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54 **PANEL AND METHOD FOR PRODUCING A PANEL**

57 The invention relates to a panel and a method for producing a panel. The panel is in particular a floor, wall or ceiling panel, and comprises at least one core layer, the core layer comprising an upper core surface and a lower core surface and at least one pair of opposite side edges; wherein the core layer comprises magnesium oxide cement and fibres dispersed in said magnesium oxide cement.

Panel and method for producing a panel

The invention relates to a panel, in particular a floor, wall or ceiling panel. The invention also related to a method for producing a panel, in particular a floor, wall or ceiling panel.

Magnesium oxide (MgO) based floor panels offer an alternative solution to oriented strand board or plywood-based construction materials. The panels are popular due to their high load capacity. Currently known magnesium oxide based panels, are conventionally produced by forming a mixture, typically in the form of a slurry, of a combination of substances including magnesium compounds, additives, water and other materials; pouring said mixture layer by layer in a container, typically a mould; reinforcing the moulded composition by adding reinforcing materials at least between two layers or approximate one surface; curing the mixture in a conditioned room at controlled temperature and moisture; demoulding the dried mixture from the mould once optimal curing is achieved; and cutting said mixture into the desired shape of the panel. In most cases, the mixture used in the conventional process usually contains a lot of brine thereby requiring a lot of water. This entails conditioning of the panel to about two weeks or more until optimal condition is achieved; whilst requiring a significant amount of heat to maintain optimal curing conditions. There are several problems with the current process including that it costs a lot, is overly time consuming; as well with the resulting panel, as it requires the addition of reinforcing layers that are often composed of non-natural materials such as fiberglass or plastics, and is easily degraded under conditions of high temperature and/or high moisture.

It is an object of the invention to provide a panel, in particular a decorative building panel, such as a wall, flooring or ceiling panel and/or a method of producing such panel, which at least partially overcomes the above-mentioned disadvantages of the prior art.

The invention provides thereto: a panel, in particular a floor, wall or ceiling panel, comprising:

- at least one core layer, the core layer comprising an upper core surface and a lower core surface and at least one pair of opposite side edges;

wherein the core layer comprises magnesium oxide cement and at least 20 wt% of natural fibres dispersed in said magnesium oxide cement, wherein the magnesium oxide cement comprises at least 30 wt% magnesium oxide; and wherein the core layer has a density in the range of 1350 kg/m³ to 1550 kg/m³.

The panel according to the present invention benefits of a density which is significantly higher than conventional magnesium oxide based panels and also than natural fibres based HDF panels. Due the combination of magnesium oxide cement comprising at least 30 wt% magnesium oxide and at least 20 wt% natural fibres and the core layer having a density in the range of 1350 kg/m³ to 1550 kg/m³ a panel, in particular core layer of a panel, is obtained having a relatively good flexural and structural strength. This enables that the use an reinforcing layer in the core layer can be completely omitted. Magnesium oxide cement based panels according to the prior art often apply a fiberglass reinforcing layer in order to obtain a panel which is sufficiently strong. However, the use of fiberglass is undesired for various reasons. The fiberglass may eventually erode thereby posing a risk for the panel to weaken. Further, since fiberglass is not used, the core layer according to the present invention is found to be easier to mill and process, for example in order to provide complementary coupling means. Hence, the adaptability of the panel is increased, resulting in larger degree of freedom for the design and/or production. The use of complementary coupling means is in practice challenging for a magnesium oxide cement based panel due to the brittleness of the material. Despite that several publication claim that interconnecting coupling means, in interconnecting coupling means particular being configured for both horizontal and vertical locking, can be applied, this is in practice not feasible. Even the application of a simple tongue and groove combination is a severe challenge for conventional magnesium oxide cement based panels as the panels tend to break, crack and/or rupture. Since the panel according to the present invention has an improved flexural and structural strength when compared to conventional magnesium oxide cement based panels, this sensitivity for damage, in particular due to brittleness and lack of flexibility, is overcome. This does not only enable the optional use of complementary coupling means, but also enables a larger freedom in practical application of the panel as such. Prior art panels are often limited for use as wall and/or ceiling panels, where the use as floor panel cannot be guaranteed due to its

fragility. Conventional magnesium oxide cement panels are typically not sufficiently resistant for forces applied during (intensive) use and/or peak loads, which limitation is overcome by the present invention. The panel according to the present invention can be both configured for and suitable for use as floor panel. The use of natural fibres is also beneficial from economical point of view, as natural fibres are typically cheaper than fiberglass, or any other conventional reinforcing material.

In the prior art it is known to produce magnesium oxide cement based panels via an extensive and time consuming process of drying of a magnesium oxide cement slurry, wherein the slurry contains at least 50 wt% of water, and often even over 60 wt% water. This production process allows a wet slurry to set in moulds, creating a sediment at its bottom moulded surface that has a higher density compared to the core and upper surface of the slurry, which contains bubbles created during the chemical reactions in the curing process, and lower density components such as wood fibres that float upward in the slurry before full curing is achieved. It is clear that the relatively low density and fragility of the material throughout most of the volume of the panel produced according to the prior art pose limitations for use as a decorative building panel. Further, it is typically attempted to achieve a density as low as possible for magnesium oxide cement based panels due to relatively light panels being more easy to handle for building purposes. Magnesium oxide cement based panels according to the prior art, and in particular the core layer of such panel, typically have a density between 600 and 1000 kg/m³. For specific embodiments of prior art magnesium oxide cement panels, densities of 1000 to 1200 kg/m³ have been observed, which is still considerably lower than the density of the core layer of the panel according to the present invention. Surprisingly it was found that a magnesium oxide cement based core layer having a density of 1350 to 1550 kg/m³, densities practically impossible to reach when produced according to the prior art, has very usable characteristics for use in floor-, wall- and/or ceiling coverings. As indicated, the panel according to the present invention benefits of a good flexural and structural strength. In addition that this contributes to the usability of the panel, the good flexural and structural strength further lowers the risk of damaging of the panel. Damaging can for example occur in the form of cracking and/or splitting of the panel during use and/or handling. When compared to convention MgO-based panels and/or HDF panels, the panel according to the present invention benefits of an enhanced modulus of rupture (MOR) and modulus

of elasticity (MOE). This benefit can at least partially be explained by the relatively high density of the panel.

