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(54) **Security receptacle**

(57) A method of manufacturing a safe body comprising a top wall, base wall back wall and two side walls includes the steps of (i) providing a hollow structure (1) defining inner and outer surfaces (2, 3) of the top, base and side walls and the inner surface (4) of the back wall, (ii) orientating the front of the structure lowermost, (iii) filling the structure with elements of hard material (6) in its portions corresponding to the top, base, back and side walls, (iv) injecting resin (9) into the structure, which resin expands upwardly to form a matrix of expanded elastomer (9') through the interstices between the elements of hard material within those portions of said structure corresponding to the top, base and side walls, and (v) injecting resin to form an expanded elastomer (13) through the interstices between the elements of hard material within the portion of the structure corresponding to the back wall, said resin expanding to form a matrix of expanded elastomer (13) through the interstices between the elements of hard material within the portion of the structure corresponding to the back wall, with the matrices of steps (iv) and (v) becoming bound together.

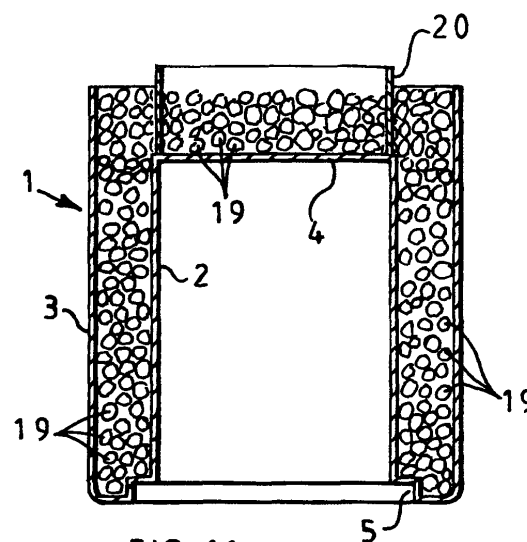
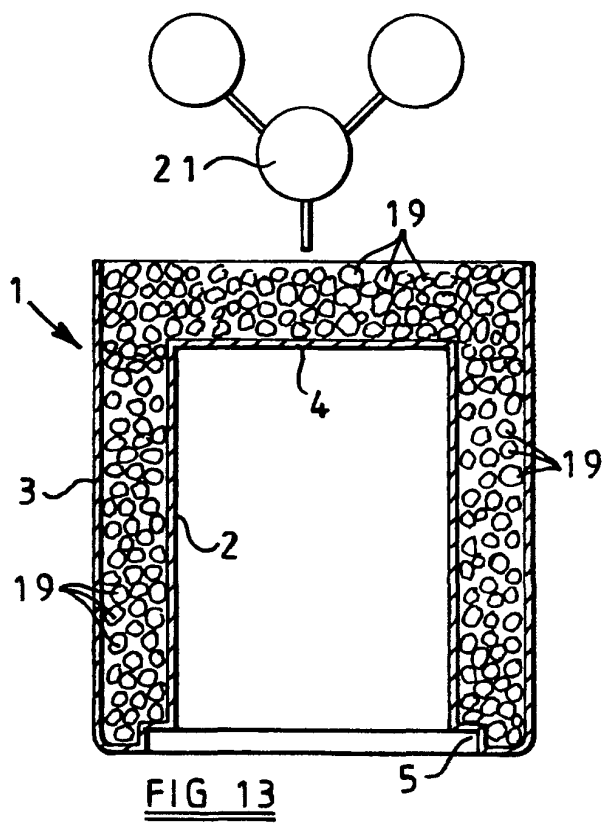
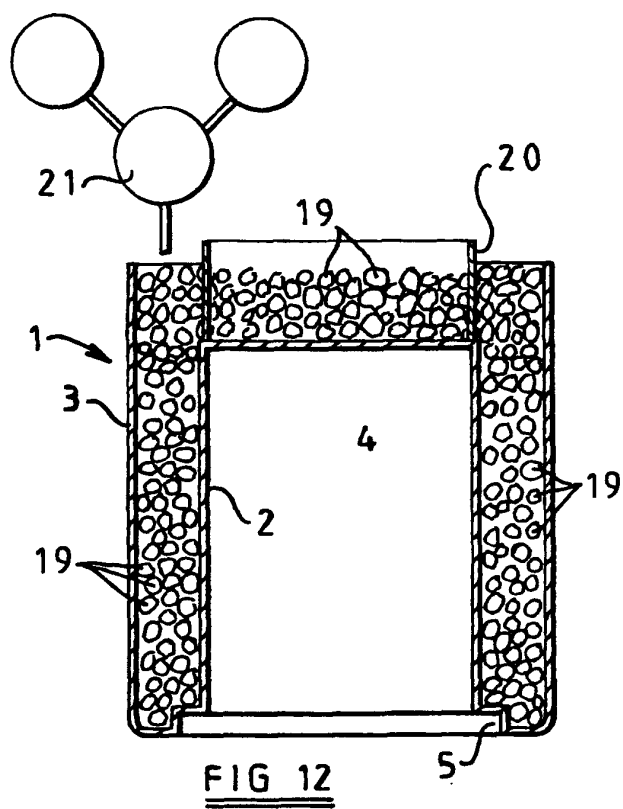


FIG 11





European Patent
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EUROPEAN SEARCH REPORT

Application Number
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Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.6)
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			TECHNICAL FIELDS SEARCHED (Int.Cl.6)
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The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 13 December 1999	Examiner Van Kessel, J
CATEGORY OF CITED DOCUMENTS		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	
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			

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**ANNEX TO THE EUROPEAN SEARCH REPORT
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