



(12) **EUROPEAN PATENT APPLICATION**

(88) Date of publication A3:  
**10.05.2017 Bulletin 2017/19**

(51) Int Cl.:  
**E04B 2/14 (2006.01) E04C 1/40 (2006.01)**

(43) Date of publication A2:  
**12.04.2017 Bulletin 2017/15**

(21) Application number: **16001930.3**

(22) Date of filing: **02.09.2016**

(84) Designated Contracting States:  
**AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR**  
Designated Extension States:  
**BA ME**  
Designated Validation States:  
**MA MD**

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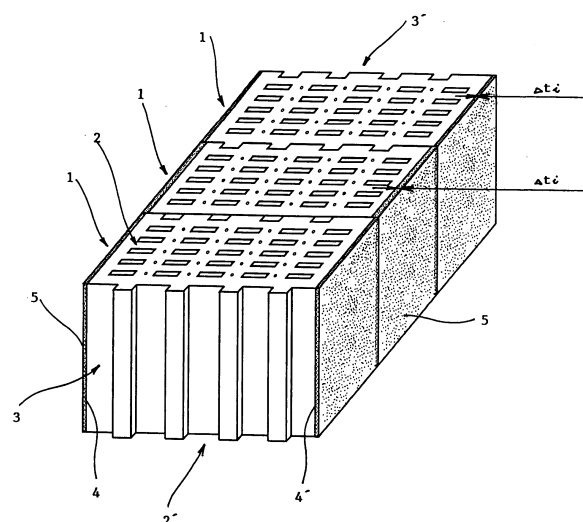
(30) Priority: **02.09.2015 CZ 20150599**

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(54) **A PRECISE WALLING BLOCK AND METHOD FOR CALIBRATION THEREOF**

(57) The invention relates to the dimensional calibration of a precision walling block (1), preferably a ceramic block (1), that has two machined opposite loading surfaces (2, 2'), two opposite contact surfaces (3, 3'), and two opposite facing surfaces (4, 4'). For calibrating the dimensions of blocks (1) and for compensating manufacturing dimensional deviations, onto at least one facing surface (4, 4') there is applied a calibration layer (5) of semi-rigid material (9) on a silicate base, preferably a lime-cement or other plaster which cures after coating. The thickness ( $\Delta t_i$ ) of the calibration layer (5) is adjustable and corresponds to the difference between the final desired calibrated distance ( $L_v$ ) and the nominal distance ( $L_{ji}$ ) of the surface of each block (1). The calibration is preferably executed using the applicator means (8) on a number of blocks (1) moving on a conveyor (6). After the calibration layer (5) has cured, the blocks (1) are dimensionally unified on their facing surfaces (4, 4') and only a thin layer of plaster is needed during the finishing work on the façade or on the interior plasters. The method of calibration according to the invention is inexpensive and suitable for line production of ceramic, concrete, porous concrete, foam silicate, aerated concrete, heat-insulated, and other blocks (1).



**FIG. 7**



## EUROPEAN SEARCH REPORT

Application Number  
EP 16 00 1930

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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
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			TECHNICAL FIELDS SEARCHED (IPC)
			E04B E04C
The present search report has been drawn up for all claims			
Place of search <b>Munich</b>		Date of completion of the search <b>30 March 2017</b>	Examiner <b>Stern, Claudio</b>
<p>CATEGORY OF CITED DOCUMENTS</p> <p>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</p> <p>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 &amp; : member of the same patent family, corresponding document</p>			

EPO FORM 1503 03/82 (P04C01)

**ANNEX TO THE EUROPEAN SEARCH REPORT  
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This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.  
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EPO FORM P0459

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