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(54) **Methods of manufacturing slider-operated string-zippered bags of VFFS machine**

(57) A method of manufacture comprising the following steps: (a) guiding a web material in a machine direction through a vertical form-fill-seal (VFFS) machine with a portion or portions of the web material being wrapped around a tube; (b) joining first and second flangeless zipper strips to first and second portions of the web material

that do not form part of the portion or portions of the web material that are wrapped around the tube; (c) inserting a slider on the first and second flangeless zipper strips joined to the web material; (d) cross sealing the web material at a location downstream from the tube; and (e) dropping product through the tube and onto the most recently formed cross seal.

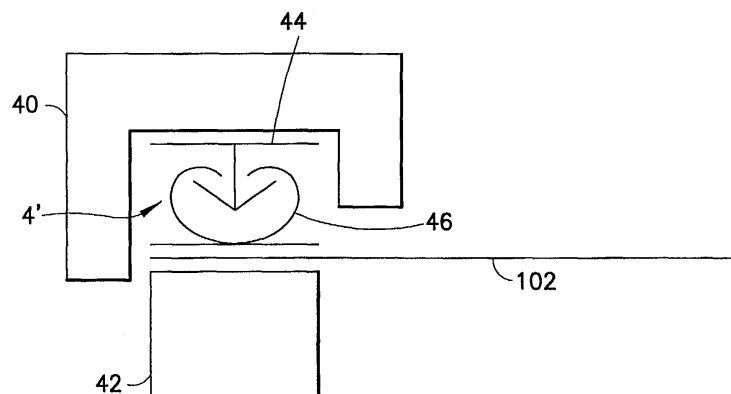


FIG.5

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EUROPEAN SEARCH REPORT

Application Number
EP 05 25 4491

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The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of the search 21 February 2006	Examiner Vigilante, M
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