

Title (en)  
METHOD AND SYSTEM FOR MANUFACTURING A TOBACCO POUCH

Title (de)  
VERFAHREN UND SYSTEM ZUR HERSTELLUNG EINES TABAKBEUTELS

Title (fr)  
PROCÉDÉ ET SYSTÈME POUR FABRICATION D'UNE POCHE À TABAC

Publication  
**EP 3138785 B1 20190130 (EN)**

Application  
**EP 16187086 A 20160902**

Priority  
NL 2015390 A 20150902

Abstract (en)  
[origin: EP3138785A1] The present invention relates to a method of manufacturing a tobacco pouch (80), the method comprising: - unrolling a film material (33) from a roll (32), - conveying the unrolled film material along an adhesive application station (36) comprising an adhesive nozzle (100A, 100B, 100C) and applying at least one row (70A, 70B, 70C) of bands of adhesive on the film material at regular intervals by ejecting a volume of adhesive from the at least one adhesive nozzle at regular intervals, - folding the film onto itself along at least one bottom fold (3) which extends lengthwise of the film material, - conveying the film material along a first heat welding station (38) and providing a right seam (10A) and a left seam (10B) in the first heat welding station along at least a right side (8A) and a left side (8B) of the tobacco pouch which is to be formed, the left and right seam extending transverse to a main longitudinal direction (7) of the film material, wherein each band of adhesive material ends at the left seam and right seam and does not extend into the left seam and right seam, - conveying the film material along a cutting station (39) and cutting the film material at regular intervals to form individual tobacco pouches.

IPC 8 full level  
**B65D 33/22** (2006.01); **A24F 23/02** (2006.01); **B65B 9/087** (2012.01); **B65B 29/00** (2006.01); **B65B 41/10** (2006.01); **B65B 51/02** (2006.01); **B65B 51/10** (2006.01); **B65B 59/00** (2006.01); **B65B 61/06** (2006.01)

CPC (source: EP US)  
**B65B 9/093** (2013.01 - EP); **B65B 29/00** (2013.01 - EP); **B65B 51/023** (2013.01 - EP); **B65B 51/146** (2013.01 - EP); **B65B 61/06** (2013.01 - EP); **B65D 33/22** (2013.01 - EP US); **A24F 23/02** (2013.01 - EP); **B31B 70/62** (2017.07 - EP); **B31B 70/79** (2017.07 - EP); **B31B 2155/00** (2017.07 - EP); **B31B 2155/001** (2017.07 - EP US); **B31B 2155/0014** (2017.07 - EP); **B31B 2160/10** (2017.07 - EP); **B31B 2170/10** (2017.07 - EP US); **B65B 59/00** (2013.01 - EP US); **B65D 75/5855** (2013.01 - EP)

Citation (opposition)  
Opponent : Focke & Co. (GmbH & Co. KG)  
• EP 1683736 A2 20060726 - FOCKE & CO [DE]  
• US 4256526 A 19810317 - MCDANIEL DAVID C  
• US 3427932 A 19690218 - WAGNER EDWARD E  
• US 3280860 A 19661025 - RUDOLF SCHNEIDER KURT, et al  
• EP 2532513 A2 20121212 - FOCKE & CO [DE]  
• EP 1812303 A1 20070801 - FOCKE & CO [DE]  
• EP 1437303 A2 20040714 - FOCKE & CO [DE]  
• DE 10109209 C1 20021010 - NORDENIA DEUTSCHLAND GRONAU [DE]  
• DE 102015001027 A1 20160602 - FOCKE & CO (GMBH & CO KG) [DE]  
• CA 2251196 A1 19990423 - HUELS CHEMISCHE WERKE AG [DE]  
• DE 202011050614 U1 20111024  
• EP 3009016 A1 20160420 - REEMTSMA H F & PH [DE]  
• US 2149030 A 19390228 - ARLINGTON MOORE GEORGE  
• DE 102012202858 A1 20120830 - NORDSON CORP [US]  
• US 8016734 B2 20110913 - FORT WESLEY C [US]  
• DE 4117428 A1 19921203 - H D G VERPACKUNGSMASCHINEN GMB [DE]  
• EP 2292520 A1 20110309 - FOCKE & CO [DE]  
• DE 102011105014 A1 20121213 - FOCKE & CO [DE]  
• SASCHA BACH: "Wirtschaftlich Siegeln", VERPACKUNGS-RUNDSCHAU, vol. 10, October 2007 (2007-10-01), pages 61 - 66, XP055651477

Cited by  
US2019075844A1; EP3435791B1

Designated contracting state (EPC)  
AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

DOCDB simple family (publication)  
**EP 3138785 A1 20170308**; **EP 3138785 B1 20190130**; **EP 3138785 B2 20230614**; DK 3138785 T3 20190423; HU E042900 T2 20190729; PL 3138785 T3 20190731

DOCDB simple family (application)  
**EP 16187086 A 20160902**; DK 16187086 T 20160902; HU E16187086 A 20160902; PL 16187086 T 20160902