5 The combination of materials used in the core layers enables that the core layer has relatively good stability under high temperatures and/or high humidity. In fact, especially when compared to HDF panels and conventional MgO panels, the panel according to the present invention exhibits relatively high waterproof and heat resistant properties, meaning that the panel is more stable when in water thereby exhibiting less swelling and is also more tolerant to heated thereby exhibiting less
10 shrinking. This effect makes the panels in particular suitable for use as a building material, such as for flooring, wall and/or ceiling panels. A further benefit of the use of natural fibres in the magnesium oxide cement is that this reduces the overall weight of the panel whilst and may also have a sound dampening effect.

15 The panel according to the present invention in particular benefits of the high density due to its clever production method which allows for good encapsulating of the natural fibres within the magnesium oxide cement. Hence, the natural fibres in fact form a reinforcing network within the core layer. This can be at least partially explained by the panel, and in particular the core layer, being subjected to a
20 relatively high pressure force of more than 7Mpa during production. Also the efficient use of process water during production is found to contribute to the beneficial material properties of the final product.

The panel according to the present invention is preferably free of phenolic and/or
25 thermoplastic resins. There is no need to use any resins, in particular phenolic and/or thermoplastic resins, as the panel according to the present invention already benefits of sufficient waterproofness. This is beneficial as in particular phenolic resins can be highly toxic, causing risks during the production process, but even after installation of the panels it is found that phenol can be emitted to the
30 atmosphere for example due to moisture degradation of the panel.

Within the scope of the present invention, when it is referred to magnesium oxide cement it can also be referred to magnesia cement. The indication wt% indicates the percentage by weight. Where it is referred to natural fibres, also the term

natural particles, fibrous chips and/or natural chips can be used within the scope of the present invention.

In a preferred embodiment of the panel according to the present invention, the average length of at least part of the natural fibres is at least 2 mm. It is beneficial to apply natural fibres having an average length of at least 2 mm as natural fibres having said length can positively contribute to the internal structure of the core layer. At least part of the natural fibres are typically encapsulated by the magnesium oxide cement, thereby forming a network of fibres dissipated over the entire core layer. Hence, the natural fibres in fact form a reinforcing network within the core layer. An average fibre length of at least 2 mm allows for good encapsulating of the fibres and for the provision of an effective reinforcing network.

Natural fibres having an average length below 2 mm cannot sufficiently contribute to improving the flexural and/or structural strength of the panel for specific purposes. The use of smaller fibres, such as dust and/or powder, will result in a relatively brittle panel which is prone to breaking. Further, this will also not allow application of interlocking coupling means for the panels. Hence, in order to be able to obtain the desired material properties for the magnesium oxide cement for the core layer, the at least 10 wt% of natural fibres having an average length of at least 2 mm is recommended. An average fibre length is mentioned, as natural fibres typically vary in their sizes, such as shape, length and/or diameter. It is conceivable that a, relatively small, fraction of natural fibres having a length below 2 mm present. It is also conceivable that the average length of at least part of the natural fibres is between 2 and 5 mm. In another preferred embodiment, the average length of at least part of the natural fibres is between 2 and 10 mm, in particular between 2.5 and 8 mm, more in particular between 3 and 5 mm. It is also conceivable that at least 50 wt% of the natural fibres dispersed in the magnesium oxide cement has an average length of at least 2 mm.

The natural fibres can for example be plant fibres, mycelium fibres and/or animal fibres. In a preferred embodiment, the natural fibres comprise lignocellulosic fibres. Hence, at least a fraction of the natural fibres may comprise lignocellulosic fibres. It is also conceivable that the natural fibres are formed by lignocellulosic fibres.

Lignocellulosic fibres are typically microstructurally seen nonuniform along any

three-dimensional orientation. This is a notable difference to synthetic fibres, like carbon and/or glass fibre. However, despite this nonuniformity of the natural fibres, they surprisingly found to be able to form an effective reinforcing network within the core layer comprising magnesium oxide cement. Lignocellulosic fibres further
5 benefit of being relatively cheap, in particular when compared to fiberglass.

The natural fibres may possibly comprise wood fibres. It is conceivable that the wood fibres are hardwood fibres or softwood fibres. However, it is also conceivable that a combination of hardwood fibres and softwood fibres is applied. The wood
10 fibres may for example be pine, oak and/or poplar fibres. It is also conceivable that the natural fibres comprise bamboo fibres.

