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# **EUROPEAN PATENT APPLICATION**

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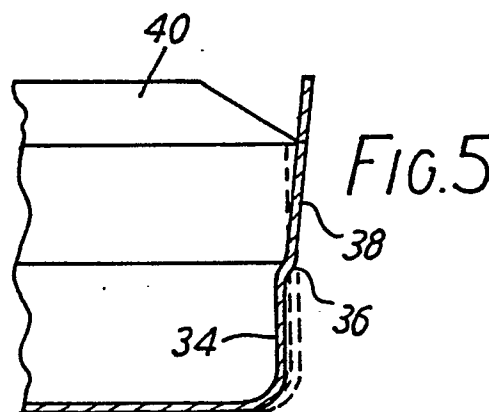
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54 **Floor panels.**

57 A tray (16) or stiffening web for a load-bearing floor panel is produced in two steps. Firstly, the tray is drawn from sheet metal to a desired depth to provide a tray (16) whose side walls are substantially vertical and are closed at the corners. The tray (16) is then redrawn to incline an upper portion (38) of the tray side walls outwardly of the tray while retaining the corners closed. The tray is then covered by a top plate to form the load-bearing floor panel.





| DOCUMENTS CONSIDERED TO BE RELEVANT                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                                                                                                                                                                          |                                                |                                                              |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------|--------------------------------------------------------------|
| Category                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Citation of document with indication, where appropriate, of relevant passages                                                                                                            | Relevant to claim                              | CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)               |
| X                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | SHEET METAL INDUSTRIES, vol. 46, no. 3, March 1969, page 206, Fuel and Metallurgical Journals Ltd. Redhill; S.J. FELLONS et. al.: "A typical production sequence"<br>* Abstract *<br>--- | 1-7,11-13                                      | B 21 D 22/02<br>B 21 D 51/16<br>E 04 F 15/024                |
| A                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | AU-B- 47 268 (TATE ARCHITECTURAL PRODUCTS LTD.)(1979)<br>* Figures 1-3; claim 1 *<br>---                                                                                                 | 1                                              |                                                              |
| A                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | DE-A-1 552 082 (SIEMENS AG)<br>* Figure 4; claim 1 *<br>-----                                                                                                                            | 8,10                                           |                                                              |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                          |                                                | TECHNICAL FIELDS SEARCHED (Int. Cl.4)                        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                          |                                                | B 21 D 22/00<br>B 21 D 47/00<br>B 21 D 51/00<br>E 04 F 15/00 |
| The present search report has been drawn up for all claims                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                          |                                                |                                                              |
| Place of search<br>THE HAGUE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                                                                          | Date of completion of the search<br>05-03-1989 | Examiner<br>SUENDERMANN R.O.                                 |
| <b>CATEGORY OF CITED DOCUMENTS</b><br>X : particularly relevant if taken alone<br>Y : particularly relevant if combined with another document of the same category<br>A : technological background<br>O : non-written disclosure<br>P : intermediate document<br>T : theory or principle underlying the invention<br>E : earlier patent document, but published on, or after the filing date<br>D : document cited in the application<br>L : document cited for other reasons<br>.....<br>& : member of the same patent family, corresponding document |                                                                                                                                                                                          |                                                |                                                              |