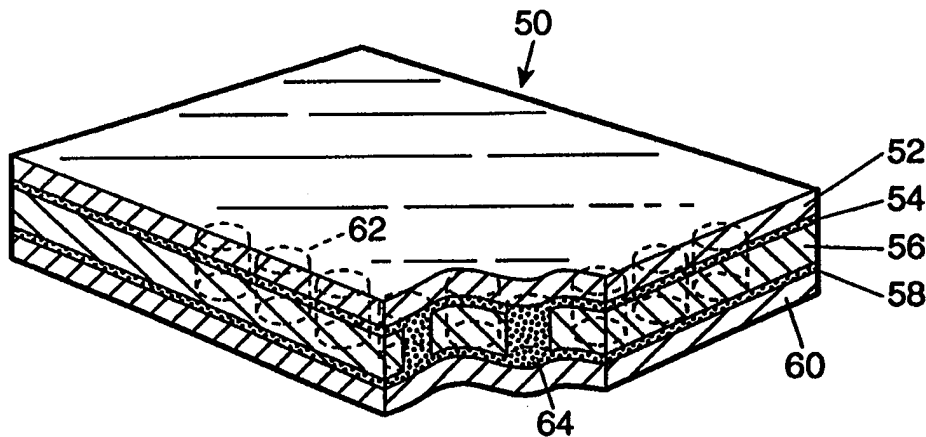




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<p>(21) International Application Number: PCT/CA98/00265 (22) International Filing Date: 10 February 1998 (10.02.98) (30) Priority Data: 60/038,816 10 February 1997 (10.02.97) US 08/947,030 8 October 1997 (08.10.97) US (71) Applicant (for all designated States except US): DOFASCO INC. [CA/CA]; P.O. Box 2460, Hamilton, Ontario L8N 3J5 (CA). (72) Inventor; and (75) Inventor/Applicant (for US only): CLIFFORD, David, D'Arcy [CA/CA]; 24 Hyslop Drive, Caledonia, Ontario N3W 2L2 (CA). (74) Agents: SCHMIDT, Ingrid, E. et al.; Rogers & Scott, 214 Randall Street, Oakville, Ontario L6J 1P7 (CA).</p>	<p>(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, GH, GM, GW, HU, ID, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, US, UZ, VN, YU, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).</p> <p>Published <i>With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i></p>	

(54) Title: STRUCTURAL PANEL WITH KRAFT PAPER CORE BETWEEN METAL SKINS



(57) Abstract

A structural panel (10, 12, 30, 50, 70) comprises a metal and paper composite in which the metal outer skins (22, 32, 40, 52, 60) have a minimum thickness of 0.005 in. (1.0 mm) exceeding foils and a preferred maximum thickness of 0.012 in. (0.3 mm) while the paper core (20, 36, 56) ranges between 0.01 in. (0.2 mm) and 0.05 in. (1.3 mm). The panel is a stiff, lightweight substitute for thicker metals and may replace light metal sheets such as aluminum with a composite in which the metal skins comprise sheets from heavier metals such as steel. The paper core (20, 36, 56) is adhesively bonded to the metal skins and may have openings (62) to create paths for adhesive bridges (64) between the metal skins (22, 32, 40, 52, 60) to minimize failure caused by buckling.

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STRUCTURAL PANEL WITH KRAFT PAPER CORE
BETWEEN METAL SKINS

TECHNICAL FIELD

5 This invention relates to laminating kraft paper between very thin sheets of metal and, more particularly, steel to produce a composite sheet having improved stiffness with little additional cost or weight.

10 BACKGROUND ART

 Sheets of steel are used in a multitude of applications where strength, durability and ease of manufacture are required at low cost. For example, sheets of steel are used in vehicle bodies, appliances, furniture, construction and packaging. An important
15 measure of a sheet steel's performance is its resistance to elastic deflection, otherwise known as stiffness.

 For applications where high stiffness is needed, the thickness of sheet steel must be increased proportionately to the stiffness requirements. The extra material thickness provides
20 additional resistance to elastic deflection. However, increasing the sheet steel's thickness negatively impacts both the cost and weight of the final product.

 Thus, while the cost of steel is significantly lower than the cost of aluminum, aluminum has become the material of choice for
25 applications where the weight of the final product is critical. Still more reductions in weight are achieved in construction materials comprising aluminum composite panels having a polymer core and outer metal skins made of aluminum sheet. Such panels find application, for example, in the construction of vehicular trailer

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bodies as disclosed in US 4,958,472 and US 4,940,279.

It has been recognized that the increased strength-to-weight ratio achieved in such composite panels results from the physical separation of the outer skins, and that a filler material or core material may not be required. In WO96/23621, it is proposed to create hollow panels in which a separation between two sheets of steel is maintained by hemispherically shaped domes formed in one sheet of steel which is selectively welded to an adjacent sheet of steel.

On the other hand, applicant is not aware of any proposals to maintain stiffness in composite panels by substituting alternative core materials for polymer cores. Applicant is also unaware of any proposals to create laminated structural panels in which the outer skins are made of steel. Those applications in which metal laminated to paper are known include *inter alia* metal clad wiring cards to support electronic components such as in US 4,314,002 where paper is used because of its contribution to dielectric properties and provides no structural advantage. In other known metal and paper laminates, such as wrapping materials disclosed in US 3,055,768, the metal is a very thin aluminum foil which has no structural utility.

An object of this invention is to increase the stiffness of sheet metal for use in structural applications of the kind mentioned above, without adding excessive cost or weight.

DISCLOSURE OF INVENTION

In accordance with this invention, there is provided a structural panel comprising outer skins of sheet metal laminated to a paper core. The metal skins are thicker than foils and have a

minimum thickness of 0.005 in. (0.1 mm). Preferably, the metal skins are also thinner than cards and have a maximum thickness of 0.012 in. (0.3 mm). The paper core "sandwiched" between the metal skins is relatively thick and has a minimum thickness of 0.01 in. (0.2 mm) and will usually not exceed 0.05 in. (1.3 mm.).

Preferably, the metal skins are sheet steel and the paper core comprises a single web of kraft paper which has a plurality of openings for creating paths for adhesively bridging the outer skins and to optimize resistance to failure resulting from buckling.

10

DESCRIPTION OF DRAWINGS

In order to better understand the invention, preferred embodiments are described below with reference to the accompanying drawings, in which:

- 15 Fig. 1 is a schematic cross-sectional view of a first embodiment of the invention comprising a single ply core of paper;
- Fig. 2 is a schematic cross-sectional view of a second embodiment of the invention comprising a
- 20 double-ply core of paper;
- Fig. 3 is a graphical representation showing the relative thickness of metal skins and paper cores for the invention (shaded area) and prior art (unshaded areas);
- 25 Fig. 4 is a graphical representation of stiffness in a beam;
- Fig. 5 (drawn above Fig. 4) is a schematic representation of the application of a load to a beam to measure stiffness;

- Fig. 6 is an enlarged fragmentary perspective view of a laminate in accordance with the invention, without any adhesive bridges;
- Fig. 7 is an enlarged perspective view, partially cut away, of a laminate in accordance with the invention with adhesive bridges;
- Fig.8a is a schematic representation of the application of a load to a beam to show the neutral axis of bending;
- Fig.8b is a plan view of a web of paper showing the machine direction of paper parallel to the neutral axis of bending;
- Fig.9a is a schematic representation of the application of a load to a beam to show the neutral axis of bending;
- Fig.9b is a plan view of a web of paper showing the machine direction of paper perpendicular to the neutral axis of bending;
- Fig.10 is a schematic representation of a laminate (without adhesive bridges) in accordance with the invention exhibiting a skin buckle failure;
- Fig.11 is a schematic representation of a laminate having adhesive bridges under a compressive load and resisting skin buckle failure;
- Fig.12 is a graphical representation showing the strength improvement of a laminate made in accordance with the invention with adhesive bridges;
- Figs.13 to 17 are graphical representations showing the stiffness

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of various laminates made in accordance with the invention and an aluminum sheet; and

Fig.18 (drawn adjacent Fig. 2) is a schematic cross-sectional view showing an application of a laminate in accordance with the invention as the exterior skin in association with a polymer core.

BEST MODE FOR CARRYING OUT THE INVENTION

The elastic deflection of a beam, plate or sheet is inversely proportional to the moment of inertia created by the beam, plate or sheet around its axis of deflection. The elastic stiffness of a metal sheet can therefore be increased substantially by increasing the moment of inertia of a metal sheet around its axis of deflection. Conventionally, this is done by increasing the thickness of the metal sheet.

An economical alternative to increasing the metal sheet's thickness, which is proposed by this invention, is to laminate successive sheets of low-cost kraft paper between the exposed sheets of metal, thereby increasing the moment of inertia of the composite sheet and increasing the stiffness of the composite sheet substantially.

