

Title (en)  
Process for making a water-soluble pouch

Title (de)  
Verfahren zur Herstellung eines wasserlöslichen Beutels

Title (fr)  
Procédé de fabrication d'un sachet soluble dans l'eau

Publication  
**EP 1504994 A2 20050209 (EN)**

Application  
**EP 04025305 A 20011127**

Priority  
• EP 01987100 A 20011127  
• GB 0028821 A 20001127  
• GB 0028823 A 20001127  
• GB 0111131 A 20010505  
• GB 0127279 A 20011114  
• US 26546201 P 20010131

Abstract (en)  
A water-soluble pouch suitable for use in machine dishwashing and which comprises a plurality of compartments in generally superposed or superposable relationship, each containing one or more detergent active or auxiliary components, and wherein the pouch has a volume of from about 5 to about 70 ml and a longitudinal/transverse aspect ratio in the range from about 2:1 to about 1:8, preferably from about 1:1 to about 1:4. The water-soluble pouch allows for optimum delivery of dishwashing detergent. A process for the manufacture of multi-compartment pouches and a pack to contain the pouches are also disclosed.

IPC 1-7  
**B65B 9/04**

IPC 8 full level  
**B65B 9/04** (2006.01); **B65B 47/10** (2006.01); **B65D 30/02** (2006.01); **B65D 30/22** (2006.01); **B65D 65/46** (2006.01); **B65D 77/08** (2006.01); **B65D 81/00** (2006.01); **B65D 85/808** (2006.01); **C11D 3/20** (2006.01); **C11D 3/22** (2006.01); **C11D 3/30** (2006.01); **C11D 3/386** (2006.01); **C11D 3/39** (2006.01); **C11D 3/395** (2006.01); **C11D 3/43** (2006.01); **C11D 11/00** (2006.01); **C11D 17/00** (2006.01); **C11D 17/04** (2006.01)

CPC (source: EP)  
**B65B 9/042** (2013.01); **B65B 47/10** (2013.01); **B65D 85/808** (2013.01); **C11D 3/225** (2013.01); **C11D 3/3942** (2013.01); **C11D 3/3947** (2013.01); **C11D 17/0004** (2013.01); **C11D 17/003** (2013.01); **C11D 17/042** (2013.01); **C11D 17/045** (2013.01); **C11D 2111/14** (2024.01)

Cited by  
EP3124587A1; WO2017019271A1; CN102428008A; EP4113432A1; US2017029750A1; EP4190706A1; EP3858966A1; WO2021158380A1; WO2015195960A1; EP3098296A1; WO2016196049A1; US10844324B2; WO2021080948A2; US10472597B2; WO2020028443A1; WO2015034975A1; WO2015138283A1; WO2016106011A1; WO2016160738A2; EP3098295A1; WO2016195827A1; WO2020086935A1; US10781000B2; WO2013096653A1; WO2015034976A1; WO2016057376A1; WO2023114942A1; WO2014099525A1; US9725685B2; WO2022235655A1; WO2024015769A1; EP2432699B1; EP2508436A2; US8757062B2; US9446865B2; WO2017091533A1; US9969154B2; US8066818B2; WO2014099523A1; WO2015095358A1; EP3354728A1; EP3789407A1; WO2022178073A1; WO2015123323A1; WO2015195777A1; WO2017100720A1; EP3901257A1; EP3919599A1; US11920170B2; WO2014164777A1; WO2014164800A1; EP3336183A1; WO2021247810A1; EP3978604A1; EP2302026A1; WO2011034701A1; WO2011034761A1; WO2012051083A1; WO2018184004A1; WO2020077331A2; WO2020252500A1; WO2021092228A1; US11608388B2; WO2017083229A1; WO2019036721A2; US10822574B2; WO2021158543A1; WO2023287684A1; WO2023114988A2; WO2013128431A2; WO2017083226A1; EP3696264A1; US10876074B2; EP4163305A1; EP2380965A1; EP2380966A1; EP3124586A1; WO2017019272A1; WO2019118674A1; EP2088187A1; WO2024081773A1; EP2933194B1; EP2088187B2

Designated contracting state (EPC)  
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU MC NL PT SE TR

DOCDB simple family (publication)  
**WO 0242408 A2 20020530; WO 0242408 A3 20030417**; AT E291077 T1 20050415; AT E325861 T1 20060615; AT E350460 T1 20070115; AT E366698 T1 20070815; AT E440942 T1 20090915; AU 3934902 A 20020603; CA 2426645 A1 20020530; CA 2426645 C 20080610; CA 2592612 A1 20020530; CA 2592612 C 20080729; CA 2592729 A1 20020530; CA 2592729 C 20110222; DE 60109483 D1 20050421; DE 60109483 T2 20060119; DE 60109483 T3 20131114; DE 60119593 D1 20060614; DE 60119593 T2 20070503; DE 60125847 D1 20070215; DE 60125847 T2 20071011; DE 60125847 T3 20151203; DE 60129363 D1 20070823; DE 60129363 T2 20080403; DE 60139727 D1 20091008; EP 1337619 A2 20030827; EP 1337619 B1 20050316; EP 1337619 B2 20130619; EP 1484389 A1 20041208; EP 1484389 B1 20060510; EP 1504994 A2 20050209; EP 1504994 A3 20050608; EP 1504994 B1 20070711; EP 1516918 A2 20050323; EP 1516918 A3 20050330; EP 1516918 B1 20070103; EP 1516918 B2 20150701; EP 1790713 A2 20070530; EP 1790713 A3 20070905; EP 1790713 B1 20090826; ES 2240545 T3 20051016; ES 2240545 T5 20131028; ES 2264784 T3 20070116; ES 2279287 T3 20070816; ES 2279287 T5 20151020; ES 2289415 T3 20080201; ES 2329725 T3 20091130; JP 2004514608 A 20040520; JP 2006290466 A 20061026; JP 2009263670 A 20091112; JP 4403150 B2 20100120; JP 5697315 B2 20150408; MX PA03004624 A 20030905; PL 362685 A1 20041102; PT 1504994 E 20071017

DOCDB simple family (application)  
**US 0144280 W 20011127**; AT 01987100 T 20011127; AT 04021614 T 20011127; AT 04025305 T 20011127; AT 04030420 T 20011127; AT 07100947 T 20011127; AU 3934902 A 20011127; CA 2426645 A 20011127; CA 2592612 A 20011127; CA 2592729 A 20011127; DE 60109483 T 20011127; DE 60119593 T 20011127; DE 60125847 T 20011127; DE 60129363 T 20011127; DE 60139727 T 20011127; EP 01987100 A 20011127; EP 04021614 A 20011127; EP 04025305 A 20011127; EP 04030420 A 20011127; EP 07100947 A 20011127; ES 01987100 T 20011127; ES 04021614 T 20011127; ES 04025305 T 20011127; ES 04030420 T 20011127; ES 07100947 T 20011127; JP 2002545115 A 20011127; JP 2006107885 A 20060410; JP 2009130029 A 20090529; MX PA03004624 A 20011127; PL 36268501 A 20011127; PT 04025305 T 20011127