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(71) Applicant: **Arca Etichette S.p.A.**
20010 Marcallo con Casone (Prov. of Milano) (IT)

(72) Inventor: **Fadiga, Mauro**
20087 Robecco (Milano) (IT)

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27.09.1999 IT MI992007

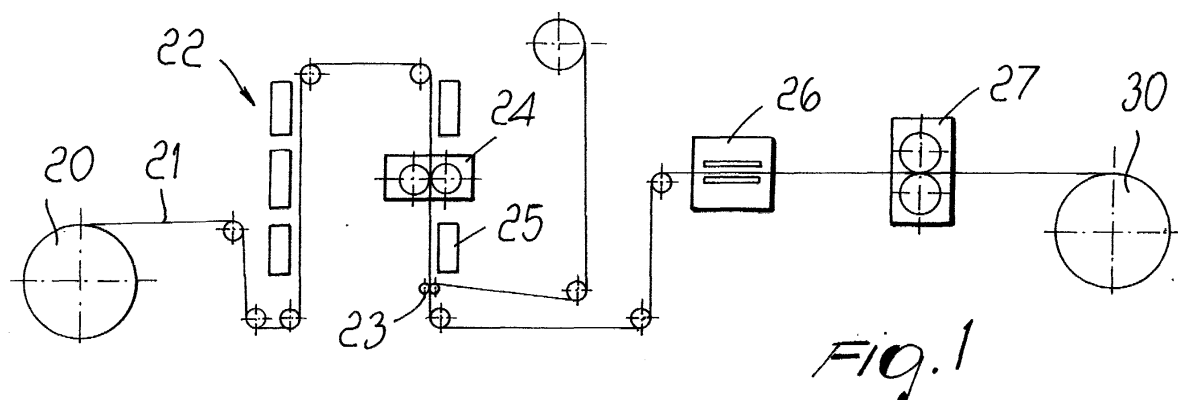
(74) Representative: **Modiano, Guido, Dr.-Ing. et al**
Modiano & Associati SpA
Via Meravigli, 16
20123 Milano (IT)

(54) **Method for producing integrity protection devices for packages of commercial products in general, apparatus for carrying out the method, and product produced with the apparatus and the method**

(57) A method for producing integrity protection devices for packagings of commercial products in general, comprising the steps of:

performing, on an adhesive-coated material, printing on a front layer of the adhesive-coated material, the front layer constituting a label;

performing a die-cutting of the front layer of material of the adhesive-coated material, in order to form pre-cuts on the front layer;
laminating the adhesive-coated material;
performing an additional die-cutting of the laminated adhesive-coated material, in order to define the contours of the label.



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EUROPEAN SEARCH REPORT

Application Number
EP 00 11 0925

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.7)
X	DE 34 31 239 A (ZWECKFORM WERK) 25 July 1985 (1985-07-25) * figure 2 *	1-8,10	G09F3/02 G09F3/03 B31D1/02
A	DE 36 38 412 A (LESCH HANS BERND DIPL ING) 26 May 1988 (1988-05-26)		
A	DE 42 39 846 A (ESSELTE METO INT GMBH) 1 June 1994 (1994-06-01)		
			TECHNICAL FIELDS SEARCHED (Int.Cl.7)
			G09F B31D
The present search report has been drawn up for all claims			
Place of search		Date of completion of the search	Examiner
THE HAGUE		28 November 2001	ROBERTS, P
<p>CATEGORY OF CITED DOCUMENTS</p> <p>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</p> <p>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</p> <p>& : member of the same patent family, corresponding document</p>			

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CLAIMS INCURRING FEES

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

- ☐ Only part of the claims 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 claim(s):
- ☐ 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 requirements 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.
- ☐ As all searchable claims could be searched without effort justifying an additional fee, the Search Division did not invite payment of any additional fee.
- ☐ 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 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 invention first mentioned in the claims, namely claims:

1-8, 10-25



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**LACK OF UNITY OF INVENTION
SHEET B**

Application Number
EP 00 11 0925

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

1. Claims: 1-8,10-25

Integrity protection device with adhesive layers of different strength and a method and apparatus for making integrity devices.

2. Claim : 9

Apparatus for making integrity devices comprising flat and rotary downstream die-cutting units.

**ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.**

EP 00 11 0925

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
The members are as contained in the European Patent Office EDP file on
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28-11-2001

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
DE 3431239 A	25-07-1985	NONE	
DE 3638412 A	26-05-1988	NONE	
DE 4239846 A	01-06-1994	NONE	

EPO FORM P0459

For more details about this annex : see Official Journal of the European Patent Office, No. 12/82