" as used in this application and the appended claims should generally be construed to mean "one or more" unless specified otherwise or clear from context to be directed to a singular form. Moreover, use of the term "an implementation" or "one implementation" throughout is not intended to mean the same embodiment, aspect or implementation unless described as such.

[0058] While the present disclosure has been described in connection with certain embodiments and measurements, it is to be understood that the present disclosure is not to be limited to the disclosed embodiments and measurements but, on the contrary, is intended to cover various modifications and equivalent arrangements included within the scope of the appended claims, which scope is to be accorded the broadest interpretation so as to encompass all such modifications and equivalent structures as is permitted under the law.

Aspects:

[0059] It is appreciated that any of aspects 1-20 can be combined.

1. A tool comprising:

a body comprising an annular trough and a forward extension axially extending from the annular trough to a forward end of the body;
a shank extending axially from a bottom of the body; and

an annular tungsten carbide ring comprising a ring bore, the forward extension extending through the ring bore, and the annular tungsten carbide ring adapted to be seated and brazed in the annular trough of the body.

2. The tool of aspect 1, further comprising:

a forward extension bore of the forward extension extending axially inwardly from the forward end of the body to a bore termination within the forward extension.

3. The tool of aspect 2, further comprising:

a generally cylindrical section of the forward extension including an annular wall, the generally cylindrical section axially extending inwardly from the forward end of the body, the forward extension bore extending axially through the generally cylindrical section of the forward extension to the bore termination adjacent an outwardly tapered section of the forward extension; and

the outwardly tapered section subjacent the generally cylindrical section of the forward extension, a distal end of the outwardly tapered section of the forward extension integrally formed with the annular trough of the body.

4. The tool of aspect 3, further comprising:

a bit tip insert comprising a tip, a base subjacent the tip, and a distal end opposite the tip, the bit tip insert adapted to be seated in the forward extension bore of the distal end of the bit tip insert adapted to be brazed in the bore termination of the forward extension.

5. The tool of aspect 4, wherein the annular wall of the generally cylindrical section of the forward extension is machined away after the distal end of the bit tip insert is brazed in the bore termination.

6. The tool of aspect 2, further comprising:

a generally cylindrical section of the forward extension including an annular wall, the generally cylindrical section axially extending inwardly from the forward end of the body;

an outwardly tapered section subjacent the generally cylindrical section of the forward extension, a distal end of the outwardly tapered section of the forward extension integrally formed with the annular trough of the body; and

the forward extension bore extending axially through the generally cylindrical section of the forward extension to the bore termination adjacent the distal end of the outwardly tapered section of the forward extension.

7. The tool of aspect 2, further comprising:

a bit tip insert comprising a tip, a base subjacent the tip, and a distal end opposite the tip, the distal end of the bit tip insert adapted to be brazed to a forward end of a generally cylindrical tungsten carbide plug; and

a distal end of the generally cylindrical tungsten carbide plug adapted to be seated and brazed in the bore termination of the forward extension and the bit tip insert adapted to be seated in the generally cylindrical section of the forward extension.

8. The tool of aspect 7, wherein the annular wall of the generally cylindrical section of the forward extension is machined away after the bit tip insert is seated in the forward extension bore.

9. The tool of aspect 2, further comprising:

a generally cylindrical section of the forward extension including an annular wall, the generally cylindrical section axially extending inwardly from the forward end of the body;

an outwardly tapered section subjacent the generally cylindrical section of the forward extension, a distal end of the outwardly tapered section of the forward extension integrally formed with the annular trough of the body; and

the forward extension bore extending axially through the generally cylindrical section of the forward extension to the bore termination adjacent the distal end of the outwardly tapered section of the forward extension.

10. The tool of aspect 9, further comprising:

a generally cylindrical bore section of the forward extension bore extending axially inwardly from the forward end of the body and the generally cylindrical section of the forward extension to a location adjacent a forward end of the outwardly tapered section of the forward extension; and

a tapered bore section of the forward extension bore extending axially inwardly from the distal end of the generally cylindrical bore section of the forward extension to the bore termination.

11. The tool of aspect 2, wherein the bore termination comprises one of a flat shape, a conical shape, and

a frustoconical shape.

12. The tool of aspect 10, further comprising:

a bit tip insert comprising a tip, a base subjacent the tip, and a distal end opposite the tip, the distal end of the bit tip insert adapted to be brazed to a forward end of a tapered tungsten carbide plug; and
a distal end of the tapered tungsten carbide plug adapted to be seated and brazed in the bore termination of the forward extension and the bit tip insert adapted to be seated in the generally cylindrical section of the forward extension.

13. The tool of aspect 12, wherein the distal end of the tapered tungsten carbide plug comprises one of a flat shape, a conical shape, and a frustoconical shape.

14. The tool of aspect 12, wherein the annular wall of the generally cylindrical section of the forward extension is machined away after the bit tip insert is seated in the forward extension bore.

15. The tool of aspect 1, further comprising:

a solid generally cylindrical section of the forward extension extending axially inwardly from the forward end of the body; and
an outwardly tapered section subjacent the generally cylindrical section of the forward extension, a distal end of the outwardly tapered section of the forward extension integrally formed with the annular trough of the body.

16. The tool of aspect 15, further comprising:

a bit tip insert comprising a tip, a base subjacent the tip, and a distal end opposite the tip, the distal end of the bit tip insert adapted to be brazed to a forward surface of the solid generally cylindrical section of the forward extension.

17. The tool of aspect 4, further comprising:

an overlay applied to an outer surface of the tip of the bit tip insert, the overlay comprising at least one of a:

single coating of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
single outer layer of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
multiple coatings of at least one of industrial diamond material, natural diamond, polycrystalline

diamond (PCD) material, and polycrystalline diamond composite or PCD material; and
multiple layers of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material.

18. The tool of aspect 7, further comprising:

an overlay applied to an outer surface of the tip of the bit tip insert, the overlay comprising at least one of a:

single coating of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
single outer layer of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
multiple coatings of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material; and
multiple layers of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material.

19. The tool of aspect 12, further comprising:

an overlay applied to an outer surface of the tip of the bit tip insert, the overlay comprising at least one of a:

single coating of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
single outer layer of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
multiple coatings of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material; and
multiple layers of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material.

20. The tool of aspect 16, further comprising:

an overlay applied to an outer surface of the tip of the bit tip insert, the overlay comprising at least one of a:

single coating of at least one of industrial diamond material, natural diamond, polycrystalline

diamond (PCD) material, and polycrystalline diamond composite or PCD material; single outer layer of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material; multiple coatings of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material; and multiple layers of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material.

Claims

1. A tool comprising:

a body comprising an annular trough and a forward extension axially extending from the annular trough to a forward end of the body;
a shank extending axially from a bottom of the body; and
an annular tungsten carbide ring comprising a ring bore, the forward extension extending through the ring bore, and the annular tungsten carbide ring adapted to be seated and brazed in the annular trough of the body.

2. The tool of claim 1, further comprising:

a forward extension bore of the forward extension extending axially inwardly from the forward end of the body to a bore termination within the forward extension.

3. The tool of claim 2, further comprising:

a generally cylindrical section of the forward extension including an annular wall, the generally cylindrical section axially extending inwardly from the forward end of the body, the forward extension bore extending axially through the generally cylindrical section of the forward extension to the bore termination adjacent an outwardly tapered section of the forward extension; and
the outwardly tapered section subjacent the generally cylindrical section of the forward extension, a distal end of the outwardly tapered section of the forward extension integrally formed with the annular trough of the body.

4. The tool of claim 3, further comprising:

a bit tip insert comprising a tip, a base subjacent the tip, and a distal end opposite the tip, the bit tip insert adapted to be seated in the forward extension bore

of the distal end of the bit tip insert adapted to be brazed in the bore termination of the forward extension.

