

PATENTS ACT 1977
P9425GB-NF/jsd

DESCRIPTION OF INVENTION

"IMPROVEMENTS IN OR RELATING TO A MILLING INSERT AND A MILLING TOOL"

THE PRESENT INVENTION relates to a milling insert and to a milling tool which utilises the insert. In particular, the invention relates to a milling insert and a milling tool of particular use in down-hole operations in the oil and gas-well industry.

Many proposals have been made concerning the provision of different types of "insert" for use on a milling tool. The insert is typically an element made of very hard material, such as tungsten carbide, which is secured to a blade of a milling tool, the insert actually cutting the metal that is to be milled away by the tool.

Very particular requirements exist in connection with cutting inserts intended for use on mills for use "down-hole". Whilst, of course, it is desirable that the mill should operate as swiftly as possible, thus cutting away the maximum amount of metal in minimum time, the swarf (or cuttings) produced by the mill must be such that it can readily be carried out of the hole by the mud that flows through the hole. It is undesirable for the swarf (or cuttings) to be too long, since otherwise the swarf may form "bird's nests", which can give rise to significant difficulties.

In either event, all of the cutting edges remaining on the insert will subsequently no longer be available to effect cutting.

It is also desirable to provide a mill which can operate with the expenditure of a minimum amount of energy.

It has been proposed to provide a mill in which a specific type of cutting insert is provided. The cutting insert presents a front or operative face which is provided with a plurality of substantially parallel transversely extending projections. Each projection is substantially of triangular form in cross-section and thus each transversely extending projection effectively forms a cutting edge. The lower-most projection provided on the cutting insert is the first part of the insert to come into contact with the metal to be cut. The swarf generated by the cutting process moves along the upper face defined by the triangular projection, but is then broken off on reaching the under-face of the next projection. Thus, the length of the swarf is restricted.

As the lower-most cutting edge is worn away, the next cutting edge comes into operation.

A disadvantage of the prior proposal is that if the cutting edge encounters an irregularity, so that a shock is imparted to the cutting element, there is a risk that the entire cutting element may become dislodged from the mill. Alternatively, the cutting element may split or delaminate. A consequence of this may be that the exposed part of the cutting element, i.e. the part defining the transverse cutting edges, is no longer available to effect cutting.



-3-

The present invention seeks to provide an improved cutting insert and a mill incorporating the improved cutting insert.

According to this invention there is provided a cutting insert for use on a mill, the cutting insert comprising an element formed of a hard material, the element defining a rear face, by means of which the element may be mounted in position, and a front face, the front face defining, towards its lower edge, a cutting projection, defining a leading single cutting edge, the front face defining a surface which extends rearwardly and upwardly from the cutting edge.

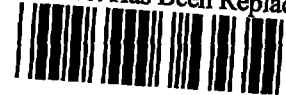
Preferably the front face is substantially planar, the arrangement being such that when the cutting insert is located in abutment with adjacent cutting inserts, the upper edge of the planar front face is located immediately adjacent a forwardly extending part of the under-surface of the cutting projection of the next adjacent cutting insert.

Conveniently the front face of the projection makes an angle of approximately 19^0 with the plane defined by the rear face of the insert.

Alternatively the upper part of the front face of the insert is of arcuate form.

Conveniently the upper part of the front face of the cutting insert is of arcuate form with a radius of curvature which gradually shortens.

Advantageously the front face terminates with a upper forwardly projecting protrusion.



-4-

Preferably the upper face and the lower face of the insert are inclined at an angle of approximately 5° to the perpendicular to the plane defined by the rear face of the cutting insert.

Conveniently the thickness of the insert is approximately 0.22 to 0.187 cms.

Advantageously the depth of the insert is approximately 0.62 to 0.635 cms.

The invention also relates to a mill, the mill comprising a body carrying a plurality of blades, the blades each carrying a plurality of cutting inserts as defined above in a regular array, with the under-face of one insert substantially abutting the upper face of the next adjacent insert.

The blades are preferably fixed blades which extend radially outwardly from the body, but the blades may be pivotally mounted blades. The blades may be aligned with the axis of the body or may exhibit a negative rake, typically of approximately 10° relative to the axis of the mill. The cutting inserts may be brazed to the blades.

In order that the invention may be more readily understood, and so that further features thereof may be appreciated, the invention will now be described, by way of example, with reference to the accompanying drawings in which:

FIGURE 1 is a perspective view of one cutting insert in accordance with the invention,



-5-

FIGURE 2 is a side view of a plurality of cutting inserts of Figure 1 when located adjacent each other,

FIGURE 3 is a perspective view of an alternative form of cutting insert in accordance with the invention,

FIGURE 4 is a side view showing a plurality of cutting inserts of the type shown in Figure 3 located adjacent one another,

FIGURE 5 is a side view, with parts cut away, of a mill provided with cutting inserts of the type shown in Figures 1 and 2.

