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(54) **Process for production of pouches**

(57) A process for the production of water-soluble pouches. The process comprises the steps of drawing a first film into a mould to form a first compartment, adding composition to the first compartment, drawing a second film into the mould to form a second compartment which comprises a composition and sealing. The first film is perforated and the second film is drawn into the mould by means of suction applied through the first film. This eliminates the need to align separately formed pouches or containers. This also reduces the total amount of film

needed to produce a multi-compartment pouch. Furthermore, it is very easy to vary the film material used according to what properties are desired. Since the different compartments may require different properties this adds flexibility to the process.

Process particularly suited for the production of water soluble pouches such as cleaning or fabric care pouches.

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## EUROPEAN SEARCH REPORT

Application Number  
EP 06 11 0336

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
Y	US 3 208 192 A (SCHAEFER JEAN E) 28 September 1965 (1965-09-28) * figures 1-3 * * column 2, line 65 * * column 3, line 54 - line 55 * * column 5, line 6 - line 12; claim 1 * -----	1-10	INV. B65B9/04 B65D65/46 B65D81/32
Y	US 3 533 215 A (OLLIER JACQUES HONORE GASPARD) 13 October 1970 (1970-10-13) * column 1, line 26 - line 31 * * figure 1 * -----	1-9	
A	US 4 862 676 A (MANCINI DEREK [CA]) 5 September 1989 (1989-09-05) * figure 1 * -----	1-10	
Y	WO 93/08095 A1 (RHONE POULENC AGROCHIMIE [FR]) 29 April 1993 (1993-04-29) * abstract * * figure 1 * * claim 23 * * page 14, line 4 - line 13 * * page 15, line 3 - line 26 * -----	10	TECHNICAL FIELDS SEARCHED (IPC)  B65B B65D
The present search report has been drawn up for all claims			
Place of search <b>Munich</b>		Date of completion of the search <b>15 February 2010</b>	Examiner <b>Damiani, Alberto</b>
<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 ..... &amp; : member of the same patent family, corresponding document</p>			

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EPO FORM 1503 03/82 (P04C01)

**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.  
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