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(54) **Method for manufacturing wooden parts**

(57) Method for manufacturing wooden parts, such as boards, particularly floorboards, having a worn look, wherein wooden parts of so-called fresh wood are planed at at least one of the main sides and subsequently are subjected to a drying process. Subsequently at least the planed main side can be subjected to a mechanical treat-

ment for artificially ageing it. Method for artificially ageing wooden parts, such as boards, particularly floorboards, comprising placing the wooden parts of dried wood in a container filled with a bed of elements provided with smooth convexly curved surfaces, after which the container is brought into repetitive motion and the wooden parts are brought into intensive contact with the bed.

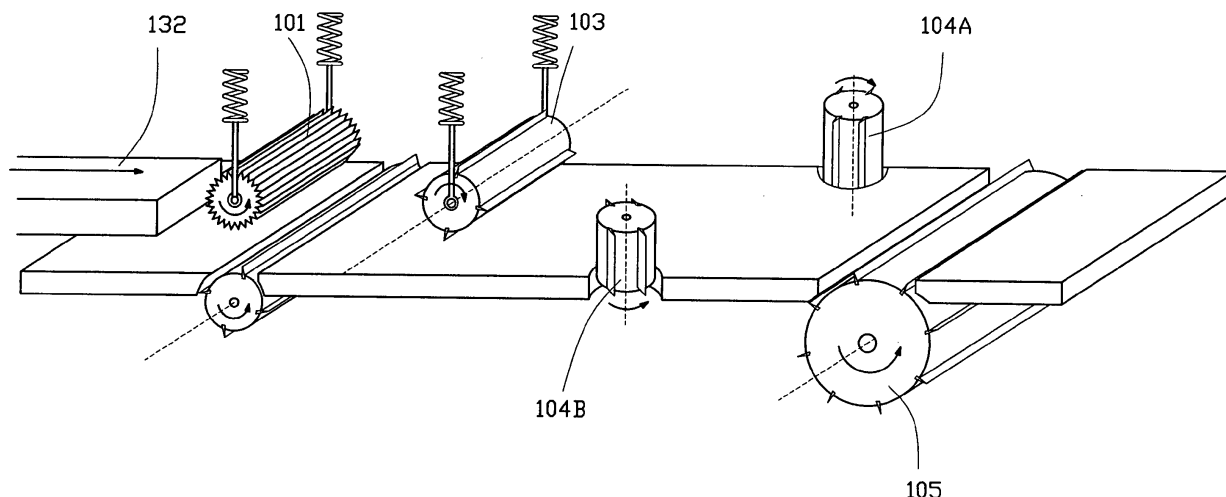


FIG. 8A



EUROPEAN SEARCH REPORT

Application Number
EP 05 07 6361

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
X	WO 01/68332 A1 (ILVOLANKOSKI OY; KUKKONEN, MATTI) 20 September 2001 (2001-09-20) * page 1, line 16 - line 18 * * page 1, line 31 - page 2, line 4 * * page 4, line 28 - page 5, line 7 * * claim 3; figures *	1,8,12,13	INV. B24B31/02 B24B31/06 B24B31/14 B27M1/00 B44D5/10 B27M3/04
X	WO 03/012354 A (SCHOTTEN & HANSEN GMBH [DE]; HANSEN TORBEN [DE]) 13 February 2003 (2003-02-13) * page 1, line 4 - line 15 * * page 1, line 20 - line 22 * * page 1, line 29 - line 35 * * page 3, line 6 - line 23 * * claim 2 *	1,12	
P,A	EP 1 516 708 A (VAN CAPELLEVEEN ALBERT ELTJO D [NL]) 23 March 2005 (2005-03-23) * the whole document *	1	
A	EP 1 252 994 A (CAPELLEVEEN ALBERT EITJO DOEWE [NL] HOUTINDUSTRIE SCHIJNDEL B V [NL]) 30 October 2002 (2002-10-30)		TECHNICAL FIELDS SEARCHED (IPC) B24B B27M B44D
3 The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of the search 17 November 2008	Examiner Huggins, Jonathan
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	

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Application Number

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CLAIMS INCURRING FEES

The present European patent application comprised at the time of filing claims for which payment was due.

☐ Only part of the claims have been paid within the prescribed time limit. The present European search report has been drawn up for those claims for which no payment was due and for those claims for which claims fees have been paid, namely claim(s):

☐ No claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for those claims for which no payment was due.

LACK OF UNITY OF INVENTION

The Search Division considers that the present European patent application does not comply with the requirements of unity of invention and relates to several inventions or groups of inventions, namely:

see sheet B

☐ All further search fees have been paid within the fixed time limit. The present European search report has been drawn up for all claims.

☐ As all searchable claims could be searched without effort justifying an additional fee, the Search Division did not invite payment of any additional fee.

☐ Only part of the further search fees have been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the inventions in respect of which search fees have been paid, namely claims:

☒ None of the further search fees have been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the invention first mentioned in the claims, namely claims:

1-3,8,11-13

☐ The present supplementary European search report has been drawn up for those parts of the European patent application which relate to the invention first mentioned in the claims (Rule 164 (1) EPC).



**LACK OF UNITY OF INVENTION
SHEET B**

Application Number

EP 05 07 6361

The Search Division considers that the present European patent application does not comply with the requirements of unity of invention and relates to several inventions or groups of inventions, namely:

1. claims: 1-3,8,11-13

The wooden part is fully planed at the sight side in a pre-planing treatment and a post-planing treatment prior to the drying process (claim 2), due to which the sight side is smooth to such an extent that a (more or less regular) profile also known as machine waves is prevented.

2. claims: 4-7,14-16

The wooden part is divided into two boards prior to the drying process, which two boards have a sight side, which is planed prior to the drying process. Such boards can be sold as pairs, wherein they have mirrored patterns that go together.

3. claims: 9,10

Wooden parts are placed in pairs with the planed sight sides against each other and in that condition are dried.

4. claim: 17

Method for artificially ageing wooden parts comprising placing the wooden parts of dried wood in a container filled with a bed of elements provided with smooth convexly curved surfaces, after which the container is brought into repetitive motion and the wooden parts are brought into intensive contact with the bed. The elements provided with smooth convexly curved surfaces exert pressure forces on the surfaces of the wooden parts, particularly boards, as a result of which a particular visible effect is achieved, particularly in the treated largest planes and on the edges.

**ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.**

EP 05 07 6361

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
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17-11-2008

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