Referring initially to Figures 1 and 2 of the drawings, one embodiment is a cutting insert in accordance with the invention comprises an element 1 made of a very hard material such as, for example, tungsten carbide. The insert may be made in a conventional way, but the insert is made to have a novel shape and configuration as will now be described.

The insert comprises a substantially cuboidal block of hard material. The rear face 2 of the block, which is a vertical face in the orientation illustrated, is substantially planar and is used, as will be described hereinafter, for mounting the block in position. The top face 3 and the under-face 4 of the block are parallel with each other but are not perpendicular to the plane defined by the rear face 2 of the block. The top face 3 and the under-face 4 are downwardly inclined from a perpendicular to the rear face at an angle 5 (see Figure 2) which is approximately 5° .

The side faces 6 and 7 of the block are parallel and extend perpendicularly to the plane defined by the rear face 2.

The front face 8 of the block is a substantially planar face inclined at an angle to the plane defined by the rear face 2 by an angle θ which is approximately 19° .

The lower part of the front face 8 thus forms a cutting projection, defining a leading single cutting edge. The front face 8 forms a surface which extends rearwardly and upwardly from the cutting edge.

As can be seen from Figure 2, a plurality of cutting inserts 1 of the type illustrated in Figure 1 may be located adjacent each other, with the rear faces 2 of the blocks being aligned to be co-planar, the upper face 3 of one insert being located substantially at abutment with the lower face 4 of the next adjacent insert. The upper edge of the planar front face 8 of the lower insert is located immediately adjacent a forwardly extending part of the under-surface of the cutting projection of the next adjacent cutting insert.

The overall thickness (T) of the block shown in Figure 1 may be 0.187 cms (0.074 inches), and the total depth (D) may be 0.635 cms (0.250 inches).

Figure 3 illustrates an alternative form of cutting insert for use in accordance with the invention. The cutting insert 10 shown in Figure 3 is again in the form of an element made of very hard material, such as tungsten carbide. The insert may again be made in a conventional way, but is made to have a novel shape and configuration.

Again the insert comprises a substantially cuboidal block of the hard material having a rear face 11 which is substantially vertical in the orientation illustrated. The insert 10 has a top face 12 and an under-face 13 which are parallel with each other, but which are not perpendicular to the plane defined by the rear face 11 of the block. The top face and the under-face are inclined downwardly, relative to a perpendicular from the rear face, at an angle 13 (see Figure 4) which is approximately 5° . The insert has side faces 14,15 which are parallel and which extend perpendicularly to the plane defined by the rear face.

The front face 16 of the block is of an arcuately recessed form. The block thus defines a lower cutting projecting portion 17 which defines a single leading cutting edge, which is initially of substantially planar form but subsequently curves 18 with a radius of curvature which gradually shortens to form an upper forwardly projecting protrusion 19.

It can be seen that when the cutting inserts, as described, are super-imposed, as shown in Figure 4, with the under-face 13 of one cutting insert located in abutment with the upper face 12 of the next adjacent insert, the upper protrusion 19 of one insert is substantially aligned with the lower projection 17 of the next adjacent insert.

A cutting insert as shown in Figures 3 and 4 may have a thickness (T) of approximately 0.22 cms (0.087 inches) and may have a depth (D) of approximately 0.62 cms (0.247 inches).

A plurality of inserts as described with reference to Figures 1 and 2, in the orientation shown in Figure 2, may be mounted on a mill 20 as shown in Figure 5. It is to

be understood that alternatively a plurality of the inserts 10 as described with reference to Figures 3 and 4, in the orientation shown in Figure 4, may be mounted on a mill in a directly corresponding manner.

The mill 20 comprises a generally cylindrical body 21 provided, at its upper end, with the threaded pin 22 to enable the body to be connected to another part of a drilling string, as is conventional. As is also conventional, the body is provided with a central flow passage 23 for mud or other drilling fluid.

The body is provided, adjacent its lower end, with a plurality of stabiliser blades 24 of a conventional design. The body is provided, towards its upper end, with a plurality of substantially radially outwardly directed cutter blades 25, these blades having a slight negative rake, approximately 10^0 , with regard to the axis of the body. It is to be appreciated that in an alternative embodiment each blade may be aligned with the axis of the body.

Each cutter blade has a substantially radially outwardly extending lower surface 26 comprising a cutter surface.

