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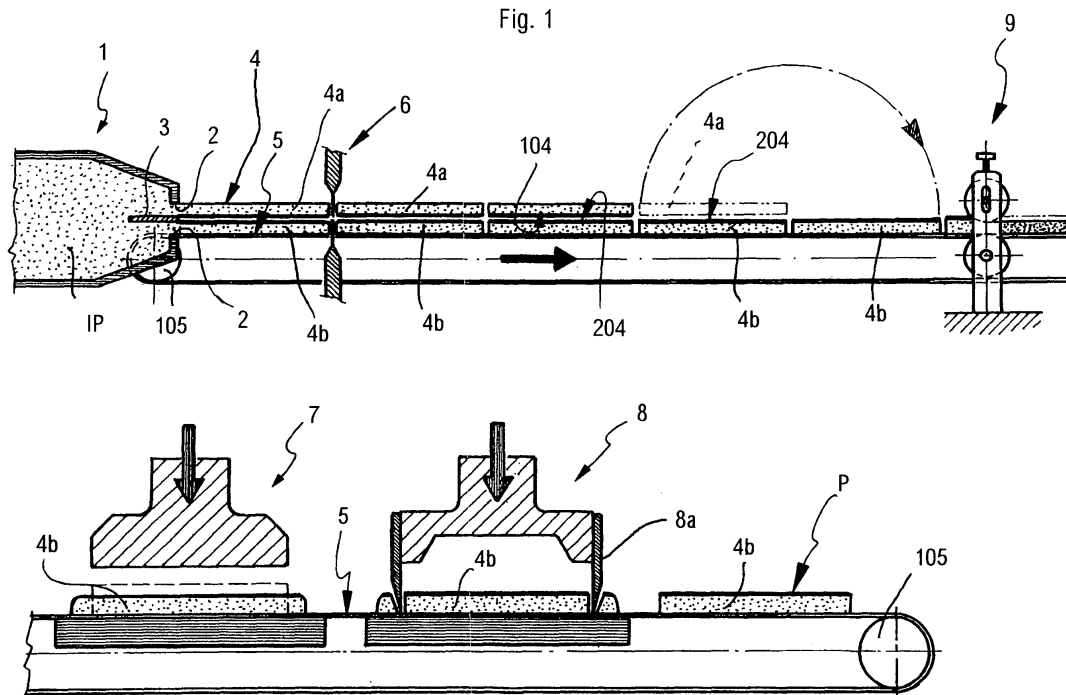
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(54) **Method and apparatus for forming flat ceramic products**

(57) A method of forming substantially flat ceramic products (P) comprises preparing a ceramic paste (IP), extruding the ceramic paste (IP) through an extrusion die (2) and over a cutter (3) to obtain a substantially continuous multiple ribbon (4) of paste with first and second ribbons (4a, 4b) of the multiple ribbon (4) not being joined together but having a separation plane that is substan-

tially parallel to the faces of the multiple ribbon (4), and severing the first and second ribbons (4a, 4b) transversely to provide the products (P), the extruding being performed substantially horizontally. The individual products (P) so obtained are squashed to reduce their thicknesses and to increase their plan areas and are then cut to size around their peripheries.

Fig. 1





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EUROPEAN SEARCH REPORT

Application Number
EP 04 00 1546

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
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Y		26	
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The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of the search 27 January 2006	Examiner Orij, J
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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EUROPEAN SEARCH REPORT

Application Number
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DOCUMENTS CONSIDERED TO BE RELEVANT			
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A	* column 3, line 34 - column 5, line 9; figures 9-12,15 * -----	21-23	
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The present search report has been drawn up for all claims			
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EPO FORM 1503 03.82 (P04C01)

**CLAIMS INCURRING FEES**

The present European patent application comprised at the time of filing more than ten claims.

- ☐ Only part of the claims have been paid within the prescribed time limit. The present European search report has been drawn up for the first ten claims 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 the first ten claims.

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:



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**LACK OF UNITY OF INVENTION
SHEET B**

Application Number
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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: 1-20

method and apparatus for extruding a multiple ribbon

2. claims: 21-30

method and apparatus for extruding a ribbon, reduce the
thickness and cut it to size

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

EP 04 00 1546

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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27-01-2006

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