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(71) Applicant: **Välinge Innovation AB**
263 65 Viken (SE)

(72) Inventors:
• **NYGREN, Per**
SE-253 60 RAMLÖSA (SE)
• **BERGELIN, Marcus**
SE-263 52 LERBERGET (SE)

(74) Representative: **Välinge Innovation AB**
Patent Department
Prästavägen 513
263 65 Viken (SE)

Remarks:

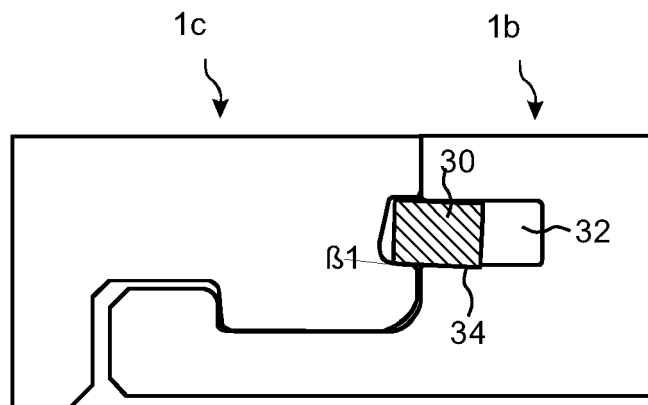
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(54) **BUILDING PANELS PROVIDED WITH A MECHANICAL LOCKING SYSTEM**

(57) Building panels, such as floorboards, provided with a mechanical locking system. The mechanical locking system includes a displacement groove (32) at a first edge (1b) of a first floorboard and a tongue groove (33) at a second edge of a second floorboard (c). A tongue is arranged in the displacement groove and is configured to cooperate, in a second position, with the tongue groove

for vertical locking of the first (1b) and the second edge (1c). The tongue includes, in a first position, an inner element and an outer element. The inner element is removable along the displacement groove, and is configured to cooperate with the outer element to obtain a displacement of the outer element towards the tongue groove and thereby obtain the second position.

Fig. 24



Description

Technical Field of the Invention

[0001] The present invention relates to a building panel such as a floor panel, a wall panel, a ceiling panel, a furniture component or the like, which is provided with a mechanical locking system comprising a displaceable tongue.

Technical Background

[0002] Building panels provided with a mechanical locking system comprising a displaceable tongue cooperating with a tongue groove for vertical locking is known and disclosed in, e.g., FR 2 975 717. The mechanical locking system in FR 2 975 717 has a displaceable tongue comprising an outer element which is pushed by a wedge part of a removable inner part of the tongue into a tongue groove, for vertical locking of adjacent edges of two floorboards. A drawback with this known system is that the locking strength is rather low.

[0003] The above description of various known aspects and drawback is the Applicant's characterization of such, and is not an admission that any of the above description is considered as prior art.

[0004] Although the description in the present disclosure relates to a floor panel, the description of techniques and problems thereof is applicable to other applications as well. For example, the description is also applicable to panels for other purposes, such as wall panels, ceiling panels, furniture panels and components, etc.

Summary

[0005] It is an object of embodiments of the present invention to provide an improvement over the above described conventional techniques.

[0006] A further object of embodiments of the present disclosure is to provide building panels, such as floorboards, wall panels or panels for furniture, provided with a locking system that comprises a tongue that improves the vertical locking of the floorboards.

[0007] Another object of embodiments of the present disclosure is to provide a more efficient production method, which requires less complicated production equipment.

[0008] At least some of these and other objects and advantages that will be apparent from the present disclosure have been achieved by certain embodiments of the building panels described herein. The building panels, such as floorboards, are provided with a locking system that comprises a displacement groove at a first edge of a first floorboard and a tongue groove at a second edge of a second floorboard. A tongue is arranged in the displacement groove and is configured to cooperate, in a second position, with the tongue groove for vertical locking of the first edge and the second edge. The tongue

comprises, in a first position, an inner element and an outer element. The inner element is removable along the displacement groove, and is configured to cooperate with the outer element to obtain a displacement of the outer element towards the tongue groove and thereby obtain the second position. The inner element and the outer element are preferably configured to vertically overlap each other in the first position to obtain an increased contact surface between a surface of the displacement groove and the outer element of the tongue in the second position. The inner element and the outer element are arranged such that the increased contact surface takes up a moment of force that arises on the tongue when a load is applied on the first or the second floorboard. The inner element in the first position may be arranged above or below the outer element. The inner element in the first position may also be arranged partly above and partly behind the outer element, or may be arranged partly below the outer element and partly behind the outer element.

[0009] The entire outer element is in the first position preferably arranged within the displacement groove.

[0010] The first position may be an initial position before a removal of inner element is initiated.

[0011] Said inner element and said outer element preferably vertically overlap each other when the inner element is displaced in order to remove the inner element from the displacement groove.

[0012] The inner element is preferably a bar element. An advantage with a bar element may be that the inner element may be displaced forth and back in the case the inner element got stuck during the removal of the inner element.

[0013] An innermost surface of the inner element, in the first position, may be arranged within the guiding groove along an inner surface of the outer element.

[0014] The outer element may be provided with a guiding groove at either an inner and upper edge of the outer element or at an inner and lower edge of the outer element, wherein at least a part of the inner element in the first position is arranged in said guiding groove. The outer element may be provided with a guiding groove at an inner surface of the outer element, between an upper surface and lower surface of the outer element, wherein at least a part of the inner element is arranged in said guiding groove in the first position. The guiding groove facilitates the removal of the inner element by guiding the inner element in a controlled manner and provides a groove without obstructions and with an eligible friction. The guiding groove preferably extends essentially along the whole longitudinal length of the outer element. This embodiment of the outer element provides for a simple production of the outer element for example by plastic profile extrusion and cutting of the profile in the desired length.

[0015] The inner element preferably comprises a first protruding part configured to cooperate with the guiding groove, to obtain said displacement of the outer element.