Mounted on the front face of each blade 25 is a regular array 27 of cutting inserts 1 as shown in Figure 1, with the inserts being located adjacent each other, in the manner illustrated in Figure 2. The rear face 2 of each cutting insert is welded or brazed to the blade 25.

In performing the brazing process, initially steps are taken to ensure that the blade 25 and the cutting inserts 1 are clean and free from grease or oil. The front

face of the blade 25 is coated with flux paste, as is the rear face of each of the carbide inserts. The fluxed carbide inserts are placed on to the fluxed face of the blade. Heat is then applied to the opposite side of the blade 25 using an appropriate gas burner nozzle.

When the flux is seen to be molten, the joint area is at a temperature of about 600°. An appropriate hand torch may then be used to heat the tungsten carbide elements and an appropriate brazing material, such as a silver brazing material, may be brought into contact with the heated joint area. The braising material is melted by heat conducted from the blade and from the cutting inserts, rather than being melted by direct application of flame from the hand torch.

Alternatively, after applying flux to the blade, a clean sheet of an appropriate foil of brazing metal may be applied to the fluxed blade before the fluxed cutting inserts are applied to the fluxed blade. If this procedure is adopted, when the blade is heated to an appropriate temperature, the foil will melt. If this procedure is utilised, it is appropriate for steps to be taken to ensure that the inserts do not move when the flux melts and the silver brazing material flows.

After the brazing process has been completed, the cutting inserts are to be cleaned so that no flux or other material is present on the cutting face.

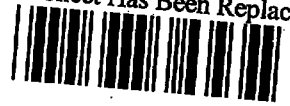
It is found that when a mill of this type is used, the swarf or cuttings that are generated are relatively cool, as compared with the temperature of cuttings produced by a significant proportion of the prior art mills. It is also found that less power has to be provided to the mill

to provide a predetermined cutting effect. It is found that the cuttings or swarf generated by the mill, when cutting a typical pipe as found down-hole in an oil or gas-well, are relatively short, typically being of the order of 1 millimetre long. It is believed that this is caused by the relative spacing between the various protrusions or cutting edges present on the front of the abutted cutting inserts. In the arrangement as shown in Figure 2, the spacing between the various cutting edges is equivalent of the thickness (T) of the insert (and a similar comment applies to the spacing between the cutting edges of the insert 10 as shown in Figures 3 and 4).

It is believed that the swarf cut travels up the inclined face 8 and is deflected when reaching the under-face 4 of the next adjacent cutting insert. The bent swarf curls over and breaks when a sufficient bending moment is imparted to the swarf. The swarf may effectively coil over until the swarf re-contacts the pipe being cut. The swarf then snaps off. With the insert 10 as shown in Figures 3 and 4, the swarf travels initially up the inclined face of the lower protrusion 17 and is then deflected when reaching the curved portion 18 which leads to the upper projection 19. The swarf thus curls over and breaks.

It is to be noted that if a cutting edge which is operative is subjected to a severe shock due, for example, to an irregularity in the item being cut, only the cutting insert 1 carrying that cutting edge will be dislodged from the tool. The remaining inserts will stay in position. The next adjacent cutting edge will thus relatively swiftly be brought into operation. Whilst not wishing to be bound by any theory the applicant believes that some of the brazing material, in this example, a silver alloy, is located between the individual cutting inserts, and forms

a shock absorbing material. The silver alloy is not as hard and unyielding as the tungsten carbide, and if the cutting insert is subjected to a shock it is better able to withstand the shock, due to the relatively small size of the cutting insert, and the shock absorbing brazing material.



-12-

CLAIMS:



1. A cutting insert for use on a mill, the cutting insert comprising an element formed of a hard material, the element defining a rear face, by means of which the element may be mounted in position, and a front face, the front face defining, towards its lower edge, a cutting projection, defining a leading single cutting edge, the front face defining a surface which extends rearwardly and upwardly from the cutting edge.
2. A cutting insert according to Claim 1 wherein the front face is substantially planar, the arrangement being such that when the cutting insert is located in abutment with adjacent cutting inserts, the upper edge of the planar front face is located immediately adjacent a forwardly extending part of the under-surface of the cutting projection of the next adjacent cutting insert.
3. A cutting insert according to Claim 2 wherein the front face of the projection makes an angle of approximately 19° with the plane defined by the rear face of the insert.
4. A cutting insert according to Claim 1 wherein the upper part of the front face of the insert is of arcuate form.
5. A cutting insert according to Claim 4 wherein the upper part of the front face of the cutting insert is of arcuate form with a radius of curvature which gradually shortens.



