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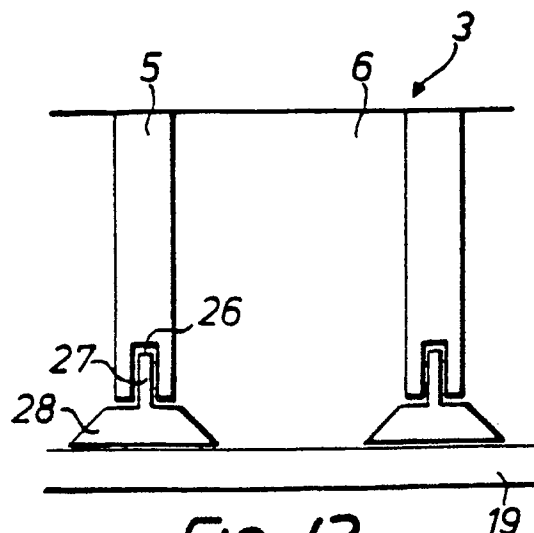
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(54) **Method for manufacturing stones in a press, and press for manufacturing said stones.**

(57) Method of manufacturing stones in a press provided with a mould (3) subdivided in several moulding rooms (4) by means of dividing walls (5), with a stamp (7) arranged above the mould and being movable up and down, with a table (14) arranged under the mould and being movable up and down, with supply means (18) for supplying empty product plates (19) below the mould (3) and with discharge (16,17) means for discharging the product plates carrying stones (1) shaped in the mould, whereby prior to filling the mould (3) with the moulding mass below dividing walls (5) there are moved a plurality of filling pieces (28) that extend parallel to one another between the mould (3) and a moulding plate (10) on the table the filling pieces (28) having surfaces protruding beyond said dividing walls (5) for shaping bevelled edges on the stones and ribs (27) sliding in grooves (26) provided in the lower ends of the dividing walls (5), whilst the filling pieces (28) are withdrawn from below said dividing walls (5) prior to pressing the stones supported by a product plate out of the mould.



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EUROPEAN SEARCH REPORT

Application Number

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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)
T	EP-A-0 290 060 (GEBROEDERS ROOK BEHEER B.V.) * The whole document *	1,3,6	B 28 B 7/24 B 28 B 3/02
T	NL-A-8 602 836 (GEBROEDERS ROOK BEHEER B.V.) * The whole document *	1-6	
A	US-A-3 504 408 (W.E. JONES) * The whole document *	1,3,6	
A	BE-A- 858 167 (E.G. CUYVERS) * The whole document *	1,3,6	
A	DE-A-1 759 153 (J. HEHN) * The whole document, in particular figure 4 *	1,3,6	
A	GB-A-1 571 461 (TIGER MACHINE SEISAKUSHO K.K.) * The whole document *	2,4	
A	US-A-4 128 357 (G. BARTH) * Figures 15-17 *	5	
The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int. Cl.4) B 28 B
Place of search THE HAGUE		Date of completion of the search 13-02-1991	Examiner GOURIER P.A.
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			