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(54) **WATER SOLUBLE POUCHES**  
**WASSERLÖSLICHE BEUTEL**  
**SACHETS SOLUBLES DANS L'EAU**

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**Description**

**[0001]** This invention concerns improvements in or relating to water-soluble pouches. More specifically, the invention concerns apparatus and methods for producing multi-compartment water-soluble pouches from two or more soluble substrates on continuous motion rotatable forming machines. The invention also concerns multi-compartment water-soluble pouches made from two or more soluble substrates, and in particular, but not exclusively, pouches made using the apparatus and methods of the present invention.

**[0002]** In our earlier applications WO2011/061628 and WO2013/190517, continuous motion rotatable formers and pouches made thereon have been described. In WO2011/061628, apparatus for making pouches from two water-soluble substrates was described wherein a rotatable former is provided with cavities into which a base web is formed to create open pockets in the base web. Once formed, the base web is tightly held by vacuum within the cavity throughout the process of filling the pockets, sealing the pockets with a top or lidding web to form pouches in the combined webs and separating the pouches from the combined web by transverse and web direction knives. In WO2013/190517, apparatus for making multi-compartment pouches from four water-soluble substrates via two pouches was described wherein each pouch was made from two water-soluble substrates on separate rotatable formers similar to the process described in WO2011/061628 and the web of pouches on one former then joined to the web of pouches on the other former produce combined pouches before separating the combined pouches from the combined webs by transverse and web direction knives.

**[0003]** As described in the above earlier applications, after separating, many water-soluble substrates, especially those based substantially upon polyvinyl alcohol, are subject to what is known as shrink-back after forming but by holding the base web tightly within the cavity throughout the filling, sealing and cutting operations, shrink-back of the base web is prevented.

**[0004]** When the machines described in the above earlier applications are used for making multi-compartment pouches from two water-soluble substrates, a particular difficulty arises when the number of compartments to be filled is greater than two due to the lack of space across the web in which to fit the necessary number of filling heads, and to the lack of time during which to complete the filling operation if the machine is to operate at its optimal manufacturing capacity. Lack of space across the web dictates the use of point filling heads such as nozzle injectors for liquids and gels, and augur fillers for powders and granules. However, even by means of point filling heads, it can be difficult to accommodate sufficient filling heads across the web, and particularly to fill powders and granules quickly enough.

**[0005]** JP-61-73642 discloses a pouch made from a single film wherein the film is folded in half and sealed on three or four sides. The pouch has a single compartment and is filled from the top side, opposite to the fold line.

**[0006]** US 2003 / 021839 A1 discloses a method of manufacturing a two-compartment capsule, each compartment holding different material.

**[0007]** It is an object of the present invention to provide apparatus and methods for producing multi-compartment water-soluble pouches from two or more soluble substrates on continuous motion rotatable forming machines that address one or more of the aforementioned problems.

**[0008]** In one aspect, the present invention provides a multi-compartment pouch as defined in claim 1. Optional features are the subject of claims 2 to 10. It may be that the pouch comprises at least two compartments and wherein each compartment is formed between the same two substrates. The compartments may contain different products selected for example from liquids, gels, powders and granules. At least one compartment may be empty, i.e. not filled.

**[0009]** It may be that the pouch comprises three or more compartments.

**[0010]** It may be that the compartments are disposed within the pouch such that they provide resistance to planar distortion.

**[0011]** It may be that the compartments are disposed within the pouch such that any bending axis arbitrarily laid across the pouch cuts through the body of at least one compartment.

**[0012]** It may be that the pouch contains a perimetric compartment.

**[0013]** It may be that the pouch contains a divided perimetric compartment.

**[0014]** It may be that at least one compartment is filled with a flowable composition, for example a liquid or gel.

**[0015]** It may be that at least one compartment is filled with a solid composition, for example a powder or granules.

**[0016]** It may be that at least one compartment is filled with more than one composition wherein the compositions are mutually compatible and not antagonistic to each other.

**[0017]** It may be that the top lidding web has a thickness of between 50% and 75% of that of the base web.

**[0018]** It may be that each compartment is filled to at least 90% of the available volume.

**[0019]** It may be that the compartments are formed sequentially in the base web and each compartment is filled before a further compartment is formed and filled until all compartments have been filled whereupon the compartments are closed by sealing with a top or lidding web.

**[0020]** It may be that the pouch is sealed to a second closed multi-compartment pouch such that the combined pouch comprises four water-soluble substrates.

**[0021]** It may be that the pouch is sealed to a second open multi-compartment pouch such that the combined pouch comprises three water-soluble substrates.

**[0022]** It may be that at least two compartments are filled with a greater weight of a powder or granular composition than the weight of any compartment filled with a liquid or gel.

5 **[0023]** In another aspect, the present invention provides a method of making a multi-compartment pouch as defined in claims 11. Optional features are the subject of claims 12 to 14.

**[0024]** It may be that each pocket of the multi-compartment pouch is filled with at least one product.

**[0025]** It may be that the former is configured so that at least one open pocket of a pouch is formed and filled before at least one other open pocket of the pouch is formed and filled, and only once all open pockets have been filled is the  
10 pouch closed by sealing with a lidding web.

**[0026]** It may be that a second pouch is affixed to the multi-compartment water-soluble pouch to form a combined pouch.

**[0027]** It may be that each pouch comprises two water soluble substrates such that the combined pouch comprises four water-soluble substrates. The second pouch may be a multi-compartment pouch.

15 **[0028]** It may be that the top or lidding web of the multi-compartment water-soluble pouch is provided by the second pouch such that the combined pouches comprises three water-soluble substrates. The second pouch may be a multi-compartment pouch.

**[0029]** The foregoing is a summary and thus, by necessity, contains simplifications, generalizations, and omissions of detail. Any or all of the features, limitations, configurations, components, subcomponents, systems, and/or subsystems described above may be used in combination. Consequently, those skilled in the art will appreciate that the summary  
20 is illustrative only and is not intended to be in any way limiting. Other aspects, inventive features, and advantages of the devices and/or processes described herein, as defined by the claims, will become apparent in the detailed description set forth herein and taken in conjunction with the accompanying drawings wherein:

25 **Figure 1** shows plan and sectional views of a multi-compartment pouch made from two substrates according to the present invention;

**Figure 2** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

30 **Figure 3** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

**Figure 4** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

35 **Figure 5** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

40 **Figure 6** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

**Figure 7** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

45 **Figure 8** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

**Figure 9** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

50 **Figure 10** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

55 **Figure 11** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

**Figure 12** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

**Figure 13** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

**Figure 14** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

**Figure 15** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

**Figure 16** shows plan, sectional and perspective views of a multi-compartment pouch made from two substrates according to the present invention;

**Figure 17** shows plan, sectional and perspective views of of a multi-compartment pouch made from two substrates according to the present invention;

**Figure 18** shows reconfiguration of a formed pouch to a symmetrical configuration;

**Figure 19** shows arrangements for filling a multi-compartment pouch comprising two compartments;

**Figure 20** shows an arrangement for filling a multi-compartment pouch comprising three compartments;

**Figure 21** shows arrangements of the filling heads for filling multi-compartment pouches;

**Figure 22** shows an embodiment of a horizontal rotatable forming machine for producing pouches from two substrates;

**Figure 23** shows an embodiment of a horizontal rotatable former machine and a cylindrical rotatable forming machine for producing pouches from four substrates;

**Figure 24** shows an embodiment of a horizontal rotatable former machine and a cylindrical rotatable forming machine for producing pouches from three substrates;

**Figure 25** shows an embodiment of two horizontal rotatable forming machines for producing pouches from four substrates;

**Figure 26** shows an embodiment of two horizontal rotatable forming machines for producing pouches from three substrates;

**Figure 27** shows a pouch with three compartments;

**Figures 28 and 29** show a method sequentially forming and filling the pouch of Figure 27

**Figure 30** shows apparatus for forming sequentially forming the compartments of the pouch shown in Figure 27;

**Figure 31** shows another apparatus for forming sequentially forming the compartments of the pouch shown in Figure 27;

**Figure 32** shows a method of sequentially forming and filling a pouch with two compartments;

**Figure 33** shows a method of sequentially forming and filling a pouch with three compartments;

**Figure 34** shows a method of sequentially forming and filling a pouch with four compartments;

**[0030]** Various multi-compartment pouches 1 are shown in Figures 1 to 17 and summarised in the following Table :

Figure Number	Configuration in Plan View	Number of Compartments
1	Circular or Elliptical with a complete perimetric compartment	2
2	Circular or Elliptical with a divided perimetric compartment	3
3	Triangular with rounded corners and a complete perimetric compartment	2
4	Triangular with rounded corners and a divided perimetric compartment	3
5	Square or Rectangular with a complete perimetric compartment	2
6	Square or Rectangular with a divided perimetric compartment and a divided central compartment	4
7	Horseshoe	2
8	Horseshoe with a divided external compartment	3
9	Central Tee compartment	3
10	Central H compartment	3
11	Rectangular with a divided perimetric compartment	3
12	Rectangular with a divided perimetric compartment	3
13	L-shaped external compartment	2
14	Wedge compartments	2
15	Wedge compartments with a central compartment	3
16	Shamrock compartments	4
17	Clover Leaf compartments	3

**[0031]** Each pouch 1 is formed from two water soluble substrates 2, 3 which may be referred to as a base web 2 and a top or lidding web 3. Any suitable water soluble substrates may be employed. Pouches 1 having two compartments 1a, 1b are shown in Figures 1,3,5,7,13,14. Pouches 1 having three compartments 1a,1b,1c are shown in Figures 2,4,8,9,10,11,12,15,17. Pouches having four compartments 1,1b,1c,1d are shown in Figures 6,16. Each pouch 1 is symmetrical about a weld line 4 between the base web 2 and top lidding web 3. Each compartment 1a,1b,1c,1d is formed between the base web 2 and the top or lidding web 3. The footprint 5 of the pouches 1 and the number, shape and arrangement of the compartments 1a,1b,1c,1d is exemplary only and other configurations that may be employed will be apparent to those skilled in the art. The term "footprint" is defined as the plan view of the pouch 1 as seen from above the top or lidding web 3 of the pouch 1.

**[0032]** Water-soluble substrates are often by the very nature of the materials, lacking in rigidity. As a result, when forming a water soluble pouch from two water soluble substrates, the resulting pouch will itself have a tendency to lack rigidity or planar strength which will give an unattractive floppy aspect to the pouch when handled by the consumer. Such a lack of rigidity or planar strength is referred to herein as planar distortion. Whilst the majority of water-soluble substrates capable of being formed, for example thermoformed or vacuum formed, are at the present time, made substantially from polyvinyl alcohol resins, other water-soluble substrates capable of being formed may be used to practise the present invention.

**[0033]** Planar distortion of multi-compartment pouches may be overcome or significantly reduced in this invention by one or more of the following factors:

- i) relative position and/or shape of the compartments 1a,1b,1c,1d within the footprint 5.
- ii) filling each compartment 1a,1b,1c,1d to a level of at least 80%, preferably at least 90%, of the available volume,
- iii) selecting the relative thicknesses of the top lidding web 3 and the base web 2 in order to utilise the retraction or shrinkback of the base web 2 after the webs have been sealed together and the pouch ejected from the forming machine or apparatus,

**[0034]** These factors and their impact on planar distortion of the resulting pouch 1 are now discussed. It may be that these factors can be employed separately, or in combination of any two, or preferably in a combination of all three. The invention extends to and includes pouches 1 so formed. Aspects of the invention referred to herein may include any of

these factors and we do not intend the invention to be limited to those aspects specifically mentioned.

## **POSITION AND/OR SHAPE OF COMPARTMENTS**

**[0035]** Planar distortion may be reduced by employing a perimetric compartment as one of the compartments. The term "perimetric" in this context describes a compartment which is situated around the perimeter of the pouch. In its simplest form, the perimetric compartment may be square or rectangular with rounded corners, allowing maximum use of the area of the footprint, and hence providing maximum possible compartment fill volumes. When viewed from above the top lidding web, such a square or rectangular perimetric compartment may follow the cut edges of the pouch with its outer limit set back from the cut edges of the pouch, for example at least 1.5mm from the cut edges of the pouch. A square or rectangular perimetric compartment may be rejected for marketing or other reasons in favour of other shapes, such as triangular with rounded corners, or pentagonal with rounded corners, or circular or elliptical although these shapes are by no means limiting. It will be apparent that departing from a square or rectangular perimetric compartment can reduce the combined fill volume of the compartments within the pouch and leave a larger flange around the perimetric or semi-perimetric compartment.

**[0036]** The perimetric compartment may be divided into two or more separate compartments in order to increase the number of compartments within a pouch of a given footprint. However, by subdividing the perimetric compartment, there may be a loss of planar stability. The invention overcomes this loss of planar stability by compartmental design. As an example, if the perimetric compartment is divided into two semi-perimetric compartments, the pouch may, unless corrective design features are introduced to prevent it, flex about a line joining the seal areas between the semi-perimetric compartments. A multi-compartment pouch which is able to flex will be less appealing to the consumer than one which has planar stability.

**[0037]** One or more of the compartments within the multi-compartment pouch may be left unfilled in order to provide additional resistance to planar distortion of the pouch.

## **COMPARTMENT FILL LEVELS**

**[0038]** Planar distortion may be reduced by filling each compartment of the pouch to at least 80%, preferably at least 90%, of its available volume. Such a percentage fill of the available volume of each compartment has been found to contribute to planar stability of the pouch.

## **WEB THICKNESSES**

**[0039]** The thickness of the top lidding web<sup>3</sup> may be selected to be between 30% and 90%, preferably between 50% and 75%, of that of the base web 2. By this means, when, after the pouches 1 have been sealed and ejected from the machine, the base web 2 retracts or shrinks back to reduce the internal volume of each compartment. The pressure so generated within each compartment of the pouch 1 causes the thinner top lidding web 3 to distend, typically to a greater degree than the shrinkage of the base web 2, thereby increasing the internal volume of each compartment of the pouch 1. This can result in the formation of a substantially symmetrical pouch 1 about the weld line 5. This reconfiguration of pouches 1 ejected from cavities 6 of a rotatable former 7 configured with a cylindrical surface is shown in Figure 18. The former may 7 may be circular as shown in Figure 18 although this is not essential and other configurations of former may be employed, for example a rotatable former configured with a flat horizontal surface.. Examples of cylindrical and horizontal formers that may be employed are shown and described in WO2011/061628 to which the reader is directed for further details.

**[0040]** Whilst the reduction in planar distortion provided by any single factor may not be sufficient to assure planar rigidity of the pouch, when all three factors are combined, there is an unexpected increase in planar rigidity which in turn provides a marketing advantage to the multi-compartment pouch of the present invention.

**[0041]** Referring now to Figures 19 and 20, examples of filling multi-compartment pouches 1 according to the present invention are illustrated although these examples are by no means limiting. The number of pouches 1 formed, filled and sealed across the web of a machine is known as the number of tracks or lanes.

**[0042]** In Figure 19, filling of pouches 1 with two compartments 1a,1b similar to the pouch shown in Figure 14 is illustrated. The rotatable former 7 of the pouch making machine may be configured as shown and described in WO2011/061628 with a cylindrical surface 7a or alternatively with a flat horizontal surface. The compartments 1a,1b may be filled by heads 8a,8b. The heads 8a,8b may be point fillers. The heads 8a,8b may be configured to add a liquid, gel, powder or granules, for example nozzle injectors for liquids or gels or augur fillers for powders or granules. Heads 8a,8b may be connected to a feed for the same or different materials. The heads 8a, 8b may be arranged with a space offset in the direction of movement of the surface 7a and fire simultaneously (option A) or with no space offset and fire at slightly different set points (option B). A similar arrangement may be provided for each track or lane across the web

of the machine. Heads in different tracks or lanes may be connected to the same or different supplies of material. This method is equally applicable where the multi-compartment pouch comprises more than two compartments. Generally, a filling head is provided for each compartment.

[0043] In Figure 20, filling of pouches 1 with three compartments 1a, 1b, 1c similar to the pouch shown in Figure 15 is illustrated. The rotatable former 7 of the pouch making machine may be configured as shown and described in WO2011/061628 with a cylindrical surface 7a or alternatively with a flat horizontal surface. The compartments 1a, 1b, 1c may be filled by heads 8a, 8b, 8c. The heads 8a, 8b, 8c may be point fillers. The heads 8a, 8b, 8c may be configured to add a liquid or gel or a powder or granules, for example nozzle injectors for liquids and gels or auger fillers for powders and granules. In this embodiment, the heads 8a, 8b are configured to add a liquid or gel and head 8c is configured to add a powder or granules. Heads 8a, 8b may be connected to a feed for the same or different liquids or gels. A similar arrangement may be provided for each track or lane across the web of the machine. Heads in different tracks or lanes may be connected to the same or different supplies of material. Other arrangements of heads 8a, 8b, 8c for delivering any combination of liquids, gels, powders and granules are envisaged. This method is equally applicable where the multi-compartment pouch comprises two or more compartments. Generally a filling head is provided for each compartment.

[0044] Referring now to Figure 21, methods of arranging the heads are illustrated. The heads may be arranged to create space for a plurality of heads within the confined space available. In one arrangement, the heads may be inclined to each other. For example, a head 8a for a liquid or gel and a head 8b for a powder or granules may be inclined to each other. In another arrangement, a head 8b for a powder or granules may be provided with a chute 9. The liquid or gel filling head 8a and chute 9 may be inclined to each other. The heads 8a, 8b may be arranged to follow the cavity 6 of the former 7 as it advances so that the time available for completion of the filling operation is thereby increased and the product being filled is spread more evenly along the compartment in the base web.

[0045] By use of the above filling arrangements and/or by the programming of the software integrating the filling operation with the running speed of the machine, it may be possible to fill the compartments of a multi-compartment pouch 1 during a time interval of up to one second. In this way, the machine may be capable of providing an output of approximately 60 pouches per minute for each track or lane of the machine. In the case of granular or powder solid products, the filling equipment is typically a multi-head auger filler and in the case of liquid products, the filling equipment is typically cylinder operated nozzle injectors with a cut off such that no drips arrive on the base web surrounding the cavities. Such contamination of the base web can subsequently inhibit good sealing of the base web with the top or lidding web. Hitherto, the filling operation has not allowed such filling speeds across so many tracks, preventing the compartments of a multi-compartment pouch from being filled within such a short time interval.

[0046] Embodiments of pouch forming machines are shown in Figures 22 to 26 wherein like reference numerals are used to indicate the same or similar parts such that the operation of the same or similar parts will be understood from a description of any embodiment without being repeated for other embodiments.

[0047] An embodiment of a pouch forming machine 20 is shown in Figure 22 comprising a horizontal rotatable former 21. The term horizontal rotatable former describes a machine wherein part of the former 21 comprises a horizontal surface or section 21a. The former 21 may comprise an endless belt (only part of the former is shown in Figure 22). The machine is configured to form multi-compartment pouches from two water soluble substrates by sequential forming and filling each compartment of the pouch. In this embodiment, the former is provided with pouch forming cavities 23 configured to form pouches with three compartments but it will be understood this is not limiting and the cavities 23 can be configured to form pouches having two or more compartments.

[0048] A base web 24 is unwound from an unwinding station 25 and a first open pocket or container 26 is formed in the base web at 27 and filled at 28. A second open pocket or container 29 is formed in the base web at 30 and filled at 31. A third open pocket or container 32 is formed in the base web at 33 and filled at 34. A lidding web 35 is unwound from an unwinding station 36 and affixed to the base web at 37 thereby sealing and closing all the open pockets or containers 26, 29, 32 in the base web to form multi-compartment pouches 38 within the cavities 23. The combined base web and lidding web is then moved to a cutting station 39 where the pouches 38 are separated from the combined web. In this embodiment, the top or lidding web 35 is affixed to the base web 24 by solvent welding by wetting the lidding web 35 at 40. Other methods of affixing the top or lidding web may be employed such as heat sealing.

[0049] It is important to note that many possible designs of multi-compartment pouches having at least two compartments may be produced employing the machine 20 by appropriate design of the pouch forming cavities. For example, the machine 20 may produce any of the pouches shown in Figures 1 to 17 although this is not limiting on the scope of the invention. Each compartment may be sequentially formed and filled with different compositions. Alternatively, where more than one compartment contains the same composition, these compartment may be formed and filled simultaneously with at least one other compartment being formed and filled sequentially.

[0050] Further embodiments of a pouch forming machine 20' are shown in Figures 23 and 24 comprising a combination of two rotatable formers wherein one rotatable former is a horizontal rotatable former 21 similar to Figure 22 and the other rotatable former is a cylindrical rotatable former 41. The term cylindrical rotatable former describes a machine

where the former 41 comprises a circular surface or section 41 a. The cylindrical former 41 is positioned above the horizontal section 21a of the horizontal former 21. The former 41 is provided with pouch forming cavities 42 and may comprise a drum.

**[0051]** In Figure 23, multi-compartment water pouches 38 comprising a water-soluble base web 24 and a water-soluble top or lidding web 35 are formed on the horizontal rotatable former 21 as described previously and water-soluble pouches 38' comprising a water soluble base web 24' and a water soluble top or lidding web 35' are formed on the cylindrical former 41. The pouches 38,38' are brought together in register and combined by joining the top or lidding webs 35,35' to each other at 44. The resulting combined pouch is formed from four water soluble webs or substrates. In this embodiment, the pouch 38' comprises a single compartment filled at 43. In other embodiments, the pouch 38' may comprise more than one compartment. The pouches 38,38' may comprise any of the pouches shown in Figures 1 to 17 although this is not limiting on the scope of the invention. In other embodiments, the pouch 38 may be a single compartment and the pouch 38' may be multi-compartment.

