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(54) **METHOD FOR MANUFACTURING A SET OF EMBOSSING ROLLERS**  
**VERFAHREN ZUR HERSTELLUNG VON EINEM SATZ PRÄGEWALZEN**  
**PROCÉDÉ DE FABRICATION D'UN ENSEMBLE DE ROULEAU DE GAUFRAGE**

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## Description

**[0001]** The present invention relates to a method for manufacturing a set of embossing rollers for a device for embossing packaging materials that has two rollers, according to the preamble of claim 1, and to a set of embossing rollers manufactured according to the aforementioned method, as well as to the use of these embossing rollers in a device for embossing packaging materials.

**[0002]** Packaging foils for the tobacco industry or the food industry have been embossed by means of embossing roller devices for some time already, the foils being e.g. so-called inner liners that are wrapped around a number of cigarettes, or packaging materials for chocolate, butter, or similar foods, electronic components, jewelry, or watches.

**[0003]** Originally, the so-called inner liners consisted of pure aluminum foils like e.g. household foils, and embossing was achieved by passing them between two rollers of which at least one was provided with a relief, the so-called logos. Until about 1980, such a roller pair mostly consisted of a steel roller on which a relief was formed and of a counter-roller of a resilient material, e.g. rubber, paper, or acrylic glass. By impressing the relief of the male roller into the counter-roller = female roller, the mirror-inverted impression was produced.

**[0004]** For more sophisticated logos, the relief of the male roller was transferred to a layer on the female roller and the indentations corresponding to the raised portions were etched out or otherwise carved out. Recently, laser has also been used for this engraving process.

**[0005]** Since this manufacture of female rollers is demanding, after about 1980, when US 5 007 271 to the applicant of the present invention was filed, a so-called pin-up/pin-up system has increasingly been used where two identical steel rollers having a very large number of small teeth interlock and emboss the paper passing therethrough. Logos are produced by partly or entirely removing teeth on one roller.

**[0006]** Furthermore it was thus possible to produce the so-called satinizing where a matt and thus also more precious appearance of the surface is produced by the large number of small indentations created by the teeth.

**[0007]** EP 0 114 169 1 discloses an embossing device which is situated after a printing device and which has a male metal embossing roller and a female counter roller made of resilient material, whereby the depressions in the female roller are bigger than the elevations on the male roller. This device is not foreseen for embossing without previous printing. The method of manufacture of both rollers is not disclosed apart from the fact that a laser can be used for the manufacturing of the depressions.

**[0008]** US 5 269 983 A discloses also a pair of rollers with a metal male and a resilient female roller.

**[0009]** DE 10 2005 056627 A1 discloses a method and device for the production of blanks for an innerliners for a group of cigarettes, comprising a pair of embossing

rollers, having elevations on one roller and corresponding depressions on the other roller. There is no disclosure as concerns the method of manufacture of the pair of rollers.

**[0010]** DE 43 42 737 A1 discloses a method and device for the production of embossed innerliner blanks with a pair of rollers, wherein one roller is provided with an engraving on a part of its circumference, whereas the counter roller is provided with an engraving on its whole circumference. There is no hint at the method of manufacture of the embossing rollers.

**[0011]** EP 2 327 502 A1 of the same applicant discloses a method and device for structuring embossing rollers by a laser device.

**[0012]** EP 1 658 965 A1 discloses an embossing device comprising two pairs of embossing rollers, one pair for satinizing a foil and a second pair for embossing graphics. The second pair of rollers can comprise a male roller and a resilient female roller, or rollers in the so-called pin up - pin down configuration. There is no disclosure of a method of manufacture of such rollers.

**[0013]** In parallel to the developments in the embossing techniques, i.e. in the manufacture of the embossing rollers, a change has also taken place with regard to the packaging materials in that the originally used all-metal aluminum foil was replaced by paper foils whose surfaces were coated for environmental considerations with increasingly thinner metal layers, the latter having lately been applied by sputtering. In recent times, the metal layer on the inner liners has been further reduced and will eventually be omitted altogether in the future.

**[0014]** At the same time, attempts are being made to replace the classical packaging system, where the cigarettes are packaged in innerliners and this package is inserted into a paperboard packet, by so-called soft packs where only a wrapping foil is provided that simultaneously fulfills the functions of keeping the cigarettes moist and protecting them against exterior olfactory influences, on one hand, and of providing a certain stiffness for the mechanical protection of the cigarettes, on the other hand.

**[0015]** The developments in the manufacture of the embossing rollers, particularly those made known by the applicant of the present invention, see e.g. US 7 036 347, have led to an ever increasing scope of decorative effects on the innerliners and to a larger diversity of advertisements that has not only been utilized in the cigarette industry but also in the food industry. Lately, however, efforts are being made to strongly restrict or completely eliminate advertising for tobacco products so that it will no longer be possible to emboss the innerliners with promotionally effective designs to the former extent. Therefore, possibilities are being sought for producing new decorative effects without using eye-catching embossings, gold rims or decorations of the kind.

**[0016]** Also being considered are new possibilities for product identification, which has mainly been ensured in internationally established brand names so far. Today,

so-called tactile effects are being used which are created by special surface structures of the papers or by special engravings. Both textiles and papers are provided with expandable IR absorption optimized colors which create so-called pseudo-embossings. The purpose of this technique may be a perceptible relief formation e.g. for creating a velvety surface or a matte effect. In applications for food safe purposes, however, wetting techniques are questionable.

**[0017]** In the case of tactile surfaces, the consumer identifies the product by means of his or her tactile sense. Furthermore, this can lead to Braille writings or for producing hidden security features. Information produced in a tactile manner may e.g. be read out by means of laser radiation based on the surface-dependent reflectance. Furthermore, recent developments aim to produce audible effects that are produced by rubbing over the surface.

**[0018]** Another sector of the tobacco industry is concerned with the cigarette itself, e.g. with its mouthpiece, also called the tip.

**[0019]** As a result of the ever more restrictive legislation on tobacco products and of the strive for further features such as tactile, acoustic, or different optical features, on one hand, and of the continually increasing diversity of different packaging materials such as aluminum foils, metal coated papers, tipping papers, hybrid foils, plastic foils, paperboard, or cardstock, on the other hand, the conventional pin-up/pin-up embossing rollers where both the driven roller and the counter-rollers have a large number of teeth are still wholly and successfully utilizable for embossing inner liners but reach their limits with regard to the aforementioned purposes.

**[0020]** Although known roller systems comprising a male roller having male structures and a female roller having female structures that are inversely congruent thereto may extend the scope of decorative elements, their production is very cost-intensive and above all time-consuming due to the pairwise and matched manufacture so that their manufacture for the industrial embossing of e.g. metallized inner liners for the tobacco industry is not adequate.

**[0021]** Moreover, fine embossing can only be ensured with a very expensive manufacture of such rollers. In addition, when a male roller and an inversely congruent female roller are used in this context, the foil therebetween will be crushed to such an extent that tensions arise in the transversal direction that are unacceptable for tobacco product papers. Moreover a hardly controllable limit to perforation is reached and very high pressures are required for a high speed on-line process while the embossing times are in the millisecond range. Ultimately there is a tendency to use thicker papers.

**[0022]** One object of the invention that arises from the preceding is to provide a method for manufacturing a set of embossing rollers that allows fine embossing of the described, most diverse surface structures of the indicated materials of the most diverse kinds in an on-line process in a packing line. In this context, the term "fine em-

bossing" means that the contours of the fine embossing structures of the rollers exhibit an overall linear error of less than  $\pm 10 \mu\text{m}$  and an angular error of less than  $4^\circ$ . This object is achieved by the method according to claim 1.

**[0023]** Another object of the invention is to keep deformations of the embossed foils during the embossing of regularly arranged and uniform structures transversally to the running direction so small that the rollers can be used in an online process in a packing line.

**[0024]** Another object is to produce such a set of rollers on an industrial scale in the required precision and numbers. This object is achieved by the method according to claim 6.

**[0025]** Further objects and advantages, such as the manufacture of roller pairs for producing creasings, become apparent from the dependent claims and the following description.

**[0026]** The invention will be explained in more detail hereinafter with reference to drawings of exemplary embodiments.

Fig. 1 schematically shows a set of embossing rollers of the pin-up/pin-up type according to the prior art in an embossing device, both rollers having teeth that project from the cylinder,

Fig. 2 schematically shows a set of embossing rollers of the pin-up/pin-down type according to the prior art, the female roller = pin-down roller being designed inversely congruent to the male roller = pin-up roller.

Fig. 3 schematically shows a set of embossing rollers of the male-female roller type according to the invention,

Fig. 4 shows an embodiment variant of the set of embossing rollers of Fig. 3,

Fig. 5 shows a further embodiment variant of the set of embossing rollers of Fig. 3,

Fig. 6 shows three different enlarged views of a detail of the male roller of the embossing set of Fig. 5,

Fig. 7 shows an embodiment variant of the set of embossing rollers of Fig. 5,

Fig. 8 shows a further embodiment variant of the set of embossing rollers of Fig. 3,

- Fig. 9 shows a laser system for producing structures of male-female rollers according to the invention,
- Figures 10-16 show embodiment variants of structures on the embossing rollers according to Fig. 3,
- Figures 17-20B show schematic sectional views of embodiments of male and female structures that are not inversely congruent,
- Figures 21-35 show embodiment variants of roller pairs having zones for producing folding creases,
- Fig. 36 schematically shows a first exemplary embodiment of a quick-change device for the rollers according to the invention in a perspective view,
- Fig. 37 shows the assembled device of Fig. 21 in a sectional view,
- Fig. 38 schematically shows a second exemplary embodiment of a quick-change device for the rollers according to the invention in a perspective view,
- Fig. 39 schematically shows a third exemplary embodiment of a quick-change device for the rollers according to the invention in a perspective view, and
- Fig. 40 schematically shows a further exemplary embodiment of a quick-change device for the rollers according to the invention in a perspective view.

**[0027]** Fig. 1 shows an embossing device 1 according to the prior art with a set of two rollers 2 and 3 of the pin-up/pin-up type. In this configuration, the steel cylinders comprise projecting teeth 4 that are generally pyramidal and have an either square or rectangular base. In cigarette packing lines and other packing lines, such rollers by the applicant of the present invention have been used for over twenty years, the axle 5 of the driven roller 2 being fixedly supported whereas counter-roller 3 is driven and synchronized by the driven roller. In a known manner, such an embossing device may comprise more than two embossing rollers, e.g. one embossing roller and two counter-rollers.

**[0028]** In this case, axle 5 of counter-roller 3 is advantageously movable in all three dimensions such that one tooth of one roller may engage between four teeth of the other roller and a non-slipping self-synchronization is possible. In order to produce logos and authentication

features, teeth of the driven roller are either completely or only partly removed, thereby creating an image that changes according to the angle of light incidence and on the viewing angle of the observer. Furthermore it is known to create authentication features on top or on the sides of the teeth by means of microengravings or alternatively to remove or modify certain teeth in a predetermined arrangement.

**[0029]** For producing authentication features or decorations on inner liners, i.e. on metal coated paper, the pin-up/pin-up rollers are very well suitable and have been successfully used for decades. As mentioned in the introduction, both the higher requirements with regard to the embossing precision and the adaptations to an ever growing diversity of packaging materials such as synthetic foils, hybrid foils, paperboard, or cardstock, and the expected more restrictive regulations on advertising and the new embossing types related thereto reveal the limits of pin-up/pin-up embossing roller devices.

**[0030]** Besides the devices using pin-up/pin-up rollers, i.e. two or multiple male rollers, embossings have also been carried out with male-female rollers or, as illustrated in Fig. 2, with so-called pin-up/pin-down roller pairs.

**[0031]** Device 7 according to Fig. 2 comprises two rollers 2 and 8 where male roller 2 may be the same as in Fig. 1 while female roller 8 is a so-called pin-down roller and indentations 9 correspond to teeth 4 on roller 2 in an inversely congruent manner. As in Fig. 1, roller 2 is driven by drive 6 while roller 8 is driven by teeth 4. In order to ensure a smooth embossing operation, the teeth and indentations have to be machined and adjusted to each other very precisely.

**[0032]** First male roller 2 is manufactured and brought into contact with a female roller steel cylinder in such a manner that the teeth of the male roller are reproduced on the female cylinder, and a photo lacquer or wax layer or the like is generally applied to the female cylinder. Subsequently, the indentations 9 in the female cylinder that correspond to teeth 4 are carved out, generally by etching. It is also known, however, to carve out the indentations on the female roller mechanically or by means of a laser system.

**[0033]** Based on these two general types of embossing rollers it is known to form, on their hard surfaces, a very large number of signs, images, letters or the like, generally referred to as "logos", as well as security features or authentication features that are often invisible by the naked eye and are readable by suitable optical apparatus.

**[0034]** Due to the very complex technology required for the manufacture of a male-female roller pair according to the prior art, the application of the latter for industrial purposes is very limited. Generally, such systems are made to specification or used for special purposes. Moreover, a conventional male-female roller system having inversely congruent structures suffers from the serious disadvantage, among others, that particularly after the embossing of row structures the foil will exhibit a distortion in the transverse direction that makes its subsequent

processing in a packing line very difficult. In addition, the resulting transverse tensions may cause the foil to be perforated, thereby making it unsuitable for use in the food sector or in the tobacco industry.

**[0035]** Based on the foregoing description, a primary requirement for a substantial improvement of the embossing possibilities and quality and mainly also for an application in the online process is that the surface structures of the rollers, particularly of the female rollers, can be manufactured in a larger diversity as well as more rationally and in particular more precisely. Whereas the precision might be ensured according to the prior art by very expensive etching or mechanical machining procedures, this is not the case for the rational and thus also faster manufacture of the male-female rollers in a large diversity of surface structures.

**[0036]** Furthermore, another requirement consists in taking measures in order to reduce the transverse tensions in the embossed foil, which appear more frequently with inversely congruent structures, to such an extent that they do no longer impair the subsequent processing.

**[0037]** One solution consists in shaping the surface structures of the rollers of a set independently of each other rather than first shaping the male roller and then the female roller in a physically dependent relationship. Currently, this is preferably achievable with the required precision and within the required production time by means of a suitable laser system that allows manufacturing not only male rollers but also female rollers rationally, precisely, and above all in a large variety of shapes and independently of each other.

**[0038]** It has been recognized that the individual manufacture of male and female rollers allows to achieve a reduction of the transverse tensions due to the fact that the female structures are not inversely congruent, i.e. do not exactly correspond to the associated male structures. Due to the fact that the dimensions and shapes of the male structures, e.g. teeth, do not exactly correspond to those of the indentations in the female roller, not only the quality of the embossing is improved but also a sufficient reduction of the transverse tensions in the embossed foil is achieved.

**[0039]** Especially in the case of the embossing of two tipping webs on respective rollers, this may cause warping of the foil web that may have consequences particularly with regard to the cutting operation. According to WO-2011/098376 to the applicant of the present invention, which refers to pin-up/pin-up rollers exclusively, this problem may be solved in that the logo lines on the two tipping webs are arranged in mutually offset positions. The result is that no tensions are created when the tipping webs are being cut and that the tipping web portions can subsequently be glued around the cigarette mouthpiece without problems to form a tip where no seam is visible.

**[0040]** In the case of the male-female rollers according to the invention, this applies not only to the embossing of relatively narrow tipping webs but more generally to embossing structures arranged in rows.

**[0041]** Fig. 3 shows a schematized illustration of an embossing device 10 according to the invention comprising a male roller P11 and a female roller M11 as well as an enlarged illustration of their surface structures, where rhombic coarse structures GP1 and GM1 are depicted, see also Figures 10 to 16.

**[0042]** Since the coarse structures are not teeth, the driving force is transmitted from male roller P11 that is driven via belt drive 6 to female roller M11 by means of gearwheels 39 and 40.

**[0043]** In the embodiment variant of Fig. 4, the rollers P11E and M11E exhibit a coarse structure GPE and GME that consists of the capital letter "E".

**[0044]** In the embodiment variant of Fig. 5, the rollers P11W and M11W exhibit the same coarse structure GPE and GME that consists of the capital letter "E" as well as an emblem W. In Fig. 6, this emblem W on male roller P11W is shown in different views: in Fig. 6A in a top view, in Fig. 6B in a perspective view, and in Fig. 6C in a sectional view.

**[0045]** Fig. 7 shows an embodiment variant of the roller pair of Fig. 5 where the two rollers P11B and M11B are provided in addition to the "E" shapes and emblem W with positioning marks 27 and 28 allowing to synchronize the rollers and the embossed material by means of a camera.

**[0046]** Fig. 8 shows a pair of embossing rollers P11L and M11L having no structures except the emblem and which are also provided with marks 27 and 28.

**[0047]** In Fig. 9 an exemplary laser system is schematically illustrated which allows producing the coarse and fine structures shown in Figs. 10 - 16 that are suitable for a continuous fine engraving = macrostructuring process. The depicted laser device L12 comprises a laser 12 that is connected to a control circuit 13 that controls laser 12 and a deflection unit 14 which may comprise beam splitters as well as acousto-optical or electro-optical modulators or polygon mirrors. Deflection unit 14, focusing optics 15, and deflection mirror 16 form engraving unit 17 that is linearly displaceable in the X axis as symbolically indicated by the X arrow. Alternatively, the entire laser device L1 may be displaceable in the X axis.

**[0048]** Control circuit 13 is connected to a position detector 18 for detecting and evaluating the data of the rotating workpiece 22, in this case an embossing roller blank. The workpiece is driven by a drive 23, which is symbolized by rotation angle  $\varphi$ . By the combination of the linear displacement of the engraving unit and of the rotation of the roller a constant helical line SL is created that allows a uniform machining.

**[0049]** The application of a deflection unit that may e.g. comprise one or multiple beam splitter(s) as well as electro-optical or acousto-optical modulators or one or multiple polygon mirror(s) allows splitting the initial laser beam into two or multiple laser beams impinging on two or multiple tracks simultaneously but at such a mutual distance that they do not interfere. Moreover, the time interval between the impingement of the individual pulses

can be chosen large enough to avoid a thermal overload.

**[0050]** By the application of short pulse lasers whose laser pulses are comprised between 10 femtoseconds and 100 picoseconds, the energy is applied in a very short time period so that a so-called "cold ablation" becomes possible where the material is evaporated very quickly without unacceptable heating of the adjacent material. The undesirable liquid state of the material that produces crater edges and splashes can thus be almost completely avoided. The desired structures are generated on a computer that controls the laser system so that it is of no importance whether a surface structure for a male roller or for a female roller is produced. For the rollers, i.e. their surface, e.g. a suitable steel, hard metal, or ceramic material is used.

**[0051]** In Figs. 10 - 16, a few structures among the very large diversity of possible surface structures are illustrated. In each of these Figures, coarse structures GP1 and GM1 are the same as illustrated in Fig. 3 whereas the superposed fine structures vary. The depicted rhombi 21 of the coarse structures comprise male ridges 22P and female grooves 22M. Exemplary dimensions are a longitudinal diagonal of 4 to 6 mm, more particularly 4.6 mm, and a transverse diagonal of 1.5 mm to 3 mm, more particularly 2.0 mm, whereas the width of the ridges and grooves 22 is equal to approximately 0.2 mm. In the enlarged views, the female structure is shown on the left of the drawings and the male structure on the right and the structures are illuminated from the bottom left.

**[0052]** As appears particularly in the enlarged views, respective fine structures FP and FM are superimposed on coarse structures GP1 and GM1, the fine structures varying in their shapes. In Fig. 10, the fine structure FPQ consists of squares. The pitch of the squares, i.e. their recurrent spacing, amounts to about 0.04 mm. As will be apparent in Figs. 17 - 20, the male and female structures are not exactly inversely congruent but their shapes and dimensions differ from each other by a certain amount.

**[0053]** In Fig. 11, the fine structure FPD and FMD is diamond-shaped instead of square. The dimensions in Fig. 11 are slightly larger than in Fig. 10, i.e. the pitch of the fine structuring is 0.07 mm here while it is understood that it may be smaller, e.g. 0.05 mm, or larger.

**[0054]** In Fig. 12, the fine structure FPRh and FMRh is rhombic. Here also the dimensions are the same as previously.

**[0055]** In Fig. 13 the fine structure FPR and FMR is round. Here also the pitch of the fine structure may amount to 0.07 mm.

**[0056]** In Fig. 14 only coarse structure GP1 and GM1 is shown, without any fine structures. Such a structure is particularly suitable for producing tactile structures that are not only well perceptible but also have an esthetically pleasing appearance. In this manner, e.g. signs in Braille or acoustically utilizable structures may be produced.

**[0057]** In Fig. 15 it is illustrated that no fine structure is superposed on male coarse structure GP1 whereas a fine structure FM (Q,D,Rh,R) is superposed on female

coarse structure GM1 that is square, diamond-shaped, rhombic or round, as shown above, or may include an emblem as according to Figure 5 or another decoration of the kind.

**[0058]** In Fig. 16 it is illustrated that a fine structure FP (Q,D,Rh,R) is superposed on male coarse structure GP1 whereas female coarse structure GM1 has no fine structure.

**[0059]** It will be noted that the depicted embodiments only represent a small fraction of all possible shapes both of the coarse structures and of the fine structures. Based thereon, a very large number of different structures can be produced which may e.g. consist of few separate logos or logotypes or the like on which a fine structure may be superposed. In addition thereto, a microstructure may be superposed in a known manner in order to produce e.g. authentication features or other distinctive features that are generally invisible to the naked eye.

**[0060]** Figs. 17 - 20B schematically show some possibilities of how the female structure may differ from the male structure. For a better representation and visualization, the surface structures are shown as being tooth-shaped and enlarged so as to illustrate the deviations more clearly.