The layers of paper may be bonded to each other and to the metal sheets with an adhesive having the necessary bond strength and mechanical characteristics to prevent slippage between the laminating layers, or delamination of the laminating layers from the metal sheets.

In its simplest embodiment, drawn in Fig. 1, a structural panel 10 according to the invention comprises a single web of kraft paper 20 sandwiched between two metal sheets 22, the paper being

bonded to the metal sheets on respective sides thereof with a layer of adhesive 24.

Alternatively, the paper core may comprise a plurality of paper webs 20 adhesively bonded to each other and to the outer metal sheets 22, as shown schematically by the structural panel 12 shown in Fig. 2.

It will be understood that bonding of the paper webs in a paper core and bonding of the paper core to the metal skins may be provided by any suitable adhesive material and may, for example, include resin impregnation of the paper core.

As indicated above, the invention provides a means to maintain stiffness while reducing weight thereby allowing thinner metals to be used without compromising performance. By way of example, the description which follows is directed to laminates of sheet steel and paper to show that such composites are viable alternatives to aluminum sheets alone. It will be understood that laminates comprising sheets of metals other than steel and paper are expected to exhibit commensurate improvements in stiffness without the additional cost and weight of increasing the thickness of the metal.

In order for the invention to be suitable as a structural panel, and provide reasonable economic benefits, applicant has determined that the outer metal skins will preferably have a thickness ranging between 0.005 in. (0.1 mm.) and 0.012 in. (0.3 mm.) while the paper core will have a minimum thickness of 0.01 in. (0.2 mm.) and a practical maximum thickness of 0.05 in. (1.3 mm). A range of product covered by the invention is graphically illustrated by the shaded area drawn in Fig. 3 while the unshaded boxed areas show prior art laminates of metal and paper known to

the Applicant. It will be understood that the minimum thickness of 0.005 in. (0.1 mm.) is representative of the practical lowest thickness range to which steel sheet can be rolled without the additional processing costs of producing a so-called "foil".

5 Please note that all thicknesses have been determined in empirical units, the metric equivalent in brackets being provided for convenience only.

10 Table I which follows shows the thickness of aluminum sheet required to provide an equivalent stiffness for various combinations of steel sheet and paper having thicknesses representing the extremities of the shaded area of Fig. 3.

TABLE 1
SHEET THICKNESS FOR EQUIVALENT STIFFNESS

STEEL SKINS	PAPER CORE	COMPOSITE PANEL (EXCLUDING ADHESIVE)	->	AL SHEET
.005" (0.1 mm.)	.01" (0.2 mm.)	0.020" (0.4 mm.)	->	.027" (0.7 mm.)
.012" (0.3 mm.)	.01" (0.2 mm.)	0.034" (0.8 mm.)	->	.048" (1.2 mm.)
.005" (0.1 mm.)	.05" (1.3 mm.)	0.06" (1.5 mm.)	->	.064" (1.6 mm.)
.012" (0.3 mm.)	.05" (1.3 mm.)	0.074" (1.9 mm.)	->	.093" (2.4 mm.)

25 It will be observed that the cumulative thickness of a composite panel of the kind shown in Fig. 1 is always less than the

thickness of aluminum sheet having equivalent stiffness. Simple calculations will suffice to persuade those skilled in the art that enormous cost savings may be achieved without the weight penalty usually attributed to steel sheets of equivalent stiffness.

5 It will be understood by those skilled in the art that the term "stiffness" is a measure of the ratio of load to deflection or resistance to elastic or recoverable bending. For clarity, a graphical representation of stiffness is drawn in Fig. 4 adjacent to a schematic illustration drawn in Fig. 5 showing the application of a load L to a
10 sample beam B to produce a deflection D.

 Selected experiments performed by the Applicant are shown in Table 2 and comprise Examples 1 to 5, each corresponding to a laminate structure for which the stiffness was measured and compared to an aluminum sheet having a thickness of 0.062 in. (1.6
15 mm.) The results are shown graphically in Figs. 13 to 17.

 Applicant has conducted numerous experiments to show the utility of the proposed structural panel in accordance with the invention as a substitute for aluminum sheet. The experiments were performed on laminated panels in which the outer metal skins
20 are sheets of low carbon uncoated steel with a nominal thickness of 0.0074 in. (0.2 mm.) laminated to a core comprising a single web of kraft paperboard. Exemplary structures are shown in Figs. 6 and 7.

 In Fig. 6, the laminate is generally indicated by reference numeral 30 and comprises the following sequential layers: a first
25 outer skin of sheet steel 32, a first adhesive layer 34, a kraft paperboard core 36, a second adhesive layer 38, and a second outer skin of sheet steel 40. A laminate of this kind was used in Example 2.

 The laminate used in the remaining Examples 1, 3-5, is
30 generally indicated by reference numeral 50 in Fig. 7 and, similarly, comprises the following sequential layers: a first outer skin of sheet metal 52, a first adhesive layer 54, a kraft paperboard core 56, a

TABLE 2

	EXAMPLE 1	EXAMPLE 2	EXAMPLE 3	EXAMPLE 4	EXAMPLE 5
STEEL SKIN THICKNESS	.0074" (0.19 mm.)	.0074" (0.19 mm.)	.0074" (0.19 mm.)	.0074" (0.19 mm.)	.0074" (0.19 mm.)
STEEL SKIN GRADE	Low carbon, uncoated	Low carbon, uncoated	Low carbon, uncoated	Low carbon, uncoated	Low carbon, uncoated
CORE WEIGHT	389 g/m ²	423 g/m ²	648 g/m ²	422 g/m ²	755 g/m ²
CORE THICKNESS	.028" (0.7 mm.)	.028" (0.7 mm.)	.039" (1 mm.) (including resin)	.028" (0.7 mm.)	.045" (1.1 mm.) (including resin)
ORIENTATION	Perpendicular	Parallel	Parallel	Parallel	Perpendicular
RESIN IMPREGNATION	None	None	40-50 wt% Phenol	None	40-50% Phenol
ADHESIVE TYPE	Urethane base	Urethane base	Urethane base	Water base	Water base
ADHESIVE SPREAD (both sides)	410 g/m ²	370 g/m ²	480 g/m ²	300 g/m ²	350 g/m ²
BRIDGING	1mm diameter	None	1mm diameter	1mm diameter	1mm diameter

second adhesive layer 58, and a second outer skin of sheet metal 60. However, in this structure, the kraft paperboard core 56 is perforated and has a matrix of circular openings 62 punched from the paper, each opening 62 having a nominal diameter of 1mm
5 (which could range between 0.5 - 2.0mm) and being spaced from adjacent openings at approximately 6.4mm intervals in longitudinal and transverse directions of the kraft paperboard core 56.

The openings 62 define paths for adhesively bridging the outer metal skins 52, 60 to each other, adhesive bridges 64
10 comprising columns of adhesive material oriented transversely to the layers of adhesive 34, 38 and integrally connected to such adhesive layers being provided to maintain the integrity of the laminated structure.

The paperboard core 56 used in the examples 1-5 is
15 designated as a kraft paper which signifies that the pulp for forming the paper is produced using a sulfate process, typically caustic sodium hydroxide and sodium sulfide to delignify wood chips under high pressure and temperature in a digester which results in a pulp with a higher cellulose content and better bonding than paper made
20 from a mechanical pulp. The kraft paperboard was sourced from Westvaco Corporation and is sold in association with the trademarks **Kraftpak** and **Durasorb**. **Kraftpak** and **Durasorb** are registered trademarks of Westvaco Corporation.

It will be appreciated that cellulose fibers will align in a
25 "machine direction" during production of the paper and that the orientation of the paper in the laminates is a factor which will affect the stiffness and strength of the laminate. The examples show that the laminates exhibit better performance when the machine direction of the kraft paper is aligned parallel to a neutral axis of

bending (Fig. 8) than when the machine direction of the kraft paper is perpendicular to a neutral axis of bending (Fig. 9).

Another important factor affecting the performance of the laminates is the presence of the adhesive bridges 64. Without the bridging, the integrity of the laminate is susceptible to failure, in particular from a defect known as "buckling" and schematically shown in Fig. 10 and resulting from a compressive stress on the top skin during bending of the laminate. Here the fibers in the paper core become separated and there is a local delamination of the paper. This is in contrast with a mode of failure known as a "wrinkle" where there is a localized buckling of the outer skin only and the wavelength of the buckle is of the same order of magnitude as the core.