**[0052]** In Figure 24, the top or lidding web 35 is omitted and the open pouches or containers formed by the base web 24 on the former 21 are closed by the top or lidding web 35' of the pouches 38' on the former 41. The resulting pouch is formed from three water soluble webs or substrates

**[0053]** Further embodiments of a pouch forming machine 20" are shown in Figures 25 and 26 comprising a combination of two rotatable formers wherein both rotatable formers are horizontal rotatable formers 21,21" similar to Figure 22 with a horizontal lower section 21b" of the former 21" positioned above the horizontal upper section 21a of the former 21.

**[0054]** In Figure 25, multi-compartment pouches 38 comprising a water-soluble base web 24 and a water-soluble top or lidding web 35 are formed on the horizontal rotatable former 21 as described previously and water-soluble pouches 38" comprising a water soluble base web 24" and a water soluble top or lidding web 35" are formed on the horizontal former 21". The pouches 38,38" are brought together in register and combined by joining the top or lidding webs 35,35" to each other at 44. The resulting combined pouch is formed from four water soluble webs or substrates. An additional cutting station 39" may be provided in at least the transverse direction so that the closed pouches 38" produced on the upper horizontal former 21", despite the vacuum holding them within the cavities 23" of the former 21", are not dislodged as the former 21" passes over the roller at 45..

**[0055]** In this embodiment, the pouch 38" is a multi-compartment pouch formed in similar manner to the pouch 38. In other embodiments, the pouch 38" may comprise a single compartment or any other design with two or more compartments. The pouches 38,38" may comprise any of the pouches shown in Figures 1 to 17 although this is not limiting on the scope of the invention.

**[0056]** In Figure 26, the top or lidding web 35 is omitted and the open pouches or containers formed by the base web 24 on the former 21 are closed by the top or lidding web 35" of the pouches 38" on the former 21". The resulting pouch is formed from three water soluble webs or substrates

**[0057]** By way of non-limiting example, a multi-compartment water soluble pouch 60 with three compartments 60a,60b,60c is shown in Figure 27. The method of sequentially forming and filling the pouch 60 is illustrated in Figures 28 and 29.

**[0058]** Referring to Figures 28 and 29, a former 61 has a cavity 62 with three recessed areas 62a,62b,62c corresponding to the compartments 60a,60b,60c of the pouch 60. A base web 63 is formed into area 62a to form an open pocket or container for compartment 60a. Compartment 60a is then filled for example with a powder or granules by a belt feeder 64. The feeder 64 may have a scraper blade 66 to prevent overfilling of the compartment 60a. Next, the base web 63 is formed into area 62b to form an open pocket or container for compartment 60b. Compartment 60b is then filled for example with a powder or granules by a belt feeder 64. Finally the base web 63 is formed into area 62c to form an open pocket or container for compartment 60c. Compartment 60c is then filled for example with a liquid or gel by a nozzle feeder 65. The sequentially formed and filled compartments 60a,60b,60c can then be closed and sealed by a top or lidding web (not shown) by any of the methods and machines described previously.

**[0059]** By means of sequential forming and filling, it may be possible to form and fill open pockets or containers in a base web to form compartments which, in plan view, "overlap" each other in the direction of travel of the web. In this way, multi-compartment pouches containing overlapping compartments can be made employing the sequential forming and filling method described herein which could not be made by conventional methods employing contemporaneous forming of the compartments followed by filling due to filling constraints. The above method may be employed for any design of multi-compartment pouch.

**[0060]** Sequential forming of the base web 63 may be effected by different methods. One method involves applying a vacuum to each recessed area 62a,62b,62c of the cavity 62 in turn. Preferably the vacuum is maintained in each area in which the base web 63 is formed and filled until the pouch 60 is ejected from the former 61. Sequential forming and filling offers the advantage of greater space, longer filling times and therefore ease of filling for powders or granules which do not flow freely from the filling heads.

- The sequential vacuum supply to the cavities 62 may be provided in various ways. Generally mechanical methods



of vacuum control are preferred as being potentially more reliable than, for example, an electrical method that would require spinning electrical connections. Two methods of arranging the vacuum supply for sequential forming the base web 63 to form open pockets or containers corresponding to compartments 60a, 60b, 60c of the pouch 60 are described below with reference to Figures 30 and 31, although other methods will be envisaged by those skilled in the art.

**[0061]** In Figure 30, a vacuum shoe arrangement for sequential forming of base web 63 is employed comprising three vacuum slots 66a, 66b, 66c wherein each slot 66a, 66b, 66c controls the vacuum start and stop to each of the three recessed areas 62a, 62b, 62c respectively. The slots 66a, 66b, 66c are of different lengths and are configured so that stop point is the same for all recessed areas 62a, 62b, 62c in order to release the pouch from the cavity 62. The first slot 66a has the earliest start point, then the second slot 66b and lastly the third slot 66c. In this way the vacuum is applied first to the area 62a through vacuum slot 66a so that the base web 63 can be drawn into the area 62a only to form an open pocket or container corresponding to compartment 60a which can then be filled. Whilst the vacuum to the area 62a is maintained, the vacuum is next applied to the area 62b through vacuum slot 66b so that the base web 63 can be drawn into the second area 62b to form an open pocket or container corresponding to compartment 60b which can then be filled. Whilst the vacuum to the areas 62a, 62b is maintained, the vacuum is applied to the area 62c through slot 66c so that the base web 63 can be drawn into the area 62c to form an open pocket or container corresponding to compartment 60c which can then be filled... When all the pockets or containers have been formed and filled, a lidding web (not shown) can be affixed to the base web 63 around the open pockets or containers to close and seal the compartments to form the multi-compartment pouch 60. The pouch 60 can then be separated from the combined web, the vacuum supply to all three recessed areas released and the pouch ejected from the cavity 62 in the rotatable former either by falling under gravity or by ejection with compressed air or a combination of both on to a suitable conveyor system.

**[0062]** In Figure 31, a vacuum valve arrangement for sequential forming of base web 63 is employed comprising three vacuum valves 67a, 67b, 67c wherein each valve 67a, 67b, 67c controls the vacuum start and stop to each of the three recessed areas 62a, 62b, 62c respectively. Each valve 67a, 67b, 67c is mechanically controlled by an actuator 68a, 68b, 69c co-operable with a straight cam 69a, 69b, 69c arranged underneath the valve. The cams 69a, 69b, 69c are of different lengths and are configured so that the stop point is the same for all recessed areas 62a, 62b, 62c in order to release the pouch from the cavity 62. The first cam 69a is the longest, then the second cam 69b and the third cam 69c is the shortest. In this way vacuum valve 67a is actuated first to apply vacuum to the area 62a so that the base web 63 can be drawn into the area 62a only to form an open pocket or container corresponding to compartment 60a which can then be filled. Whilst the vacuum to the area 62a is maintained, the vacuum valve 67b is next actuated to apply vacuum to the area 62b so that the base web 63 can be drawn into the second area 62b to form an open pocket or container corresponding to compartment 60b which can then be filled. Whilst the vacuum to the areas 62a, 62b is maintained, the vacuum valve 67c is actuated to apply vacuum to the area 62c so that the base web 63 can be drawn into the area 62c to form an open pocket or container corresponding to compartment 60c which can then be filled... When all the pockets or containers have been formed and filled, a lidding web (not shown) can be affixed to the base web 63 around the open pockets or containers to close and seal the compartments to form the multi-compartment pouch 60. The pouch 60 can then be separated from the combined web, the vacuum supply to all three recessed areas released and the pouch ejected from the cavity 62 in the rotatable former either by falling under gravity or by ejection with compressed air or a combination of both on to a suitable conveyor system.

**[0063]** In arrangement of Figure 31, a simple vacuum shoe or some kind of a vacuum manifold for the initial vacuum connection to the valve block 70 is required. However, the cams 69a, 69b, 69c can be configured to be adjustable to alter the vacuum start and/or stop points to change the valve timing. For example the cams 69a, 69b, 69c may be made of two pieces (dove tailed, for example) which allows for length adjustment. Such adjustment may be effected remotely. This may allow easier adjustment of the valve timing compared to the arrangement of Figure 30 where the vacuum shoe has to be removed and either replaced by a vacuum shoe with different length slots or the slots cut to change the length and the shoe refitted.

**[0064]** A further advantage of the arrangement of Figure 31 is that there is only one vacuum line going to the valve block for the valves 67a, 67b, 67c for each of the recessed areas 62a, 62b, 62c. In the arrangement of Figure 30, individual lines from the vacuum shoe to each recessed area 62a, 62b, 62c are required.

**[0065]** In some embodiments the cavities 62 in the former may be heated by internal and/or external heaters to assist forming the base web 63 into the cavities. In some embodiments the base web 63 may pass over a heated roller prior to being drawn into the first recessed area 62a. In some embodiments, the base web 63 may be heated prior to be drawn into the second and/or third recessed areas to maintain flexibility of the web and assist forming into the recessed areas. Such heating may be effected from above for example by means of externally mounted hot air jets or externally mounted infra-red heaters.

**[0066]** Figure 32 illustrates an example, which is by no means limiting, of a two compartment pouch 70 that can be produced on a machine similar to Figure 22 wherein a first open pocket or container 71 is formed in a base web and in

this example filled using a belt feeder 72 or similar type area filler and only once the first container 71 has been filled, is a second open pocket or container 73 sequentially formed in the base web and in this example, filled using a point feeder 74. The feeders 72,74 may be replaced by any other feeders to suit the product added to the containers 71,73.

**[0067]** Figure 33 illustrates an example, which is by no means limiting, of a three compartment pouch 80 that can be produced on a machine similar to Figure 22 wherein a first open pocket or container 81 is formed in a base web and in this example filled using a belt feeder 82 or similar type area filler and only once the first container 81 has been filled is a second open pocket or container 83 sequentially formed in the base web and in this example filled using a belt feeder 84 or similar type area filler and only once the second container 83 has been filled, is a third container 85 sequentially formed in the base web and in this example filled using a point feeder 86. The feeders 82,84,86 may be replaced by any other feeders to suit the product added to the containers 81,83,85. In a modification, containers 81 and 83 may be formed and filled simultaneously and container 85 formed and filled sequentially.

**[0068]** Figure 34 illustrates an example, which is by no means limiting, of a four compartment pouch 90 that can be produced on a machine similar to Figure 22 wherein a first container 91 is formed in a base web and in this example filled using a belt feeder 92 or similar type area filler and only once the first container 91 has been filled, is a second container 93 sequentially formed in the base web and in this example filled using a belt feeder 94 or similar type area filler and only once the second container 93 has been filled are a third container 95 and a fourth container 96 formed simultaneously in the base web and in this example, filled simultaneously using point feeders 97 and 98 respectively. The feeders 92,94,97,98 may be replaced by any other feeders to suit the product added to the containers 91,93,95,96. In other arrangements, containers 91, 93, 95 and 96 may each be formed and filled sequentially. In other arrangements, containers 91 and 93 may be formed and filled simultaneously and containers 95 and 96 may be formed and filled sequentially. Other combinations of simultaneous and sequential forming and filling of the containers will be apparent to those skilled in the art.

**[0069]** Figure 35 illustrates examples, which are by no means limiting, of pouch designs which may be produced by means of the present invention.

**[0070]** Figure 35(i) illustrates a two compartment pouch 100 where typically, although the nature of each composition as described hereafter is by no means limiting, open pocket or container 101 is formed first in a base web and filled with a powder or granular composition by means of a belt feeder or similar type area feeder, and container 102 is formed second and filled with a liquid or gel composition filled by means of a point feeder. The pouch 100 is then closed by means of a lidding web.

**[0071]** Figures 35(ii), 35(v), and 35(ix) illustrate different three compartment pouches 110 where typically, although the nature of each composition as described hereafter is by no means limiting, an open pocket or container 111 is formed first in a base web and filled with a powder or granular composition by means of a belt feeder or similar type area feeder, open pocket or container 112 is formed second and filled with a powder or granular composition by means of a belt feeder or similar type area feeder, and container 113 is formed third and filled with a liquid or gel composition filled by means of a point feeder. The pouch 110 is then closed by means of a lidding web.

**[0072]** Figures 35(iii), 35(iv), 35(vi) and 35(vii) illustrate different four compartment pouches 120 where typically, although the nature of each composition as hereafter described is by no means limiting, an open pocket or container 121 is formed first in a base web and filled with a powder or granular composition by means of a belt feeder or similar type area feeder, container 122 is formed second and filled with a powder or granular composition by means of a belt feeder or similar type area feeder, containers 123 and 124 are formed and filled either sequentially or contemporaneously with the same or different liquid or gel composition(s) filled by means of point feeders. The pouch 120 is then closed by means of a lidding web.

**[0073]** Figure 35(viii) illustrates a six compartment pouch 130 where typically, although the nature of each composition as hereafter described is by no means limiting, container 131 is formed first in a base web and filled with a powder or granular composition by means of a belt feeder or similar type area feeder, container 132 is formed second and filled with a powder or granular composition by means of a belt feeder or similar type area feeder, and containers 133, 134, 135, and 136 are formed and filled either sequentially or contemporaneously and filled with the same or different liquid or gel composition(s) by means of point feeders. The pouch is then closed by means of a lidding web.

**[0074]** For the two compartment pouch illustrated in Figure 35(i), the method of fill may be as follows:

1. Vacuum is applied to form container 101 in the base web
2. Container 101 is filled by a belt feeder or similar type area filler
5. Whilst maintaining the vacuum to form container 101, vacuum is applied to form container 102
6. Container 102 is filled with a point type filler, i.e auger or liquid nozzle.

**[0075]** For the remaining pouches illustrated in Figure 35 the method of fill may be the same wherein:

1. Vacuum is applied to form container 111,121,131 only in the base web
2. Container 111,121,131 is filled by a belt feeder or similar type area filler
3. Whilst maintaining the vacuum to form container 111,121,131, vacuum is applied to form container 112,122,132 in the base web
4. Container 112,122,132 is filled by similar means as container 111,121,131
5. Whilst maintaining the vacuum to form containers 111,112,121,122,131,12, vacuum is applied to form containers 113,123,133 and above (134, 135, 136) in the base web
6. Containers 113,123,133 and above (134,135,136) are filled with a point type filler, i.e auger, or liquid nozzle.

**[0076]** The construction and arrangement of the elements as shown in the exemplary embodiments are illustrative only. Although only a few embodiments of the present disclosure have been described in detail, those skilled in the art who review this disclosure will readily appreciate that many modifications are possible (e.g., variations in sizes, dimensions, structures, shapes and proportions of the various elements, values of parameters, mounting arrangements, use of materials, colors, orientations, etc.) without materially departing from the novel teachings and advantages of the subject matter recited. The elements and assemblies may be constructed from any of a wide variety of materials that provide sufficient strength or durability, in any of a wide variety of colors, textures, and combinations. Additionally, in the subject description, the word "exemplary" is used to mean serving as an example, instance, or illustration. Any embodiment or design described herein as "exemplary" is not necessarily to be construed as preferred or advantageous over other embodiments or designs. Rather, use of the word "exemplary" is intended to present concepts in a concrete manner. Accordingly, all such modifications are intended to be included within the scope of the present disclosure. Other substitutions, modifications, changes, and omissions may be made in the design, operating conditions, and arrangement of the preferred and other exemplary embodiments without departing from the scope of the appended claims.

**[0077]** For purposes of this disclosure, references to the orientation of the elements in this description are merely used to identify the various elements as they are oriented in the FIGURES. These terms are not meant to limit the element which they describe, as the various elements may be oriented differently in various applications. Further, the order or sequence of any process or method steps may be varied or re-sequenced according to alternative embodiments. Any means-plus-function clause is intended to cover the structures described herein as performing the recited function and not only structural equivalents but also equivalent structures. Other substitutions, modifications, changes and omissions may be made in the design, operating configuration, and arrangement of the preferred and other exemplary embodiments without departing from the scope of the appended claims. For example, the methods and apparatus described herein may be adapted to produce multi-compartment pouches wherein all compartments of the pouch are filled with a composition or wherein at least one compartment is filled and at least one compartment is empty (i.e. not filled). All combinations of filled and empty compartments may be produced by the method and apparatus described herein. Multi-compartment pouches may have the compartments formed simultaneously or sequentially or a combination of simultaneous and sequentially formed compartments may be produced by the method and apparatus described herein.

## Claims

1. A multi-compartment pouch (1) formed from two water soluble substrates (2,3) wherein the pouch is substantially symmetrical about a weld line (4) between the two substrates, wherein one of the water soluble substrates is a top or lidding web (3) and the other water soluble substrate is a base web (2) and the top or lidding web is thinner than the base web, and wherein the top lidding web has a thickness of between 30% and 90% of that of the base web and wherein each compartment (1a;1b;1c;1d) is filled to at least 80% of the available volume.
2. The pouch of claim 1 wherein the pouch comprises at least two compartments and wherein each compartment is formed between the same two substrates.
3. The pouch of claim 2 wherein the compartments contain different products.
4. The pouch of any preceding claim wherein the pouch comprises three or more compartments.

5. The pouch according to any of claims 2 to 4 wherein the compartments are disposed within the pouch such that they provide resistance to planar distortion and/or such that any bending axis arbitrarily laid across the pouch cuts through the body of at least one compartment.
- 5 6. The pouch according to any preceding claim containing a perimetric compartment and/or a divided perimetric compartment.
7. The pouch according to any preceding claim wherein at least one compartment is filled with a flowable composition or a solid composition or more than one composition wherein the compositions are mutually compatible and not antagonistic to each other.
- 10 8. The pouch of any preceding claim wherein the top lidding web has a thickness of between 50% and 75% of that of the base web.
- 15 9. The pouch of any preceding claim wherein each compartment is filled to at least 90% of the available volume.
10. The pouch of any preceding claim wherein the pouch is sealed to a second closed multi-compartment pouch or to a second open multi-compartment pouch to form a combined pouch.
- 20 11. A method of making a multi-compartment pouch from two water soluble substrates consisting of a base web (3) and a top lidding web (2), the method including providing a former (21;41 ;61) having a plurality of multi-compartment pouch forming cavities (23 ;42 ;62) in a peripheral surface of the former, drawing the base web into the cavities to form a plurality of pockets within each pouch, filling one or more pockets with at least one product, closing the pockets in the base web with the top lidding web to form a plurality of sealed multi-compartment pouches (20 ;38 ;60),  
25 and separating the sealed multi-compartment pouches from the combined base web and top lidding web, wherein the top lidding web is thinner than the base web so that, as the base web retracts or shrinks back after the pouch has left the former, the pressure so generated within the pouch causes the top lidding web to distend to a greater extent than the contraction of the base web thereby increasing the internal volume of the pouch sufficiently to form a multi-compartment pouch substantially symmetrical about the weld line between the two substrates.
- 30 12. The method of claim 11 wherein each pocket of the multi-compartment pouch is filled with at least one product.
13. The method claim 11 or claim 12 wherein the former is configured so that at least one open pocket of a pouch is formed and filled before at least one other open pocket of the pouch is formed and filled, and only once all open  
35 pockets have been filled is the pouch closed by sealing with a lidding web.
14. The method of any of claims 11 to 13 wherein a second pouch is affixed to the multi-compartment water-soluble pouch to form a combined pouch.

#### Patentansprüche

1. Ein Mehrkammer-Beutel (1), der aus zwei wasserlöslichen Substraten (2,3) geformt ist, wobei der Beutel im Wesentlichen symmetrisch zu einer Liniennaht (4) zwischen den beiden Substraten ist, wobei eines der wasserlöslichen  
45 Substrate ein Top oder Lidding Web (3) und das andere wasserlösliche Substrat ein Base Web (2) darstellt und das Top oder Lidding Web dünner ist als das Base Web, und wobei das Top Lidding Web eine Dicke von 30% bis 90% der Dicke des Base Web hat und wobei jede Kammer (1a;1b;1c;1d) mit mindestens 80% des verfügbaren Volumens gefüllt ist.
- 50 2. Der Beutel gemäß Anspruch 1, wobei der Beutel mindestens zwei Kammern aufweist und wobei jede Kammer zwischen denselben beiden Substraten geformt ist.
3. Der Beutel gemäß Anspruch 2, wobei die Kammern verschiedene Produkte enthalten.
- 55 4. Der Beutel eines der vorhergehenden Ansprüche, wobei der Beutel drei oder mehr Kammern aufweist.
5. Der Beutel gemäß eines der Ansprüche 2 bis 4, wobei die Kammern so im Beutel angeordnet sind, dass sie einen Widerstand gegen flächige Ausbeulung bieten und/oder so dass jede Biegeachse, die beliebig über den Beutel

gelegt wurde, durch den Hauptteil mindestens einer Kammer schneidet.

