

Title (en)
METHOD FOR PRODUCING A PRINTED SURFACE ON A FLAT WORKPIECE

Title (de)
VERFAHREN ZUM HERSTELLEN EINER BEDRUCKTEN OBERFLÄCHE AUF EINEM FLÄCHIGEN WERKSTÜCK

Title (fr)
PROCÉDÉ POUR PRODUIRE UNE SURFACE IMPRIMÉE SUR UNE PIÈCE PLANE

Publication
EP 2313281 B1 20120711 (DE)

Application
EP 10741967 A 20100811

Priority
• EP 2010061691 W 20100811
• DE 102009043812 A 20090819

Abstract (en)
[origin: WO2011020755A1] The invention relates to a method for producing a decoratively printed surface on a flat workpiece, comprising the following steps: pretreating a flat workpiece substantially made of wood or wood components by applying at least one liquid base coating (12, 22); partially or completely drying the at least one applied liquid base coating (12, 22); digitally inkjet-printing in passing on the pretreated flat workpiece, wherein inkjet print heads dispense droplets having a variable droplet size during the inkjet printing, wherein the smallest droplet size is < 20 pl and the small droplets differ from the larger droplets by a factor of at least two.

IPC 8 full level
B41M 5/00 (2006.01); **B41J 3/407** (2006.01); **B41J 11/00** (2006.01)

CPC (source: EP US)
B41J 3/407 (2013.01 - EP); **B41J 11/0015** (2013.01 - EP); **B41J 11/00214** (2021.01 - EP US); **B41M 5/0047** (2013.01 - EP US); **B41M 5/0076** (2013.01 - EP)

Cited by
US9409382B2; US9605168B2; US10369837B2; US10328680B2; US11077652B2; US11186997B2; DE102022103652A1; WO2023156087A1; US11203224B2; US11697303B2; US10017950B2; US10071563B2; US10737506B2; US11173722B2; US11559824B2; US9994010B2; US10899121B2; US11141759B2; US11420229B2; US11511318B2; US11717850B2; US11717851B2; US11883843B2

Designated contracting state (EPC)
AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO SE SI SK SM TR

DOCDB simple family (publication)
WO 2011020755 A1 20110224; DE 102009043812 A1 20110310; DE 102009043812 B4 20211125; EP 2313281 A1 20110427; EP 2313281 B1 20120711; EP 2313281 B2 20200902; ES 2391166 T3 20121122; ES 2391166 T5 20210617; PL 2313281 T3 20121231; PL 2313281 T5 20201214

DOCDB simple family (application)
EP 2010061691 W 20100811; DE 102009043812 A 20090819; EP 10741967 A 20100811; ES 10741967 T 20100811; PL 10741967 T 20100811