By selectively spacing the openings 62 in the paper core so that adhesive bridges 64 are spaced from each other, within an estimated range of buckle wavelengths, as shown schematically in Fig. 11, one can optimize resistance to failure of the laminate resulting from buckling. The improved performance realized in a laminate having adhesive bridges 64 of the kind drawn in Fig. 7 when compared to a laminate without such adhesive bridges (Example 2) of the kind drawn in Fig. 6 is shown graphically in Fig. 12. However, since the theory of elastic buckling teaches that a buckle wavelength is dependent on sample geometry, the required maximum spacing of the openings 62 will have to be calculated on a case-by-case basis in accordance with the intended application of the laminate.

The examples also show that the kraft paperboard core may optimally be impregnated with resin to improve performance (Example 3) but that adequate performance may be achieved without

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resin impregnation (Example 1) and without the associated cost of such impregnation. As indicated above, the resin selected may also function as an adhesive.

5 The nature of the adhesive is also expected to be a factor which will affect performance as shown by Examples 4 and 5 where a water-based adhesive is used while a urethane-based adhesive is used in the remaining Examples 1 to 3.

INDUSTRIAL APPLICABILITY

10 It will be appreciated that a structural panel made with a laminate in accordance with the invention will be dimensioned in accordance with the intended application and will have reinforcements where required to facilitate mounting of the panels to an underlying structure such as a framework. It is believed that a
15 structural panel in accordance with the invention will find application wherever sheet metal is used and that it could replace such sheets whether they are used with both surfaces essentially exposed or whether they are themselves part of a composite panel 70 and bonded to a supplementary polymer core 72 so that the
20 composite panel of the invention defines the outer skins 74. Such a structure is shown schematically in Fig. 18.

Several variations may be made to the above-described embodiments of the invention within the scope of the appended claims. It will be appreciated that the outer metal skins (22, 32, 40,
25 52, 60) may be made from metals other than steel and could, for example, comprise aluminum or copper alloys. The metal skins may also comprise sheet steel selected from the following: cold rolled steel, galvanized steel, tin-coated steel, and stainless steel, including zinc aluminum alloyed castings and paint coatings in said

sheets, without limitation.

Further, it will be understood that some sheet metals may be more desirable as skins for use in structural panels, according to the invention, than others. For example, it is envisaged that single-sided galvanized sheet may be preferred in some applications where an outer, galvanized, surface is required for improved weather resistance and an inner plain steel surface, without galvanizing or coating, is desirable for improved adhesion to the paper core.

Applicant also foresees that the outer metal skins may conveniently comprise galvanized steel sheet which is subsequently cold-rolled to a minimum acceptable thickness for the intended application without any subsequent annealing.

CLAIMS

1. A structural panel (10, 12, 30, 50, 70) characterized by:
first and second skins of sheet metal (22, 32, 40, 52, 60)
having a thickness of at least 0.005 in. (0.1 mm);
5 a paper core (20, 36, 56) sandwiched between said skins of
sheet metal (22, 32, 40, 52, 60), the paper core (20, 36, 56) having a
thickness of at least 0.015 in. (0.4 mm).
2. A structural panel (10, 12, 30, 50, 70) characterized by
10 first and second skins of sheet metal (22, 32, 40, 52, 60) having a
thickness of 0.005 in. (0.1 mm.) to 0.012 in. (0.3 mm.) and a paper
core (20, 36, 56) adhesively bonded between said skins, the paper
core having a thickness of at least 0.01 in. (0.2 mm.)
- 15 3. A structural panel (10, 12, 30, 50, 70) according to either
Claim 1 or Claim 2 in which the sheet metal (22, 32, 40, 52, 60) is
steel sheet selected from the following group: cold rolled steel,
galvanized steel, tin-coated steel, and stainless steel.
- 20 4. A structural panel (10, 12, 30, 50, 70) according to either
Claim 1 or Claim 2 in which the sheet metal (22, 32, 40, 52, 60) is
aluminum sheet.
- 25 5. A structural panel (10, 12, 30, 50, 70) according to either
Claim 1 or Claim 2 in which the paper core (20, 36, 56) comprises a
single web of paper.
6. A structural panel according to Claim 5 in which the
machine direction of the paper web (20, 36, 56) is aligned parallel to

the neutral axis of bending expected from using the panel.

5 7. A structural panel (10, 12, 30, 50, 70) according to either Claim 1 or Claim 2 in which the paper core (20, 36, 56) comprises a plurality of webs of paper.

8. A structural panel (10, 12, 30, 50, 70) according to either Claim 1 or Claim 2 in which the paper core (20, 36, 56) is impregnated with resin.

10

9. A structural panel (10, 12, 30, 50, 70) according to either Claim 1 or Claim 2 in which the paper core (20, 36, 56) has a plurality of openings (62) formed therein defining paths for adhesively bridging said first and second skins of sheet metal (22, 32, 15 40, 52, 60).

10. A structural panel (10, 12, 30, 50, 70) according to Claim 9 in which the openings (62) are selectively spaced from each other to optimize resistance to failure resulting from buckling.

20

11. A structural panel (10, 12, 30, 50, 70) characterized by:
first and second skins of sheet metal (22, 32, 40, 52, 60):
a paper core (20, 36, 56) sandwiched between said skins of
sheet metal (22, 32, 40, 52, 60), the paper core (20, 36, 56) having a
25 plurality of openings (62) formed therein extending between said
first and second skins of sheet metal;

and adhesive bridges (64) comprising adhesive material (24)
disposed in said openings (62) and adhesively bonding said first and
second skins of sheet metal (22, 32, 40, 52, 60) to each other.

12. A structural panel (10, 12, 30, 50, 70) characterized by:
first and second skins of sheet metal (22, 32, 40, 52, 60)
having a thickness of at least 0.005 in. (0.1 mm);
a paper core (20, 36, 56) sandwiched between said skins of
sheet metal (22, 32, 40, 52, 60), the paper core (20, 36, 56) having a
thickness of at least 0.015 in. (0.4 mm.) and having a plurality of
openings (62) formed therein extending between said first and
second skins of sheet metal;
and adhesive bridges (64) comprising adhesive material (24)
disposed in said openings (62) and adhesively bonding said first and
second skins of sheet metal (22, 32, 40, 52, 60) to each other).

13. Structural panel (10, 12, 30, 50, 70) characterized by:
first and second skins of steel sheet (22, 32, 40, 52, 60)
having a thickness of at least 0.005 in. (0.1 mm) to 0.012 in. (0.3
mm.);
a paper core (20, 36, 56) sandwiched between said skins of
steel sheet (22, 32, 40, 52, 60), the paper core (20, 36, 56) having a
thickness of at least 0.015 in. (0.4 mm.) and having a plurality of
openings (62) formed therein extending between said first and
second skins of steel sheet;
and adhesive bridges (64) comprising adhesive material (24)
disposed in said openings (62) and adhesively bonding said first and
second skins of steel sheet (22, 32, 40, 52, 60) to each other).

