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**Long et al.**

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(45) **Date of Patent:** **Nov. 2, 2021**

(54) **GOLF CLUB HEAD AND METHOD OF MANUFACTURE**

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Sep. 20, 2019, now Pat. No. 11,004,046, which is a  
(Continued)

(51) **Int. Cl.**

**G06Q 20/00** (2012.01)  
**G06Q 20/18** (2012.01)

(Continued)

(52) **U.S. Cl.**

CPC ..... **G06Q 20/18** (2013.01); **A63B 53/04**  
(2013.01); **A63B 53/047** (2013.01); **A63B**  
**53/0475** (2013.01); **A63B 60/42** (2015.10);  
**A63B 71/0619** (2013.01); **G01B 5/0023**  
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(58) **Field of Classification Search**

CPC .... G06Q 20/00; G06Q 20/18; A63B 71/0619;  
A63B 53/047; A63B 53/0475; A63B  
53/0433; A63B 53/0437; A63B 53/0445;  
A63B 53/0408; A63B 53/005;

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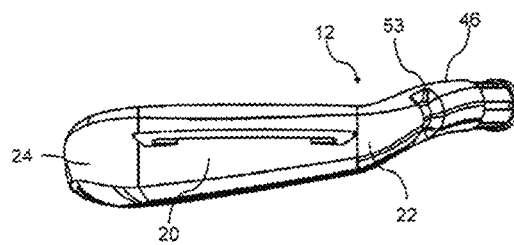
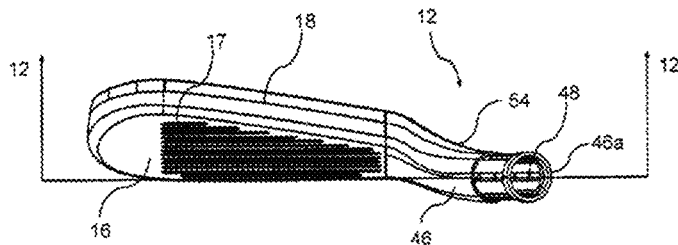
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David J. Dawsey

(57) **ABSTRACT**

An iron-type golf club and a method of creating the iron-type golf club including the steps of forming a club head blank having an external sacrificial region with an ESR thickness, an ESR sole portion, an ESR face portion, and an ESR leading edge portion. A finished club head is formed having a finished club head weight of less than 310 grams by machining off an ESR removed mass from at least a portion of the external sacrificial region including at least a portion of the ESR sole portion, a portion of the ESR face portion, and a portion of the ESR leading edge portion.

**20 Claims, 22 Drawing Sheets**



**Related U.S. Application Data**

- continuation of application No. 15/681,678, filed on Aug. 21, 2017, now Pat. No. 10,423,945.
- (60) Provisional application No. 62/441,276, filed on Dec. 31, 2016.
- (51) **Int. Cl.**  
*G01B 5/00* (2006.01)  
*A63B 53/04* (2015.01)  
*A63B 60/42* (2015.01)  
*A63B 71/06* (2006.01)  
*A63B 102/32* (2015.01)  
*A63B 53/00* (2015.01)
- (52) **U.S. Cl.**  
 CPC ..... *A63B 53/0408* (2020.08); *A63B 53/0433* (2020.08); *A63B 53/0437* (2020.08); *A63B 53/0445* (2020.08); *A63B 2053/0491* (2013.01); *A63B 2102/32* (2015.10); *A63B 2225/20* (2013.01)
- (58) **Field of Classification Search**  
 CPC . *A63B 60/00*; *A63B 60/42*; *A63B 2053/0491*; *A63B 2102/32*; *A63B 2225/20*  
 See application file for complete search history.

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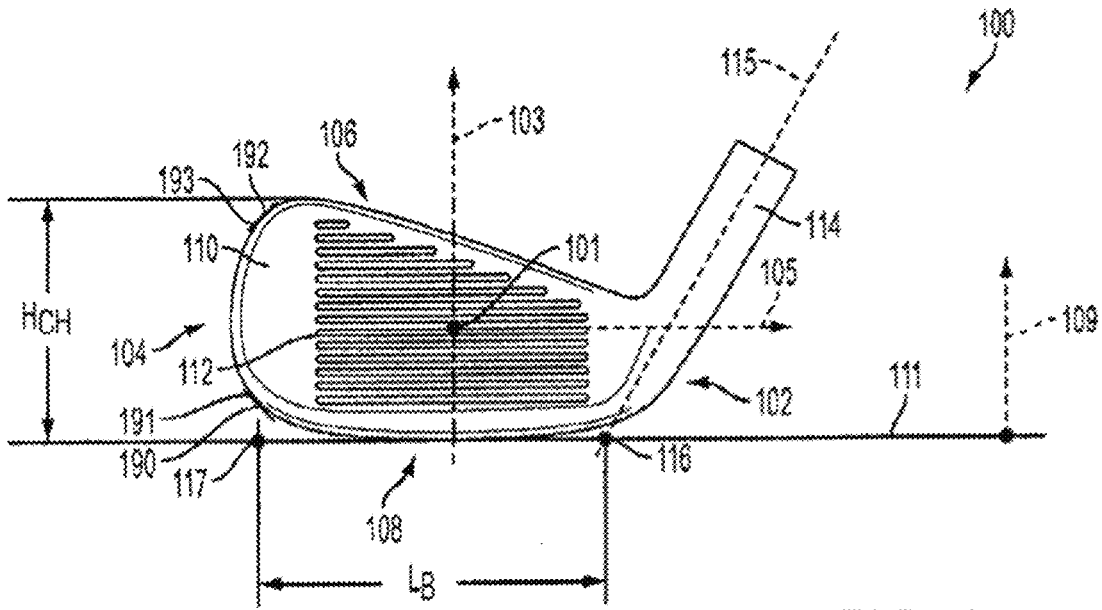


FIG. 1

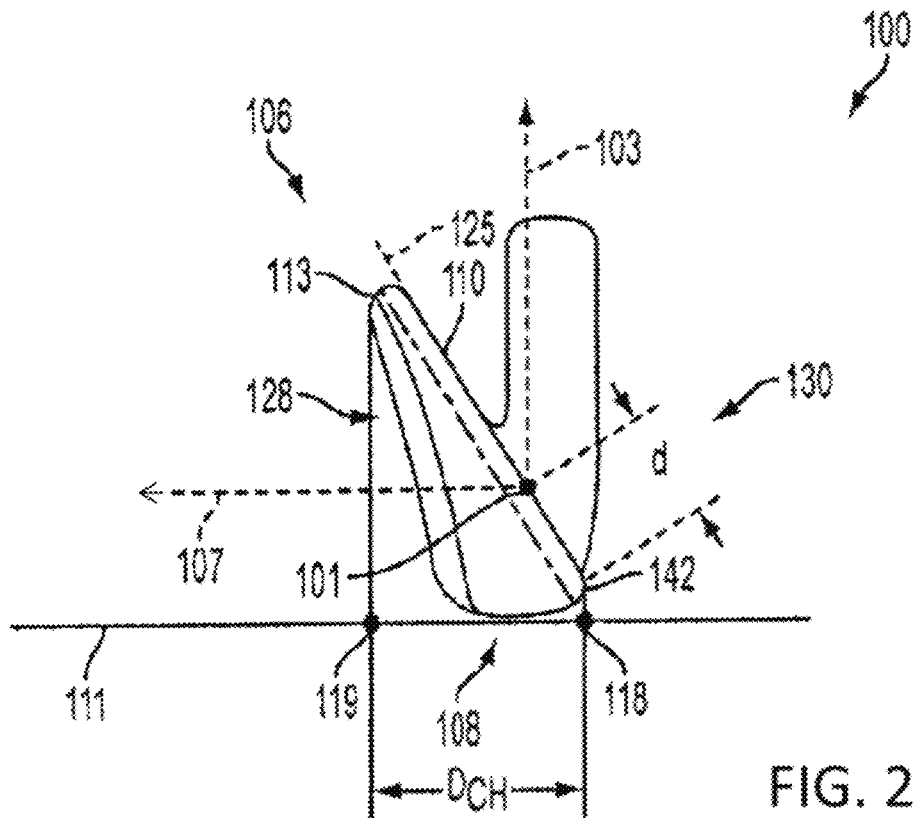
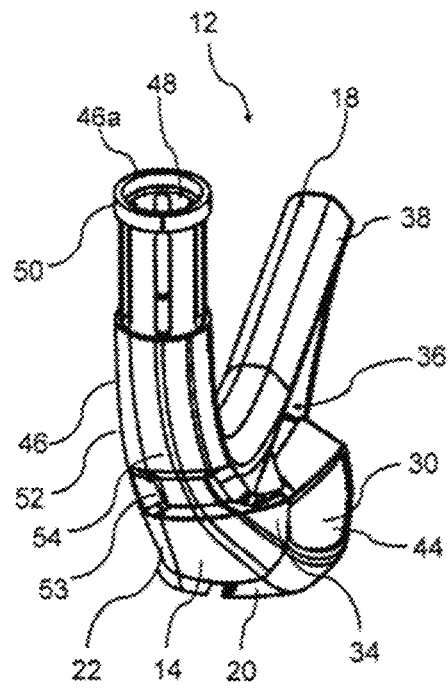
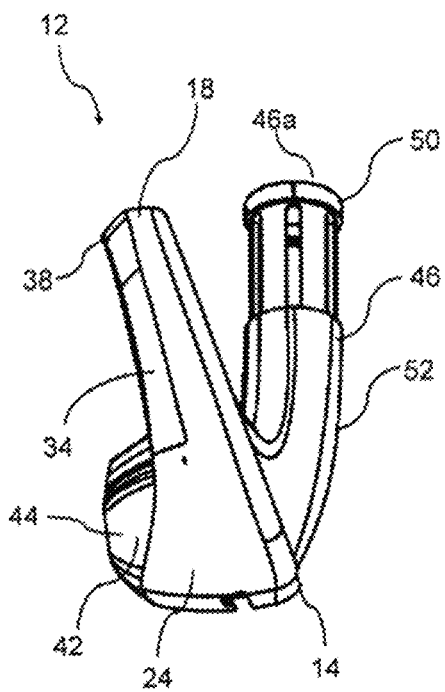
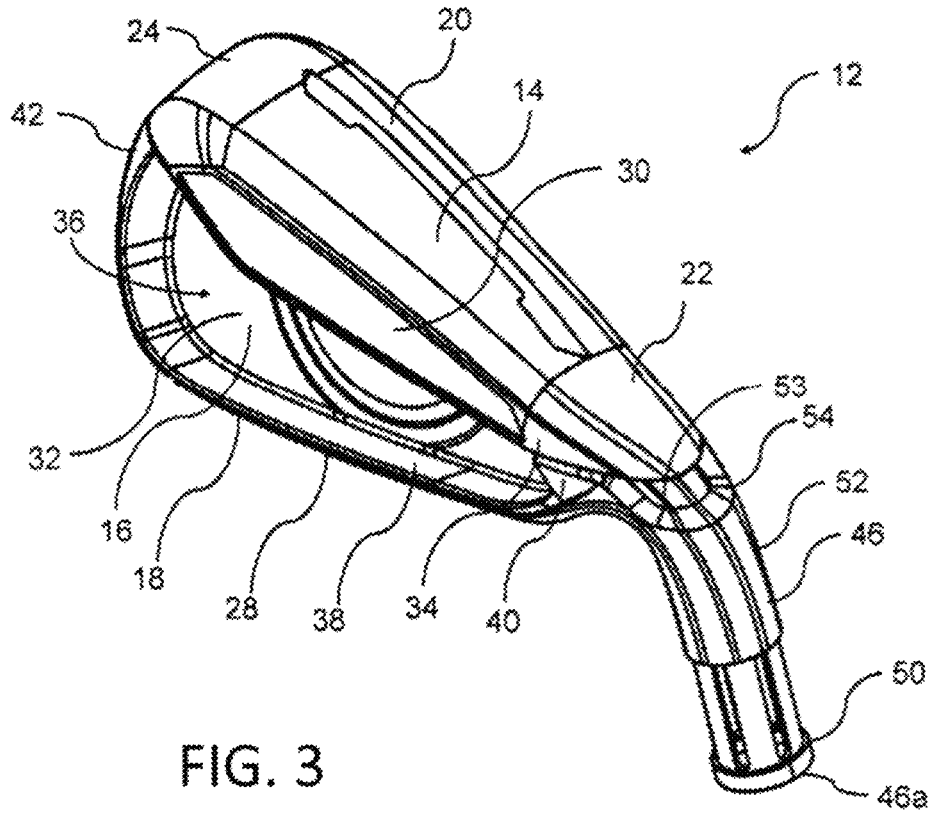