**[0061]** First, in order to be able to indicate the voluntary deviations, the errors, i.e. the manufacturing tolerances have to be specified. As previously mentioned, one goal of the improvements in the roller manufacture among others is to produce more precise and suitable structures for fine embossing, and thus the problem of achieving small manufacturing tolerances arises. These tolerances are also influenced *inter alia* by the surface quality of the rollers and it is therefore advantageous to use a hard surface. Thus, the rollers may be full hard metal rollers or metal rollers provided with a hard metal surface, or full ceramic rollers or metal rollers provided with a ceramic surface. All of these materials are particularly suitable for fine machining by means of a laser system. In most cases it is advantageous to provide the surface of the embossing rollers with a suitable protective layer.

**[0062]** For example, for the intended machining by means of a laser system, in the case of an embossing roller having a length of 150 mm and a diameter of 70 mm, errors of 2-4  $\mu\text{m}$  in the direction of rotation and of  $\pm 2 \mu\text{m}$  in the axial direction would be desirable and in height, for a tooth height of 0.1 mm, an error of 0.5 to 3  $\mu\text{m}$ . For two opposed tooth flanks forming an angle of e.g. 80°, an angular error of less than 3° is desirable. Thus, for new rollers, a maximum linear error of  $\pm 5 \mu\text{m}$  results, so that the manufacturing deviations may attain approx. 10  $\mu\text{m}$ .

**[0063]** Since these values are strongly influenced by the measurements and the manufacture, however, only a linear deviation of the male structures from the female structures of 15  $\mu\text{m}$  and more and an angular deviation of 4° and more can be qualified as a voluntary difference. The upper limit of the difference of the structures is set by the condition that the cooperation of the two rollers

may not be impaired.

**[0064]** The voluntary difference between the respective associated structures on the male roller and those on the female roller is strongly dependent upon the material being embossed. Thus, for example, the linear difference for embossing a foil having a thickness of about 30  $\mu\text{m}$  is around 40  $\mu\text{m}$  and for embossing cardstock having a thickness of about 300  $\mu\text{m}$  around 120  $\mu\text{m}$ .

**[0065]** In Figures 17 - 20B it is illustrated that it is advantageous for certain structures if the rollers are arranged at a certain constant distance from each other. For a pin-up/pin-up roller system, such a constant spacing in the form of a depression on one of the rollers, i.e. of a reduction in diameter at least on the width of the foil, by 0.02 to 0.2 mm is described in WO 2011/161002 A1 to the applicant of the present invention.

**[0066]** In the cases according to Figures 17 - 20B, the diameter of one of the rollers, advantageously of the male roller, is reduced at least on the width of the foil by an amount of over 0.02 mm relative to the remainder of the roller. In this manner a more uniform embossing can be produced. In Figures 17 - 20B this depression or reduced diameter of the male rollers is denoted by an 'S'.

**[0067]** Alternatively, instead of a depression, other spacing means may be provided, e.g. an electronic or mechanical spacing control.

**[0068]** According to Fig. 17, female roller M23 has a surface structure SM23 where two opposed flanks of the indentations form an angle  $\alpha_{23}$  and the male roller P23 has a structure SP23 where two opposed flanks of the teeth include and angle  $\beta_{23}$  and  $\beta_{23}$  is smaller than  $\alpha_{23}$ . These angles may have a value of 10° to 110° and a difference of more than 4°.

**[0069]** Female roller M24 in Fig. 18 has a female structure SM24 whose grooves N24 have a plane groove bottom. Male roller P24 has a surface structure SP24 whose teeth T24 are rounded.

**[0070]** Female roller M25 in Fig. 19 has the same surface structure SM24 as previously whereas the teeth T25 of male roller P25 have flattened tips.

**[0071]** Fig. 20 shows a further embodiment variant where female roller M26 has a surface structure SM26 with rounded grooves N26 while teeth T26 in the surface structure SP26 of male roller P26 are also rounded but have a smaller radius than grooves N26.

**[0072]** Fig. 20A shows a further embodiment variant where female roller M27 has a surface structure SM27 with a rounded groove N27 while key T27 in surface structure SP27 of male roller P27 is also rounded but has a smaller radius than groove N27.

**[0073]** Fig. 20B shows a further embodiment variant where female roller M28 has a surface structure SM28 with rounded grooves N28 while the teeth T28 in surface structure SP28 of male roller P28 are also rounded but have a smaller radius than grooves N28.

**[0074]** The embodiment variants according to Figures 21 to 35 have also been produced according to the principle that the female structures are not exactly inversely

congruent to the male structures. These variants refer to roller pairs including zones for creating creasings. The creasings may serve decorative purposes too. Such creasings are advantageous in cases where it is difficult to wrap the foil around objects such as tobacco products without interfering with the on-line packaging process.

**[0075]** In Figures 21 to 35, respective devices 80 having a roller pair 81P and 81M are illustrated where male roller 81P is driven by drive 6 and synchronized to the female roller by means of gearwheels 39, 40. All rollers in the depicted exemplary embodiments have a basic structure consisting e.g. of triangles TP or TM and a number of creasing zones 82, e.g. four, which may exhibit different structures having a decorative effect also.

**[0076]** Thus, the creasing zones of roller pair P81R1 and M81R1 of Fig. 21 have a grid structure R where the grids of the male roller are raised and those of the female roller are recessed. In order to serve as creasings, these structures are generally more raised and recessed, respectively, than the triangle structures. This applies to all depicted creasing structures.

**[0077]** Inversely, the creasing zones of roller pair P81R2 and M81R2 of Fig. 22 have recessed grid structures on the male roller and raised grid structures on the female roller.

**[0078]** The grid structures of the creasing zones of P81R3, M81R3 of Fig. 23 correspond to those of Fig. 21 with the difference that the creasing zones do not extend up to the edges of the rollers.

**[0079]** The creasing zones of roller pairs P81LR1-3 and M81LR1-3 of Figures 24 - 26 include radially arranged ridges W projecting either from the male roller or from the female roller, with corresponding indentations on the female or male roller. The creasing zones on roller pair P81LR3 and M81LR3 are shorter than the length of the rollers.

**[0080]** The creasing zones of roller pairs P81LL1-3 and M81LL1-3 of Figures 27 - 29 include longitudinally arranged ridges L projecting either from the male roller or from the female roller, with corresponding indentations on the female or male roller. The creasing zones on roller pair P81LL3 and M81LL3 are shorter than the length of the rollers.

**[0081]** The creasing zones of roller pairs P81Z1-3 and M81Z1-3 of Figures 30 - 32 include teeth Z projecting either from the male roller or from the female roller, with corresponding indentations on the female or male roller. The creasing zones on roller pair P81Z3 and M81Z3 are shorter than the length of the rollers.

**[0082]** The creasing zones of roller pairs P81K1-3 and M81K1-3 of Figures 33 - 35 include teeth K having a round cross-section and tapering conically toward their tips, and projecting either from the male roller or from the female roller, with corresponding indentations on the female or male roller. The creasing zones on roller pair P81K3 and M81K3 are shorter than the length of the rollers.

**[0083]** From the schematically illustrated Figures 17 -

20B it follows that due to the fact that the structures of the female rollers are not inversely congruent to the structures of the male rollers, i.e. that the dimensions and also the shapes of the structures of the male roller and the associated structures of the female roller are different from each other, a reduced crushing of the foil between the two rollers results, thereby strongly reducing or entirely eliminating any distortion of the embossed foil in the transverse direction in a number of embossing types.

**[0084]** This offers the significant advantage that in spite of the required high pressures between the rollers a perforation of the foil is avoided and its subsequent processing in a packing line is facilitated. Only thus it is possible to use such rollers analogously to the known and frequently used pin-up/pin-up rollers in an on-line process in a packing line. In the case of the embossing of tippings or of structures arranged in webs, it is advantageous to mutually offset the structural elements on the two webs.

**[0085]** The male-female rollers of the prior art were always manufactured in pairs, and due to the fact that the female rollers were shaped inversely congruent to the male rollers, each time one of the rollers had to be replaced, it was inevitable to replace the other roller too. With the method according to the invention, which allows an individual manufacture, it is possible to exchange either the male roller or the female roller separately, which is an important advantage not only on account of the differences in wear behavior but also with regard to the design possibilities.

**[0086]** Quick-change devices for the usual pin-up/pin-up rollers are known from US-6 665 998 to the applicant of the present invention and have been used in the majority of all cigarette paper embossing devices worldwide ever since. In these devices, the axle of the counter-roller is movable in all three coordinate directions in order to allow a self-synchronization of the embossing rollers.

**[0087]** The quick-change device 30 of Figures 36 and 37 comprises a housing 31 having two seats 32 and 33 intended to receive respective roller supports 34 and 35. Roller support 34 serves for mounting the male roller 36 that is driven by the non-represented drive 6, and roller support 35 serves for mounting the female roller 37. According to Fig. 20, roller support 34 is inserted into seat 32 and roller support 35 into seat 33. Housing 31 is closed by means of a closure plate 38.

**[0088]** In the present example, as in the examples according to Figures 3 - 8, the female roller is driven by the driven male roller 36 via gearwheels 39 and 40 located at one end of the rollers. In order to ensure the required high precision of the synchronization, the gearwheels are very fine. However, other synchronizing means, e.g. electric motors, may also be used.

**[0089]** In the sectional view of Fig. 37 it is visible that on the external drive side, on the left of the drawing, roller axle 41 of male roller 36 is rotatably supported in a needle bearing 42 in roller support 34 and on the other side in a ball bearing 43. The two ends 44 and 45 of the roller support are retained in corresponding openings 46 and

47 of the housing and of the closure plate, respectively. For a precise and unequivocal insertion and positioning of the roller support in the housing, the housing bottom has a T-shaped groove 48 to which a T-shaped key 49 on the bottom of the roller support corresponds.

**[0090]** On one side, on the left of the drawing, the roller axle 50 of female roller 37 is supported in a wall 51 of roller support 35, and on the other side in a second wall 52 of the roller support. The edges 53 of cover 54 of the roller support are shaped as keys that are insertable into the corresponding T-shaped groove 55 in housing 31, and one of the sidewalls 51 fits into a corresponding opening 56 in the housing wall.

**[0091]** The depicted versions where the second roller is driven via gearwheels require an adjustment of the rollers after mounting them in the roller support. This is e.g. achieved by means of the gearwheels.

**[0092]** In the embodiment variant of the quick-change device 59 of Figure 38, housing 60 does not have a closure plate but a wall 61 with a lower semicircular opening 62 and an upper approximately rectangular opening 63. The two rollers and the roller supports are the same as previously, and the T-shaped groove for receiving the female roller support and the T-shaped groove 48 in the housing bottom are also the same. The rear openings are similar to the forward openings 62 and 63 according to the drawing. In this embodiment also the roller supports are unequivocally and precisely fastened in the housing.

**[0093]** In the embodiment variant of Fig. 39, quick-change device 64 comprises two identical roller supports 65 and 66 having each a T-shaped key 49, one roller support 65 being guided and retained at the bottom and the other roller support 66 at the top of housing 67. The two roller supports are secured by means of a closure plate 68 having an opening 69 for receiving one roller end.

**[0094]** In the exemplary embodiment of Fig. 40, quick-change device 70 comprises a housing 71 having two opposed side walls 72, 73 in each of which two openings 74, 75 are arranged in order to receive the axles 76, 77 of the two embossing cylinders 36, 37 with gearwheels 39 and 40. In this strongly simplified schematic drawing it is visible that first the roller is inserted into the housing and then the axle is introduced and fastened. Furthermore it follows from this example that a quick exchange is also possible without roller supports.

## Claims

1. Method for manufacturing a set of embossing rollers for a device for embossing packaging materials that has two rollers, wherein

the embossing roller set comprises

a male roller having a male surface structure including structural elements and/or logo structures and



- a female roller having a female surface structure that is associated to the surface structure of the male roller for the common embossing operation with the male roller,
- and is designed in view of using the embossing rollers for fine embossing in the on-line process, whereby the associated female surface structure is produced independently of a previously produced or physically pre-existing male surface structure, wherein contours of the male surface structures and the female surface structures are manufactured for a fine embossing process with an overall linear error of less than  $\pm 10 \mu\text{m}$  and an angular error of less than  $4^\circ$ , the dimensions of the structural elements of the male roller, on one hand, and the dimensions of the associated structural elements of the female roller, on the other hand, deviate from one another by a determined amount without however impairing their cooperation, and any voluntary deviations of linear dimensions of the structural elements of the rollers from each other are of  $15 \mu\text{m}$  or greater than  $15 \mu\text{m}$  and/or the angles of the edges of the structural elements deviate by  $4^\circ$  or more than  $4^\circ$  from each other.
2. Method according to claim 1, **characterized in that** the surface structures of the embossing rollers are shaped such that the embossed packaging material is provided with a tactually perceptible embossing pattern.
  3. Method according to claim 2, **characterized in that** the tactually perceptible embossing pattern includes special signs such as Braille or acoustically utilizable signs.
  4. Method according to anyone of claims 1 to 3, **characterized in that** in order to reduce the transverse tensions in the embossed packaging material, the logo structures of the embossing rollers are arranged and designed such that during the passage of a foil web between the embossing rollers, at least two sections can be embossed on the foil web in such a manner that the logo structures embossed on one section are offset relative to the respective logo structures on the other section in the running direction.
  5. Method according to anyone of claims 1 to 4, **characterized in that** raised positioning marks (27) are produced on the male roller and associated recessed positioning marks (28) on the female roller, or vice-versa.
  6. Method according to anyone of claims 1 to 5, **characterized in that** the male surface structures and the female surface structures of the embossing rollers are produced by means of a femto- or picosecond laser system.
  7. Method according to claim 6, **characterized in that** on the surface of the rollers a coarse structure and a superposed fine structure are produced.
  8. Method according to claim 6, **characterized in that** on the surfaces of the roller pairs, zones for creating creasings are produced, raised creasing structures being produced on one roller and associated recessed creasing structures on the other roller, the creasing structures being more raised or recessed, respectively, than the other structures.
  9. Method according to any one of claims 1 to 8, **characterized in that** one of the embossing rollers is manufactured at least on the width of the packaging material web with a diameter that is reduced relative to the remainder of the embossing roller by an amount S, the value of S being greater than 0.02 mm.
  10. Method according to anyone of claims 1 to 9, **characterized in that** the packaging material is suitable for packaging foods and pharmaceuticals, or is tipping paper, cigarette paper, innerliner or innerframe paper, hybrid paper, a synthetic foil, or paperboard or cardstock for packaging tobacco products.
  11. Embossing roller set comprising
    - a male roller (P11, P11B, P11E, P11L, P11W, P23-28, 36, P81-RI-3; LR1-3; LLI-3; KI-3) and a female roller (M11, M11B, M11E, M11L, M11W, M23-28, 37; M81-R1-3; LR1-3; LL1-3; KI-3),
    - characterized in that** both are manufactured according to the method of any one of claims 1 to 10, the structural elements (GP1, GPB, GPE, GPL, GPW, FP-Q,D,Rh,R) on the male roller and the associated structural elements (GM1, GMB, GME, GML, GMW, FM-Q,D,Rh,R) on the female roller are not inversely congruent and deviate by a defined amount equal to or of more than  $15 \mu\text{m}$  linearly and equal to or of more than  $4^\circ$  angularly, and contours of the male surface structures and the female surface structures exhibit an overall linear error of less than  $\pm 10 \mu\text{m}$  and an angular error of less than  $4^\circ$ .
  12. Embossing roller set according to claim 11, **charac-**

**terized in that** at least the surface of the rollers consists of metal, hard metal, or ceramics, and the surface is possibly provided with a protective layer.

13. Embossing roller set according to claim 11 or 12, **characterized in that** one of the embossing rollers is connected to the other embossing roller by synchronizing means, preferably gearwheels (39, 40). 5
14. Embossing roller set according to one of claims 11-13, **characterized in that** the two embossing rollers (P81-R1-3; LR1-3; LL1-3; K1-3), (M81-R1-3; LR1-3; LL1-3; K1-3) include mutually corresponding zones (82) having raised resp. recessed structures (R, W, L, Z, K) for the creation of creasing zones, these structures being more raised or recessed, respectively, than the other structures. 10
15. Use of an embossing roller set according to claims 11 to 14 in an embossing device, **characterized in that** the embossing device is integrated on-line in a packing line either directly or via a robot. 15
16. Use according to claim 15, **characterized in that** the rollers are arranged at a determined mutual distance of preferably more than 0.02 mm. 20
17. Use according to claim 15 or 16, **characterized in that** the embossing roller set is arranged in a quick-change device (30, 59, 64, 70) that is designed such that the embossing rollers (36, 37) are exchangeable individually and independently of each other. 25
18. Use according to claim 17, **characterized in that** the embossing rollers (36, 37) are rotatably retained in respective roller supports (34, 35; 65, 66) and the roller supports are fastened in unequivocal positions in a quick-change housing and are individually and independently removable, one end of the male roller support (34) being supported in a needle bearing (42) and its other end in a ball bearing (43). 30
19. Use according to claim 17 or 18, **characterized in that** the lower part of one of the roller supports (34, 65) has a key (49) and the bottom of the housing (31, 60, 67) a corresponding groove (48). 35
20. Use according to claim 19, **characterized in that** the upper part of the other roller support (66) has a key (49) and in the upper part of the housing (67) is arranged a groove (48), or the edges (53) of its upper side form a T-shaped key and the upper side of the housing (60) has a T-groove. 40
21. Use according to claim 18, **characterized in that** the quick-change device (70) comprises a housing (71) with two opposed walls (72, 73) each having two openings (74, 75) with fastening means for re- 45

ceiving and fastening the axles (76, 77) of the rollers (36, 37).

## 5 Patentansprüche

1. Verfahren zum Herstellen von einem Satz Prägewalzen für eine Vorrichtung zum Prägen von Verpackungsmaterialien, die zwei Walzen aufweist, wobei der Satz Prägewalzen Folgendes umfasst 10

eine Positivwalze mit einer positiven Oberflächenstruktur, die strukturelle Elemente und/oder Logostrukturen umfasst, und eine Negativwalze mit einer negativen Oberflächenstruktur, die der Oberflächenstruktur der Positivwalze für die gemeinsame Prägeoperation mit der Positivwalze zugeordnet ist, und im Hinblick auf eine Verwendung der Prägewalzen zum Feinprägen in dem Online-Prozess entworfen ist, 15

wonach die dazugehörige negative Oberflächenstruktur unabhängig von einer zuvor hergestellten oder physikalisch schon vorhandenen positiven Oberflächenstruktur hergestellt ist, wobei 20

Konturen der positiven Oberflächenstrukturen und der negativen Oberflächenstrukturen für einen Feinprägeprozess mit einem Gesamtlineargehalt von weniger als  $\pm 10 \mu\text{m}$  und einem Winkelfehler von weniger als  $4^\circ$  hergestellt werden, 25

die Abmessungen der strukturellen Elemente der Positivwalze auf der einen Seite und die Abmessungen der dazugehörigen strukturellen Elemente der Negativwalze auf der anderen Seite durch einen bestimmten Betrag voneinander abweichen, ohne jedoch ihr Zusammenwirken zu beeinträchtigen, und 30

alle willkürlichen Abweichungen der Linearabmessungen der strukturellen Elemente der Walzen voneinander  $15 \mu\text{m}$  oder größer als  $15 \mu\text{m}$  sind und/oder die Winkel der Kanten der strukturellen Elemente um  $4^\circ$  oder um mehr als  $4^\circ$  voneinander abweichen. 35

2. Verfahren nach Anspruch 1, **dadurch gekennzeichnet, dass** die Oberflächenstrukturen der Prägewalzen derartig geformt sind, dass das geprägte Verpackungsmaterial mit einem taktil wahrnehmbaren Prägemuster versehen wird. 40

3. Verfahren nach Anspruch 2, **dadurch gekennzeichnet, dass** das taktil wahrnehmbare Prägemuster spezielle Zeichen, wie beispielsweise Braille oder akustisch nutzbare Zeichen, umfasst. 45

