

Title (en)

METHOD FOR PRODUCING A CONTINUOUS PAPER WEB

Title (de)

VERFAHREN ZUM HERSTELLEN EINER ENDLOSEN PAPIERBAHN

Title (fr)

PROCÉDÉ PERMETTANT DE FABRIQUER UNE BANDE DE PAPIER SANS FIN

Publication

**EP 2943340 B1 20180314 (DE)**

Application

**EP 14705969 A 20140108**

Priority

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Abstract (en)

[origin: WO2014108329A1] The invention relates to a method for producing a continuous paper web for the production of security documents and value documents, comprising the following steps: • a) producing a continuous paper web on a cylinder mould machine, wherein the paper web is divided into a plurality of identical sheets of paper extending perpendicularly to the continuous longitudinal direction, and providing at least one sheet of paper per mould circumference of the cylinder mould with at least one watermark for the control of further processing steps, wherein there are certain position deviations between the positions of the watermarks of the sheets of paper, • b) detecting the positions of two or more watermarks on the continuous paper web, • c) determining mark positions having position deviations smaller than the position deviations of the detected watermarks, • d) producing coloured identification marks at the determined mark positions of the paper web, • e) detecting the positions of the produced identification marks, • f) providing the paper web with at least one through-opening in each of the sheets of paper by using the detected positions of the produced identification marks, wherein the through-openings each have exactly one straight edge arranged perpendicular to the longitudinal direction of the continuous paper web, • g) detecting the positions of the straight edges contained in the produced through-openings, and • h) providing the paper web with at least one film, which has security features to be applied to the paper web, on each of the sheets of paper by using the detected positions of the straight edges contained in the produced through-openings.

IPC 8 full level

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