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(71) Applicant: **CIMA LABS INC.**
Eden Prairie, MN 55344-9361 (US)

(72) Inventors:
• **Amborn, Jerry**
Spring Lake Park
Minnesota 55432 (US)
• **Tiger, Vern**
Minneapolis
Minnesota 55418 (US)

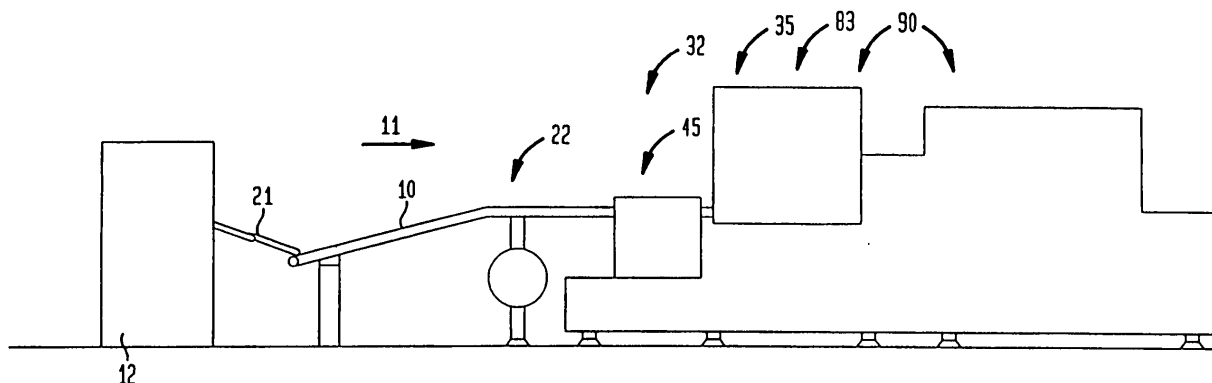
(74) Representative: **Amery, Marcus James et al**
Albihns GmbH
Bayerstrasse 83
80335 München (DE)

(54) **Apparatus for handling and packaging friable tablets**

(57) An assembly for handling and packaging pharmaceutical dosage forms includes an infeed structure (22), a laning structure (35), and a plenum structure (32) extending from the infeed structure to the laning structure. The infeed, laning and plenum structures guide dosage forms as they are carried in a downstream direction by a surface movable with downstream direction. A guide portion guides the dosage forms into the laning structure

to avoid jamming of tablets. A form handling device (83) receives dosage forms and transports the dosage forms to a packaging device (90). A timed controller and dump gate operate so that debris is carried out of the assembly. The assembly is particularly useful for fragile dosage forms. A packaging device having a bottom plate with floatably supported blocks is provided for sealing dosage forms into packages.

FIG. 1





European Patent
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EUROPEAN SEARCH REPORT

Application Number
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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
A	DE 44 06 089 A (LINGENFELDER OLI SPEZIALANLAGE) 19 October 1995 (1995-10-19) * claims 4-28; figures 1,3,4 *	1	B65B7/28 B65B23/00 B65B35/30 B65B51/14 B65B5/10
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			TECHNICAL FIELDS SEARCHED (IPC)
			B65B
The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of the search 20 February 2006	Examiner Grentzius, W
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	

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**ANNEX TO THE EUROPEAN SEARCH REPORT
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EP 04 02 5128

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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20-02-2006

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