5. The tool of claim 4, wherein the annular wall of the generally cylindrical section of the forward extension is machined away after the distal end of the bit tip insert is brazed in the bore termination, or wherein the tool further comprises an overlay applied to an outer surface of the tip of the bit tip insert, the overlay comprising at least one of a:

single coating of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
single outer layer of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
multiple coatings of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material; and
multiple layers of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material.

6. The tool of claim 2, further comprising:

a generally cylindrical section of the forward extension including an annular wall, the generally cylindrical section axially extending inwardly from the forward end of the body;
an outwardly tapered section subjacent the generally cylindrical section of the forward extension, a distal end of the outwardly tapered section of the forward extension integrally formed with the annular trough of the body; and
the forward extension bore extending axially through the generally cylindrical section of the forward extension to the bore termination adjacent the distal end of the outwardly tapered section of the forward extension.

7. The tool of claim 2, further comprising:

a bit tip insert comprising a tip, a base subjacent the tip, and a distal end opposite the tip, the distal end of the bit tip insert adapted to be brazed to a forward end of a generally cylindrical tungsten carbide plug; and
a distal end of the generally cylindrical tungsten carbide plug adapted to be seated and brazed in the bore termination of the forward extension and the bit tip insert adapted to be seated in the generally cylindrical section of the forward ex-

tension.

8. The tool of claim 7, wherein the annular wall of the generally cylindrical section of the forward extension is machined away after the bit tip insert is seated in the forward extension bore, or wherein the tool further comprises an overlay applied to an outer surface of the tip of the bit tip insert, the overlay comprising at least one of a:

single coating of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
single outer layer of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
multiple coatings of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material; and
multiple layers of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material.

9. The tool of claim 2, further comprising:

a generally cylindrical section of the forward extension including an annular wall, the generally cylindrical section axially extending inwardly from the forward end of the body;
an outwardly tapered section subjacent the generally cylindrical section of the forward extension, a distal end of the outwardly tapered section of the forward extension integrally formed with the annular trough of the body; and
the forward extension bore extending axially through the generally cylindrical section of the forward extension to the bore termination adjacent the distal end of the outwardly tapered section of the forward extension.

10. The tool of claim 9, further comprising:

a generally cylindrical bore section of the forward extension bore extending axially inwardly from the forward end of the body and the generally cylindrical section of the forward extension to a location adjacent a forward end of the outwardly tapered section of the forward extension; and
a tapered bore section of the forward extension bore extending axially inwardly from the distal end of the generally cylindrical bore section of the forward extension to the bore termination.

11. The tool of claim 2, wherein the bore termination comprises one of a flat shape, a conical shape, and a frustoconical shape.

12. The tool of claim 10, further comprising:

a bit tip insert comprising a tip, a base subjacent the tip, and a distal end opposite the tip, the distal end of the bit tip insert adapted to be brazed to a forward end of a tapered tungsten carbide plug; and
a distal end of the tapered tungsten carbide plug adapted to be seated and brazed in the bore termination of the forward extension and the bit tip insert adapted to be seated in the generally cylindrical section of the forward extension.

13. The tool of claim 12, wherein the distal end of the tapered tungsten carbide plug comprises one of a flat shape, a conical shape, and a frustoconical shape, or wherein the annular wall of the generally cylindrical section of the forward extension is machined away after the bit tip insert is seated in the forward extension bore, or wherein the tool further comprises an overlay applied to an outer surface of the tip of the bit tip insert, the overlay comprising at least one of a:

single coating of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
single outer layer of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
multiple coatings of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material; and
multiple layers of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material.

14. The tool of claim 1, further comprising:

a solid generally cylindrical section of the forward extension extending axially inwardly from the forward end of the body; and
an outwardly tapered section subjacent the generally cylindrical section of the forward extension, a distal end of the outwardly tapered section of the forward extension integrally formed with the annular trough of the body.

15. The tool of claim 14, further comprising:

a bit tip insert comprising a tip, a base subjacent the

tip, and a distal end opposite the tip, the distal end of the bit tip insert adapted to be brazed to a forward surface of the solid generally cylindrical section of the forward extension, wherein the tool optionally further comprises an overlay applied to an outer surface of the tip of the bit tip insert, the overlay comprising at least one of a:

single coating of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
single outer layer of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material;
multiple coatings of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material; and
multiple layers of at least one of industrial diamond material, natural diamond, polycrystalline diamond (PCD) material, and polycrystalline diamond composite or PCD material.

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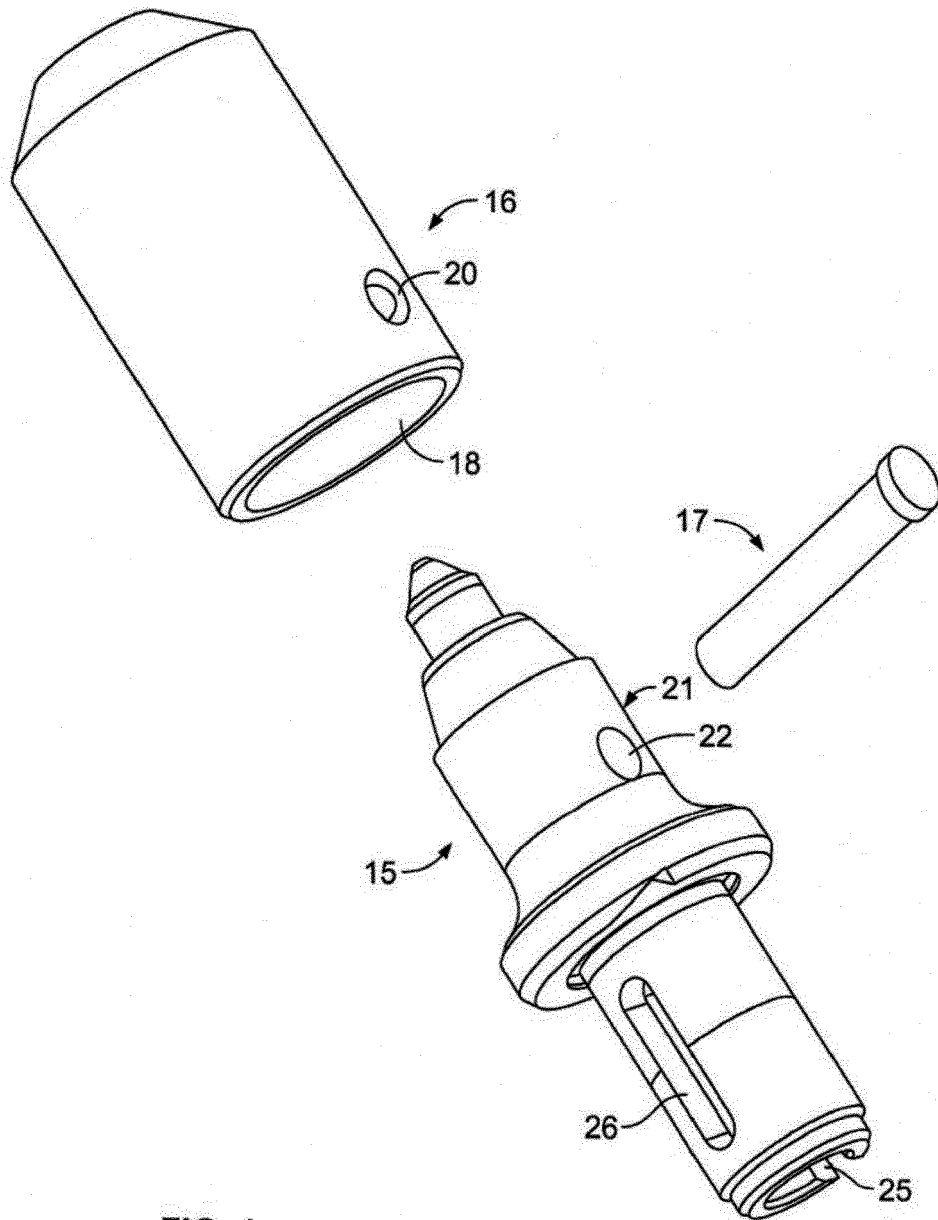


