(19) Europäisches Patentamt
European Patent Office
Office européen des brevets

(11) EP 1 321 256 A3

(12) EUROPEAN PATENT APPLICATION

(88) Date of publication A3:
26.05.2004 Bulletin 2004/22

(43) Date of publication A2:
25.06.2003 Bulletin 2003/26

(21) Application number: **02080172.6**

(22) Date of filing: **09.12.2002**

(51) Int Cl.[7]: **B28B 3/12**, B28B 11/08, B28B 11/06, B28B 11/04

(84) Designated Contracting States:
AT BE BG CH CY CZ DE DK EE ES FI FR GB GR IE IT LI LU MC NL PT SE SI SK TR
Designated Extension States:
AL LT LV MK RO

(30) Priority: **21.12.2001 IT RE20010127**

(71) Applicant: **SACMI COOPERATIVA MECCANICI IMOLA Soc. Coop. a r.l.**
40026 Imola (Bologna) (IT)

(72) Inventors:
- **Acerbi, P.,**
  c/o SACMI-Cooperativa Meccanici Imola
  40026 Imola (Bologna) (IT)
- **Valli, S., c/o SACMI-Cooperativa Meccanici Imola**
  40026 Imola (Bologna) (IT)
- **Vandelli, E,**
  c/o SACMI-Cooperativa Meccanici Imola
  40026 Imola (Bologna) (IT)

(74) Representative: **Corradini, Corrado et al**
Studio Ing. C. CORRADINI & C. S.r.l.
4, Via Dante Alighieri
42100 Reggio Emilia (IT)

(54) Method and plant for manufacturing ceramic tiles and slabs, and tiles and slabs obtained thereby

(57) A method for manufacturing construction elements such as ceramic tiles and slabs, consisting of pressing in one or two stages a mass consisting of at least two ceramic materials generally in powder form at least partially mixed together and having different properties, generally different colours, followed by firing of the pressed product, characterised by comprising the following operative steps: separately preparing bodies of generally irregular form starting from at least one ceramic material generally in powder form having properties different from those of said at least two materials of said mass; adding said bodies to said mass before the final pressing; and subjecting the product to a surface finishing operation before or after said firing step.

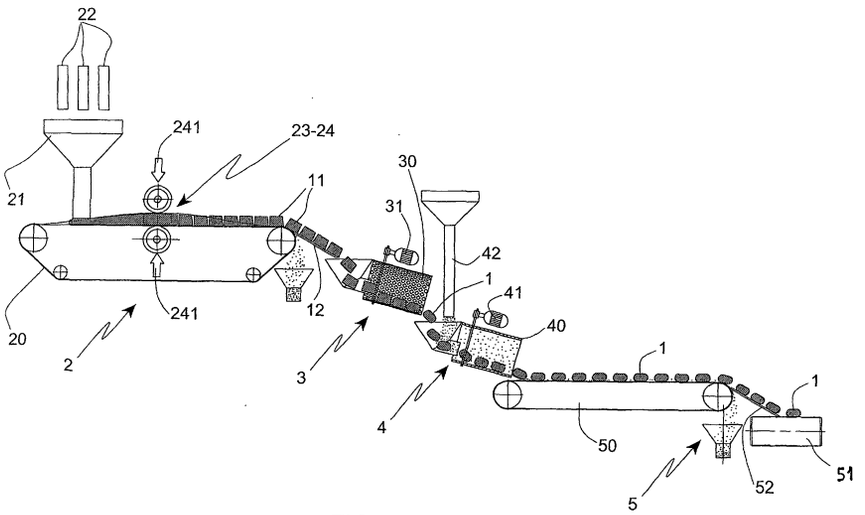


FIG. 1

EP 1 321 256 A3

European Patent Office

EUROPEAN SEARCH REPORT

Application Number
EP 02 08 0172

DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.7)
X	WO 96 15888 A (ALGERI MARIS ;CAMORANI CARLO ANTONIO (IT)) 30 May 1996 (1996-05-30) * page 1, line 1 - line 9 * * page 2, line 24 - line 34 * * page 3, line 31 - line 36 * * page 4, line 11 - line 17 * * page 14, line 32 - line 36 *	1,11-16, 33-35	B28B3/12 B28B11/08
A	* figure 1 *	2-10, 17-32	

X	US 5 976 642 A (YANG DENING) 2 November 1999 (1999-11-02) * column 4, line 41 - line 54 * * column 6, line 19 - line 25 * * column 6, line 35 - line 50 * * claim 14 *	1,11-16, 33-35	
A	* figure 10 *	2-10, 17-32	

X	US 1 390 244 A (DE BAS WILLEM JACOBUS) 6 September 1921 (1921-09-06)	34,35	TECHNICAL FIELDS SEARCHED (Int.Cl.7)
A	* page 1, line 104 - page 2, line 9 *	1-33	B28B B30B

A	DE 719 772 C (GERHARDT RAUPACH DIPL ING) 1 September 1942 (1942-09-01) * page 1, line 1 - line 9 * * page 2, line 10 - line 47 * * figures 1-6 *	2-4, 17-23	

The present search report has been drawn up for all claims

Place of search	Date of completion of the search	Examiner
THE HAGUE	2 April 2004	Real Cabrera, R

CATEGORY OF CITED DOCUMENTS

X : particularly relevant if taken alone
Y : particularly relevant if combined with another document of the same category
A : technological background
O : non-written disclosure
P : intermediate document

T : theory or principle underlying the invention
E : earlier patent document, but published on, or after the filing date
D : document cited in the application
L : document cited for other reasons

& : member of the same patent family, corresponding document

EPO FORM 1503 03.82 (P04C01)

ANNEX TO THE EUROPEAN SEARCH REPORT ON EUROPEAN PATENT APPLICATION NO. EP 02 08 0172

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP file on
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

02-04-2004

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
WO 9615888 A	30-05-1996	IT M0940159 A1	22-05-1996
		AU 4174396 A	17-06-1996
		BR 9509806 A	21-10-1997
		CN 1173154 A ,B	11-02-1998
		DE 69529997 D1	24-04-2003
		WO 9615888 A1	30-05-1996
		EP 0793565 A1	10-09-1997
US 5976642 A	02-11-1999	CN 1153751 A	09-07-1997
		AU 686080 B3	29-01-1998
		AU 2564797 A	22-10-1997
		WO 9736840 A1	09-10-1997
		DE 29705844 U1	28-05-1997
		FR 2747385 A1	17-10-1997
		IT 1290513 B1	04-12-1998
		JP 10114576 A	06-05-1998
US 1390244 A	06-09-1921	NONE	
DE 719772 C	01-09-1942	NONE	

EPO FORM P0459

For more details about this annex : see Official Journal of the European Patent Office, No. 12/82