6. Der Beutel gemäß eines der vorhergehenden Ansprüche, der eine perimetrische Kammer und/oder eine geteilte perimetrische Kammer aufweist.
7. Der Beutel gemäß eines der vorhergehenden Ansprüche, wobei mindestens eine Kammer mit einer fließfähigen Zusammensetzung oder einer festen Zusammensetzung oder mehr als einer Zusammensetzung gefüllt ist, wobei die Zusammensetzungen kompatibel zueinander und nicht entgegenwirkend zueinander sind.
8. Der Beutel gemäß eines der vorhergehenden Ansprüche, wobei das Top Lidding Web eine Dicke zwischen 50% und 75% der Dicke des Base Web hat.
9. Der Beutel gemäß eines der vorhergehenden Ansprüche, wobei jede Kammer zu mindestens 90% des verfügbaren Volumens gefüllt ist.
10. Der Beutel gemäß eines der vorhergehenden Ansprüche, wobei der Beutel gegenüber einem zweiten geschlossenen Mehrkammer-Beutel oder gegenüber einem zweiten offenen Mehrkammer-Beutel versiegelt ist, um einen kombinierten Beutel zu bilden.
11. Ein Verfahren für die Herstellung eines Mehrkammer-Beutels aus zwei wasserlöslichen Substraten, die aus einem Base Web (3) und einem Top Lidding Web (2) bestehen, das Verfahren schließt dabei die Bereitstellung eines Formers (21; 41; 61) ein, mit einer Vielzahl von Mehrkammer-Beutel formenden Vertiefungen (23; 42; 62) auf einer peripheren Fläche des Formers, das Hineinziehen des Base Web in die Vertiefungen, um eine Vielzahl von Taschen in jedem Beutel zu bilden, das Füllen einer oder mehrerer Taschen mit mindestens einem Produkt, das Schließen der Taschen im Base Web mit dem Top Lidding Web, um eine Vielzahl von versiegelten Mehrkammer-Beuteln (20; 38; 60) zu bilden, und die Trennung der versiegelten Mehrkammer-Beutel vom kombinierten Base Web und Top Lidding Web, wobei das Top Lidding Web dünner ist als das Base Web, so dass, wenn sich das Base Web zusammenzieht oder schrumpft, sobald der Beutel den Former verlassen hat, der dadurch im Beutel erzeugte Druck dazu führt, das Top Lidding Web in größeren Maße aufzublähen als sich das Base Web zusammenzieht, wodurch sich das Innenvolumen des Beutel ausreichend erhöht, um einen Mehrkammer-Beutel zu bilden, der im Wesentlichen symmetrisch zur Liniennaht zwischen den beiden Substraten ist.
12. Das Verfahren gemäß Anspruch 11, wobei jede Tasche des Mehrkammer-Beutels mit mindestens einem Produkt gefüllt ist.
13. Das Verfahren gemäß Anspruch 11 oder Anspruch 12, wobei der Former so gestaltet ist, dass mindestens eine offene Tasche eines Beutels geformt und gefüllt wird bevor mindestens eine andere offene Tasche des Beutels geformt und gefüllt wird, und erst wenn alle offenen Taschen gefüllt sind, der Beutel durch Versiegelung mit einem Lidding Web geschlossen wird.
14. Das Verfahren gemäß eines der Ansprüche 11 bis 13, wobei ein zweiter Beutel an dem wasserlöslichen Mehrkammer-Beutel befestigt wird, um einen kombinierten Beutel zu bilden.

## Revendications

1. Une poche à multicompartiments formée à partir de deux substrats solubles dans l'eau (2,3) dans laquelle la poche est pratiquement symétrique par rapport à une ligne de soudure (4) entre les deux substrats, dans laquelle l'un des substrats solubles dans l'eau est une bande supérieure ou d'operculage (3) et l'autre substrat soluble dans l'eau est une bande de base (2) et la bande supérieure ou d'operculage est plus fine que la bande de base et dans laquelle la bande d'operculage supérieure présente une épaisseur variant entre 30 % et 90 % de celle de la bande de base et dans lequel chaque compartiment (1 a ; 1 b ; 1 c ; 1 d) est rempli à au moins 80 % du volume disponible.
2. La poche selon la revendication 1, dans laquelle la poche comprend au moins deux compartiments et dans laquelle chaque compartiment est formé entre les deux mêmes substrats.
3. La poche selon la revendication 2, dans laquelle les compartiments contiennent des produits différents.

4. La poche selon l'une quelconque des revendications précédentes, dans laquelle la poche comprend trois ou plusieurs compartiments.
5. La poche selon l'une quelconque des revendications 2 à 4, dans laquelle les compartiments sont disposés à l'intérieur de la poche de sorte qu'ils offrent une résistance à la déformation planaire et/ou de sorte que tout axe de cintrage arbitrairement placé sur toute l'étendue de la poche traverse le corps d'au moins un compartiment.
6. La poche selon l'une quelconque des revendications précédentes contenant un compartiment périmétrique et/ou un compartiment périmétrique divisé.
7. La poche selon l'une quelconque des revendications précédentes, dans laquelle au moins un compartiment est rempli d'une composition liquide ou d'une composition solide ou de plus d'une composition dans laquelle les compositions sont mutuellement compatibles et non antagonistes entre elles.
8. La poche selon l'une quelconque des revendications précédentes, dans laquelle la bande supérieure d'operculage présente une épaisseur entre 50 % et 75 % de celle de la bande de base.
9. La poche selon l'une quelconque des revendications précédentes, dans laquelle chaque compartiment est rempli à au moins 90 % du volume disponible.
10. La poche de l'une quelconque des revendications précédentes, dans laquelle la poche est scellée à une seconde poche à multicompartiments fermés ou à une seconde poche à multicompartiments ouverts pour former une poche combinée.
11. Un procédé de fabrication d'une poche à multicompartiments à partir de deux substrats solubles dans l'eau consistant en une bande de base (3) et une bande supérieure d'operculage (2), le procédé comprenant la fourniture d'une ancienne poche (21 ; 41 ; 61) présentant une pluralité de poches à multicompartiments formant des cavités (23 ; 42 ; 62) dans une surface périphérique de l'ancienne poche, en traçant la bande de base dans les cavités pour former une pluralité de poches à l'intérieur de chaque poche, remplissant une ou plusieurs poches avec au moins un produit, fermant la poche dans la bande de base avec la bande supérieure d'operculage pour former une pluralité de poches à multicompartiments étanches (20 ; 38 ; 60) et séparant les poches à multicompartiments étanches à partir de la bande de base et de la bande supérieure d'operculage combinées, dans lequel la bande supérieure d'operculage est plus fine que la bande de base de manière à ce que, comme la bande de base se rétracte ou se rétrécit à nouveau après que la poche a quitté l'ancienne poche, la pression ainsi produite à l'intérieur de la poche amène la bande supérieure d'operculage à se dilater dans une plus grande mesure que la contraction de la bande de base augmentant ainsi le volume interne de la poche suffisamment pour former une poche à multicompartiments pratiquement symétrique autour de la ligne de soudure entre les deux substrats.
12. Le procédé selon la revendication 11, dans lequel chaque poche de la poche à compartiments multiples est remplie avec au moins un produit.
13. Le procédé selon la revendication 11 ou la revendication 12, dans lequel l'ancienne poche est conçue de manière à ce qu'au moins une poche ouverte d'une poche soit formée et remplie avant qu'au moins une autre poche ouverte de la poche soit formée et remplie et seulement une fois que toutes les poches ouvertes ont été remplies, la poche est fermée par scellement avec une bande d'operculage.
14. Le procédé selon l'une quelconque des revendications 11 à 13, dans lequel une seconde poche est apposée sur la poche à multicompartiments soluble dans l'eau pour former une poche combinée.