25

Fig 1

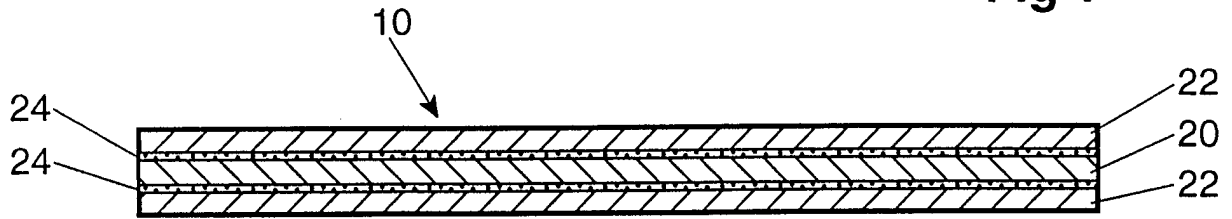


Fig 2

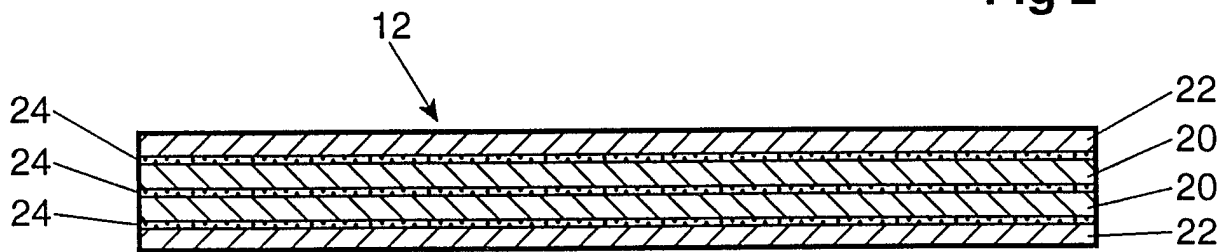


Fig 18

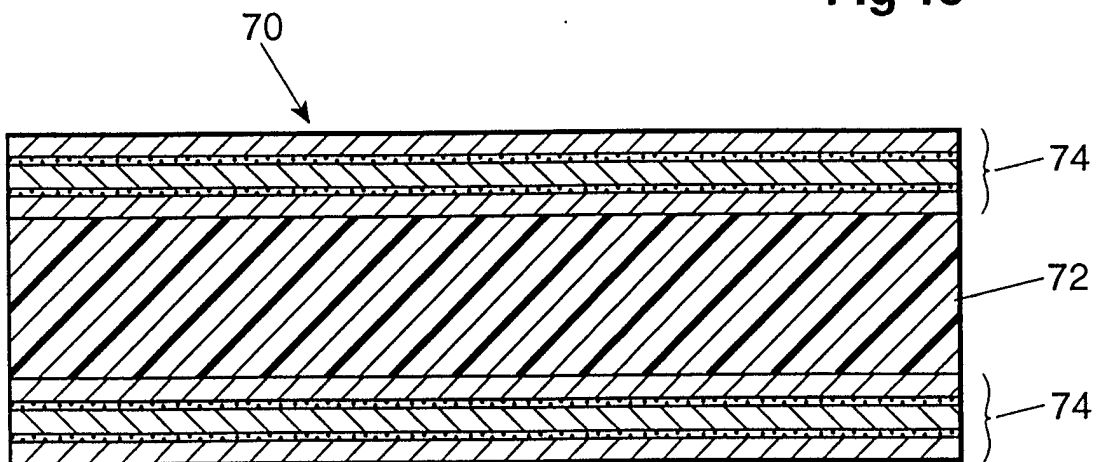
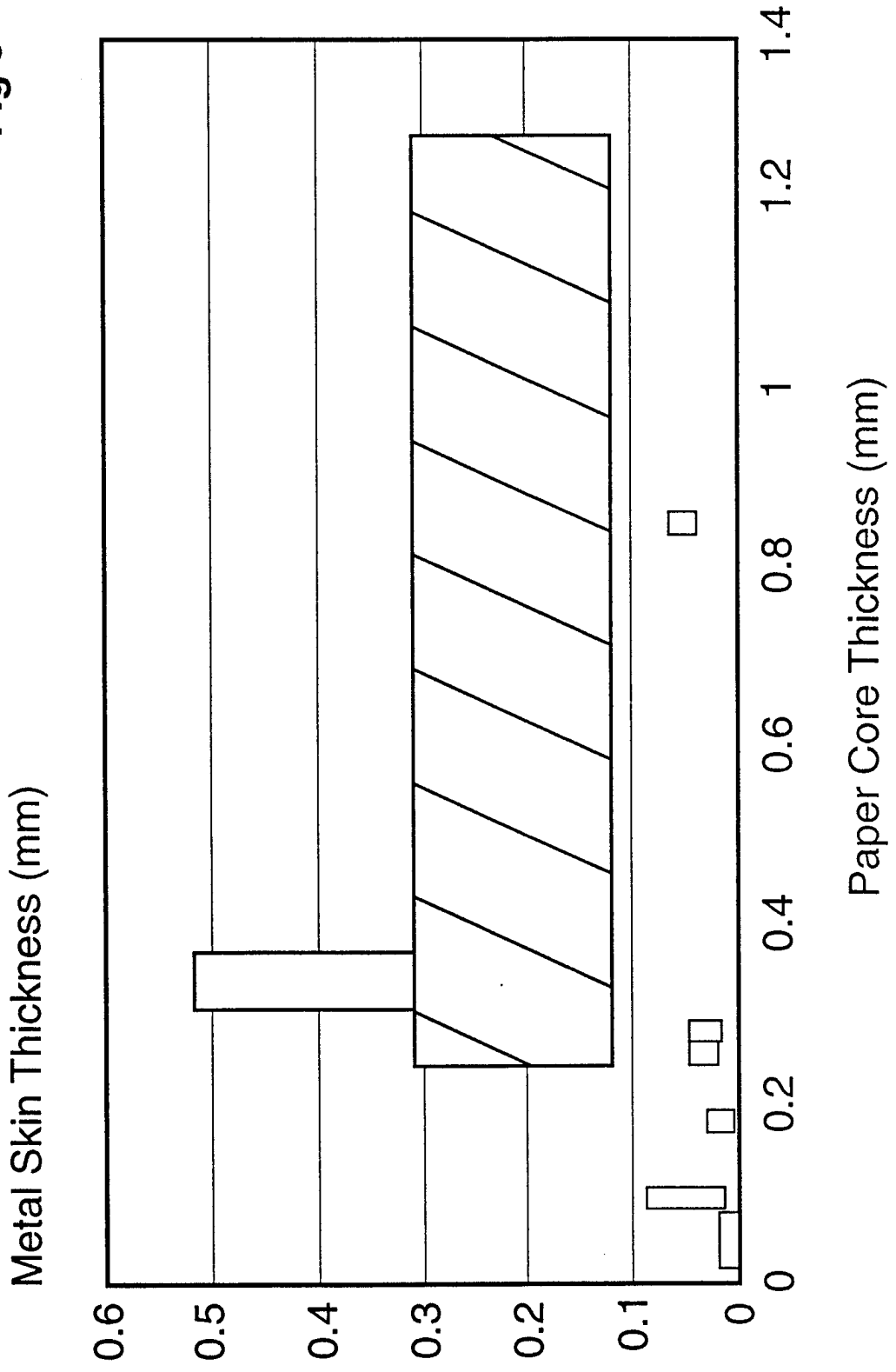


Fig 3



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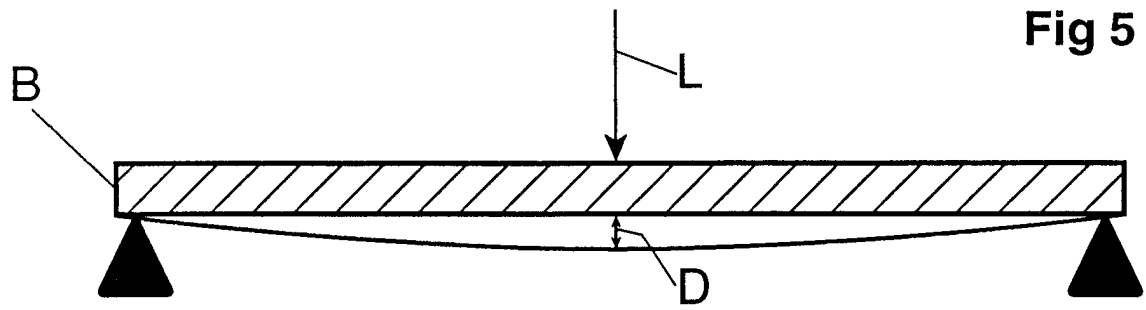


