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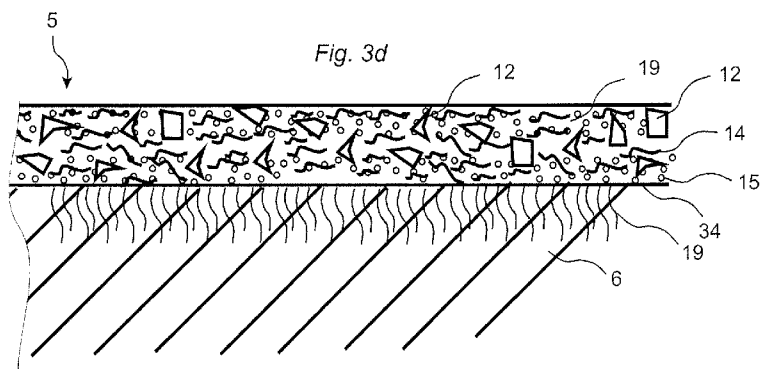
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— with international search report (Art. 21(3))  
— before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments (Rule 48.2(h))

(88) Date of publication of the international search report:  
3 September 2009

(54) Title: FIBRE BASED PANELS WITH A WEAR RESISTANCE SURFACE



(57) Abstract: A flooring panel (1) comprising a core (6) and a surface layer (5), the surface layer (5) comprising cork particles (14) or wood fibres (14) comprising lignin resin, melamine resin as binder (19), colour pigments (15), and aluminium oxide as wear resistant particles (12), all components being homogeneously mixed, and the core (6) comprising fibres and binder and being provided with a mechanical locking system (4) at its edges and a rear balancing layer (7). Also disclosed is a method of manufacturing said flooring panel by - homogeneously mixing the dry particles of the surface layer; - scattering them on an embossed pressure matrix; - applying the core layer as scattered or prefabricated layer on the surface layer; - applying a balancing layer as scattered or prefabricated layer on the core layer; - pre-pressing the panel; - printing and brushing the surface layer; - forming the panel by a further pressing and heating step; - machining the mechanical locking system.



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**INTERNATIONAL SEARCH REPORT**

International application No  
PCT/EP2008/065489

**A. CLASSIFICATION OF SUBJECT MATTER**  
 INV. B27N3/06 B32B21/08  
 ADD. B27N7/00 B44C5/04 B44F9/02 B27M3/06 E04F15/10

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)  
 B27M B27N B32B B44C B44F E04F

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)  
 EPO-Internal

**C. DOCUMENTS CONSIDERED TO BE RELEVANT**

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	DE 202 14 532 U1 (HW IND GMBH & CO KG [DE]) 19 February 2004 (2004-02-19)	1-8, 11-13, 17, 21-26, 28, 29, 31-33, 37
Y	the whole document	10, 14-16, 18-20, 27, 30, 34-36, 38-40

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	*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
*E* earlier document but published on or after the international filing date	*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
*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)	*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.
*O* document referring to an oral disclosure, use, exhibition or other means	*&* document member of the same patent family
*P* document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search <b>16 March 2009</b>	Date of mailing of the international search report <b>03/07/2009</b>
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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 <b>Fournier, Thomas</b>
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## INTERNATIONAL SEARCH REPORT

International application No

PCT/EP2008/065489

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	EP 1 690 603 A (KRONOTEC AG [CH]) 16 August 2006 (2006-08-16)	10, 18, 19, 30, 38, 39
X	the whole document	41, 43, 45-47, 49, 50, 53-55
Y		42, 44, 48, 51, 52, 56
Y	----- DE 20 2006 007797 U1 (REHAU AG & CO [DE]) 17 August 2006 (2006-08-17)	15, 16, 27, 35, 36, 44
	the whole document	
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	the whole document	
Y	----- DE 71 48 789 U (EBERT K; SIPPL J) 20 April 1972 (1972-04-20)	15, 35
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Y	----- WO 2004/042168 A (MANNINGTON MILLS [US]) 21 May 2004 (2004-05-21)	16, 36
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Y	----- DE 10 2005 046264 A1 (KRONOTEC AG [CH]) 12 April 2007 (2007-04-12)	14, 34
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Y	----- WO 00/22225 A (HALSTEAD JAMES LTD [GB]; KAY JOHN GRANVILLE [GB]; MINETT MICHAEL GEOFF) 20 April 2000 (2000-04-20)	57-60
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P, X	----- DE 10 2006 024593 A1 (FLOORING TECHNOLOGIES LTD [MT]) 6 December 2007 (2007-12-06)	1, 21, 41
	the whole document	

# INTERNATIONAL SEARCH REPORT

International application No.  
PCT/EP2008/065489

## 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.:

see annex

### 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.

FURTHER INFORMATION CONTINUED FROM PCT/ISA/ 210

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

1. claims: 1-60

A building panel and its manufacturing, the panel comprising a surface layer and a core, the core comprising wood fibres, the surface layer comprising a substantially homogenous mix of fibres, a binder and wear resistant particles, the panel being manufactured by scattering and pressing the layers of the panel.

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2. claims: 61-63

The manufacturing of a flooring panel from two original floorboard types with different designs or structures by connecting them and separating this resulting combi panel.

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# INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/EP2008/065489

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
DE 20214532	U1	19-02-2004	NONE
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