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(54) **Method of machining component parts of wood or similar, in particular door and window frame component parts**

(57) A method of machining component parts (2) of wood or similar, wherein a component part (2) is inserted into at least one clamp (16) in a first insertion direction (10a), is machined on a first side (2a), is removed from the clamp (16) by means of a grip-and-carry assembly (24), is inserted by the grip-and-carry assembly (24) into

at least one clamp (16) in a second insertion direction (10b) opposite the first insertion direction (10a), and is machined on a second side (2b) opposite the first side (2a).

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EUROPEAN SEARCH REPORT

Application Number  
EP 07 12 1372

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
Y	DE 101 08 134 A1 (BIESSE SPA [IT]) 6 September 2001 (2001-09-06) * column 2, line 38 - column 3, line 16 * * column 3, line 36 - line 43 * * column 4, line 21 - line 40; figures *	1-4	INV. B27M1/08 B27F1/04 B23Q7/04
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A	EP 0 922 547 A (IMA MASCHINENFABRIKEN KLESSMAN [DE] KLESSMANN IMA GMBH HOLZBEARBEI [DE]) 16 June 1999 (1999-06-16)	1	
A,P	EP 1 810 802 A (SCM GROUP SPA [IT]) 25 July 2007 (2007-07-25) * the whole document *	1	
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A	DE 100 30 997 A1 (BIESSE SPA [IT]) 11 January 2001 (2001-01-11)	5,10,18	
The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of the search 21 July 2009	Examiner Huggins, Jonathan
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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EPC FORM 1503 03.82 (F04C01)



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**CLAIMS INCURRING FEES**

The present European patent application comprised at the time of filing claims for which payment was due.

- Only part of the claims have been paid within the prescribed time limit. The present European search report has been drawn up for those claims for which no payment was due 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 those claims for which no payment was due.

**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:
- The present supplementary 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 (Rule 164 (1) EPC).



**LACK OF UNITY OF INVENTION  
SHEET B**

Application Number  
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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: 1-4, 6-9

Method of machining comprising inserting at least one component part (2) for machining into at least one clamp (16) in a first insertion direction (10a); machining a first side (2a) of the component part (2); and removing the component part (2) from the clamp (16) by means of the grip and carry assembly (24); and being characterized by also comprising the steps of: inserting the component part (2), by means of the grip and carry assembly (24), into at least one clamp (16) in a second insertion direction (10b) opposite the first insertion direction (10a); and machining a second side (2b), opposite the first side (2a), of the component part (2).

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2. claims: 5, 10-25

Method of machining comprising a feed device (19) for feeding the component parts (2) in steps between a loading station (22) where the component parts (2) for machining are loaded onto the feed device (19), and an unloading station (23) where the component parts (2) for machining are unloaded off the feed device (19)

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

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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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21-07-2009

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