FIG. 2







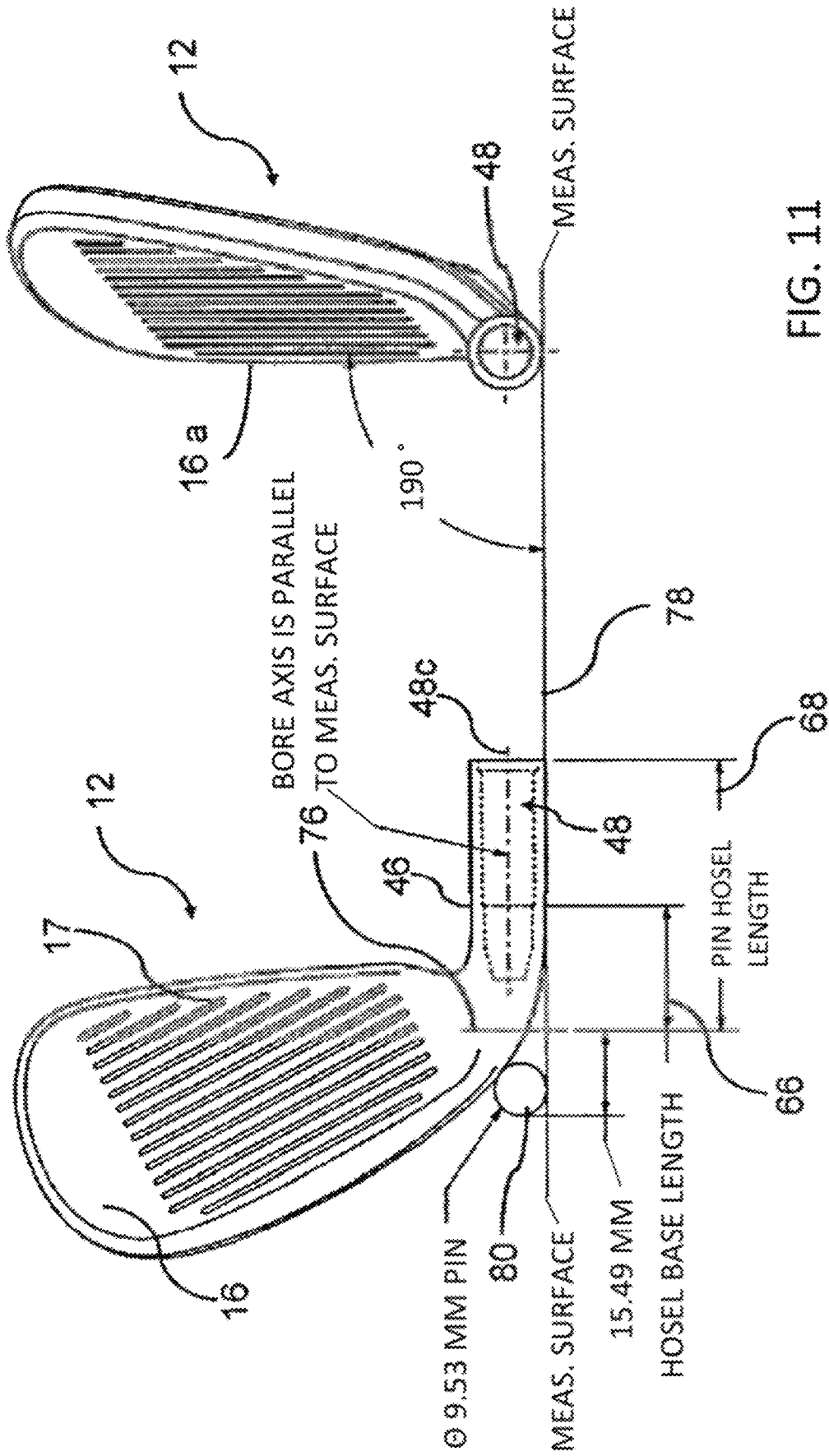


FIG. 11

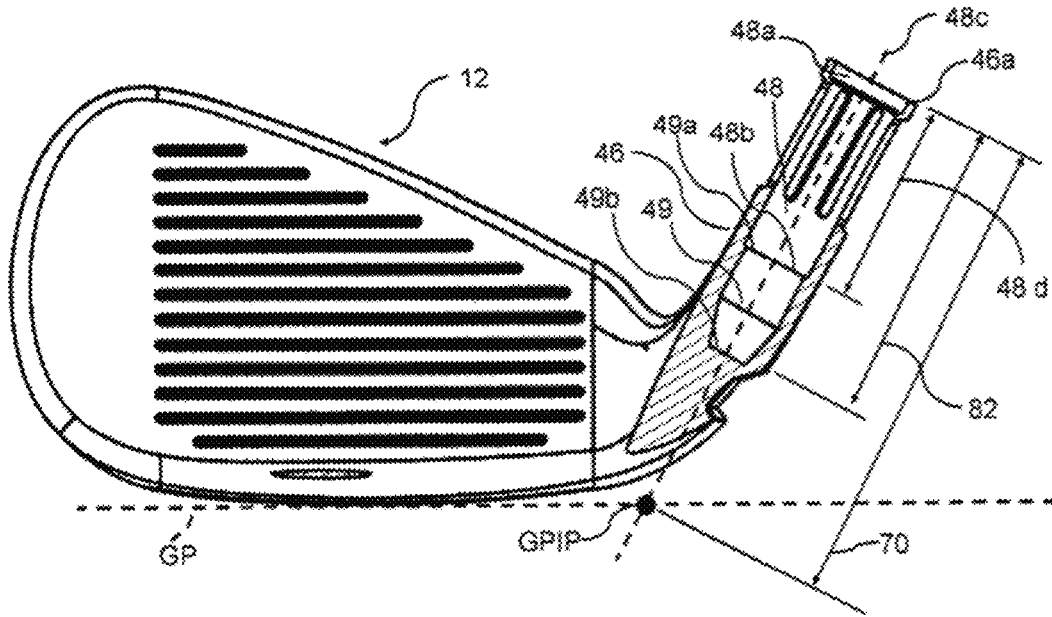


FIG. 12

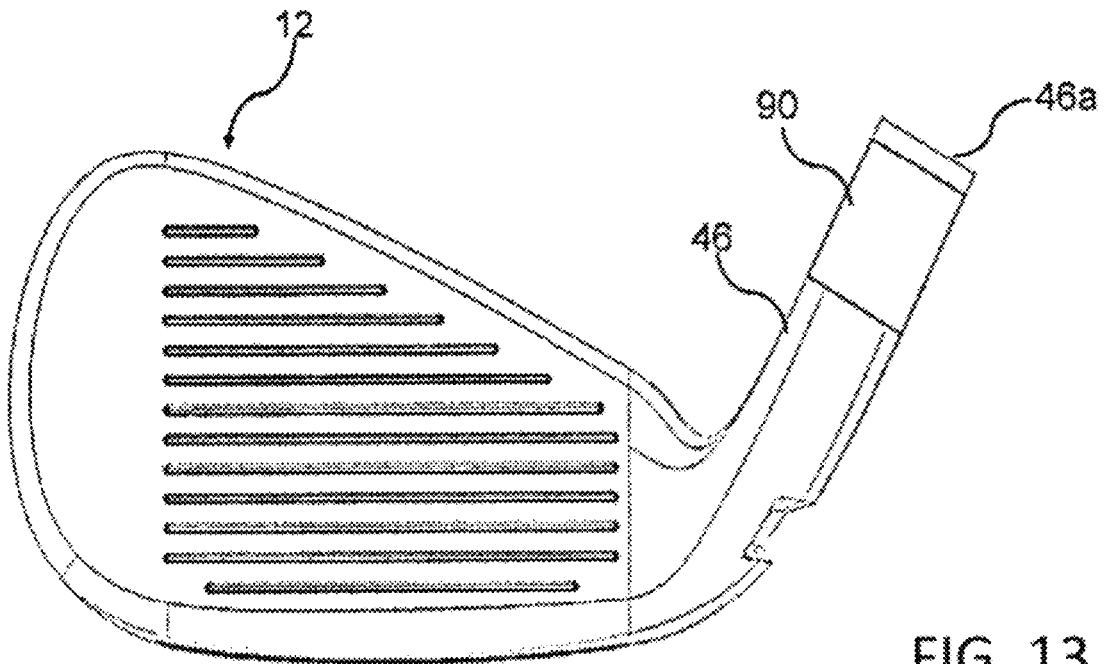


FIG. 13



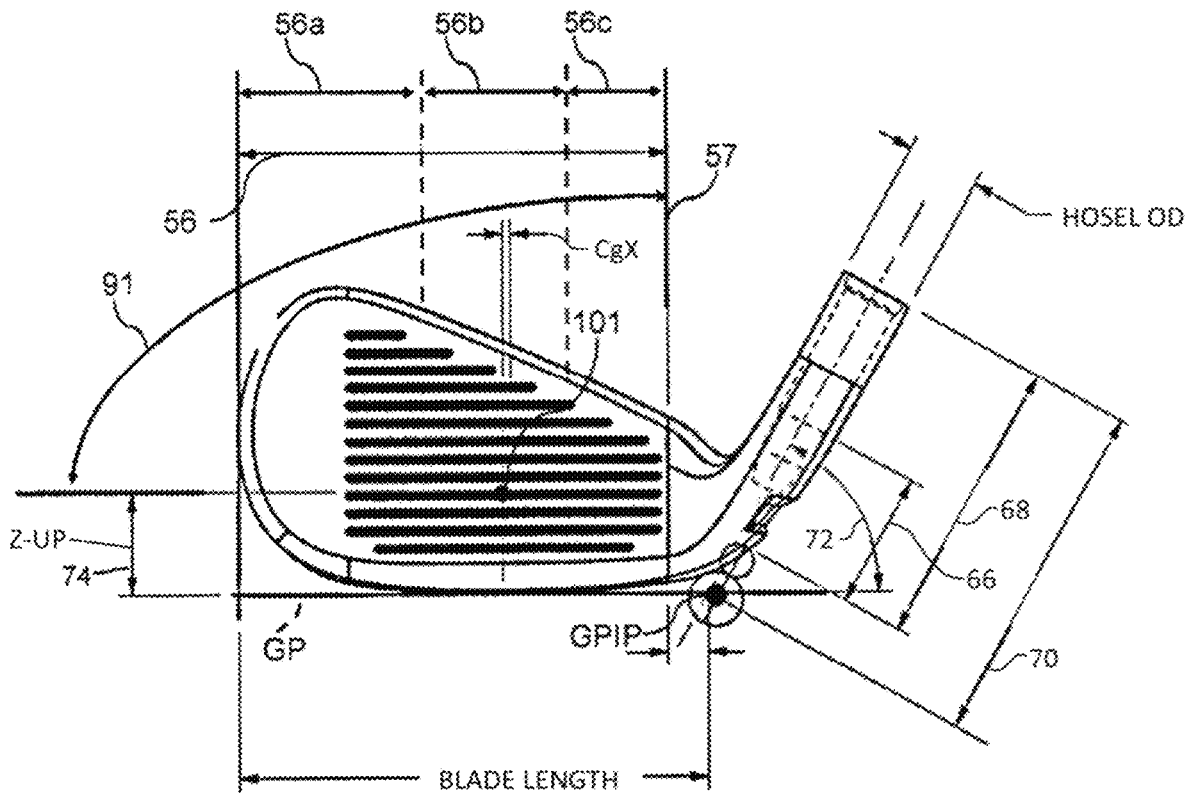
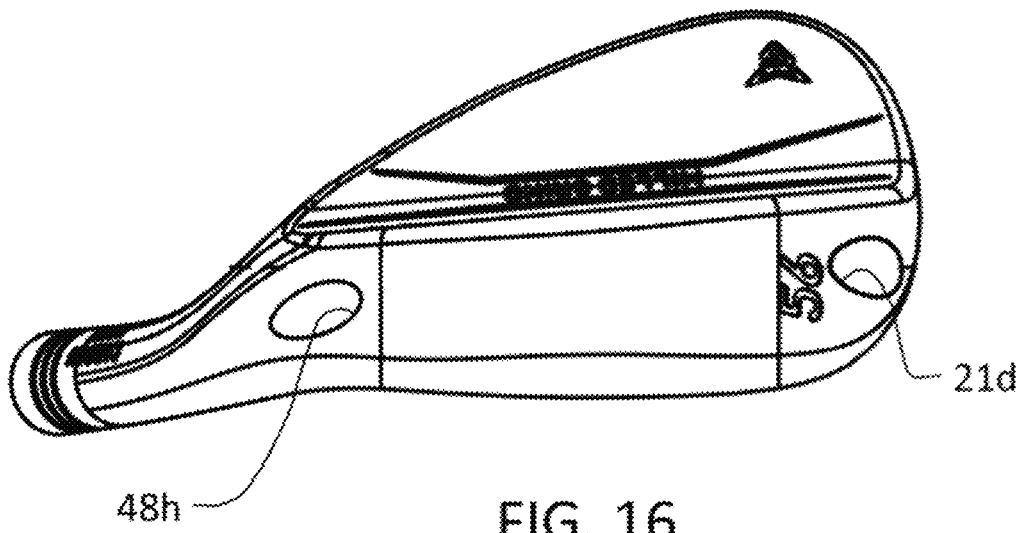
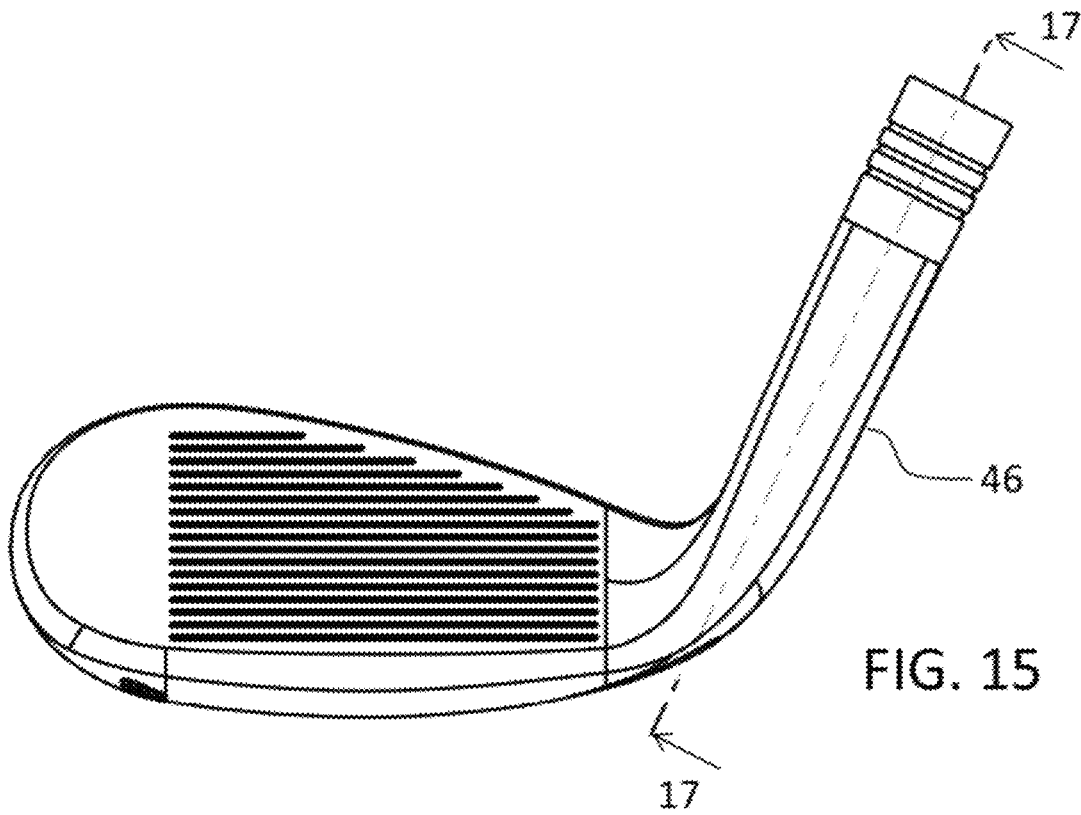
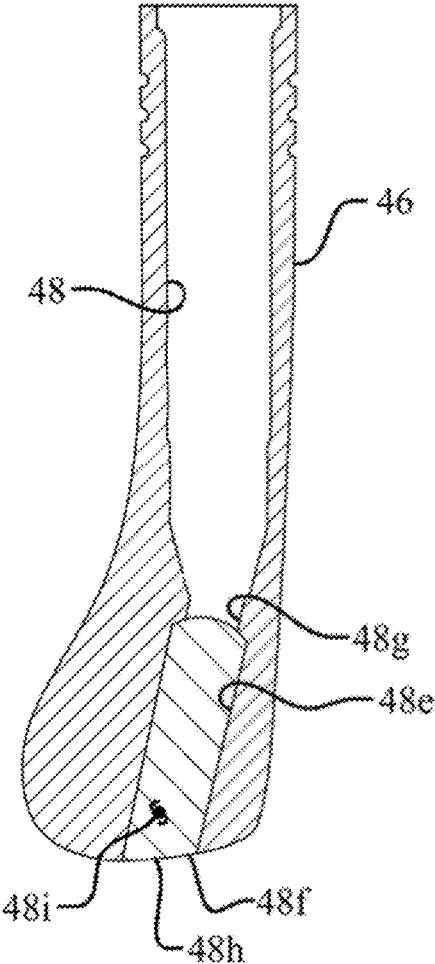
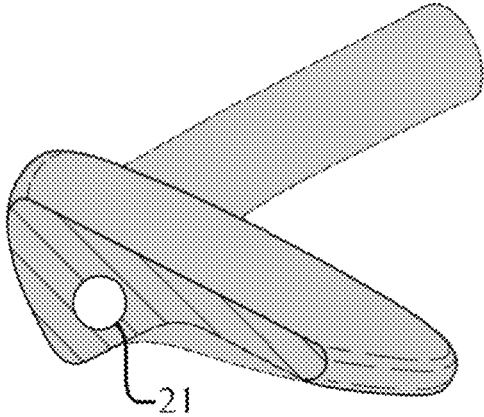