4. Verfahren nach einem der Ansprüche 1 bis 3, **dadurch gekennzeichnet, dass** um die Querspannungen in dem geprägten Verpackungsmaterial zu reduzieren, die Logostrukturen der Prägewalzen derartig angeordnet und ausgelegt sind, dass während des Durchgangs eines Foliengewebes zwischen den Prägewalzen mindestens zwei Abschnitte auf dem Foliengewebe auf eine derartige Weise geprägt werden können, dass die Logostrukturen, die auf einem Abschnitt geprägt werden, in Bezug auf die jeweiligen Logostrukturen auf dem anderen Abschnitt in der Laufrichtung versetzt sind.
5. Verfahren nach einem der Ansprüche 1 bis 4, **dadurch gekennzeichnet, dass** erhabene Positioniermarkierungen (27) auf der Positivwalze und dazugehörige vertiefte Positioniermarkierungen (28) auf der Negativwalze hergestellt werden, oder vice-versa.
6. Verfahren nach einem der Ansprüche 1 bis 5, **dadurch gekennzeichnet, dass** die positiven Oberflächenstrukturen und die negativen Oberflächenstrukturen der Prägewalzen mittels einem Femto- oder Picosekunden-Lasersystem hergestellt werden.
7. Verfahren nach Anspruch 6, **dadurch gekennzeichnet, dass** auf der Oberfläche der Walzen eine grobe Struktur und eine überlagerte feine Struktur hergestellt werden.
8. Verfahren nach Anspruch 6, **dadurch gekennzeichnet, dass** auf den Oberflächen der Walzenpaare Zonen zum Erzeugen von Faltungen hergestellt werden, wobei erhabene Faltungsstrukturen auf einer Walze und dazugehörige vertiefte Faltungsstrukturen auf der anderen Walze hergestellt werden, wobei die Faltungsstrukturen erhabener bzw. vertiefter sind als die anderen Strukturen.
9. Verfahren nach einem der Ansprüche 1 bis 8, **dadurch gekennzeichnet, dass** eine der Prägewalzen mindestens auf die Breite des Verpackungsmaterialgewebes mit einem Durchmesser hergestellt wird, der in Bezug auf den Rest der Prägewalze um einen Betrag S reduziert ist, wobei der Wert von S größer ist als 0,02 mm.
10. Verfahren nach einem der Ansprüche 1 bis 9, **dadurch gekennzeichnet, dass** das Verpackungsmaterial zum Verpacken von Lebensmitteln und Arzneimitteln geeignet ist, oder Zigarettenmundstückpapier, Zigarettenpapier, Innerliner- oder Innenrahmenpapier, Hybridpapier, eine synthetische Folie oder Pappe oder Karton zum Verpacken von Tabakprodukten ist.
11. Satz Prägewalzen, Folgendes umfassend
  - eine Positivwalze (P11, P11B, P11E, P11L, P11W, P23-28, 36, P81-R1-3; LR1-3; LL1-3; K1-3) und
  - eine Negativwalze (M11, M11B, M11E, M11L, M11W, M23-28, 37; M81-R1-3; LR1-3; LL1-3; K1-3),
  - dadurch gekennzeichnet, dass** beide gemäß dem Verfahren nach einem der Ansprüche 1 bis 10 hergestellt sind, die strukturellen Elemente (GP1, GPB, GPE, GPL, GPW, FP-Q, D, Rh, R) auf der Positivwalze und die dazugehörigen strukturellen Elemente (GM1, GMB, GME, GML, GMW, FM-Q, D, Rh, R) auf der Negativwalze nicht invers kongruent sind und um einen definierten Betrag größer oder gleich 15 µm linear und größer oder gleich 4° im Winkel abweichen und Konturen der positiven Oberflächenstrukturen und der negativen Oberflächenstrukturen einen Gesamtlinafehler von weniger als +/-10 µm und einem Winkelfehler von weniger als 4° zeigen.
12. Satz Prägewalzen nach Anspruch 11, **dadurch gekennzeichnet, dass** mindestens die Oberfläche der Walzen aus Metall, Hartmetall oder Keramiken besteht und die Oberfläche möglicherweise mit einer Schutzschicht versehen ist.
13. Satz Prägewalzen nach Anspruch 11 oder 12, **dadurch gekennzeichnet, dass** eine der Prägewalzen durch Synchronisierungsmittel, vorzugsweise Zahnräder (39, 40), mit der anderen Prägewalze verbunden ist.
14. Satz Prägewalzen nach einem der Ansprüche 11 bis 13, **dadurch gekennzeichnet, dass** die beiden Prägewalzen (P81-R1-3; LR1-3; LL1-3; K1-3), (M81-R1-3; LR1-3; LL1-3; K1-3) gegenseitig entsprechende Zonen (82) umfassen, die erhabene bzw. vertiefte Strukturen (R, W, L, Z, K) für die Erzeugung von Faltungszonen umfassen, wobei diese Strukturen erhabener bzw. vertiefter sind, als die anderen Strukturen.
15. Verwenden eines Satzes Prägewalzen nach den Ansprüchen 11 bis 14 in einer Prägevorrichtung, **dadurch gekennzeichnet, dass** die Prägevorrichtung online in einem Verpackungsfließband, entweder unmittelbar oder über einen Roboter, integriert ist.
16. Verwendung nach Anspruch 15, **dadurch gekennzeichnet, dass** die Walzen in einer bestimmten gegenseitigen Entfernung von vorzugsweise mehr als 0,02 mm angeordnet sind.
17. Verwendung nach Anspruch 15 oder 16, **dadurch**

**gekennzeichnet, dass** der Satz Prägewalzen in einer Schnellwechsellvorrichtung (30, 59, 64, 70) angeordnet ist, die derartig entworfen ist, dass die Prägewalzen (36, 37) einzeln und unabhängig voneinander austauschbar sind.

18. Verwendung nach Anspruch 17, **dadurch gekennzeichnet, dass** die Prägewalzen (36, 37) drehbar in jeweiligen Walzenträgern (34, 35; 65, 66) gehalten werden und die Walzenträger in eindeutigen Positionen in einem Schnellwechselgehäuse befestigt sind und einzeln und unabhängig abnehmbar sind, wobei ein Ende des Positivwalzenträgers (34) in einem Nadellager (42) getragen wird und sein anderes Ende in einem Kugellager (43) getragen wird.

19. Verwendung nach Anspruch 17 oder 18, **dadurch gekennzeichnet, dass** der untere Teil eines der Walzenträger (34, 65) eine Verdübelung (49) und der Boden des Gehäuses (31, 60, 67) eine entsprechende Auskehlung (48) aufweist.

20. Verwendung nach Anspruch 19, **dadurch gekennzeichnet, dass** der obere Teil des anderen Walzenträgers (66) eine Verdübelung (49) aufweist und in dem oberen Teil des Gehäuses (67) eine Auskehlung (48) angeordnet ist oder die Kanten (53) seiner oberen Seite eine T-förmige Verdübelung ausbilden und die obere Seite des Gehäuses (60) eine T-förmige Auskehlung aufweist.

21. Verwendung nach Anspruch 18, **dadurch gekennzeichnet, dass** die Schnellwechsellvorrichtung (70) ein Gehäuse (71) mit zwei gegenüberliegenden Wänden (72, 73) umfasst, die jeweils zwei Öffnungen (74, 75) mit Montagemitteln zum Aufnehmen und Befestigen der Achsen (76, 77) der Walzen (36, 37) aufweisen.

## Revendications

1. Procédé de fabrication d'un jeu de cylindres de gaufrage pour un dispositif destiné à gaufrer des matériaux d'emballage qui comporte deux cylindres, dans lequel

le jeu de cylindres de gaufrage comprend un cylindre mâle ayant une structure de surface mâle comportant des éléments de structure et/ou des structures de logo et un cylindre femelle ayant une structure de surface femelle qui est associée à la structure de surface du cylindre mâle pour l'opération commune de gaufrage avec le cylindre mâle, et est conçu en vue d'utiliser les cylindres de gaufrage pour un gaufrage fin dans le procédé en ligne,

dans lequel

la structure de surface femelle associée est produite indépendamment d'une structure de surface mâle produite antérieurement ou physiquement préexistante, dans lequel

les contours des structures de surface mâles et des structures de surface femelles sont fabriqués pour un procédé de gaufrage fin avec une erreur linéaire globale de moins de  $\pm 10 \mu\text{m}$  et une erreur angulaire de moins de  $4^\circ$ , les dimensions des éléments de structure du cylindre mâle d'une part, et les dimensions des éléments de structure associés du cylindre femelle d'autre part diffèrent les uns des autres d'une quantité déterminée sans nuire cependant à leur coopération, et toutes les différences volontaires de dimensions linéaires entre les éléments de structure des cylindres sont de  $15 \mu\text{m}$  ou plus de  $15 \mu\text{m}$  et/ou les angles des bords des éléments de structure diffèrent de  $4^\circ$  ou plus de  $4^\circ$  l'un de l'autre.

2. Procédé selon la revendication 1, **caractérisé en ce que** les structures de surface des cylindres de gaufrage sont façonnées de telle sorte que le matériau d'emballage gaufré est pourvu d'un motif de gaufrage perceptible au toucher.

3. Procédé selon la revendication 2, **caractérisé en ce que** le motif de gaufrage perceptible au toucher comporte des signes particuliers tels que des signes en Braille ou utilisables acoustiquement.

4. Procédé selon l'une quelconque des revendications 1 à 3, **caractérisé en ce que**, afin de réduire les tensions transversales dans le matériau d'emballage gaufré, les structures de logo des cylindres de gaufrage sont agencées et conçues de telle sorte que, pendant le passage d'une bande de feuille entre les cylindres de gaufrage, au moins deux sections peuvent être gaufrées sur la bande de feuille de manière à ce que les structures de logo gaufrées sur une section soient décalées par rapport aux structures de logo respectives sur l'autre section dans la direction d'avance.

5. Procédé selon l'une quelconque des revendications 1 à 4, **caractérisé en ce que** des repères de positionnement surélevés (27) sont produits sur le cylindre mâle et des repères de positionnement en retrait associés (28) sur le cylindre femelle, ou vice versa.

6. Procédé selon l'une quelconque des revendications 1 à 5, **caractérisé en ce que** les structures de surface mâles et les structures de surface femelles des cylindres de gaufrage sont produites au moyen d'un système laser femto- ou picoseconde.

7. Procédé selon la revendication 6, **caractérisé en ce qu'**une structure grossière et une structure fine superposées sont produites sur la surface des cylindres.
8. Procédé selon la revendication 6, **caractérisé en ce que** des zones destinées à créer des plis sont produites sur les surfaces des paires de cylindres, des structures de pli surélevées étant produites sur un cylindre et des structures de pli en retrait associées sur l'autre cylindre, les structures de pli étant plus surélevées ou en retrait, respectivement, que les autres structures.
9. Procédé selon l'une quelconque des revendications 1 à 8, **caractérisé en ce qu'**un des cylindres de gaufrage est fabriqué au moins sur la largeur de la bande de matériau d'emballage avec un diamètre qui est réduit par rapport au reste du cylindre de gaufrage d'une quantité S, la valeur de S étant supérieure à 0,02 mm.
10. Procédé selon l'une quelconque des revendications 1 à 9, **caractérisé en ce que** le matériau d'emballage est approprié pour emballer des aliments et des médicaments, ou est du papier manchette, du papier à cigarettes, une doublure intérieure ou du papier de renfort, du papier hybride, une feuille synthétique, ou du carton ou papier cartonné destiné à emballer des produits du tabac.
11. Jeu de cylindres de gaufrage comprenant
- un cylindre mâle (P11, P11B, P11E, P11L, P11W, P23-28, 36 ; P81-R1-3 ; LR1-3 ; LLI-3 ; K1-3) et
  - un cylindre femelle (M11, M11B, M11E, M11L, M11W, M23-28, 37 ; M81-R1-3 ; LR1-3 ; LL1-3 ; K1-3),
- caractérisé en ce que** tous deux sont fabriqués selon le procédé de l'une quelconque des revendications 1 à 10, les éléments de structure (GP1, GPB, GPE, GPL, GPW, FP-Q, D, Rh, R) sur le cylindre mâle et les éléments de structure associés (GM1, GMB, GME, GML, GMW, FM-Q, D, Rh, R) sur le cylindre femelle ne sont pas inversement congruents et s'écartent d'une quantité définie égale ou supérieure à 15  $\mu\text{m}$  linéairement et égale ou supérieure à 4° angulairement, et les contours des structures de surface mâles et des structures de surface femelles présentent une erreur linéaire globale de moins de  $\pm 10 \mu\text{m}$  et une erreur angulaire de moins de 4°.
12. Jeu de cylindres de gaufrage selon la revendication 11, **caractérisé en ce qu'**au moins la surface des cylindres consiste en du métal, du métal dur ou de la céramique, et la surface est éventuellement pourvue d'une couche protectrice.
13. Jeu de cylindres de gaufrage selon la revendication 11 ou 12, **caractérisé en ce qu'**un des cylindres de gaufrage est relié à l'autre cylindre de gaufrage par des moyens de synchronisation, de préférence des roues dentées (39, 40).
14. Jeu de cylindres de gaufrage selon une des revendications 11 à 13, **caractérisé en ce que** les deux cylindres de gaufrage (P81-R1-3 ; LR1-3 ; LL1-3 ; K1-3), (M81-R1-3 ; LR1-3 ; LL1-3 ; K1-3) comportent des zones mutuellement correspondantes (82) ayant des structures surélevées, respectivement en retrait (R, W, L, Z, K) pour la création de zones de pli, ces structures étant plus surélevées ou en retrait, respectivement, que les autres structures.
15. Utilisation d'un jeu de cylindres de gaufrage selon les revendications 11 à 14 dans un dispositif de gaufrage, **caractérisée en ce que** le dispositif de gaufrage est intégré en ligne dans une ligne d'emballage, directement ou par l'intermédiaire d'un robot.
16. Utilisation selon la revendication 15, **caractérisée en ce que** les cylindres sont disposés à une distance mutuelle déterminée de préférence supérieure à 0,02 mm.
17. Utilisation selon la revendication 15 ou 16, **caractérisée en ce que** le jeu de cylindres de gaufrage est disposé dans un dispositif de changement rapide (30, 59, 64, 70) qui est conçu de telle sorte que les cylindres de gaufrage (36, 37) peuvent être changés individuellement et indépendamment l'un de l'autre.
18. Utilisation selon la revendication 17, **caractérisée en ce que** les cylindres de gaufrage (36, 37) sont retenus en rotation dans des supports de cylindre respectifs (34, 35 ; 65, 66) et les supports de cylindre sont fixés à des positions sans équivoque dans un boîtier de changement rapide et peuvent être retirés individuellement et indépendamment, une extrémité du support de cylindre mâle (34) étant supportée dans un roulement à aiguilles (42) et son autre extrémité dans un roulement à billes (43) .
19. Utilisation selon la revendication 17 ou 18, **caractérisée en ce que** la partie inférieure d'un des supports de cylindre (34, 65) a une clavette (49) et le bas du boîtier (31, 60, 67) a une rainure correspondante (48) .
20. Utilisation selon la revendication 19, **caractérisée en ce que** la partie supérieure de l'autre support de cylindre (66) a une clavette (49) et une rainure (48) est disposée dans la partie supérieure du boîtier (67), ou les bords (53) de son côté supérieur forment

une clavette en forme de T et le côté supérieur du boîtier (60) a une rainure en T.

21. Utilisation selon la revendication 18, **caractérisée en ce que** le dispositif de changement rapide (70) comprend un boîtier (71) avec deux parois opposées (72, 73) ayant chacune deux ouvertures (74, 75) avec des moyens de fixation destinés à recevoir et fixer les axes (76, 77) des cylindres (36, 37).

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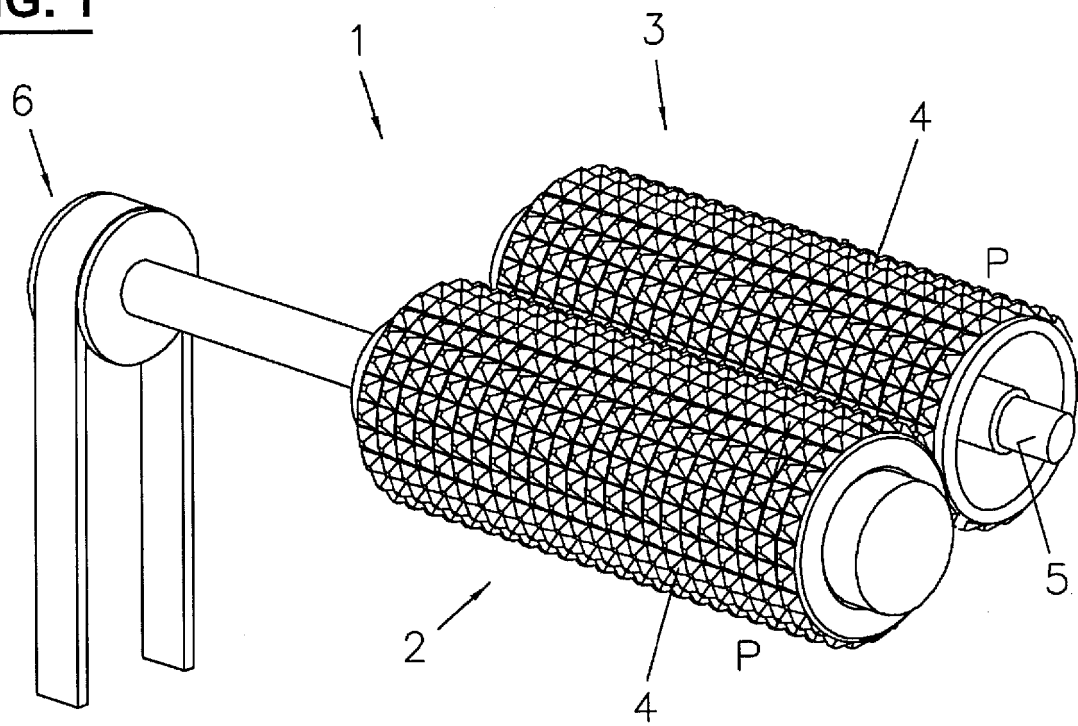
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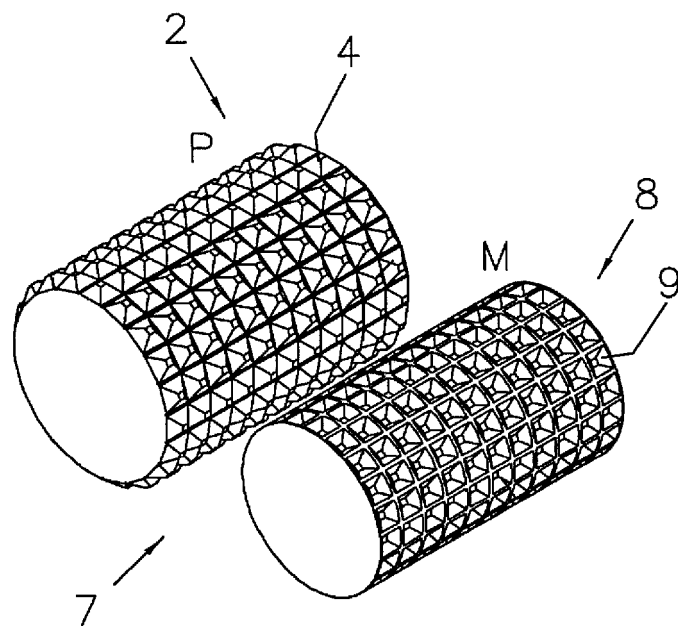
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**FIG. 1**



