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(54) **A process for producing security tapes**

(57) A process for producing security tapes wound in webs which comprise the following layers:

- a support film (1),
- a layer of adhesive material (2) or adhesive layer (2), positioned on the internal surface of the support film,
- a protective film (3) which is coated with an antiadhesive material on the side contacting the exposed surface of the adhesive layer, the protective film (3) being cut longitudinally from the web in two parts (3a) and (3b), optionally, between the support film (1) and the layer of adhesive material (2), one or more additional layers are inserted,

said process comprising the following passages:

- a1) optionally application on the internal surface of the support film (1) of one or more additional layers,
- b) application of the adhesive layer (2) on the internal surface of the last additional layer applied, when present, or on the internal surface of the support film (1),
- c) application of the protective film (3) to the adhesive layer (2),
- d) cutting longitudinally the protective film (3) to form two parts (3a) and (3b),
- e) winding the security tape in web.

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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)
X	US 3 859 157 A (MORGAN BURTON D) 7 January 1975 (1975-01-07) * column 3, line 38 - column 4, line 15; figure 9 *	1-18	INV. B31D1/02 G09F3/00
X	FR 2 238 982 A1 (AVERY PRODUCTS CORP [US]) 21 February 1975 (1975-02-21) * page 2, line 18 - page 2, line 29 *	1-18	
			TECHNICAL FIELDS SEARCHED (IPC)
			G09F B31D
The present search report has been drawn up for all claims			
Place of search Munich		Date of completion of the search 7 February 2012	Examiner Farizon, Pascal
<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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For more details about this annex : see Official Journal of the European Patent Office, No. 12/82