



(11) **EP 1 974 899 A3**

(12) **EUROPEAN PATENT APPLICATION**

(88) Date of publication A3:  
**20.10.2010 Bulletin 2010/42**

(51) Int Cl.:  
**B31D 1/02 (2006.01)** **B26D 7/18 (2006.01)**  
**G09F 3/02 (2006.01)**

(43) Date of publication A2:  
**01.10.2008 Bulletin 2008/40**

(21) Application number: **08251162.7**

(22) Date of filing: **28.03.2008**

(84) Designated Contracting States:  
**AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MT NL NO PL PT RO SE SI SK TR**  
Designated Extension States:  
**AL BA MK RS**

(72) Inventor: **Kendall, Ian George**  
**Reflex Labels Ltd., Vision House**  
**Mansfield, Nottinghamshire NG18 5BU (GB)**

(30) Priority: **31.03.2007 GB 0706360**

(74) Representative: **Skinner, Michael Paul**  
**Swindell & Pearson Limited**  
**48 Friar Gate**  
**Derby DE1 1GY (GB)**

(71) Applicant: **Reflex Labels Ltd**  
**Enterprise Way Sherburn-in -Elmet**  
**Leeds LS25 6NA (GB)**

(54) **Label manufacturing apparatus and method**

(57) Label manufacturing apparatus 55 forms rolls of label web at 82 from stock material 56, which consists of label material carried by a liner or backing paper. Labels are printed on the web at printing stations 58. The label material is kiss cut at a cutting station 60 to define the

outline of the labels. This defines waste label material around the labels. The waste material is stripped from the web by a suction arrangement 64 having a suction pump 68 and a mouth 66 into which the waste material is drawn.

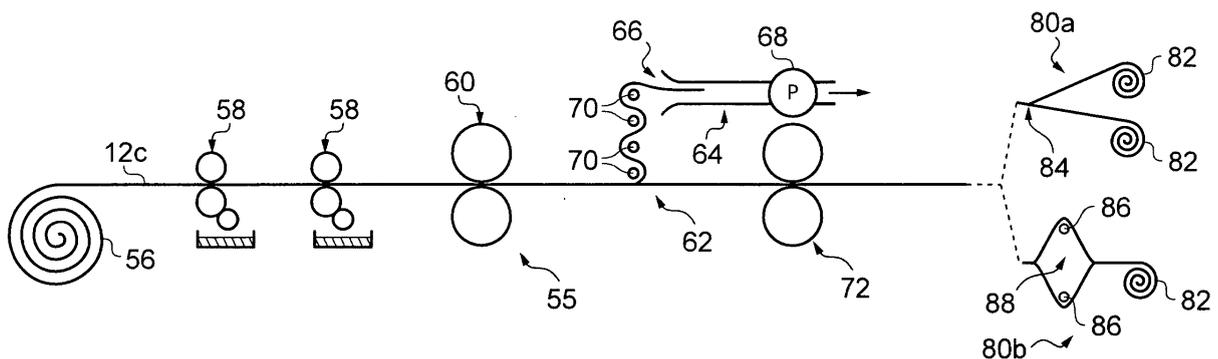


FIG. 4

EP 1 974 899 A3



EUROPEAN SEARCH REPORT

Application Number  
EP 08 25 1162

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	CN 1 781 698 A (ZHENGWEI PRINTING CO LTD SHANH [CN]) 7 June 2006 (2006-06-07) * abstract; figures 1-4 * -----	1-13	INV. B31D1/02 B26D7/18 G09F3/02
X	US 6 547 913 B1 (LIBBY TERRY L [US] ET AL) 15 April 2003 (2003-04-15) * the whole document * -----	1-13	
X	JP 2002 086597 A (LINTEC CORP) 26 March 2002 (2002-03-26) * the whole document * -----	1-13	
A	FR 2 763 017 A1 (FIANCETTE GERARD JEAN PIERRE [FR]) 13 November 1998 (1998-11-13) * abstract; figure 2 * -----	1,9	
<del>The present search report has been drawn up for all claims</del>			TECHNICAL FIELDS SEARCHED (IPC)
			G09F
Place of search		Date of completion of the search	Examiner
Munich		15 September 2010	Farizon, Pascal
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone		T : theory or principle underlying the invention	
Y : particularly relevant if combined with another document of the same category		E : earlier patent document, but published on, or after the filing date	
A : technological background		D : document cited in the application	
O : non-written disclosure		L : document cited for other reasons	
P : intermediate document		& : member of the same patent family, corresponding document	

2

EPO FORM 1503 03.82 (P04C01)



Application Number

EP 08 25 1162

**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:  
1-13
- 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).



**LACK OF UNITY OF INVENTION  
SHEET B**

Application Number  
EP 08 25 1162

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: 1-13

Waste station with suction arrangement

---

2. claims: 14-17

"lines" of label "interlocking" with neighbouring lines

---

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

EP 08 25 1162

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 The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

15-09-2010

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
CN 1781698	A	07-06-2006	NONE	
-----				
US 6547913	B1	15-04-2003	NONE	
-----				
JP 2002086597	A	26-03-2002	JP 4515612 B2	04-08-2010
-----				
FR 2763017	A1	13-11-1998	NONE	
-----				

EPO FORM P0459

For more details about this annex : see Official Journal of the European Patent Office, No. 12/82