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(54) **Toner supply roll and production method therefore**

(57) A toner supply roll comprises a shaft (1) and a soft polyurethane sponge layer (2) provided on an outer circumferential surface of the shaft, wherein not less than 90% of cell walls defining boundaries between respective adjacent cells have openings. The soft polyurethane sponge layer of the toner supply roll is of an open-cell foam structure in which the cells are three-dimensionally connected to one another via the openings in the cell walls, so that air contained in the sponge layer smoothly flows out when the sponge layer is depressed. Therefore, the sponge layer has a lower hardness than a soft polyurethane sponge layer of a closed-cells foam structure. Since not less than 90% of the cell walls defining the boundaries between the respective adjacent cells have openings, toner fluidity can properly be maintained. Therefore, the toner supply roll can minimise degradation of the toner during prolonged use and stably maintain toner scrapability and toner supplying capability, thereby ensuring formation of high quality images for an extended period of time.

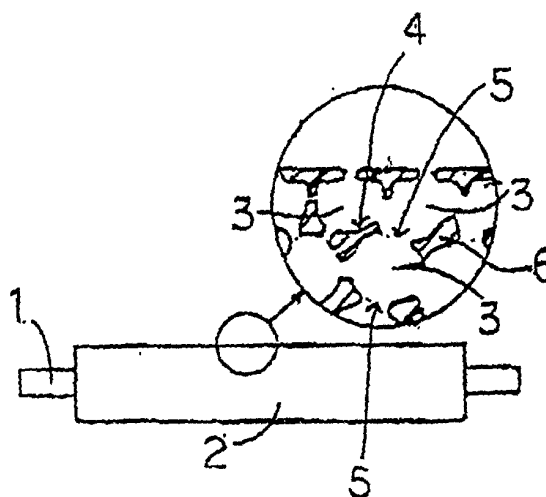


Fig. 1



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EUROPEAN SEARCH REPORT

Application Number
EP 00 12 1843

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Y	* column 11, line 63 - column 13, line 62; figures 2A,2B *	3,5	
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X	EP 0 597 444 A (KONISHIROKU PHOTO IND) 18 May 1994 (1994-05-18) * page 5, line 3 - page 15, line 43; figure 7; table 1 *	1,4	TECHNICAL FIELDS SEARCHED (Int.Cl.7)
			G03G
The present search report has been drawn up for all claims			
Place of search MUNICH		Date of completion of the search 20 November 2003	Examiner Borowski, M
<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 & : member of the same patent family, corresponding document</p>			

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**ANNEX TO THE EUROPEAN SEARCH REPORT
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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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