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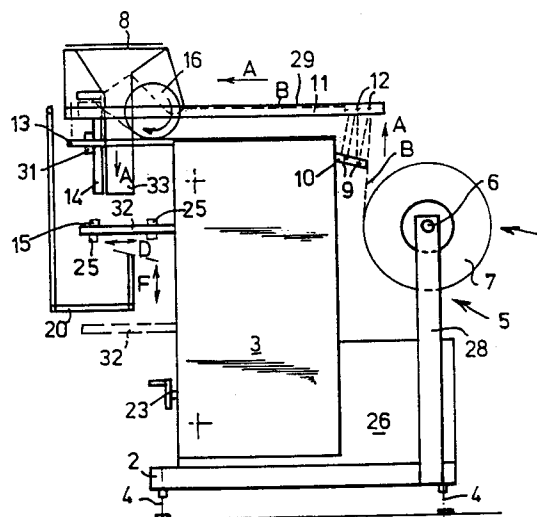
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(54) **Form, fill and seal apparatus.**

(57) Apparatus (1) for forming bags from a web (B) of synthetic film, filling them with a product and sealing them, comprising forming means (8, 33) for transforming a fed flat web of heat sealable material into a tubular form with overlapping margins, first heat sealing means (14) for forming a longitudinal sealing seam in the formed tube at the overlapping margins by heat sealing and second heat sealing means (15) for forming transverse sealing in the formed tube by heat sealing, as well as means (16, 19) for supplying a strip (S) of the same material up to and parallel to the tubularly formed web at a location upstream from the second heat sealing means which form the transverse sealing seam and downstream from the location where the film web is transformed to a tube.

**FIG. 1****EP 0 562 690 A3**



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EUROPEAN SEARCH REPORT

Application Number

EP 93 20 0834

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
D,X	US-A-4 894 975 (S. AUSNIT) * column 3, line 24 - column 4, line 26; figures *	1,2,3	B65B9/20 B65B61/18 B65B61/20
A	US-A-5 046 300 (R. CUSTER) * column 4, line 37 - column 6, line 22; figures *	1,2,3	
X	US-A-3 557 525 (U. BAUDER) * column 2, line 18 - column 3, line 33; figures *	4	
Y		5,6,7	
D,Y	NL-A-7 513 157 (PROCTER & GAMBLE) * page 8, line 6 - page 10, line 1 * * page 12, line 18 - page 13, line 17; figures 1-7 *	5,6	
Y	US-A-4 077 308 (J. SCULLY) * column 3, line 35 - column 6, line 5; figures *	7	
A		4,5	TECHNICAL FIELDS SEARCHED (Int. Cl.5)
A	US-A-4 517 787 (W. KREAGER) * column 4, line 16 - line 27 * * column 7, line 4 - line 38; figures *	4,5	B65B
A	US-A-4 322 929 (R. NEUMANN)		
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 22 SEPTEMBER 1993	Examiner JAGUSIAK A.H.G.
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			



CLAIMS INCURRING FEES

The present European patent application comprised at the time of filing more than ten claims.

- ☐ All claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for all claims.
- ☐ Only part of the claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for the first ten claims and for those claims for which claims fees have been paid, namely claims:
- ☐ No claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for the first ten claims.

LACK OF UNITY OF INVENTION

The Search Division considers that the present European patent application does not comply with the requirement of unity of invention and relates to several inventions or groups of inventions, namely:

see sheet -B-

- ☒ All further search fees have been paid within the fixed time limit. The present European search report has been drawn up for all claims.
- ☐ Only part of the further search fees have been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the inventions in respect of which search fees have been paid, namely claims:
- ☐ None of the further search fees has been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the invention first mentioned in the claims, namely claims:



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LACK OF UNITY OF INVENTION

The Search Division considers that the present European patent application does not comply with the requirement of unity of invention and relates to several inventions or groups of inventions, namely:

1. Claims 1,2,3: Apparatus for forming bags from a web of heat sealable material, including means for supplying a strip of the same material up to the tubularly formed web.
2. Claims 4,5,6,7: Apparatus for forming bags from a web of non-heat sealable material, including means for applying adhesive strips to the material web.

At least, there is non-unity a posteriori !
(contribution over US 4894975)