FIG. 14

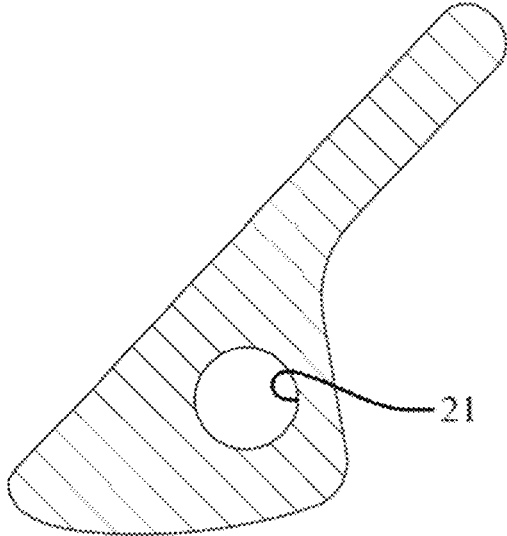




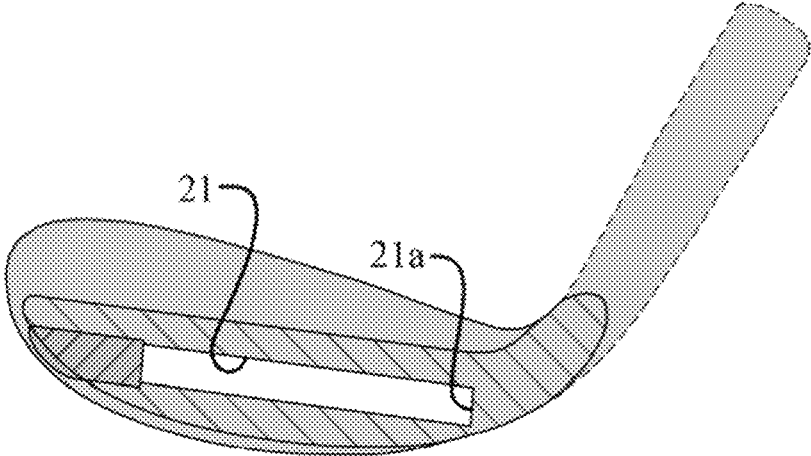
*Fig. 17*



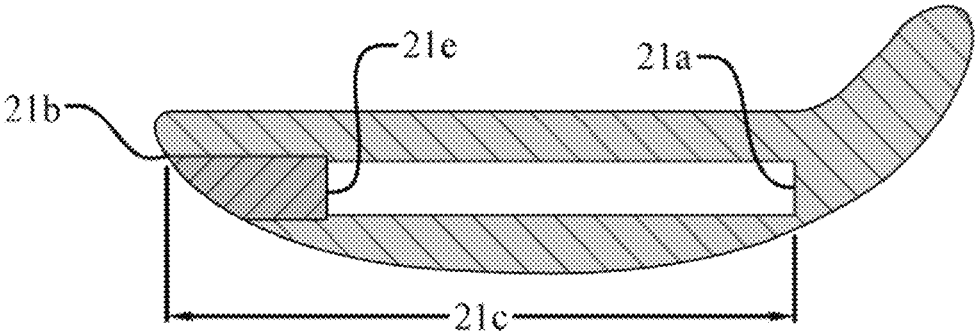
*Fig. 18*



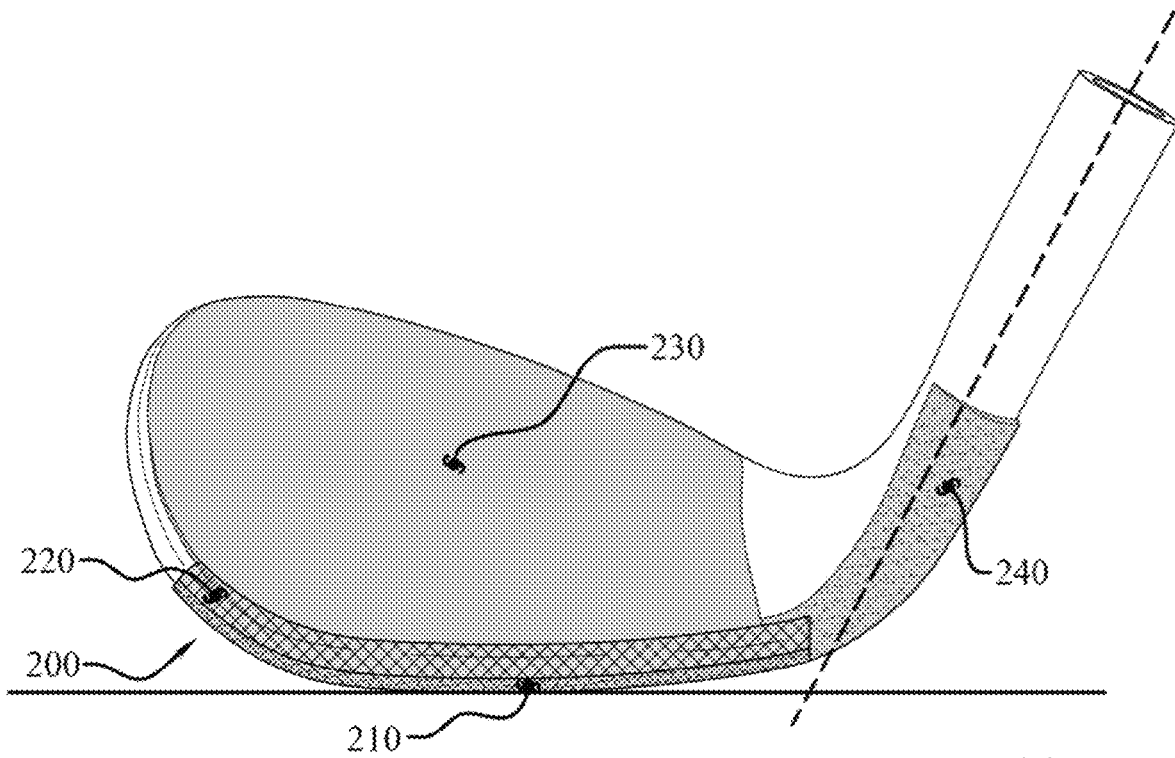
*Fig. 19*



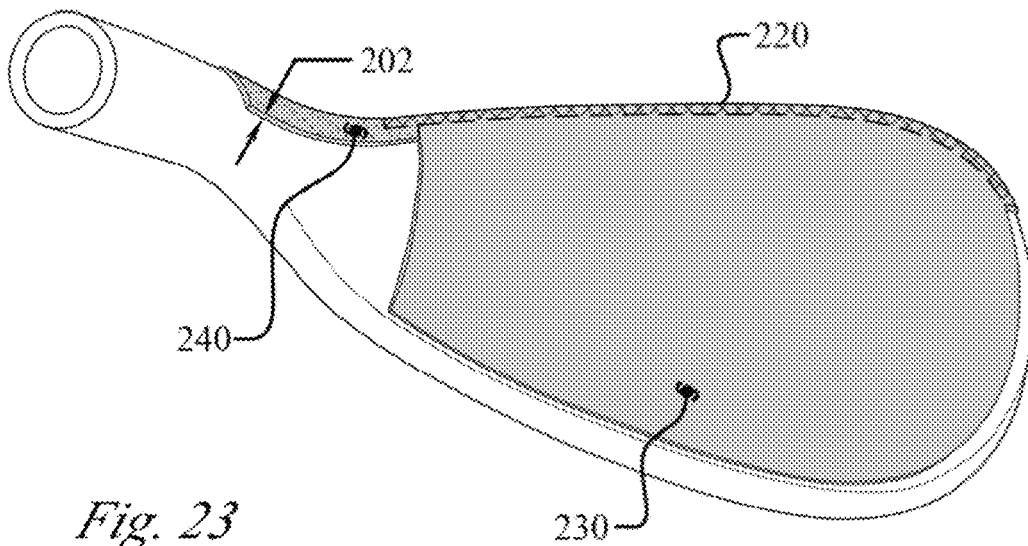
*Fig. 20*



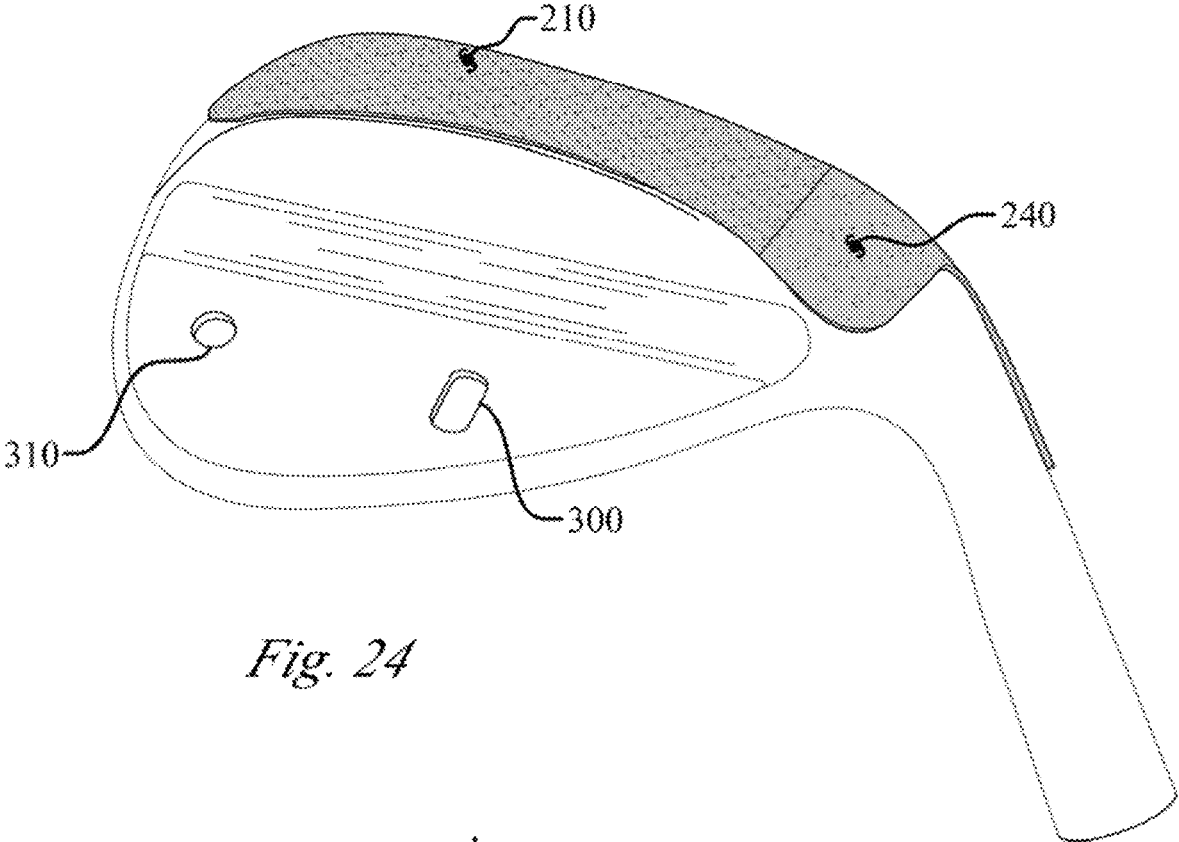
*Fig. 21*



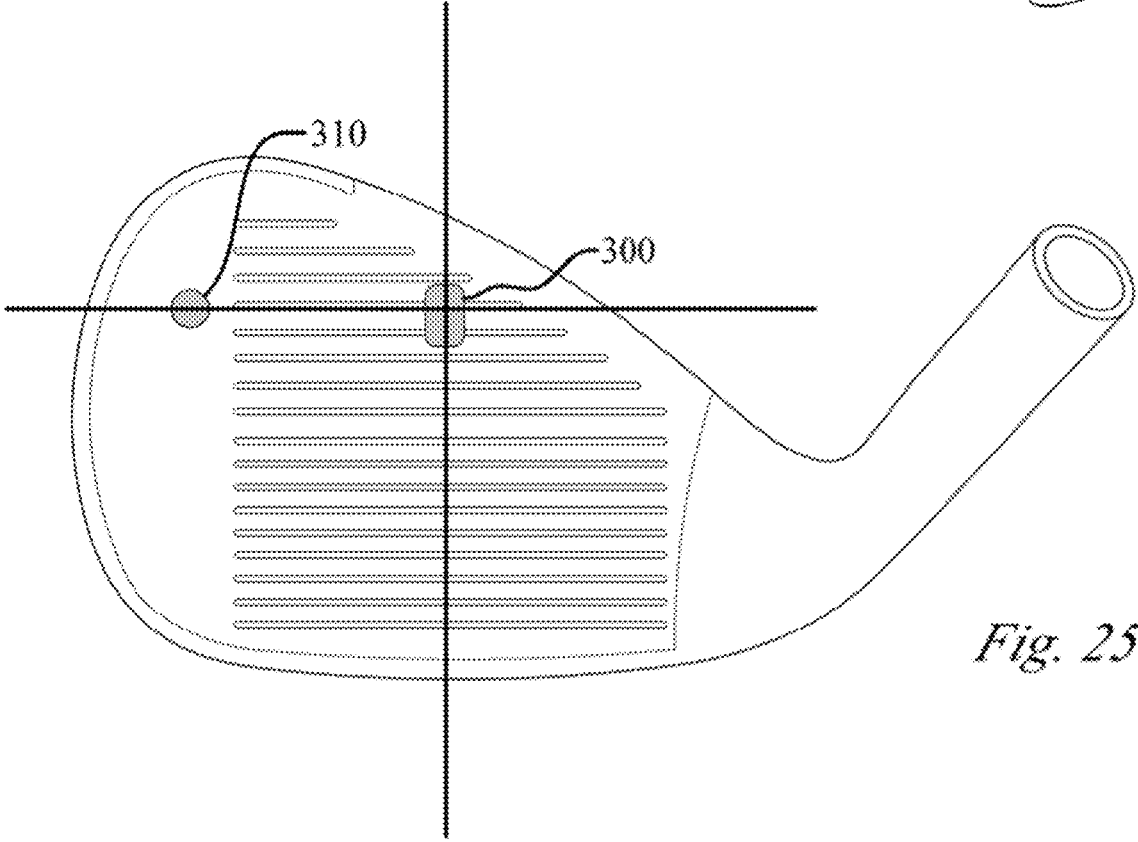
*Fig. 22*



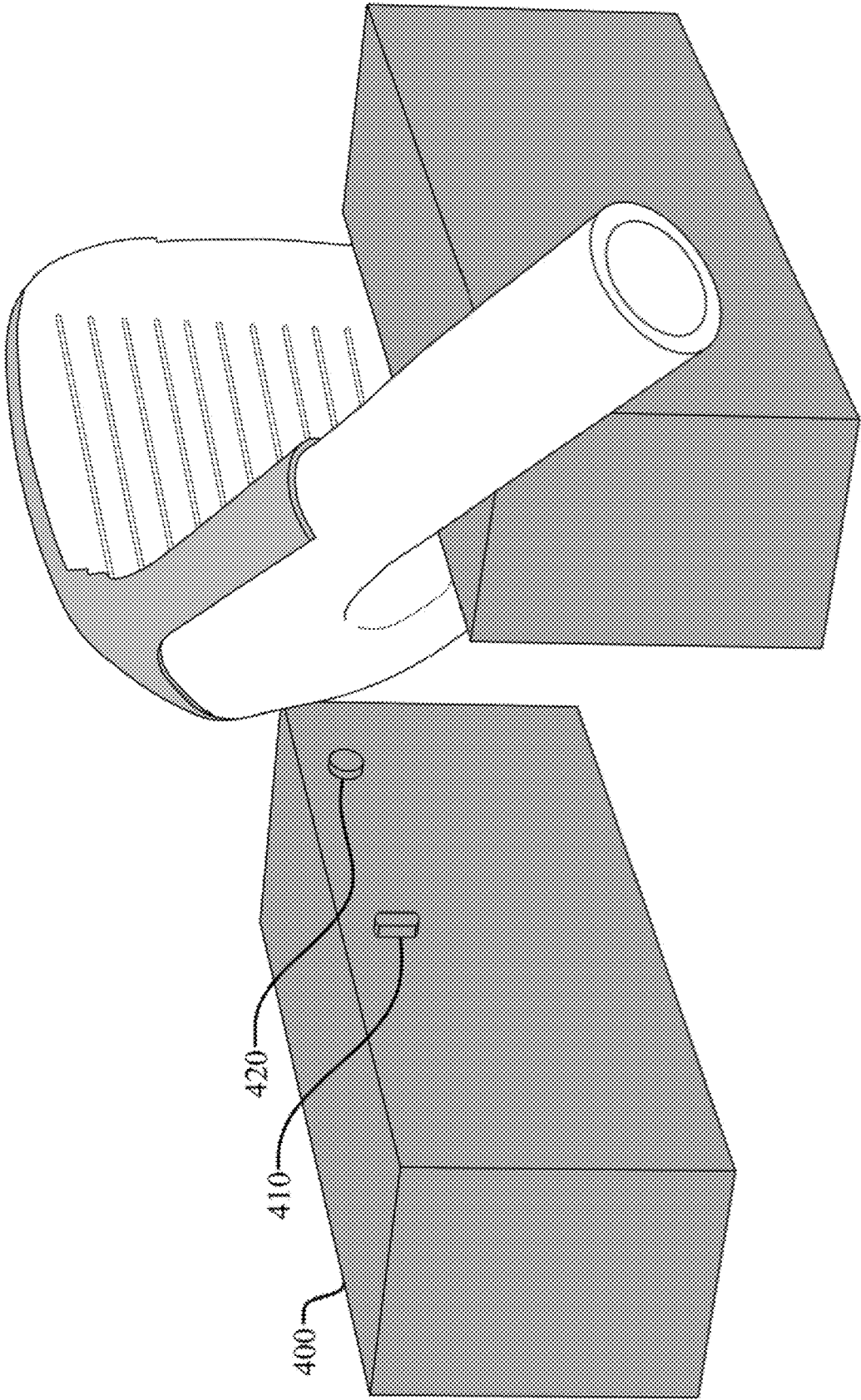
*Fig. 23*



*Fig. 24*



*Fig. 25*



*Fig. 26*



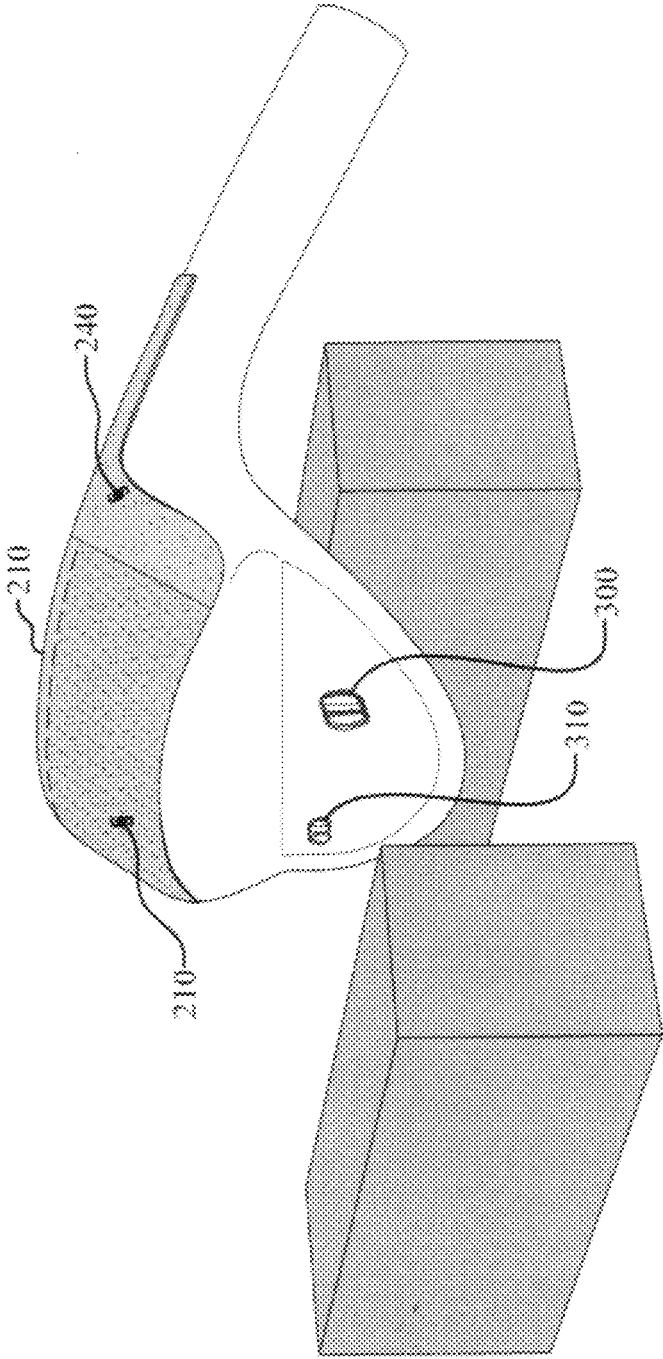


Fig. 27

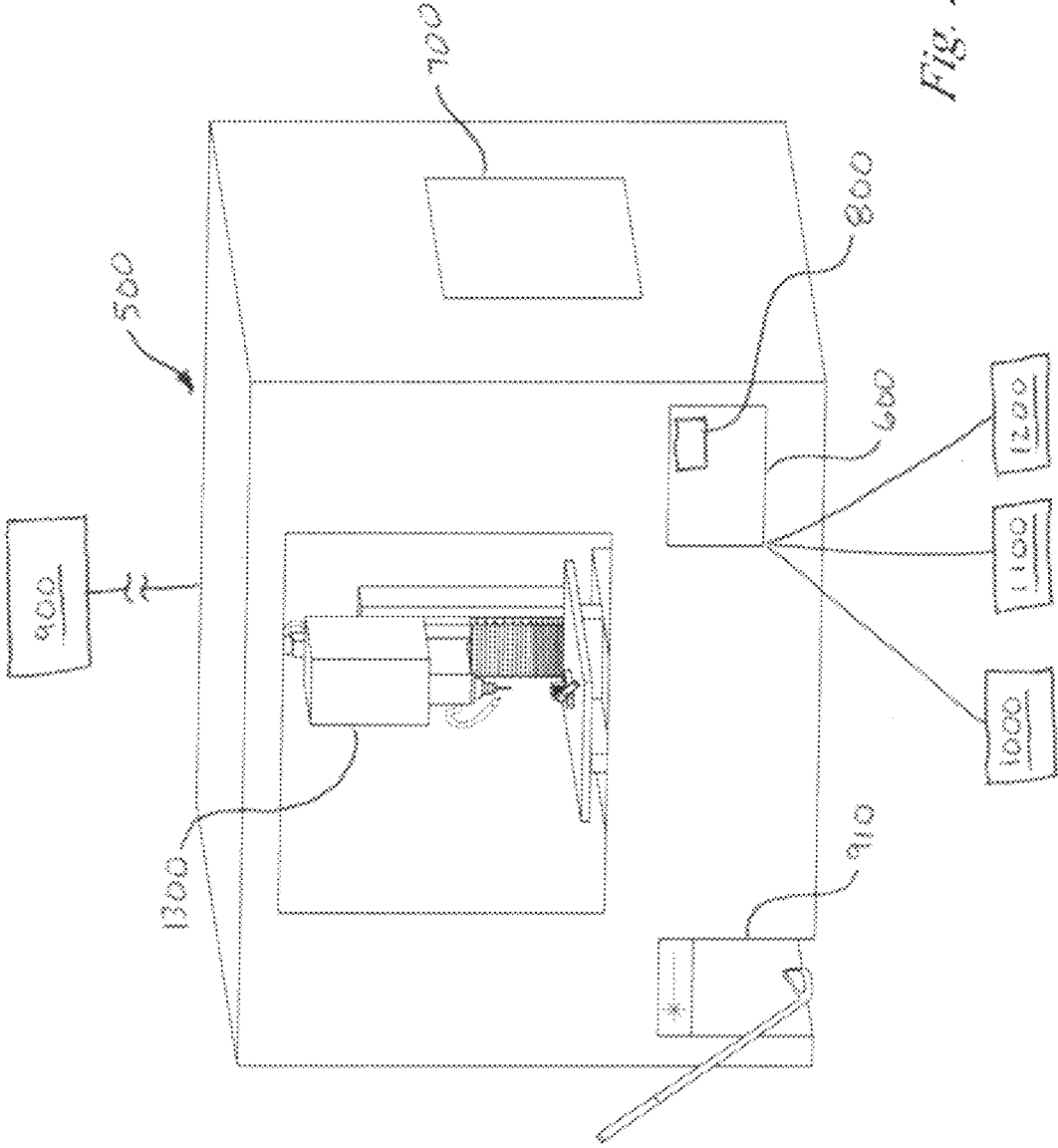


Fig. 28

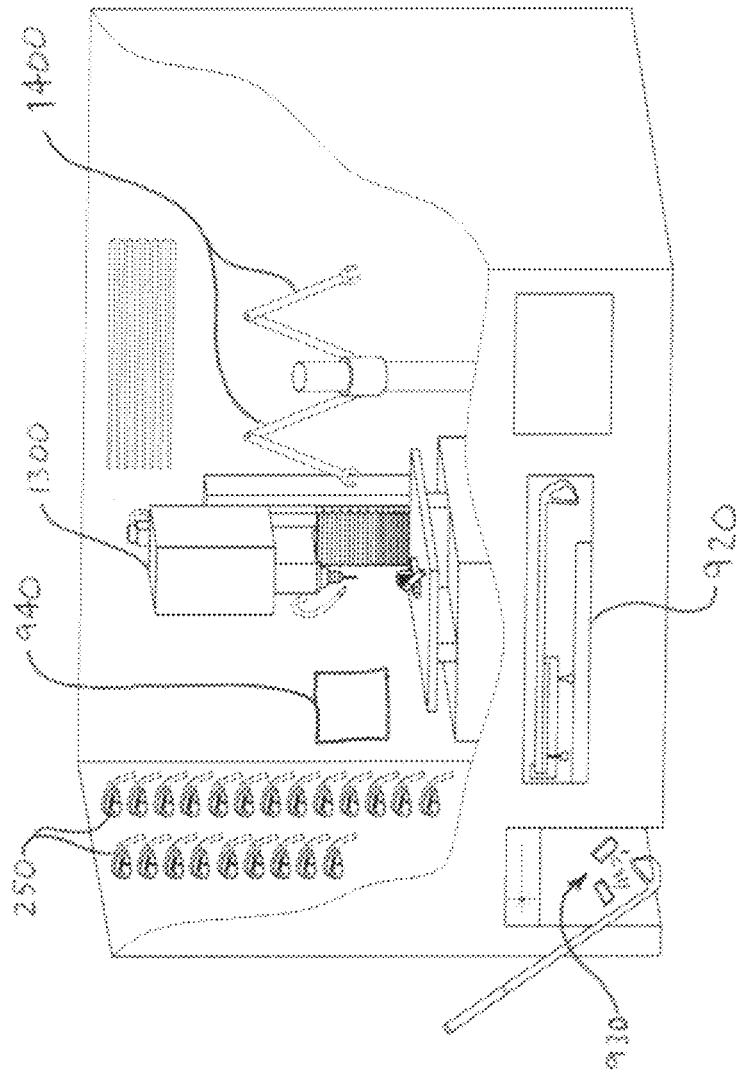
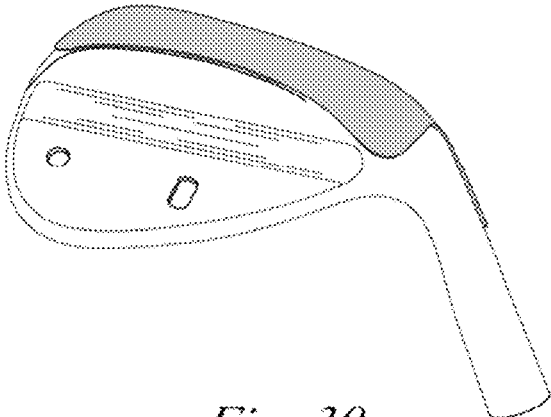
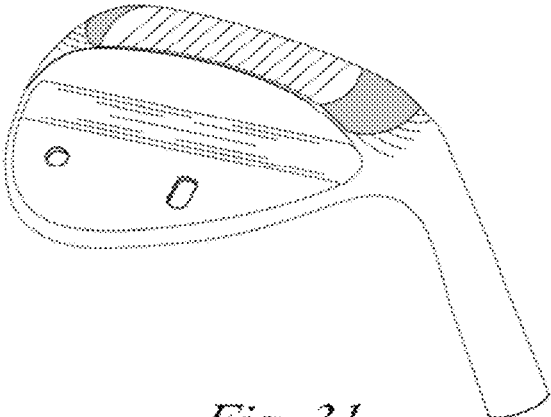