FIG. 1

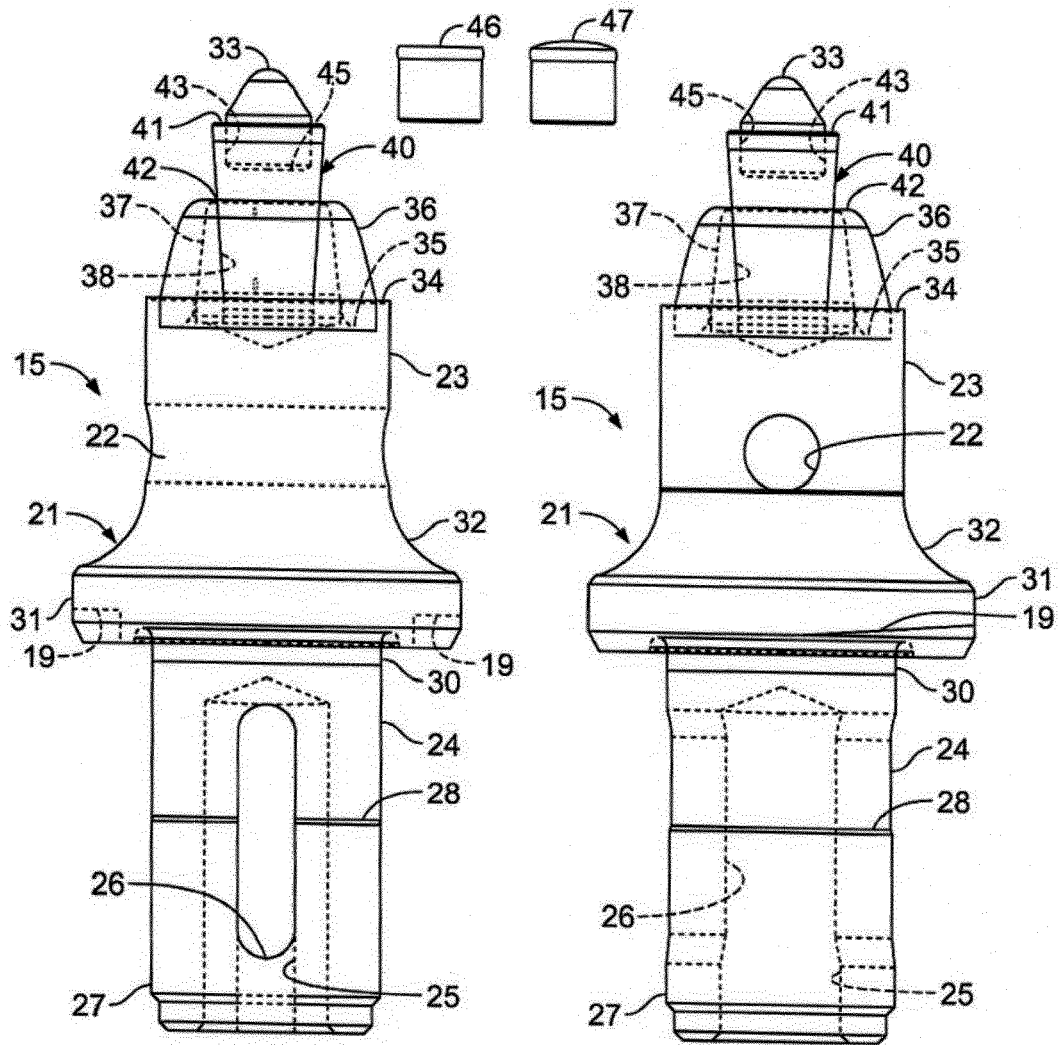


FIG. 2

FIG. 3

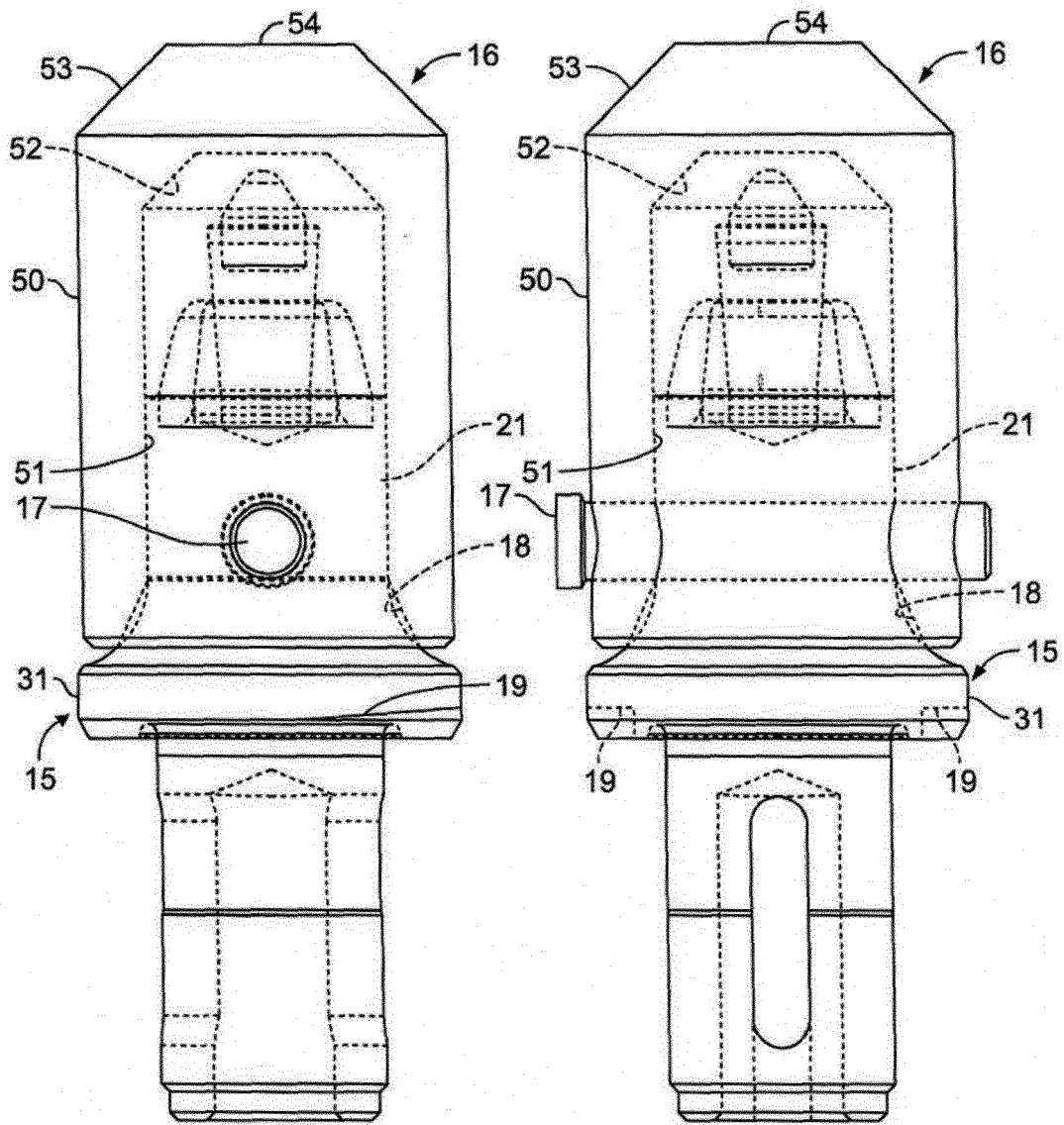