In a further preferred embodiment, the core layer comprises at least 30 wt% natural fibres. It is conceivable that the core layer comprises up to 60 wt% of natural fibres,
15 preferably up to 50 wt%. Non-limitative examples are the core layer comprising between 25 and 45 wt% of natural fibres or between 30 and 40 wt% of natural fibres. Yet another non-limitative example is the core layer comprising between 15 and 25 wt% natural fibres, and preferably between 17 and 20 wt%. In a preferred
20 embodiment, the spatial variation of density of the core layer is below 10%, preferably below 8%, even more preferably below 6%, over the (entire) volume of the core layer. It is also conceivable that the spatial variation of density of the core layer is below 4%, preferably below 2%, even more preferably below 1%, over the (entire) volume of the core layer. Typically, the spatial variation of the density of the
25 core layer of a panel according to the present invention is minimal. Possibly, the density of the core layer is substantially constant over the (entire) volume of the core layer. Hence, the core layer is substantially homogeneous over the entire volume of the core layer. The core layer is in particular free of any regions and/or zones having an increased density. Regions having an increased density are generally observed for conventional magnesium oxide cement based panels. The
30 increased density regions observed in the prior art panels are typically obtained by applying a conventional production process using excessive water and/or by the use of integrated reinforcing layers.

The magnesium oxide cement comprises preferably at least 35 wt% magnesium
35 oxide, and more preferably at least 40 wt%, and even more preferably at least 45

wt%. It is for example imaginable that the magnesium oxide cement comprises between 35 and 55 wt% magnesium oxide, preferably between 40 and 50 wt%. In a possible embodiment, the magnesium oxide cement comprises magnesium hydroxide. It is conceivable that at least part of the magnesium oxide is converted into magnesium hydroxide during the production process of the magnesium oxide cement. In yet further possible embodiment, the magnesium oxide cement may comprise magnesium chloride ($MgCl_2$) and/or magnesium sulphate ($MgSO_4$). It is for example possible that the magnesium oxide cement comprises up to 30 wt% of magnesium chloride, and preferably up to 25 wt%, and/or up to 30 wt% of magnesium sulphate, and preferably up to 25 wt%. It is also conceivable that the magnesium oxide cement comprises both magnesium chloride and magnesium sulphate, preferably up to 30 wt%, and preferably up to 25 wt%.

It is also imaginable that at least one core layer at least partially comprises a magnesium crystal structure. The formation and microstructure of a magnesium oxide cement can be described in "crystal" or "hydration" phases and expressed in terms of a ternary system consisting of the ratio of magnesia, a magnesium salt such as magnesium sulphate or magnesium chloride, and water. Crystalline phases are formed upon curing into a ceramic compound and can be expressed in an abbreviated version referring to the molar ratio of each in the crystal formed. Magnesium oxysulphate cement, which uses the salt magnesium sulphate as a key binding material, can form two stable crystalline phases under ambient conditions; one of which is composed of the compounds magnesium oxide, magnesium sulphate and water, generally referred to as the 5-phase (also known as 5-1-3 phase, standing for $5Mg(OH)_2.MgSO_4.3H_2O$), and 3-phase (also known as 3-1-8 phase, standing for $3Mg(OH)_2.MgSO_4.8H_2O$). Magnesium oxychloride similarly can form two stable crystalline phases, generally referred to as the 3-phase (also known as 3-1-8 phase, standing for $3Mg(OH)_2.MgCl_2.8H_2O$), and 5-phase (also known as 5-1-8 phase, standing for $5Mg(OH)_2.MgCl_2.8H_2O$). Other phases can form under extreme pressures and temperatures but are not stable under livable temperatures.

It is also conceivable that the core layer and/or the magnesium oxide cement comprises at least one filler, such as but not limited to talc, calcium carbonate ($CaCO_3$), perlite, polymer foam beads and/or a combination thereof. The core layer

- may for example comprise up to 15 wt% and preferably up to 10 wt% of fillers. The core layer and/or the magnesium oxide cement may also comprise at least one additive. At least one additive can for example be chosen from the group consisting of: a pigment, a colorant, an impact modifier, a lubricant, a stabilizer, a wax, an anti-halogen agent and/or an aid processing agent. The core layer may for example comprise up to 5 wt% of additive(s), preferably up to 2 wt%. A non-limiting example is the core layer comprising up to 1 wt%, preferably up to 0.5 wt% and more preferably up to 0.25 wt% ferric oxide (FeO₃).
- 10 Typically, the core layer has a thickness between 3 and 30 mm. It is for example conceivable that the core layer has a thickness between 3 and 15 mm, in particular between 5 and 10 mm. Due to the outstanding material properties of the core layer, the panel can be relatively thin compared to conventional panel configured for the same purpose. In a further preferred embodiment, the core layer has a density in
- 15 the range of 1375 to 1550 kg/m³, preferably in the range of 1400 to 1500 kg/m³. It is for example possible that the density of the core layer substantially equals 1400 kg/m³. Said density ranges are still found to provide good flexural and structural strength.
- 20 The core layer according to the present invention is found to be sufficiently strong for the provision of coupling parts. Hence, preferably, at least one pair of opposite side edges of the panel, and in particular of the core layer, is provided with complementary coupling parts. For example, the core layer comprises at least one pair of complementary coupling parts on at least two of its opposite side edges.
- 25 Said coupling parts may for example be interlocking coupling parts configured for mutual coupling of adjacent panels on multiple directions. Preferably, said interlocking coupling parts provide locking in both horizontal and vertical directions. Any suitable interlocking coupling parts as known in the art could be applied. For example, said interlocking coupling parts may be in the form of complementary
- 30 tongue and groove, male and female receiving parts, a projecting strip and a recess configured to receive said strip or any other suitable form. It is conceivable the mutually coupling parts require a downward scissoring motion when engaging, or are locked together by means of a horizontal movement. The complementary coupling means may even, according to the present invention, allow elastic
- 35 deformation in order to be engaged and/or disengaged. In a preferred embodiment,

at least one pair of complementary coupling parts is configured such that in a coupled state a pretension is existing. This pretension means that the complementary coupling parts exert forces onto each other in coupled state such that the complementary coupling parts, and thus the adjacent panels are forced
5 towards another. The complementary coupling parts thereby co-act in a substantially clamping manner, resulting in a more reliable coupling of the adjacent panels. The pretension may also positively contribute to the stability of the adjacent panels in a coupled state. It is for example conceivable that the complementary coupling parts have at least partially overlapping contours.

