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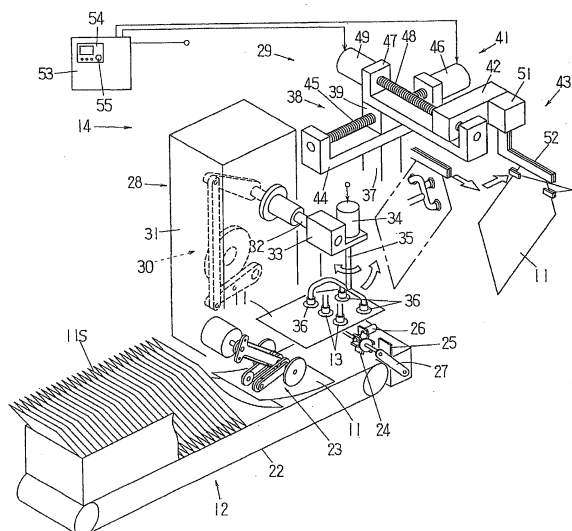
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(54) **Method and apparatus for manufacturing spout-equipped bags**

(57) Method and apparatus for manufacturing spout-equipped bags in which the lateral sides of a bag (11) are gripped by a pair of grippers (3, 3), the bag is conveyed along a conveying path, and a spout is attached to the bag mouth during the conveyance. Unloading suction members (13) adheres by suction to a bag in a horizontal orientation and takes out the bag (11); and then bag suction members (36) adheres to the bag (11) and changes the bag into a vertical orientation, the bag

is then rotated through a predetermined angle, making the bag mouth horizontal. A transfer chuck (52) grips the bag (11) and conveys it towards grippers (3, 3), and the bag is displaced a predetermined distance horizontally and supplied to the grippers. The horizontal displacement distance of the transfer chuck (52) is set in advance such that gripping margins on the bag (11) for the grippers (3, 3) are made substantially equal on the left and right of the bag (11).

FIG. 1





PARTIAL EUROPEAN SEARCH REPORT

Application Number

under Rule 62a and/or 63 of the European Patent Convention.
This report shall be considered, for the purposes of
subsequent proceedings, as the European search report

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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)
A,D	JP 3 261543 B2 (TOYO JIDOKI KK) 4 March 2002 (2002-03-04) * the whole document *	1-9,14	INV. B31B1/06 B31B1/12 B31B19/02 B31B19/84
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			TECHNICAL FIELDS SEARCHED (IPC)
			B31B B65H B65B B65G

INCOMPLETE SEARCH

The Search Division considers that the present application, or one or more of its claims, does/do
not comply with the EPC so that only a partial search (R.62a, 63) has been carried out.

Claims searched completely :

Claims searched incompletely :

Claims not searched :

Reason for the limitation of the search:

see sheet C

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Place of search	Date of completion of the search	Examiner
Munich	18 January 2016	Sundqvist, Stefan
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		

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**INCOMPLETE SEARCH
SHEET C**

Application Number

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Claim(s) completely searchable:
1-9, 14

Claim(s) not searched:
10-13, 15-18

Reason for the limitation of the search:

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The search has been restricted to the subject-matter indicated by the applicant in his letter of 18.12.2015 filed in reply to the invitation pursuant to Rule 62a(1) EPC.

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**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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18-01-2016

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