

Title (en)  
CORELESS ROLLED PAPER MANUFACTURING METHOD

Title (de)  
HERSTELLUNGSVERFAHREN FÜR KERNLOSE PAPIERROLLEN

Title (fr)  
PROCÉDÉ DE FABRICATION DE PAPIER ENROULÉ SANS NOYAU CENTRAL

Publication  
**EP 3632280 B1 20230510 (EN)**

Application  
**EP 18911318 A 20180319**

Priority  
JP 2018010889 W 20180319

Abstract (en)  
[origin: EP3632280A1] Provided is a coreless paper roll manufacturing method for manufacturing roll-shaped wound paper that can be used up to its last edge. The method includes: a first step for winding up paper (2) to form paper roll (1) having a roll shape; a second step for inserting an insertion section, which ejects an adhesive, into a center hole (3) of the paper roll (1); a third step for causing the adhesive to adhere to a predetermined position of the center hole (3); and a fourth step for performing a heating and drying process on an area to which the adhesive is adhered so as to harden opposite ends (3a, 3b) of the center hole (3). The third step includes causing the adhesive to adhere to near opposite extending ends of the center hole (3). The adhesive has adhesive strength to an extent that the paper (2) wound up into the roll shape is peelable when the paper roll (1) is to be used. The fourth step includes drying the adhesive adhered to the center hole (3) before the adhesive spreads from the predetermined position of the center hole (3).

IPC 8 full level  
**A47K 10/16** (2006.01); **A47K 10/32** (2006.01); **B31C 5/00** (2006.01); **B65H 18/02** (2006.01); **B65H 18/28** (2006.01)

CPC (source: EP KR US)  
**A47K 10/16** (2013.01 - EP US); **B31C 5/00** (2013.01 - EP KR); **B31C 99/00** (2022.08 - KR); **B65H 18/028** (2013.01 - EP); **B65H 18/28** (2013.01 - EP KR US); **A47K 2010/3206** (2013.01 - EP US); **B65H 19/2276** (2013.01 - US); **B65H 2301/41424** (2013.01 - EP); **B65H 2301/41429** (2013.01 - EP); **B65H 2301/5143** (2013.01 - EP); **B65H 2301/517** (2013.01 - EP); **B65H 2406/21** (2013.01 - EP); **B65H 2701/1846** (2013.01 - EP US); **B65H 2701/1924** (2013.01 - KR US)

Cited by  
EP4049954A4

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 3632280 A1 20200408**; **EP 3632280 A4 20210127**; **EP 3632280 B1 20230510**; CN 110505825 A 20191126; CN 110505825 B 20210709; ES 2945436 T3 20230703; KR 102241172 B1 20210415; KR 20190111062 A 20191001; US 2020156891 A1 20200521; WO 2019180792 A1 20190926

DOCDB simple family (application)  
**EP 18911318 A 20180319**; CN 201880020920 A 20180319; ES 18911318 T 20180319; JP 2018010889 W 20180319; KR 20197023720 A 20180319; US 201816611360 A 20180319