* C L M S *

-13-

6. A cutting insert according to Claim 5 wherein the front face terminates with a upper forwardly projecting protrusion.
7. A cutting insert according to any one of the preceding Claims wherein the upper face and the lower face of the insert are inclined at an angle of approximately 5° to the perpendicular to the plane defined by the rear face of the cutting insert.
8. A cutting insert according to any one of the preceding Claims wherein the thickness of the insert is approximately 0.22 to 0.187 cms.
9. A cutting insert according to any one of the preceding Claims wherein the depth of the insert is approximately 0.62 to 0.635 cms.
10. A mill, the mill comprising a body carrying a plurality of blades, the blades each carrying a plurality of cutting inserts according to any one of the preceding Claims in a regular array, with the under-face of one insert substantially abutting the upper face of the next adjacent insert.
11. A mill according to Claim 10 wherein the blades are fixed blades which extend radially outwardly from the body.
12. A mill according to Claim 11 wherein the blades are substantially aligned with the axis of the mill.
13. A mill according to Claim 11 wherein the blades exhibit a negative rake relative to the axis of the mill.



* C L H S *

-14-

14. A mill according to Claim 13 wherein the blades exhibit a negative rake of approximately 10^0 relative to the axis of the mill.
15. A mill according to any one of Claims 10 to 14 wherein the cutting elements are brazed to the blades.
16. A cutting insert substantially as herein described with reference to and as shown in Figures 1 and 2 of the accompanying drawings.
17. A cutting insert substantially as herein described with reference to and as shown in Figures 3 and 4 of the accompanying drawings.
18. A mill substantially as herein described with reference to and as shown in Figure 5 of the accompanying drawings.
19. Any novel feature or combination of features disclosed herein.



-15-

ABSTRACT**"IMPROVEMENTS IN OR RELATING TO A MILLING INSERT AND A MILLING TOOL"**

A cutting insert is described for use on a milling tool. The cutting insert comprises an element formed of hard material, such as carbide. The element defines a rear face, by means of which it may be mounted in position, and a front face. The front face defines, towards its lower edge, a cutting projection defining a single leading cutting edge. The front face defines a surface, which may be a curved surface, which extends rearwardly and upwardly from the cutting edge.