**FIG. 2**



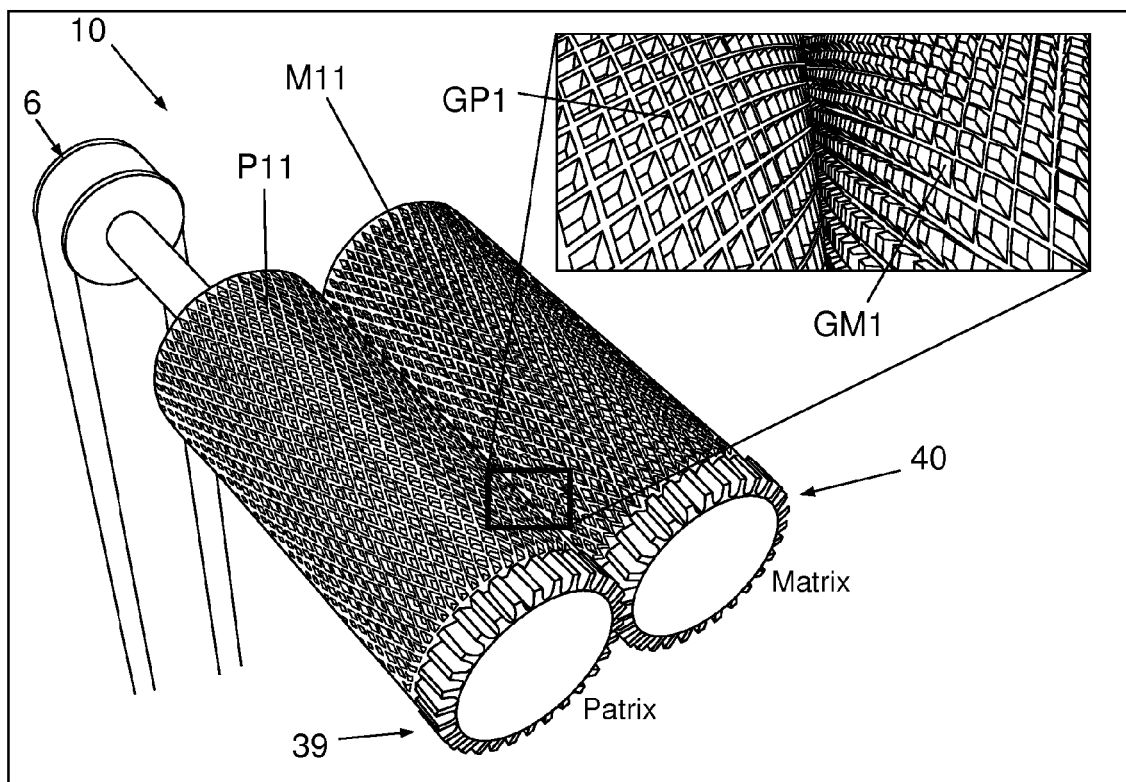


FIG. 3

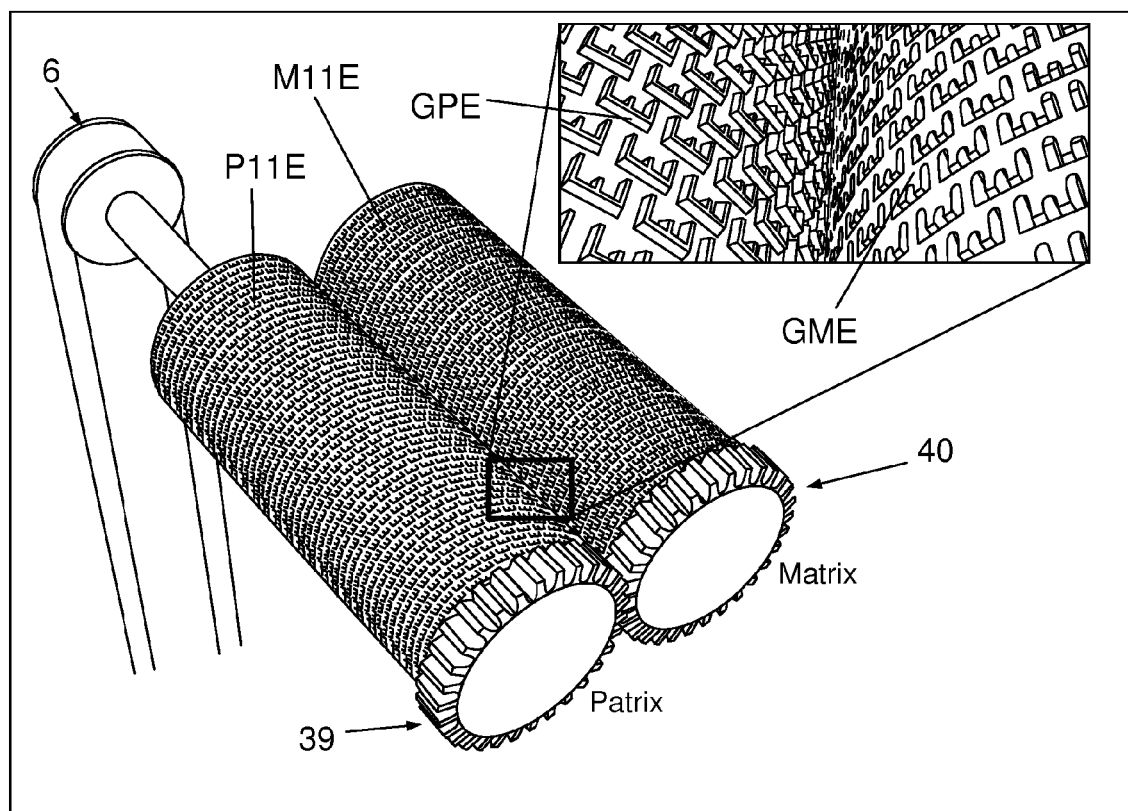


FIG. 4



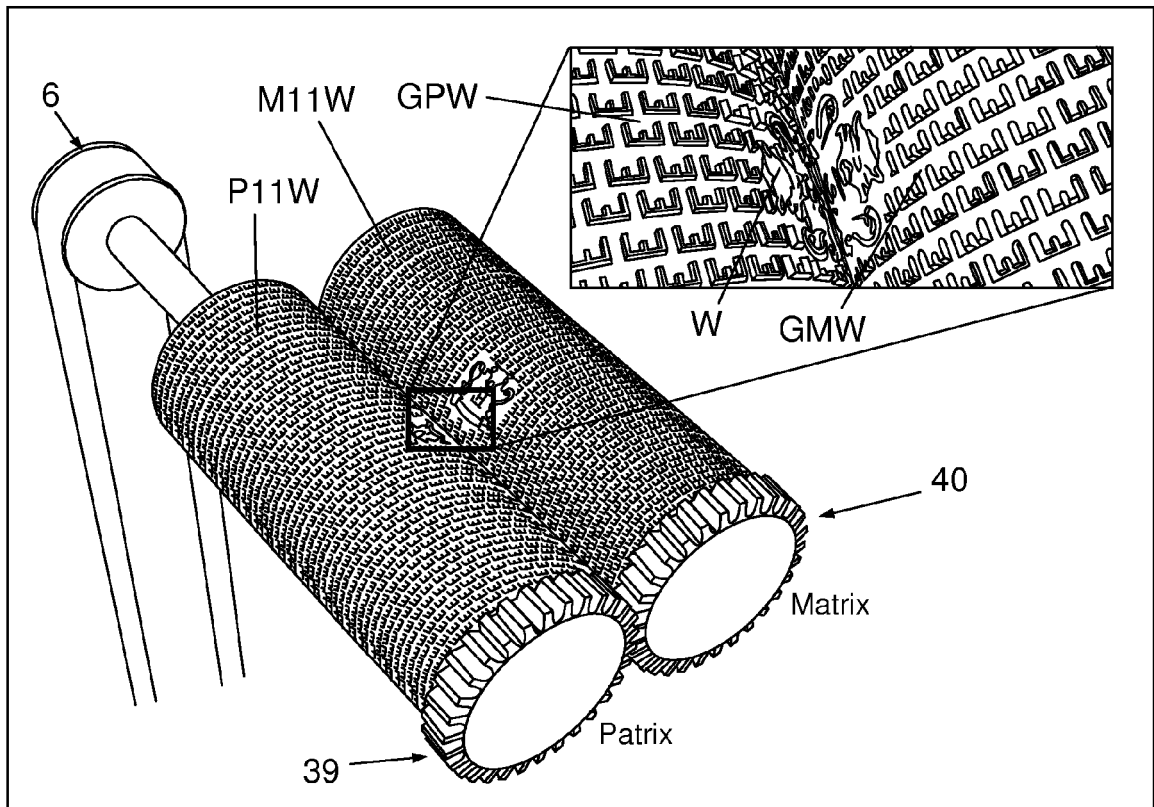


FIG. 5

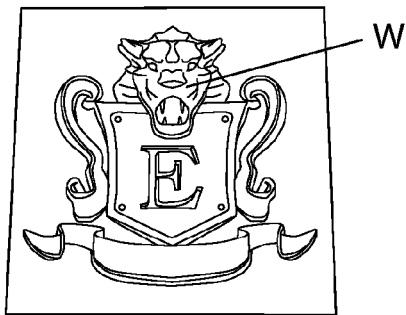


FIG. 6A

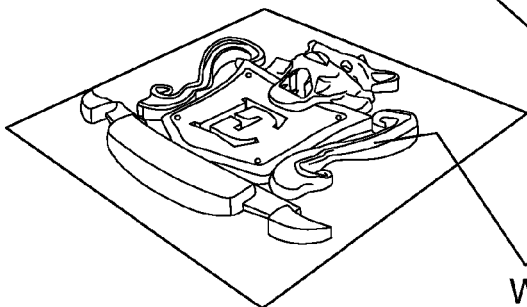


FIG. 6B

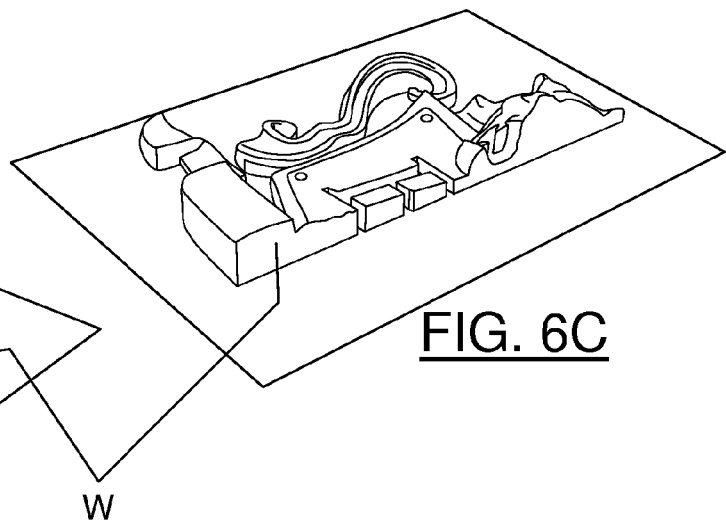


FIG. 6C

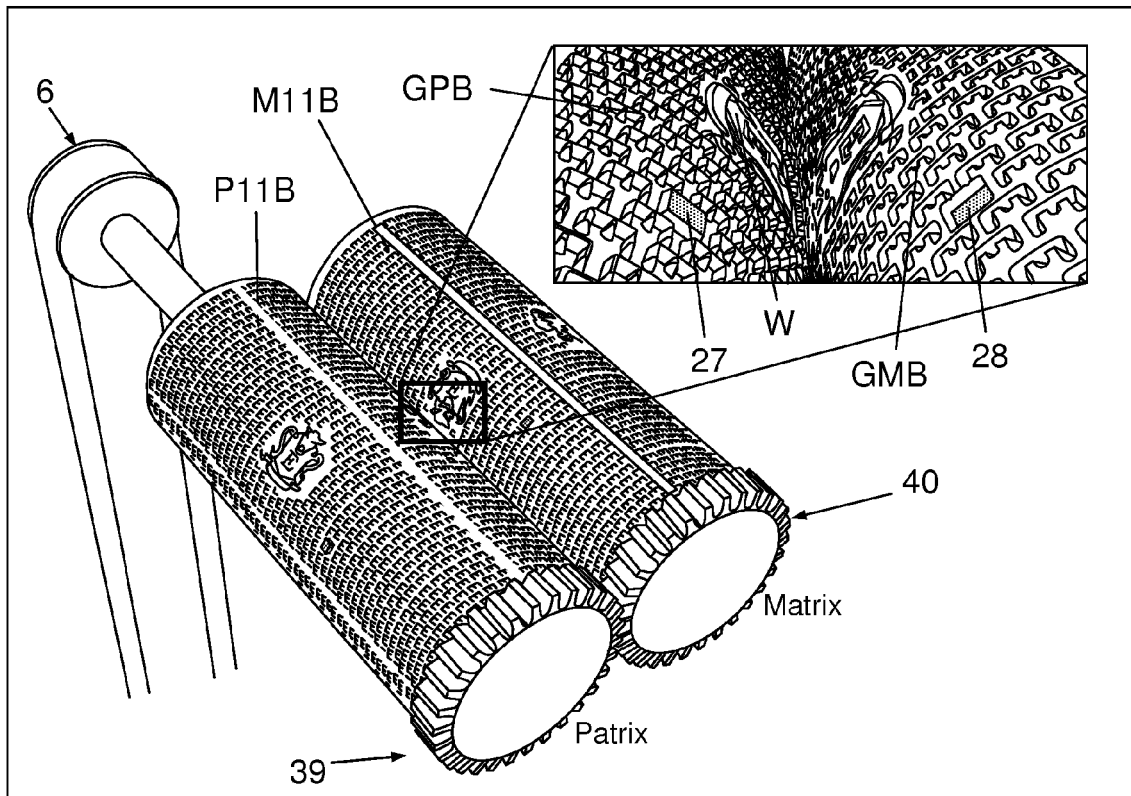


FIG. 7

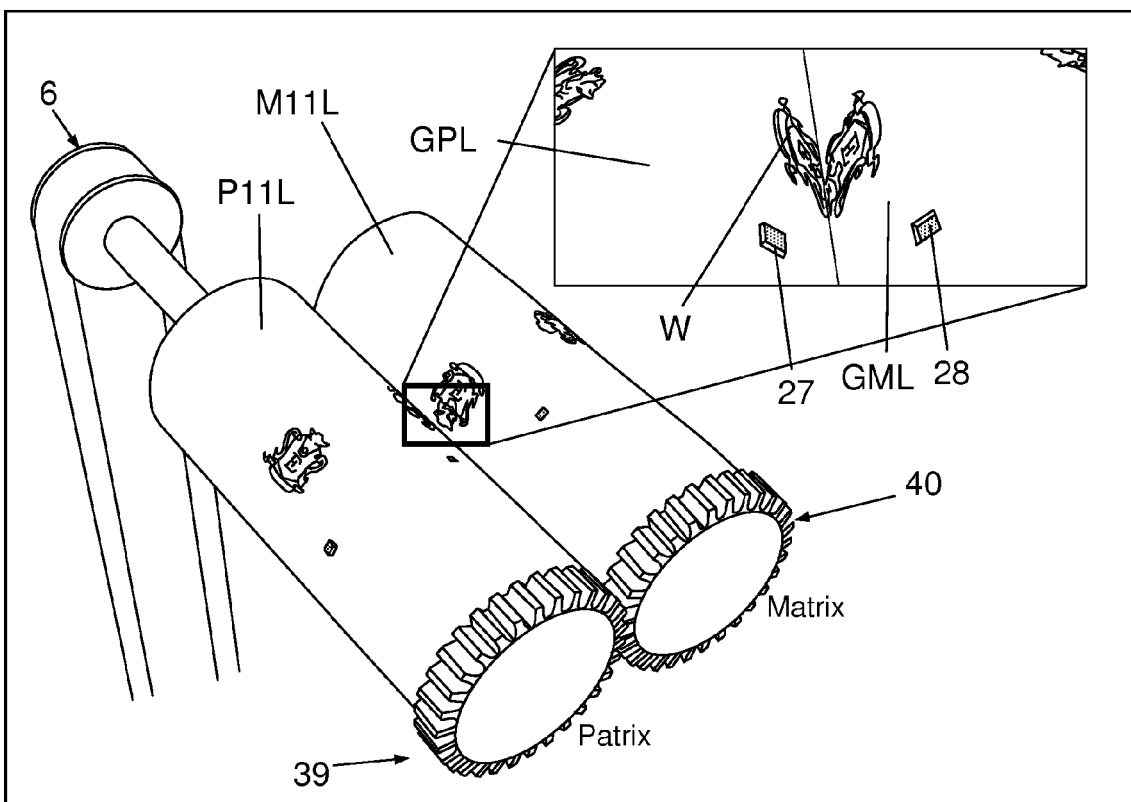
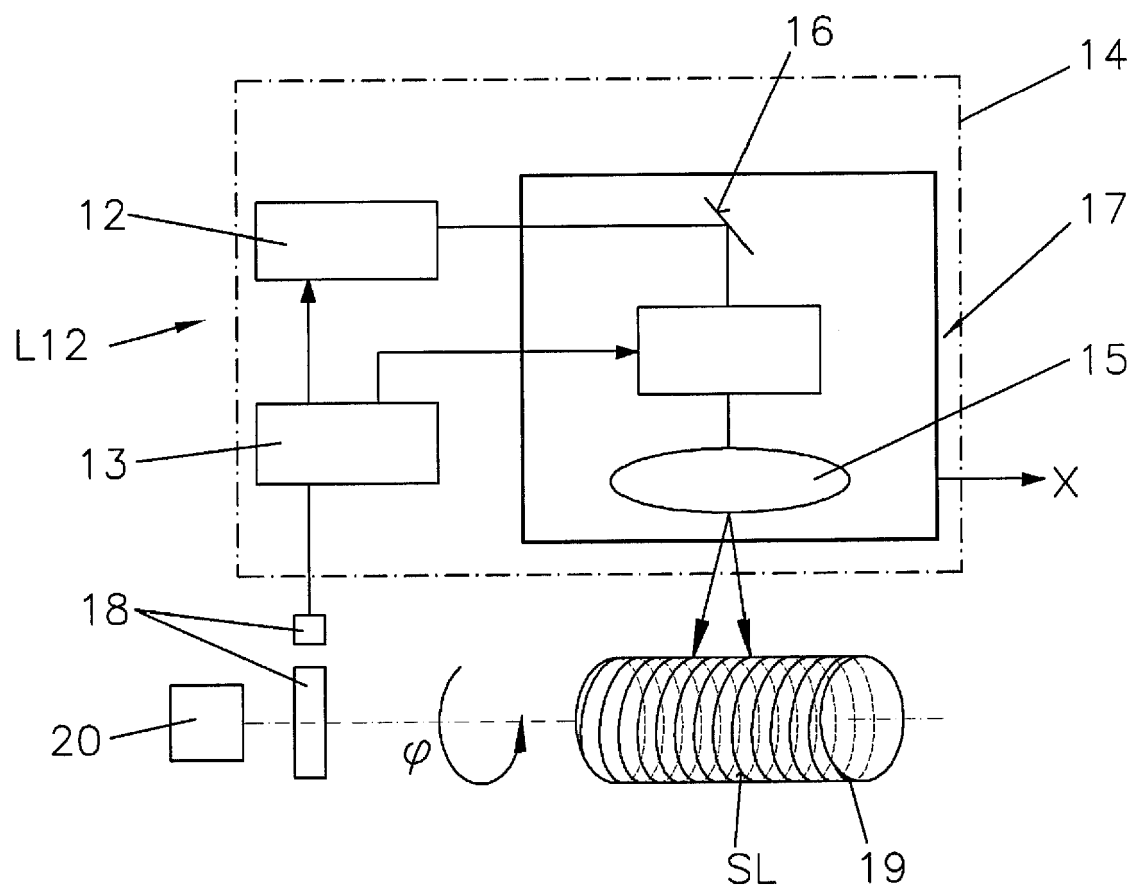
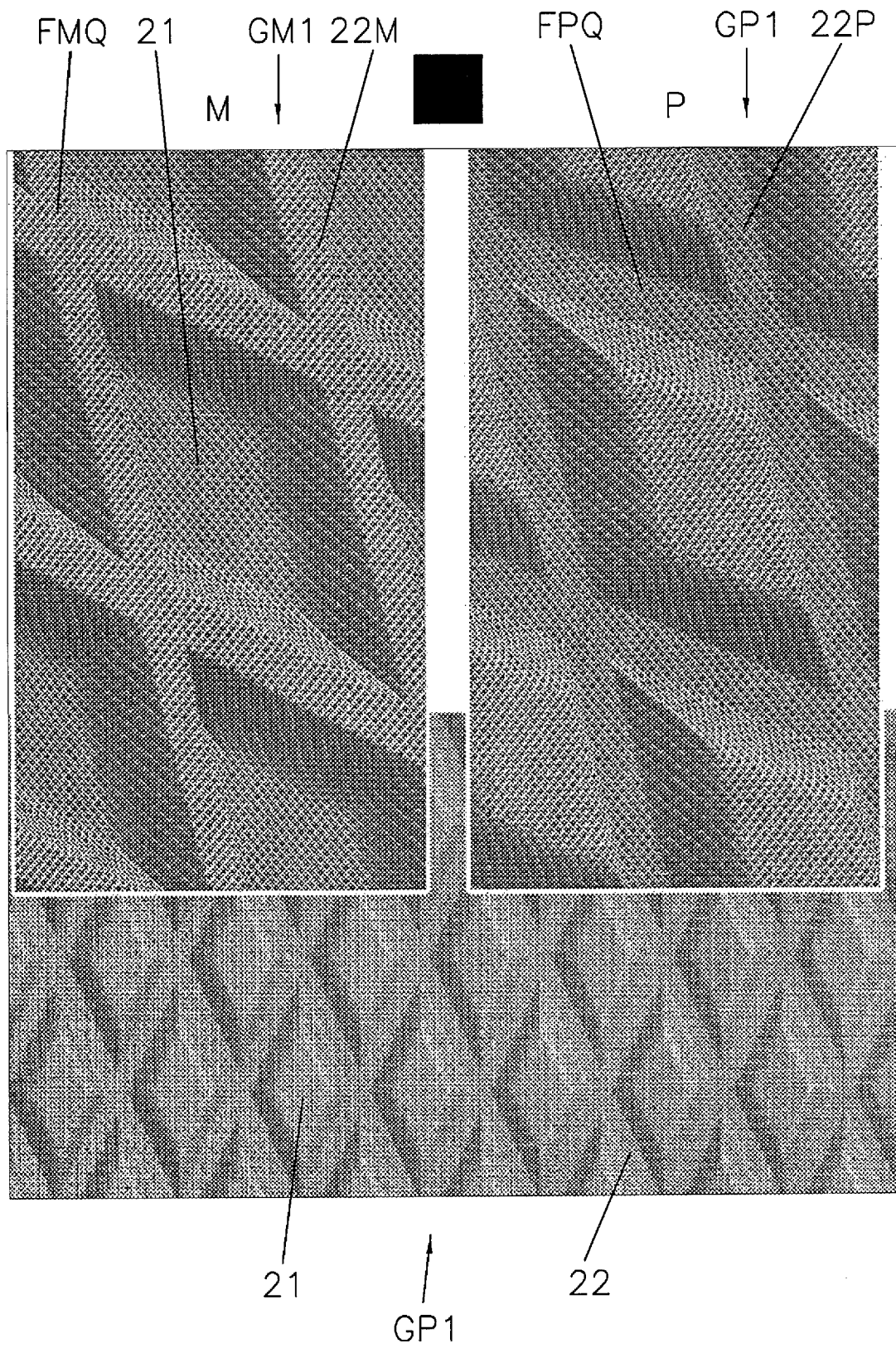