Fig 4



Fig 6

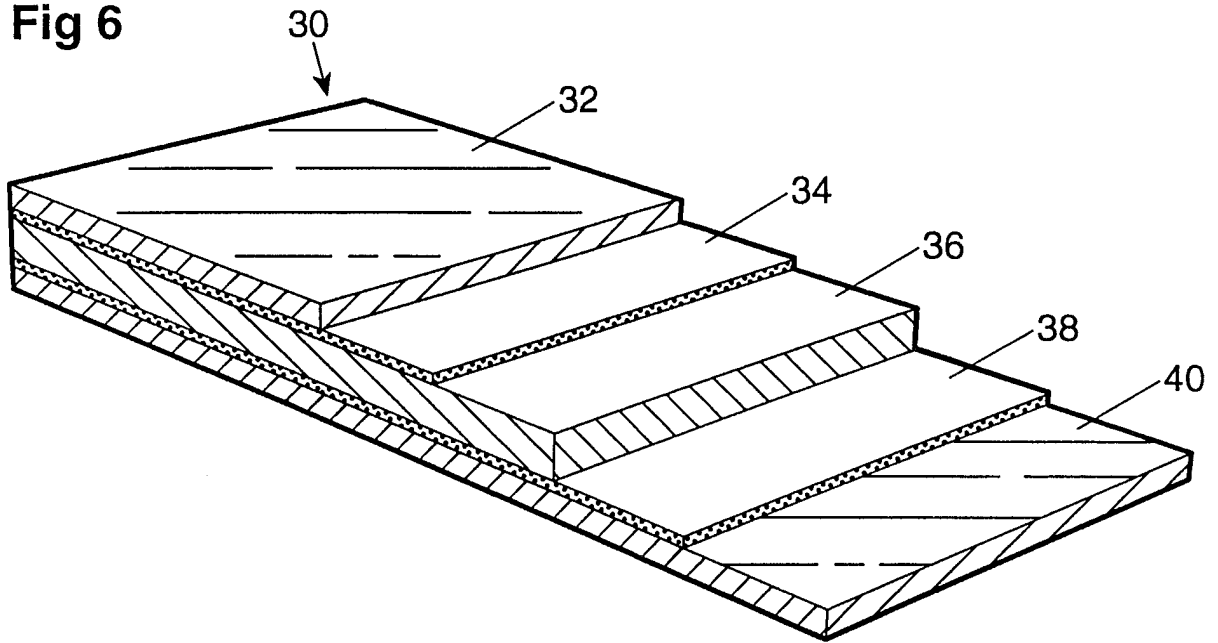


Fig 7

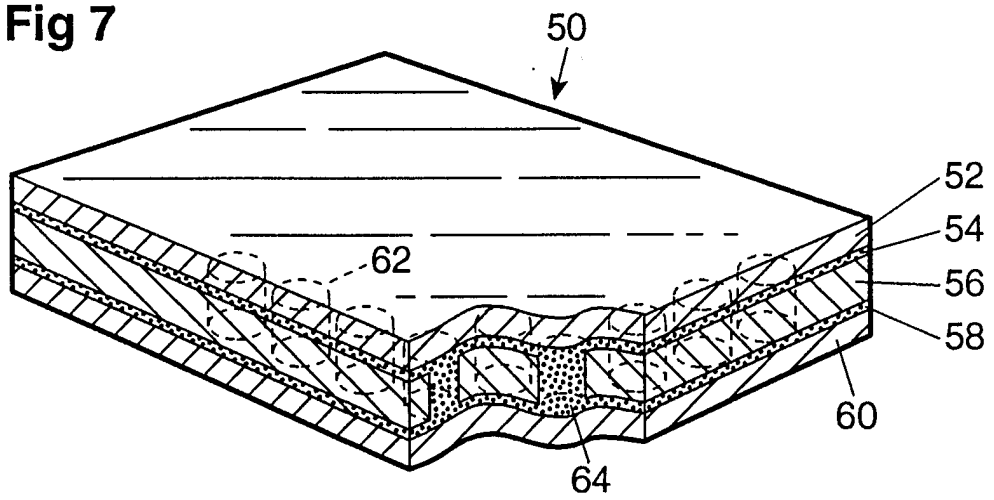


Fig 8

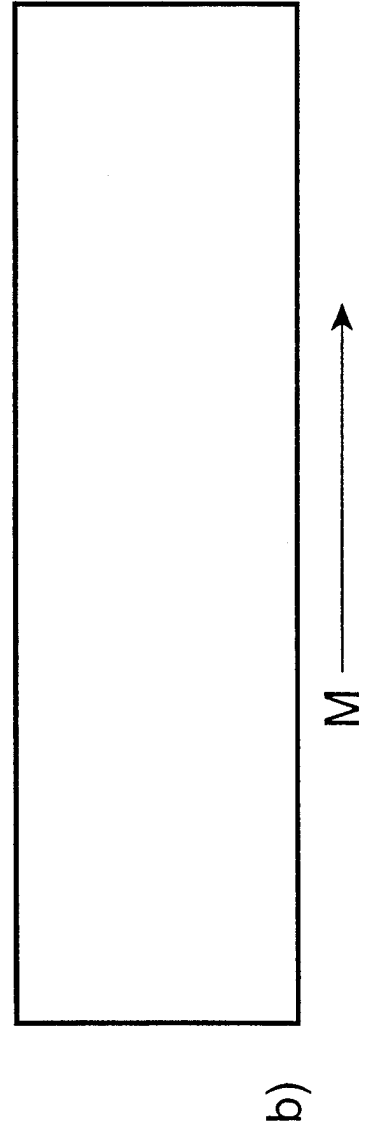
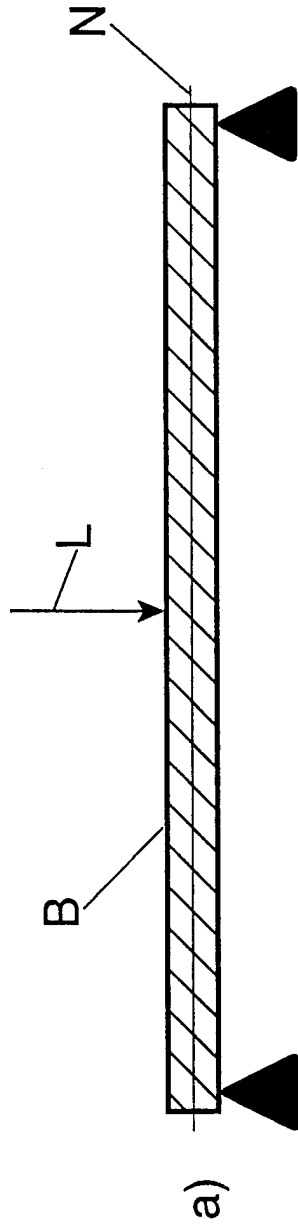
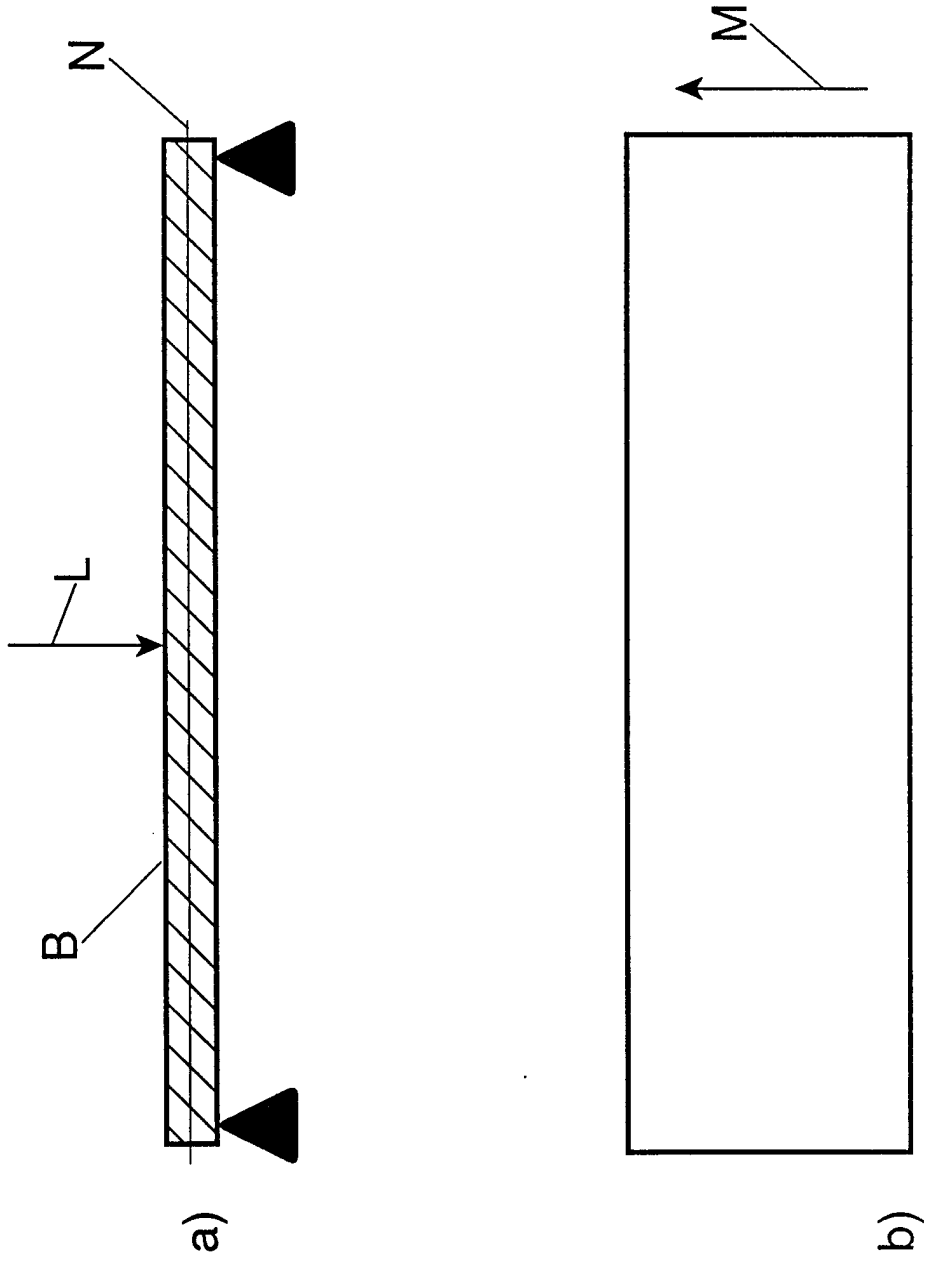