FIG 1

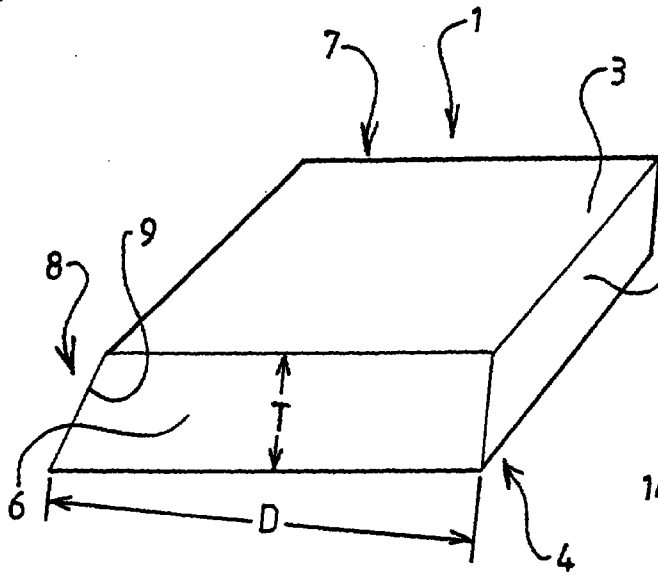


FIG 3

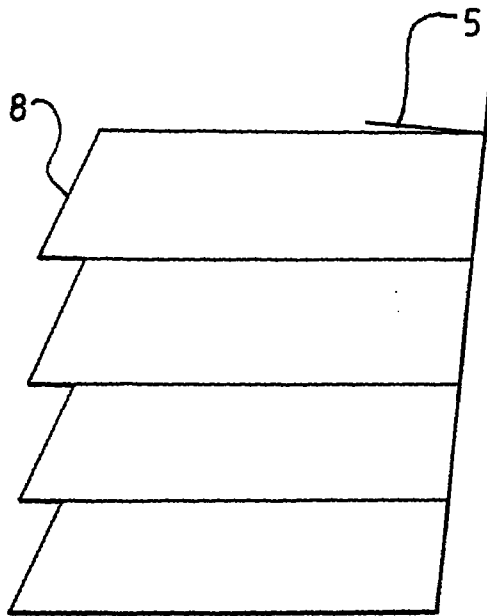
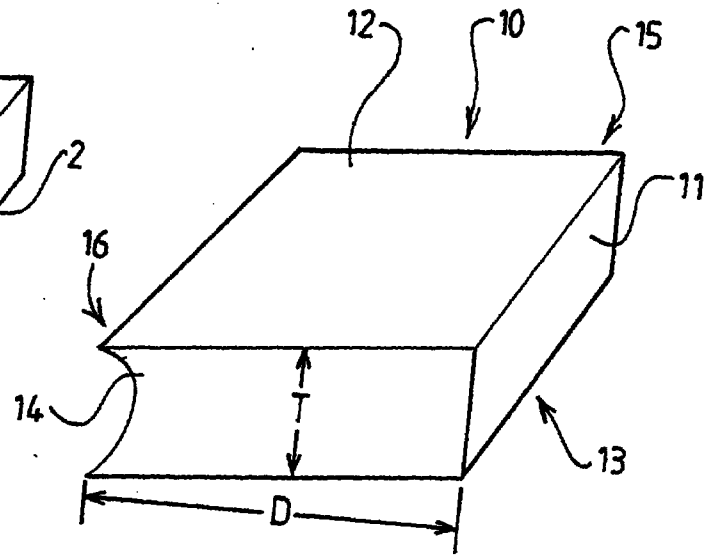