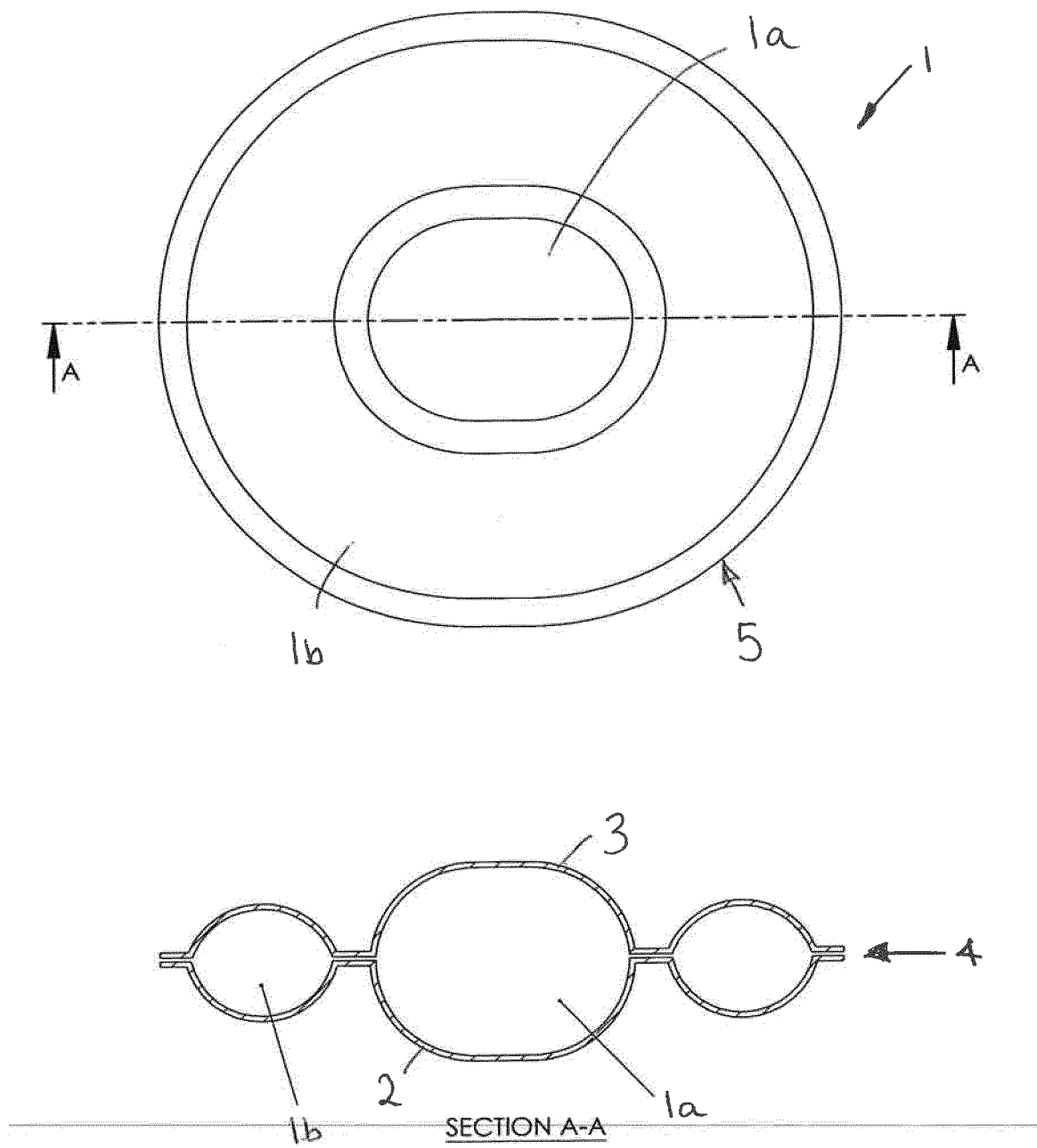


Figure 1

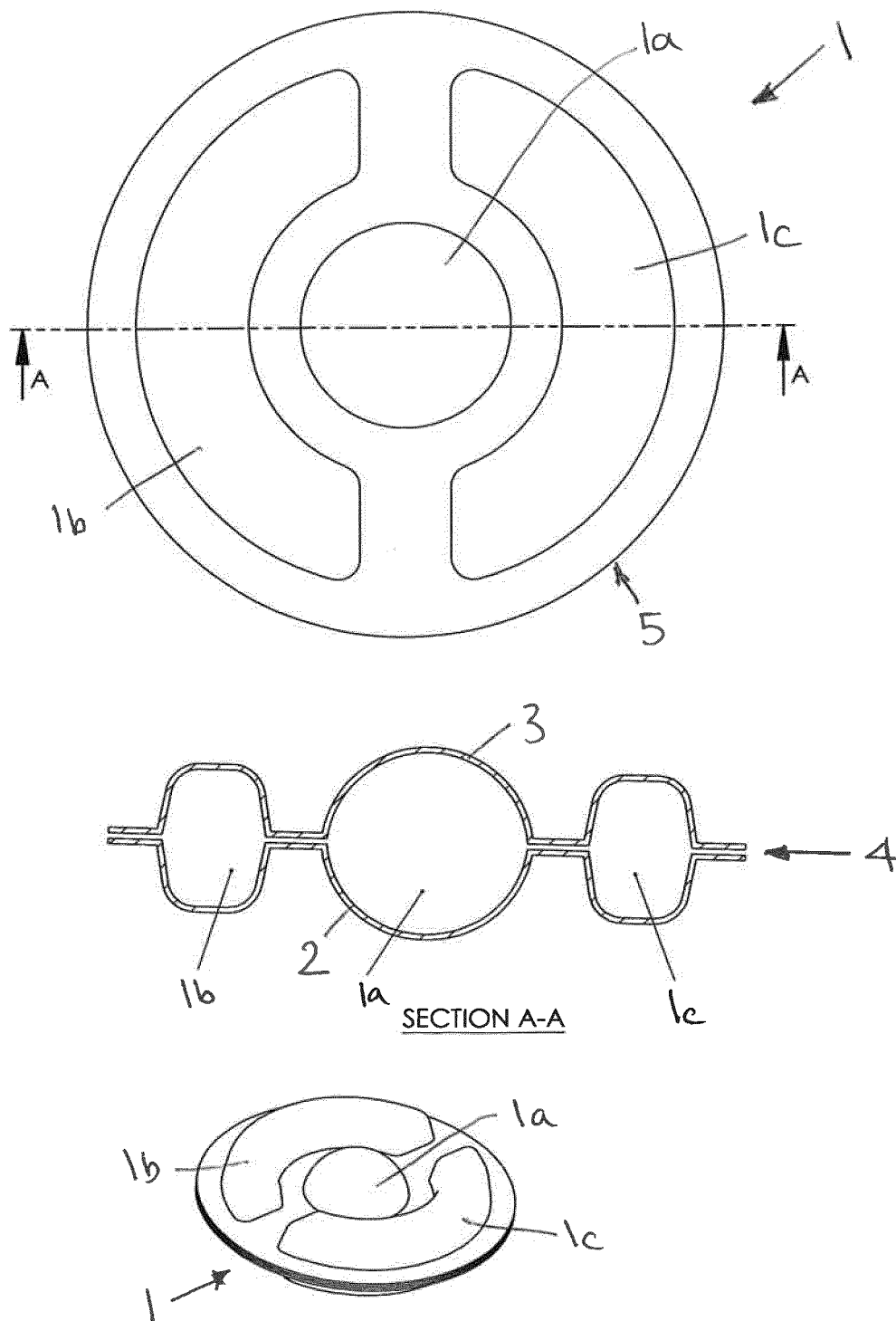


Figure 2



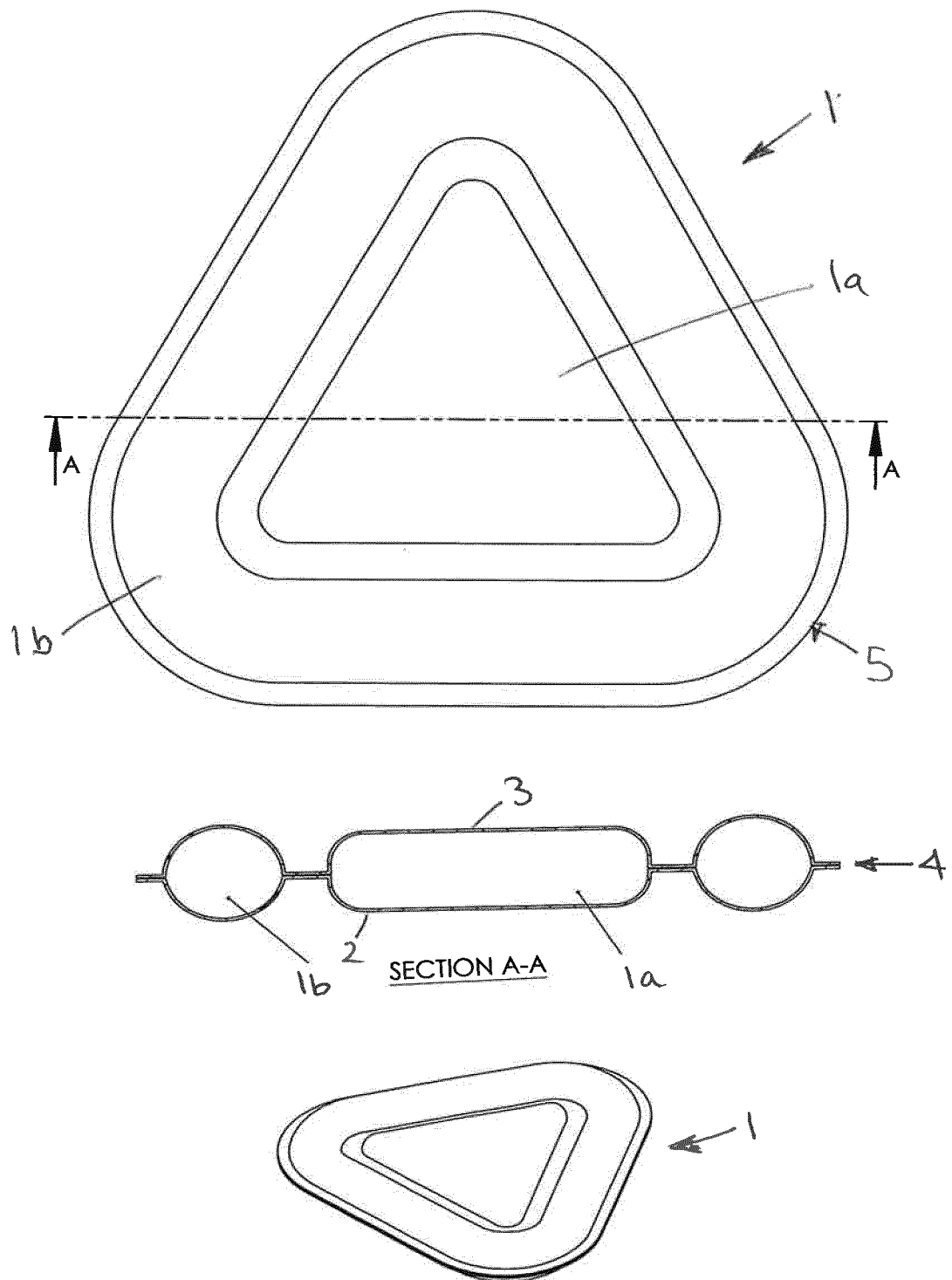


Figure 3

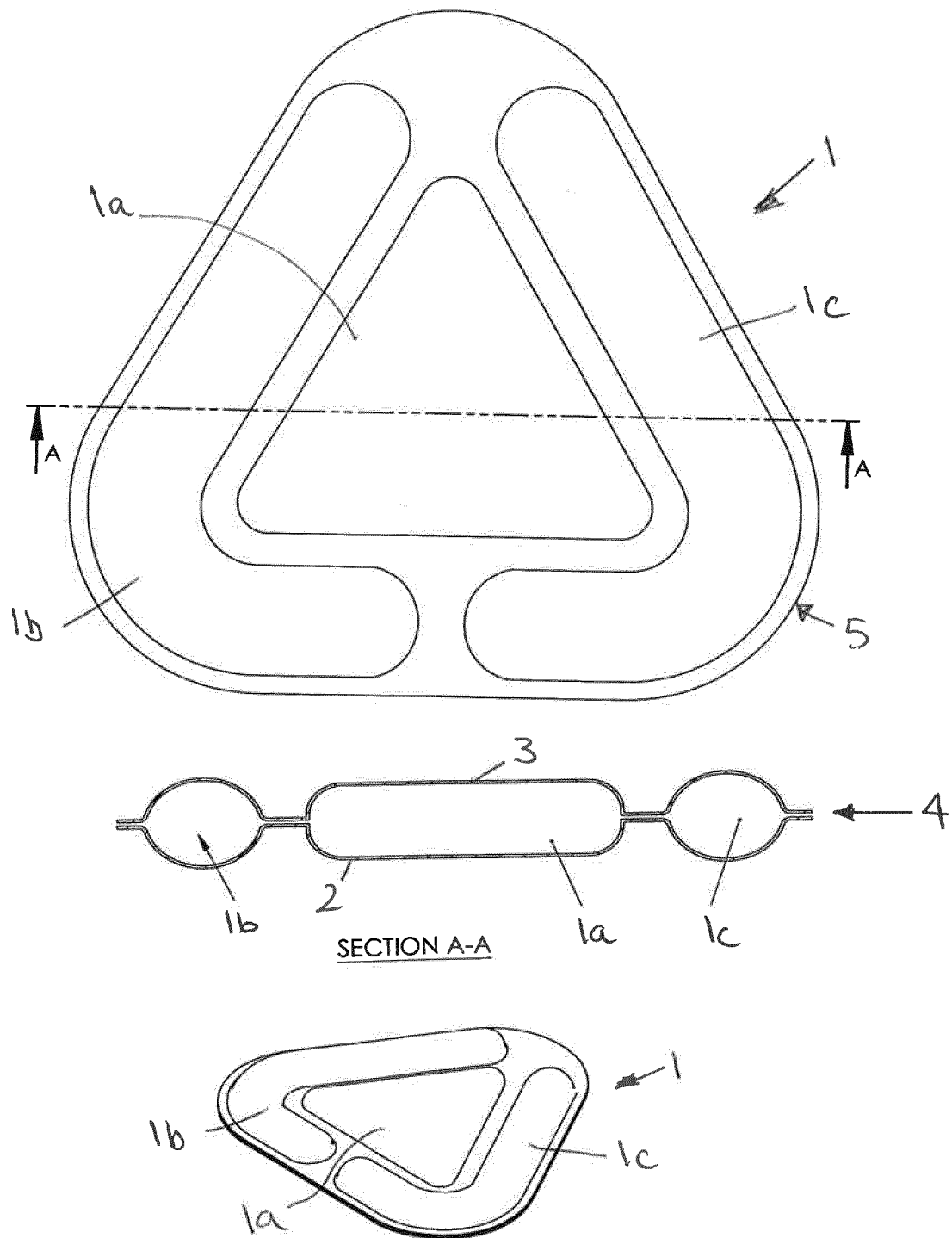


Figure 4

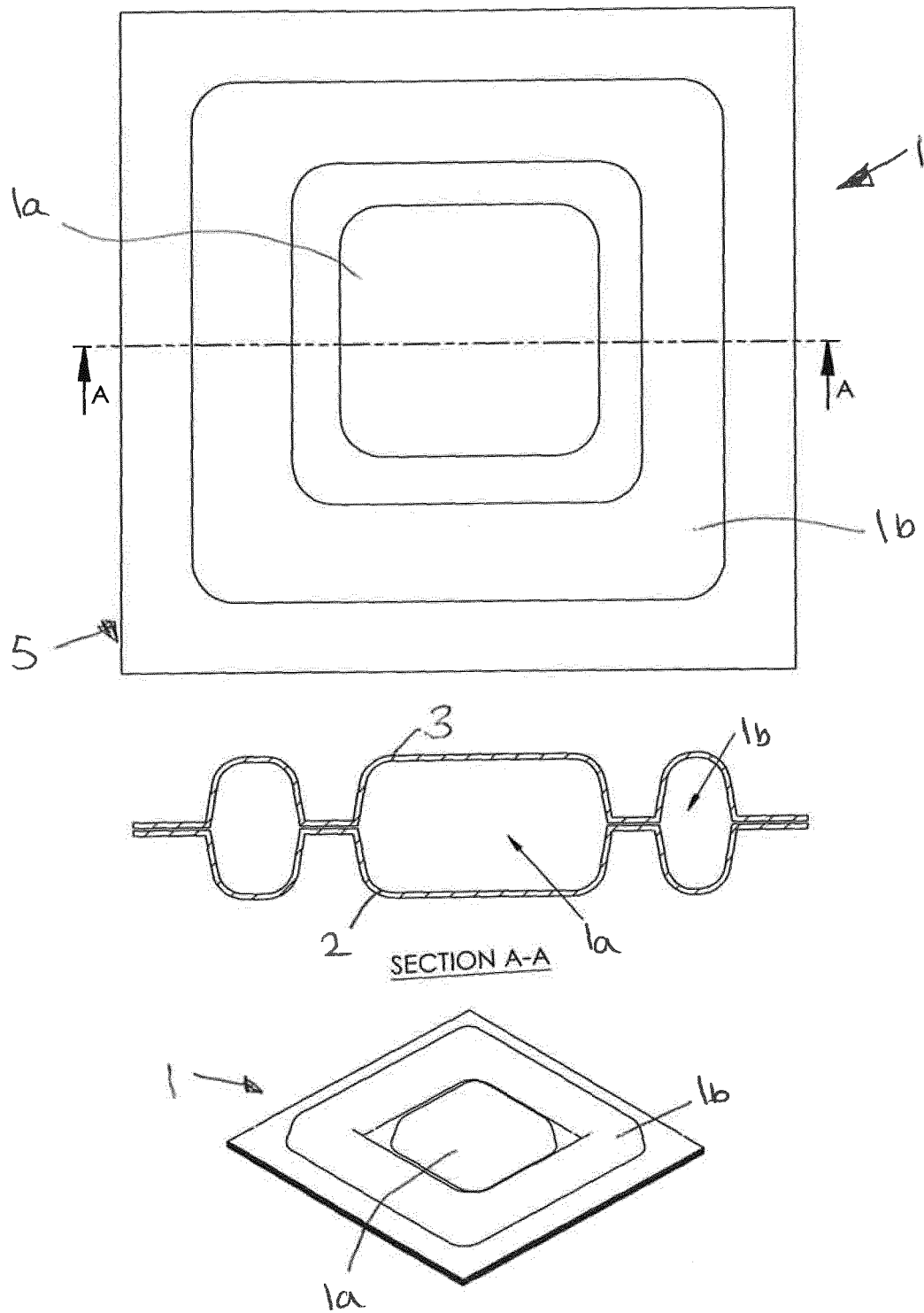
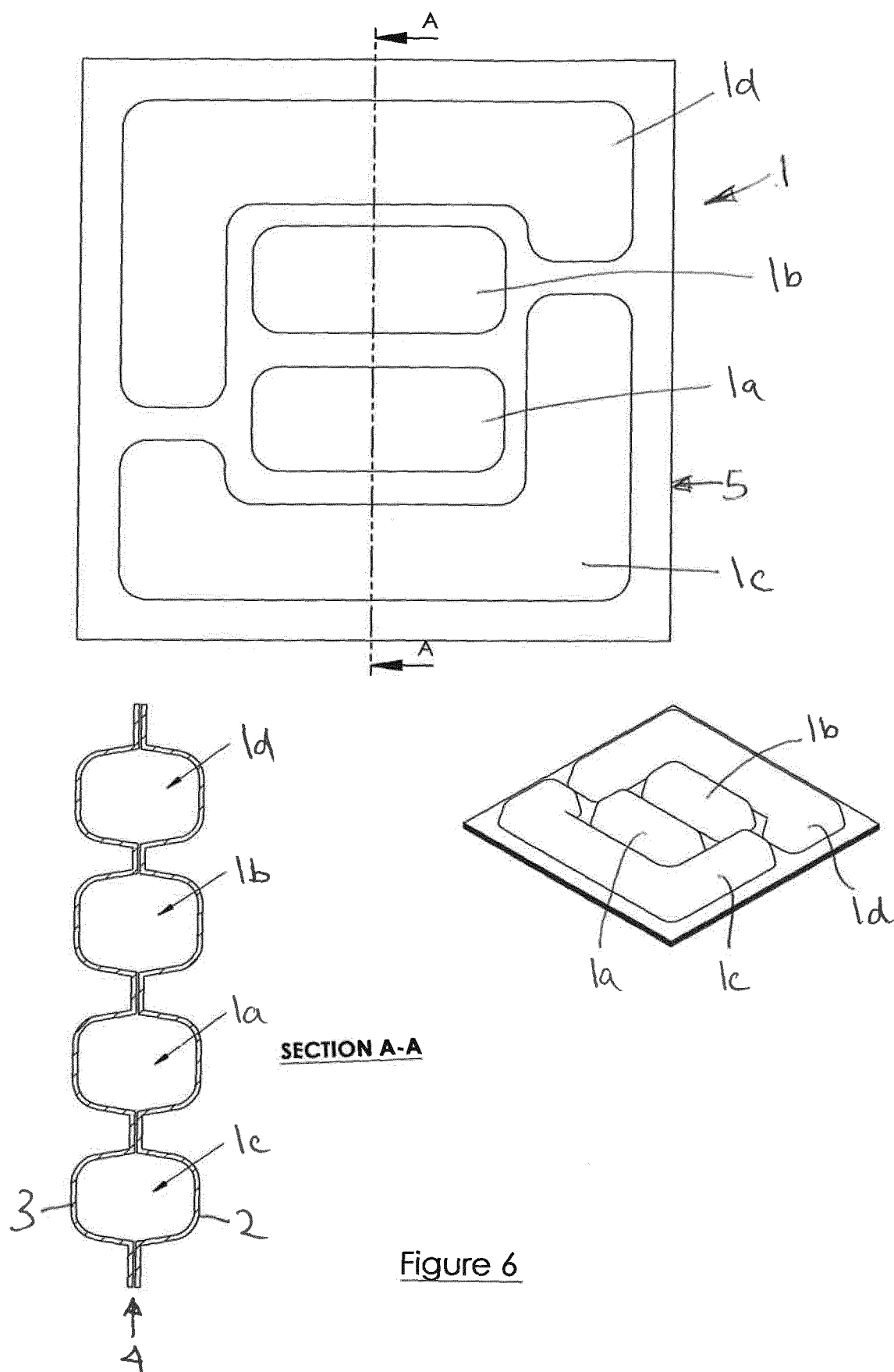