Fig 9



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Fig 10

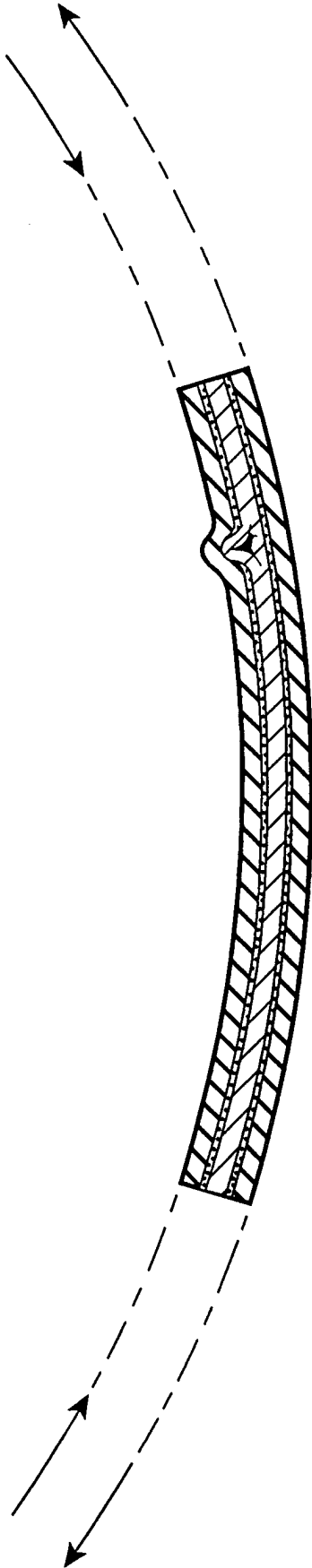
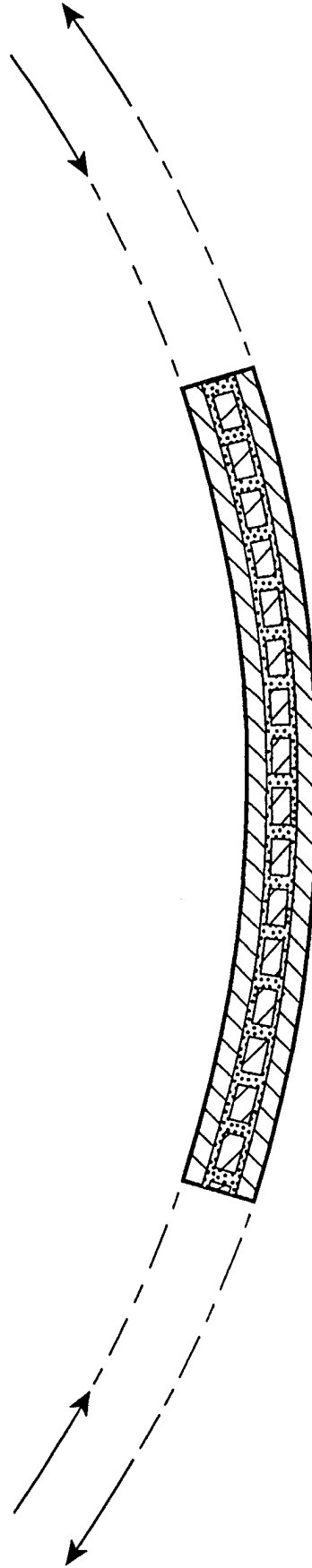
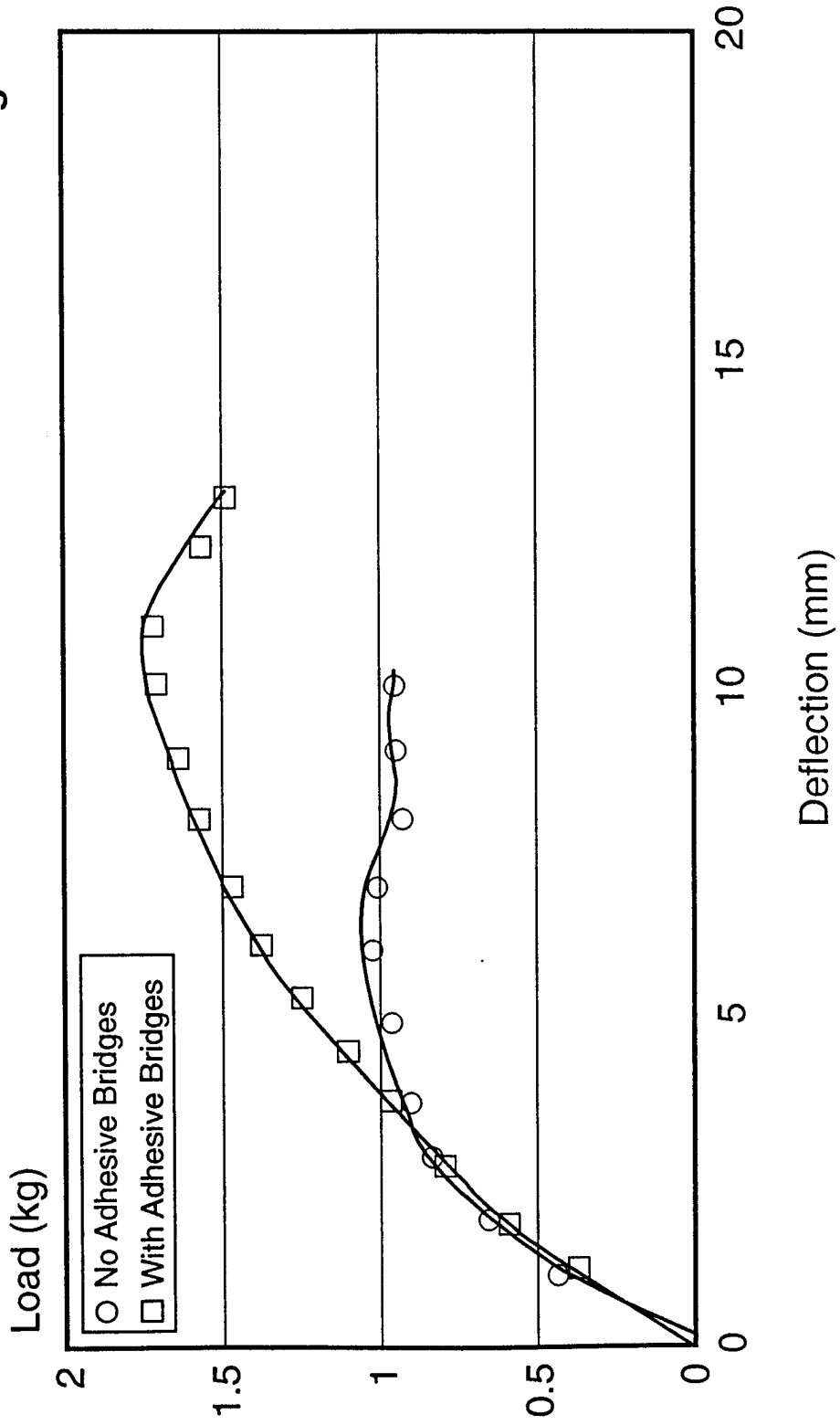