[0016] The first protruding part in the first position is preferably arranged outside of the outer element and/or in a recess of the outer element. When the inner element is removed by a displacement along the displacement groove and preferably in the guiding groove, the outer element is gradually pushed into the tongue groove to obtain the second position.

[0017] The first protruding part may be wedge shaped or of an essentially spherical shape. Such shapes facilitate the displacement of the inner element. The outer element may also be provided with guiding surfaces at the location of the first protruding part in the first position. The first protruding part is preferably elastic, to make it easier to displace the first protruding part over irregularities in the displacement groove. The first protruding part may comprise an elastic material and may be provided with a recess to increase the elasticity.

[0018] The inner element is preferably provided with a second protruding part, preferably configured such that the second protruding part is easy to grasp by an installer of the floorboards. The second protruding part may also be configured such that the inner element is secured in the correct position.

[0019] The cross section of the inner element may be L-shaped or rectangular or of an essentially circular shape.

[0020] The inner element may comprise plastic and may be produced by injection moulding or extrusion. An extruded inner element of plastic may be provided with the first and or the second protruding part by heating and compressing a part of the extruded profile in a press tool.

[0021] The inner and outer element may be produced in one piece by injection moulding of plastic and connected together by a connection configured to break when the inner element is displaced or when the tongue is inserted into the displacement groove.

[0022] The building panels may comprise a wood-based core, preferably made of at least one of MDF, HDF, OSB, WPC (Wood Plastic Composite), and particle-board, or of plastic, such as vinyl or PVC.

Brief Description of the Drawings

[0023] The present invention will by way of example be described in more detail with reference to the appended schematic drawings, which illustrate several embodiments.

Figs. 1-3 show a known locking system with a tongue comprising an inner and an outer element.

Figs. 4-7 show a tongue comprising a guiding groove at an inner edge, according to embodiments of the invention.

Figs. 8 and 9 each shows a tongue from a top view, according to embodiments of the invention.

Figs. 10 and 11 show cross-sections of a tongue comprising an L-shaped inner element, according to embodiments of the invention.

Figs. 12-15 show tongues comprising a guiding groove at an inner surface, according to embodiments of the invention.

Figs. 17-19 show a method for producing an inner element of a tongue, according to embodiments of the invention.

Fig. 20 shows an embodiment of an inner element of a tongue, according to an embodiment of the invention.

Figs. 21 and 22 show a tongue with an inner element having a circular cross-section, according to an embodiment of the invention.

Figs. 23-25 show a displacement groove provided with recess, according to an embodiment of the invention.

Figs. 26 shows a tongue from a top view, according to an embodiment of the present disclosure.

Detailed Description

[0024] Figs. 1-3 show floorboards provided with a known locking system which comprises a tongue 20 having an inner element 21 and an outer element 22. The tongue 20 is arranged in a displacement groove 24 at a first edge 1b of a first floorboard. Fig. 1 shows a position during assembling of the first floorboard. The first floorboard is arranged in a second row and is connected at a third edge to a fourth edge of a third floorboard in first row. A second floorboard is arranged in an angled position with a third edge adjacent the fourth edge of the third floorboard and a second edge 1c of the second floorboard is arranged adjacent the first edge 1b of the first floorboard.

[0025] Fig. 2 shows a cross-section of the first edge 1b and the second edge 1c after the second floorboard is angled down and connected to the third floorboard in the first row. The first edge 1b and the second edge 1c are in Fig. 2 locked together in the horizontal direction, and the inner element 21 and the outer element 22 of the tongue 20 are arranged in a first position. The first edge 1b and the second edge 1c are in the first position vertically unlocked. To lock the first edge 1b and the second edge 1c in the vertical direction, the inner element 21 is displaced and removed along the first edge 1b. The inner element 21 is provided with a protruding part. The protruding part pushes the outer element 22 of the tongue 20 into a tongue groove 23 at the second edge 1c of the second floorboard when the inner element 21 is displaced and removed.

[0026] Fig 3 shows a cross-section of the first edge 1b and the second edge 1c in a second position. The inner element 21 of the tongue 20 is in the second position displaced and removed. The outer element 22 of the tongue 20 cooperates with the tongue groove 23 at the second edge 1c of the second floorboard for vertical locking of the first edge 1b and the second edge 1c.

[0027] An embodiment of the invention is shown in Fig. 4 and Fig. 5, with an inner and outer element 31, 30 of the tongue 10 arranged in a displacement groove 32 at a first edge 1b of a first floorboard. Figs. 4 and 5 illustrate the first position and the second position, respectively, of the inner and outer elements 31, 30. The outer element 30 of the tongue 10 extends below the inner element 31 of the tongue 10, such that the inner element 31 vertically overlaps the outer element 30. The inner element 31 is in this embodiment arranged in a guiding groove 60 at an inner and upper edge of the outer element 30. The width x of a first contact surface between a lower surface of the outer element 30 of the tongue 10 and the displacement groove 32 is increased, as compared to the known locking system shown in Fig. 3, in order to improve the strength of the locking system and minimize the offset in height between the first edge 1b and the second edge 1c when a load is applied, in the second position, on the first floorboard.

[0028] The second position in which the outer element 30 is pushed into the tongue groove 33 at the second edge 1c is shown in Fig. 5. The outer element 30 is pushed into tongue groove 33 by a first protruding part 36 (see Figs. 8 and 9) arranged on the inner element 31, when the inner element 31 is removed and displaced along the first edge 1b. A load applied on the first edge 1b will be taken up by a second contact surface, between an upper surface of the outer element 30 of the tongue 10 and the displacement groove 32, and a third contact surface between a lower surface of the outer element 30 of the tongue and the tongue groove 33. Since the second contact surface and the third contact surface are displaced, the load applied will result in a moment of force, which is taken up by the first contact surface. In order to increase the strength of the locking system, the width x of the first contact surface is preferably larger than the width y of the third contact surface, and preferably the width x is about twice or more the width y. For the purpose of reducing the momentum that arises when a load is applied on the first edge 1b, the horizontal distance between the second and the third contact surfaces should be as small as possible, preferably less than about 1 mm and more preferably less than about 0,5 mm. This applies also to the embodiments described below.