Figure 5



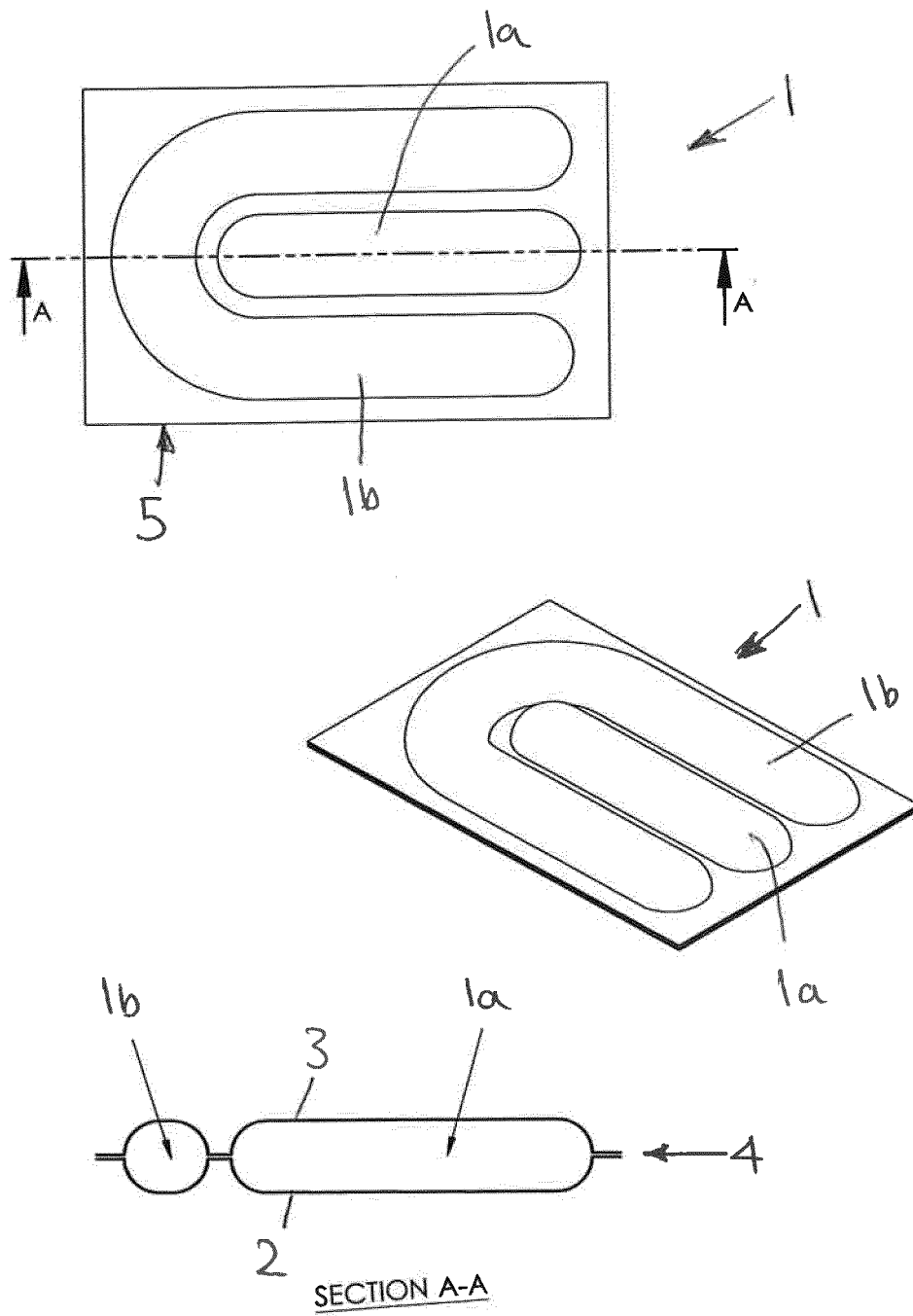


Figure 7

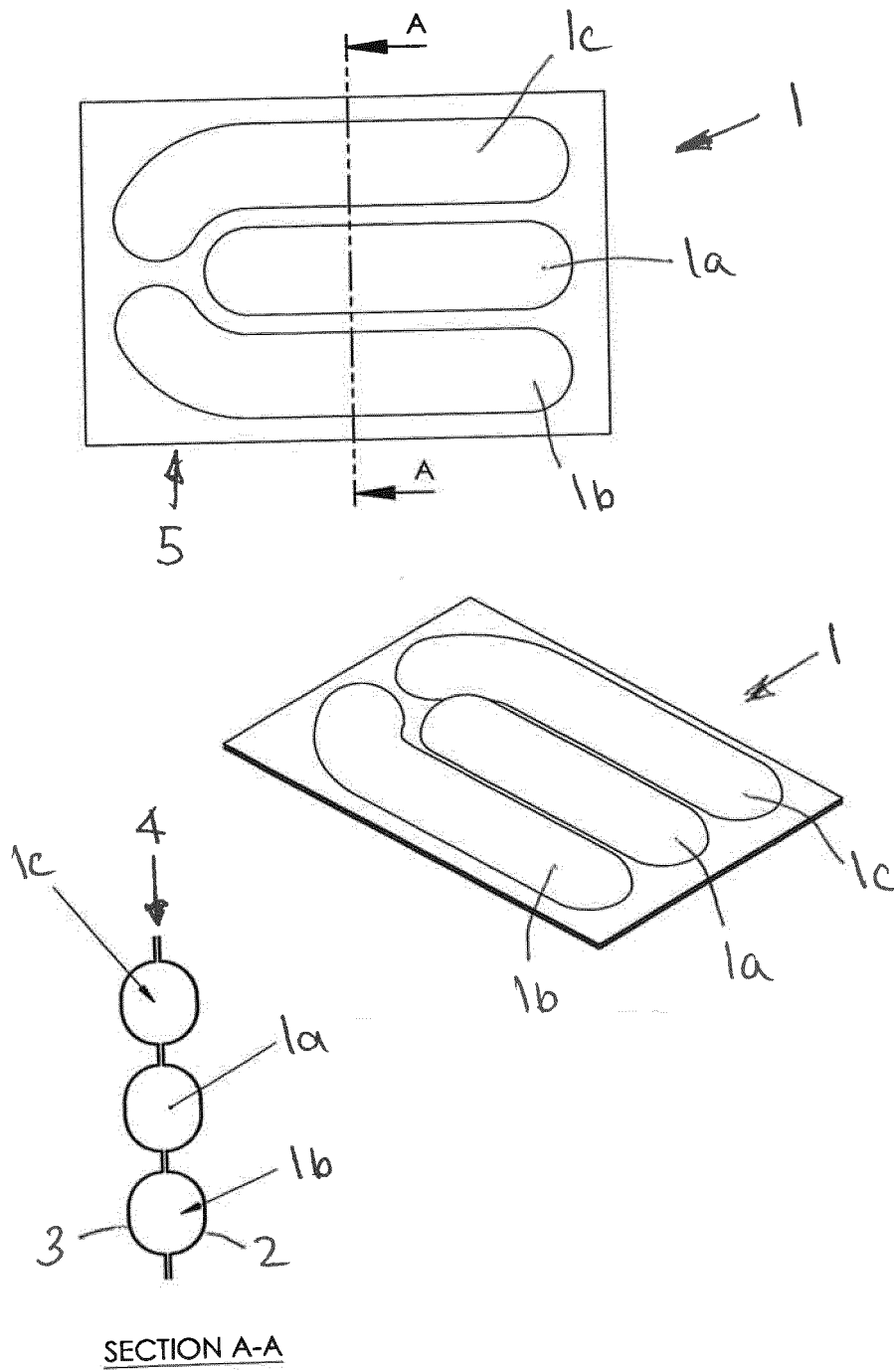


Figure 8

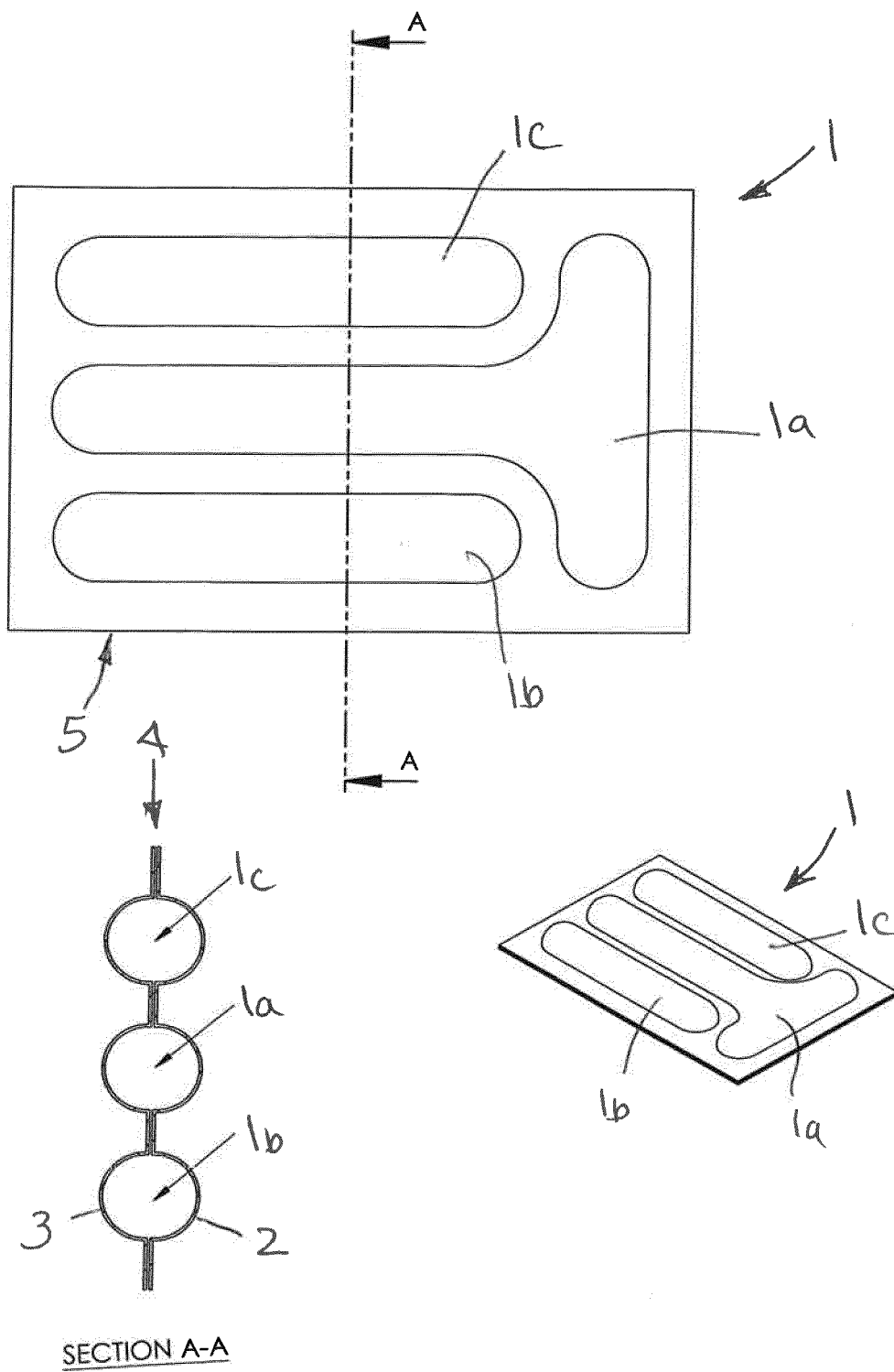


Figure 9

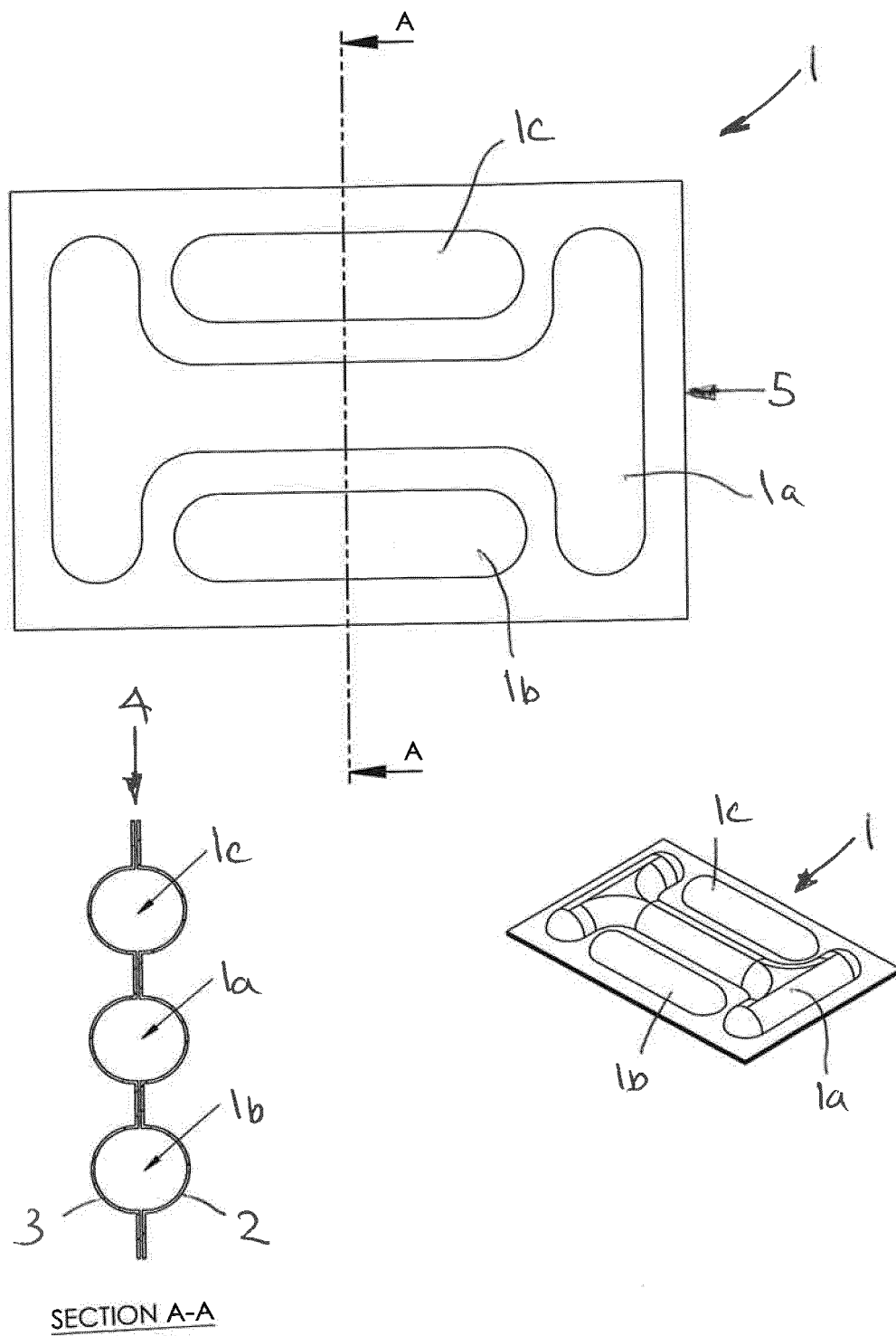


Figure 10



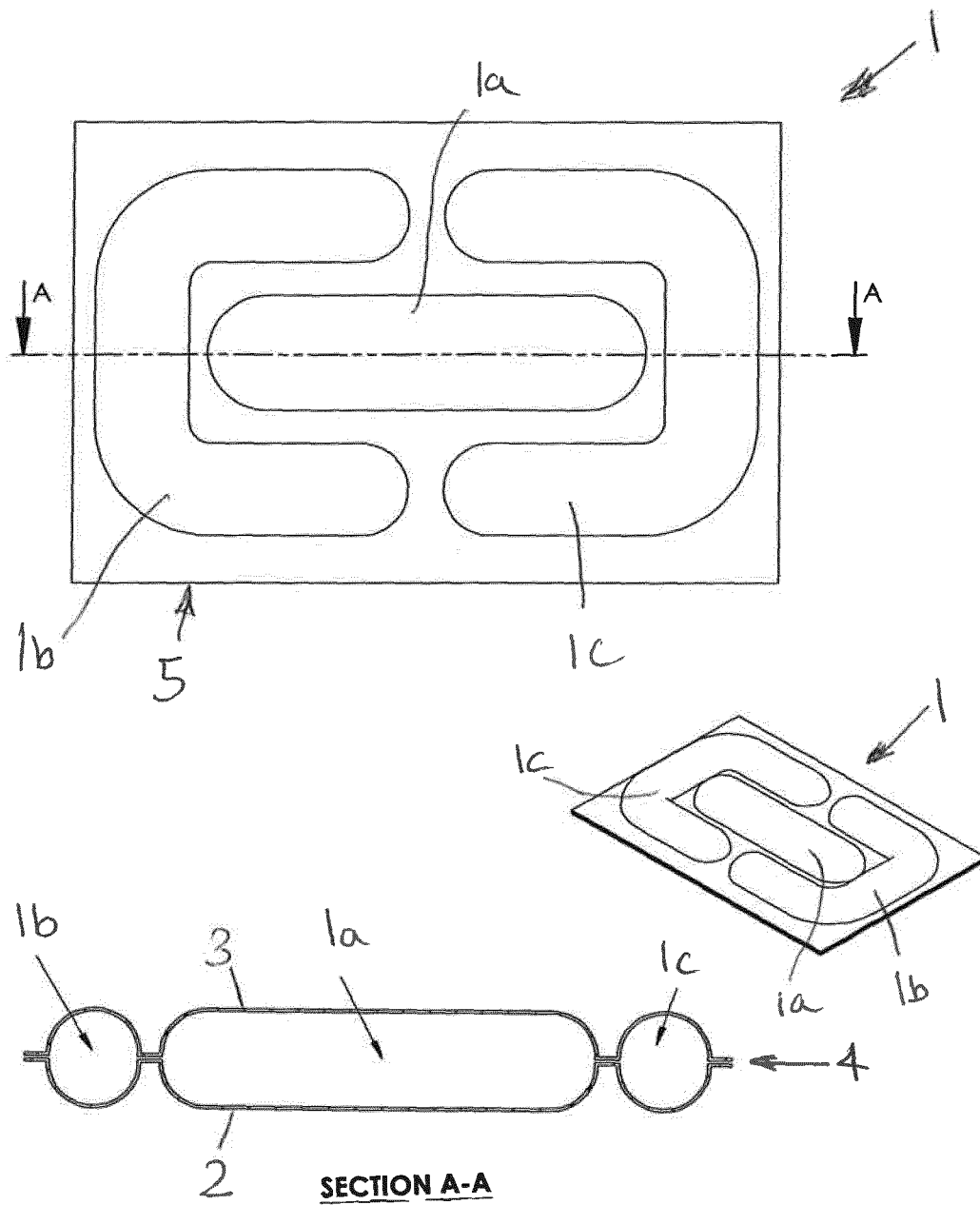


Figure 11

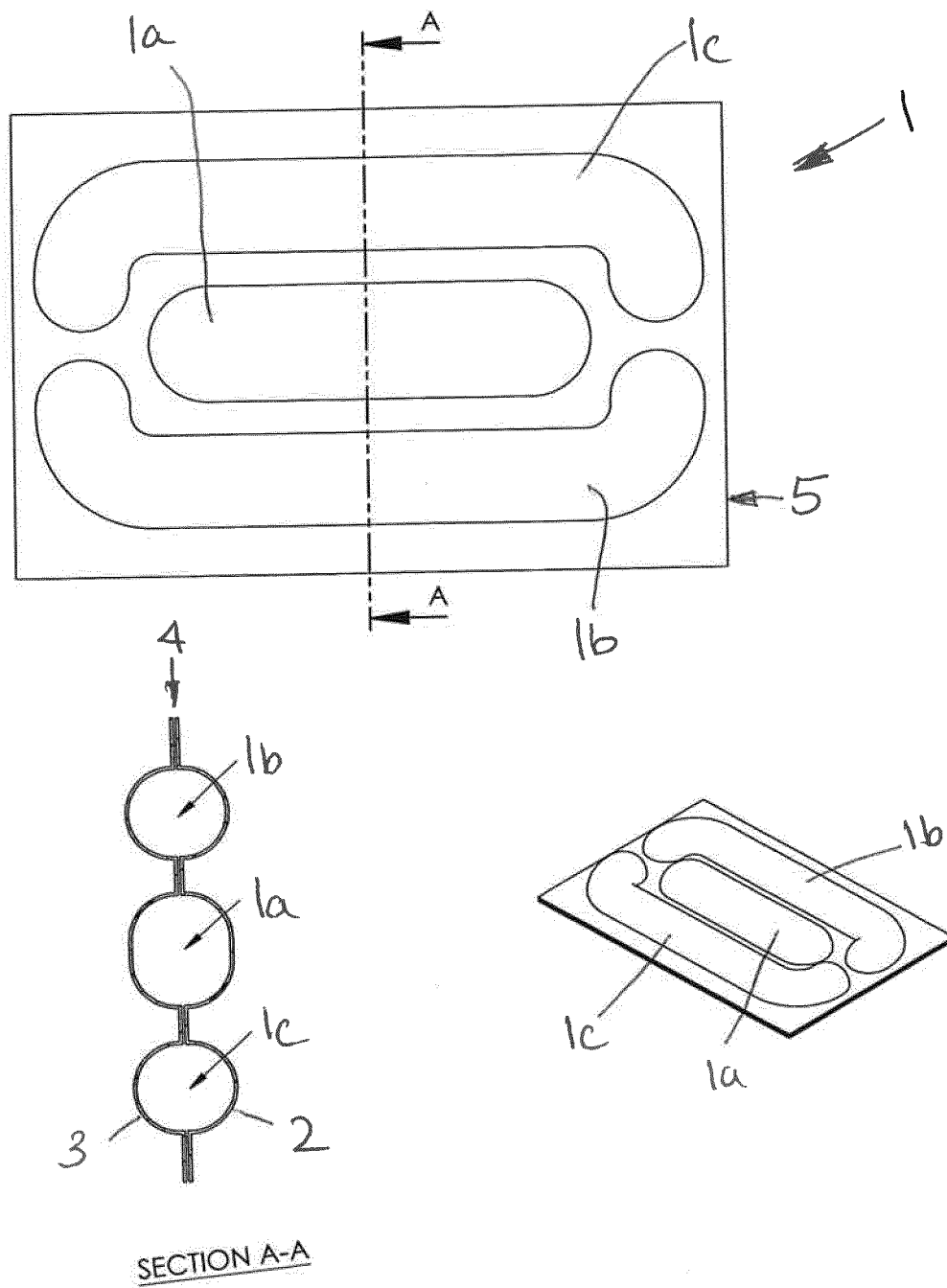


Figure 12

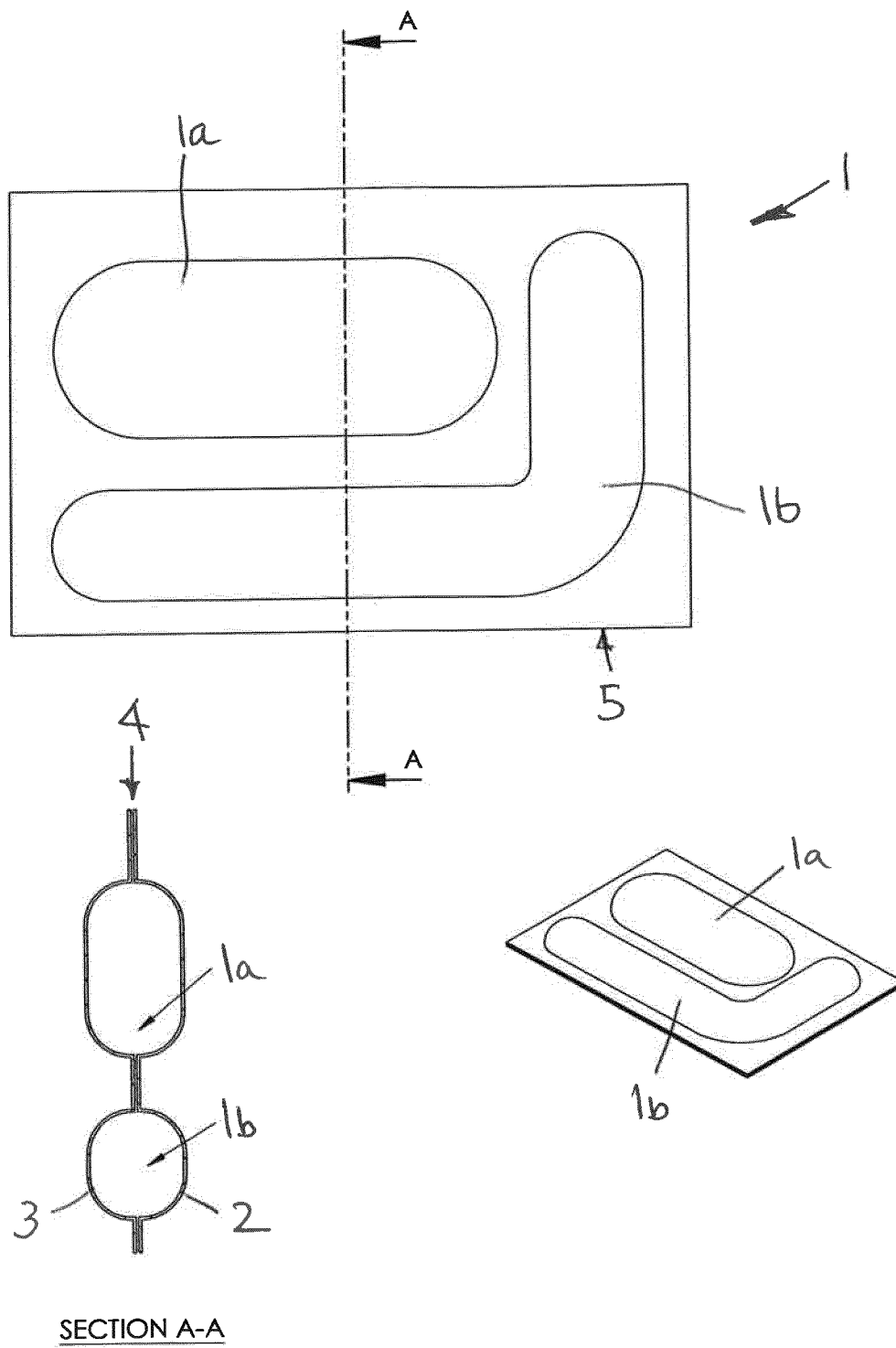


Figure 13

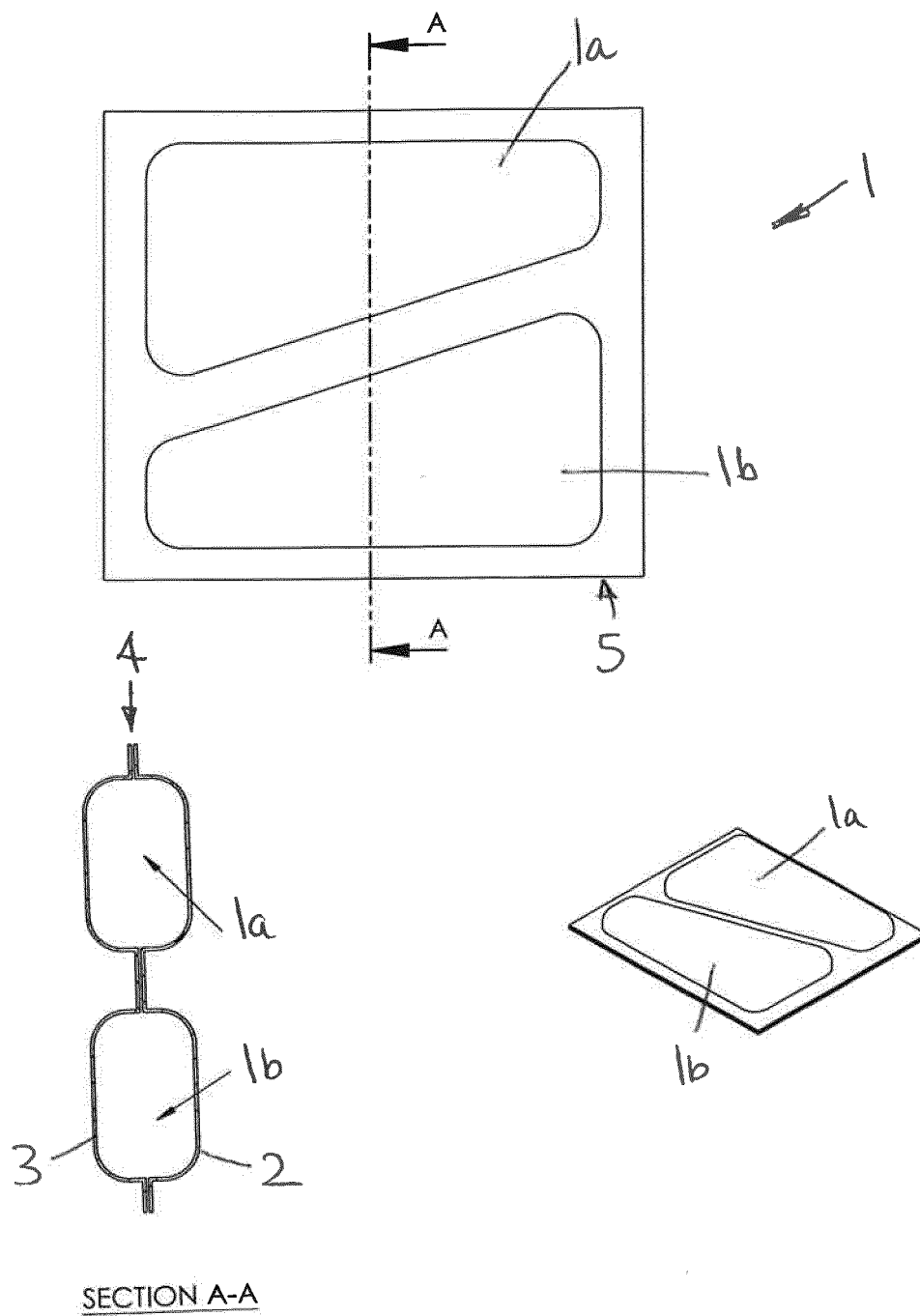


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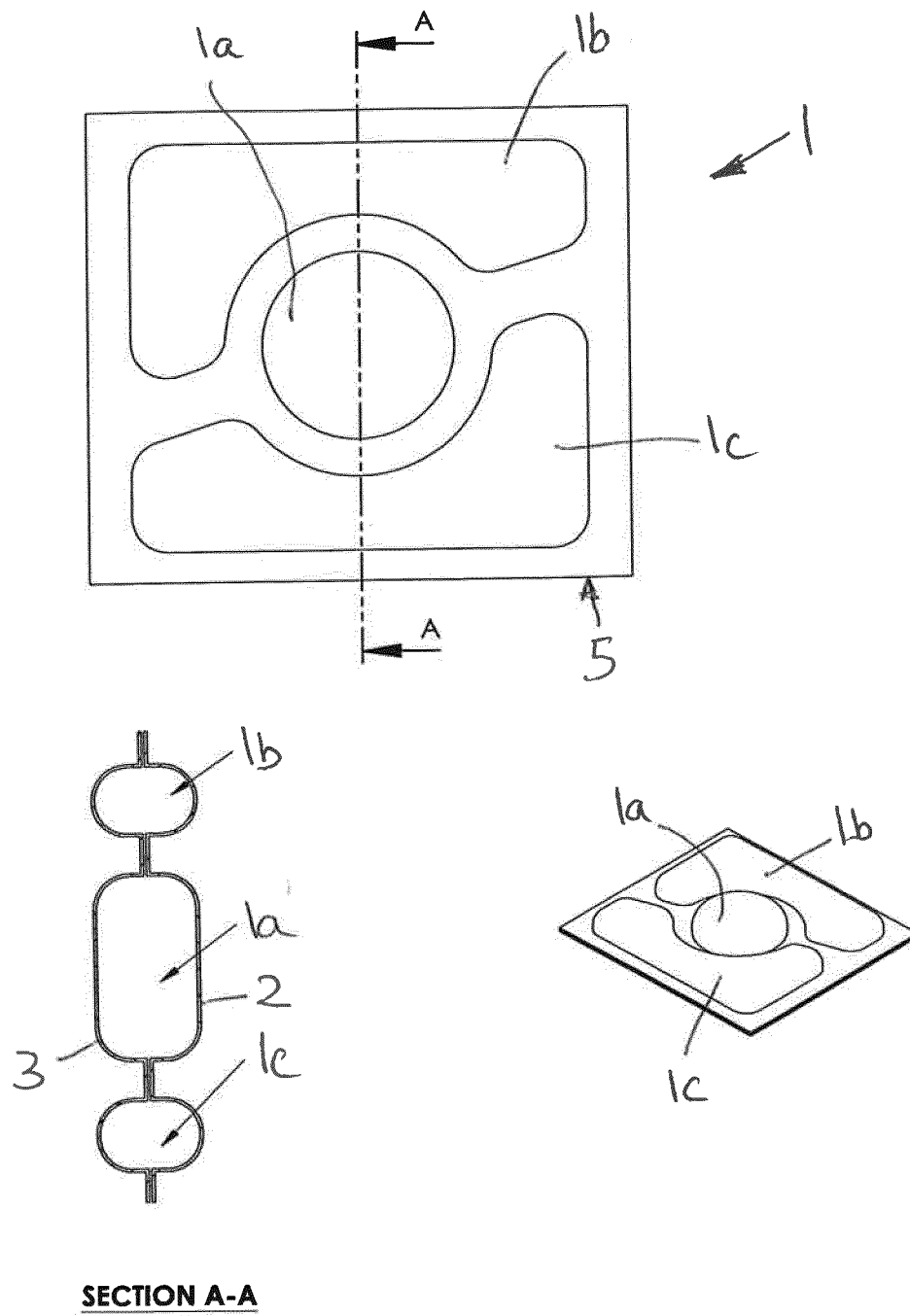


