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(54) **Method for manufacturing tiles having their exposed side provided with depressions and reliefs to reproduce the appearance of split quarystone**

(57) The method comprises the following operations:

- in a usual mould, forming a crude tile from an atomized powder mix, that mould punch intended to create the exposed face of the tile reproducing the appearance of split quarystone or of a non-flat surface;
- drying the thus formed tile in a continuous dryer in accordance with a usual drying cycle;

- applying on the exposed side of the dried tile at least one layer of coloured atomized clay or of pigment in powder form, to at least partly cover said side of the tile;
- subjecting the exposed side of the tile to the action of an air stream at an incidence angle tending towards zero;
- kiln-firing the tile treated in this manner in accordance with a usual firing cycle.

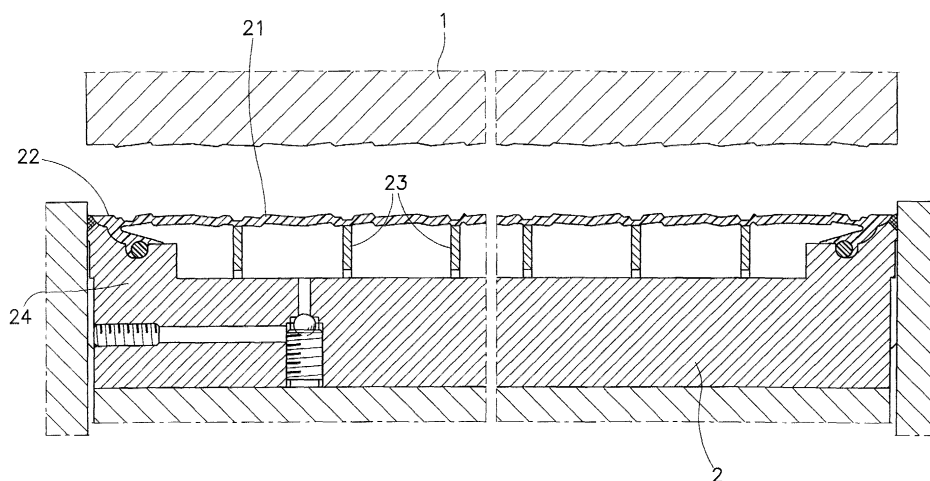


FIG. 4



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# EUROPEAN SEARCH REPORT

Application Number  
EP 00 20 3852

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.7)
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X	---	24	
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<del>The present search report has been drawn up for all claims</del>			
Place of search <b>THE HAGUE</b>		Date of completion of the search <b>6 December 2002</b>	Examiner <b>Orij, J</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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### CLAIMS INCURRING FEES

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

- ☐ Only part of the claims 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 claim(s):
- ☐ 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 requirements 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.
- ☐ As all searchable claims could be searched without effort justifying an additional fee, the Search Division did not invite payment of any additional fee.
- ☐ 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 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 invention first mentioned in the claims, namely claims:

1-17, 24-27



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# EUROPEAN SEARCH REPORT

Application Number  
EP 00 20 3852

DOCUMENTS CONSIDERED TO BE RELEVANT			
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			TECHNICAL FIELDS SEARCHED (Int.Cl.7)
<del>The present search report has been drawn up for all claims</del>			
Place of search		Date of completion of the search	Examiner
THE HAGUE		6 December 2002	Orij, J
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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**LACK OF UNITY OF INVENTION  
SHEET B**

Application Number  
EP 00 20 3852

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

1. Claims: 1-17, 24-27

glaze decorating surfaces and tiles obtained

2. Claims: 18-23

pressing tiles with two irregular faces

**ANNEX TO THE EUROPEAN SEARCH REPORT  
ON EUROPEAN PATENT APPLICATION NO.**

EP 00 20 3852

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.  
The members are as contained in the European Patent Office EDP file on  
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06-12-2002

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For more details about this annex : see Official Journal of the European Patent Office, No. 12/82