[0029] The locking system additionally comprises in this embodiment a locking strip 6, which protrudes horizontally from the first edge 1b. The locking strip 6 is provided with a locking element 8 which cooperates with a locking groove 14 provided at the second edge 1c for horizontal locking of the first edge 1b and the second edge 1c. A load applied on the second edge 1c is pref-

erably taken up by a strip contact surface between an upper surface of the locking strip 6 and a lower surface of the second edge 1c.

[0030] In order to push the first edge 1b and the second edge 1c vertically against each other, a lower surface of the tongue groove 33 at the third contact surface is preferably arranged with an angle $\beta 1$ in relation to the horizontal plane of the floorboards. The angle $\beta 1$ may be in the range of about 5 ° to about 20 °, and preferably about 15°.

[0031] In the embodiment shown in Figs. 6 and 7, the tongue 10 is arranged in a displacement groove 32 at the second edge 1c. The inner element 31 of the tongue 10 is for this embodiment preferably arranged in a guiding groove 60 at an inner and lower edge of the outer element 30 of the tongue 10 to obtain an increased first contact surface between an upper surface of the outer element 30 of the tongue 10 and the displacement groove 32. Also, in this embodiment the first contact surface takes up a momentum force resulting from a load applied at the first edge 1b, in a similar way as described for the embodiment shown in Figs. 4 and 5. In order to push the first edge 1b and the second edge 1c vertically against each other, an upper surface of the tongue groove is preferably arranged with an angle $\beta 2$ in relation to the horizontal plane of the floorboards. The angle $\beta 2$ may be in the range of about 5 ° to about 20°, and preferably about 15°.

[0032] Figs. 8 and 9 show top view embodiments of a tongue 10 of an elongated shape, to be arranged in a displacement groove 32 at a first edge 1b of a first floorboard. The tongue comprises an inner element 31 and an outer element 30. The inner element 31 is arranged in a guiding groove 60 at an inner edge of the outer element 30. The inner element 31 is preferably a bar element of an elongated shape and is provided at a first short edge with a first protruding part in the form of a wedge shaped element 36. The wedge shaped element 36 is configured to push the outer element 30 into a tongue groove 33 of an adjacent second edge 1c of a second floorboard when the inner element 31 is removed and displaced along the first edge 1b. The wedge shaped element is in a preferred embodiment guided by the guiding groove during the displacement of the inner element. The wedge shaped element 36 is, before the displacement, preferably arranged adjacent and at least partly outside a first short edge of the outer element 30 as shown in Fig. 8. A second edge of the inner element 31 is preferably provided with a gripping part 37 that facilitates the displacement of the inner element 31. Fig. 9 shows that the first short edge of the outer element 30 may be provided with first chamfer 38 that guides the wedge shaped element 36 into the guiding groove 60. The gripping part 37 is, before displacement of the inner element 31, preferably arranged adjacent a second short edge of the outer element 30 and preferably outside the second edge. As shown in Fig. 9 the inner element 31 may be provided with a second protruding part 40, for a

correct positioning of the inner element 31, that before displacement of the inner element is preferably arranged in a notch or in a second chamfer 39 provided at the second short edge of the outer element 30. The outer element 30 may have a uniform cross-section from the first short edge to the second short edge. A uniform cross-section makes it possible to produce the outer element 30 at low cost, by e.g., extrusion of plastic. Also the inner element 31 may have uniform cross-section with the exception of the protruding part (wedge shaped element) 36 at the first edge. For the purpose of obtaining a correct position of the inner element 31, a preferred embodiment of the present disclosure comprises the first chamfer 38 and the second chamfer 39, which cooperate with the first protruding part 36 and the second protruding part 40, respectively.

[0033] Figs. 10 and 11 show an embodiment of the tongue 10 comprising an L-shaped inner element 31 arranged in a corresponding guiding groove at an inner edge of the outer element 30.

[0034] Figs. 12-15 show an embodiment of the tongue 10 comprising inner element 31 arranged in a guiding groove 60 at an inner surface of the outer element 30. Fig. 13 shows that outer edges 42, 43 of the outer element 30 may be chamfered in order to guide the outer element 30 into the tongue groove 33. Fig. 14 shows a cross section of the tongue 10 and that the guiding groove 60 may be provided with chamfered edges 41. Fig. 15 shows a cross section of the tongue 10 in a plane indicated by AA in Fig. 14. The inner element 31 in this embodiment is provided with friction elements 44 that avert that the inner element 31 from falling out before the floorboards are installed. The first protruding part 36 is provided with a recess 45 that makes its most protruding part 46 more resilient. The most protruding part 46 may be, during the displacement of the inner element 31, compressed during, e.g., entrance of the inner element 21 into the guiding groove 60, or at any irregularities in the displacement groove 32. Also the other embodiments of the tongue 10 may be provided with a friction element 44 on the inner element 31 and/or on the outer element 30, and/or a recess 45 in the first protruding part 36.

[0035] A method for producing the first protruding part 36 and/or the second protruding part 40 of the inner element 31 is illustrated in Figs. 17-19. A plastic blank 50 of an elongated shape is displaced into a press tool comprising a first part 55 and a second part 56. The first part 55 and the second part 56 are displaced against each other and a protruding part 35 at a first short edge of the plastic blank 50 is formed under heat and pressure. The process may be repeated for a second short edge of the plastic blank 50. The method may also comprise the step of forming the second protruding part 35 simultaneously and essentially in the same manner as the first protruding part 35. The produced first and/or second protruding part 35 may be of, for example, an essentially spherical shape or wedge shaped. Fig. 20 shows an inner element 31 that may be produced according to the method illustrated

in Figs. 17-19. The inner element 31 preferably has an essentially circular cross-section and preferably comprises protruding parts 35 of an essentially spherical shape.

