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(54) **Textile disc or wheel impregnated with resin containing abrasive particles, process of preparation thereof and lapping/buffing process.**

(57) Textile discs and wheels for surface lapping/buffing are impregnated with a resin solution containing an abrasive powder suspended therein. Following vacuum impregnation and centrifugation, the impregnated buffing discs and wheels are oven-treated for polymerizing the resin. The abrasive powder incorporated in the impregnating resin provides a source of abrasive material in the work area of the disc or wheel, thus making up for the abrasive paste shortage during intervals between successive paste applications. This allows a considerable saving of abrasive paste while increasing buffing disc life.

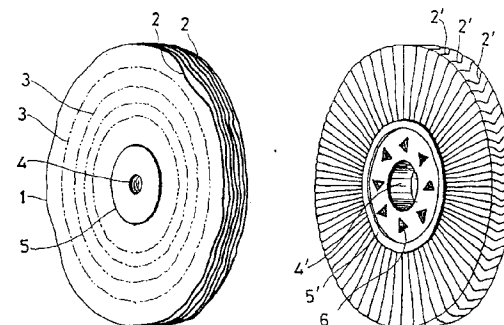


FIG. 1

FIG. 2

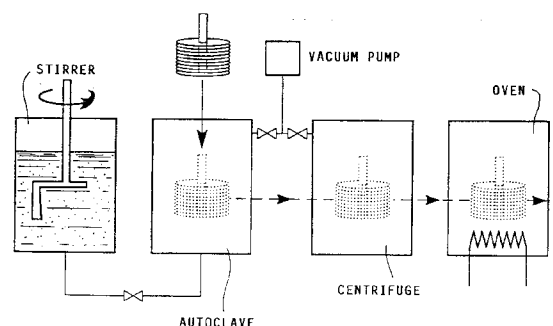


FIG. 3



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EUROPEAN SEARCH REPORT

Application Number
EP 94 83 0368

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.6)
X	DE-U-84 30 781 (BRAND) * page 3, line 4 - page 5, line 5; figure 1 *	1,3,5,7	B24D13/12 B24D18/00 B24D3/28
Y	---	2,4,6,8,9	
Y	DATABASE WPI Week 8612, Derwent Publications Ltd., London, GB; AN 86-079162 & JP-A-61 028 573 (MITSUBISHI MINING CEMENT) 8 February 1986 * abstract *	2,6	
A	---	10,11	
Y	US-A-5 129 919 (KALINOWSKI ET AL) * column 19, line 53 - line 59 *	4,8	
Y	US-A-5 224 968 (CHAMBERS) * abstract *	9	
A	EP-A-0 400 658 (NORTON COMPANY) * claim 15 *	1,2	TECHNICAL FIELDS SEARCHED (Int.Cl.6) B24D
The present search report has been drawn up for all claims			
Place of search		Date of completion of the search	Examiner
THE HAGUE		19 October 1994	GARELLA, M
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			

EPO FORM 1503 03.92 (P04C01)



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CLAIMS INCURRING FEES

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

- ☐ All claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for all claims.
- ☐ Only part of the claims fees 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 claims:
- ☐ 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 requirement 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.
- ☐ 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 has 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: 1-11



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LACK OF UNITY OF INVENTION

The Search Division considers that the present European patent application does not comply with the requirement of unity of invention and relates to several inventions or groups of inventions, namely:

1. Claims 1-11 : Cloth disc or wheel and method for manufacturing the same.
2. Claim 12 : Lapping and buffing process.