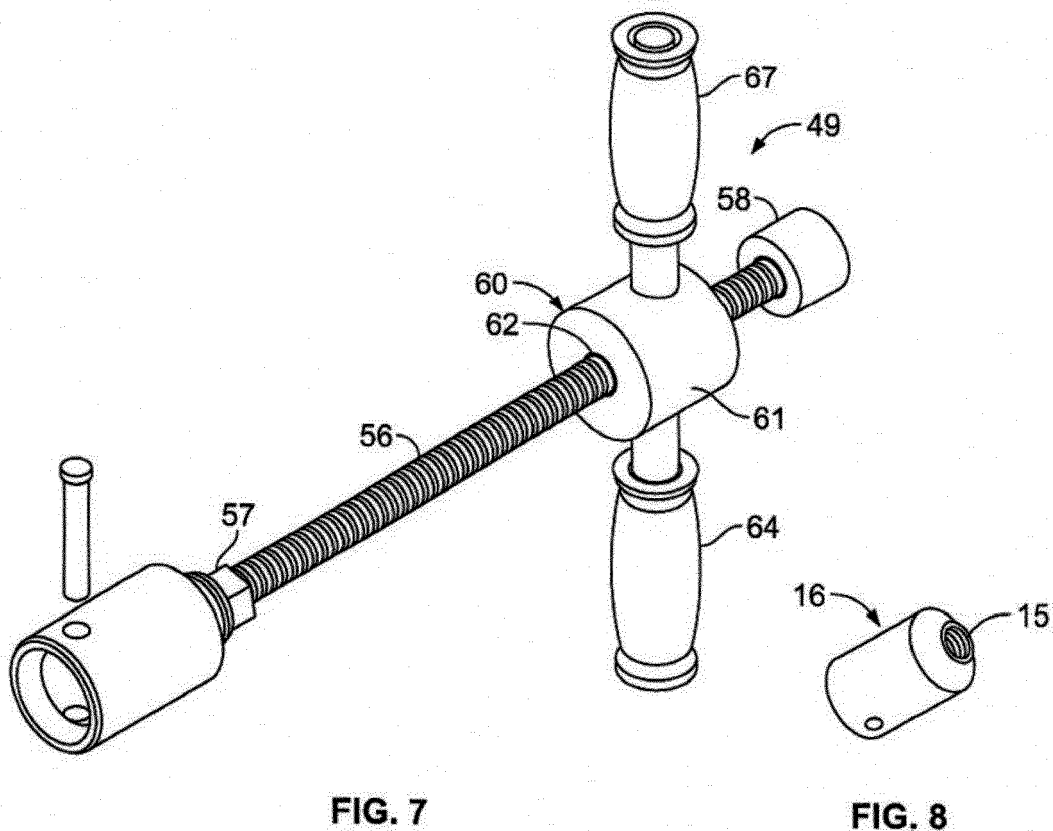
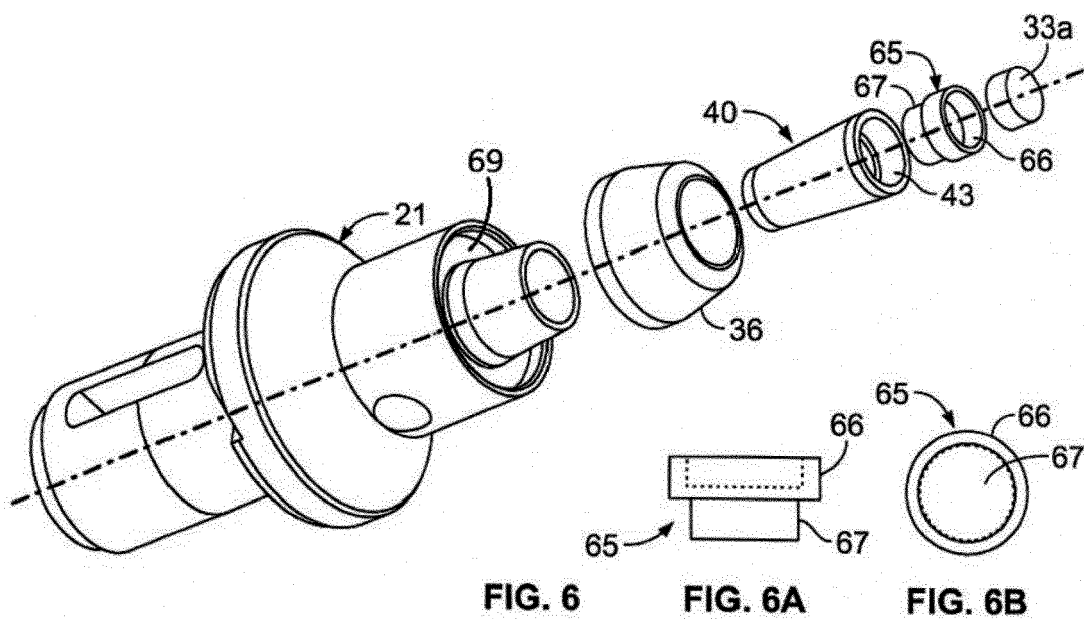