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In a preferred embodiment, the panel comprises at least one decorative top layer attached to the upper core surface of the core layer. The decorative top layer may for example be attached to the upper core surface of the core layer by means of an adhesive layer. The decorative top layer can for example comprise at least one
15 décor layer and at least one base coating layer. The décor layer may be formed by a decorative print which is printed directly on the upper core surface of the core layer. That the core layer is relatively stable under several ambient conditions, and not sensitive to swelling allows that a relatively large number of different top layers can be applied. Further non-limiting examples of possible decorative top layers
20 which can be used are a PVC decorative film, a PP decorative film, and/or PET decorative film. The decorative top layer may also comprises a wear layer, preferably a transparent and/or thermoplastic wear layer. It is also conceivable that the decorative top layer comprises a stone or a wood veneer. In case a stone veneer is applied, the stone veneer preferably comprises a material selected from
25 the group: natural stone, marble, granite, slate, glass and/or ceramic. The decorative top layer may for example comprise a ceramic tile. Due to the core layer according to the present invention having a good flexural and structural strength, the core layer is strong enough to be used in combination with a ceramic tile. This also applies to other relatively heavy top layers, wherein the core layer according to
30 the present invention can provide sufficient support. In case a decorative top layer comprising ceramic is applied, the ceramic may be of a type selected from the group: monocuttura ceramic, monoporosa ceramic and/or porcelain ceramic. The ceramic may also be a multi-cased ceramic. It is also conceived that the decorative top layer comprises a high-pressure laminate (HPL), a plurality of impregnated
35 layers, a decorative plastic or vinyl, linoleum, and/or decorative thermoplastic film.

The panel according to the present invention could optionally comprise at least one backing layer. Such backing layer, if applied, is preferably attached to the lower core surface of the core layer. It is also conceivable that the panel comprises (at its bottom surface) at least one balancing layer, generally composed of at least one layer comprising lignocellulose and a cured resin. The panel may also comprise at least one acoustic layer, usually composed of a low density foamed layer of ethylene-vinyl acetate (EVA), irradiation-crosslinked polyethylene (IXPE), expanded polypropylene (XPP) and/or expanded polystyrene (XPS). It is also conceivable that such acoustic layer comprises nonwoven fibres, wherein possibly the acoustic layer can be made from natural fibres like hemp or cork. However, the acoustic layer may also comprise a recycled and/or recyclable material, such as PET and/or rubber. The density of this acoustic layer, if applied, preferably has a density between 65 kg/m³ and 300 kg/m³, most preferably between 80 kg/m³ and 150 kg/m³. At least one backing layer may also be an adhesive layer in particular configured to attached the panel onto a surface. It is also imaginable that multiple backing layers are applied or that the backing layer is a combination of any of the said layers.

The invention also relates to a floor-, wall- and/or ceiling covering comprises a plurality of panels according to the present invention. The invention also relates to a panel, in particular a floor, wall or ceiling panel, comprising at least one core layer, the core layer comprising an upper core surface and a lower core surface and at least one pair of opposite side edges; wherein the core layer comprises magnesium oxide cement and at least 10 wt% of natural fibres dispersed in said magnesium oxide cement, wherein the magnesium oxide cement comprises at least 10 wt% magnesium oxide; and wherein the core layer has a density in the range of 1200 kg/m³ to 1600 kg/m³.

The invention also relates to a method for producing a panel, in particular a floor, wall or ceiling panel, preferably a panel according to the present invention, the method comprising the steps of:

- a) forming a magnesium oxide cement damp composition comprising at least magnesium oxide, natural fibres and water,
- b) subjecting the magnesium oxide cement damp composition to at least one sieving step;

- c) applying at least one layer of the magnesium oxide cement damp composition in or upon a mould part; and
- d) subjecting the layer of magnesium oxide cement damp composition to a force having a pressure of at least 7 MPa, in particular such that a core layer is formed, the core layer comprising an upper core layer and a lower core layer.

The steps of said method are generally subsequent steps. After the pressure of step d) is released, a core layer, or core board whereof multiple core layers can be formed, is obtained. The method according to the present invention allows to produce a core layer having a density in the range of 1200 kg/m³ to 1600 kg/m³, in particular between 1350 kg/m³ and 1550 kg/m³. As indicated above, a core layer comprising magnesium oxide cement and natural fibres, having a density in the range of 1350 kg/m³ to 1550 kg/m³ a panel, results in a core layer having a relatively good flexural and structural strength. The method also enables that a core layer can be obtained having a density which is substantially constant over the entire volume of the core layer. This can at least partially be explained by the pressure applied at step d). A substantially constant density is also beneficial for the overall strength of the panel. Typically, the magnesium oxide cement damp composition is formed by mixing at least magnesium oxide powder, natural fibres and water. The magnesium oxide cement damp composition is in practice a substantially powdery composition, which has a lower water content than a convention magnesium oxide cement slurry. The magnesium oxide cement damp composition is typically slightly wet but not soaked. Hence, the magnesium oxide cement damp composition can also be classified as textured composition.