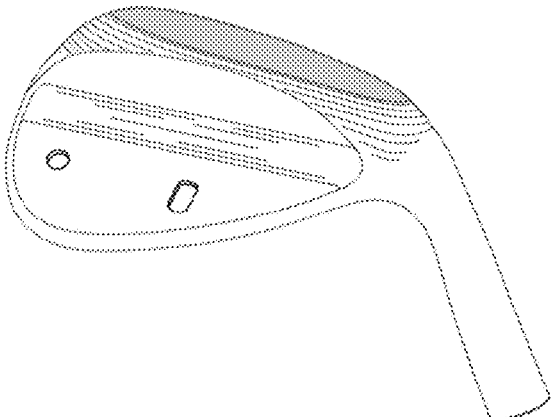
Fig. 29



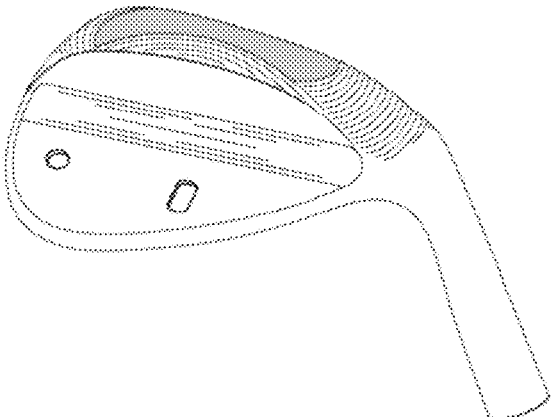
*Fig. 30*



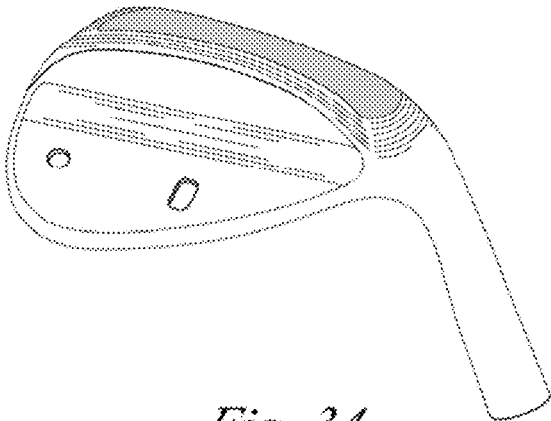
*Fig. 31*



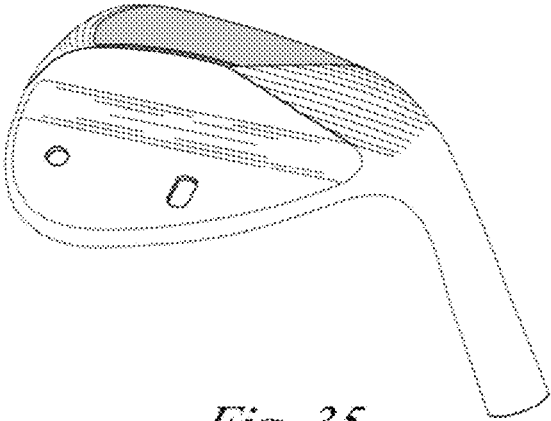
*Fig. 32*



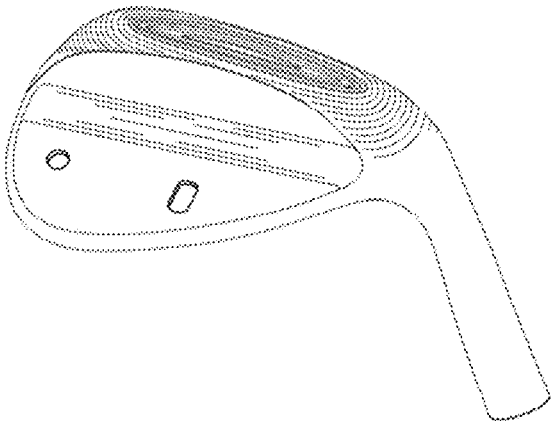
*Fig. 33*



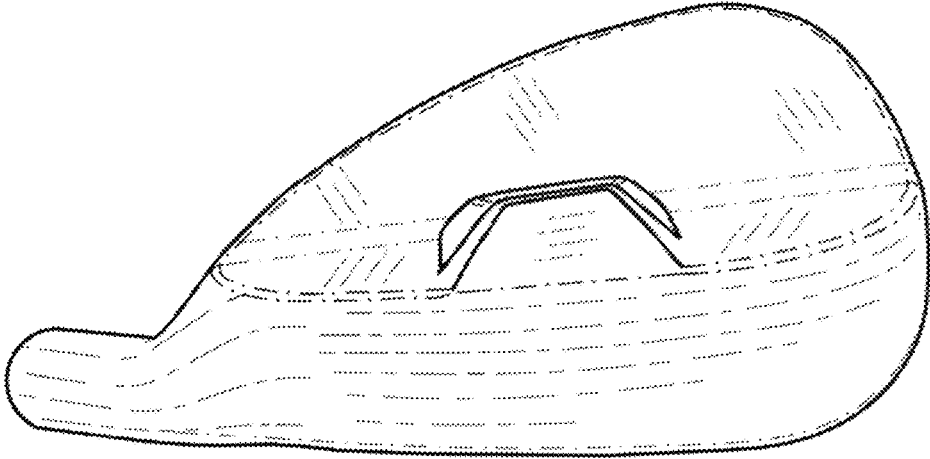
*Fig. 34*



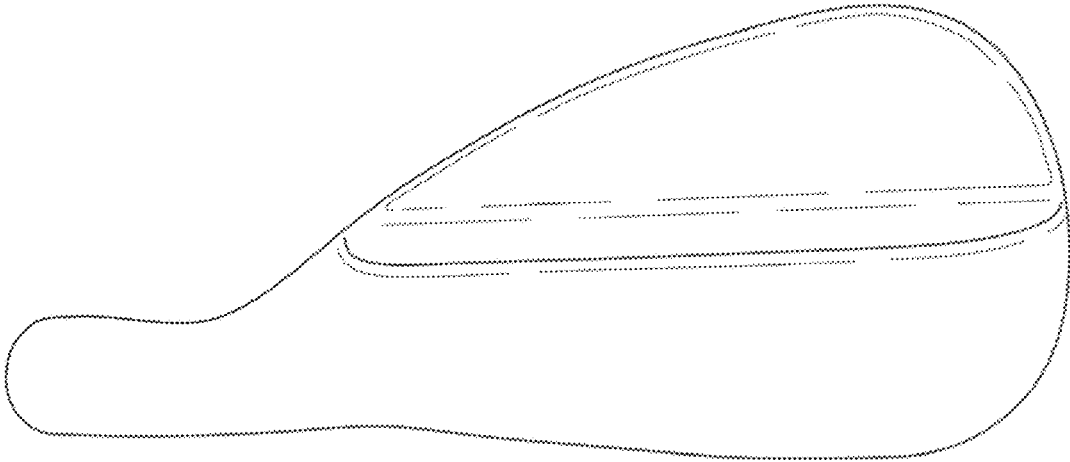
*Fig. 35*



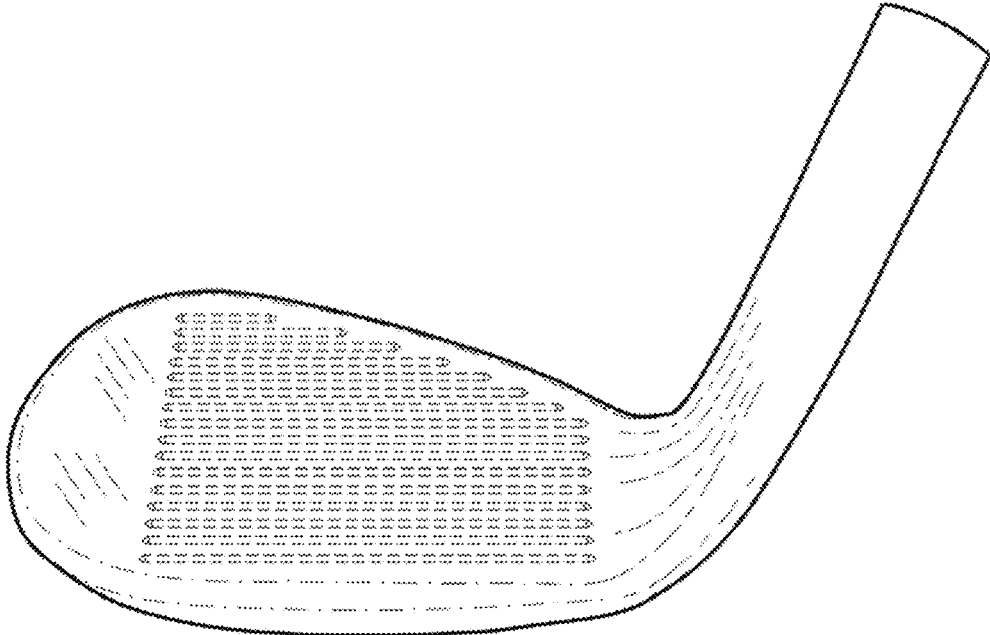
*Fig. 36*



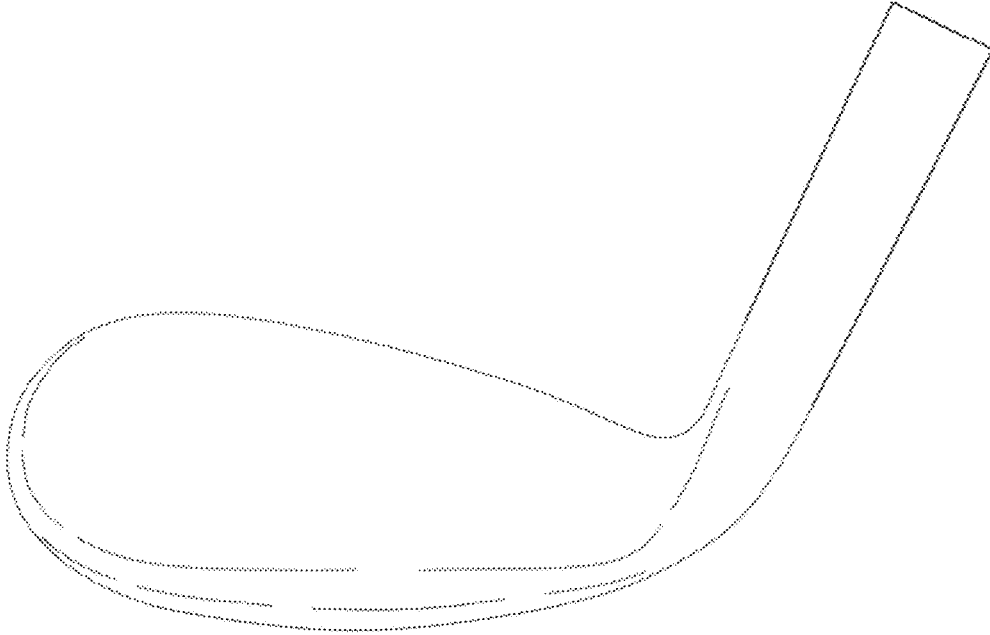
*Fig. 37a*



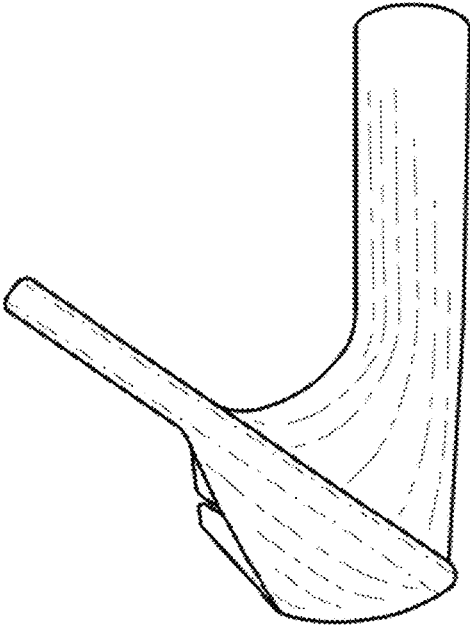
*Fig. 37b*



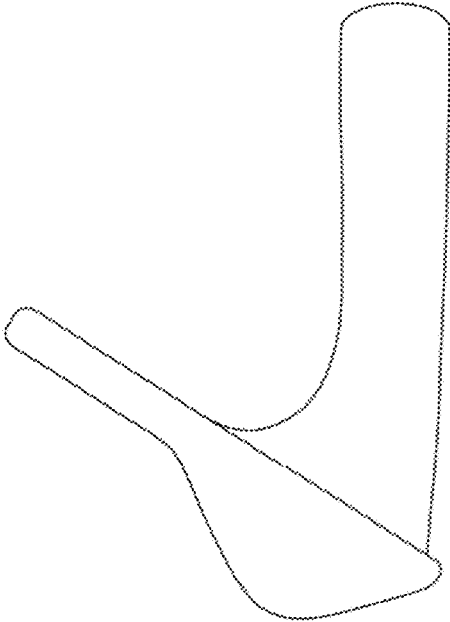
*Fig. 38a*



*Fig. 38b*



*Fig. 39a*



*Fig. 39b*



**GOLF CLUB HEAD AND METHOD OF  
MANUFACTURE****CROSS-REFERENCE TO RELATED  
APPLICATIONS**

This application is a continuation of U.S. nonprovisional application Ser. No. 16/577,233, filed on Sep. 20, 2019, which is a continuation of U.S. nonprovisional application Ser. No. 15/681,678, filed on Aug. 21, 2017, now U.S. Pat. No. 10,423,945, which claims the benefit of U.S. provisional patent application Ser. No. 62/441,276, filed on Dec. 31, 2016, all of which are incorporated by reference as if completely written herein. Related applications concerning golf clubs include U.S. patent application Ser. Nos. 14/981,330, 14/843,856, 62/098,707, 62/099,012, 14/719,054, 14/701,962, 14/538,614, 14/632,947, 13/842,545, 14/226,899, 15/012,880, 15/002,471, 15/334,790, 14/330,205, 14/878,131, 14/868,446, 14/658,267, 14/873,477, 14/226,899, 13/842,545, 15/141,893, which are incorporated by reference herein in their entirety.

**FIELD**

The present application is directed to embodiments of golf clubs, golf club heads, and methods of manufacturing golf club heads and golf clubs.

**BACKGROUND**

The performance of golf equipment is continuously advancing due to the development of innovative clubs and club designs. While all clubs in a golfer's bag are important, both scratch and novice golfers rely on the performance and feel of their irons for many commonly encountered playing situations.

Irons are generally configured in a set that includes clubs of varying loft, with shaft lengths and clubhead weights selected to maintain an approximately constant "swing weight" so that the golfer perceives a common "feel" or "balance" in swinging both the low irons and high irons in a set. The size of an iron's "sweet spot" is generally related to the size (i.e., surface area) of the iron's striking face, and iron sets are available with oversize club heads to provide a large sweet spot that is desirable to many golfers.

Conventional "blade" type irons have been largely displaced (especially for novice golfers) by so-called "perimeter weighted" irons, which include "cavity-back" and "hollow" iron designs. Cavity-back irons have a cavity directly behind the striking plate, which permits club head mass to be distributed about the perimeter of the striking plate, and such clubs tend to be more forgiving to off-center hits. Hollow irons have features similar to cavity-back irons, but the cavity is enclosed by a rear wall to form a hollow region behind the striking plate. Perimeter weighted, cavity back, and hollow iron designs permit club designers to redistribute club head mass to achieve intended playing characteristics associated with, for example, placement of club head center of gravity or a moment of inertia.

In addition, even with perimeter weighting, significant portions of the club head mass, such as the mass associated with the hosel, topline, or striking plate, are unavailable for redistribution. The striking plate must withstand repeated strikes both on the driving range and on the course, requiring significant strength for durability.

Golf club manufacturers are consistently attempting to design golf clubs that are easier to hit and offer golfers

greater forgiveness when the ball is not struck directly upon the sweet spot of the striking face. As those skilled in the art will certainly appreciate, many designs have been developed and proposed for assisting golfers in learning and mastering the very difficult game of golf.

With regard to iron type club heads, cavity back club heads have been developed. Cavity back golf clubs shift the weight of the club head toward the outer perimeter of the club. By shifting the weight in this manner, the center of gravity of the club head is pushed toward the sole of the club head, thereby providing a club head that is easier to use in striking a golf ball. In addition, weight is shifted to the toe and heel of the club head, which helps to expand the sweet spot and assist the golfer when a ball is struck slightly off center.

Shifting weight to the sole lowers the center of gravity (CG) of the club resulting in a club that launches the ball more easily and with greater backspin. Golf club designers may measure the vertical CG of the golf club relative to the ground when the golf club is soled and in the proper address position, this CG measurement will be referred to as Zup or Z-up or CG Z-up. Decreasing Z-up as opposed to increasing it is preferable. Golf club designers can use a golf club with a low Z-up to design clubs for both low and high handicap golfers by either making a golf club that maintains similar launch angles but increases ball speed and distance or a club that launches the ball more easily in the air. Higher handicap golfers typically have trouble launching the ball in the air so a club that gets the ball in the air more easily is a great benefit. For lower handicap golfers, launching the ball in the air is not typically an issue. For lower handicap golfers, golf club designers may strengthen the loft of the golf club to maintain similar launch conditions and similar amounts of backspin, but resulting in greater ball speed and distance gains of several yards. The result is better golfers may now use one less club when approaching a green, such as, for example, a golfer may now use a 7-iron instead of a 6-iron to hit a green. Placing weight at the toe increases the moment of inertia (MOI) of the golf club resulting in a club that resists twisting and is thereby easier to hit straight even on mishits.

As club manufacturers have learned to assist golfers by shifting the center of gravity toward the sole of the club head, a wide variety of designs have been developed. Unfortunately, many of these designs substantially alter the appearance of the club head while attempting to shift the center of gravity toward the sole and perimeter of the club head. For example, one method of lowering the CG is to simply decrease the face height at the toe and make it closer in height to the face height at the heel of the club resulting in a very untraditional looking club. This is highly undesirable as golfers become familiar with a certain style of club head and alteration of that style often adversely affects their mental outlook when standing above a ball and aligning the club head with the ball. As such, a need exists for an improved club head which achieves the goal of shifting the center of gravity further toward the sole and perimeter of the club head without substantially altering the appearance of a traditional cavity back club head with which golfers have become comfortable. The present invention provides such a club head.

Unfortunately, an additional problem arises from relocating mass on a golf club in that the acoustical properties of the golf club head is often negatively impacted. The acoustical properties of golf club heads, e.g., the sound a golf club head generates upon impact with a golf ball, affect the overall feel of a golf club by providing instant auditory

feedback to the user of the club. For example, the auditory feedback can affect the feel of the club by providing an indication as to how well the golf ball was struck by the club, thereby promoting user confidence in the club and himself.