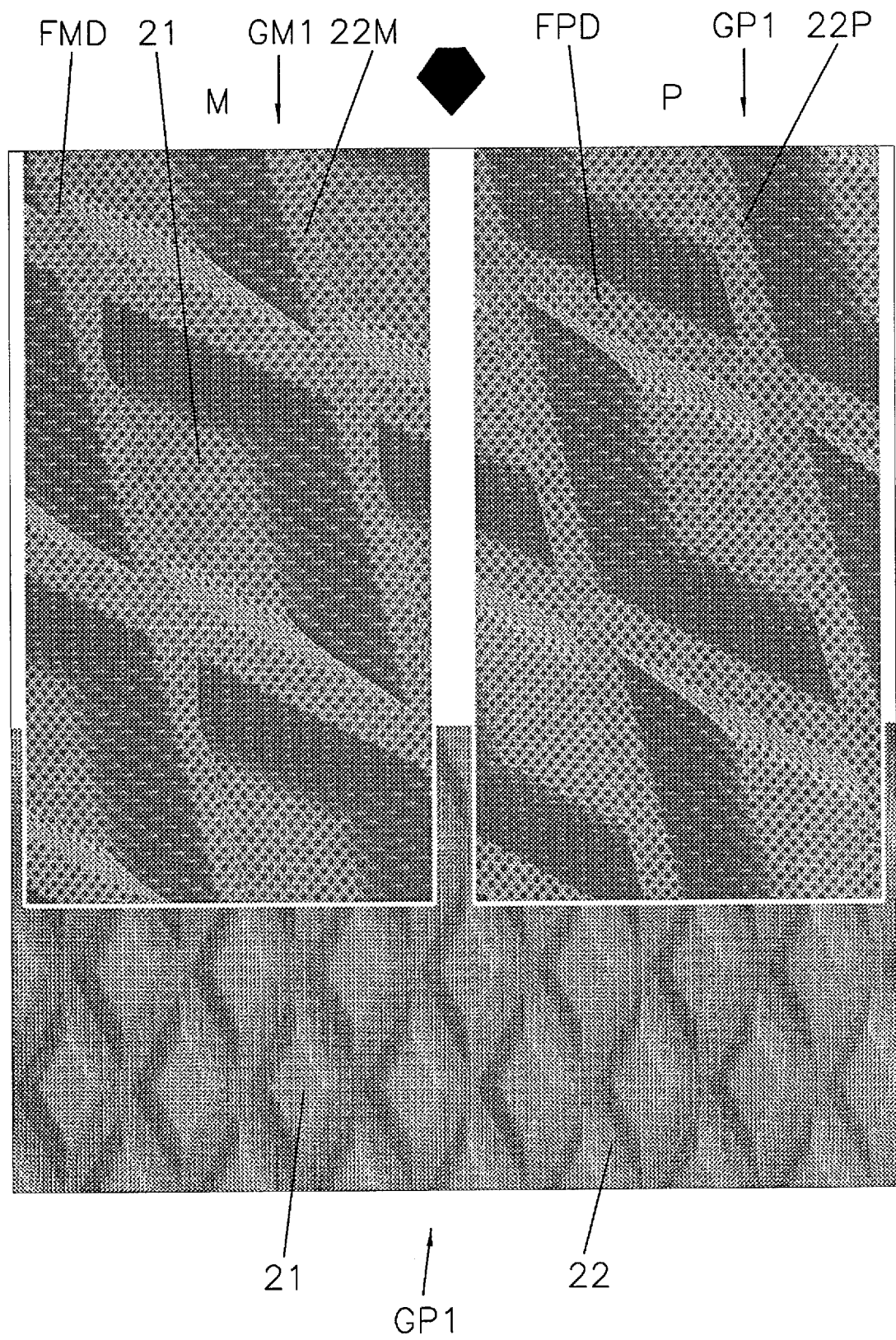
FIG. 8

**FIG. 9**

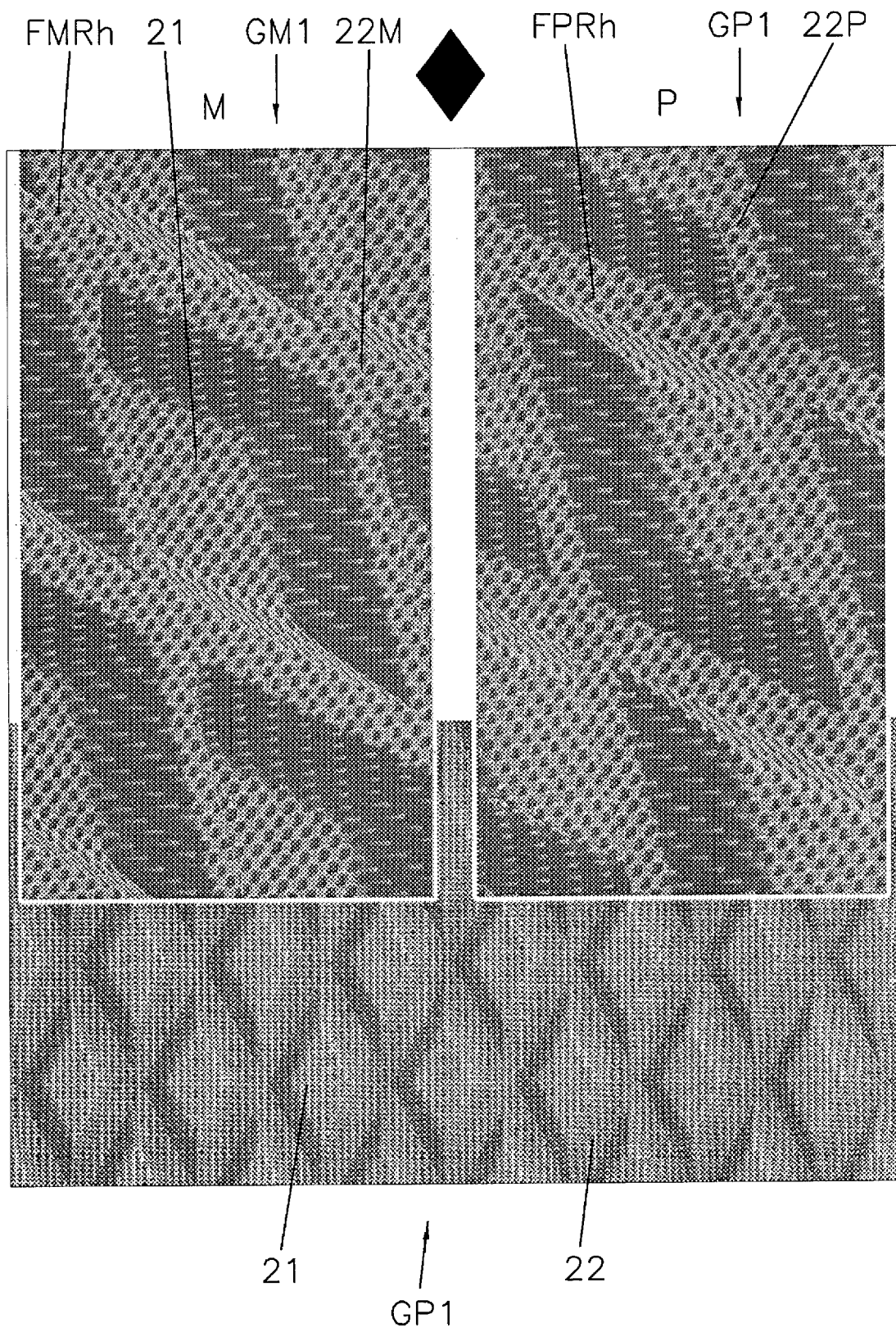
**FIG. 10**



**FIG. 11**

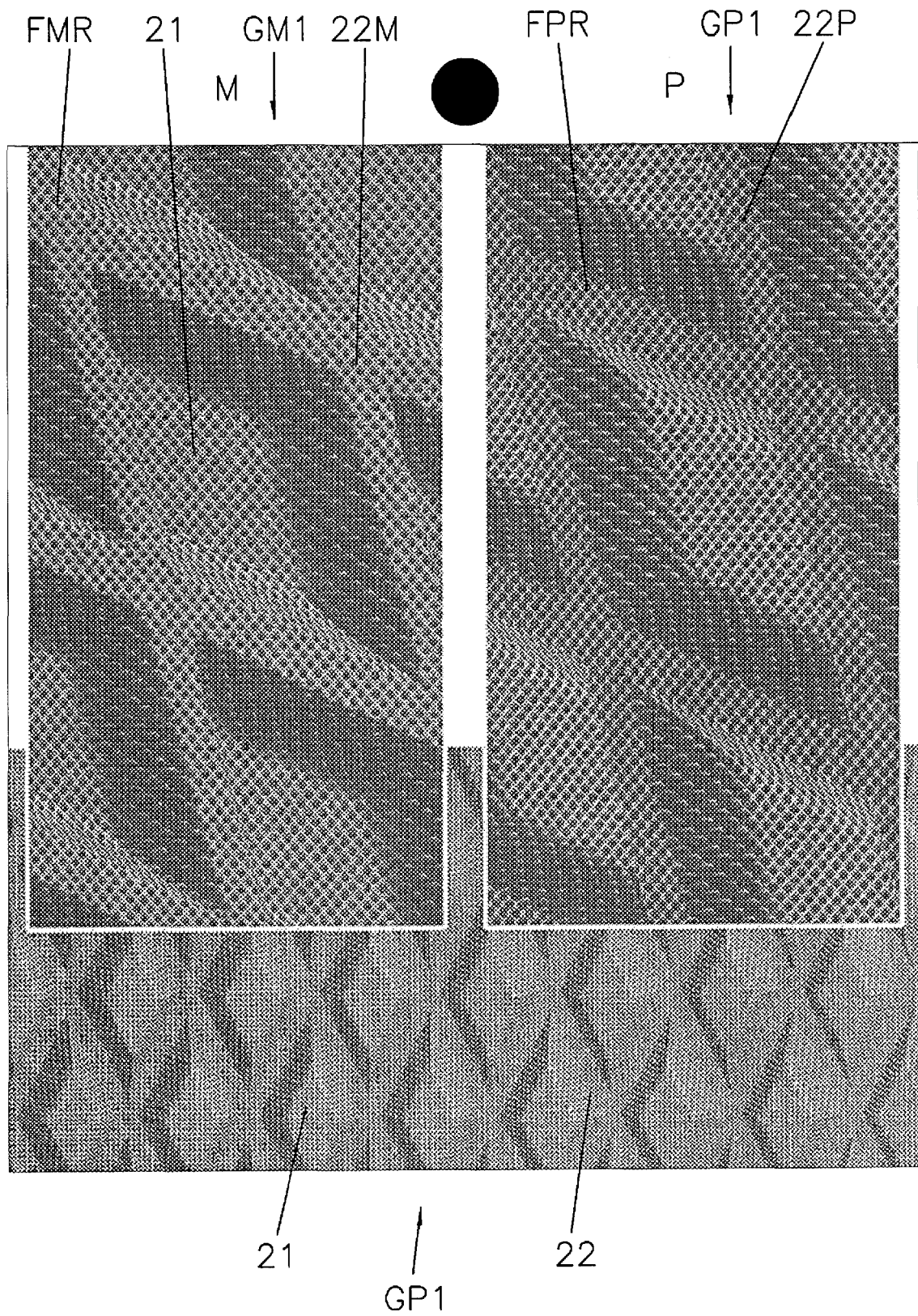


**FIG. 12**

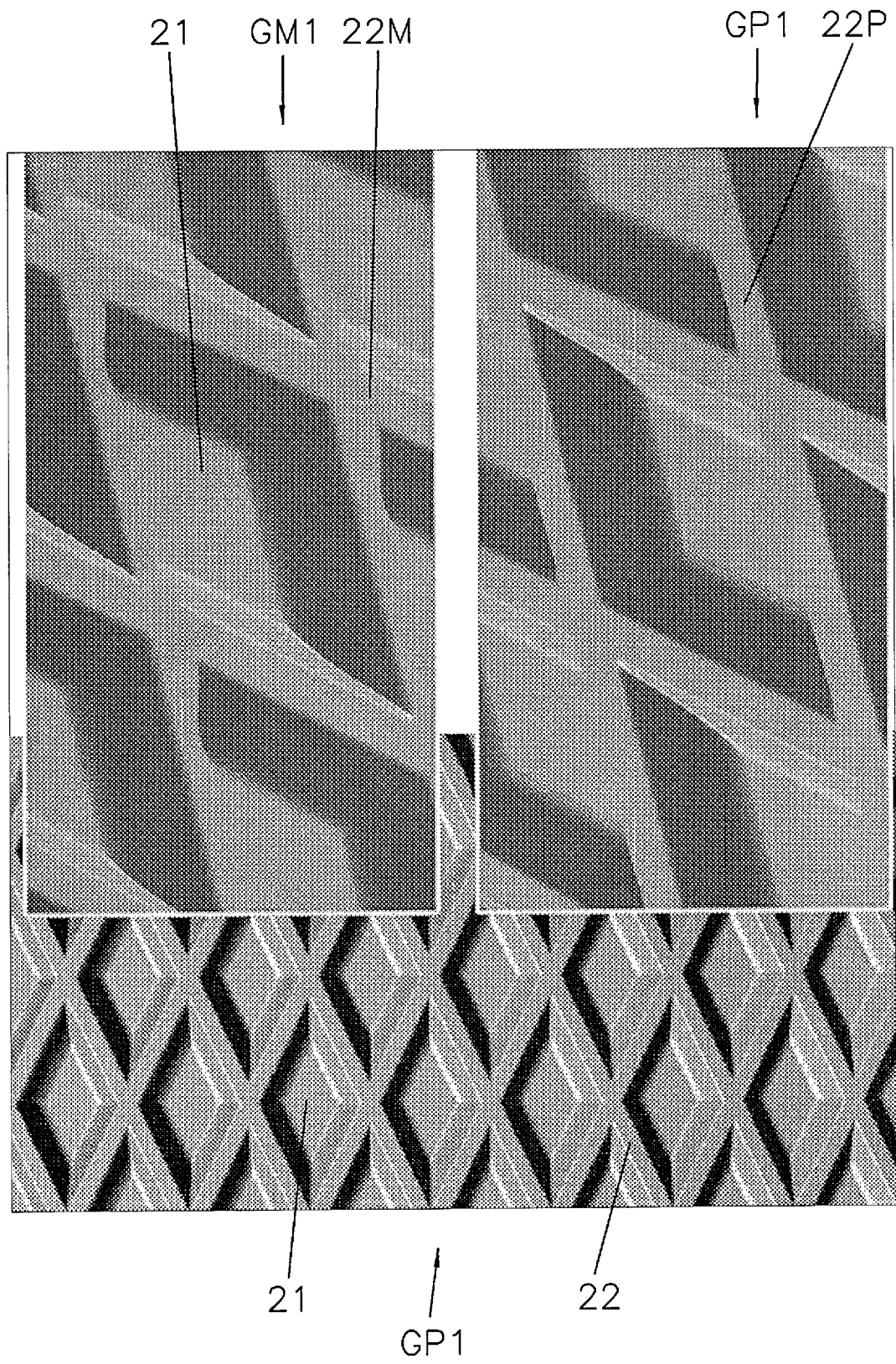




**FIG. 13**

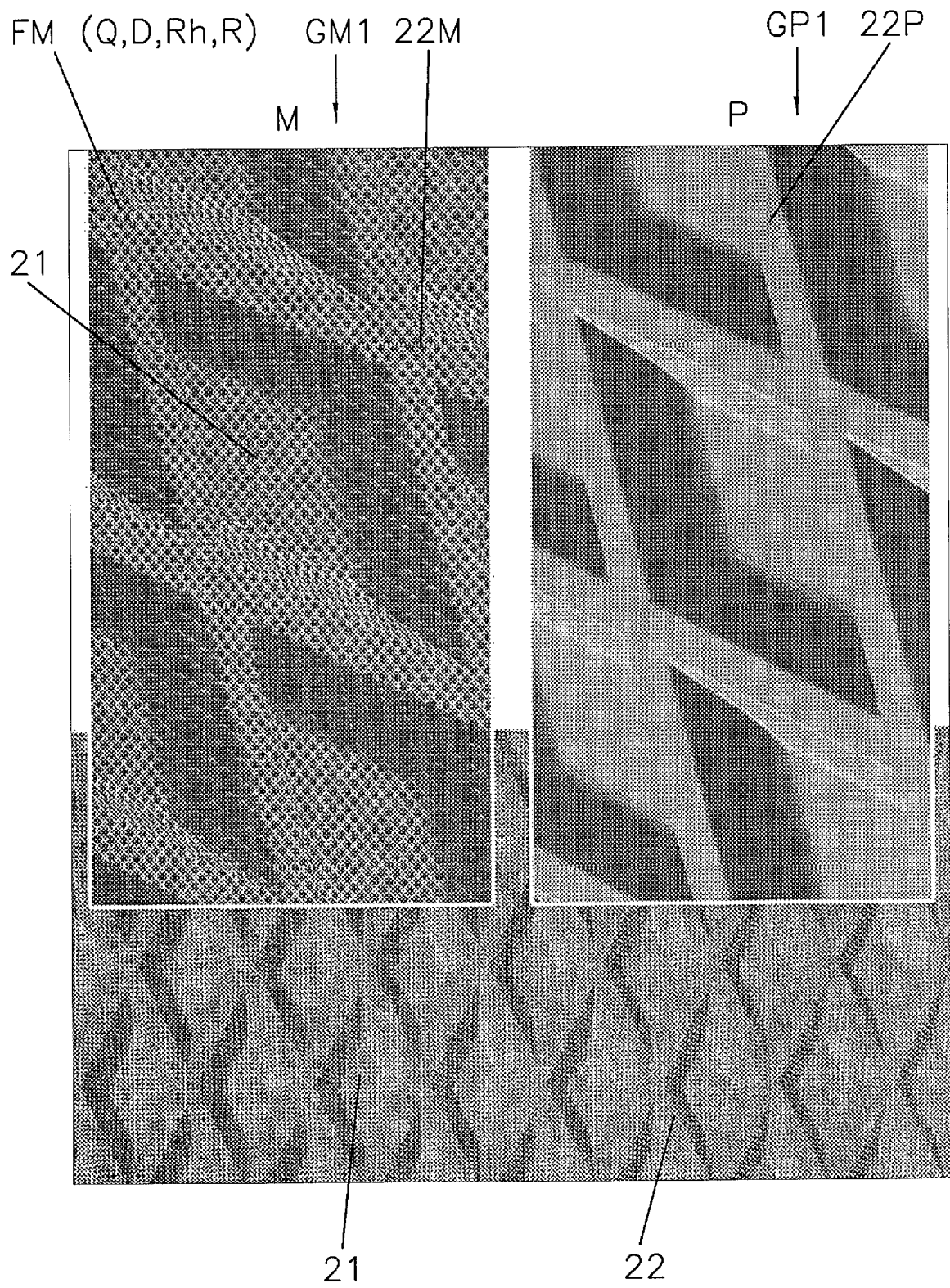


**FIG. 14**

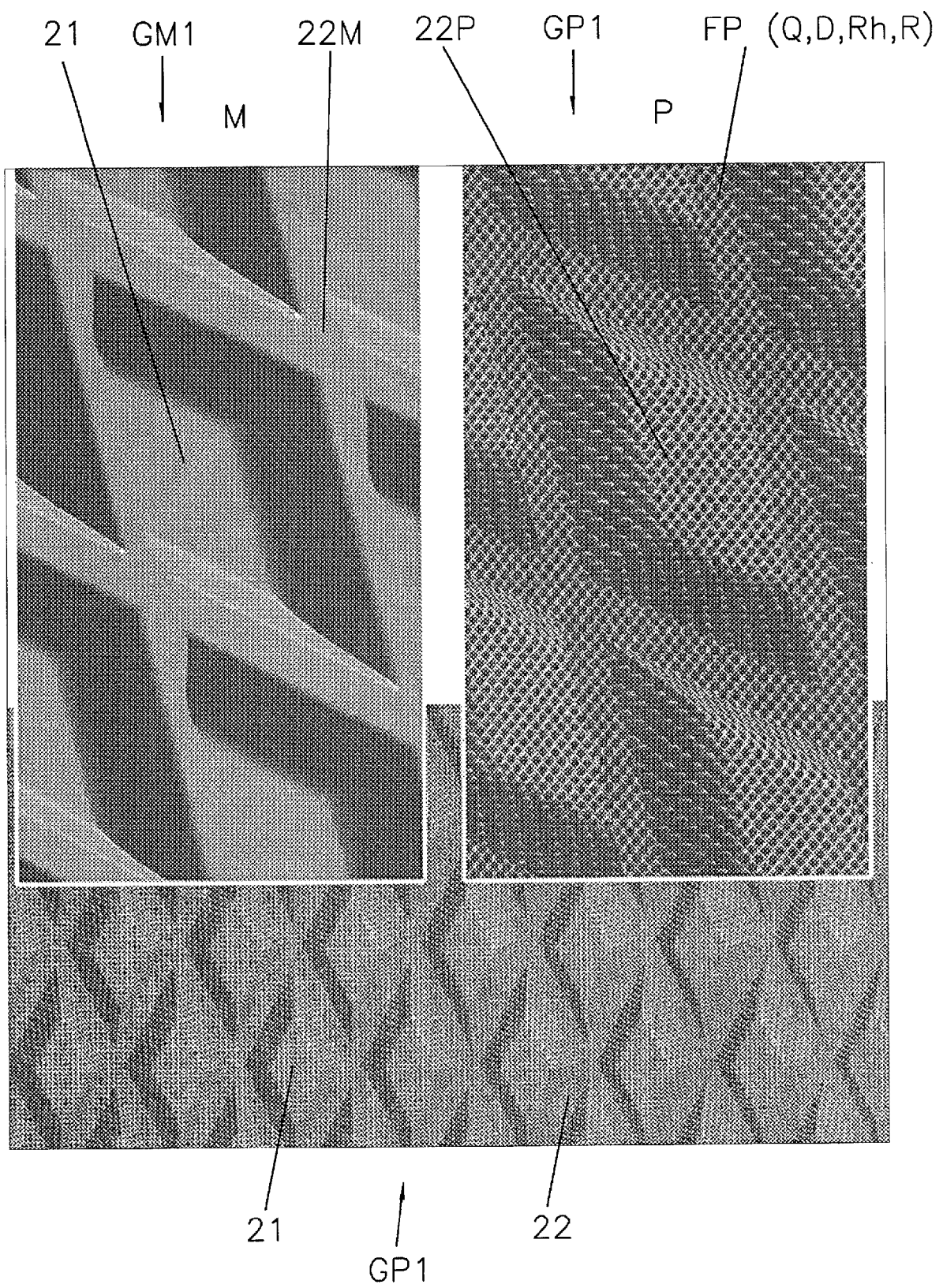


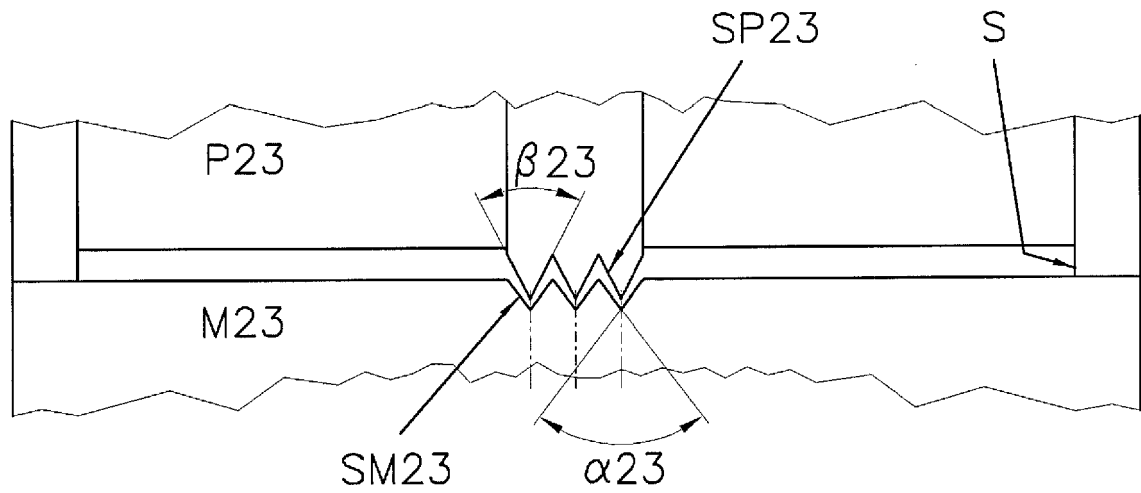
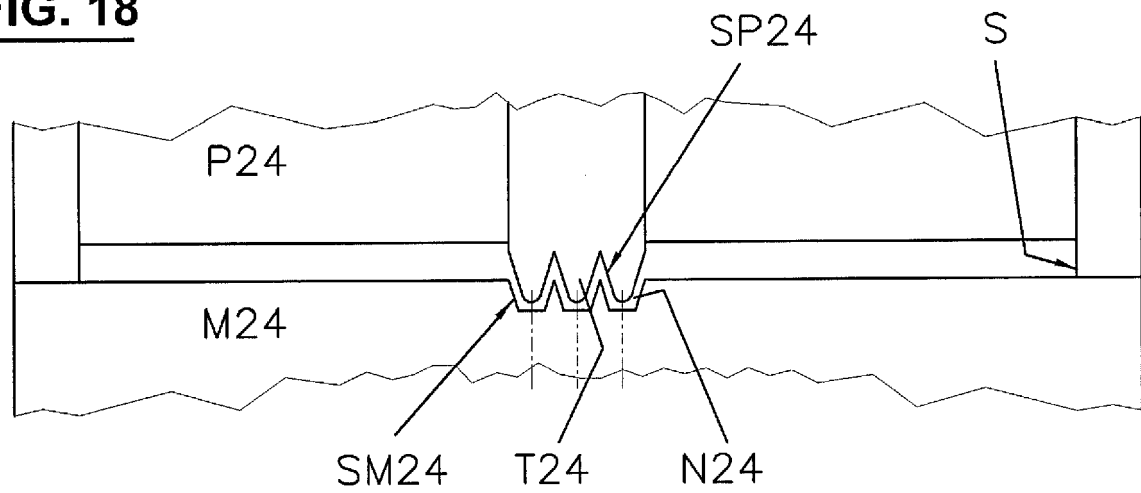
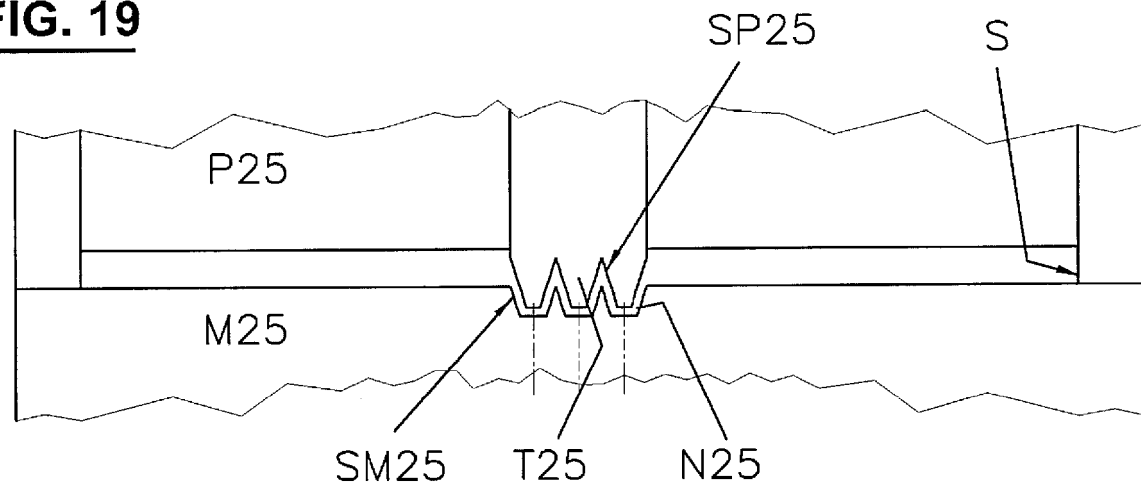