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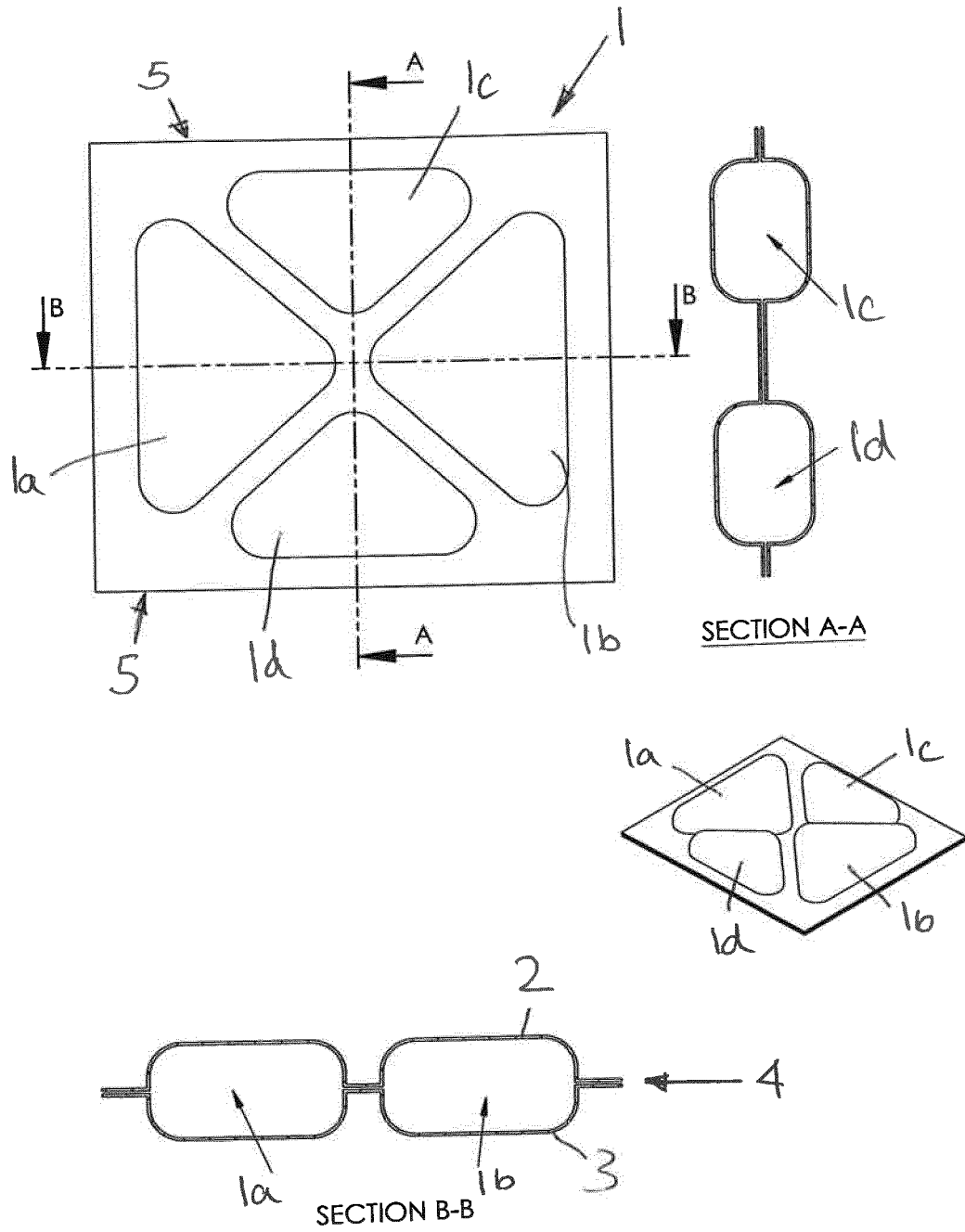


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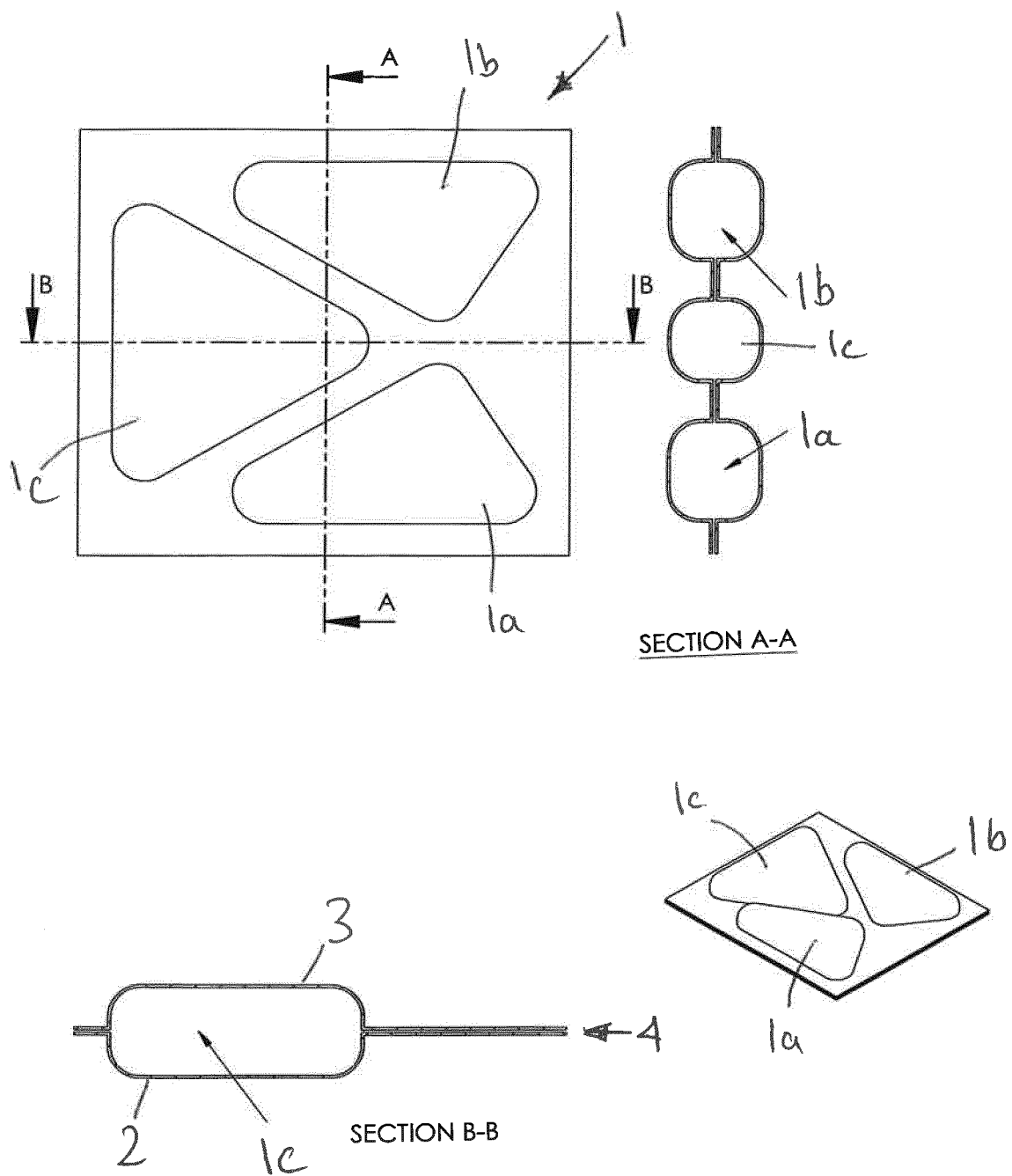


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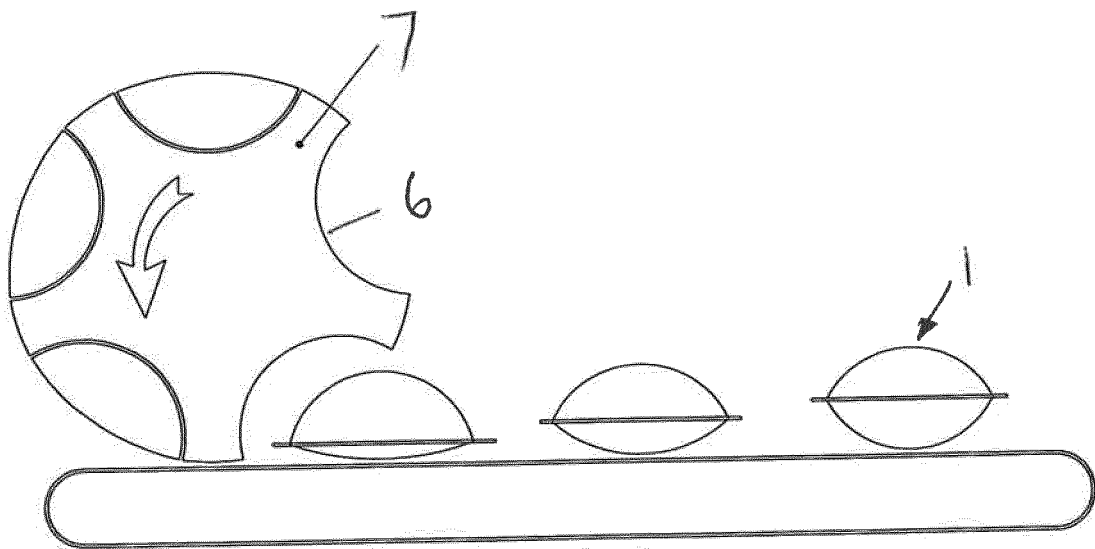


Figure 18



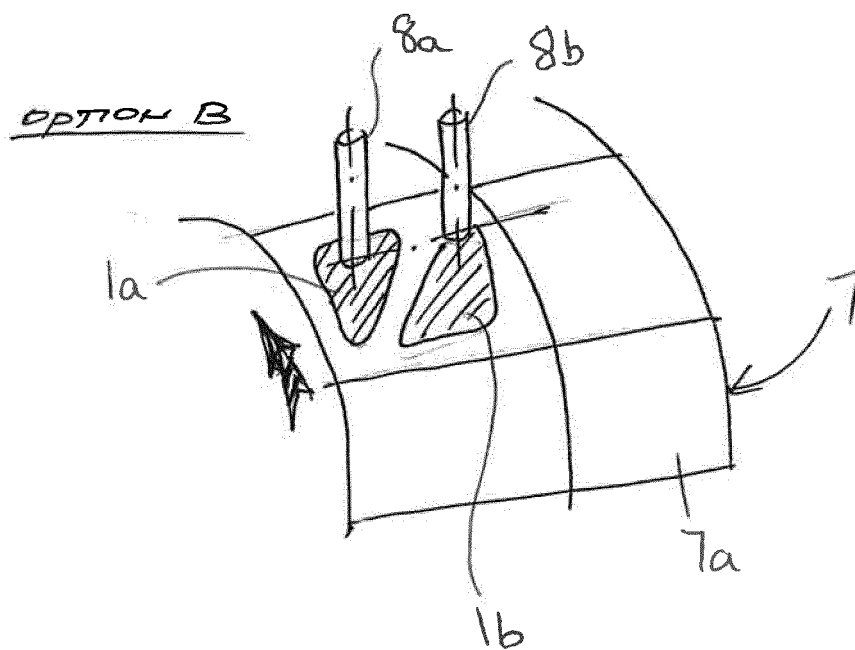
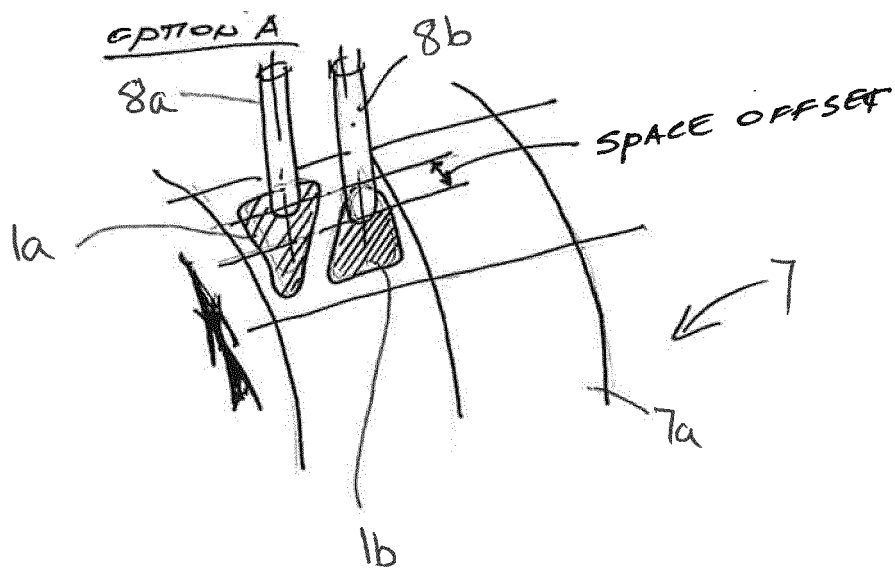


Figure 19

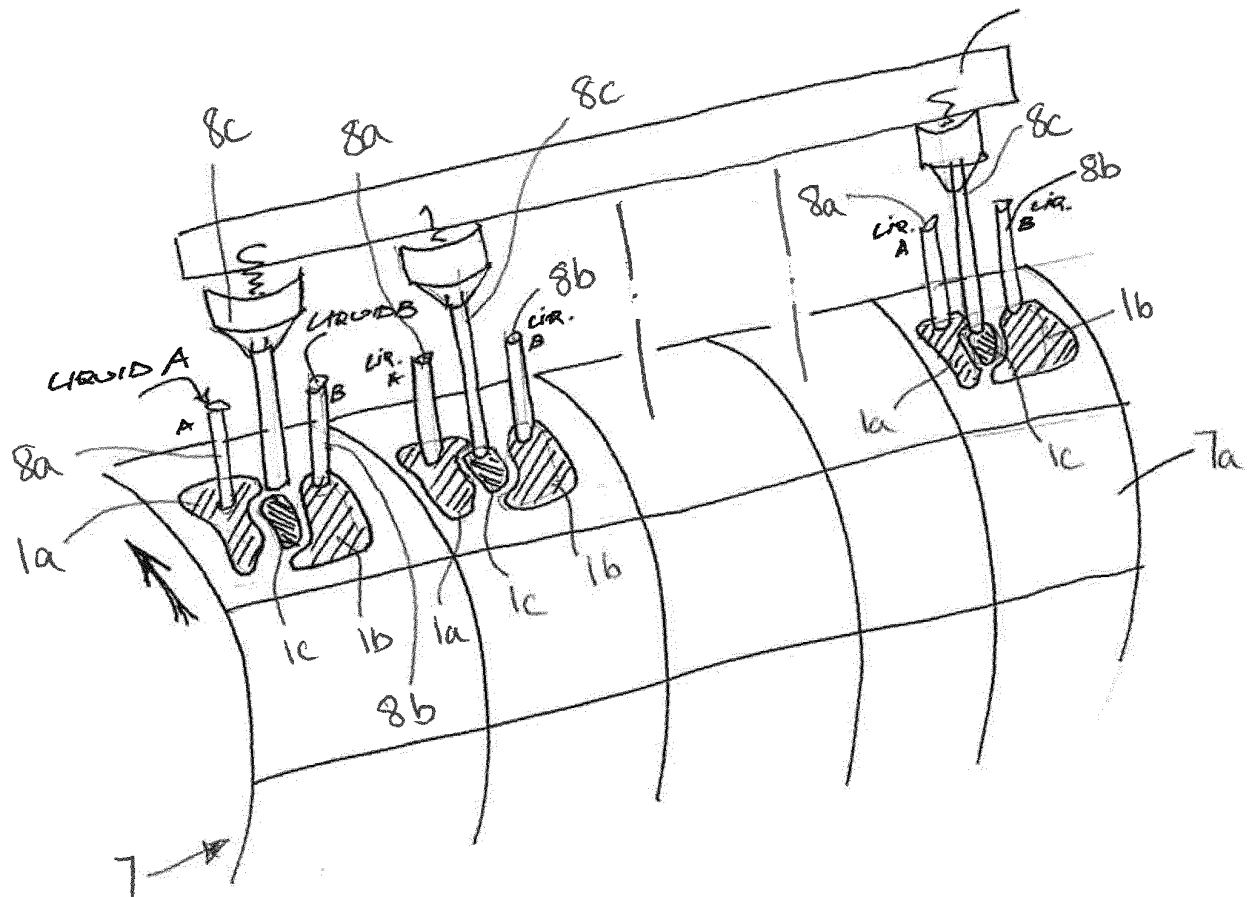


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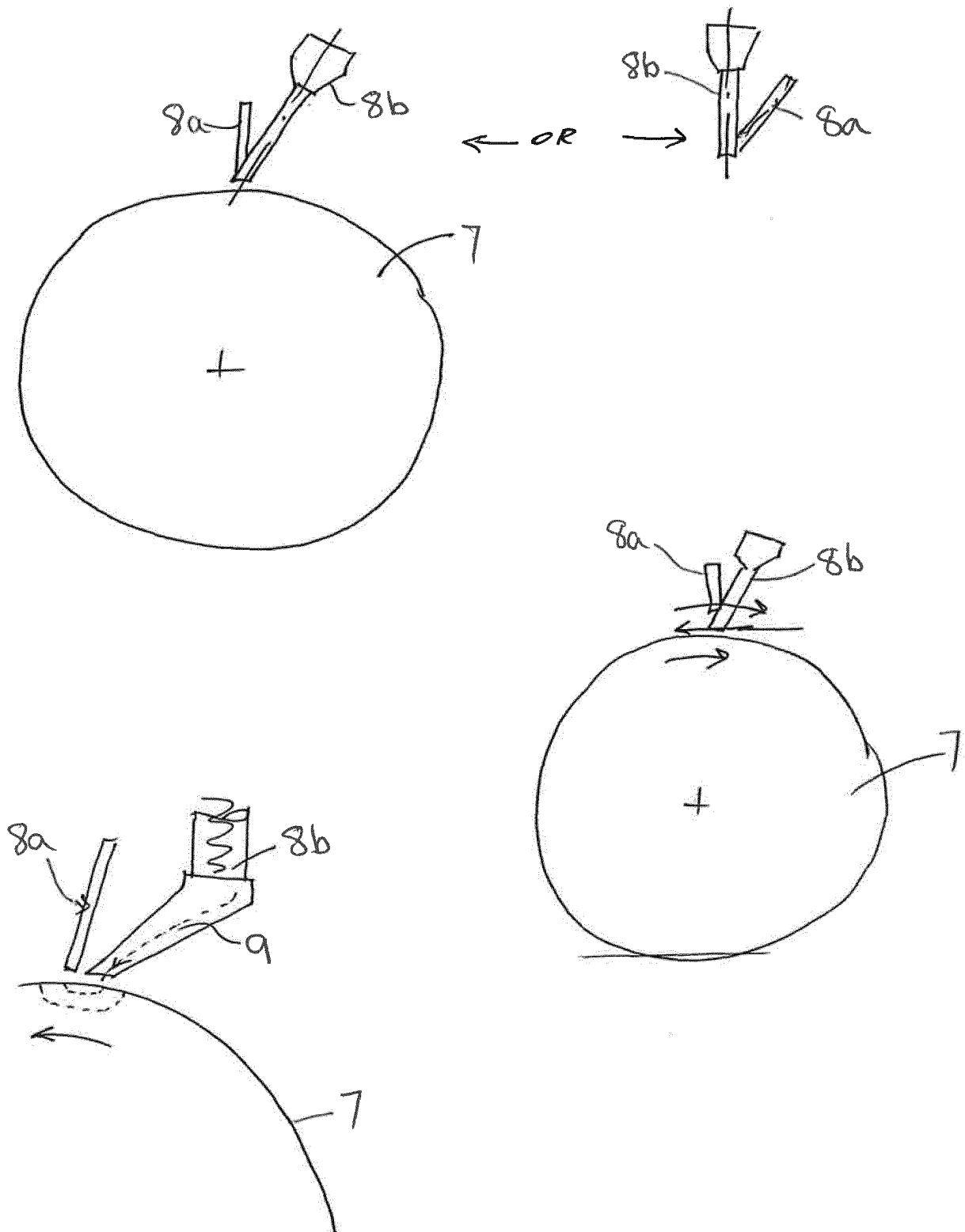