The sound generated by a golf club is based on the rate, or frequency, at which the golf club head vibrates and the duration of the vibration upon impact with the golf ball. Generally, for iron-type golf clubs, a desired first mode frequency is generally around 3,000 Hz and preferably greater than 3,200 Hz. A frequency less than 3,000 Hz may result in negative auditory feedback and thus a golf club with an undesirable feel. Additionally, the duration of the first mode frequency is important because a longer duration results in a ringing sound and/or feel, which feels like a mishit or a shot that is not solid. This results in less confidence for the golfer even on well struck shots. Generally, for iron-type golf clubs, a desired first mode frequency duration is generally less than 10 ms and preferably less than 7 ms.

Accordingly, it would be desirable to reduce the topline weight to shift the CG to the sole and/or toe while maintaining acceptable vibration frequencies and durations. Such a club would be easier to hit because it would launch the ball more easily (low CG) and/or hit the ball straighter even on mishits (increased MOI), and the club would still provide desirable feel through positive auditory feedback. Accordingly, there exists a need for iron-type golf club heads with a strong and lightweight topline.

Golf clubs are typically manufactured with standard lie and loft angles. Some golfers prefer to modify the lie and loft angles of their golf clubs in order to improve the performance and consistency of their golf clubs and thereby improve their own performance.

In some cases, golf club heads, particularly iron-type golf club heads, can be adjusted by being plastically bent in a post-manufacturing process. In such a bending process, it can be difficult to plastically bend the material of the club head in a desired manner without adversely affecting the shape or integrity of the hosel bore, the striking face, or other parts of the club head. In addition, advancements in materials and manufacturing processes, such as extreme heat treatments, have resulted in club heads that are stronger and harder to bend and have more sensitive surface finishes. This increases the difficulty in accurately bending a club head in a desired manner without adversely affecting the club head. Additionally, the iron-type club heads must have a hosel design that will allow for bending. Bending bars are used for bending golf club heads to a golfer's preferred loft and lie. The bending process requires a significant amount of force and/or torque to plastically deform the iron-type club head. It can be difficult to plastically bend the club head in a desired manner without adversely affecting the shape or integrity of the hosel bore, the striking face, or other parts of the club head. As a result the hosel must have significant structural integrity to withstand multiple bending sessions and repeated strikes at the range and the golf course. The risk of club failure makes for a challenging design problem and makes the mass associated with the hosel largely unavailable for redistribution. Accordingly, there exists a need for iron-type golf club heads with strong and lightweight hosels.

Additionally, traditional manufacturing techniques often result in inconsistent curvatures of the finished leading edge, both from head to head as well as across the length of the leading edge of a single club head. Such variabilities may be the result of inconsistencies in casting and forging, but more often they are the result of hand polishing and grinding of the club head during finishing, which often leaves one or

more flat areas along the leading edge. Such inconsistencies can be detected by a golfer as they impact how well the leading edge passes through the grass and/or impacts the ground. Hand grinding and polishing during the finishing process essentially establishes the sole contact point, leading edge height, and bounce, whether intentionally or unintentionally. Such hand operations introduce significant variability from one club head to another. A need exists for a golf club head blank having engineered external sacrificial region(s) to be used in conjunction with machining techniques and relationships, such that variability is reduced or removed and the sole contact point, leading edge height, and bounce may be precisely established with respect to one another.

## SUMMARY

An iron-type golf club and a method of creating the iron-type golf club including the steps of forming a club head blank having a blank loft, a blank head weight, and an external sacrificial region having an ESR thickness, an ESR sole portion, an ESR face portion, and an ESR leading edge portion. A finished club head is formed having a finished club head weight of less than 310 grams by machining off an ESR removed mass from at least a portion of the external sacrificial region including at least a portion of the ESR sole portion, a portion of the ESR face portion, and a portion of the ESR leading edge portion.

## BRIEF DESCRIPTION OF THE DRAWINGS

Without limiting the scope of the present invention as claimed below and referring now to the drawings and figures:

FIG. 1 is a front elevation view of an embodiment of a golf club head;

FIG. 2 is a side elevation view of an embodiment of a golf club head;

FIG. 3 is a perspective view of an embodiment of a golf club head;

FIG. 4 is a side elevation view of an embodiment of a golf club head;

FIG. 5 is a side elevation view of an embodiment of a golf club head;

FIG. 6 is a top plan view of an embodiment of a golf club head;

FIG. 7 is a bottom plan view of an embodiment of a golf club head;

FIG. 8 is a rotated front elevation view of an embodiment of a golf club head so that the face is in a vertical plane;

FIG. 9 is a rear elevation view of an embodiment of a golf club head;

FIG. 10 is a front elevation view of an embodiment of a golf club head;

FIG. 11 is an elevation view of an embodiment of a golf club head in a measurement configuration;

FIG. 12 is a partial cross-sectional view of an embodiment of a golf club head;

FIG. 13 is a front elevation view of an embodiment of a golf club head;

FIG. 14 is a front elevation view of an embodiment of a golf club head;

FIG. 15 is a front elevation view of an embodiment of a golf club head;

FIG. 16 is a bottom plan view of an embodiment of a golf club head;

FIG. 17 is a partial cross-sectional view of an embodiment of a golf club head;

FIG. 18 is a partial cross-sectional view of an embodiment of a golf club head;

FIG. 19 is a partial cross-sectional view of an embodiment of a golf club head;

FIG. 20 is a partial cross-sectional view of an embodiment of a golf club head;

FIG. 21 is a partial cross-sectional view of an embodiment of a golf club head;

FIG. 22 is a front elevation view of an embodiment of a golf club head blank;

FIG. 23 is a top plan view of an embodiment of a golf club head blank;

FIG. 24 is a perspective view of an embodiment of a golf club head blank;

FIG. 25 is a rotated front elevation view of an embodiment of a golf club head blank so that the face is in a vertical plane;

FIG. 26 is a perspective view of an embodiment of a golf club head blank;

FIG. 27 is a perspective view of an embodiment of a golf club head blank;

FIG. 28 is a perspective view of an embodiment of a kiosk;

FIG. 29 is a perspective view of an embodiment of a kiosk;

FIG. 30 is a perspective view of an embodiment of a golf club head blank;

FIG. 31 is a perspective view of an embodiment of a golf club head;

FIG. 32 is a perspective view of an embodiment of a golf club head;

FIG. 33 is a perspective view of an embodiment of a golf club head;

FIG. 34 is a perspective view of an embodiment of a golf club head;

FIG. 35 is a perspective view of an embodiment of a golf club head;

FIG. 36 is a perspective view of an embodiment of a golf club head;

FIG. 37a is a bottom plan view of an embodiment of a golf club head;

FIG. 37b is a bottom plan view of an embodiment of a golf club head;

FIG. 38a is a front elevation view of an embodiment of a golf club head;

FIG. 38b is a front elevation view of an embodiment of a golf club head;

FIG. 39a is a side elevation view of an embodiment of a golf club head; and

FIG. 39b is a side elevation view of an embodiment of a golf club head.

These drawings are provided to assist in the understanding of the exemplary embodiments of the invention as described in more detail below and should not be construed as unduly limiting the invention. In particular, the relative spacing, positioning, sizing and dimensions of the various elements illustrated in the drawings are not drawn to scale and may have been exaggerated, reduced or otherwise modified for the purpose of improved clarity. Those of ordinary skill in the art will also appreciate that a range of alternative configurations have been omitted simply to improve the clarity and reduce the number of drawings.

#### DETAILED DESCRIPTION

The inventive features include all novel and non-obvious features disclosed herein both alone and in novel and

non-obvious combinations with other elements. As used herein, the phrase “and/or” means “and”, “or” and both “and” and “or”. As used herein, the singular forms “a,” “an,” and “the” refer to one or more than one, unless the context clearly dictates otherwise. As used herein, the term “includes” means “comprises.” The preferred embodiments of the invention accomplish the stated objectives by new and novel arrangements of elements and configurations, materials, and methods that are configured in unique and novel ways and which demonstrate previously unavailable but preferred and desirable capabilities. The description set forth below in connection with the drawings is intended merely as a description of the presently preferred embodiments of the invention, and is not intended to represent the only form in which the present invention may be constructed or utilized. The description sets forth the designs, materials, functions, means, and methods of implementing the invention in connection with the illustrated embodiments. It is to be understood, however, that the same or equivalent functions, features, and material properties may be accomplished by different embodiments that are also intended to be encompassed within the spirit and scope of the invention. The present disclosure is described with reference to the accompanying drawings with preferred embodiments illustrated and described. The disclosure may, however, be embodied in many different forms and should not be construed as limited to the embodiments set forth herein; rather, these embodiments are provided so that this disclosure will be thorough and complete, and will fully convey the scope of the disclosure to those skilled in the art. Like numbers refer to like elements throughout the disclosure and the drawings. In the figures, the thickness of certain lines, layers, components, elements or features may be exaggerated for clarity. All publications, patent applications, patents, and other references mentioned herein are incorporated herein by reference in their entireties. Even though the embodiments of this disclosure are particularly suited as oversized golf club heads and oversized golf clubs and reference is made specifically thereto, it should be immediately apparent that embodiments of the present disclosure are applicable to non-oversized club heads as well.

The following disclosure describes embodiments of golf club heads and methods manufacturing club heads and golf clubs. The disclosure makes reference to the accompanying drawings which form a part hereof, wherein like numerals designate like parts throughout. The drawings illustrate specific embodiments, but other embodiments may be formed and structural changes may be made without departing from the intended scope of this disclosure. Directions and references (e.g., up, down, top, bottom, left, right, rearward, forward, heelward, toward, etc.) may be used to facilitate discussion of the drawings but are not intended to be limiting. For example, certain terms may be used such as “up,” “down,” “upper,” “lower,” “horizontal,” “vertical,” “left,” “right,” and the like. These terms are used, where applicable, to provide some clarity of description when dealing with relative relationships, particularly with respect to the illustrated embodiments. Such terms are not, however, intended to imply absolute relationships, positions, and/or orientations. For example, with respect to an object, an “upper” surface can become a “lower” surface simply by turning the object over. Nevertheless, it is still the same object. Accordingly, the following detailed description shall not to be construed in a limiting sense and the scope of property rights sought shall be defined by the appended claims and their equivalents.

The present disclosure describes iron type golf club heads typically including a head body and a striking plate. The head body includes a heel portion, a toe portion, a topline portion, a sole portion, and a hosel configured to attach the club head to a shaft. In various embodiments, the head body defines a front opening configured to receive the striking plate at a front rim formed around a periphery of the front opening. In various embodiments, the striking plate is formed integrally (such as by casting or forging) with the head body.

Various embodiments and aspects will be described with reference to details discussed below, and the accompanying drawings will illustrate the various embodiments. The following description and drawings are illustrative and are not to be construed as limiting on the scope of the disclosure. Numerous specific details are described to provide a thorough understanding of various embodiments of the present disclosure. However, in certain instances, well-known or conventional details are not described in order to provide a concise discussion of the various embodiments described herein.

FIG. 1 illustrates an iron type golf club head **100** including a body **113** (FIG. 2) having a heel **102**, a toe portion **104**, a sole portion **108**, a top line portion **106**, and a hosel **114**. The golf club head **100** is shown in FIG. 1A in a normal address position with the sole portion **108** resting upon a ground plane **111**, which is assumed to be perfectly flat. As used herein, “normal address position” means the club head position wherein a vector normal to the center of the club face substantially lies in a first vertical plane (i.e., a vertical plane is perpendicular to the ground plane **111**), a centerline axis **115** of the hosel **114** substantially lies in a second vertical plane, and the first vertical plane and the second vertical plane substantially perpendicularly intersect. The center of the club face is determined using the procedures described in the USGA “Procedure for Measuring the Flexibility of a Golf Club head,” Revision 2.0, Mar. 25, 2005.

A lower tangent point **190** on the outer surface of the club head **100** of a line **191** forming a 45 degree angle relative to the ground plane **111** defines a demarcation boundary between the sole portion **108** and the toe portion **104**. Similarly, an upper tangent point **192** on the outer surface of the club head **100** of a line **193** forming a 45 degree angle relative to the ground plane **111** defines a demarcation boundary between the top line portion **106** and the toe portion **104**. In other words, the portion of the club head that is above and to the left (as viewed in FIG. 1) of the lower tangent point **190** and below and to the left (as viewed in FIG. 1) of the upper tangent point **192** is the toe portion **104**.

The striking face **110** (FIG. 2) defines a face plane **125** and includes grooves **112** that are designed for impact with the golf ball. It should be noted that, in some embodiments, the toe portion **104** may be understood to be any portion of the golf club head **100** that is toward of the grooves **112**. In some embodiments, the golf club head **100** can be a single unitary cast or forged piece, while in other embodiments, a striking plate can be formed separately to be adhesively, welded, brazed, or mechanically attached to the body **113** (FIG. 2) of the golf club head **100**.

FIGS. 1 and 2 also show an ideal striking location **101** on the striking face **110** and respective orthogonal CG axes. As used herein, the ideal striking location **101** is located within the face plane **125** and coincides with the location of the center of gravity (CG) of the golf club head along the CG x-axis **105** (i.e., CG-x) and is offset from the leading edge **142** (defined as the midpoint of a radius connecting the sole portion **108** and the face plane **125**) by a distance  $d$  of 16.5

mm within the face plane **125**, as shown in FIG. 1B. A CG x-axis **105**, CG y-axis **107**, and CG z-axis **103** intersect at the ideal striking location **101**, which defines the origin of the orthogonal CG axes. With the golf club head **100** in the normal address position, the CG x-axis **105** is parallel to the ground plane **111** and is oriented perpendicular to a normal extending from the striking face **110** at the ideal striking location **101**. The CG y-axis **107** is also parallel to the ground plane and is perpendicular to the CG x-axis **105**. The CG z-axis **103** is oriented perpendicular to the ground plane. In addition, a CG z-up axis **109** is defined as an axis perpendicular to the ground plane **111** and having an origin at the ground plane **111**. In certain embodiments, a desirable CG-y location is between about 0.25 mm to about 20 mm along the CG y-axis **107** toward the rear portion of the club head. Additionally, in another embodiment a desirable CG-z location is between about 12 mm to about 25 mm along the CG z-up axis **109**, as previously described. The golf club head may be of solid (also referred to as “blades” and/or “musclebacks”), hollow, cavity back, or other construction.

In the embodiments shown in FIGS. 1-2, the grooves **112** are located on the striking face **110** such that they are centered along the CG x-axis about the ideal striking location **101**, i.e., such that the ideal striking location **101** is located within the striking face plane **125** on an imaginary line that is both perpendicular to and that passes through the midpoint of the longest score-line groove **112**. In other embodiments (not shown in the drawings), the grooves **112** may be shifted along the CG x-axis to the toe side or the heel side relative to the ideal striking location **101**, the grooves **112** may be aligned along an axis that is not parallel to the ground plane **111**, the grooves **112** may have discontinuities along their lengths, or the grooves may not be present at all. Still other shapes, alignments, and/or orientations of grooves **112** on the surface of the striking face **110** are also possible.

In reference to FIG. 1, the club head **100** has a sole length,  $L_B$ , and a club head height,  $H_{CH}$ . The sole length,  $L_B$ , is defined as the distance between two points projected onto the ground plane **111**. A heel side **116** of the sole is defined as the intersection of a projection of the hosel axis **115** onto the ground plane **111**. A toe side **117** of the sole is defined as the intersection point of the vertical projection of the lower tangent point **190** (described above) onto the ground plane **111**. The distance between the heel side **116** and toe side **117** of the sole is the sole length  $L_B$  of the club head. The club head height,  $H_{CH}$ , is defined as the distance between the ground plane **111** and the uppermost point of the club head as projected in the x-z plane, as illustrated in FIG. 1.

FIG. 2 illustrates an elevated toe view of the golf club head **100** including a back portion **128**, a front portion **130**, a sole portion **108**, a top line portion **106**, and a striking face **110**, as previously described. A leading edge **142** is defined by the midpoint of a radius connecting the face plane **125** and the sole portion **108**, within a vertical front-to-rear plane is perpendicular to the vertical shaft axis plane, as will be defined later in more detail. The club head includes a club head front-to-back depth,  $D_{CH}$ , which is the distance between two points projected onto the ground plane **111**. A forward end **118** of the club head is defined as the intersection of the projection of the leading edge **142** onto the ground plane **111**. A rearward end **119** of the club head is defined as the intersection of the projection of the rearward-most point of the club head (as viewed in the y-z plane) onto the ground plane **111**. The distance between the forward end **118** and rearward end **119** of the club head is the club head depth  $D_{CH}$ .

In some embodiments, the volume of the hollow iron club head **100** may be between about 10 cubic centimeters (cc) and about 120 cc. For example, in some embodiments, the iron club head **100** may have a volume between about 20 cc and about 110 cc, such as between about 30 cc and about 100 cc, such as between about 40 cc and about 90 cc, such as between about 50 cc and about 80 cc, or such as between about 60 cc and about 80 cc. In addition, in some embodiments, the iron club head **100** has a club head depth,  $D_{CH}$ , that is between about 15 mm and about 100 mm. For example, in some embodiments, the iron club head **100** may have a club head depth,  $D_{CH}$ , of between about 20 mm and about 90 mm, such as between about 30 mm and about 80 mm, such as between about 40 mm and about 70 mm.

In certain embodiments of the golf club head **100** that include a separate striking plate attached to the body **113** of the golf club head, the striking plate can be formed of forged maraging steel, maraging stainless steel, precipitation-hardened (PH) stainless steel, titanium alloys, or even non-metallic materials. In general, maraging steels have high strength, toughness, and malleability. Being low in carbon, they derive their strength from precipitation of inter-metallic substances other than carbon. The principle alloying element is nickel (15% to nearly 30%). Other alloying elements producing inter-metallic precipitates in these steels include cobalt, molybdenum, and titanium. In one embodiment, the maraging steel contains 18% nickel. Maraging stainless steels have less nickel than maraging steels but include significant chromium to inhibit rust. The chromium augments hardenability despite the reduced nickel content, which ensures the steel can transform to martensite when appropriately heat-treated. In another embodiment, a maraging stainless steel C455 is utilized as the striking plate. In other embodiments, the striking plate is a precipitation hardened stainless steel such as 17-4, 15-5, or 17-7.

The striking plate may be forged by hot press forging using any of the described materials in a progressive series of dies. After forging, the striking plate may be subjected to heat-treatment. For example, 17-4 PH stainless steel forgings are heat treated by 1040° C. for 90 minutes and then solution quenched. In another example, C455 or C450 stainless steel forgings are solution heat-treated at 830° C. for 90 minutes and then quenched.

In some embodiments, the body **113** of the golf club head is made from 17-4 steel. However another material such as carbon steel (e.g., 1020, 1030, 8620, or 1040 carbon steel), chrome-molybdenum steel (e.g., 4140 Cr—Mo steel), Ni—Cr—Mo steel (e.g., 8620 Ni—Cr—Mo steel), austenitic stainless steel (e.g., 304, N50, N60 stainless steel (e.g., 410 stainless steel), titanium alloys, or non-metallic materials can be used.

In addition to those noted above, some examples of metals and metal alloys that can be used to form the components of the parts described include, without limitation: titanium alloys (e.g., 3-2.5, 6-4, SP700, 15-3-3-3, 10-2-3, or other alpha/near alpha, alpha-beta, and beta/near beta titanium alloys), aluminum/aluminum alloys (e.g., 3000 series alloys, 5000 series alloys, 6000 series alloys, such as 6061-T6, and 7000 series alloys, such as 7075), magnesium alloys, copper alloys, and nickel alloys.

In still other embodiments, the body **113** and/or striking plate of the golf club head are made from fiber-reinforced polymeric composite materials, and are not required to be homogeneous. Examples of composite materials and golf club components comprising composite materials are

described in U.S. Patent Application Publication No. 2011/0275451, which is incorporated herein by reference in its entirety.