**FIG. 15**

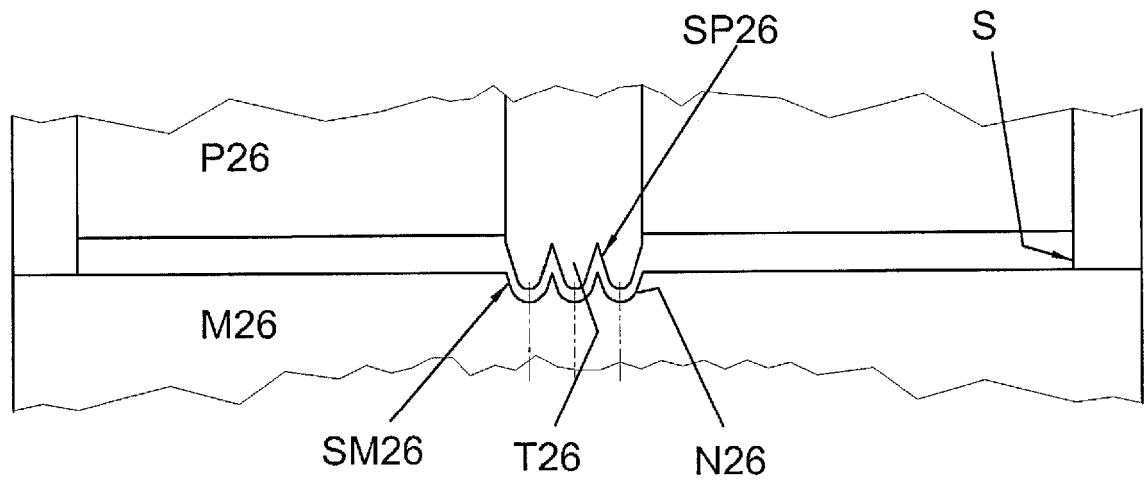


**FIG. 16**

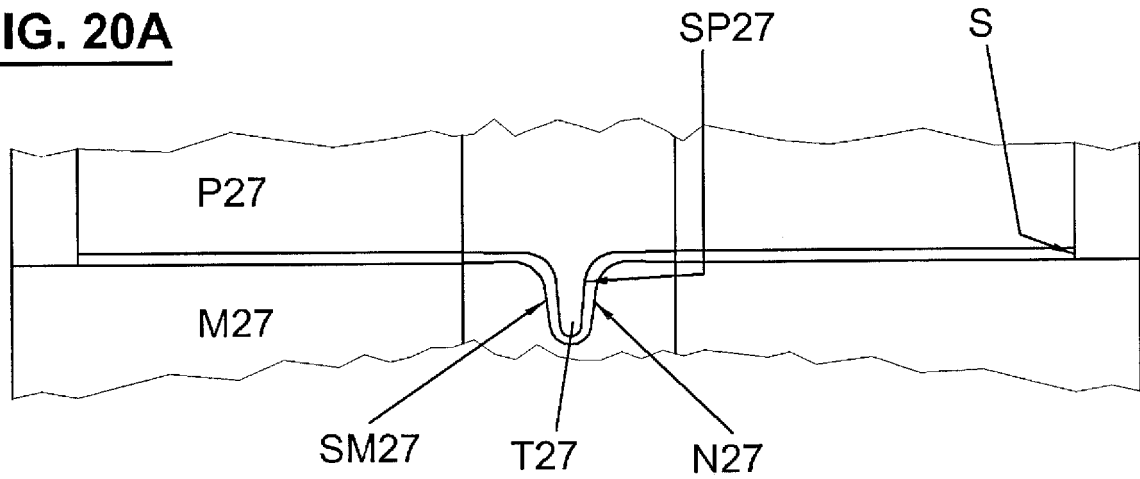


**FIG. 17****FIG. 18****FIG. 19**

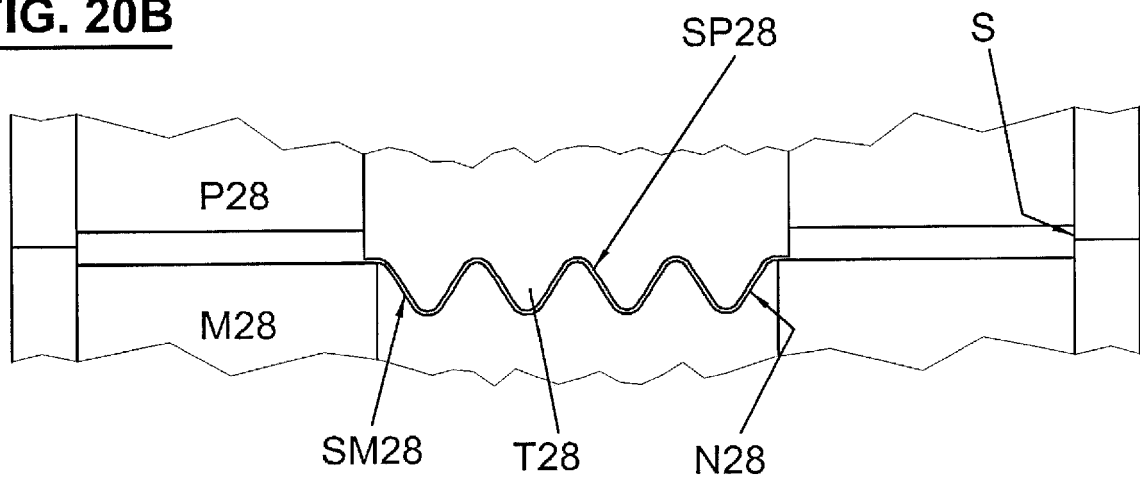
**FIG. 20**



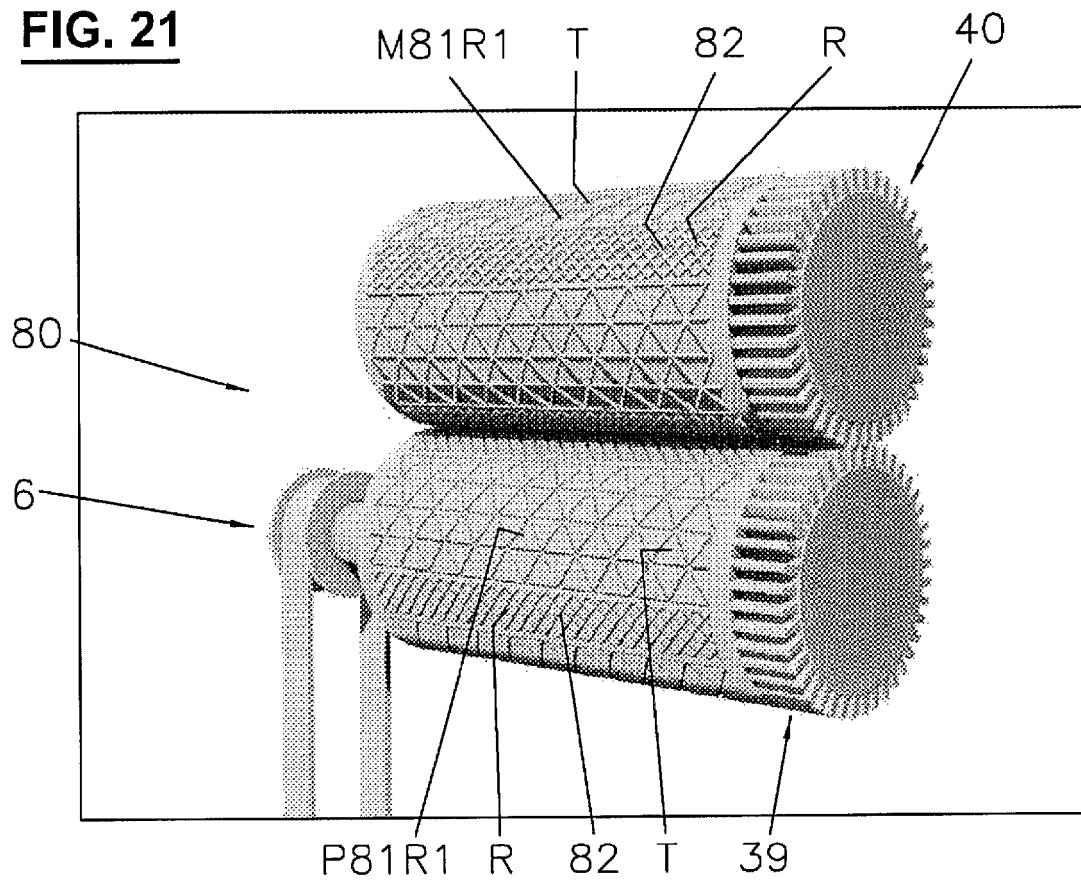
**FIG. 20A**



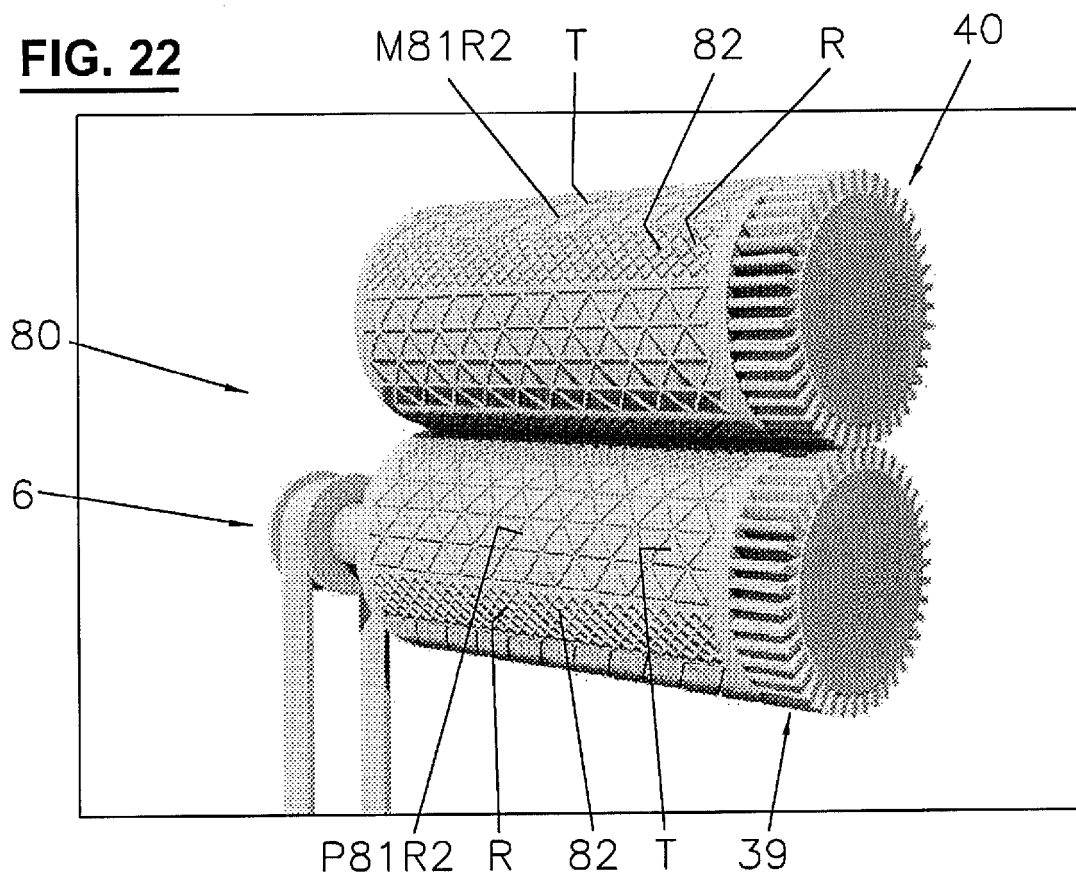
**FIG. 20B**



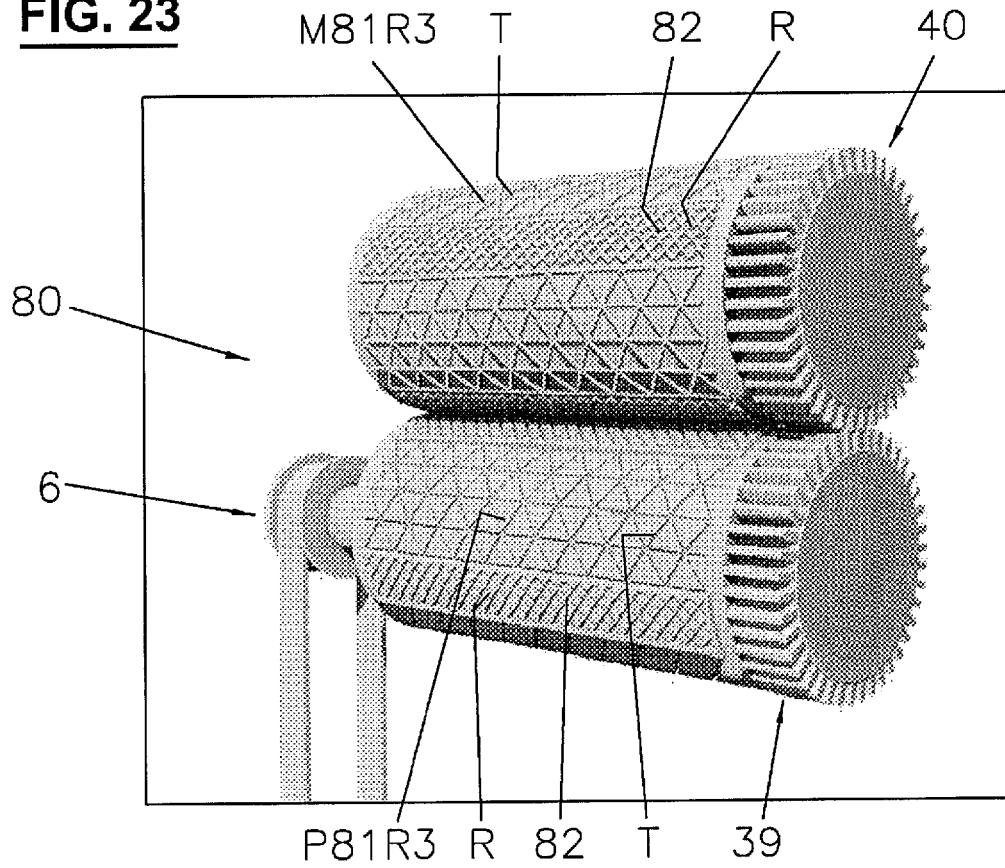
**FIG. 21**



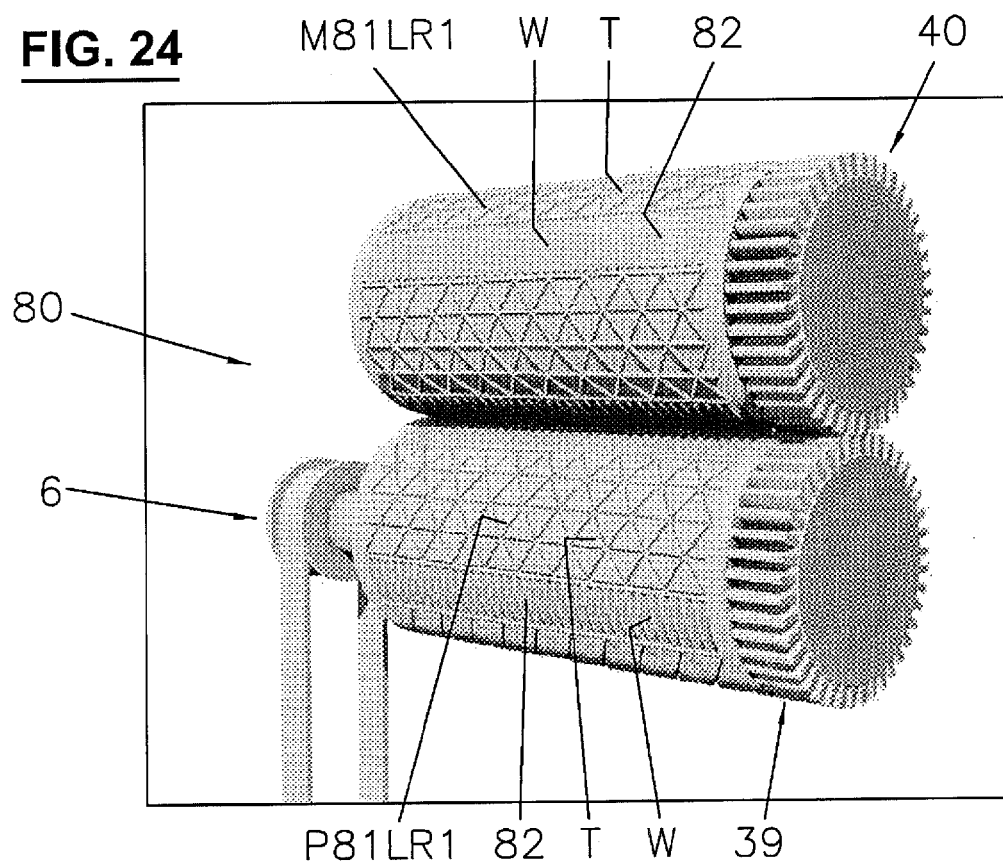
**FIG. 22**



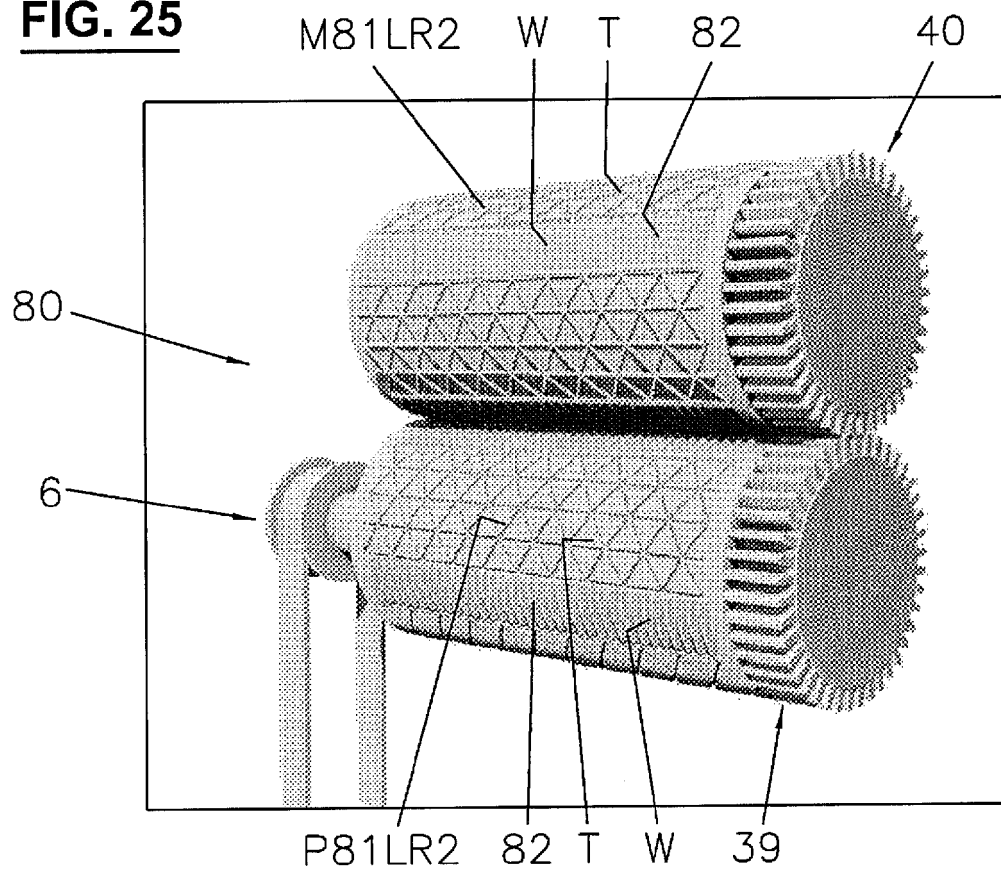