Figure 21

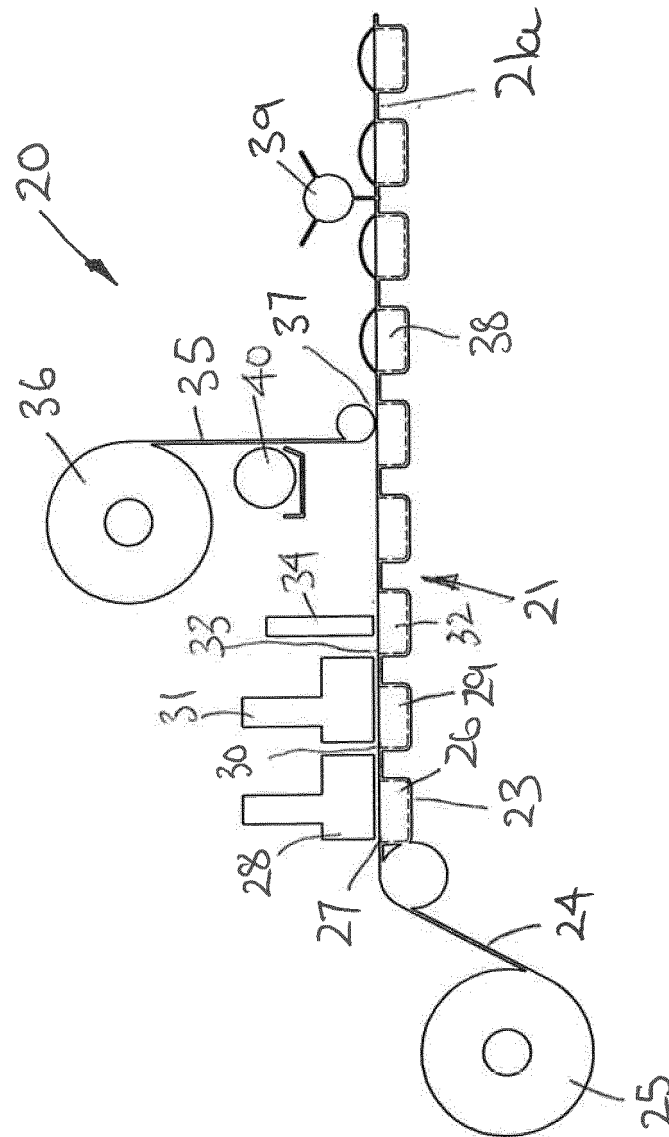


Figure 22

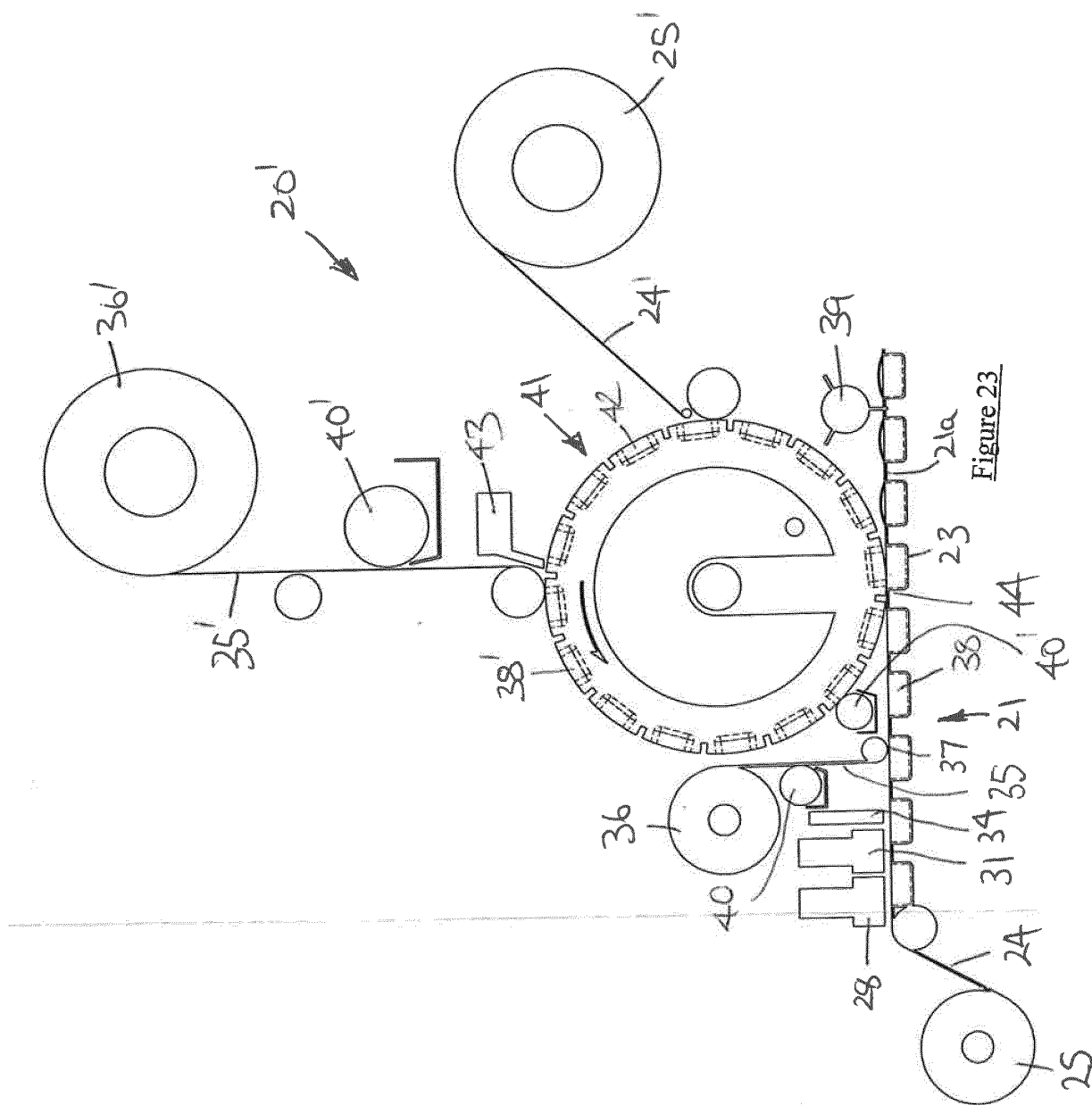
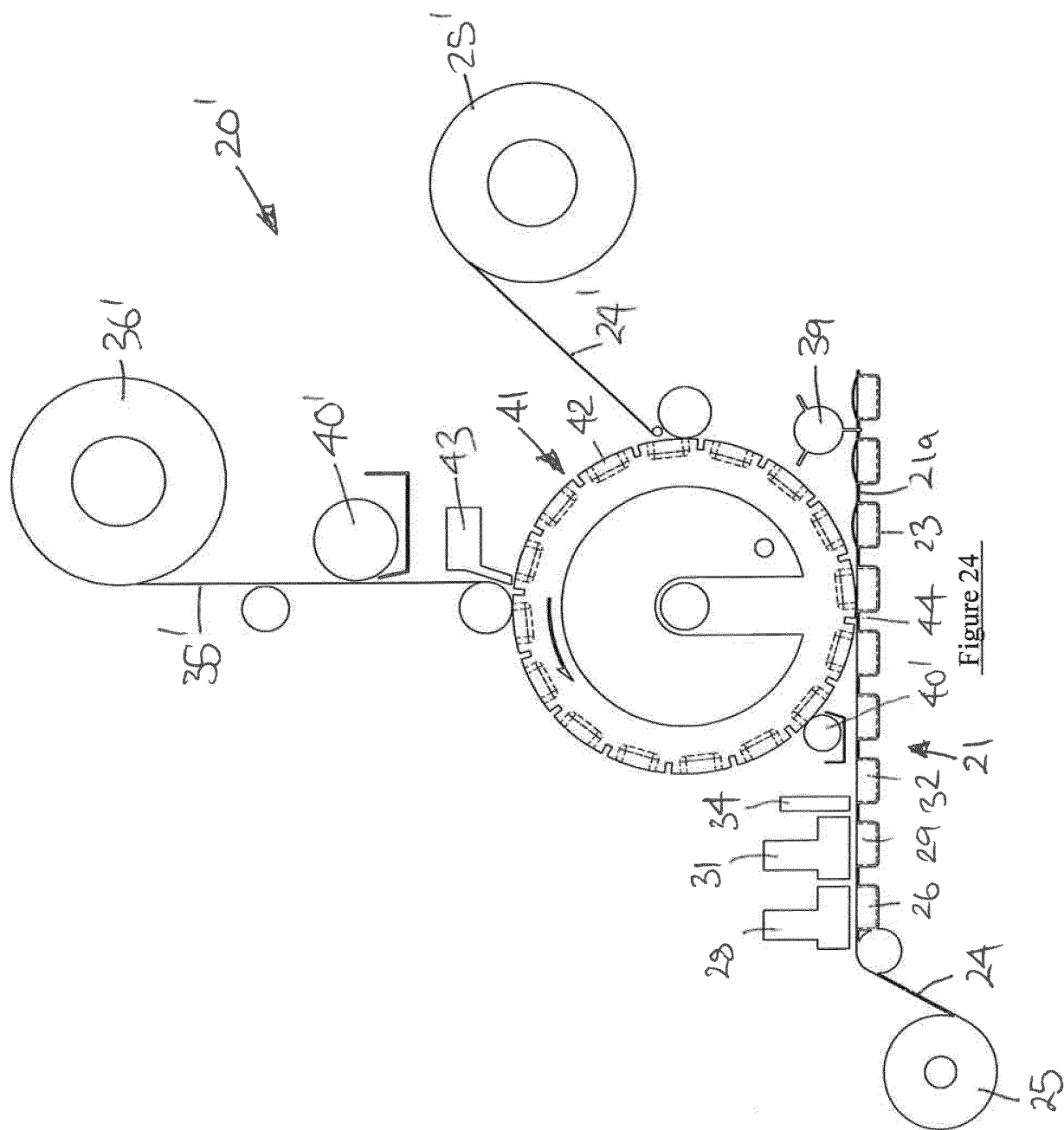


Figure 23



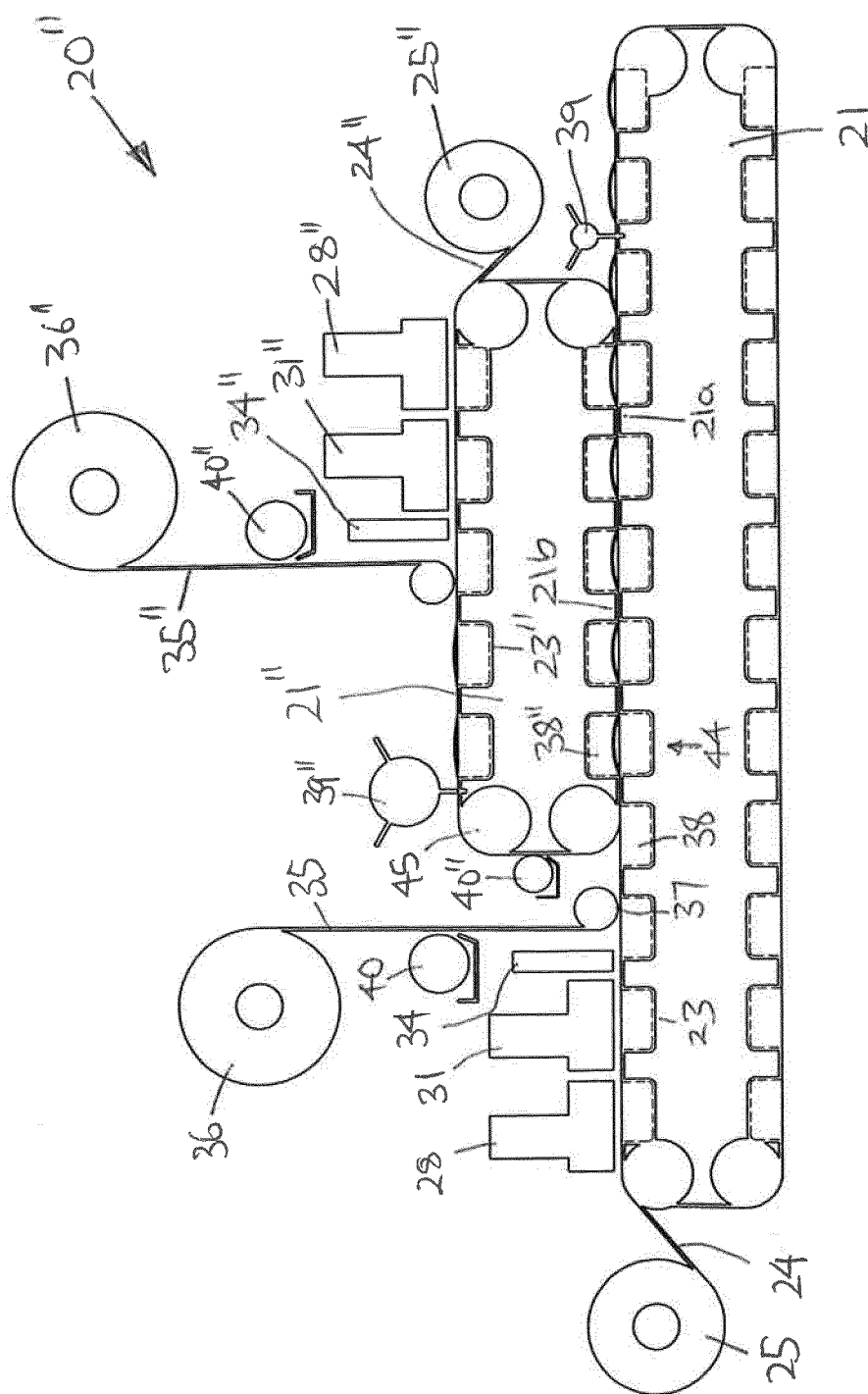


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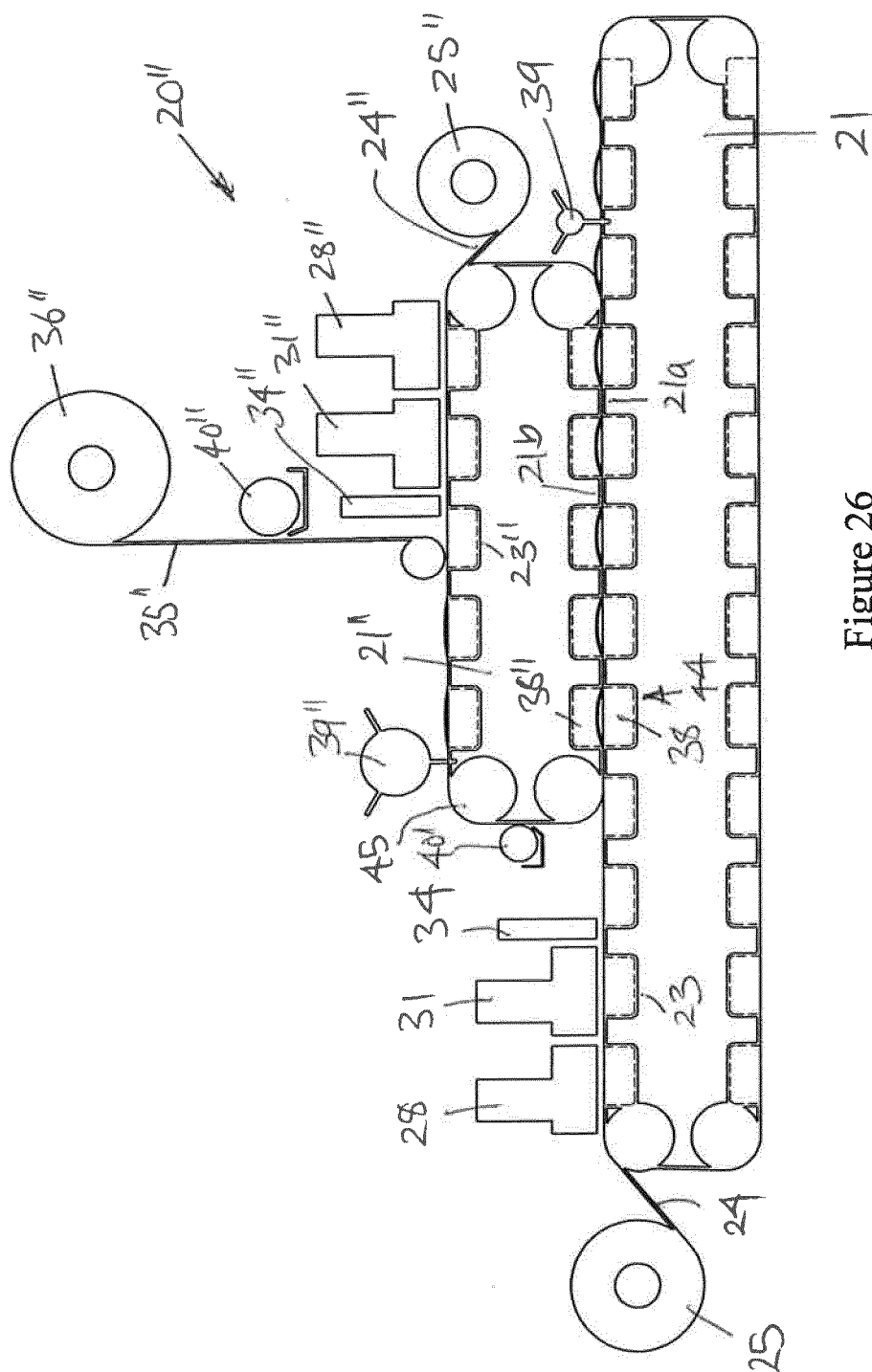


