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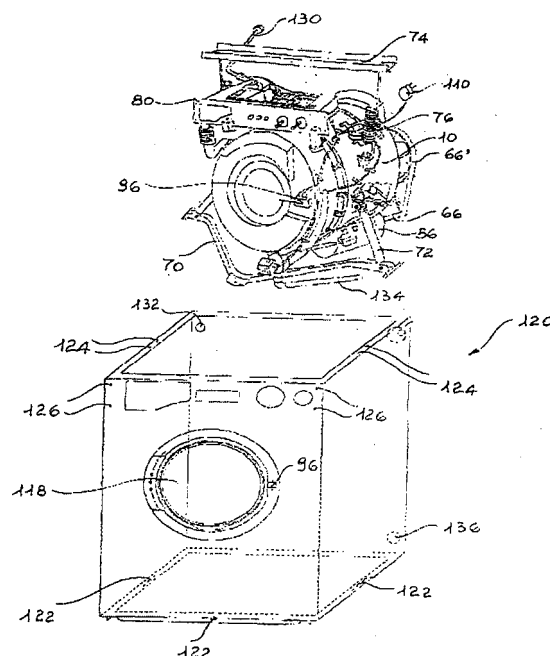
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(54) **Process for assembling washing machines**

(57) A process for assembling washing machines comprises a tub (10, 26), a rotary drum (12), mechanical components comprising a motor (56), a water discharge pump (115), elastic support means (74, 76), and shock absorbers (70, 72); electric components (62, 64), a front panel (80) wherein there are housed and fastened the activation, program and control devices (82), a detergents box (84) and an external body (120), said process comprising the following steps:

- fastening on the outer surface of tub (10, 26), wherein drum (12) is inserted, all the mechanical and electric components, an end of the elastic means (76) and of the shock absorbers (72) and the front panel (80);
- testing the so assembled washing machine;
- inserting the tested washing machine in the external body (120), and
- fastening to said external body the free ends of the elastic means (76) and of the shock absorbers (72) and the front panel (80), on prior detachment from the tub.

**FIG. 14**





European Patent  
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# EUROPEAN SEARCH REPORT

Application Number  
EP 00 10 1438

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			TECHNICAL FIELDS SEARCHED (Int.Cl.7)
			D06F
The present search report has been drawn up for all claims			
Place of search <b>THE HAGUE</b>		Date of completion of the search <b>14 March 2002</b>	Examiner <b>Goodall, C</b>
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			

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**ANNEX TO THE EUROPEAN SEARCH REPORT  
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