**FIG. 23**



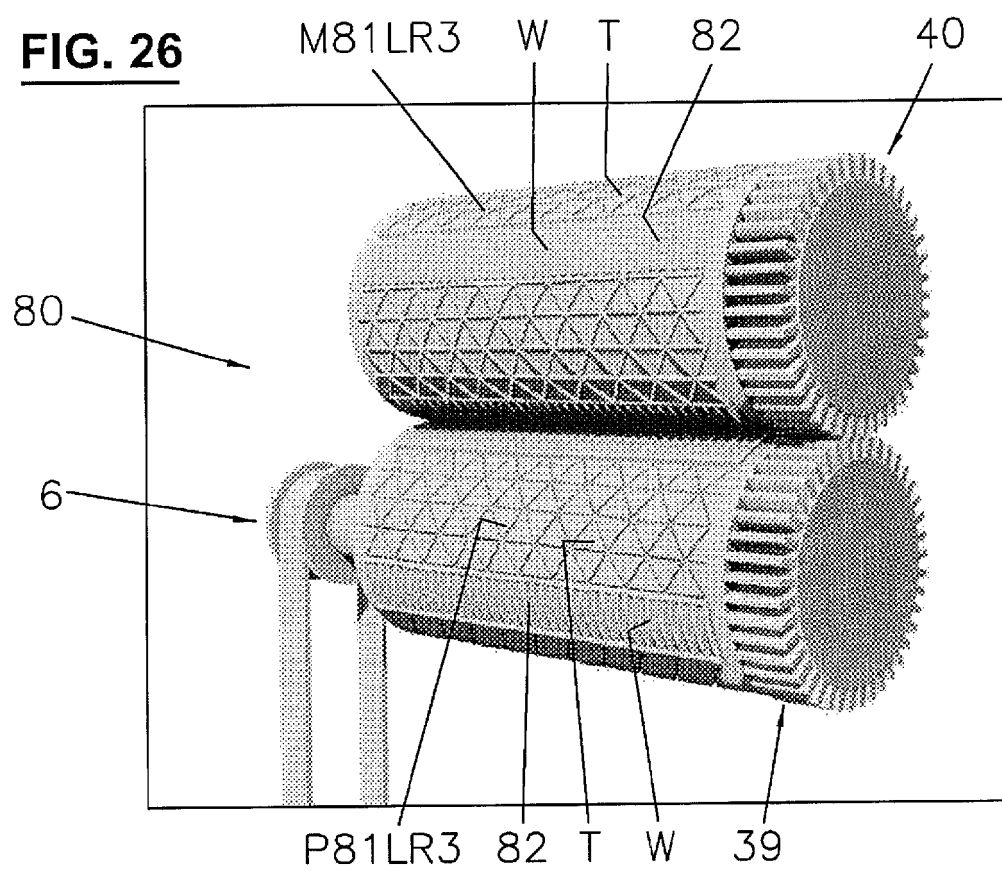
**FIG. 24**



**FIG. 25**

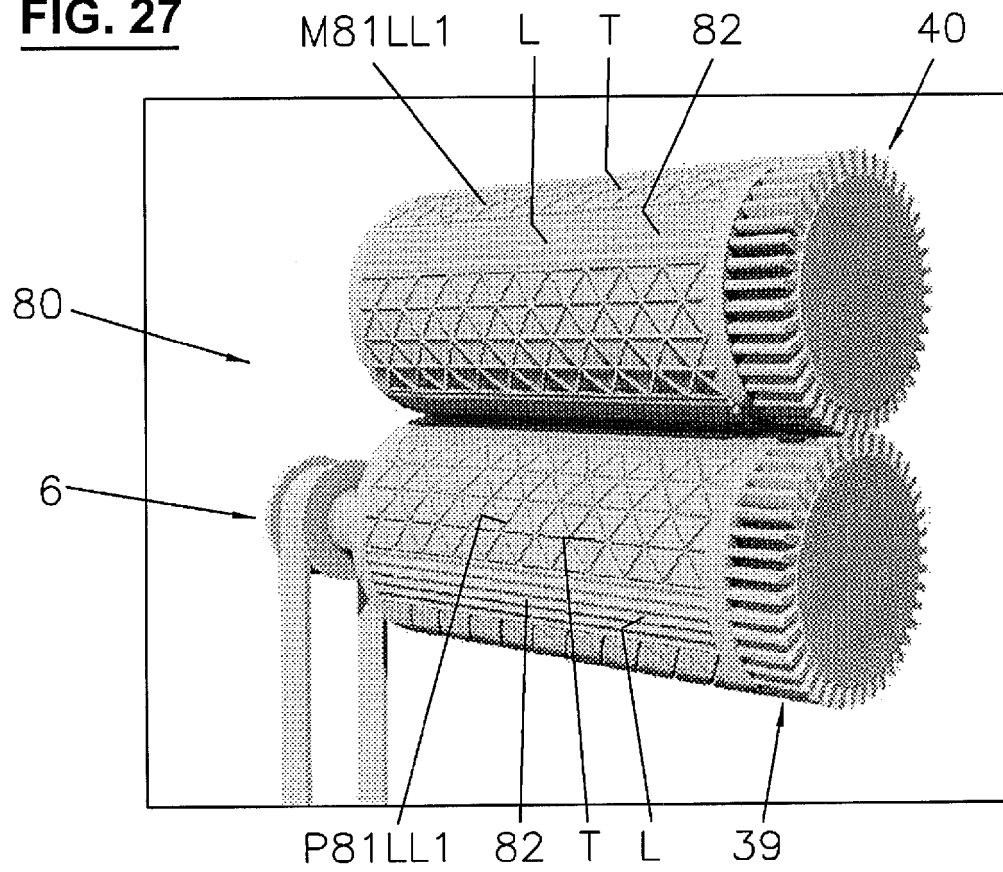


**FIG. 26**

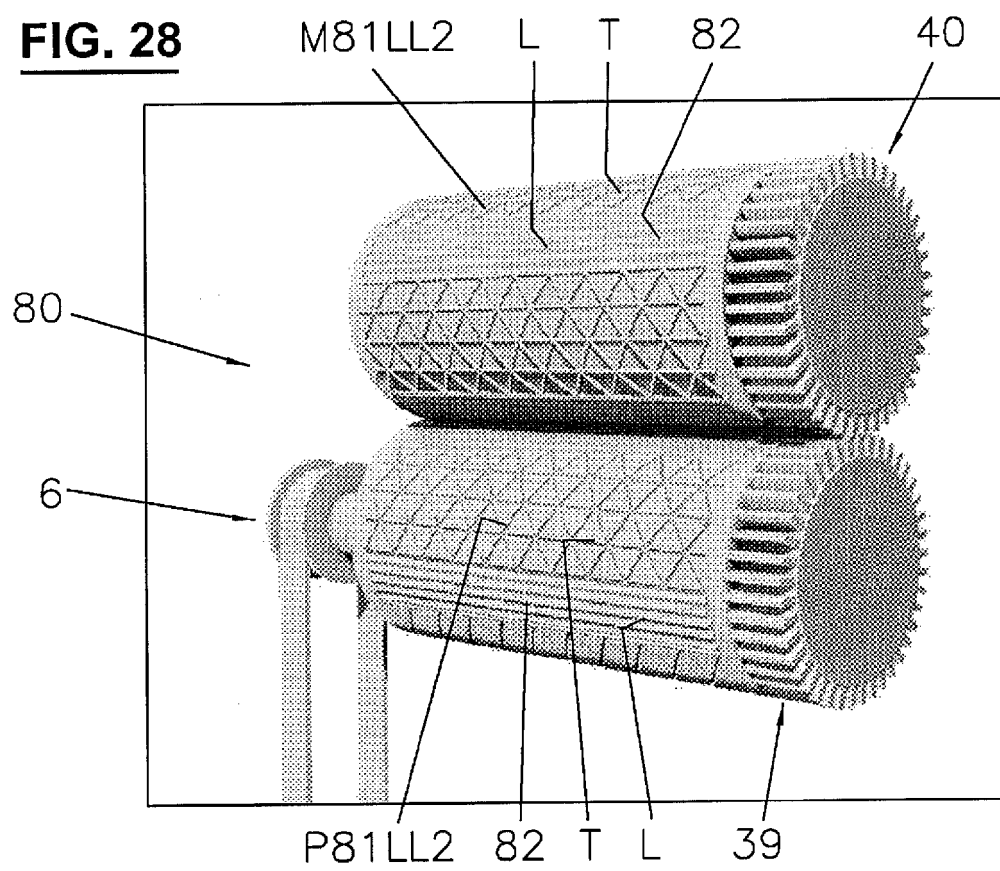




**FIG. 27**

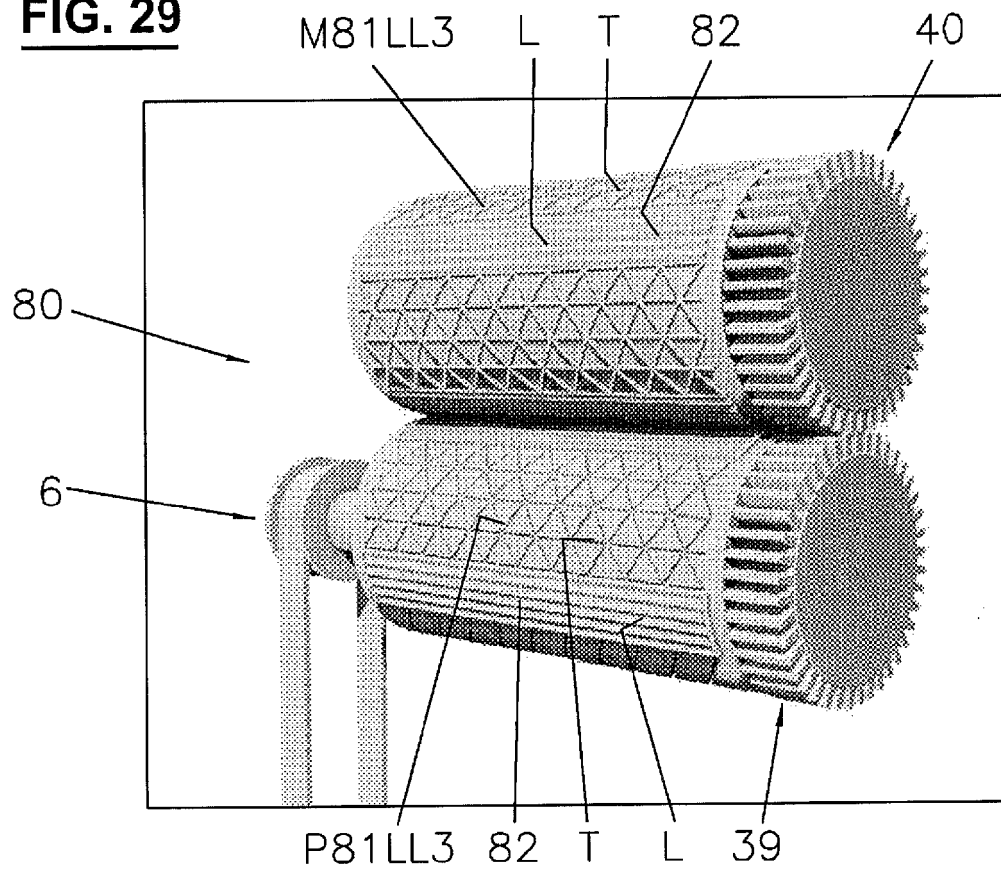


**FIG. 28**

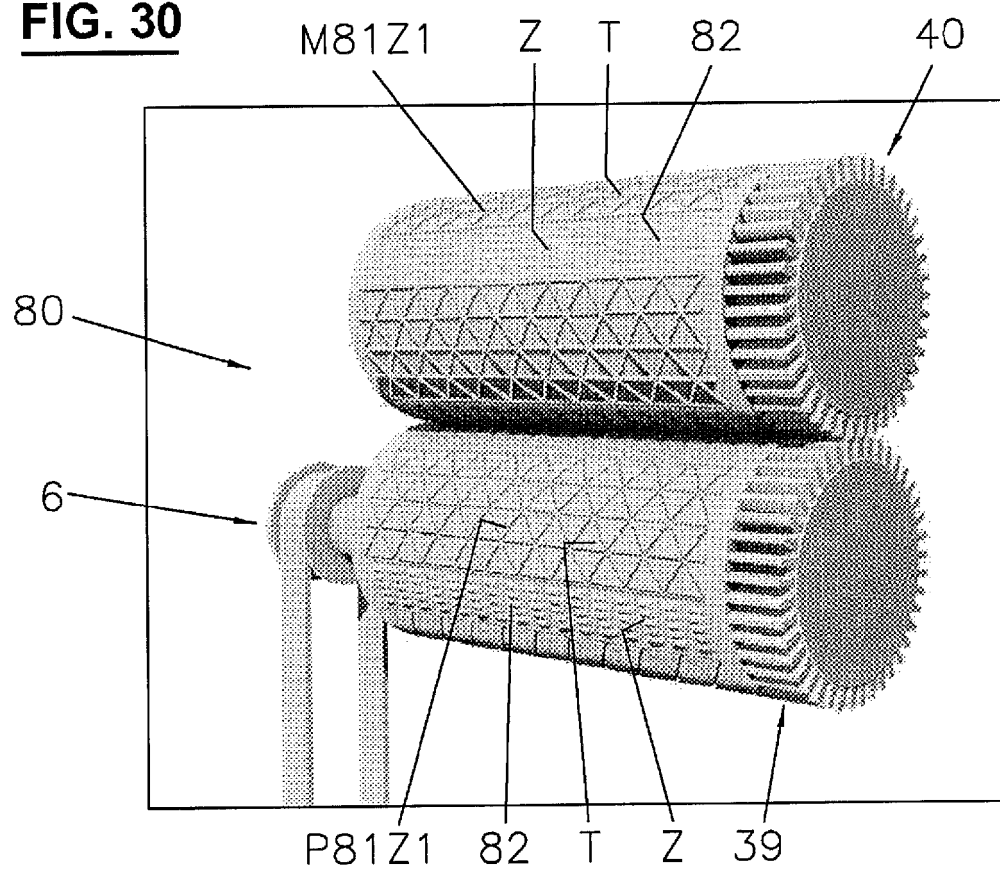




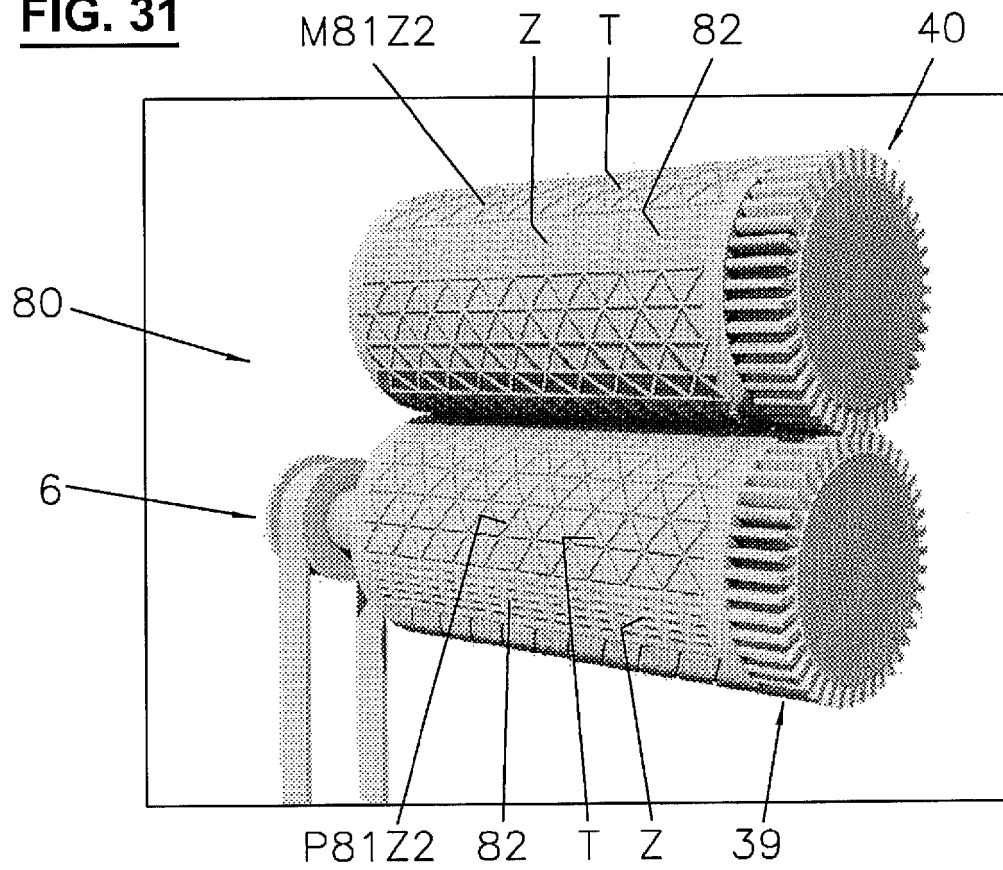
**FIG. 29**



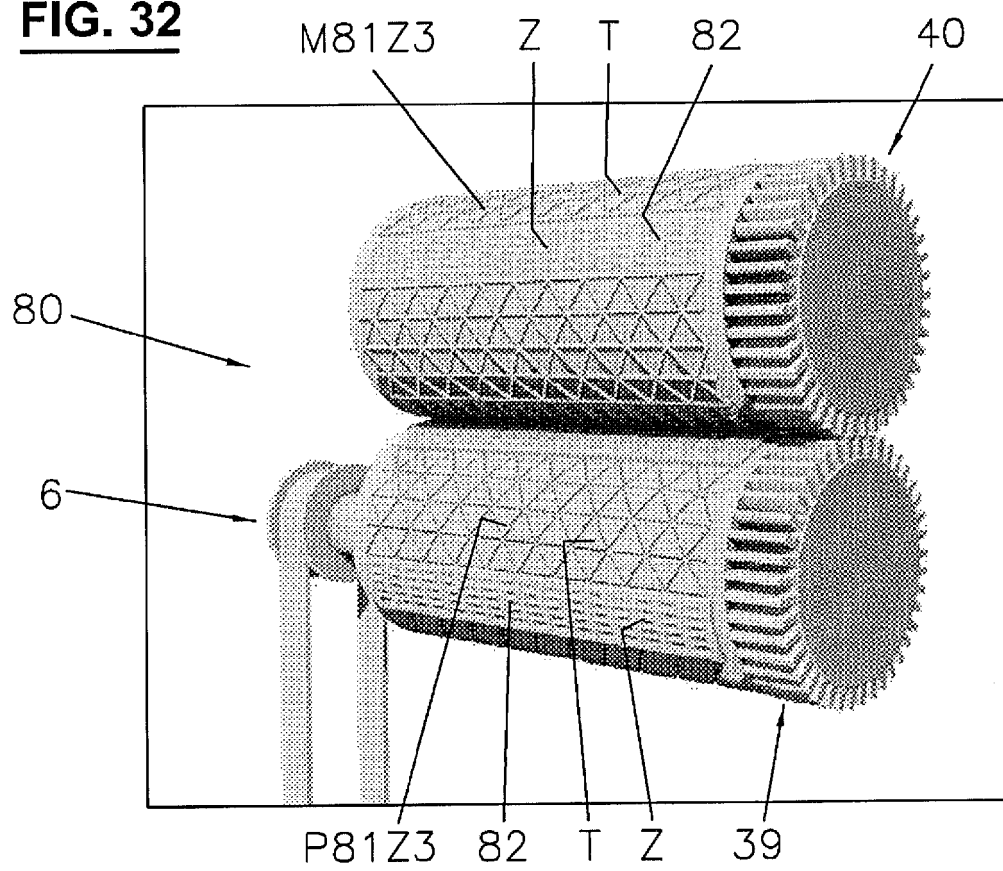
**FIG. 30**



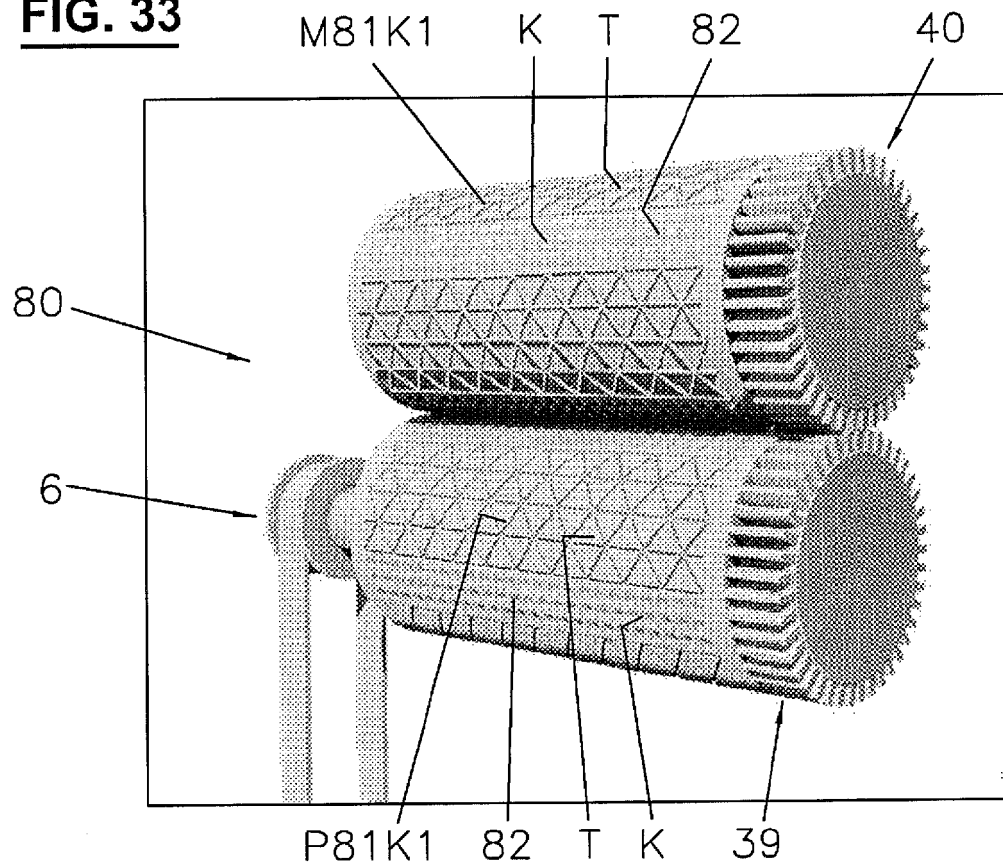
**FIG. 31**



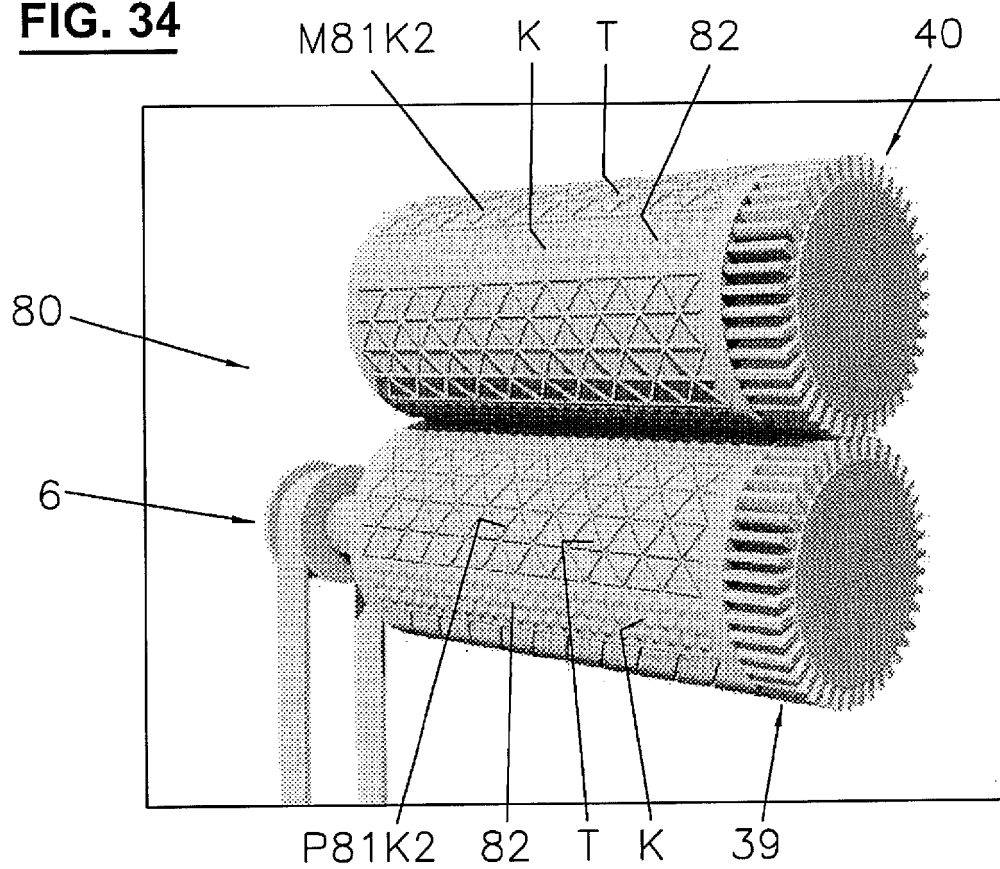
