

FORM 2

THE PATENTS ACT, 1970
(39 of 1970)
AND
THE PATENTS RULES, 2003

**COMPLETE
SPECIFICATION**

(See Section 10; rule 13)

TITLE OF THE INVENTION

“PANEL FORMING”

APPLICANT

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The following specification particularly describes
the invention and the manner in which
it is to be performed

CLAIMS

1. Method for producing a panel (1) with a wood based core (3) and a surface
5 layer (2) comprising a thermosetting resin wherein the method comprising the steps of:
- curing and connecting the surface (2) layer to the core (3) while applying heat and pressure in a first main pressing step, thus raising a temperature of the surface layer above an initial temperature;
 - 10 • applying a bending force (F) on the panel (1) after the first main pressing step to bend the panel such that an uppermost surface of the panel is convex and a lowermost surface of the panel is concave while the panel is still above the initial temperature; and
 - 15 • releasing the bending force such that the panel springs back to an essentially flat shape.
2. The method as claimed in claim 1, wherein the method further comprises the step of decreasing the surface temperature during bending.
3. The method as claimed in claim 2, wherein the surface temperature decrease is about 20 C°.
- 20 4. The method as claimed in claim 2, wherein the surface temperature decrease is more than 20 C°.
5. The method as claimed in any one of the claims 1-4, wherein the thermosetting resin is a melamine formaldehyde resin
6. The method as claimed in any one of the claims 1-5, wherein the bending
25 (B) is at least about 3 cm/m.
7. The method as claimed in any one of the preceding claims, wherein the surface layer comprises wood fibres and wear resistant particles.
8. The method as claimed in any one of the preceding claims, wherein the surface layer comprises impregnated paper bonded to an HDF core.

9. The method as claimed in any one of the preceding claims, wherein the surface layer comprises wood fibres, wear resistant particles and colour pigments.
- 5 10. The method as claimed in any one of the preceding claims, wherein the surface layer comprises a powder based layer, the powder comprising wood fibres, wear resistant particle and colour pigments.
11. The method as claimed in any one of the preceding claims, wherein the bending force is applied to at least two opposite edge portions of the panel.
- 10 12. The method as claimed in any one of the preceding claims, wherein the panel is rectangular and the bending force is applied to both sets of opposite edge portions of the panel.
13. The method as claimed in any one of the preceding claims, wherein the bending force is applied with a first press table on the uppermost surface of
- 15 the panel and a second press table on the lowermost surface of the panel.
14. The method as claimed in press table, wherein the first and second press tables are curved in two perpendicular directions, such that bending is made along and across the panel.
15. The method as claimed in any one of the preceding claims, wherein the
- 20 panel is a building panel.
16. The method as claimed in any one of the preceding claims, wherein the panel is a floor panel.
17. A floor panel comprising a wood based core (3) provided with a surface layer (2) on the front face, said surface layer comprises a thermosetting resin,
- 25 characterized in that the panel is produced according to the method in anyone of the claims 1-10 and that the back face has no balancing layer,
18. The floor panel as claimed in claim 17, wherein the back face is the wood based core (3).

19. The floor panel as claimed in claim 17 or 18, wherein the panel is a DPL panel comprising a surface layer (2) of impregnated paper bonded to a HDF core.

20. The floor panel as claimed in claim 17 or 18, wherein the panel is a WFF
5 panel comprising a powder based surface layer (2).

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Dated this 21 day of March 2014

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