Figure 26



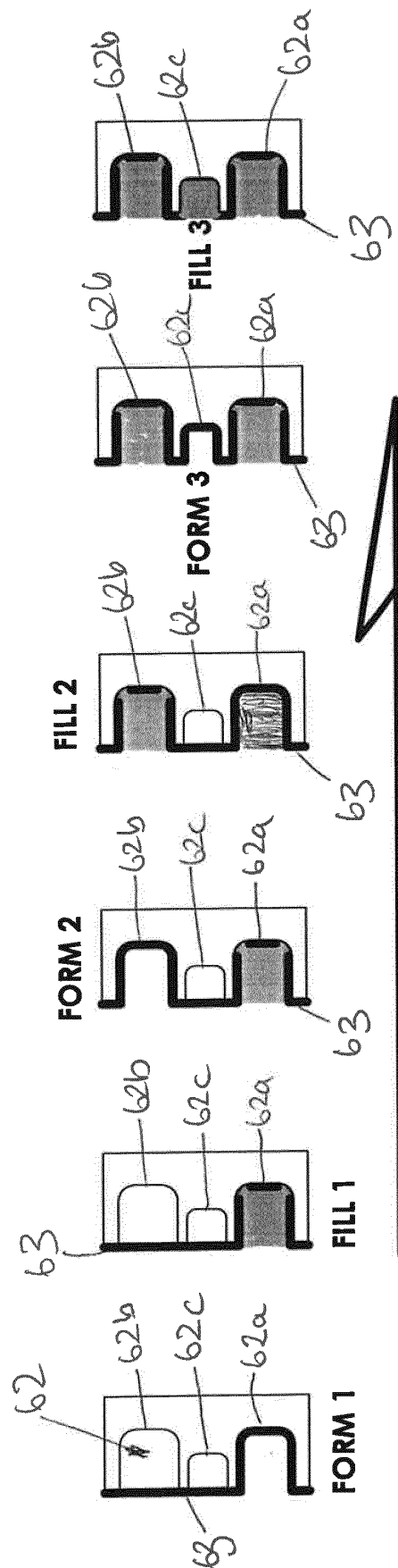


Figure 28

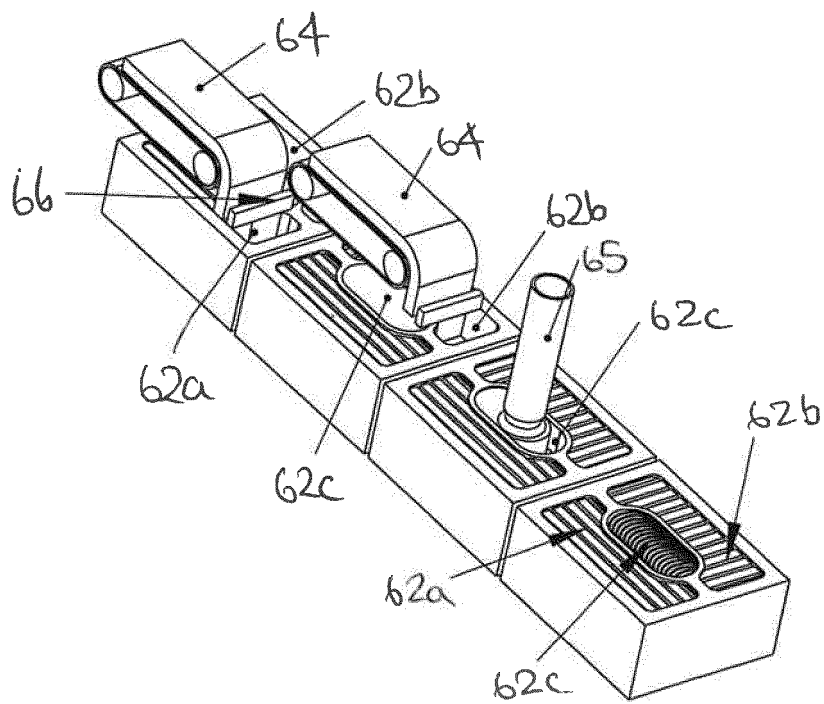


Figure 29

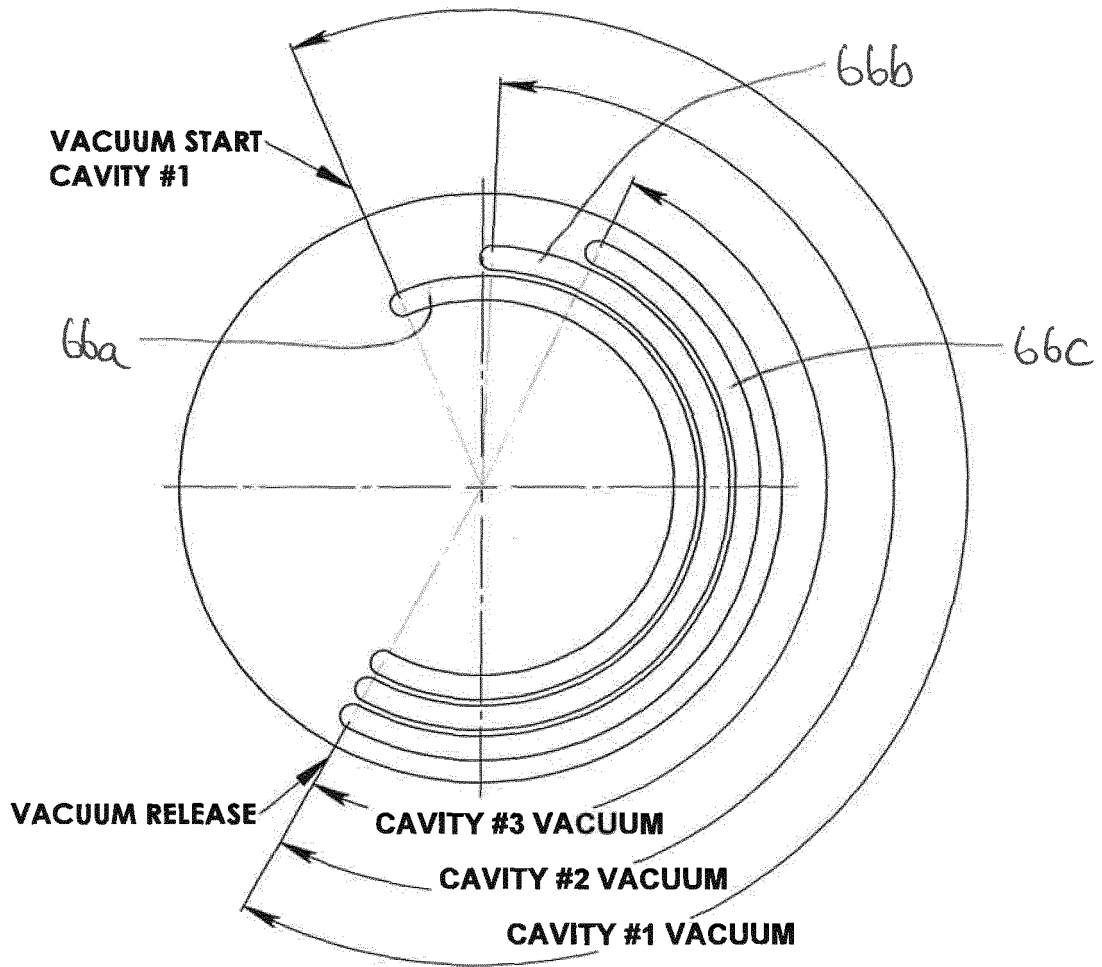


Figure 30

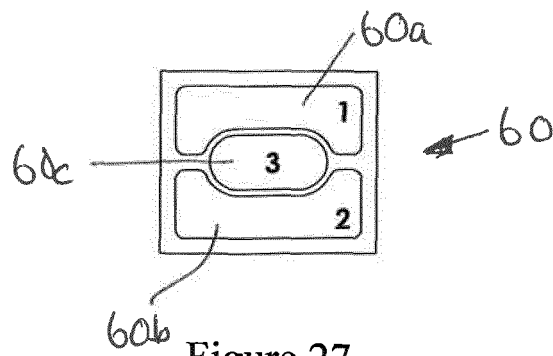


Figure 27

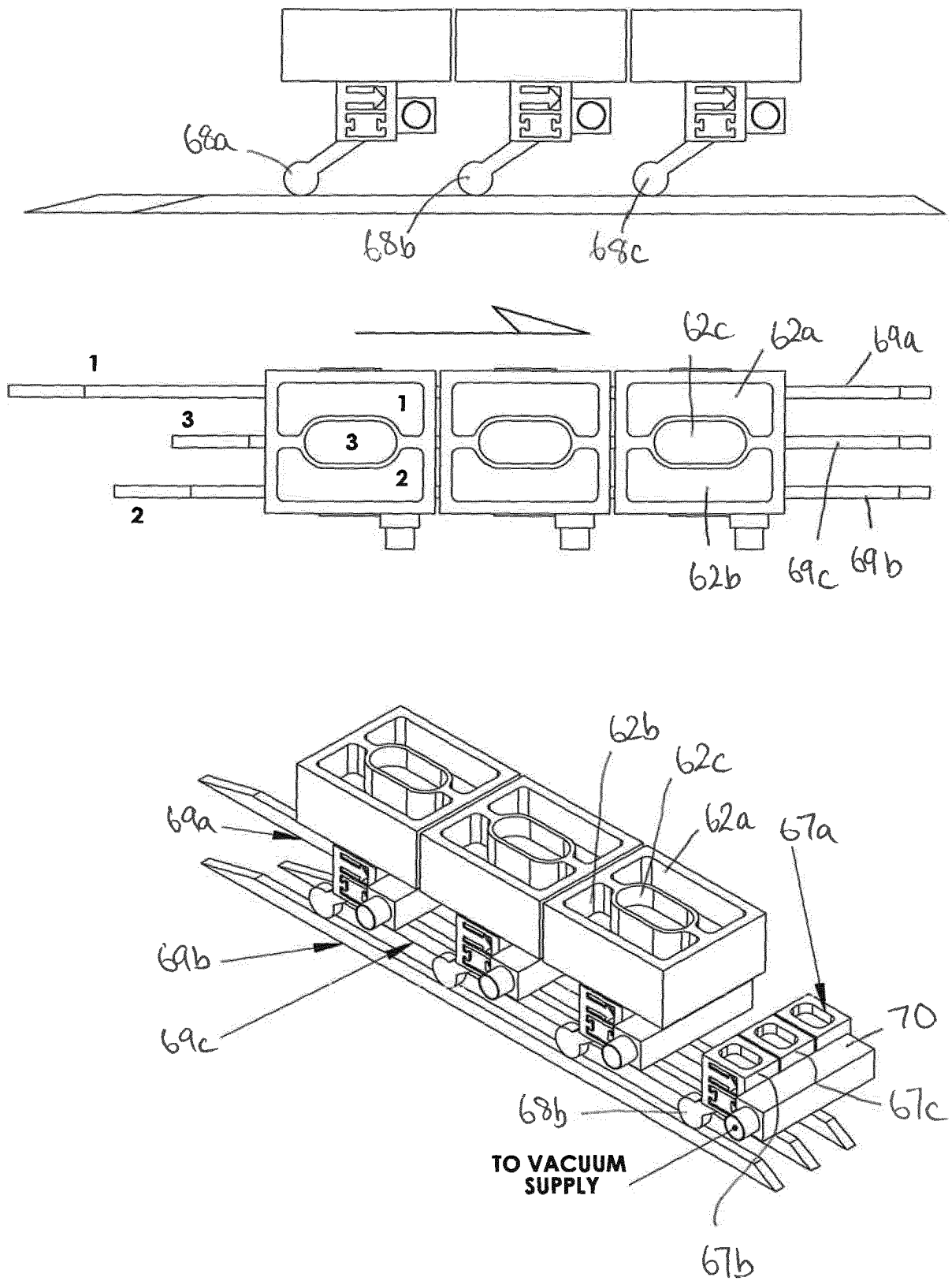


Figure 31

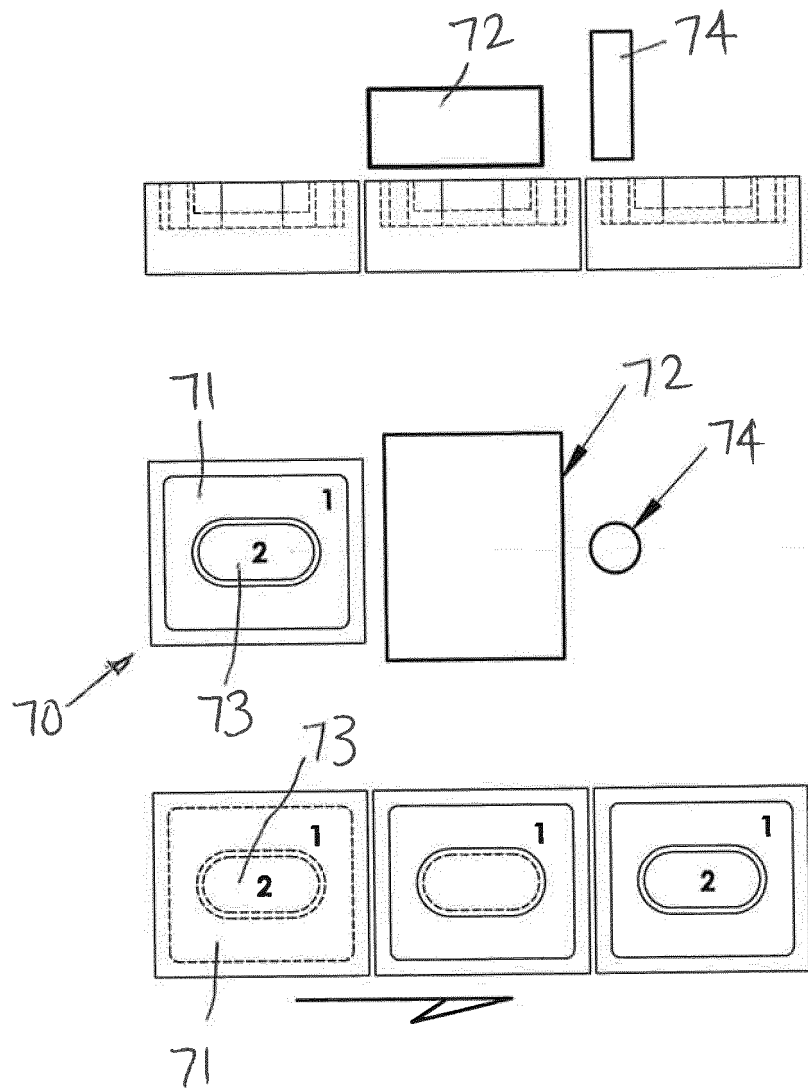


Figure 32

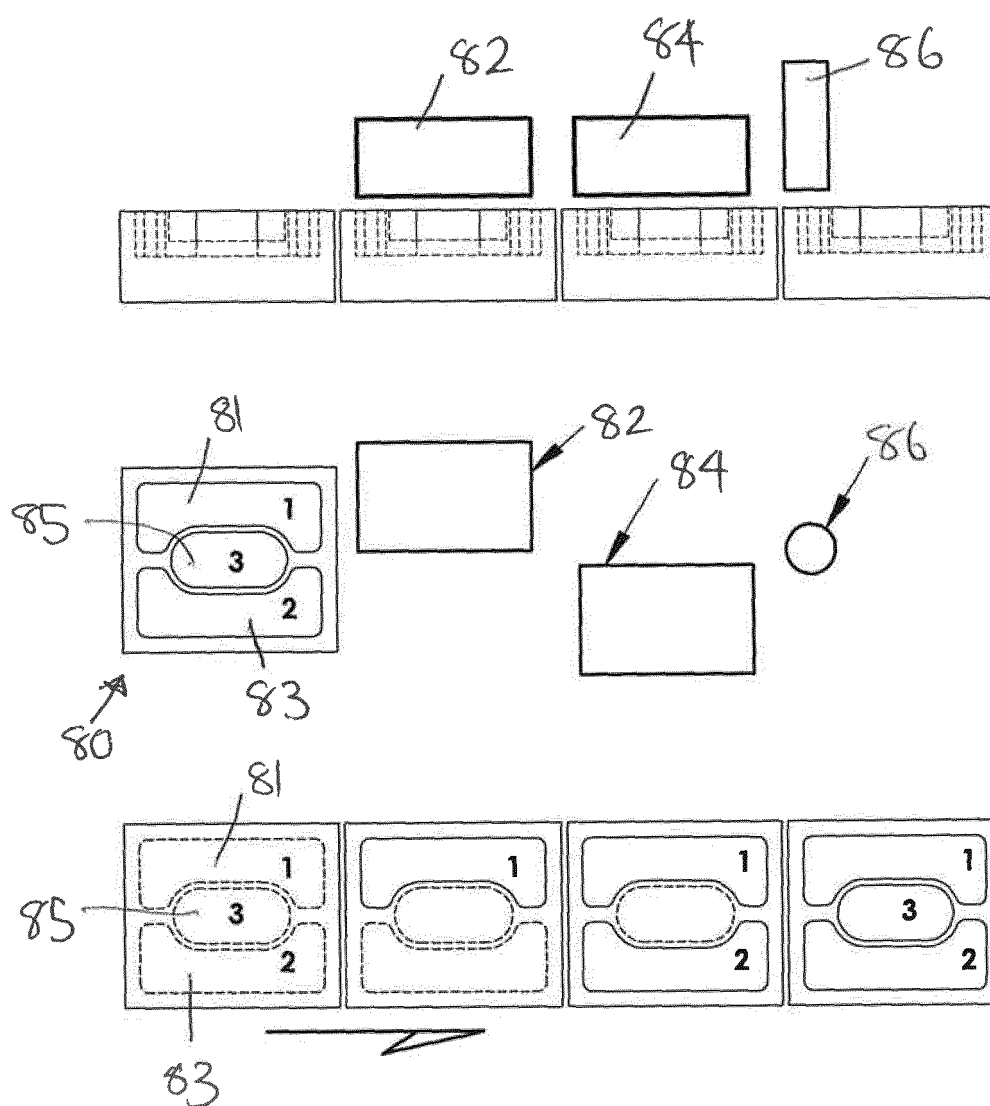


Figure 33

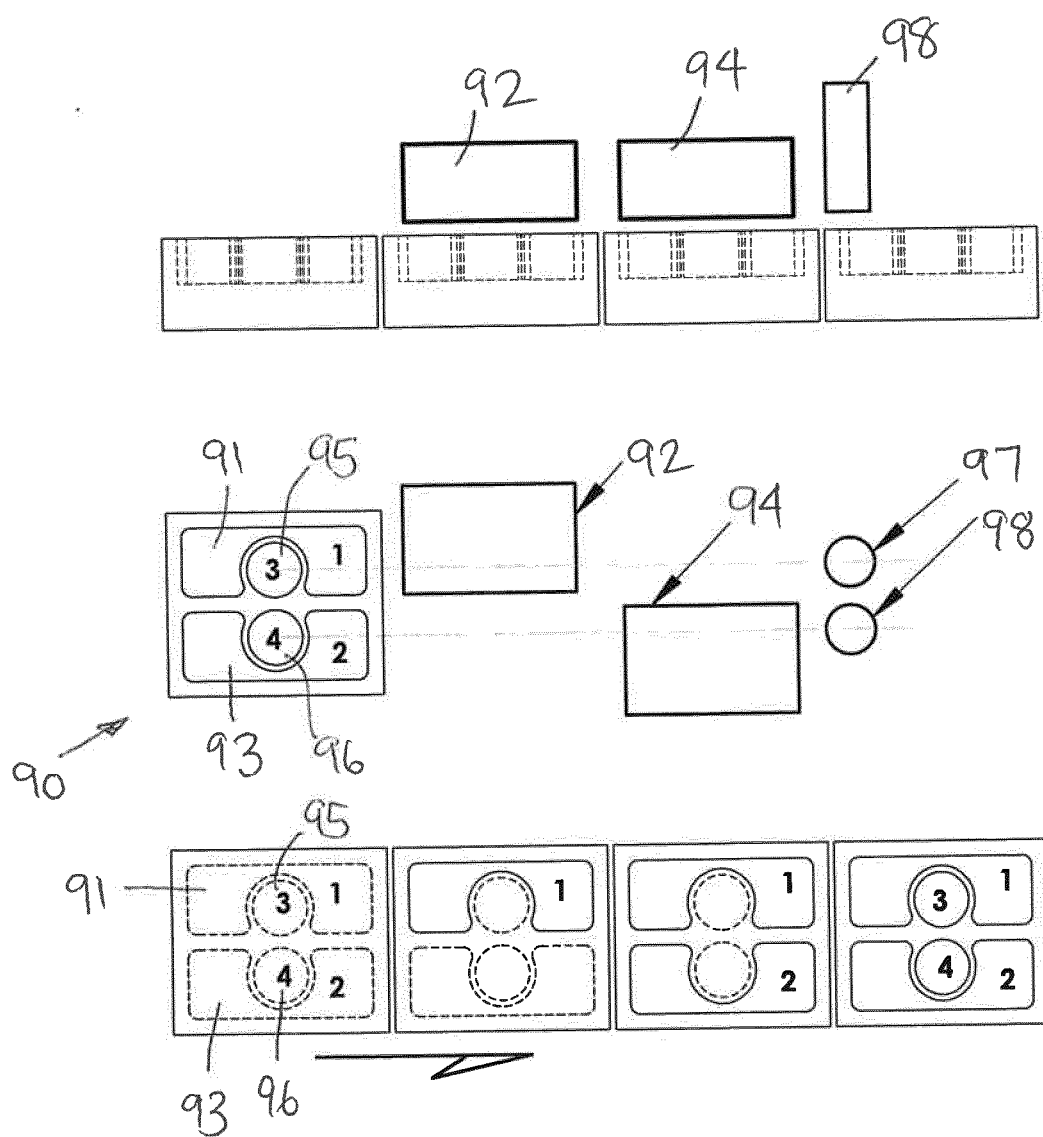


Figure 34

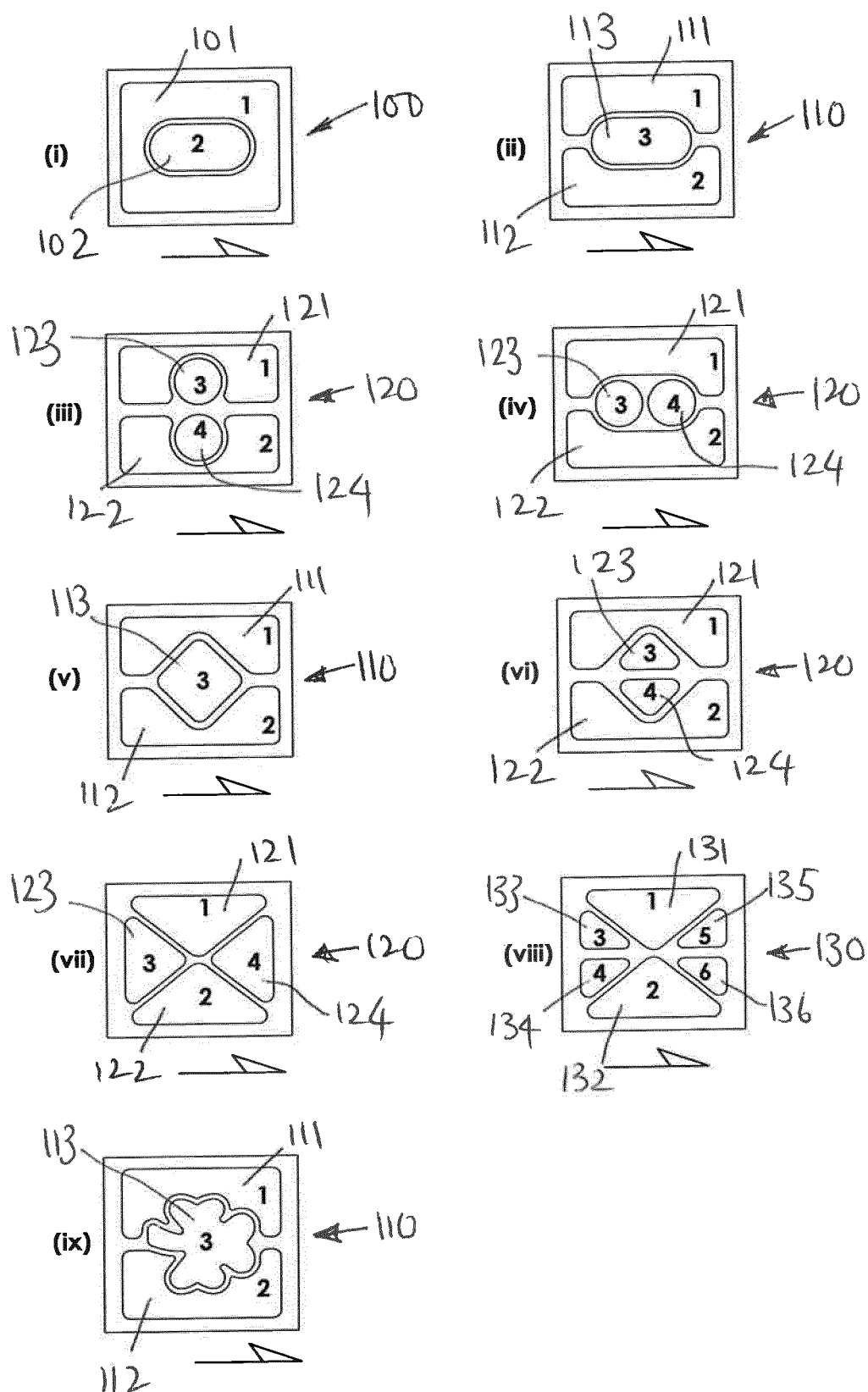


Figure 35



**REFERENCES CITED IN THE DESCRIPTION**

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