Title (en)
METHOD FOR MAKING A CENTRAL UNWINDING ROLL AND RESULTING ROLL

Title (de)
VERFAHREN ZUR HERSTELLUNG EINER ZENTRALEN ABWICKELROLLE UND ROLLE

Title (fr)
PROCEDE DE FABRICATION D"UN ROULEAU A DEVIDAGE CENTRAL ET ROULEAU OBTENU

Publication
EP 1747158 A1 20070131 (FR)

Application
EP 05763745 A 20050429

Priority
• FR 2005001065 W 20050429
• FR 0405022 A 20040510

Abstract (en)
[origin: WO2005120997A1] The invention concerns a method for making a coreless roll (110') consisting of a sheet (110) of non-humid soft material such as a fibrous absorbent material produced by unwinding the sheet in one direction and winding same about a reeling axis perpendicular to said direction, and comprising a central unwinding leader strip forming a projection along said axis relative to at least one part of the plane of one of the flanks of the roll. Said method is characterized in that it consists in producing the lead by offsetting prior to winding an end portion of the sheet (110) such that one of its longitudinal edges forms a non-null angle (alpha) relative to said unwinding direction, then in winding the sheet about the axis. Preferably, several rolls are manufactured by cutting longitudinally a large sheet. The invention is in particular useful for making wipe rolls, hand towel rolls or toilet paper rolls.

IPC 8 full level
B65H 19/28 (2006.01); **B65H 19/22** (2006.01)

CPC (source: EP US)
B65H 19/2246 (2013.01 - EP US); **B65H 19/2276** (2013.01 - EP US); **B65H 19/28** (2013.01 - EP US); B65H 2301/41429 (2013.01 - EP US); B65H 2301/4148 (2013.01 - EP US); B65H 2301/41485 (2013.01 - EP US); B65H 2301/415016 (2013.01 - EP US); B65H 2301/41828 (2013.01 - EP US)

Citation (search report)
See references of WO 2005120997A1

Designated contracting state (EPC)
AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HU IE IS IT LI LT LU MC NL PL PT RO SE SI SK TR

Designated extension state (EPC)
AL BA HR LV MK YU

DOCDB simple family (publication)
WO 2005120997 A1 20051222; AT E542764 T1 20120215; CA 2565107 A1 20051222; CA 2565107 C 20131126; EA 008988 B1 20071026; EA 200601866 A1 20070629; EP 1747158 A1 20070131; EP 1747158 B1 20120125; ES 2380772 T3 20120518; FR 2869891 A1 20051111; FR 2869891 B1 20070629; US 2007262187 A1 20071115; US 7878442 B2 20110201

DOCDB simple family (application)
FR 2005001065 W 20050429; AT 05763745 T 20050429; CA 2565107 A 20050429; EA 200601866 A 20050429; EP 05763745 A 20050429; ES 05763745 T 20050429; FR 0405022 A 20040510; US 56880605 A 20050429