Fig 11



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Fig 12



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Fig 13

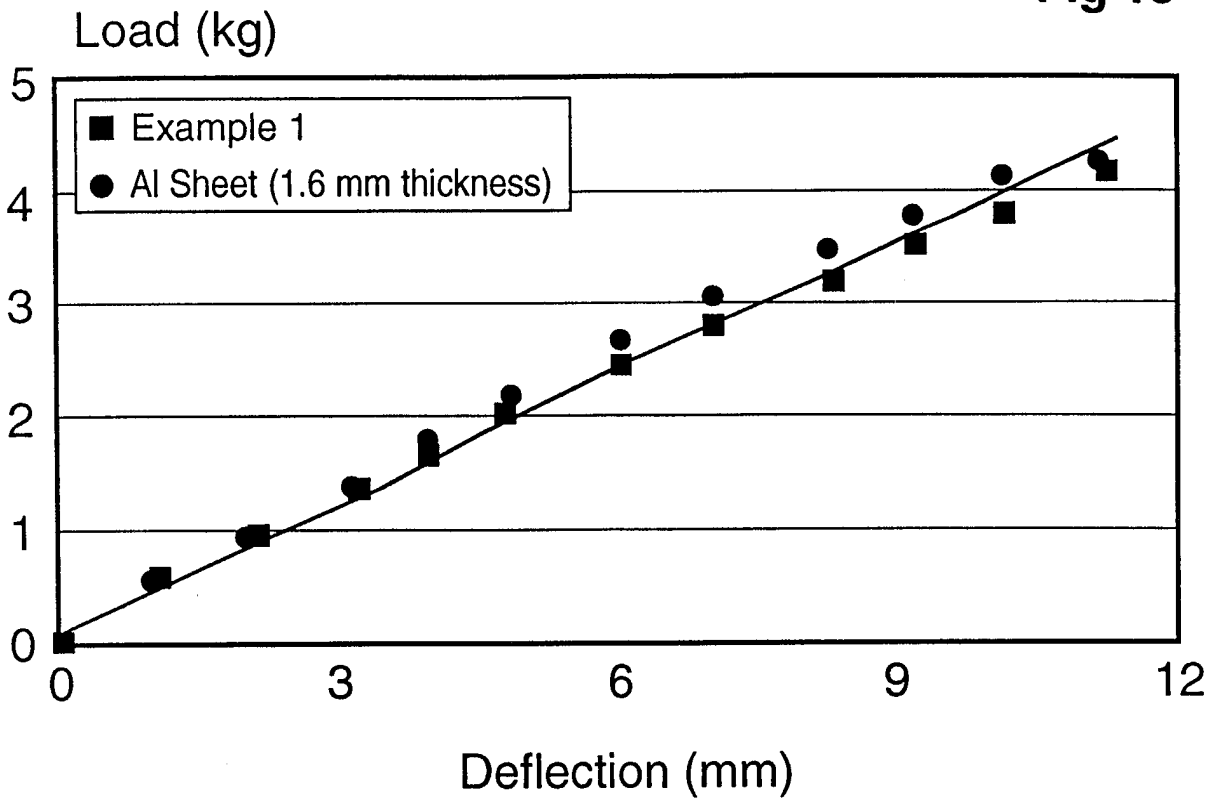
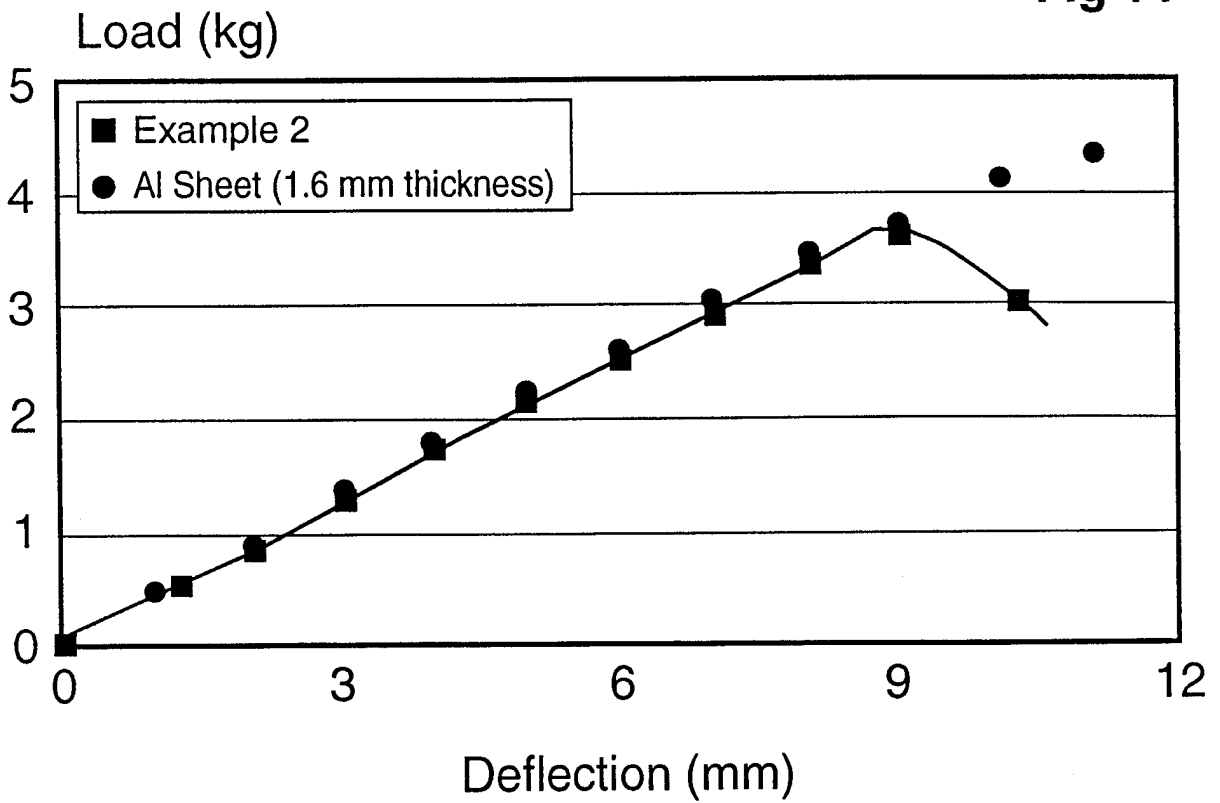


