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(54) **A method of belt reeling and a belt reeler**

(57) A method in a belt reeler in which a reeling nip (7) is formed by a reeling core (6) or a growing machine reel (4) and at least one endless supporting member (3) travelling at least via a first wire guiding roll (1), and a second wire guiding roll (2). In the method several parameters are adjusted simultaneously to adjust the reel-

ing process, of which parameters at least the first parameter and the second parameter are one of the following: web tension (P1), wire tension (P2), distance of the machine reel from the wire turning roll (P3), depression of the wire/machine reel (P4), surface draw (P5, P5', P5''), peripheral force (P6).

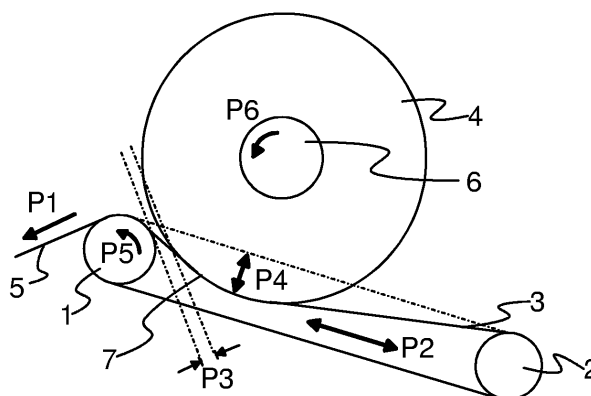


Fig. 1



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EUROPEAN SEARCH REPORT

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EP 06 39 7015

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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 17 July 2008	Examiner Haaken, Willy
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			

9 EPO FORM 1503 03.02 (P04C01)



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Application Number
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The present search report has been drawn up for all claims			
Place of search		Date of completion of the search	Examiner
The Hague		17 July 2008	Haaken, Willy
<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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EPO FORM 1503.03.82 (P04C01)

**CLAIMS INCURRING FEES**

The present European patent application comprised at the time of filing claims for which payment was due.

- ☐ Only part of the claims have been paid within the prescribed time limit. The present European search report has been drawn up for those claims for which no payment was due 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 those claims for which no payment was due.

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:
- ☐ The present supplementary 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 (Rule 164 (1) EPC).



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, 2, 7

A method in a belt reeler in which a reeling nip is formed by a reeling core or a growing machine reel and at least one endless supporting member travelling at least via a first wire guiding roll and a second wire guiding roll, characterized in that several parameters are determined and adjusted simultaneously to adjust the reeling process, of which parameters at least the first parameter and the second parameter are one of the following: web tension, wire tension, distance of the machine reel from the wire turning roll, depression of the wire/machine reel, surface draw, peripheral force.

2. claims: 3, 8, 11

A method for rebuilding a centre-driven reeler, said reeler comprising at least a reeling cylinder, characterized in that the centre-driven reeler is formed into a belt reeler by replacing its reeling cylinder with a first wire guiding roll and adding at least a second wire guiding roll, and an endless supporting member.

3. claims: 4, 5, 9, 10, 12, 13

A reeling apparatus comprising at least a belt reeler in which a reeling nip is formed by a reeling core or a growing machine reel and at least one endless supporting member arranged to travel at least via a first wire guiding roll and a second wire guiding roll, characterized in that the belt reeler comprises at least two stationary reeling station to form a machine reel.

4. claims: 6, 14-16

A reel change method to be used in a belt reeler in which a reeling nip is formed by a reeling core or a growing machine reel and at least one endless supporting member travelling at least via a first wire guiding roll and a second wire guiding roll, characterized in that the reeling core is provided with an adhesive element located in such an area in the reeling core which at least in the beginning of the reeling process remains outside the reeling nip, to which adhesive element a section of the paper web is guided when changing the reeling core.

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

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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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