[0036] Figs. 21 and 22 show that an inner element 31 with a circular cross section may be combined with a displacement groove 32 having an inner surface 62, which is smaller than the opening of the displacement groove 32. The inner surface 62 may be provided with a round shaped bottom that facilitates the displacement of the inner element 31.

[0037] An upper or lower surface of the displacement groove 32 may be provided with a recess 34 having an angled surface at an angle β_3 to the horizontal plane. The angle β_3 may be in the range of about 3° to about 10° . An embodiment of the recess 34 is shown in Figs. 23-25. The recess 34 and the angled surface has the effect that the outer element 30 of the tongue 10 tilts and the outer element 30 is restrained from being displaced back into the displacement groove 32 after the outer element 30 is pushed into the tongue groove 33 by the inner element 31. Such a recess 34 may be provided in locking systems comprising any type of the disclosed displaceable tongue.

[0038] A preferred embodiment of the tongue 10 is shown in Fig 26. The inner element 31 and the outer element 30 are produced in one piece by injection moulding of plastic. The inner element 31 and the outer element 30 are connected together by a connection 47 configured to break when the inner element is displaced or when the tongue is inserted into the displacement groove.

[0039] Further embodiments of the invention are described below in numbered paragraphs.

1. Floorboards including at least a first floorboard and a second floorboard provided with a mechanical locking system comprising:

a displacement groove (32) at a first edge (1b) of the first floorboard and a tongue groove (33) at a second edge of the second floorboard (1c), a tongue (10) arranged in the displacement groove (32) and configured to cooperate, in a second position, with the tongue groove (33) for vertical locking of the first edge (1b) and the second edge (1c), the tongue (10) comprises, in a first position, an inner element (31) and an outer element (30), the inner element being removable along the displacement groove (32) and configured to cooperate with the outer element to obtain a displacement of the outer element (30) towards the tongue groove (33) and thereby obtain the second position, characterized in that said inner element (31) and said outer element (30) vertically overlap each other in the first position.

2 Floorboards as described in paragraph 1, wherein said inner element (31) and said outer element (30)

vertically overlap each other when the inner element is displaced, in order to be removed from the displacement groove.

3. Floorboards as described in paragraph 1 or 2, wherein the inner element (31) is a bar element. 5

4. Floorboards as described in any one of the preceding paragraphs, wherein the inner element (31) in the first position is arranged above or below the outer element (30). 10

5. Floorboards as described in any one of the preceding paragraphs 1-3, wherein the inner element (31) in the first position is arranged partly above and partly behind the outer element (3), or is arranged partly below the outer element and partly behind the outer element. 15

6. Floorboards as described in any one of the preceding paragraphs, wherein the outer element (30) is provided with a guiding groove (60) at either an inner and upper edge of the outer element or at an inner and lower edge of the outer element (30), and at least a part of the inner element in the first position is arranged in said guiding groove (60). 20 25

7. Floorboards as described in any one of the preceding paragraphs 1-5, wherein the outer element is provided with a guiding groove (60) at an inner surface of the outer element (30), between an upper surface and a lower surface of the outer element, and at least a part of the inner element is arranged in said groove in the first position. 30 35

8. Floorboards as described in paragraph 6 or 7, wherein the guiding groove (60) extends essentially along the whole longitudinal length of the outer element. 40

9. Floorboards as described in any one of the paragraphs 6-8, wherein in the first position an innermost surface of the inner element (31) is within the guiding groove (60) along an inner surface of the outer element (30). 45

10. Floorboards as described in any one of the paragraphs 6-9, wherein the inner element (31) comprises a first protruding part (36) configured to cooperate with the guiding groove (60), to obtain said displacement of the outer element. 50

11. Floorboards as described in paragraph 10, wherein the first protruding part (36) in the first position is arranged outside of the outer element and/or in a recess of the outer element. 55

12. Floorboards as described in paragraph 10 or 11,

wherein the first protruding part is one of wedge shaped and essentially spherical shaped.

13. Floorboards as described in any one of the preceding paragraphs, wherein a cross section of the inner element (31) is one of an L-shape, rectangular shape, and an essentially circular shape.

14. Floorboards as described in any one of the preceding paragraphs, wherein the entire outer element is arranged within the displacement groove in the first position.

15. Floorboards as described in any one of the preceding paragraphs, wherein the first position is an initial position before a removal of inner element is initiated.

16. Floorboards as described in any one of the preceding paragraphs, wherein the inner and outer elements are produced in one piece by injection moulding of plastic.

17. Floorboards as described in any one of the preceding paragraphs, wherein the inner and outer elements (31, 30) are connected together by a connection (47) configured to break when the inner element is displaced, in order to be removed from the displacement groove, or when the tongue is inserted into the displacement groove.

18. Floorboards as described in any one of the preceding paragraphs, wherein the floorboards comprise a wood-based core made of at least one of MDF, HDF, OSB, WPC, and particleboard.

19. Floorboards as described in any one of the paragraphs, wherein the floorboards comprise a plastic core, such as vinyl or PVC

Claims

1. Floorboards including at least a first floorboard and a second floorboard provided with a mechanical locking system comprising:

a displacement groove (32) at a first edge (1b) of the first floorboard and a tongue groove (33) at a second edge of the second floorboard (1c), a tongue (10) arranged in the displacement groove (32) and configured to cooperate, in a second position, with the tongue groove (33) for vertical locking of the first edge (1b) and the second edge (1c), the tongue (10) comprises, in a first position, an inner element (31) and an outer element (30), the inner element being removable along the