FIG 2

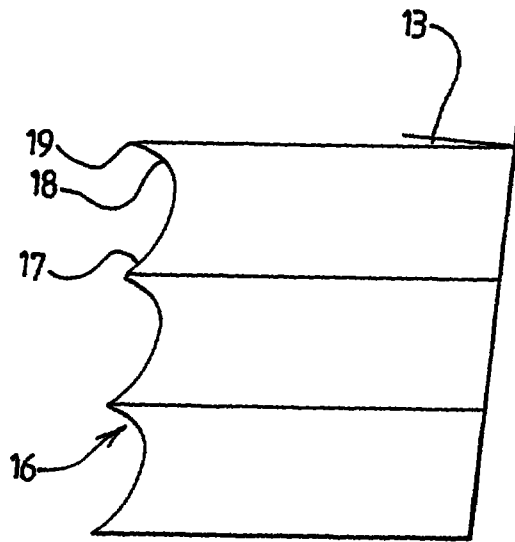


FIG 4

2 / 2

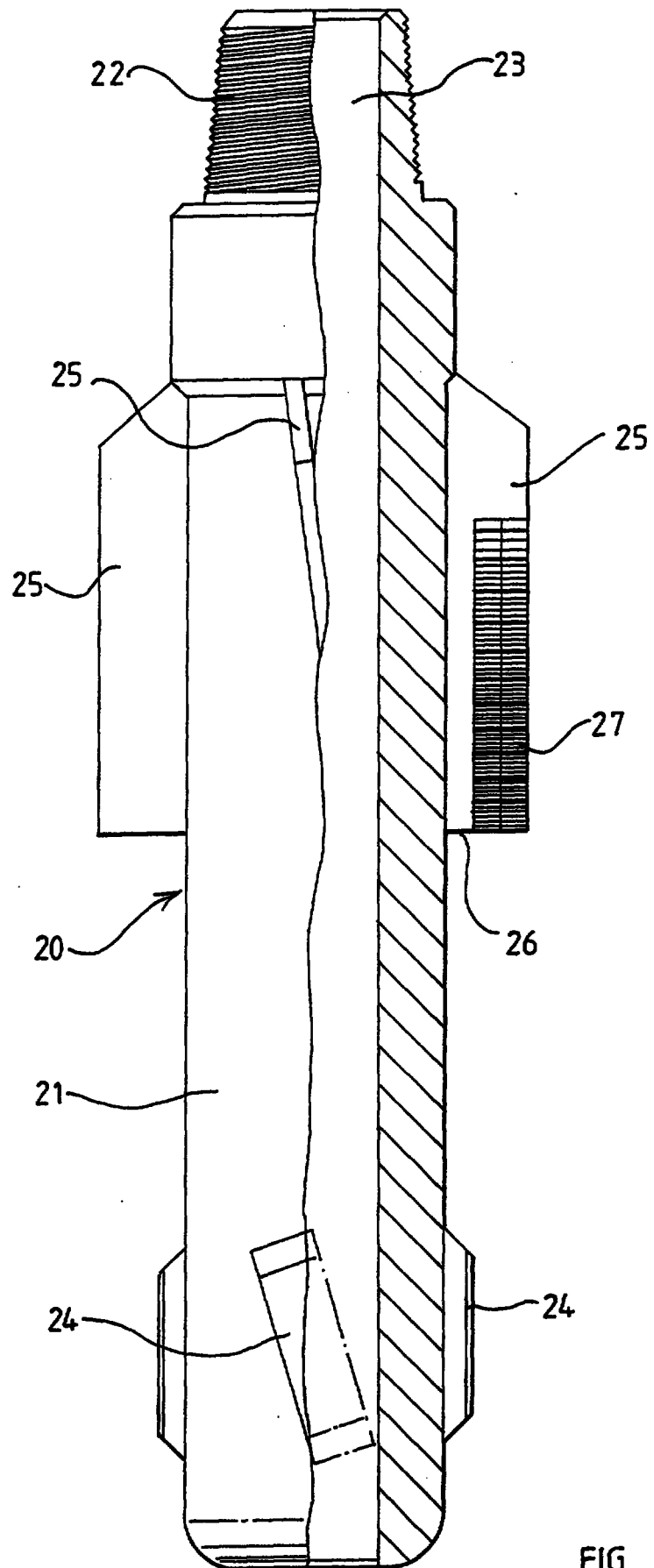


FIG 5

-15-

This Sheet Has Been Replaced



ABSTRACT

"IMPROVEMENTS IN OR RELATING TO A MILLING INSERT AND A MILLING TOOL"

A cutting insert is described for use on a milling tool. The cutting insert comprises an element formed of hard material, such as carbide. The element defines a rear face, by means of which it may be mounted in position, and a front face. The front face defines, towards its lower edge, a cutting projection defining a single leading cutting edge. The front face defines a surface, which may be a curved surface, which extends rearwardly and upwardly from the cutting edge.

Figure 1 of the drawings is to accompany the abstract when published.

ABSTRACT

"IMPROVEMENTS IN OR RELATING TO A MILLING INSERT AND A MILLING TOOL"

A cutting insert (1) is described for use on a milling tool (20). The cutting insert comprises an element formed of hard material, such as carbide. The element defines a rear face (2), by means of which it may be mounted in position, and a front face (8). The front face (8) defines, towards its lower edge, a cutting projection defining a single leading cutting edge. The front face (8) defines a surface, which may be a curved surface, which extends rearwardly and upwardly from the cutting edge. The milling tool (20) comprises a body carrying a plurality of blades (25), the blades (25) each carrying a plurality of cutting inserts (1) in a regular array (27), with the under-face of one insert substantially abutting the upper face of the next adjacent insert.

Figure 1 of the drawings is to accompany the abstract when published.



-3-

The present invention seeks to provide an improved cutting insert and a mill incorporating the improved cutting insert.

According to this invention there is provided a cutting insert for use on a mill, the cutting insert comprising an element formed of a hard material, the element defining a rear face, by means of which the element may be mounted in position, and a front face, the front face defining, towards its lower edge, a cutting projection, defining a leading single cutting edge, the front face defining a surface which extends rearwardly and upwardly from the cutting edge, the element defining upper and lower faces, the thickness of the insert between the upper and lower faces being between 0.187 and 0.22 cms.

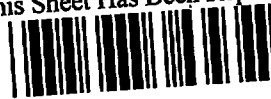
Preferably the front face is substantially planar, the arrangement being such that when the cutting insert is located in abutment with adjacent cutting inserts, the upper edge of the planar front face is located immediately adjacent a forwardly extending part of the under-surface of the cutting projection of the next adjacent cutting insert.

Conveniently the front face of the projection makes an angle of approximately 19° with the plane defined by the rear face of the insert. Alternatively the upper part of the front face of the insert is of arcuate form.

Conveniently the upper part of the front face of the cutting insert is of arcuate form with a radius of curvature which gradually shortens.

Advantageously the front face terminates with a upper forwardly projecting protrusion.

AMENDED SHEET



-4-

Preferably the upper face and the lower face of the insert are inclined at an angle of approximately 5° to the perpendicular to the plane defined by the rear face of the cutting insert.

Advantageously the depth of the insert is approximately 0.62 to 0.635 cms.

The invention also relates to a mill, the mill comprising a body carrying a plurality of blades, the blades each carrying a plurality of cutting inserts as defined above in a regular array, with the under-face of one insert substantially abutting the upper face of the next adjacent insert.

The blades are preferably fixed blades which extend radially outwardly from the body, but the blades may be pivotally mounted blades. The blades may be aligned with the axis of the body or may exhibit a negative rake, typically of approximately 10° relative to the axis of the mill. The cutting inserts may be brazed to the blades.