The body **113** of the golf club head can include various features such as weighting elements, cartridges, and/or inserts or applied bodies as used for CG placement, vibration control or damping, or acoustic control or damping. For example, U.S. Pat. No. 6,811,496, incorporated herein by reference in its entirety, discloses the attachment of mass altering pins or cartridge weighting elements.

In further embodiments the club head **100** may incorporate any of the “Iron Type Golf Club Heads Having a Flexible Boundary Structures” described in U.S. patent application Ser. No. 14/981,330, which is incorporated herein by reference in its entirety.

Turning to FIGS. 3-20, an iron-type golf club head **12** includes a club head body **14** having a striking face **16** with a plurality of scorelines **17**, a top line **18** defining the upper limit of the striking face **16**, a sole portion **20** defining the lower limit of the striking face **16**, a heel portion **22**, a toe portion **24** and a rear surface opposite the striking face **16**. In some embodiments the rear surface **26** may have a cavity back construction and includes an upper section **28** adjacent the top line **18**, a lower section **30** adjacent the sole portion **20** and a middle section **32** between the upper section **28** and the lower section **30**.

In some embodiments the iron-type golf club head **12** has the general configuration of a cavity back club head and, consequently, the rear surface **26** includes a flange **34** extending rearwardly around the periphery of the club head body **14**. The rearwardly extending flange **34** defines a cavity **36** within the rear surface **26** of the club head body **14**. The flange **34** includes a top flange **38** extending rearwardly along the top line **18** of the club head body **14** adjacent the upper section **28**. The top flange **38** extends the length of the top line **18** from the heel portion **22** of the club head body **14** to the toe portion **24** of the club head body **14**. The club head body **14** is further provided with rearwardly extending flanges **40**, **42** along the heel portion **22** (that is, a heel flange **40**) and the toe portion **24** (that is, a toe flange **42**) of the club head body **14**. These rearwardly extending flanges **38**, **40**, **42** extend through the upper section **28**, lower section **30** and middle section **32** of the rear surface **26** of the iron-type golf club head **12**. Additionally, the club head body **14** is provided with a bottom flange **44** extending along the sole portion **20** of the club head body **14**. In some embodiments iron-type golf club head **12** is preferably cast from suitable metal such as stainless steel. Although shown as a cavity-back iron, the iron-type golf club head **12** could be a “muscle back, or “blade,” construction, or even a “hollow” iron-type club and may be any iron-type club head from a one-iron to a wedge.

The iron type golf club head **12** further includes a hosel **46**. The hosel **46** has a hosel top edge **46a**, a hosel bore **48**, a hosel outer diameter top **50**, and a hosel outer diameter bottom **52** (if the hosel is tapered). The hosel bore **48** includes a proximal end **48a** and a distal end **48b**. The proximal end **48a** of the hosel bore **48** is proximate the hosel top edge **46a**. Proximate the distal end **48b** of the hosel bore **48** is a weight cartridge port or simply a cartridge port **49** (See FIG. 12). The cartridge port **49** has a proximal end **49a** and a distal end **49b**. The hosel **46** further includes a neck **54** connected to the heel portion **22** of the body **14**.

In some embodiments the hosel bore **48** ranges from about 8-12 mm, such as about 9.0 mm to about 9.6 mm. The hosel outer diameter top **50** ranges from about 12-15 mm, such as about 13.0 mm to about 13.6 mm. The hosel outer

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diameter bottom **52** ranges from about 12-17 mm, such as about 13.0 mm to about 13.6 mm.

The cartridge port **49** allows for addition of a weight adjustment member (not shown) having a shape and size similar to the cartridge port **49**, which may optionally be used to adjust the swing weight of the iron type golf club. This may help with overcoming manufacturing tolerances or adjusting the iron type club to a player's preferred swing weight. The weight adjustment member may be formed of metal or plastic. Since the weight adjustment member is located near the center of gravity of the iron type club head **12**, the club head center of gravity will not change significantly when selecting any of the plurality of weight adjustment members.

Turning to FIGS. **8** and **14**, the iron type golf club head **12** includes a face length **56**, a par line **57**, a toe face height **58**, a heel face height **60**, a scoreline length **62**, and a toe-to-end-of-scorelines length **64**. The par line **57** is at the transition point between the flat striking face **16** and the organically shaped region that attaches the club head body **14** to the hosel **46**. The scorelines **17** end just before the par line **57**. The face length **56** extends from the par line **57** to toe portion **24** of the iron type golf club head **12**. As shown the toe face height **58** and the heel face height **60** sandwich the scorelines. Accordingly, the toe face height **58** is measured proximate the scorelines **17** near the toe portion **24**, and the heel face height **60** is measured proximate the scorelines **17** near the heel portion **22**. In some embodiments the toe face height **58** is at least 35 mm, such as at least 40 mm, such as at least 45 mm, such as at least 50 mm, or such as at least 60 mm. The heel face height **60** ranges from about 20-60 mm, such as about 25-45 mm, such as about 25-40 mm, or such as about 25-35 mm. The a toe-to-end-of-scorelines length **64** is the maximum distance measuring from the scorelines to the toe portion **24**, and in some embodiments the a toe-to-end-of-scorelines length **64** is at least 5 mm, such as at least 10 mm, or such as at least 15 mm. The scorelines length **62** is the maximum length of the scorelines, and the scorelines length **62** is at least 40 mm, such as at least 45 mm, such as at least 50 mm, or such as at least 60 mm.

Turning to FIGS. **10** and **11**, the iron type golf club head **12** may include a base hosel length **66**, a pin hosel length **68**, a hosel length **70**, a lie angle **72**, and a Z-up **74**. In some embodiments, the hosel bore **46** may be generally symmetric about a longitudinal hosel bore axis **48c**. As shown, the hosel bore axis **48c** is at an angle relative to a ground plane (GP), and this angle is commonly referred to as a lie angle **72** of the club head. The ground plane is the plane onto which the iron type golf club head **12** may be properly soled i.e. arranged so that the sole portion **20** is in contact with the GP. The intersection of the ground plane and the hosel bore axis **48c** creates a ground plane intersection point (GPIP). The GPIP may be used to measure or reference features of the iron type golf club head **12**.

The hosel length **70** is measured from the GPIP to hosel top edge **46a** along the hosel bore axis **48c**. A hosel bore length **48d** is measured from the hosel top edge **46a** along the hosel bore axis **48c** to the hosel bore distal end **48b**. For reference and as shown in FIG. **11**, a hosel measurement datum **76** is used for making the base hosel length and the pin hosel length measurements **66**, **68**. The hosel measurement datum **76** is created by first placing the iron type golf club head **12** on a generally planar measurement surface **78**, second the hosel bore axis **48c** is aligned parallel to the measurement surface **78** and the heel portion **22** of the iron type golf club head **12** is pressed against a pin **80** having a

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0.375 inch diameter, next the hosel measurement datum **76** is created perpendicular to the measurement surface and offset 15.49 mm from a plane tangent to a distal end of the pin and perpendicular to the measurement surface. Additionally, as shown a leading edge **16a** of the striking face **16** is aligned at 90 degrees relative to the measurement surface **78**.

The base hosel length **66** is measured parallel to the measurement surface from the hosel measurement datum **76** to the distal end **48b** of the hosel bore **48**. The pin hosel length **68** is measured parallel to the measurement surface **78** from the hosel measurement datum **76** to the hosel top edge **46a**. Generally, the hosel bore axis **48c** passes through the center of the hosel. The hosel bore axis can be found by inserting a cylindrically shaped pin or dowel having a diameter substantially similar to the hosel bore in the hosel bore. The axis of the pin or dowel should be substantially aligned with the hosel bore axis. If the hosel bore is tapered then the pin or dowel should have a substantially similar taper to determine the hosel bore axis. Another method of determining the hosel bore axis would be to measure the diameter of the hosel bore at two or more locations along the hosel bore and then construct an axis through the center points of the two or more diameters measured.

In an embodiment the base hosel length **66** is at least 15 mm, such as at least 20 mm, such as at least 25 mm, such as at least 30 mm, or such as at least 35 mm. Typically in a lower lofted iron (e.g. 17 degrees to 48 degrees) the base hosel length may range from about 20 mm to about 30 mm. For wedges 50 degrees and greater, such as gap wedge, sand wedge, and lob wedge, the base hosel length is generally at least 40 mm.

In an embodiment the pin hosel length **68** is at least 40 mm, such as at least 45 mm, such as at least 50 mm, such as at least 55 mm, such as at least 60 mm, such as at least 65 mm, such as at least 70 mm, or such as at least 75 mm. Although, this measurement may vary, generally the pin hosel length will be about 23 mm to about 33 mm greater than the base hosel length, or preferably about 25 mm to about 28 mm. Typically in a lower lofted iron e.g. 17 degrees to 48 degrees the pin hosel length may range from about 45 mm to about 60 mm, or preferably about 50 mm to about 60 mm. For wedges 50 degrees and greater, such as gap wedge, sand wedge, and lob wedge, the base hosel length is generally at least 40 mm. In an embodiment the hosel length **70** is at least 40 mm, such as at least 45 mm, such as at least 50 mm, such as at least 55 mm, such as at least 60 mm, such as at least 65 mm, such as at least 70 mm, such as at least 75 mm, such as at least 80 mm, such as at least 85 mm, such as at least 90 mm, or such as at least 95 mm.

The portion of the shaft that bonds to the hosel bore of the iron type golf club head is referred to as the bond length. In many instances, the bond length is the same as the hosel bore length **48d**, however in some instances there is a difference of about 1 mm to about 4 mm between the bond length and the hosel bore length. This is because a ferrule may be used that snaps into the hosel bore, which requires about 1 mm to about 4 mm for engagement. The bond length is generally about 20 mm to about 35 mm, preferably about 25 mm to about 30 mm. The bond length may also be approximated by finding the difference between the pin hosel length **68** and the base hosel length **66**, which is typically between about 25 mm to about 30 mm.

As seen in FIGS. **15** and **17**, an embodiment incorporates a bore through-passageway **48e**, which connects a portion of the hosel bore **48** with an external surface of the club head **12**. The bore through-passageway **48e** has a passageway

distal end **48f** at the external surface and produces a passageway opening **48h**, as well as a passageway proximal end **48g**, which is open to a portion of the hosel bore **48**. A portion of, or all of, the bore through-passageway **48e** may be filled with a passageway insert **48i**, which may be metallic or non-metallic in nature. In a preferred embodiment the passageway insert **48i** is a thermoplastic polyurethane, however it may preferably be any non-metallic material having a density less than the metallic portion of the club head **12**, and preferably has a density of less than one-half of the density of the metallic portion of the club head **12**. The bore through-passageway **48e** has a volume that is preferably at least 0.25 cc, and less than one-half of a volume of the hosel bore **48**, and in an embodiment the passageway insert **48i** has a volume that is at least 0.25 cc, and less than one-half of a volume of the hosel bore **48**. The size and volume of the bore through-passageway **48e** and the passageway insert **48i** are significant enough to provide weight savings and reduce undesirable club head vibrations, while not being so large as to introduce new uncommon vibrations or overly deaden the vibrations and feedback that a golfer expects to experience upon impact with a golf ball.

Further, as seen in FIGS. **16** and **18-21**, an embodiment incorporates a sole portion void **21** having a void proximal end **21a**, a void distal end **21b**, a void length **21c**, and a void volume. In some instances the sole portion void **21** extends to an exterior surface of the club head **12**, thereby creating a void opening **21d**. A portion of, or all of, the sole portion void **21** may be filled with a void insert **21e**, which may be metallic or non-metallic in nature.

In an embodiment the void insert **21e** is a thermoplastic polyurethane, however it may be any non-metallic material having a density less than the metallic portion of the club head **12**, and preferably has a density of less than one-half of the density of the metallic portion of the club head **12**. Alternatively, the void insert **21e** is a is formed of a metallic insert secured within a portion of the sole portion void **21**, which may be accomplished by welding, brazing, friction fit, mechanical attachment, or adhesives. In some embodiments the void insert **21e** is a metallic alloy having a density at least 25% greater than the density of the material forming the hosel **46**, while at least 50% greater in a further embodiment, and at least 75% greater in yet another embodiment. Such embodiments allow the center of gravity of the club head **12** to be shifted more toward the toe portion **24**, thereby bringing the center of gravity toward the center of the striking face **16** by offsetting some of the weight associated with the hosel **46**.

The void length **21c** is preferably at least 50% of the scoreline length **62**, such as at least 75% of the scoreline length **62**, and at least 100% of the scoreline length **62** in another embodiment, and is preferably oriented in a heel-toe direction, as seen in FIG. **20**. These embodiments produce preferred feel in that a mishit away from the center of the face **16** will still result in the ball contacting the face **16** at a point having a portion of the sole portion void **21** behind it. In one embodiment the sole portion void **21** is continuous and consistent across the portion of the club head **12** having scorelines. In fact, in one embodiment the void length **21c** is greater than the sum of the scoreline length **62** and the toe-to-end-of-scorelines length **64**, seen in FIG. **8**. In another embodiment the void insert **21e** extends into the sole portion void **21** from the void opening **21d**, but does not extend into the portion of the sole portion void **21** located behind the scorelines any more than 25% of the scoreline length **62**, no more than 10% in another embodiment, and in still a further

embodiment the void insert **21** does not extend into any portion of the sole portion void **21** that is located behind a portion of a scoreline.

The sole portion void **21** has a volume that is preferably at least 0.5 cc, and less than the volume of the hosel bore **48**, and in an embodiment the void insert **21** has a volume that is at least 0.125 cc, and less than 25% of the volume of the sole portion void **21**. In another embodiment the sole portion void **21** has a volume that is preferably at least 0.75 cc, and less than 75% of the volume of the hosel bore **48**, and in an embodiment the void insert **21** has a volume that is at least 0.175 cc, and less than 20% of the volume of the sole portion void **21**; and in still another embodiment the sole portion void **21** has a volume that is preferably at least 1.00 cc, and less than 50% of the volume of the hosel bore **48**, and in an embodiment the void insert **21** has a volume that is at least 0.200 cc, and less than 17.5% of the volume of the sole portion void **21**. The size and volume of the sole portion void **21** and the void insert **21** are significant enough to provide weight savings, preferential location of the center of gravity, and produce consistent feel on impacts located away from the face center. As will be explained later in greater detail, the sole portion void **21**, and/or the void insert **21**, may serve as a weight adjustment parameter to fine tune the overall weight of the club head **12** to achieve a desired club head weight and swing weight.

#### The External Sacrificial Region

As seen in FIGS. **22-27**, any of the club heads described herein may incorporate an external sacrificial region **200** formed with the club head. The external sacrificial region **200**, abbreviated ESR, is an external region of the club head containing excess material, a portion of which is intended to be removed to provide a precisely machined surface or desired transition to the contour of the club head. Strategic use of the external sacrificial region **200** allows for improved customization of the club head, including, but not limited to, improved milling surface to achieve a wide variety of sole grinds and neck blends on a single club head blank **250**, and the ability to create preferred leading edge profiles and/or locations. Unlike traditional weight pads intended to be milled to achieve a target weight, the present external sacrificial regions **200** are located on areas of the club head intended to contact the ball or the ground.

As previously noted with respect to FIG. **1**, the lower tangent point **190** on the outer surface of the club head **100** of a line **191** forming a 45 degree angle relative to the ground plane **111** defines a demarcation boundary between the sole portion **108** and the toe portion **104**. The club head **100** has a sole length,  $L_B$ , defined as the distance between two points projected onto the ground plane **111**. A heel side **116** of the sole is defined as the intersection of a projection of the hosel axis **115** onto the ground plane **111**. A toe side **117** of the sole is defined as the intersection point of the vertical projection of the lower tangent point **190** (described above) onto the ground plane **111**. The distance between the heel side **116** and toe side **117** of the sole is the sole length  $L_B$  of the club head. In order to define a sole surface area an imaginary horizontal plane it created parallel to the ground plane **111** and offset 5 mm above the ground plane **111**. The sole surface area includes the area of the entire surface between the ground plane **111** and the 5 mm imaginary offset plane, throughout the sole length  $L_B$ , that is oriented facing the ground plane **111** such that a line normal to the surface is oriented at least 10 degrees from the horizontal 5 mm imaginary offset plane toward the ground plane **111**.

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As previously noted with respect to FIG. 2, the leading edge 142 is defined as the midpoint of a radius connecting the sole portion 108 and the face plane 125. The leading edge surface area includes the entire area created by the radius throughout the sole length  $L_B$ .

The external sacrificial region 200 includes an ESR thickness 202 that is at least 0.25 mm, however in an embodiment the ESR thickness 202 that is at least 0.50 mm, and in a further embodiment it is at least 0.75 mm. In another embodiment the ESR thickness 202 is no more than 2.00 mm.

The external sacrificial region 200 may include an ESR sole portion 210, which is the portion of the external sacrificial region 200 located on the sole surface area. Further, the external sacrificial region 200 may include an ESR leading edge portion 220, which is the portion of the external sacrificial region 200 located on the leading edge surface area. Additionally, the external sacrificial region 200 may include an ESR face portion 230, which is the portion of the external sacrificial region 200 located on the flat face plane 125, however in embodiments having a curved striking face the ESR face portion 230 is that portion of the external sacrificial region 200 located on the striking face 16 having a substantially constant bulge radius. Lastly, the external sacrificial region 200 may include an ESR neck blend portion 240, which is the portion of the external sacrificial region 200 located between the sole heel side 116 and the hosel top edge 46a, and located in front of a shaft axis plane defined as a vertical plane containing the hosel bore axis 48c.

The previously discussed club heads 12, 100 represent a finished golf club head after portions of the external sacrificial region 200 have been machined from a club head blank 250, seen in FIGS. 22-24. The disclosure will first discuss a wedge type golf club head, however one of skill in the art will appreciate that the disclosure applies equally to less lofted club heads, as will be discussed in more detail.

Thus, in one embodiment the process of producing a finished club head begins with a step of forming a club head blank 250 having a blank loft of at least 43 degrees, a blank lie angle of at least 64 degrees, and a blank head weight of 345-400 grams. The club head blank includes a body 14, 113 including a hosel 46, 114, a heel portion 22, 116, a sole portion 20, 108, a toe portion 24, 117, a top-line portion 18, 106, a face portion 16, 110, and a leading edge 16a, 142 joining the face portion 16, 110 and the sole portion 20, 108, and the sole portion 20, 108 extends rearwardly from the leading edge 16a, 142. In this embodiment the club head blank 250 includes an external sacrificial region 200 having an ESR thickness 202, an ESR sole portion 210, an ESR face portion 230, and an ESR leading edge portion 220. A finished club head having a finished club head weight of less than 310 grams is formed from the club head blank 250 by machining off an ESR removed mass from at least a portion of the external sacrificial region 200 including at least a portion of the ESR sole portion 210, a portion of the ESR face portion 230, and a portion of the ESR leading edge portion 220. In one embodiment less than 70% of the ESR removed mass is removed from the ESR face portion, while at least 20% of the ESR removed mass is removed from the ESR sole portion, and at least 50% of the ESR leading edge portion is machined to produce a finished leading edge radius. In another embodiment at least 75% of the ESR leading edge portion is machined to produce a finished leading edge radius, while in an even further embodiment all of the ESR leading edge portion is machined. In a further embodiment majority of the ESR sole portion 210 is

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machined off to produce the finished sole profile, while in another embodiment at least 75% of the ESR sole portion 210 is machined, and in still a further embodiment the entire ESR sole portion 210 is machined. Additionally, in still another embodiment majority of the ESR face portion 230 is machined off to produce the finished sole profile, while in another embodiment at least 75% of the ESR face portion 230 is machined, and in still a further embodiment the entire ESR face portion 230 is machined.