Preferably, the magnesium oxide cement damp composition is mixed prior to at least one sieving step. Mixing of the magnesium oxide cement damp composition may contribute to at least part of the natural fibres being encapsulated by magnesium oxide cement. The method according to the present invention allows to achieve panels having a rather consistent quality, which can be at least partially explained by the clever combination of steps b) and d). These steps also at least partially prevent bubble formation and/or remove gas and/or bubbles present in the damp composition. Step d) enables the (chemical) reaction of the components of the magnesium oxide cement damp composition to finish and/or to cure the magnesium oxide cement damp composition. A further benefit of the method

according to the present invention, is that where conventional magnesium oxide cement based panels are typically produced by a process using excessive water, the panel according to the present invention can produced via a more process water efficient method. In practice, this means that substantially less process water is used, and needed, during the production process and it also enables a significant reduction of the overall production time. Hence, no overload of water is applied during the production process, which is amongst others, beneficial from environmental point of view. Typically, a predetermined amount of water is applied for forming the magnesium oxide cement damp composition, wherein the amount is determined based upon the water required for the (chemical) reaction with magnesium oxide and optionally any further components and/or curing thereof. For example, the amount of water to be used can be controlled based upon the desired properties of the final product and the desired crystal structure in the core. More specifically, the amount of water in weight percentage or molar ratio added to the composition directly influences which crystal structure is formed in the core during the pressing phase.

Step d) of the method can for example be achieved via at least one pressing and/or compressing step. Step d) enables the removal of excessive liquid from the magnesium oxide cement damp composition. During step d), the magnesium oxide cement damp composition is typically dried and/or cured. It is experimentally found that magnesium oxide and natural fibres effectively bond under pressure. The at least one sieving step enables that a more even composition of magnesium oxide cement damp composition and natural fibres can be obtained. During at least one sieving step a mesh size between 10 and 35 mm could for example be applied. The sieving step can for example be achieved by making use of a processor which preferably comprises brushes and/or sieves, for example sieves having a mesh size between 10 and 35 mm. It is also possible that multiple subsequent sieving steps are applied.

Where it is referred to a mould part also a mould, conveyer, container and/or a plate can be meant. Basically, due to the magnesium oxide cement damp composition having a relatively functional structure, it is not required that the mould part comprises raised edges and/or a rim. Typically, the magnesium oxide cement damp composition has a relatively low moisture content, wherefore the damp

composition does not behave like a liquid. This enables easier handling of the composition during processing thereof. Step c) may for example involve applying a layer which is at least partially 4 to 7 cm in thickness of the magnesium oxide cement damp composition in or upon the mould part. As indicated above, the method can also allow the production of core board whereof multiple core layers can be formed.

Preferably, the magnesium oxide cement damp composition formed at step a) has a moisture content below 50%, preferably below 35%, more preferably below 25%. It is for example possible that the magnesium oxide cement damp composition formed at step a) has a moisture content between 25 and 35%. It is possible to apply such relatively low moisture content due to the combination and/or fractions of materials used and the process steps applied in the present method. As indicated above, in the prior art it is known to produce magnesium oxide cement based panels via an extensive and time consuming process of drying of a magnesium oxide cement slurry, wherein the slurry contains at least 50 wt% of water, and often even over 60 wt% water. The need to use an overload of water is overcome by the method according to the present invention. The magnesium oxide cement damp composition may further comprise magnesium hydroxide, magnesium chloride and/or magnesium sulphate. The magnesium oxide cement damp composition may further comprises any of the additives and/or fillers as described for the present invention.

The natural fibres may be any of the above described natural fibres and may be present in any of the above described volumes. The average length of the natural fibres may for example be at least 2 mm. The natural fibres may comprise lignocellulosic fibres, such as but not limited to wood fibres. The method is typically performed under ambient conditions. However, it is also conceivable that the method is performed under vacuum or under a predetermined pressure above atmospheric pressure. Step d) is typically performed for a duration of at least 2 hours, preferably at least 4 hours. Step d) is in a further preferred embodiment performed for a duration between 6 hours and 12 hours. The panels can be demoulded after step d). The boards or panels typically have an initial strength that is at least 50% of the final strength after said duration intervals, and are the sufficiently strong to be further processed. Hence, the required process time is

significantly shorter than the process times which are typically required for the production of a magnesium oxide based panel. Conventional processes for the production of a magnesium oxide based panel typically have a duration of at least seven days, which can be even longer in case a layer of fiberglass is included in the panel.

The method may also comprise the step of profiling and/or edging of at least one side edge of at least one panel, and in particular the core layer of the panel. Such step may for example involve that at least one pair of complementary coupling parts is provided at at least two opposite side edges of the panel, preferably wherein the complementary coupling parts are configured such that in a coupled state a pretension is existing. The method may for comprise a step of attaching at least one decorative top layer to the upper core surface of the core layer and/or attaching at least one backing layer to the lower core surface of the core layer. Non-limiting examples of possible backing layers and/or decorative top layers to be used are described above for the panel according to the present invention.

In a further possible embodiment, the layer of magnesium oxide cement damp composition is during step d) subjected to a force having a pressure between 7 MPa and 20 MPa. It is for example also possible that the magnesium oxide cement damp composition is subjected to a force having a pressure below 18 MPa. The preferred pressure applied is at least partially dependent of the desired thickness and/or density of the final product.

It will be apparent that the invention is not limited to the examples described, but that numerous variants are possible within the scope of the attached claims that will be obvious to a person skilled in the art. It is not necessary to elaborate on examples of all conceivable combinations of the above-described inventive concepts, as a person skilled in the art will understand numerous inventive concepts can be (re)combined in order to arrive at a specific application.

The verb "comprise" and conjugations thereof used in this patent publication are understood to mean not only "comprise", but are also understood to mean the phrases "contain", "substantially consist of", "formed by" and conjugations thereof.