In order that the invention may be more readily understood, and so that further features thereof may be appreciated, the invention will now be described, by way of example, with reference to the accompanying drawings in which:

FIGURE 1 is a perspective view of one cutting insert in accordance with the invention,

AMENDED SHEET

This Sheet Has Been Replaced



REPLACEMENT SHEET

Date: 19 SEP 1996

-12-

CLAIMS:



1. A cutting insert for use on a mill, the cutting insert comprising an element formed of a hard material, the element defining a rear face, by means of which the element may be mounted in position, and a front face, the front face defining, towards its lower edge, a cutting projection, defining a leading single cutting edge, the front face defining a surface which extends rearwardly and upwardly from the cutting edge, the element defining upper and lower faces, the thickness of the insert between the upper and lower faces being between 0.187 and 0.22 cms.
2. A cutting insert according to Claim 1 wherein the front face is substantially planar, the arrangement being such that when the cutting insert is located in abutment with adjacent cutting inserts, the upper edge of the planar front face is located immediately adjacent a forwardly extending part of the under-surface of the cutting projection of the next adjacent cutting insert.
3. A cutting insert according to Claim 2 wherein the front face of the projection makes an angle of approximately 19° with the plane defined by the rear face of the insert.
4. A cutting insert according to Claim 1 wherein the upper part of the front face of the insert is of arcuate form.
5. A cutting insert according to Claim 4 wherein the upper part of the front face of the cutting insert is of

AMENDED SHEET



-13-

arcuate form with a radius of curvature which gradually shortens.

6. A cutting insert according to Claim 5 wherein the front face terminates with a upper forwardly projecting protrusion.

7. A cutting insert according to any one of the preceding Claims wherein the upper face and the lower face of the insert are inclined at an angle of approximately 5° to the perpendicular to the plane defined by the rear face of the cutting insert.

8. A cutting insert according to any one of the preceding Claims wherein the depth of the insert is approximately 0.62 to 0.635 cms.

9. A mill, the mill comprising a body carrying a plurality of blades, the blades each carrying a plurality of cutting inserts according to any one of the preceding Claims in a regular array, with the under-face of one insert substantially abutting the upper face of the next adjacent insert.

10. A mill according to Claim 9 wherein the blades are fixed blades which extend radially outwardly from the body.

11. A mill according to Claim 10 wherein the blades are substantially aligned with the axis of the mill.

12. A mill according to Claim 10 wherein the blades exhibit a negative rake relative to the axis of the mill.

AMENDED SHEET

PATENTS ACT 1977Agents Ref: P9425SG-NF/er

DESCRIPTION OF INVENTION

"IMPROVEMENTS IN OR RELATING TO A MILL

THE PRESENT INVENTION relates to a mill. In particular, the invention relates to a milling tool of particular use in down-hole operations in the oil and gas-well industry.

Many proposals have been made concerning the provision of different types of "insert" for use on a milling tool. The insert is typically an element made of very hard material, such as tungsten carbide, which is secured to a blade of a milling tool, the insert actually cutting the metal that is to be milled away by the tool.

Very particular requirements exist in connection with cutting inserts intended for use on mills for use "down-hole". Whilst, of course, it is desirable that the mill should operate as swiftly as possible, thus cutting away the maximum amount of metal in minimum time, the swarf (or cuttings) produced by the mill must be such that it can readily be carried out of the hole by the mud that flows through the hole. It is undesirable for the swarf (or cuttings) to be too long, since otherwise the swarf may form "bird's nests", which can give rise to significant difficulties.

AMENDED SHEET

-3-

The present invention seeks to provide an improved mill.

According to this invention there is provided a mill, the mill comprising a body carrying a plurality of substantially radially outwardly extending blades, the leading face of each blade carrying a plurality of cutting inserts in a regular array, each insert comprising an element formed of a hard material, the element defining a rear face which is secured to the blade to mount the element in a position, and a front face, the front face defining, towards its lower edge, a cutting projection which has a leading single cutting edge, the front face defining a surface which extends rearwardly and upwardly from the cutting edge, each insert also defining an under face and an upper face, the under face of one insert substantially abutting the upper face of the next adjacent insert, the upper edge of the front face of the said next adjacent insert being located immediately adjacent the forwardly extending part of the under face of the cutting projection of the said one insert.

Preferably the front face of each cutting insert is substantially planar.

Conveniently the front face of the projection of each cutting insert makes an angle of approximately 19° with the plane defined by the rear face of the insert.

Alternatively the upper part of the front face of each insert is of arcuate form.

Conveniently the upper part of the front face of each cutting insert is of arcuate form with a radius of curvature which gradually shortens.

AMENDED SHEET

-4-

Advantageously the front face of each cutting insert terminates with an upper forwardly projecting protrusion.

Preferably the upper face and the lower face of each insert are inclined at an angle of approximately 5^0 to the perpendicular to the plane defined by the rear face of the cutting insert.

