

Title (en)
Improvements in paper manufacturing

Title (de)
Verbesserungen bei der Papierherstellung

Title (fr)
Améliorations dans la fabrication du papier

Publication
EP 2860310 A1 20150415 (EN)

Application
EP 14184871 A 20140916

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Abstract (en)
The present invention relates to improvements in methods of manufacturing paper, and in particular to improvements in forming stacks of sheets and cylinder moulds for manufacturing paper incorporating security elements. The method of forming a stack of sheets, comprises the steps of making a continuous web of paper having a plurality of sets of counterpoint watermarks (30) distributed along a longitudinal direction of the web. The sets of counterpoint watermarks (30) comprise at least a first set (45) of counterpoint watermarks having a first pattern and a second set (46) of counterpoint watermarks having a second pattern different from the first pattern. The web is slit in a transverse direction of the web into a plurality of interim sheets (31, 32), each sheet comprising one set of counterpoint watermarks (30). The interim sheets (31, 32) are stacked so that the counterpoint watermarks (30) of the first and second sets (45, 46) on the stacked interim sheets (31, 32) overlap each other at a plurality of overlap points (33) and the counterpoint watermarks comprise watermarks having positive regions.

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Citation (search report)

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