Fig 14



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Fig 15

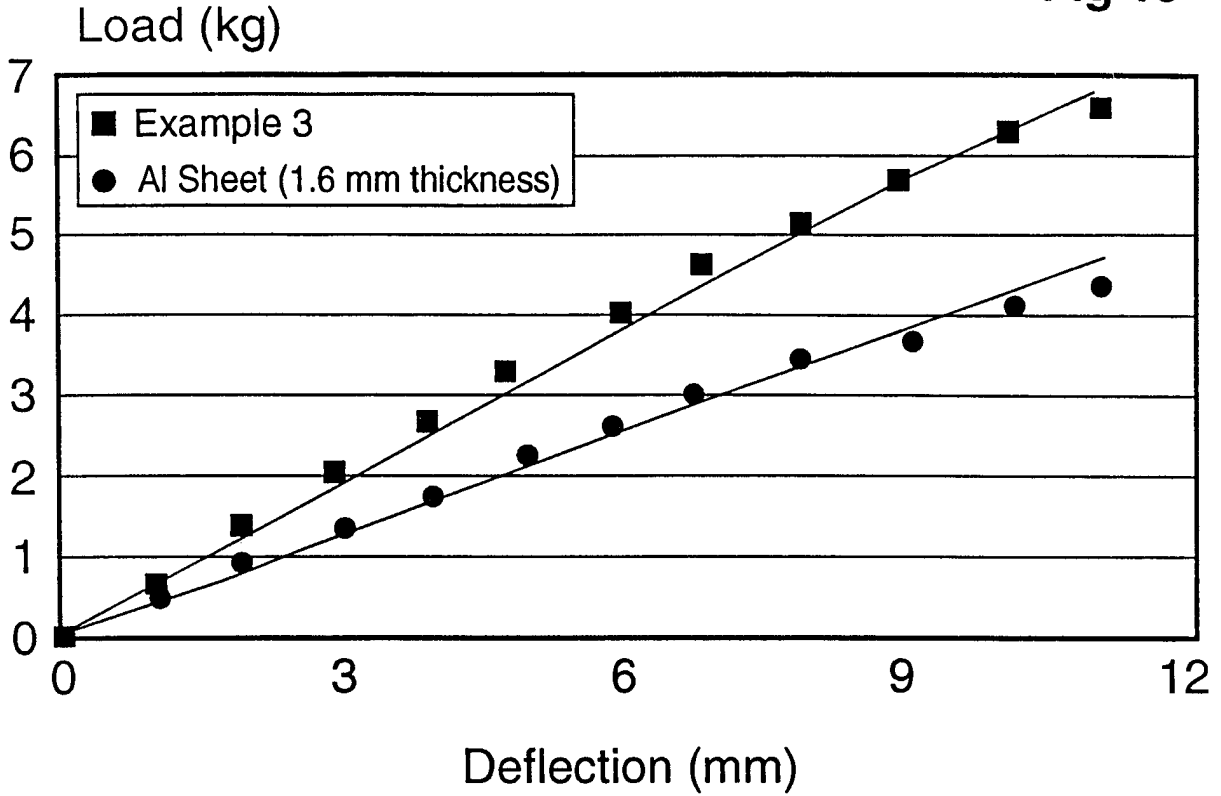


Fig 16

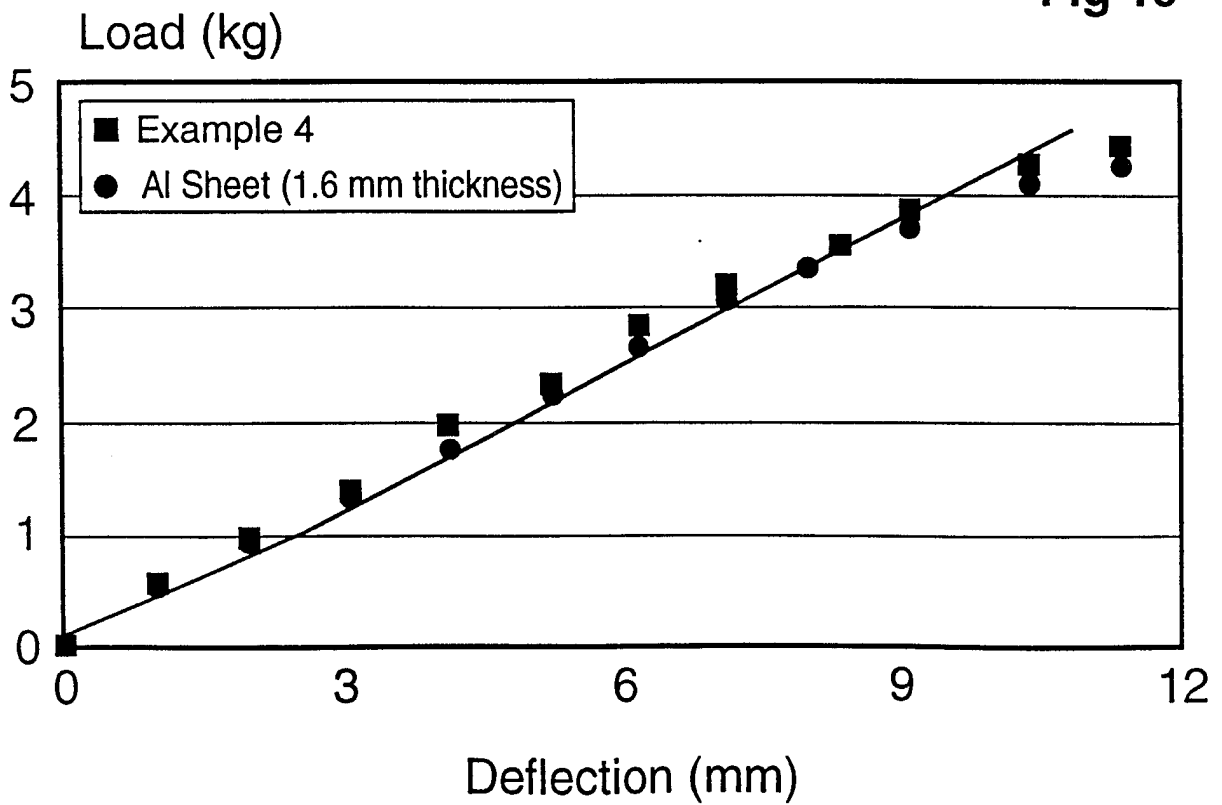
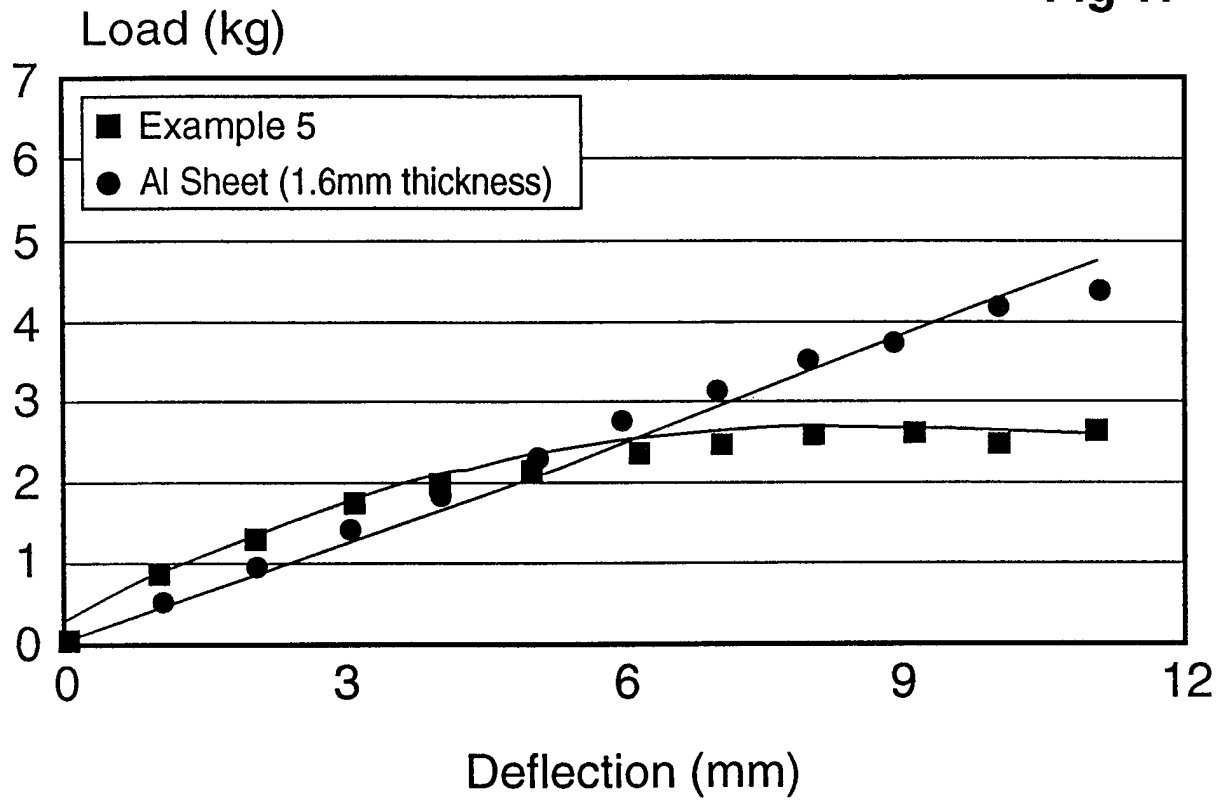


Fig 17



INTERNATIONAL SEARCH REPORT

International Application No
PCT/CA 98/00265

A. CLASSIFICATION OF SUBJECT MATTER
IPC 6 E04C2/26 B32B15/08

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED
Minimum documentation searched (classification system followed by classification symbols)
IPC 6 E04C B32B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	GB 1 225 500 A (BECK, KOLLER & COMPANY) 17 March 1971	2,4,5,8
Y	see page 1, line 55 - page 2, line 9-23-25; claims 1,4 ---	1,3,9-13
X	US 4 652 324 A (YAMASHINA NAOTOSHI ET AL) 24 March 1987 see claims 1,2,12; examples ---	1,2,4,5
X	US 4 416 949 A (GABELLIERI RODOLFO ET AL) 22 November 1983	1,2,4,8
Y	see column 2, line 60-68 - column 4, line 25-49-53; claims 1,7-9 see column 4, line 58 - column 5, line 3-13-15; examples; tables I,III ---	3
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Further documents are listed in the continuation of box C.

Patent family members are listed in annex.

* Special categories of cited documents :

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- "&" document member of the same patent family

Date of the actual completion of the international search
3 July 1998

Date of mailing of the international search report
15/07/1998

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INTERNATIONAL SEARCH REPORT

International Application No

PCT/CA 98/00265

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	LU 86 594 A (EURO COMPOSITES) 5 April 1988	1,2,4,5, 8-10,12, 13
X	see page 6, line 6-10; claim 1; figure 1 ---	11
Y	WO 96 04441 A (SICO INC) 15 February 1996 see page 3, line 29-31 - page 5, line 18-20; claim 1; figures 3,4 see page 7, line 36-37 - page 8, line 7 & DATABASE WPI Derwent Publications Ltd., London, GB; AN 96-129453 see abstract ---	1,2,9-13
Y	WO 91 18738 A (RENOUF IND PTY LTD) 12 December 1991 see page 1, line 23-24 - page 2, line 1-3; claims 1-3,14; figure 1 see page 5, line 11 - page 7, line 1-7 see page 8, line 19 ---	1,2,4,5, 8
A	US 3 847 724 A (POWERS T ET AL) 12 November 1974 see claims 1,7; figures ---	1,2
X	DATABASE WPI Section Ch, Week 8818 Derwent Publications Ltd., London, GB; Class A21, AN 88-123148 XP002070392 & JP 63 067 142 A (NIPPON STEEL CORP) see abstract ---	1-4,7,8
Y	DATABASE WPI Section Ch, Week 8240 Derwent Publications Ltd., London, GB; Class A94, AN 82-84793E XP002070393 & JP 57 140 156 A (AIKA KOGYO KK) see abstract ---	1
Y	DATABASE WPI Section Ch, Week 8240 Derwent Publications Ltd., London, GB; Class A81, AN 82-84794E XP002070394 & JP 57 140 157 A (AIKA KOGYO KK) see abstract -----	1

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International Application No

PCT/CA 98/00265

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