- displacement groove (32) and configured to cooperate with the outer element to obtain a displacement of the outer element (30) towards the tongue groove (33) and thereby obtain the second position, **characterized in that** the displacement groove (32) comprises recess (34) having an angled surface at an angle (β 3) to the horizontal plane such that the outer element (30) of the tongue (10) tilts and the outer element (30) is restrained from being displaced back into the displacement groove (32) after the outer element (30) is pushed into the tongue groove (33) by the inner element (31)
2. Floorboards as claimed in claim 1, wherein the angle (β 3) is in the range of about 3° to about 10°.
 3. Floorboards as claimed in claim 1 or 2, wherein said inner element (31) and said outer element (30) vertically overlap each other in the first position.
 4. Floorboards as claimed in any one of the preceding claims, wherein said inner element (31) and said outer element (30) vertically overlap each other when the inner element is displaced, in order to be removed from the displacement groove.
 5. Floorboards as claimed in any one of the preceding claims, wherein the inner element (31) is a bar element.
 6. Floorboards as claimed in any one of the preceding claims, wherein the inner element (31) in the first position is arranged above or below the outer element (30).
 7. Floorboards as claimed in any one of the preceding claims 1-5, wherein the inner element (31) in the first position is arranged partly above and partly behind the outer element (3), or is arranged partly below the outer element and partly behind the outer element.
 8. Floorboards as claimed in any one of the preceding claims, wherein the outer element (30) is provided with a guiding groove (60) at either an inner and upper edge of the outer element or at an inner and lower edge of the outer element (30), and at least a part of the inner element in the first position is arranged in said guiding groove (60).
 9. Floorboards as claimed in any one of the preceding claims 1-7, wherein the outer element is provided with a guiding groove (60) at an inner surface of the outer element (30), between an upper surface and a lower surface of the outer element, and at least a part of the inner element is arranged in said groove in the first position.
 10. Floorboards as claimed in claim 8 or 9, wherein the guiding groove (60) extends essentially along the whole longitudinal length of the outer element.
 11. Floorboards as claimed in any one of the claims 8-10, wherein in the first position an innermost surface of the inner element (31) is within the guiding groove (60) along an inner surface of the outer element (30).
 12. Floorboards as claimed in any one of the claims 8-11, wherein the inner element (31) comprises a first protruding part (36) configured to cooperate with the guiding groove (60), to obtain said displacement of the outer element.
 13. Floorboards as claimed in claim 12, wherein the first protruding part (36) in the first position is arranged outside of the outer element and/or in a recess of the outer element.
 14. Floorboards as claimed in claim 12 or 13, wherein the first protruding part is one of wedge shaped and essentially spherical shaped.
 15. Floorboards as claimed in any one of the preceding claims, wherein the entire outer element is arranged within the displacement groove in the first position.