**FIG. 32**



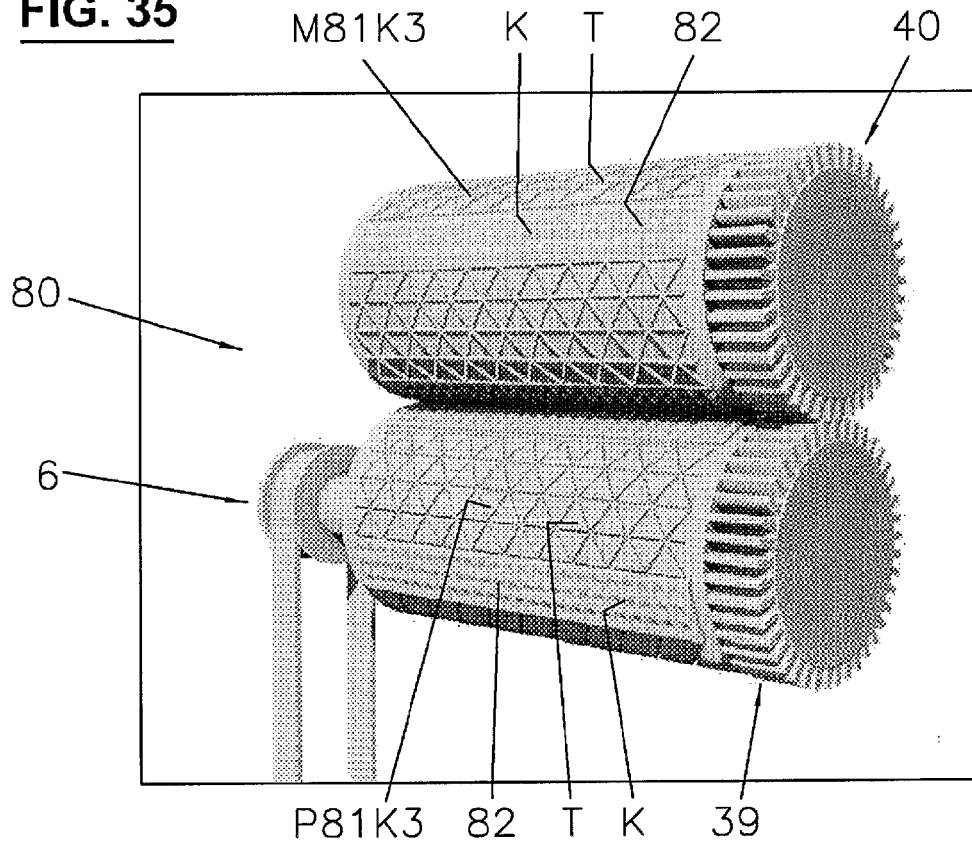
**FIG. 33**



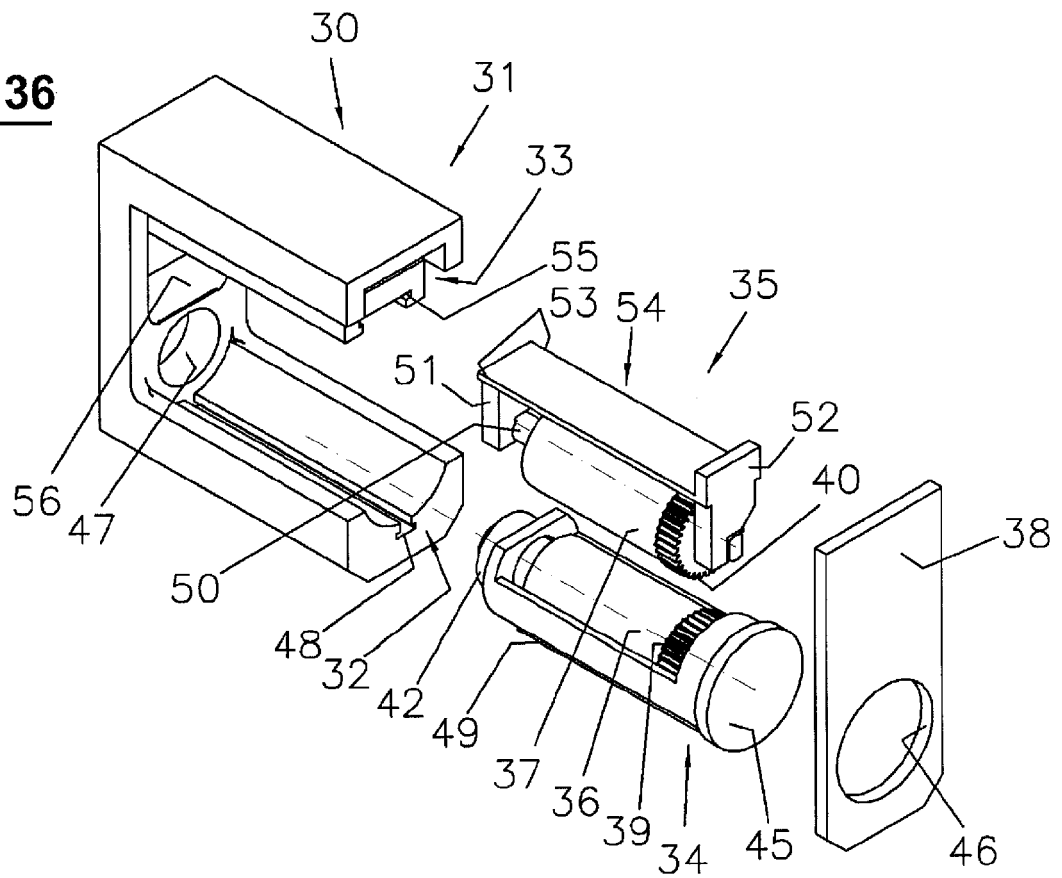
**FIG. 34**



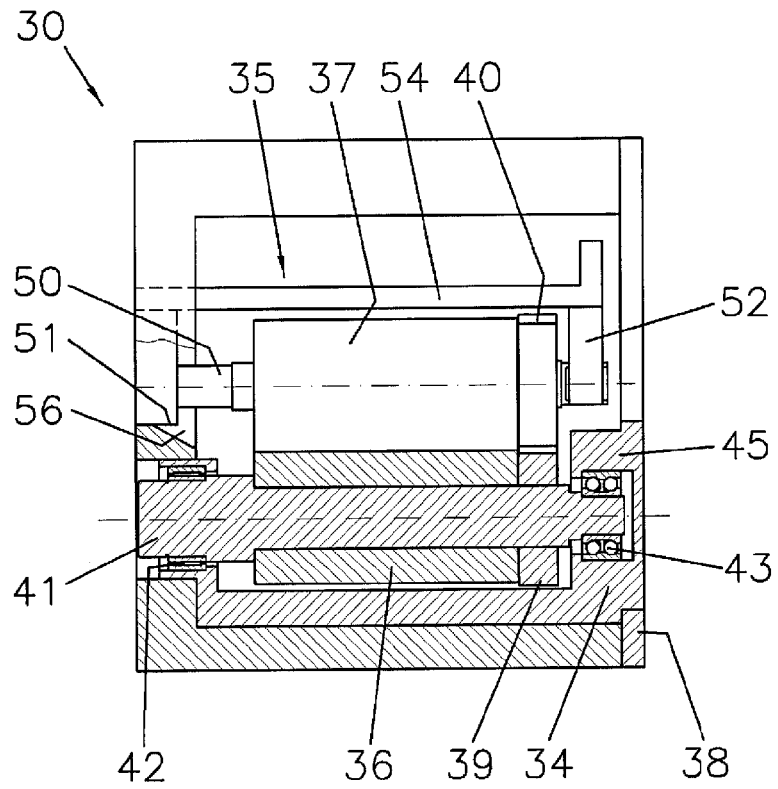
**FIG. 35**



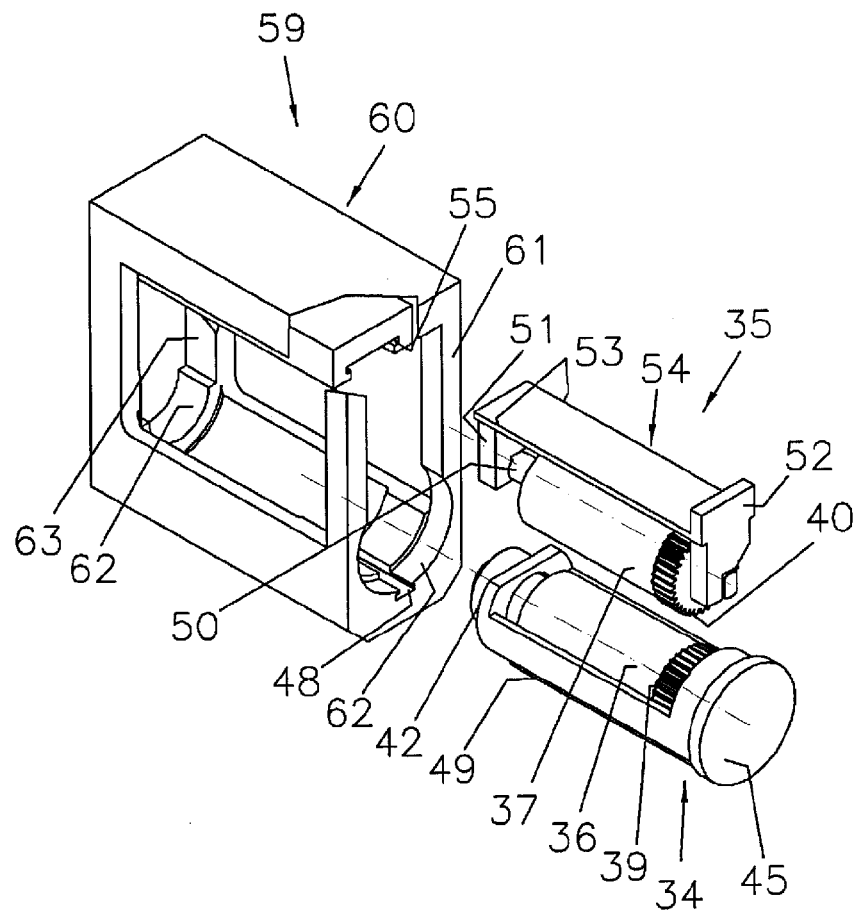
**FIG. 36**



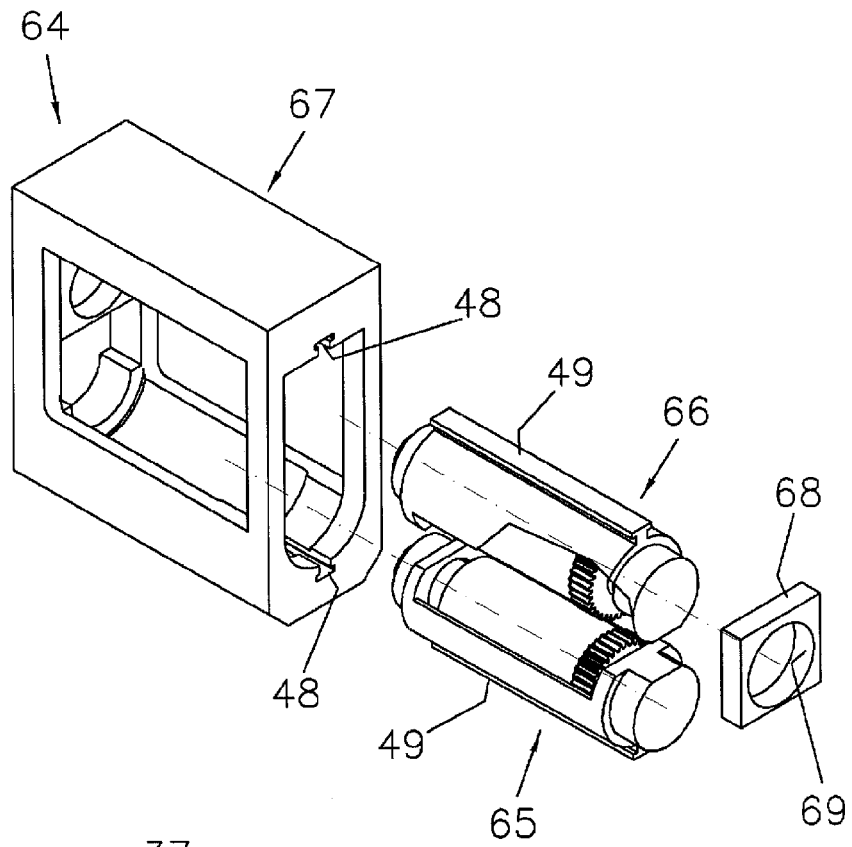
**FIG. 37**



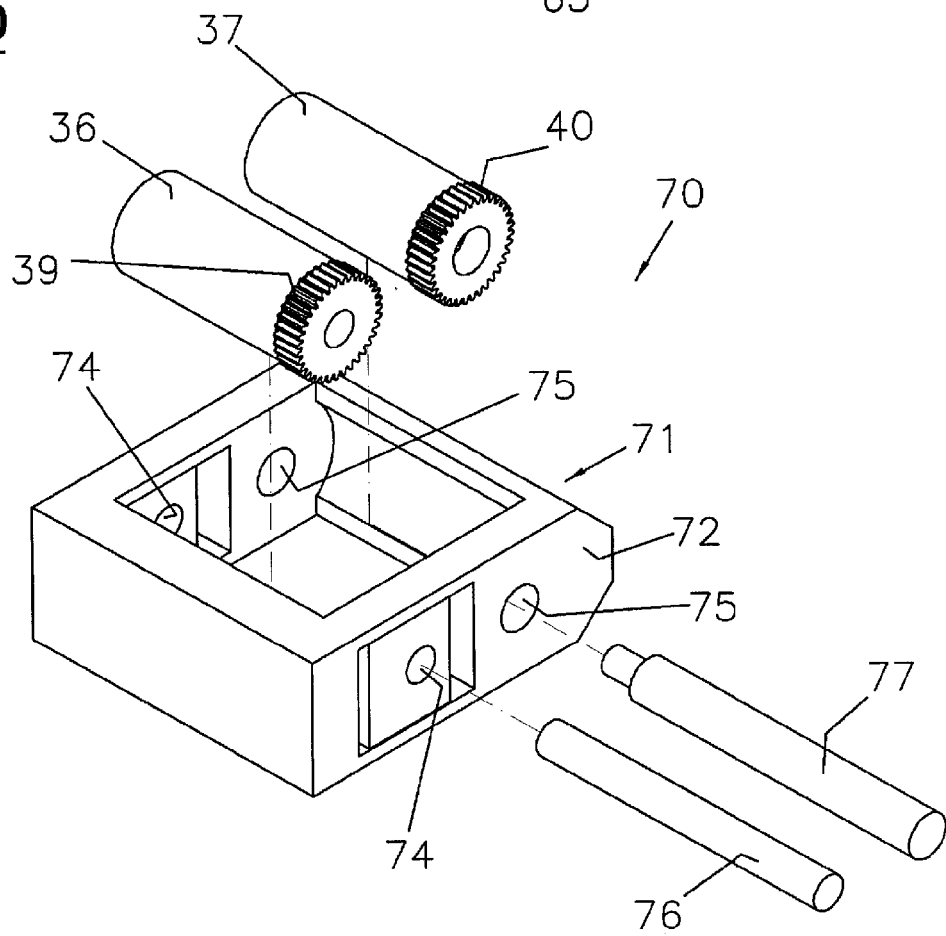
**FIG. 38**



**FIG. 39**



**FIG. 40**



**REFERENCES CITED IN THE DESCRIPTION**

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