Conveniently the thickness of each insert is approximately 0.22 to 0.187 cms.

Advantageously the depth of each insert is approximately 0.62 to 0.635 cms.

The blades are preferably fixed blades which extend radially outwardly from the body, but the blades may be pivotally mounted blades. The blades may be aligned with the axis of the body or may exhibit a negative rake, typically of approximately 10^0 relative to the axis of the mill. The cutting inserts may be brazed to the blades.

In order that the invention may be more readily understood, and so that further features thereof may be appreciated, the invention will now be described, by way of example, with reference to the accompanying drawings in which:

FIGURE 1 is a perspective view of one cutting insert for use on a mill in accordance with the invention,

FIGURE 2 is a side view of a plurality of cutting inserts of Figure 1 when located adjacent each other,

AMENDED SHEET

-5-

FIGURE 3 is a perspective view of an alternative form of cutting insert in accordance with the invention,

FIGURE 4 is a side view showing a plurality of cutting inserts of the type shown in Figure 3 located adjacent one another, and

FIGURE 5 is a side view, with parts cut away, of a mill provided with cutting inserts of the type shown in Figures 1 and 2.

Referring initially to Figures 1 and 2 of the drawings, one embodiment is a cutting insert for use in a mill in accordance with the invention comprises an element 1 made of a very hard material such as, for example, tungsten carbide. The insert may be made in a conventional way, but the insert is made to have a novel shape and configuration as will now be described.

The insert comprises a substantially cuboidal block of hard material. The rear face 2 of the block, which is a vertical face in the orientation illustrated, is substantially planar and is used, as will be described hereinafter, for mounting the block in position. The top face 3 and the under-face 4 of the block are parallel with each other but are not perpendicular to the plane defined by the rear face 2 of the block. The top face 3 and the under-face 4 are downwardly inclined from a perpendicular to the rear face at an angle 5 (see Figure 2) which is approximately 5° .

AMENDED SHEET

-12-



CLAIMS:

1. A mill, the mill comprising a body carrying a plurality of substantially radially outwardly extending blades, the leading face of each blade carrying a plurality of cutting inserts in a regular array, each insert comprising an element formed of a hard material, the element defining a rear face which is secured to the blade to mount the element in position, and a front face, the front face defining, towards its lower edge, a cutting projection which has a leading single cutting edge, the front face defining a surface which extends rearwardly and upwardly from the cutting edge, each insert also defining an under face and an upper face, the under face of each one insert substantially abutting the upper face of the next adjacent insert, the upper edge of the front face of the said next adjacent insert being located immediately adjacent the forwardly extending part of the under face of the cutting projection of the said insert.
2. A mill according to Claim 1, wherein the front face of each cutting insert is substantially planar.
3. A mill according to Claim 2, wherein the front face of the projection of each cutting insert makes an angle of approximately 19° with the plane defined by the rear face of the insert.
4. A mill according to Claim 1, wherein the upper part of the front face of each insert is of arcuate form.
5. A mill according to Claim 4, wherein the upper part of the front face of each cutting insert is of arcuate form with a radius of curvature which gradually shortens.

AMENDED SHEET



-13-

6. A mill according to Claim 5, wherein the front face of each cutting insert terminates with an upper forwardly projecting protrusion.

7. A mill according to any one of the preceding Claims wherein the upper face and the lower face of each insert is inclined at an angle of approximately 5^0 to the perpendicular to the plane defined by the rear face of the cutting insert.

8. A mill according to any one of the preceding Claims, wherein the thickness of each insert is approximately 0.22 to 0.187 cms.

9. A mill according to any one of the preceding Claims wherein the depth of each insert is approximately 0.62 to 0.635 cms.

10. A mill according to any one of the preceding claims wherein the blades are substantially aligned with the axis of the mill.

11. A mill according to any one of Claims 1 to 9, wherein the blades exhibit a negative rake relative to the axis of the mill.

12. A mill according to Claim 11 wherein the blades exhibit a negative rake of approximately 10^0 relative to the axis of the mill.

13. A mill according to any one of the preceding claims wherein the cutting inserts are brazed to the blades.

AMENDED SHEET

Date : 25 NOV 1996



-14-

14. A mill containing cutting inserts substantially as herein described with reference to and as shown in Figures 1 and 2 of the accompanying drawings.

15. A mill containing cutting inserts substantially as herein described with reference to and as shown in Figures 3 and 4 of the accompanying drawings.

16. A mill substantially as herein described with reference to and as shown in Figure 5 of the accompanying drawings.

17. Any novel feature or combination of features disclosed herein.

AMENDED SHEET