Fig. 1

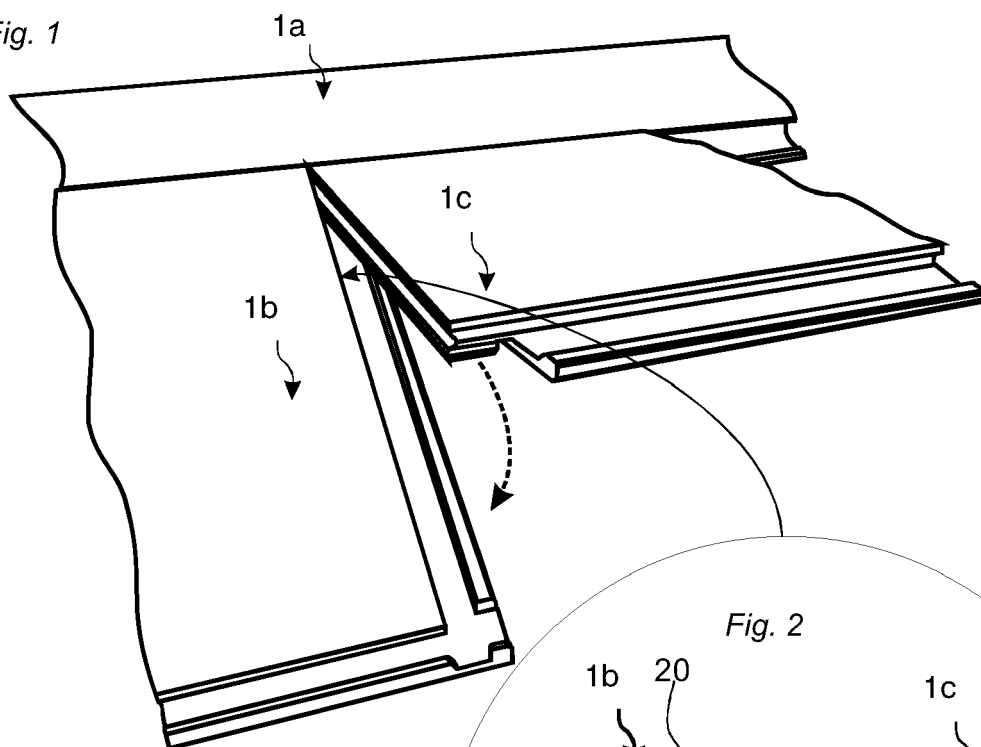


Fig. 2

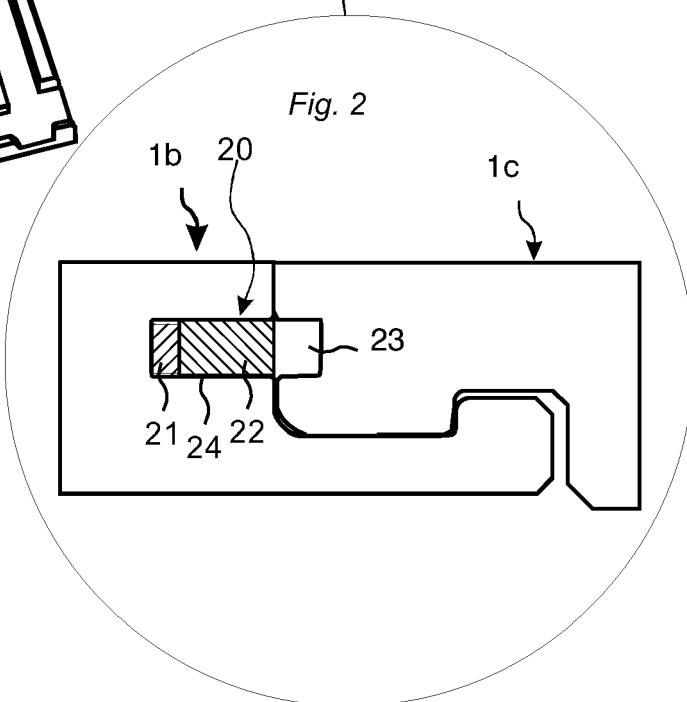
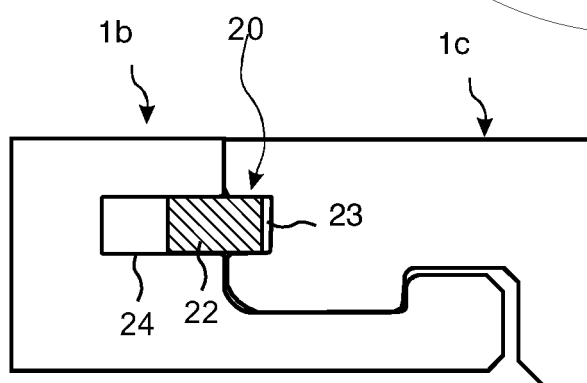