FIG. 4

FIG. 5



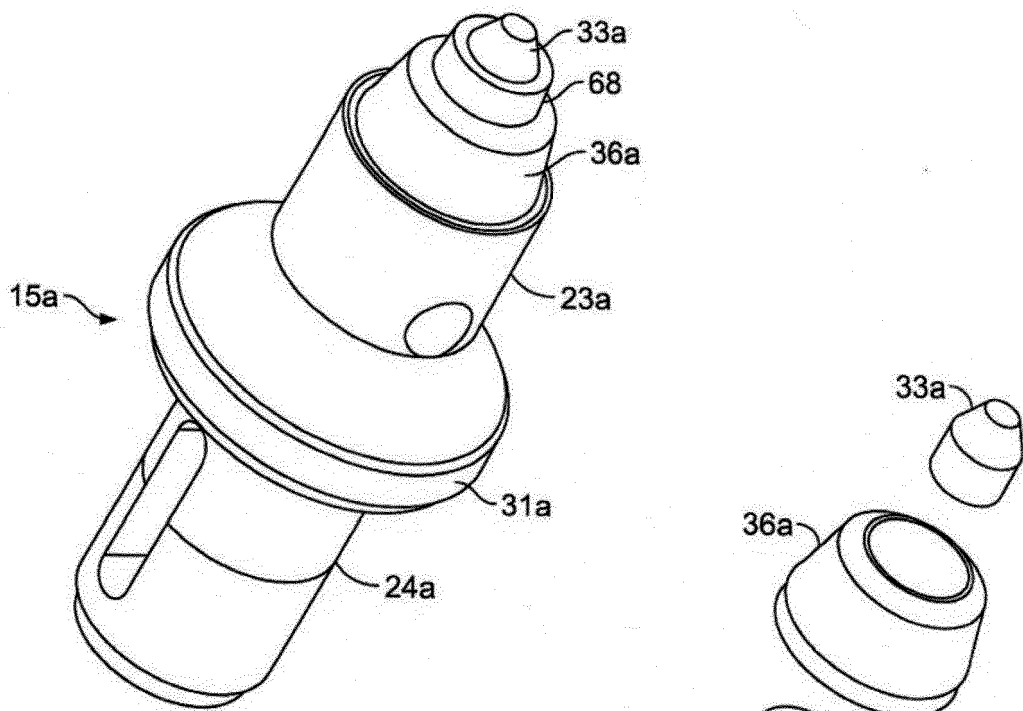


FIG. 9

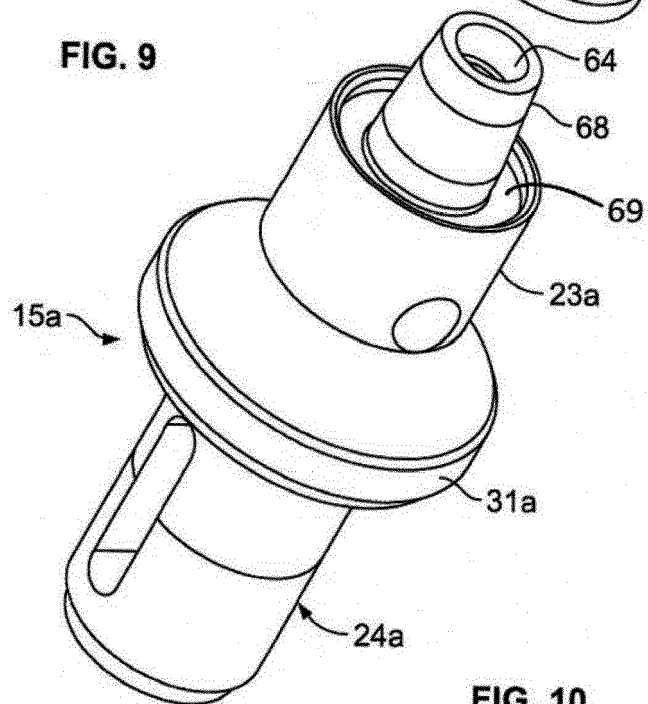


FIG. 10

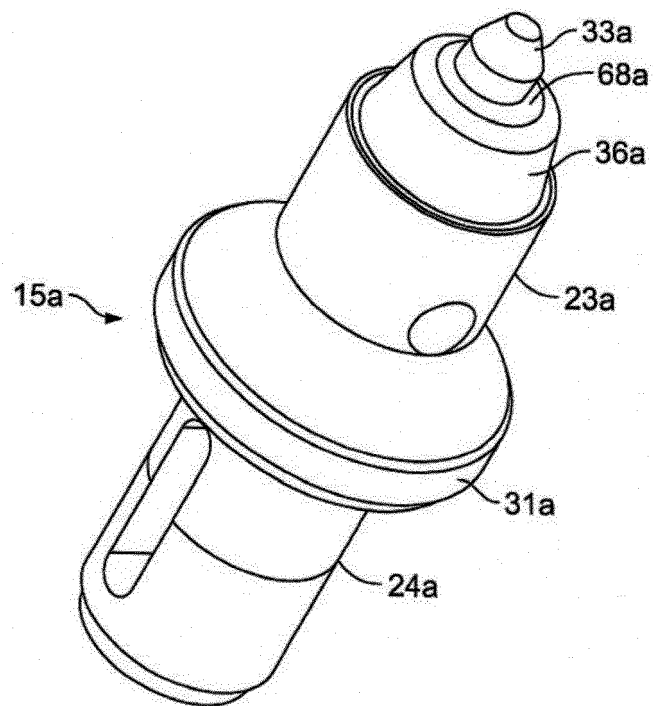


FIG. 11

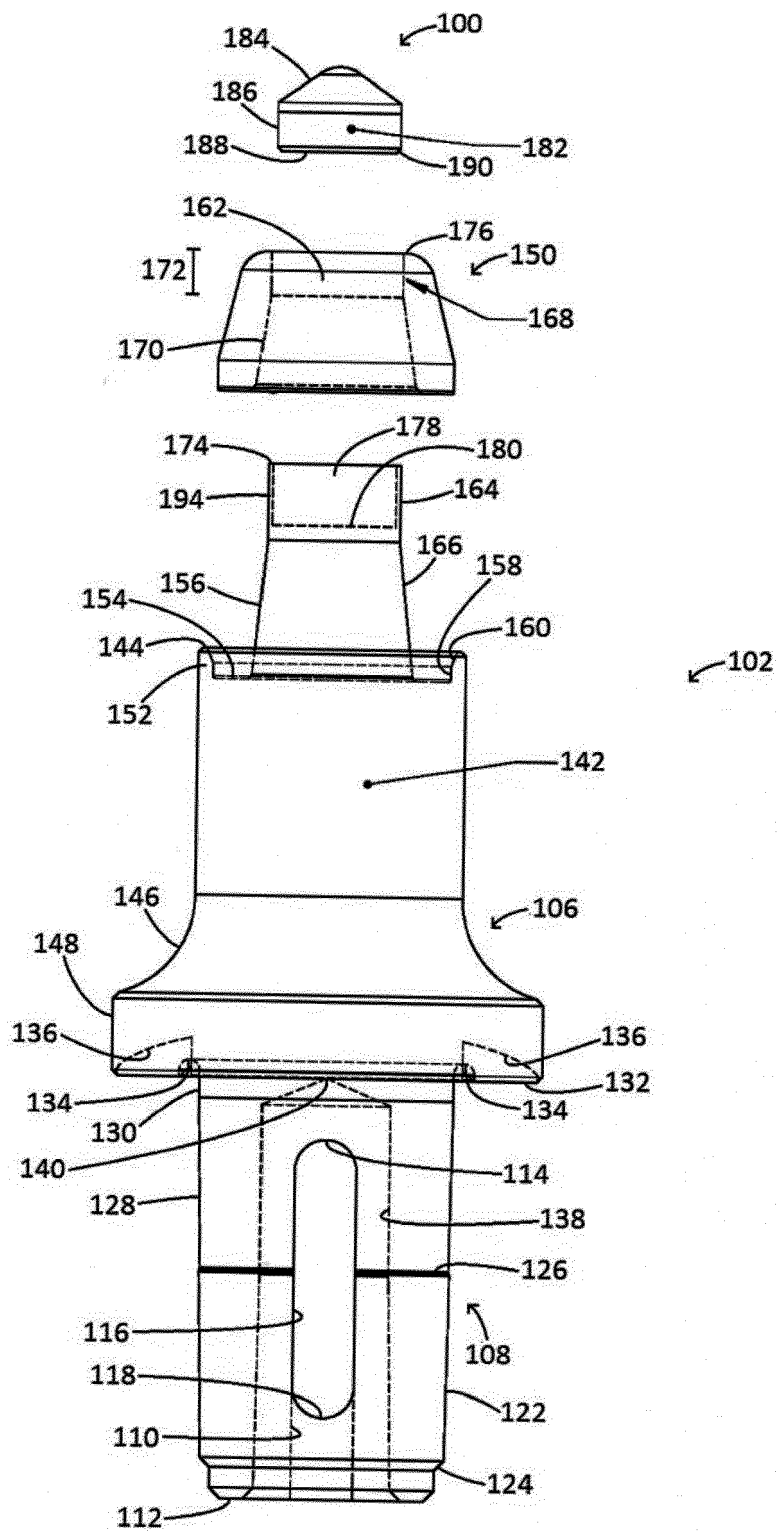


FIG. 12

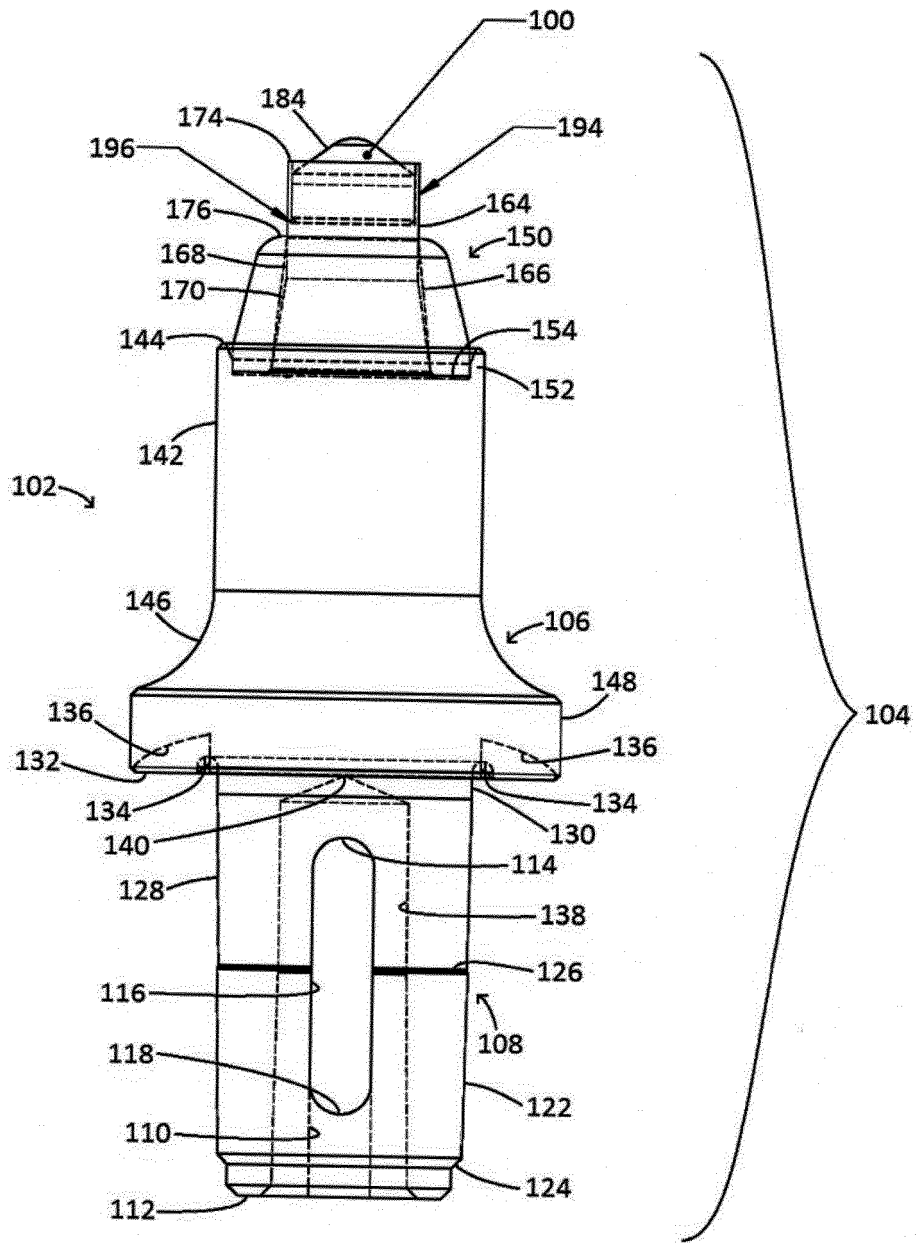


FIG. 13

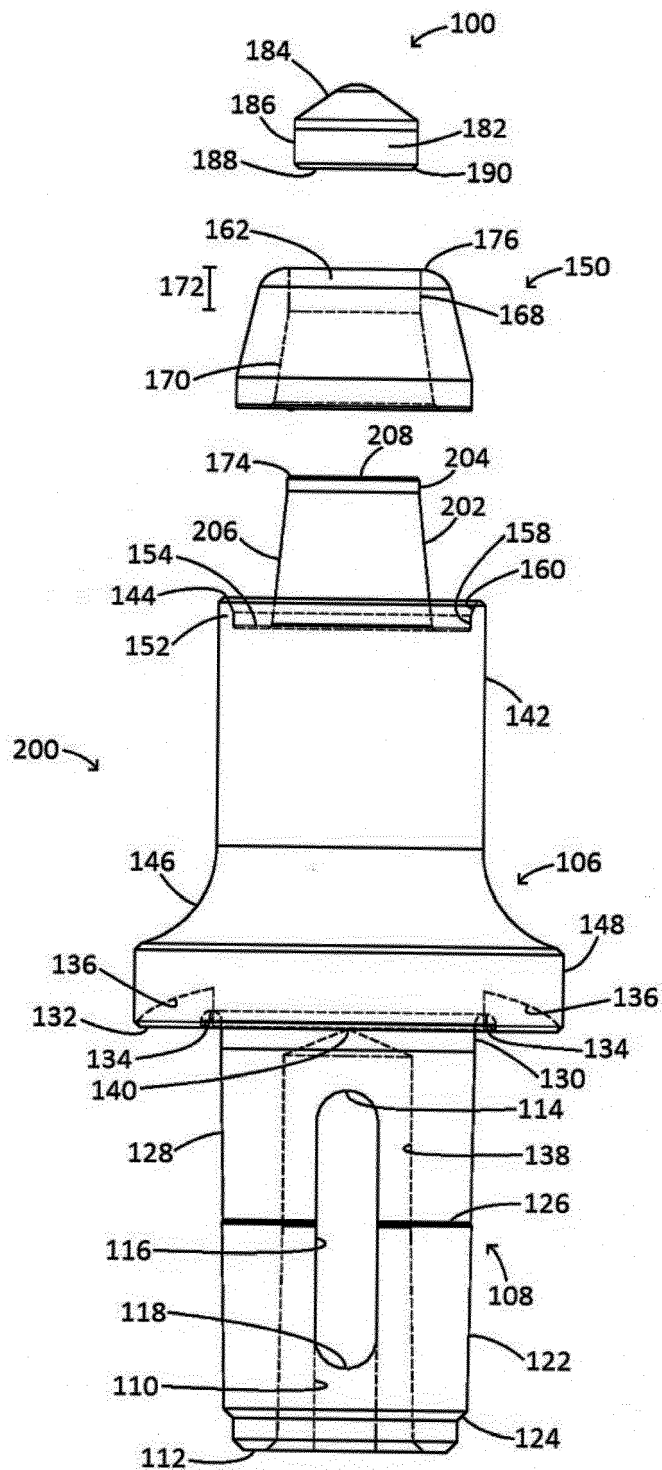