Conclusies

1. Paneel, in het bijzonder een vloer-, wand- of plafondpaneel, omvattende:
 - ten minste één kernlaag, waarbij de kernlaag een bovenkernvlak en een onderkernvlak omvat en tenminste één paar tegenoverliggende zijranden;
5 waarbij de kernlaag magnesiumoxide-cement omvat en ten minste 20 gew.% natuurlijke vezels die verdeeld zijn over het magnesiumoxide-cement, waarbij het magnesiumoxide-cement ten minste 30 gew.% magnesiumoxide omvat; en
 - 10 waarbij de kernlaag een dichtheid heeft die ligt in het gebied van 1350 kn/m³ tot 1550 kg/m³.
2. Paneel volgens conclusie 1, waarbij de gemiddelde lengte van de natuurlijke vezels ten minste 2 mm bedraagt.
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3. Paneel volgens een van de voorgaande conclusies, waarbij de gemiddelde lengte van de natuurlijke vezels tussen 2 en 5 mm ligt.
4. Paneel volgens een van de voorgaande conclusies, waarbij de natuurlijke
20 vezels lignocellulose vezels omvatten.
5. Paneel volgens een van de voorgaande conclusies, waarbij de kernlaag tenminste ten dele een kristalstructuur van magnesium omvat.
- 25 6. Paneel volgens een van de voorgaande conclusies, waarbij de kernlaag ten minste 30 gew.% natuurlijke vezels omvat.
7. Paneel volgens een van de voorgaande conclusies, waarbij de dichtheid van de kernlaag hoofdzakelijk constant is over het gehele volume van de kernlaag.
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8. Paneel volgens een van de voorgaande conclusies, waarbij het magnesiumoxide-cement ten minste 35 gew.% magnesiumoxide omvat, en bij voorkeur ten minste 40 gew.%, en meer bij voorkeur ten minste 45 gew.%.

9. Paneel volgens een van de voorgaande conclusies, waarbij het magnesiumoxide-cement magnesium hydroxide omvat.
10. Paneel volgens een van de voorgaande conclusies, waarbij het
5 magnesiumoxide-cement magnesiumchloride en/of magnesiumsulfaat omvat.
11. Paneel volgens een van de voorgaande conclusies, waarbij de kernlaag een dichtheid heeft in het gebied van 1400 tot 1500 kg/m³.
- 10 12. Paneel volgens een van de voorgaande conclusies, waarbij ten minste één paar tegenoverliggende zijranden van de kernlaag is voorzien van complementaire koppeldelen.
13. Paneel volgens conclusie 12, waarbij de complementaire koppeldelen
15 zodanig zijn uitgevoerd dat een voorspanning aanwezig is in een gekoppelde toestand.
14. Paneel volgens een van de voorgaande conclusies, omvattende ten minste één decoratieve toplaag die bevestigd is aan het bovenkernvlak van de kernlaag.
20
15. Paneel volgens een van de voorgaande conclusies, omvattende ten minste één achterlaag die is bevestigd aan het onderkernvlak van de kernlaag.
16. Werkwijze voor het produceren van een paneel, in het bijzonder een vloer-,
25 wand- of plafondpaneel, bij voorkeur volgens een van de voorgaande conclusies, omvattende de stappen van:
- a) het vormen van een vochtige samenstelling van magnesiumoxide-cement die tenminste magnesiumoxide, natuurlijke vezels en water omvat,
- b) het onderwerpen van de vochtige samenstelling van magnesiumoxide-
30 cement aan tenminste één zeefstap;
- c) het aanbrengen van ten minste één laag van de vochtige samenstelling van magnesiumoxide-cement op een gedeelte van een mal; en
- d) het onderwerpen van de laag van de vochtige samenstelling van magnesiumoxide-cement aan een kracht met een druk van tenminste 7 MPa.

17. Werkwijze volgens conclusie 16, waarbij de vochtige samenstelling van magnesiumoxide-cement een vochtgehalte heeft beneden 50%, bij voorkeur beneden 35%, meer bij voorkeur beneden 25%.
- 5 18. Werkwijze volgens conclusie 16 of 17, waarbij de vochtige samenstelling van magnesiumoxide-cement magnesiumhydroxide, magnesiumchloride en/of magnesiumsulfaat omvat.
- 10 19. Werkwijze volgens een van de conclusies 16 - 18, waarbij stap d) wordt uitgevoerd voor een periode van 6 tot 12 uur.
20. Werkwijze volgens een van de conclusies 16 - 19, waarbij tijdens stap d) de laag van de vochtige samenstelling van magnesiumoxide-cement wordt onderworpen aan een kracht met een druk tussen 7 MPa en 20 MPa.

SAMENWERKINGSVERDRAG (PCT)

RAPPORT BETREFFENDE NIEUWHEIDSONDERZOEK VAN INTERNATIONAAL TYPE

IDENTIFICATIE VAN DE NATIONALE AANVRAGE	KENMERK VAN DE AANVRAGER OF VAN DE GEMACHTIGDE
Nederlands aanvraag nr. 2025684	Indieningsdatum 26-05-2020
	Ingeroepen voorrangsdatum
Aanvrager (Naam) CHAMPION LINK INTERNATIONAL CORPORATION	
Datum van het verzoek voor een onderzoek van internationaal type 12-09-2020	Door de Instantie voor Internationaal Onderzoek aan het verzoek voor een onderzoek van internationaal type toegekend nr. SN76867
I. CLASSIFICATIE VAN HET ONDERWERP (bij toepassing van verschillende classificaties, alle classificatiesymbolen opgeven)	
Volgens de internationale classificatie (IPC) Zie onderzoeksrapport	
II. ONDERZOCHE GEBIEDEN VAN DE TECHNIEK	
Onderzochte minimumdocumentatie	
Classificatiesysteem	Classificatiesymbolen
IPC	Zie onderzoeksrapport
Onderzochte andere documentatie dan de minimum documentatie, voor zover dergelijke documenten in de onderzochte gebieden zijn opgenomen	
III. <input type="checkbox"/>	GEEN ONDERZOEK MOGELIJK VOOR BEPAALDE CONCLUSIES (opmerkingen op aanvullingsblad)
IV. <input type="checkbox"/>	GEBREK AAN EENHEID VAN UITVINDING (opmerkingen op aanvullingsblad)