Fig. 3



KNOWN TECHNOLOGY

Fig. 4

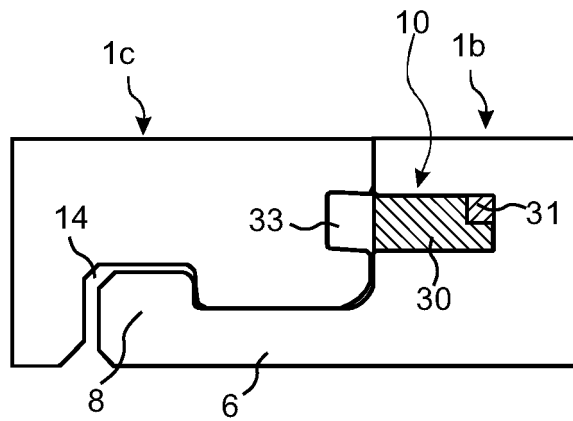


Fig. 5

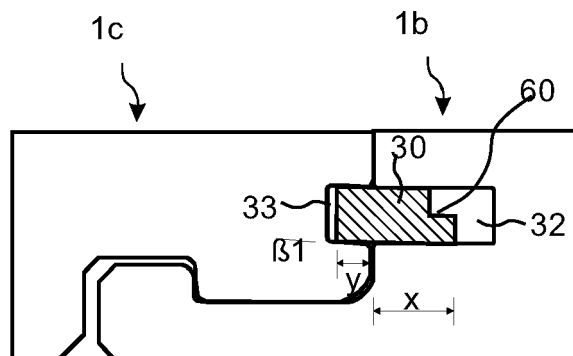


Fig. 6

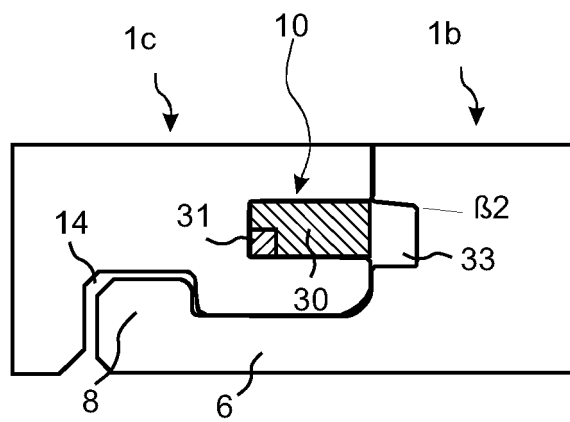


Fig. 7

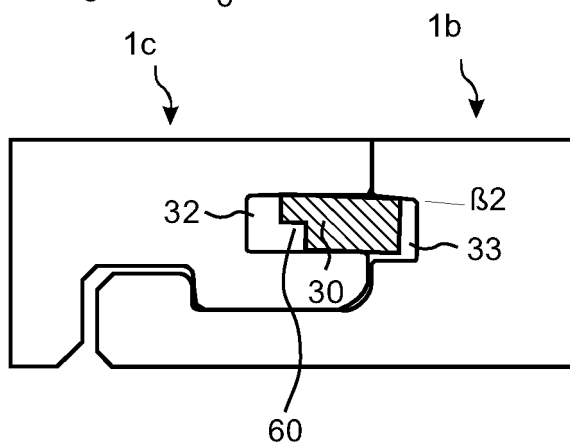


Fig. 8

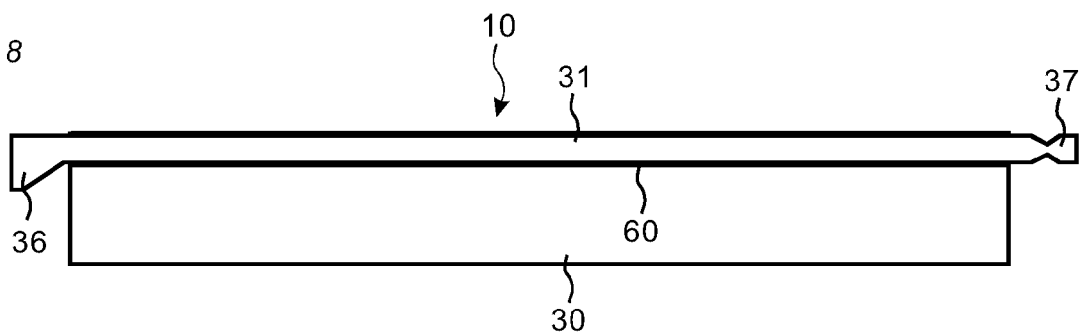


Fig. 9

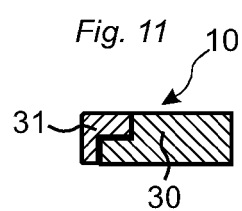
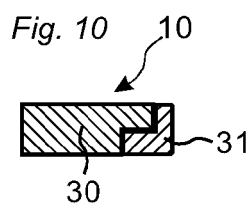
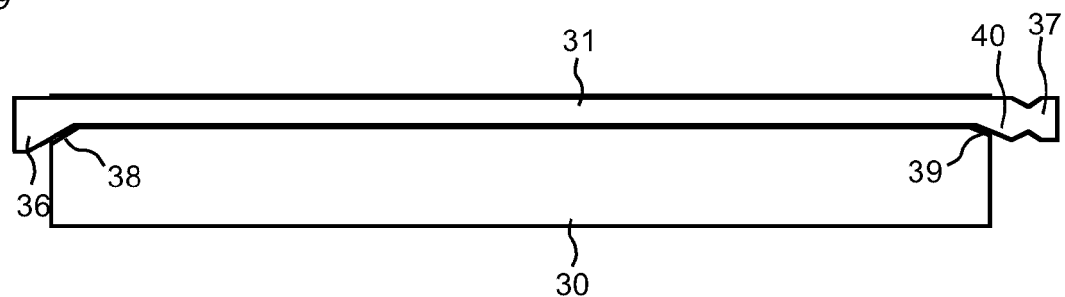


Fig. 12

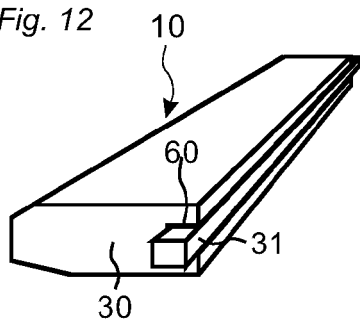


Fig. 13

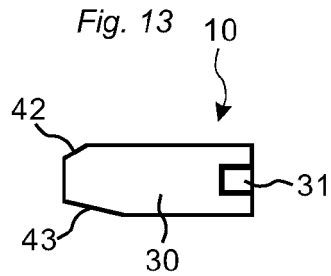


Fig. 14

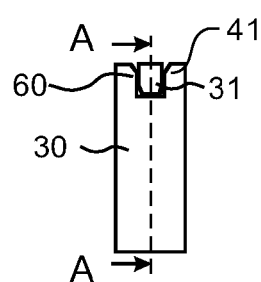
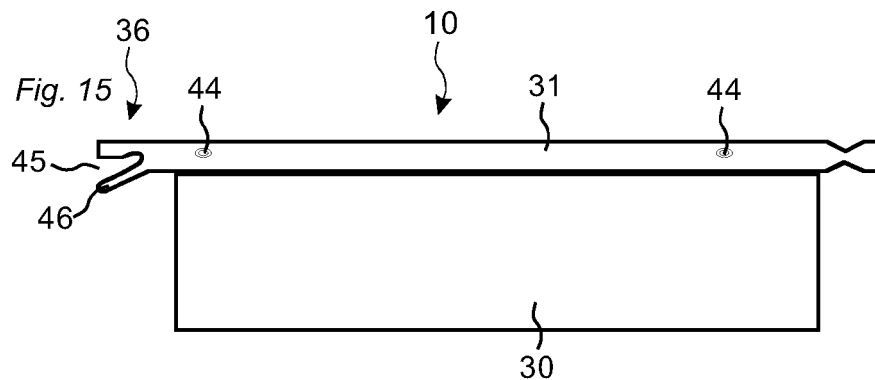


Fig. 15



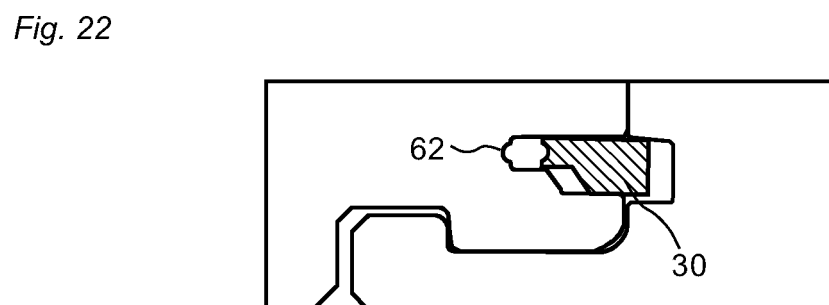
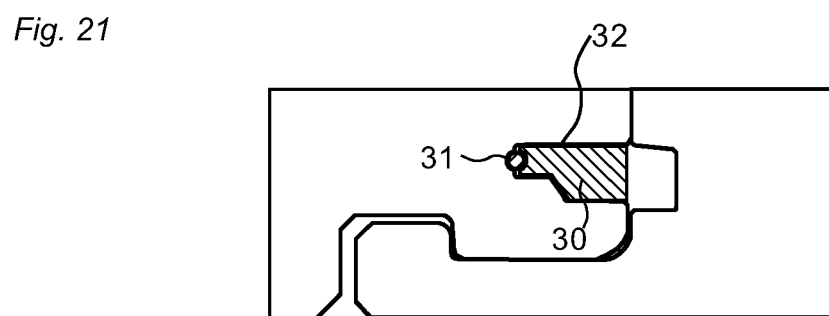
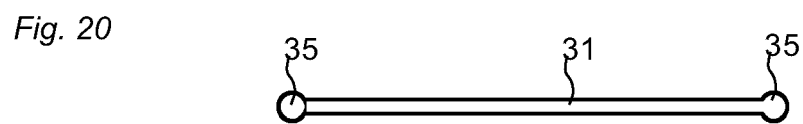
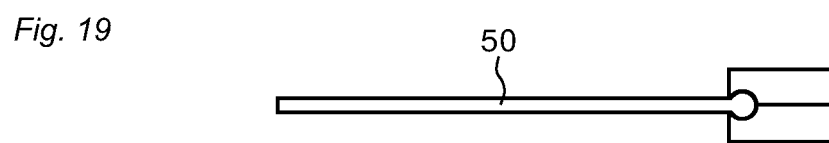
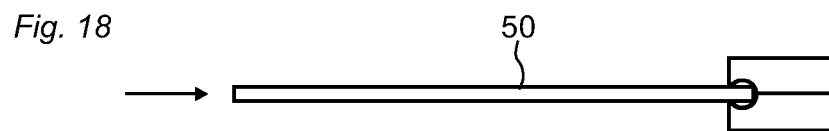
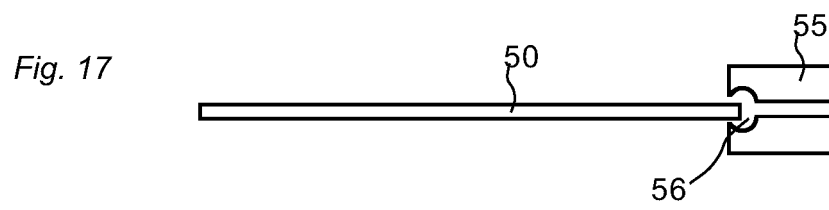