FIG. 14

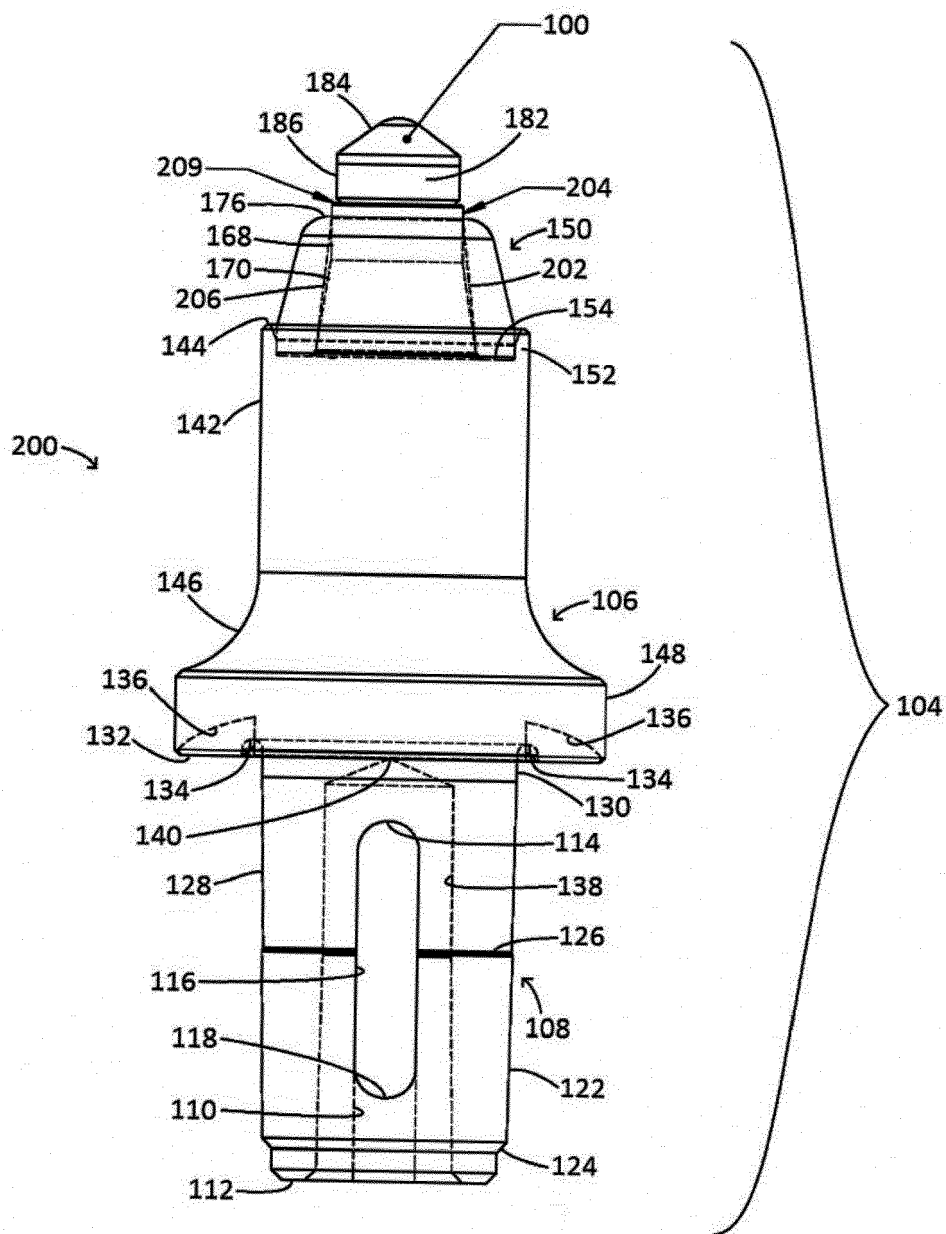


FIG. 15

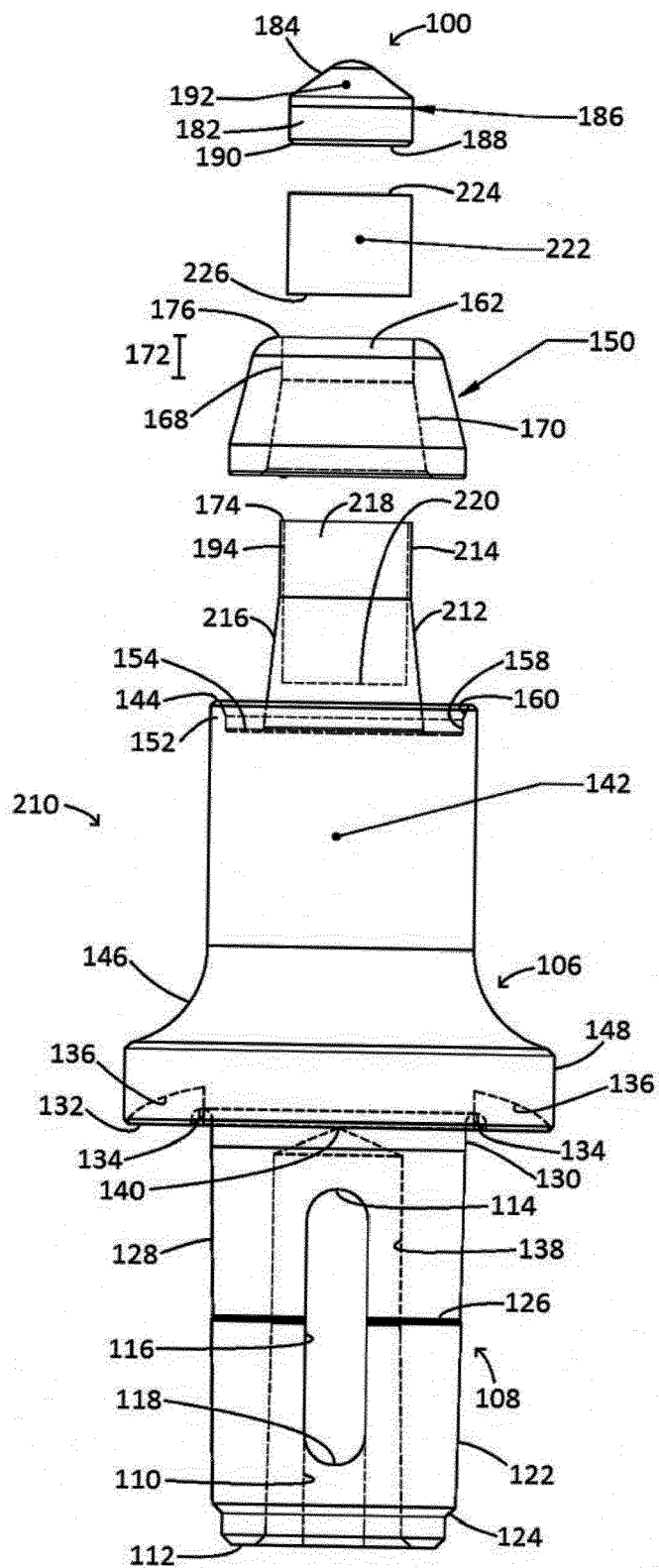


FIG. 16

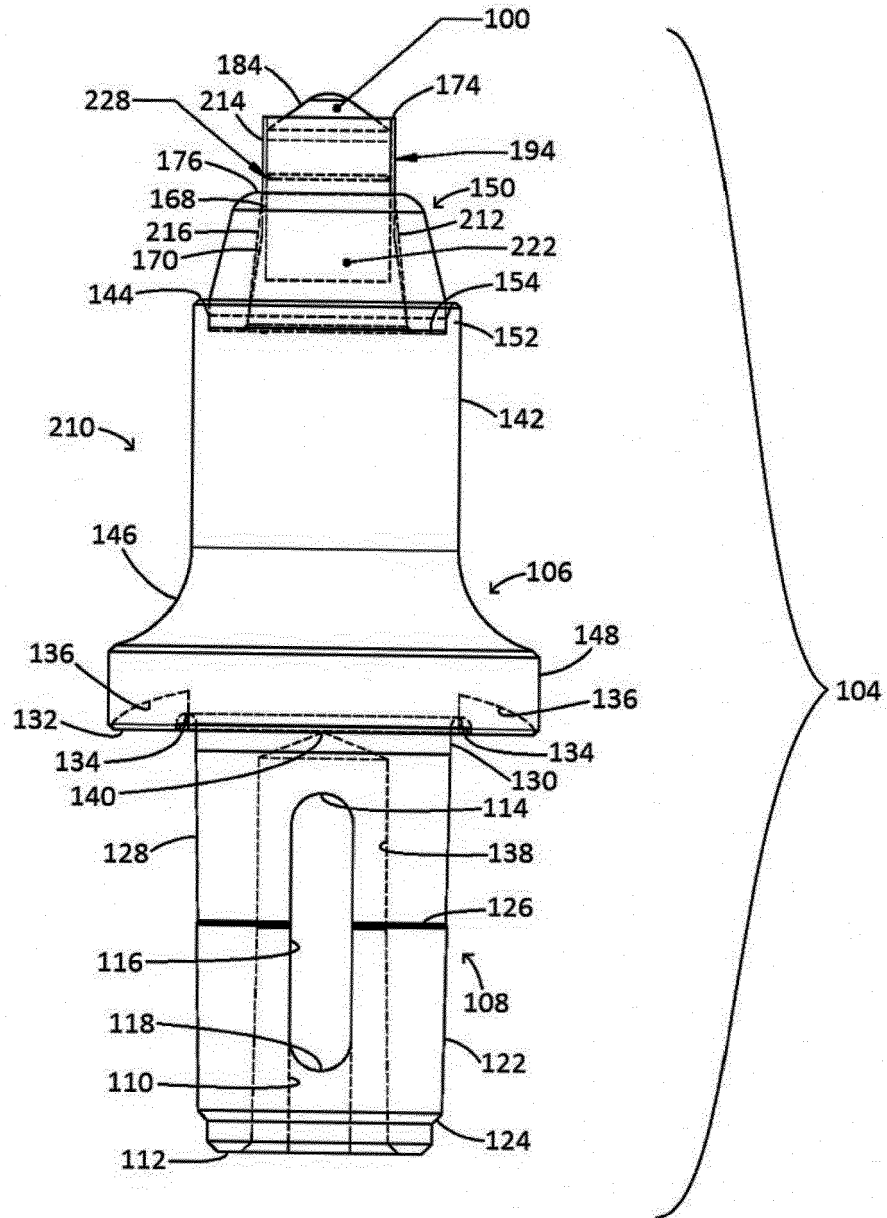


FIG. 17

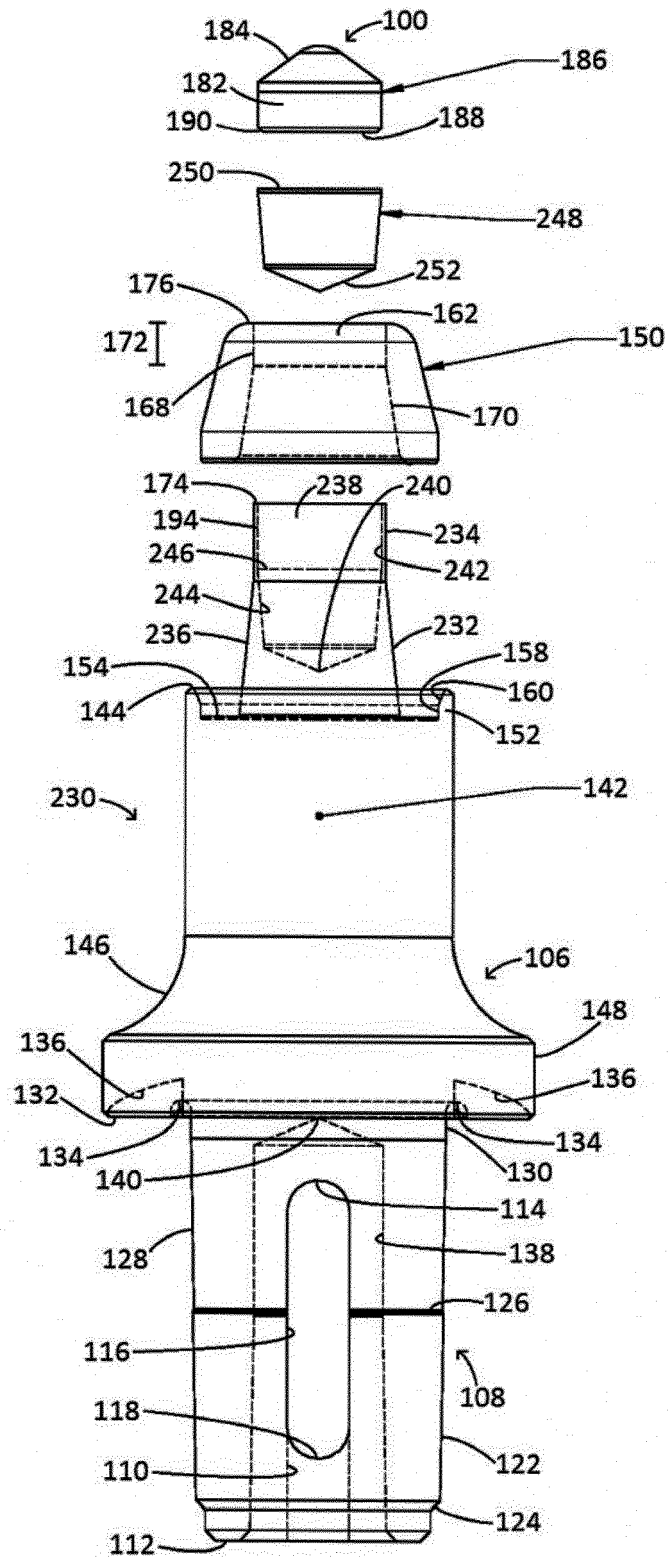


FIG. 18

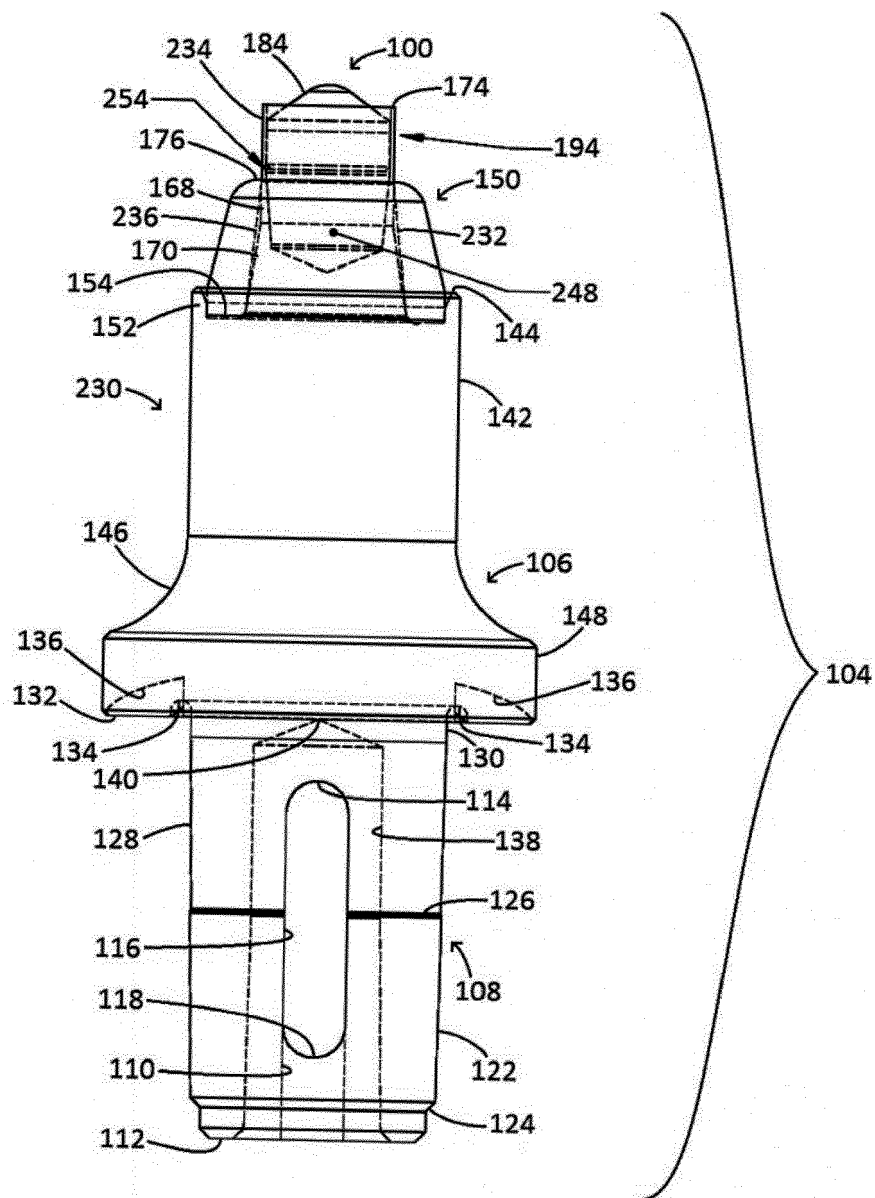


FIG. 19



EUROPEAN SEARCH REPORT

Application Number
EP 19 18 5939

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X	US 2003/122414 A1 (SOLLAMI PHILLIP A [US]) 3 July 2003 (2003-07-03) * paragraph [0033]; figures 5, 7 *	1,2,11	
X	US 2017/089198 A1 (SOLLAMI PHILLIP [US]) 30 March 2017 (2017-03-30) * figures 4, 5 *	1,2,11	
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			E21C
The present search report has been drawn up for all claims			
Place of search Munich		Date of completion of the search 20 November 2019	Examiner Georgescu, Mihnea
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20-11-2019

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