This disclosure applies equally to other iron type golf club heads conventionally referred to as a 3-iron, 4-iron, 5-iron, 6-iron, 7-iron, 8-iron, and 9-iron, however with the loft, lie, blank head weight, and finished head weight adjusted accordingly, one embodiment of which is seen in Table 1; as well as hybrid iron type golf club heads, often referred to as rescue golf club heads, generally having a hollow construction and curved, or flat, faces, however with the loft, lie, blank head weight, and finished head weight adjusted accordingly, one embodiment of which is seen in Table 2; as well as fairway wood type golf club heads, generally having a hollow construction and curved faces, however with the loft, lie, blank head weight, and finished head weight adjusted accordingly, one embodiment of which is seen in Table 3; and even driver golf club heads, generally having a hollow construction and curved faces, however with the loft, lie, blank head weight, and finished head weight adjusted accordingly, one embodiment of which is seen in Table 4.

TABLE 1

	3-iron	4-iron	5-iron	6-iron	7-iron	8-iron	9-iron
Blank Head Weight (grams)	275-315	285-325	290-335	300-345	305-365	310-375	315-385
Finished Head Weight (grams) ± 2 g	240	247	254	261	268	275	282
Loft (degrees) ± 2 degrees	21	24	27	30	34	38	42
Lie (degrees) ± 2 degrees	60.5	61.0	61.5	62	62.5	63	63.5

TABLE 2

	2-hybrid	3-hybrid	4-hybrid	5-hybrid	6-hybrid	7-hybrid
Blank Head Weight (grams)	250-290	260-300	270-310	280-320	290-330	300-340
Finished Head Weight (grams) ± 3 g	217	227	237	247	257	267
Loft (degrees) ± 3 degrees	16.5	19	22	25	28	32
Lie (degrees) ± 2 degrees	56.75	58.00	59.25	60.25	61.25	62.25

TABLE 3

	3 fairway wood	5 fairway wood
Blank Head Weight (grams)	250-290	255-295
Finished Head Weight (grams) ± 3 g	215	218
Loft (degrees) ± 3 degrees	17	20
Lie (degrees) ± 2 degrees	58.00	58.50



TABLE 4

	driver
Blank Head Weight (grams)	230-270
Finished Head Weight (grams) ± 3 g	195-205
Loft (degrees) ± 3 degrees	11
Lie (degrees) ± 2 degrees	58.00

As disclosed herein, the external sacrificial region **200** may include any one, or more, of the following: an ESR sole portion **210**, an ESR face portion **230**, an ESR leading edge portion **220**, an ESR neck blend portion **240**, and even an ESR crown portion, not illustrated, but understood by one skilled in the art, particularly in light of U.S. patent application Ser. No. 14/330,205, which is incorporated by reference.

In some embodiments majority of the portion of the ESR leading edge portion **220** that is machined is adjacent to a portion of the ESR face portion **230** that is also machined. In further embodiments majority of the portion of the ESR leading edge portion **220** that is machined is adjacent to a portion of the ESR sole portion **210** that is also machined. Even further, at least 70% of the ESR leading edge portion **220** is machined in additional embodiments, and at least 90% of the ESR leading edge portion **220** is machined in still further embodiments. Machining external sacrificial regions **200** of adjacent surfaces provides improved precision and customization capabilities, while eliminating the waste of time, energy, and material associated with machining a golf club head from a billet.

In one embodiment the ESR face portion covers at least 1800 mm<sup>2</sup>, the ESR sole portion covers at least 900 mm<sup>2</sup>, and the ESR leading edge portion covers at least 50 mm<sup>2</sup>, and wherein the ESR thickness is less than 2.5 mm, while in a further embodiment the ESR face portion covers at least 2500 mm<sup>2</sup>, the ESR sole portion covers at least 1250 mm<sup>2</sup>, and the ESR leading edge portion covers at least 75 mm<sup>2</sup>, and in yet another embodiment ESR face portion covers at least 3200 mm<sup>2</sup>, the ESR sole portion covers at least 1600 mm<sup>2</sup>, and the ESR leading edge portion covers at least 100 mm<sup>2</sup>. In yet another embodiment the ESR face portion covers at least 3000 mm<sup>2</sup>, the ESR sole portion covers at least 1500 mm<sup>2</sup>, and the ESR leading edge portion covers at least 100 mm<sup>2</sup>, and wherein the ESR thickness **202** is no more than 2.0 mm. The ESR thickness referred to herein is the average thickness for all areas that have material removed by machining, thereby allowing for some areas having greater thicknesses. In one embodiment the ESR thickness is at least 0.25 mm, such as at least 0.50 mm in a further embodiment, and at least 0.75 mm in still another embodiment. One particular embodiment has an average ESR thickness of the ESR face portion **230** is less than an average ESR thickness of the ESR sole portion **210**, while in an even further embodiment an average ESR thickness of the ESR face portion **230** is less than an average ESR thickness of the ESR leading edge portion **220**, and in still another embodiment an average ESR thickness of the ESR face portion **230** is less than an average ESR thickness of the ESR neck blend portion **230**.

Traditional manufacturing techniques often result in inconsistent curvatures of the finished leading edge, both from head to head as well as across the length of the leading edge of a single club head. Such variabilities may be the result of inconsistencies in casting and forging, but more often they are the result of hand polishing and grinding of the club head during finishing, which often leaves one or

more flat areas along the leading edge. Such inconsistencies can be detected by a golfer as they impact how well the leading edge passes through the grass and/or impacts the ground.

In some embodiments at least 0.25 grams of the ESR removed mass is removed from the ESR leading edge portion **220**, at least 2.5 grams of the ESR removed mass is removed from the ESR sole portion **210**, and at least 5.0 grams of the ESR removed mass is removed from the ESR face portion **230**. Unlike club heads machined from a large billet, in one embodiment the ESR removed mass removed from the ESR sole portion **210** is at least 30% of the ESR removed mass removed from the ESR face portion **230**, while in a further embodiment the ESR removed mass removed from the ESR sole portion **210** is no more than 125% of the ESR removed mass removed from the ESR face portion **230**, and in yet another embodiment the ESR removed mass removed from the ESR sole portion **210** is 40-80% of the ESR removed mass removed from the ESR face portion **230**. In one particular embodiment 20-60% of the ESR removed mass is removed from the ESR face portion **230**, while in an even further embodiment 15-45% of the ESR removed mass is removed from the ESR sole portion **210**. Generally the ESR removed mass removed is 10-40% of the finished club head weight, such as 12-35% in an embodiment, 14-32% in another embodiment, and at least 16% in yet a further embodiment. In one embodiment the ESR removed mass removed is preferably at least 0.55 grams per degree of loft, and no more than 3.75 grams per degree of loft. In further embodiments at least 0.50 grams of the ESR removed mass is removed from the ESR leading edge portion **220**, at least 5.0 grams of the ESR removed mass is removed from the ESR sole portion **210**, and at least 10.0 grams of the ESR removed mass is removed from the ESR face portion **230**, such as at least 0.75 grams of the ESR removed mass is removed from the ESR leading edge portion **220**, at least 7.5 grams of the ESR removed mass removed from the ESR sole portion **210**, and at least 15.0 grams of the ESR removed mass is removed from the ESR face portion **230**. In still another embodiment 0.5-4.0 grams of the ESR removed mass is removed from the ESR leading edge portion **220**, at least 5.0-40.0 grams of the ESR removed mass is removed from the ESR sole portion **210**, and 10.0-50.0 grams of the ESR removed mass is removed from the ESR face portion **230**.

Further, in embodiments incorporating an ESR neck blend portion **240**, at least 0.25 grams of the ESR removed mass is removed from the ESR neck blend portion **240**, such as at least 0.50 grams in another embodiment, and at least 1.0 grams in still a further embodiment. One particular embodiment has the ESR removed mass removed from the ESR neck blend portion **240** being greater than the ESR removed mass is removed from the ESR leading edge portion **220**, while in a further embodiment the ESR removed mass removed from the ESR neck blend portion **240** is less than the ESR removed mass is removed from the ESR sole portion **210**, such as less than 75% of the ESR removed mass is removed from the ESR sole portion **210**. In another embodiment the ESR removed mass removed from the ESR neck blend portion **240** is less than the ESR removed mass is removed from the ESR face portion **230**, such as less than 75% of the ESR removed mass is removed from the ESR face portion **230**. In another embodiment the ESR removed mass removed from the ESR neck blend portion **240** is both (a) less than 50% of the ESR removed mass is removed from the ESR sole portion **210**, and (b) less than 50% of the ESR removed mass is removed from the ESR face portion **230**.

Some embodiments even have a portion of the ESR neck blend portion **240** that extends to an elevation above a ground plane that is greater than a height of a center of gravity of the finished club head, and at least a portion of the ESR neck blend portion located above the center of gravity of the finished club head is machined off to create the finished club head.

The step of machining off at least a portion of the ESR sole portion **210** and a portion of the ESR leading edge portion **220** may be performed with the club head blank **250** held in a single orientation with a single machine tool. Still further, the step of machining off at least a portion of the ESR sole portion **210** and a portion of the ESR leading edge portion **220** may be performed in a single continuous operation. Even further, in one particular embodiment a portion of the ESR face portion **230** is machined off first producing a step discontinuity with at least a portion of the ESR neck blend portion **240**, then in a single orientation and with a single machine tool, at least a portion of the ESR sole portion **210**, a portion of the ESR leading edge portion **220**, and a portion of the ESR neck blend portion **240**, including the step discontinuity, are removed. In an embodiment the single machine tool is a ball end mill, which in a further embodiment has a tool diameter of 2 mm or less. In another embodiment, recognizing the significance of the finished leading edge geometry to performance, the ball end mill machining of the ESR leading edge portion is carried out with a step-over distance that is less than the finished leading edge radius, and produces a scallop height of less than 50% of the finished leading edge radius; while in another embodiment the ball end mill machining of the ESR leading edge portion is carried out with a step-over distance that is less than 75% of the finished leading edge radius, and produces a scallop height of less than 35% of the finished leading edge radius; and in still a further embodiment the ball end mill machining of the ESR leading edge portion is carried out with a step-over distance that is less than 25-75% of the finished leading edge radius, and produces a scallop height of 10-35% of the finished leading edge radius. While some embodiments utilize a single machine tool to machine the ESR sole portion **210** and the ESR leading edge portion **220**, this is not required in embodiments in which the properties of the ball end mill vary by less than 50%. Thus, in one embodiment the ball end mill used in machining the ESR sole portion **210** has a tool diameter of 3 mm or less. Similarly, in another embodiment, recognizing the significance of the transition of the sole geometry to the finished leading edge geometry to performance, the ball end mill machining of the ESR sole portion **210** is carried out with a step-over distance that is less than 150% of the finished leading edge radius, and produces a scallop height of less than 75% of the finished leading edge radius; while in another embodiment the ball end mill machining of the ESR sole portion **210** is carried out with a step-over distance that is less than the finished leading edge radius, and produces a scallop height of less than 70% of the finished leading edge radius; and in still a further embodiment the ball end mill machining of the ESR sole portion **210** is carried out with a step-over distance that is less than 25-100% of the finished leading edge radius, and produces a scallop height of 15-70% of the finished leading edge radius. In one embodiment the same ball end machine tool is used in machining both the ESR sole portion **210** and the ESR leading edge portion **220** and is carried out with a step-over distance of 1.5 mm or less, and in another embodiment produces a scallop height of less than 0.50 mm.

With a finished club head in a design position, a hosel centerline axis **115** establishes a vertical shaft axis plane containing the hosel centerline axis **115**. Further, a vertical front-to-rear plane is perpendicular to the vertical shaft axis plane. Additionally, a tool path plane is vertical and within a path angle of the vertical front-to-rear plane. In other words, keeping the vertical front-to-rear plane in the vertical position and rotating it from the initial position perpendicular to the vertical shaft axis plane through an angle referred to as the path angle, establishes the tool path plane. In an embodiment, during the step of machining the ESR leading edge portion, the machine tool traverses the ESR leading edge portion along a machine tool path that lies between the vertical front-to-rear plane and the tool path plane, and the path angle is no more than 35 degrees, such as no more than 25 degrees in a further embodiment, no more than 15 degrees in another embodiment, and no more than 5 degrees in still a further embodiment. One skilled in the art will appreciate that for simplicity these planes are defined based upon the finished club head being in the design position, however actual machining of the blank club head **250** may be performed in any orientation and the defined planes rotate with the club head to define the path of the machine tool, essentially with respect to the front-to-rear direction of the club head. Without limiting the invention, it is convenient to visualize the blank club head **250** in a design position, such as that of FIG. **22**, with a ball end mill machine tool traversing the ESR sole portion **210** along the tool path plane to the ESR leading edge portion **220**, and then traveling vertically around the ESR leading edge portion **220**, removing ESR material in the process, to perfectly blend with the previously machined face and avoiding machining scallop lines that are substantially parallel to the finished leading edge, which may adversely impact how the finished leading edge interacts with grass and the ground. With respect to the machining of the ESR leading edge portion **220**, in some embodiments the tool path plane changes as the machine tool gets farther away from a vertical midpoint demarcation plane, which is a plane that passes through the midpoint of the longest score-line groove **112** and is perpendicular to the vertical shaft axis plane, thereby facilitating tighter control of the curvature of the leading edge and the blend into the face. In one embodiment the tool path plane rotates at least one-half a degree for every 10 mm the machine tool is horizontally displaced from the vertical midpoint demarcation plane, while in another embodiment the tool path plane rotates at least one degree for every 10 mm the machine tool is horizontally displaced from the vertical midpoint demarcation plane, and in an even further embodiment the tool path plane rotates at least 1.5 degrees for every 10 mm the machine tool is horizontally displaced from the vertical midpoint demarcation plane. In one embodiment the rotation of the tool path plane is such that it intersects the vertical midpoint demarcation plane behind the face. However in an alternative embodiment the rotation of the tool path plane is such that it intersects the vertical midpoint demarcation plane in front of the face.

The ESR leading edge portion **220** may be configured to have an initial curved leading edge, with a blank leading edge radius, or the ESR leading edge portion **220** may be configured so that at least a portion of the ESR sole portion **210** and a portion of the ESR face portion **230** meet along a flat surface of the ESR leading edge portion **220** producing an initial leading edge that has a flat surface for ease of manufacturing the club head blank **250**. One embodiment has a flat surface, on the initial leading edge of the ESR leading edge portion **220**, that extends throughout at least

25% of the sole length,  $L_B$ , such as throughout at least 50% of the sole length,  $L_B$ , in another embodiment, and throughout at least 75% of the sole length,  $L_B$ , in yet a further embodiment. In an alternative series of embodiments, a curved surface, on the initial leading edge of the ESR leading edge portion **220**, may extend throughout at least 25% of the sole length,  $L_B$ , in one embodiment, such as throughout at least 50% of the sole length,  $L_B$ , in another embodiment, and throughout at least 75% of the sole length,  $L_B$ , in yet a further embodiment. In an embodiment the blank leading edge of the ESR leading edge portion **220** has a blank leading edge radius, and the finished leading edge radius is at least 25% less than the blank leading edge radius, while in a further embodiment the finished leading edge radius is 25-75% less than the blank leading edge radius, and in yet another embodiment the finished leading edge radius is 25-50% less than the blank leading edge radius. In a preferred embodiment the finished leading edge contains no flat surfaces throughout at least 50% of the sole length,  $L_B$ , such as throughout at least 75% of the sole length,  $L_B$ , in another embodiment, such as throughout the entire sole length,  $L_B$ , in still a further embodiment. In one particular embodiment the finished leading edge radius is 1.0-4.0 mm, such as a finished leading edge radius is 1.5-3.5 mm in another embodiment, and no more than 3.0 mm in a further embodiment, and no more than 2.5 mm in still another embodiment.

Yet another advantage of using the disclosed machining techniques on at least a portion of the ESR sole portion **210** and at least a portion of the ESR leading edge portion **220** is that the finished leading edge radius may vary along the finished leading edge providing preferred turf and ground interaction attributes. For instance, the finished club head is divided into a toe half and a heel half by using a vertical midpoint demarcation plane that passes through the midpoint of the longest score-line groove **112**, wherein the vertical midpoint demarcation plane is perpendicular to the vertical shaft axis plane, the portion of the club head containing the hosel is the heel half, with the portion on the other side of the demarcation plane being the toe half. A score-line area toe boundary plane is parallel to the vertical midpoint demarcation plane and passes through the toeward-most point of the longest score-line groove, and similarly a score-line area heel boundary plane is parallel to the vertical midpoint demarcation plane and passes through the heelward-most point of the longest score-line groove. In one embodiment a portion of the finished leading edge, between the vertical midpoint demarcation plane and the score-line area heel boundary plane, has a heel minimum leading edge radius that is less than a toe minimum leading edge radius that is located on the finished leading edge between the vertical midpoint demarcation plane and the score-line area toe boundary plane. In a further embodiment, the greatest leading edge radius located between the score-line area heel boundary plane and the score-line area toe boundary plane, is located between the vertical midpoint demarcation plane and the score-line area toe boundary plane. Conversely, in another embodiment the finished leading edge, between the vertical midpoint demarcation plane and the score-line area heel boundary plane, has a heel minimum leading edge radius that is greater than a toe minimum leading edge radius that is located on the finished leading edge between the vertical midpoint demarcation plane and the score-line area toe boundary plane. Similarly, in a further embodiment, the greatest leading edge radius located between the score-line area heel boundary plane and the score-line area toe boundary plane, is located between the vertical midpoint demar-

cation plane and the score-line area heel boundary plane. In still a further embodiment the leading edge radius at the vertical midpoint demarcation plane is at least 10% greater than the leading edge radius at the score-line area toe boundary plane, such as at least 20% greater in another embodiment, and at least 30% greater in yet a further embodiment. Similarly, in another embodiment the leading edge radius at the vertical midpoint demarcation plane is at least 10% greater than the leading edge radius at the score-line area heel boundary plane, such as at least 20% greater in another embodiment, and at least 30% greater in yet a further embodiment.

With continued reference to the vertical midpoint demarcation plane, score-line area heel boundary plane, and the score-line area toe boundary plane, in one embodiment majority of the ESR removed mass taken from the ESR sole portion **210** is removed between the vertical midpoint demarcation plane and the score-line area heel boundary plane, while majority of the ESR removed mass taken from the ESR face portion **230** is removed from the opposite side of the vertical midpoint demarcation plane. In a further embodiment the minority of the total ESR removed mass is from the portion on the hosel side of the vertical midpoint demarcation plane, with the majority removed from the opposite side of the vertical midpoint demarcation plane. However, in still another embodiment the club head blank **250** has a club head blank CG location and the finished club head has a finished club head CG location. In an embodiment a shortest distance from the club head blank CG location to the finished club head CG location is no more than 2 mm, such as no more than 1.5 mm in another embodiment, and no more than 1.0 mm in yet another embodiment.

The external sacrificial region **200** is a way to create repeatable club head blanks **250**, from which select areas of the external sacrificial region **200** may be removed to achieve desired curvatures and/or profiles of the contact surfaces of a finished club head. In one embodiment the step of machining a portion of the ESR sole portion establishes a sole contact point, and in another embodiment the step of machining a portion of the ESR sole portion and a portion of the ESR leading edge portion establishes a leading edge height of the finished club head, while in an even further embodiment the step of machining a portion of the ESR sole portion establishes a bounce of the finished club head. Traditionally hand grinding and polishing during the finishing process essentially establishes the sole contact point, leading edge height, and bounce, whether intentionally or unintentionally. Such hand operations introduce significant variability from one club head to another. Utilizing the disclosed external sacrificial region **200** and machining techniques and relationships, such variability is removed and the sole contact point, leading edge height, and bounce may be precisely established with respect to one another. The bounce is the angle between the lowest point on the sole and the leading edge directly in front of the lowest point. Further, the grind is the relief and contour that is machined from the ESR sole portion **210**. FIG. **30** illustrates the ESR sole portion **210** before it has been machined, while FIGS. **31-36** illustrate embodiments in which various grinds have been machined from the ESR sole portion **210**. FIGS. **31** and **36** illustrate embodiments in which the sole contact point has been machined, while the other figures illustrate alternative grinds.