Fig. 23

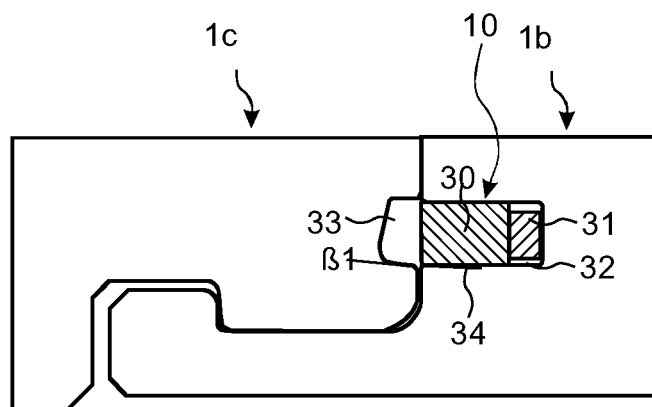


Fig. 24

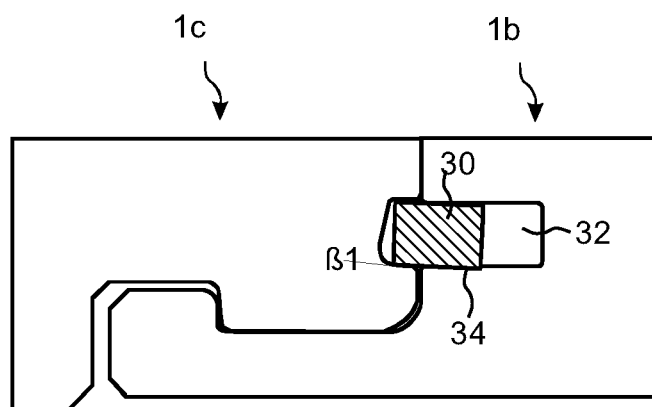


Fig. 25

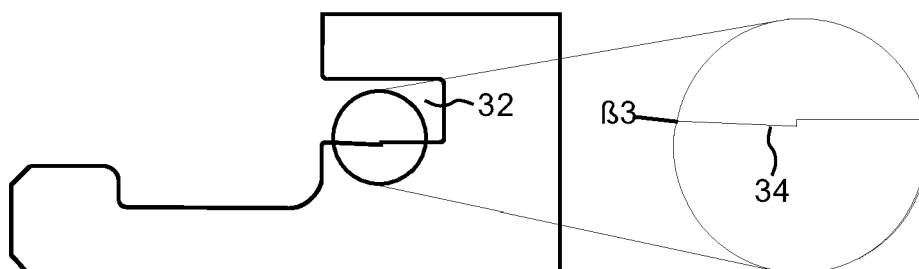
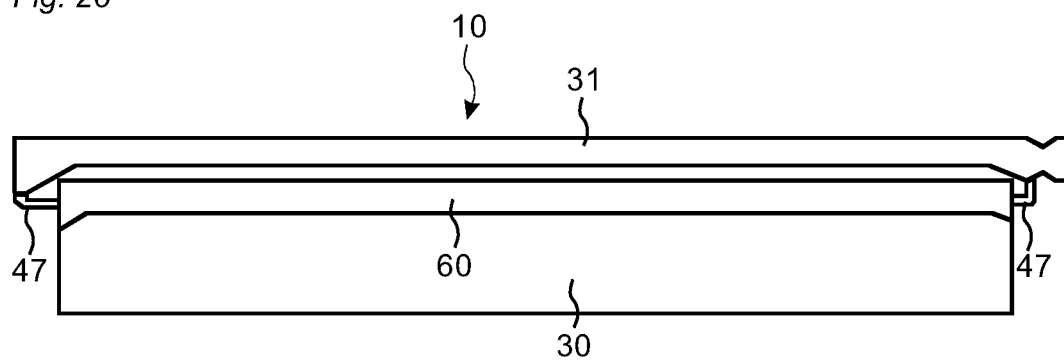


Fig. 26





EUROPEAN SEARCH REPORT

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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)
X	FR 2 975 716 A1 (ESPACE PRODUCTION INTERNATIONALE [FR]) 30 November 2012 (2012-11-30) * figures 1-6,9,12,15,17,19 * * page 4, line 36 - line 37 * * page 5, line 1 - line 5 * * page 5, line 10 - line 19 * * page 6, line 25 - line 34 * * page 7, line 2 - line 5 * * page 9, line 21 - line 24 * * page 10, line 10 - line 15 * -----	1-15	INV. E04F15/02 E04F15/04 E04F15/10
			TECHNICAL FIELDS SEARCHED (IPC)
			E04F
The present search report has been drawn up for all claims			
Place of search Munich		Date of completion of the search 6 July 2018	Examiner Estorgues, Marlène
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10	Patent document cited in search report	Publication date	Patent family member(s)	Publication date
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