**ONDERZOEKSRAPPORT BETREFFENDE HET
RESULTAAT VAN HET ONDERZOEK NAAR DE STAND
VAN DE TECHNIEK VAN HET INTERNATIONALE TYPE**

Nummer van het verzoek om een onderzoek naar
de stand van de techniek

NL 2025684

<p>A. CLASSIFICATIE VAN HET ONDERWERP INV. E04C2/04 B28B1/52 ADD.</p>		
<p>Volgens de Internationale Classificatie van octrooien (IPC) of zowel volgens de nationale classificatie als volgens de IPC.</p>		
<p>B. ONDERZOCHE TE GEBIEDEN VAN DE TECHNIEK</p>		
<p>Onderzochte minimum documentatie (classificatie gevolgd door classificatiesymbolen) E04C B29C B28B</p>		
<p>Onderzochte andere documentatie dan de minimum documentatie, voor dergelijke documenten, voor zover dergelijke documenten in de onderzochte gebieden zijn opgenomen</p>		
<p>Tijdens het onderzoek geraadpleegde elektronische gegevensbestanden (naam van de gegevensbestanden en, waar uitvoerbaar, gebruikte trefwoorden) EPO-Internal</p>		
<p>C. VAN BELANG GEACHTE DOCUMENTEN</p>		
Categorie °	Geciteerde documenten, eventueel met aanduiding van speciaal van belang zijnde passages	Van belang voor conclusie nr.
X	US 2 944 291 A (PRIOR WILLIAM L ET AL) 12 juli 1960 (1960-07-12) * kolom 3 *	1-20
X	----- KR 2014 0066086 A (SHINN HOWARD JONGHO [US]; SHINN JONG MU [KR]) 30 mei 2014 (2014-05-30) * alinea's [0012], [0019] - [0023]; conclusie 1 *	1-20
A	----- US 2009/011279 A1 (WISEBAKER JR JOHN [US] ET AL) 8 januari 2009 (2009-01-08) * alinea's [0022] - [0025]; figuren 1,3 *	1-20
E	----- WO 2020/197475 A1 (CERALOC INNOVATION AB [SE]) 1 oktober 2020 (2020-10-01) * bladzijde 3 *	1-20
<p><input type="checkbox"/> Verdere documenten worden vermeld in het vervolg van vak C. <input checked="" type="checkbox"/> Leden van dezelfde octrooifamilie zijn vermeld in een bijlage</p>		
<p>° Speciale categorieën van aangehaalde documenten</p> <p>"A" niet tot de categorie X of Y behorende literatuur die de stand van de techniek beschrijft</p> <p>"D" in de octrooiaanvraag vermeld</p> <p>"E" eerdere octrooi(aanvraag), gepubliceerd op of na de indieningsdatum, waarin dezelfde uitvinding wordt beschreven</p> <p>"L" om andere redenen vermelde literatuur</p> <p>"O" niet-schriftelijke stand van de techniek</p> <p>"P" tussen de voorrangsdatum en de indieningsdatum gepubliceerde literatuur</p>		<p>"T" na de indieningsdatum of de voorrangsdatum gepubliceerde literatuur die niet bezwarend is voor de octrooiaanvraag, maar wordt vermeld ter verheldering van de theorie of het principe dat ten grondslag ligt aan de uitvinding</p> <p>"X" de conclusie wordt als niet nieuw of niet inventief beschouwd ten opzichte van deze literatuur</p> <p>"Y" de conclusie wordt als niet inventief beschouwd ten opzichte van de combinatie van deze literatuur met andere geciteerde literatuur van dezelfde categorie, waarbij de combinatie voor de vakman voor de hand liggend wordt geacht</p> <p>"&" lid van dezelfde octrooifamilie of overeenkomstige octrooipublicatie</p>
<p>Datum waarop het onderzoek naar de stand van de techniek van internationaal type werd voltooid</p> <p>29 januari 2021</p>		<p>Verzenddatum van het rapport van het onderzoek naar de stand van de techniek van internationaal type</p>
<p>Naam en adres van de instantie</p> <p>European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016</p>		<p>De bevoegde ambtenaar</p> <p>Saretta, Guido</p>

**ONDERZOEKSRAPPORT BETREFFENDE HET
 RESULTAAT VAN HET ONDERZOEK NAAR DE STAND
 VAN DE TECHNIEK VAN HET INTERNATIONALE TYPE**
 Informatie over leden van dezelfde octrooifamilie

Nummer van het verzoek om een onderzoek naar
 de stand van de techniek
 NL 2025684

In het rapport genoemd octrooigeschrift	Datum van publicatie	Overeenkomend(e) geschrift(en)	Datum van publicatie
US 2944291	A	12-07-1960	GEEN

KR 20140066086	A	30-05-2014	GEEN

US 2009011279	A1	08-01-2009	GEEN

WO 2020197475	A1	01-10-2020	US 2020308846 A1 01-10-2020
			WO 2020197475 A1 01-10-2020

WRITTEN OPINION

File No. SN76867	Filing date (<i>day/month/year</i>) 26.05.2020	Priority date (<i>day/month/year</i>)	Application No. NL2025684
International Patent Classification (IPC) INV. E04C2/04 B28B1/52			
Applicant CHAMPION LINK INTERNATIONAL CORPORATION			