The ESR face portion **230** may also facilitate control of the curvature of the face, as well as imparting variable face thickness to the striking face. In fact, some club head

embodiments have a face insert that is attached to the club head, generally by welding, brazing, or adhesive, and in these embodiments the ESR face portion **230** allows the impartation of a variable face thickness, from the exterior of the club head, after the face insert is attached, as well as creation of a specific bulge and roll, either, or both, of which may also be varied by the selective removal of portions of the ESR face portion **230**, which may be included on the face insert and the surrounding club head, from the exterior.

Further, all of the disclosure with respect to the ESR leading edge portion **220**, applies equally to an ESR top edge portion located at the top of the face and an associated top edge radius, which is analogous to the leading edge radius. Such disclosure is generally applicable to embodiments having a curved face, i.e. having a bulge and/or roll, so that the top edge radius and the machining of the ESR top edge portion produces the desired top edge radius and finished curvature. In one such embodiment the machining of the ESR top edge portion allows precise variability of the top edge radius and/or curvature for customization of the appearance of the club when held at address by a golfer. For instance, machining of the ESR top edge portion facilitates the creation of a club head that appears to have an open or closed face angle even though it is not, or alternatively the appearance of a neutral face angle even though the actual face angle is closed or open. Thus, one skilled in the art will appreciate that the ESR top edge portion allows for incredible customization of the club head for a particular golfer's desired appearance, which can greatly improve performance. Additionally, an ESR top edge portion and/or a ESR crown portion allows the selective machining of these areas to introduce aerodynamic features that are specifically tailored for the swing speed of the purchasing golfer. For instance, any of the aerodynamic features disclosed in U.S. patent application Ser. No. 14/330,205, which is incorporated by reference, may be machined into the ESR top edge portion and/or an ESR crown portion at locations, or orientations, that minimize the aerodynamic drag for a specific swing speed. Similarly, incorporation of the ESR crown portion may facilitate selective machining of the portion to achieve crown curvatures that reduce aerodynamic drag for a particular golfer's swing speed, such as the curvatures disclosed in U.S. patent application Ser. Nos. 15/012,880, 15/002,471, and 15/334,790, which are incorporated by reference.

Additionally, the club head blank **250** has a back portion that may be formed with at least one head engager **300** used to hold the club head blank **250** during machining, as seen in FIGS. **24-27**. A vice **400**, having at least one cooperating vice engager **410**, may be used to hold the club head blank **250** during machining. Further, the disclosed methods may further include the step of machining off the at least one head engager after the desired portions of the desired portions of the external sacrificial region **200** have been removed. In one embodiment the club head blank **250** also includes a secondary head engager **310**, spaced apart from the first head engager **300**, that cooperates with a secondary vice engager **420**, spaced apart from the first vice engager **410**. The engagers may be projections or indentations, or a combination thereof. In one embodiment the at least one head engager **300** projects from the back portion a projection distance of at least 3 mm and has a surface area of at least 35 mm<sup>2</sup>. Additionally, in another embodiment the at least one head engager **300** is located at an elevation above a ground plane that is greater than a height of a center of gravity of the finished club head.

The relationships disclosed herein regarding the ESR removed mass removed from the various portions, the finished club head weight, the ESR thickness, the machining parameters, tools, and associated paths, all preferentially control the amount of heat imparted to the club head during machining, and thus the residual stresses on these surfaces. Further, machining of these contact surfaces may further remove areas plagued by residual stresses imparted to these surfaces during the casting or forging of the club head.

As used herein, the terms "wedge" and "wedge-type golf club" mean any iron-type golf club having a static loft angle that is greater than 45°. Any of the disclosure described herein in relation to a wedge or wedge-type golf club can be embodied in any of various wedges having different loft angles, such as a pitching wedge, gap wedge, sand wedge, lob wedge, flop wedge, and/or wedges having static loft angles of 46°, 48°, 50°, 52°, 54°, 56°, 58°, 60°, greater than 60°, and any other angles greater than 45°. The disclosed technologies and methods may also be applied to iron-type golf clubs having static loft angles of 45° or less, such as a 9-iron or lower-numbered irons, as well as hybrid or rescue clubs having flat or curved faces, fairway woods, drivers, and putters.

The components of the embodiments disclosed herein can be formed from any of various suitable metals, metal alloys, polymers, composites, or various combinations thereof. In addition to those noted elsewhere herein, examples of metals and metal alloys that can be used to form the components include, without limitation, carbon steels (e.g., 1020 or 8620 carbon steel), stainless steels (e.g., 304 or 410 stainless steel), PH (precipitation-hardenable) alloys (e.g., 17-4, C450, or C455 alloys), titanium alloys (e.g., 3-2.5, 6-4, SP700, 15-3-3-3, 10-2-3, or other alpha/near alpha, alpha-beta, and beta/near beta titanium alloys), aluminum/aluminum alloys (e.g., 3000 series alloys, 5000 series alloys, 6000 series alloys, such as 6061-T6, and 7000 series alloys, such as 7075), magnesium alloys, copper alloys, nickel alloys, and tungsten. Examples of composites that can be used to form the components include, without limitation, glass fiber reinforced polymers (GFRP), carbon fiber reinforced polymers (CFRP), metal matrix composites (MMC), ceramic matrix composites (CMC), and natural composites (e.g., wood composites). Examples of polymers that can be used to form the components include, without limitation, thermoplastic materials (e.g., polyethylene, polypropylene, polystyrene, acrylic, PVC, ABS, polycarbonate, polyurethane, polyphenylene oxide (PPO), polyphenylene sulfide (PPS), polyether block amides, nylon, and engineered thermoplastics), thermosetting materials (e.g., polyurethane, epoxy, and polyester), copolymers, and elastomers (e.g., natural or synthetic rubber, EPDM, and Teflon®).

#### Customer Directed Manufacturing

An advantage of forming a club head blank **250** having an external sacrificial region **200** is the ability to use create a number of custom finished club head configurations from a common club head blank **250**. Such customer directed manufacturing may occur remotely, such as by a user configuring a desired combination of club head attributes online to produce a custom finished club head that is manufactured remotely in a plant, or locally, potentially in a retail establishment, via the use of a self-service kiosk **500**. Self-service kiosk **500** embodiments will be described first.

The self-service kiosk **500** includes a kiosk control system **600**, a user input system **700**, a club attribute database **800** in communication with the kiosk control system **600**, locally

stored or remotely accessible, a plurality of club head blanks **250**, and a machining system **1300**, such as a CNC machine or other computer-controlled machining tool, and in some embodiments at least one robotic arm **1400** for moving components within the kiosk **500**. In a simple embodiment the consumer selects a desired product using the user input system **700**, and then selects at least one of a variety of predefined options available in the club attribute database **800** that are specifically filtered for the selected desired product. The predefined options include, but are not limited to, bounce, grind, leading edge height, leading edge offset, score-line pattern, and groove profile. Alternatively, the consumer may simply select a predefined club head that automatically sets all of the predefined options, which in some embodiments the consumer can then edit, such as by increasing or decreasing the attribute values within a fixed adjustment range that is set for the selected product. Further, in another embodiment the kiosk control system **600** may be programmed to present the consumer with a series of questions about the consumers skill level, typical playing conditions, and/or most common mis-hits. The consumer enters their responses with the user input system **700**, the kiosk control system **600** analyzes the responses, and presents the consumer with recommended predefined club heads to select from, which then in some embodiments may present the consumer with the ability to adjust one, or more, attribute values within a fixed adjustment range that is set for the selected product. The kiosk control system **600** then transmits instructions to the machining system **1300**, which then machines the club head and, in some embodiments dispenses the finished club head to the consumer, while in other embodiments the self-service kiosk **500** assembles a finished club head with a shaft and a grip to dispense to the consumer.

The predefined club heads within the club attribute database **800** may include manufacturer recommended club head configurations, and in some embodiments may include configurations that are attributed to a particular touring professional. For instance, the consumer may be able to select a Jason Day design so that all of the predefined options are substantially equal to those of the club heads used by Jason Day. Touring professionals are known to be very particular about the attributes of their club heads and generally require extensive custom contouring of the soles and leading edges. Thus, once the touring professional is satisfied with their custom contouring the club head may be scanned so that all the attributes may be configured for the club head blank **250** and stored in the Jason Day predefined club head within the club attribute database **800**. In an even further embodiment predefined club heads within the club attribute database **800** may include configurations that mimic attributes of popular past club head designs that have been scanned and configured for use with the club head blank **250** to closely replicate attributes such as bounce, leading edge height, sole contact point, and/or grind of the past, often out of production, club head.

Further, the self-service kiosk **500** may include a data acquisition system **900** so that the consumer may bring a preferred existing club head to the kiosk **500** to have attributes mimicked into a new finished club head. For instance, the data acquisition system **900** may include a lie angle measurement system **910**, a swing weight measurement system **920**, a contour acquisition system **930**, and/or a mass property acquisition system **940**. In this embodiment the kiosk control system **600** may prompt the user to hold the preferred existing club as if they are addressing a golf ball. The lie angle measurement system **910** would then, optically

or mechanically, capture the individual customers target lie angle. The contour acquisition system **930** would then capture a 3-D image of the club head in a target orientation. Further, the kiosk control system **600** may then prompt the consumer to position the preferred existing club head on the swing weight measurement system **920** and record a target swing weight; or alternatively the kiosk **500** may simply receive the preferred existing golf club and automatically perform the necessary analysis.

The 3-D image may then be transferred to a contour transformation module, resident either locally in the kiosk control system **600** or remotely on a manufacturer's computer system. The contour transformation module would then analyze the 3-D image, determine how to best fit the attributes of the sole and leading edge onto the club head blank **250**, and create a model for a mimicked club head. In one embodiment the contour transformation module identifies the location of the ground contact point, in the customers target lie angle, with respect to another attribute of the club head, which may be, but is not limited to, the midpoint of the lowest scoreline, or the intersection of the shaft axis with the ground plane. Similarly, the contour transformation module may further identify the leading edge height profile throughout the length of the sole, as well as how the sole is shaped as it moves away from the ground contact point. Since the length and width of the club head blank **250** will be different than that of the preferred existing club head, the contour transformation module will then determine how to best mimic the sole and leading edge attributes of the 3-D image on the club head blank **250**. Further, in some embodiments the contour transformation module may create multiple models that the consumer may then select from. For instance one model may be based upon locating the ground contact point with respect to the center of the face, while another model may be based upon a ground contact point with respect to the shaft axis. Similarly, the kiosk control system **600** may prompt the consumer to indicate which attribute of the preferred existing club head should drive the contour transformation module, such as, but not limited to, the ground contact point, the bounce, the leading edge profile, the leading edge height profile, and/or the grind. In fact, in one embodiment the kiosk control system **600** prompts the consumer to rank several of these attributes in order of importance, which the consumer enters via the user input system **700**, and which is fed to the contour transformation module to influence the creation of the model, which is then ultimately transferred to the machining system **1300**, and in some embodiments may be transferred to a remote club attribute library **1200** that collects data associated with mimicked club heads.

The swing weight measurement system **920** may supply data to a headweight transformation module, resident either locally in the kiosk control system **600** or remotely on a manufacturer's computer system, which is also in communication with the contour transformation module. The swing weight measurement system **920** measures and transmits the swingweight of the preferred existing club to the kiosk control system **600**. The length of the preferred existing club may be acquired by the swing weight measurement system **920**, or another aspect of the kiosk **500**, such as by an image. Regardless, the headweight transformation module utilizes the measured swingweight and club length, and in some embodiments the desired shaft and grip that the consumer has selected for the new golf club, to determine the target head weight of the finished club head. Just as with the other design attributes that, in some embodiments, the consumer has prioritized in significance for the new club head design,

the head weight may be another attribute for consumer prioritization. Either the contour transformation module or the headweight transformation module may then determine if additional mass must be removed from, or added to, the club head, such as, but not limited to, the a sole portion void 5 21.

In further embodiments the kiosk 500 includes a plurality of shafts, grips, ferrules, grip tape, solvent, epoxy, shaft cutting, deburring, and roughening equipment, and application equipment such that the robotic arm(s) 1400 may assemble a complete golf club. 10

For purposes of this description, certain aspects, advantages, and novel features of the embodiments of this disclosure are described herein. The disclosed methods, apparatuses, and systems should not be construed as limiting in any way. Instead, the present disclosure is directed toward all novel and nonobvious features and aspects of the various disclosed embodiments, alone and in various combinations and sub-combinations with one another. The methods, apparatuses, and systems are not limited to any specific aspect or feature or combination thereof, nor do the disclosed embodiments require that any one or more specific advantages be present or problems be solved. 15

As used herein, the terms “a”, “an” and “at least one” encompass one or more of the specified element. That is, if two of a particular element are present, one of these elements is also present and thus “an” element is present. The terms “a plurality of” and “plural” mean two or more of the specified element. As used herein, the term “and/or” used between the last two of a list of elements means any one or more of the listed elements. For example, the phrase “A, B, and/or C” means “A,” “B,” “C,” “A and B,” “A and C,” “B and C” or “A, B and C.” As used herein, the term “coupled” generally means physically coupled or linked and does not exclude the presence of intermediate elements between the coupled items absent specific contrary language. 20 25 30 35

In view of the many possible embodiments to which the principles of this disclosure may be applied, it should be recognized that the illustrated embodiments are only preferred examples and should not be taken as limiting the scope of the inventions. Rather, the scope of the invention is defined by the following claims. We therefore claim all that comes within the scope and spirit of these claims. Whereas the invention has been described in connection with representative embodiments, it will be understood that the invention is not limited to those embodiments. On the contrary, the invention is intended to encompass all modifications, alternatives, and equivalents as may fall within the scope of the invention, as defined by the following claims. 40 45

We claim:

1. A method of creating an iron-type golf club, comprising:

a) forming a club head blank, wherein:

(i) the club head blank includes a body including a hosel, a heel portion, a sole portion, a toe portion, a top-line portion, a face portion, and a leading edge joining the face portion and the sole portion, wherein the sole portion extends rearwardly from the leading edge; 55

(ii) the club head blank includes an external sacrificial region having an ESR thickness, an ESR sole portion, an ESR face portion, and an ESR leading edge portion; 60

b) forming a finished club head having a finished club head weight of less than 310 grams by machining off an ESR removed mass from at least a portion of the external sacrificial region including at least a portion of 65

the ESR sole portion, a portion of the ESR face portion, and a portion of the ESR leading edge portion, wherein:

(i) a face ESR removed mass removed from the ESR face portion accounts for less than 70% of the ESR removed mass;

(ii) a sole ESR removed mass removed from the ESR sole portion accounts for at least 20% of the ESR removed mass;

(iii) at least 50% of the ESR leading edge portion is machined to produce a finished leading edge radius;

(iv) the ESR removed mass is no more than 3.75 grams per degree of loft of the finished club head, wherein the loft is 17-60 degrees; and

(v) a volume of the finished club head is 10-120 cc.

2. The method of claim 1, wherein at least 0.5 grams are removed from the ESR leading edge portion.

3. The method of claim 2, wherein 5-40 grams are removed from the ESR sole portion.

4. The method of claim 3, wherein 0.5-4.0 grams are removed from the ESR leading edge portion, and at least 70% of the ESR leading edge portion is machined.

5. The method of claim 4, wherein 10-50 grams are removed from the ESR face portion.

6. The method of claim 1, wherein the sole ESR removed mass is at least 30% of the face ESR removed mass, at least 90% of the ESR leading edge portion is machined, and the sole ESR removed mass is 30-125% of the face ESR removed mass.

7. The method of claim 6, wherein the ESR removed mass is at least 0.55 grams per degree of loft.

8. The method of claim 1, wherein the ESR removed mass is 10-40% of the finished club head weight.

9. The method of claim 1, wherein the ESR thickness is at least 0.25 mm on a portion of the ESR sole portion and a portion of the ESR face portion, and the ESR thickness of the ESR face portion is no more than 2.5 mm.

10. The method of claim 2, wherein the ESR face portion covers at least 1800 mm<sup>2</sup>, the ESR sole portion covers at least 900 mm<sup>2</sup>, and the ESR leading edge portion covers at least 50 mm<sup>2</sup>.

11. The method of claim 3, wherein the club head blank has a club head blank CG location and the finished club head has a finished club head CG location, and a shortest distance from the club head blank CG location to the finished club head CG location is no more than 2 mm.

12. The method of claim 1, wherein an average face ESR thickness is less than an average sole ESR thickness, and the average face ESR thickness is less than an average leading edge ESR thickness. 50

13. The method of claim 1, wherein the machining off of a portion of the ESR sole portion is performed with a step-over distance of less than 150% of the finished leading edge radius producing a scallop height less than 75% of the finished leading edge radius at a vertical midpoint demarcation plane.

14. The method of claim 13, wherein the step-over distance is 25-100% of the finished leading edge radius producing the scallop height of 15-70% of the finished leading edge radius at the vertical midpoint demarcation plane.

15. The method of claim 1, wherein the machining off of a portion of the ESR leading edge portion is performed along a machine tool path that lies between a vertical front-to-rear plane and a tool path plane that is vertical and within a path angle of the vertical front-to-rear plane, and the path angle is no more than 35 degrees.

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16. The method of claim 15, wherein the machine tool path varies along the ESR leading edge portion.

17. A method of creating an iron-type golf club, comprising:

- a) forming a club head blank, wherein:
  - (i) the club head blank includes a body including a hosel, a heel portion, a sole portion, a toe portion, a top-line portion, a face portion, and a leading edge joining the face portion and the sole portion, wherein the sole portion extends rearwardly from the leading edge;
  - (ii) the club head blank includes an external sacrificial region having an ESR thickness, an ESR sole portion and an ESR leading edge portion;
- b) forming a finished club head having a finished club head weight of less than 310 grams by machining off an ESR removed mass from at least a portion of the external sacrificial region including at least a portion of the ESR sole portion and a portion of the ESR leading edge portion, wherein:
  - (i) a sole ESR removed mass removed from the ESR sole portion is 5-40 grams and accounts for at least 20% of the ESR removed mass;
  - (ii) a leading edge ESR removed mass removed from the ESR leading edge portion is at least 0.5 grams and at least 50% of the ESR leading edge portion is machined to produce a finished leading edge radius;
  - (iii) the ESR thickness is at least 0.25 mm on a portion of the ESR sole portion;

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(iv) the ESR removed mass is no more than 3.75 grams per degree of loft of the finished club head, wherein the loft is 17-60 degrees;

(v) the ESR sole portion covers at least 900 mm<sup>2</sup> and the ESR leading edge portion covers at least 50 mm<sup>2</sup>;

(vi) a volume of the finished club head is 10-120 cc; and

(vii) the club head blank has a club head blank CG location and the finished club head has a finished club head CG location, and a shortest distance from the club head blank CG location to the finished club head CG location is no more than 2 mm.

18. The method of claim 17, wherein 0.5-4.0 grams are removed from the ESR leading edge portion, and at least 70% of the ESR leading edge portion is machined.

19. The method of claim 17, wherein the machining off of a portion of the ESR sole portion is performed with a step-over distance of 25-100% of the finished leading edge radius producing a scallop height of 15-70% of the finished leading edge radius at a vertical midpoint demarcation plane.

20. The method of claim 17, wherein the machining off of a portion of the ESR leading edge portion is performed along a machine tool path that lies between a vertical front-to-rear plane and a tool path plane that is vertical and within a path angle of the vertical front-to-rear plane, and the path angle is no more than 35 degrees.

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