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(54) Title: FORMING AND PRE-PRESSING STATION FOR FORMING A FIBERBOARD FROM LIGNOCELLULOSIC FIBERS

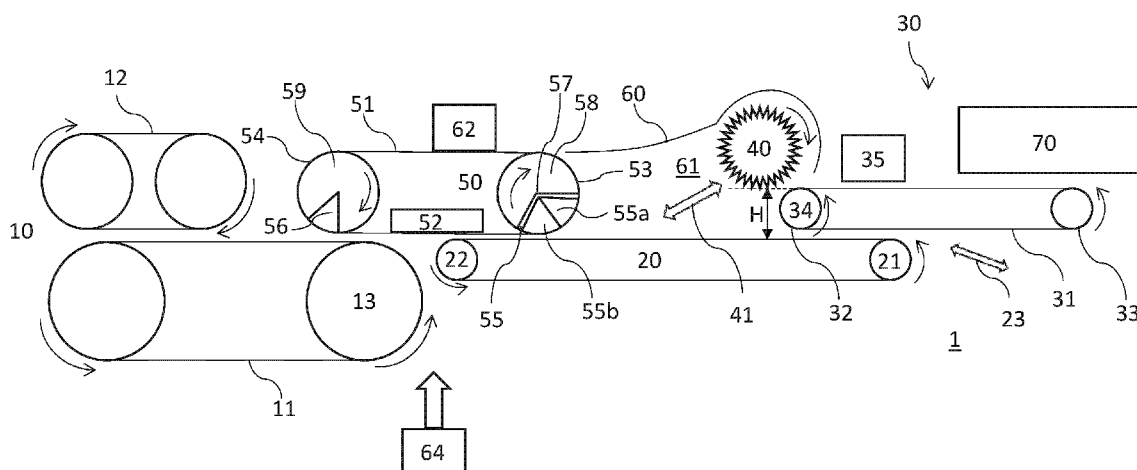


Fig. 1a

(57) Abstract: A forming station (1) for forming a fiberboard comprising compressed lignocellulosic fibers. The forming station 1 comprises a press (10) arranged downstream of a forming belt (20), the forming belt (20) being arranged downstream of a dosing station (30) and at a lower vertical level than a delivery end (34) of the dosing station (30). Further a pre-press (50) is arranged over a part of the forming belt (20). The pre-press (50) is arranged to pre-press the layer of dissolved and distributed lignocellulosic fibers by means of suction into a pre-compressed layer of lignocellulosic fibers.



SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN,
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INTERNATIONAL SEARCH REPORT

International application No.
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Box No. II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:
3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box No. III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

see additional sheet

1. ☒ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fees, this Authority did not invite payment of additional fees.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims;; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest and, where applicable, the payment of a protest fee.
- ☐ The additional search fees were accompanied by the applicant's protest but the applicable protest fee was not paid within the time limit specified in the invitation.
- ☒ No protest accompanied the payment of additional search fees.

INTERNATIONAL SEARCH REPORT

International application No
PCT/EP2023/053762

A. CLASSIFICATION OF SUBJECT MATTER		
INV.	B27N1/00	B27N3/04
	B30B5/06	B30B15/30
ADD.	B27N3/22	
	B27N3/14	B27N3/18
	B27N3/00	B27N3/24
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) B27N B30B		
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 practicable, search terms used) EPO-Internal, WPI Data		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 4 311 555 A (REINHALL ROLF B) 19 January 1982 (1982-01-19)	1, 6, 11, 12
Y	column 2, line 58 - column 3, line 12;	1, 2, 13
A	claim 1; figure 1	3

X	US 2008/303191 A1 (MILLER DAVID PAUL [US] ET AL) 11 December 2008 (2008-12-11)	1, 2, 4, 5, 12
Y	paragraphs [0111] - [0116]; claim 28; figure 4	1, 8-10, 13-18

X	DE 102 07 573 C1 (SIEMPELKAMP MASCH & ANLAGENBAU [DE]) 3 July 2003 (2003-07-03)	1, 2, 7
Y	paragraphs [0001], [0009], [0014]; claims 1, 2, 12, 13; figures 1-3	1, 2, 8-10, 13-18

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☒ Further documents are listed in the continuation of Box C. ☒ See patent family annex.		
* Special categories of cited documents : "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search 1 October 2023		Date of mailing of the international search report 11/10/2023
Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016		Authorized officer Baran, Norbert

INTERNATIONAL SEARCH REPORT

International application No

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C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	WO 97/04931 A1 (SUNDS DEFIBRATOR IND AB [SE]; LUNDGREN GOERAN [SE] ET AL.) 13 February 1997 (1997-02-13)	1, 2, 4, 5
Y	figures 1-3 page 4, lines 12-22 page 6, lines 3-13 -----	13
X	DE 10 2009 042361 A1 (SIEMPELKAMP MASCH & ANLAGENBAU [DE]) 14 April 2011 (2011-04-14)	13, 18
Y	paragraphs [0020], [0022], [0023]; claim 1; figures 1, 2 -----	1, 8, 9, 13-18
X	US 4 432 714 A (FORRY JOHN S [US] ET AL) 21 February 1984 (1984-02-21)	13
Y	figures 1-3 -----	1, 8-10, 13-18
X	EP 0 179 301 A2 (KAST CASIMIR GMBH & CO KG [DE]) 30 April 1986 (1986-04-30)	13
Y	claims 1, 18; figures 1, 2 -----	8, 9, 13-18

INTERNATIONAL SEARCH REPORT

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/EP2023/053762

Patent document cited in search report	Publication date	Patent family member(s)	Publication date

FURTHER INFORMATION CONTINUED FROM PCT/ISA/ 210

This International Searching Authority found multiple (groups of) inventions in this international application, as follows:

1. claims: 2-7, 11, 12 (completely); 1 (partially)

A forming and pre-pressing station.

2. claims: 8-10, 13-18 (completely); 1 (partially)

A forming and pre-pressing station involving a dissolving roller, and a process for forming and pre-pressing lignocellulosic fibers involving dissolving lignocellulosic fibers.