This opinion contains indications relating to the following items:

- Box No. I Basis of the opinion
- Box No. II Priority
- Box No. III Non-establishment of opinion with regard to novelty, inventive step and industrial applicability
- Box No. IV Lack of unity of invention
- Box No. V Reasoned statement with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement
- Box No. VI Certain documents cited
- Box No. VII Certain defects in the application
- Box No. VIII Certain observations on the application

	Examiner Saretta, Guido
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WRITTEN OPINION**Box No. I Basis of this opinion**

1. This opinion has been established on the basis of the latest set of claims filed before the start of the search.
2. With regard to any **nucleotide and/or amino acid sequence** disclosed in the application and necessary to the claimed invention, this opinion has been established on the basis of:
 - a. type of material:
 - a sequence listing
 - table(s) related to the sequence listing
 - b. format of material:
 - on paper
 - in electronic form
 - c. time of filing/furnishing:
 - contained in the application as filed.
 - filed together with the application in electronic form.
 - furnished subsequently for the purposes of search.
3. In addition, in the case that more than one version or copy of a sequence listing and/or table relating thereto has been filed or furnished, the required statements that the information in the subsequent or additional copies is identical to that in the application as filed or does not go beyond the application as filed, as appropriate, were furnished.
4. Additional comments:

Box No. V Reasoned statement with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement

1. Statement

Novelty	Yes: Claims	1-20
	No: Claims	
Inventive step	Yes: Claims	
	No: Claims	1-20
Industrial applicability	Yes: Claims	1-20
	No: Claims	
2. Citations and explanations
see separate sheet

WRITTEN OPINION

Application number
NL2025684

Box No. VI Certain documents cited

Certain published documents

see the Search Report

Non-written disclosures

Re Item V

Reasoned statement with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement

- 1 Reference is made to the following documents:
- D1 US 2 944 291 A (PRIOR WILLIAM L ET AL) 12 juli 1960 (1960-07-12)
- D2 KR 2014 0066086 A (SHINN HOWARD JONGHO [US]; SHINN JONG MU [KR]) 30 mei 2014 (2014-05-30)
- D3 US 2009/011279 A1 (WISENBAKER JR JOHN [US] ET AL) 8 januari 2009 (2009-01-08)
- D4 WO 2020/197475 A1 (CERALOC INNOVATION AB [SE]) 1 oktober 2020 (2020-10-01)
- 2 The present application does not meet the criteria of patentability, because the subject-matter of claim 1 does not involve an inventive step.
- 2.1 D1 reveals a Paneel, in het bijzonder een vloer-, wand- of plafondpaneel, omvattende:
- ten minste één kernlaag, waarbij de kernlaag een bovenkernvlak en een onderkernvlak omvat en tenminste één paar tegenoverliggende zijranden; waarbij de kernlaag magnesiumoxide-cement omvat en ten minste 20 gew.% natuurlijke vezels die verdeeld zijn over het magnesiumoxide-cement (see column 3, lines 20-24), waarbij het magnesiumoxide-cement ten minste 30 gew.% magnesiumoxide omvat (see column 3, lines 24-26).
- 2.2 The density is described as varying between about 160 to about 800 kg/cubic meter (see column 3, lines 39-42). Thus, the claimed panel differs from the known panel in that :
en waarbij de kernlaag een dichtheid heeft die ligt in het gebied van 1350 kg/m³ tot 1550 kg/m³.
- 2.3 The technical effect is that the resulting panel is stronger and adapted to resist higher loads/forces. *It is noted that this difference concerns only a final parameter of the panel and claim 1 is silent as to effective technical features to obtain such a different parameter.*
- 2.4 No inventive step may be ascertained for such a modification. Depending on the wished use, the skilled person would consider adopting measures for raising the density of the panel on the basis of her/his technical knowledge without involving an inventive step.

- 3 With regard to the independent method claim 16, similar considerations apply. The method of D1 involves introduction of the mixture into a steam press under pressure varying in accordance with *inter alia* fiber density. Typical value of pressure is 2000 lbs/sq.ft. for a 21 lbs/cubic foot density (column 3, lines 72-74), which corresponds to about 0,1 MPa for a desired density of 337 kg/m³. With a view of obtaining a higher density, the skilled person would start experimenting and raising the pressure value, while using a mould instead of a continuous roller arrangement like the one described in D1. This is straightforward for the skilled technician and does not involve an inventive step.
- 4 Similar considerations apply when starting from the panel and the method disclosed in D2. Here, the same starting mixture is described (see paras 11-12 and claim 1). Although no final density is revealed in D2, the skilled person would experiment with the method disclosed in paras 18-25, with corresponding density values as claimed.
- 5 Dependent claims 2-15, 17-20 do not appear to contain any additional features which involve an inventive step by themselves, because the man skilled in the art would employ them, if required, on the basis of his expert knowledge even if they are not disclosed in or obvious from the cited state of the art.

Concerning these claims, reference is made to the following documents:

To claims 2-10 and 17-19 : see D1, column 3, lines 15-38 and column 4;

To claims 11-12 : see D1, cited passages and D2, figure 3 ;

To claims 13-15 : top layer and backing sheet are common features for building panels, for which no inventive step may be seen.

To claim 20 : these values of pressure can be arrived at by means of routine experimentation.

Thus, even a combination of the features set out in these claims with the features of the independent claim to which they refer would not lead to subject-matter involving an inventive step.

Re Item VI

Certain documents cited

- 6 D4 is a relevant document (see page 3) which has been post-published but bears a priority date which is before the filing date of the present application. Its contents will be examined in the regional phase, if any.