



(12) **EUROPEAN PATENT APPLICATION**

(43) Date of publication:
26.07.2017 Bulletin 2017/30

(51) Int Cl.:
B65D 75/58 (2006.01) **B65D 77/02 (2006.01)**
B65D 85/10 (2006.01)

(21) Application number: **17161209.6**

(22) Date of filing: **22.07.2013**

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

• **POLLONI, Roberto**
47015 Modigliana (IT)
• **NEGRINI, Stefano**
40012 Calderara di Reno (IT)

(30) Priority: **20.07.2012 IT BO20120392**

(74) Representative: **Maccagnan, Matteo et al**
Studio Torta S.p.A.
Via Viotti, 9
10121 Torino (IT)

(62) Document number(s) of the earlier application(s) in accordance with Art. 76 EPC:
13773362.2 / 2 874 909

(71) Applicant: **G.D SOCIETA' PER AZIONI**
40133 Bologna (IT)

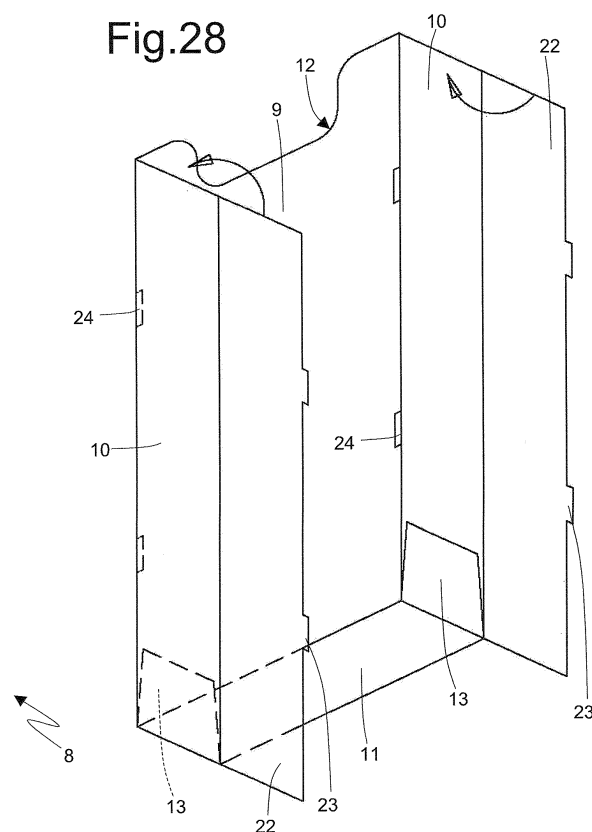
Remarks:

This application was filed on 15.03.2017 as a divisional application to the application mentioned under INID code 62.

(72) Inventors:
• **SPIRITO, Gilberto**
40133 Bologna (IT)

(54) **PACKAGE OF TOBACCO ARTICLES COMPRISING A SEALED INNER PACKAGE**

(57) A package of tobacco articles, having: a group (4) of tobacco articles; a sealed inner package (3) enclosing the group (4) of tobacco articles having an extraction opening (5) from which to extract the tobacco articles being closed by a sealing flap (6); and a stiffener (8) located inside the sealed inner package (3) contacting the group (4) of tobacco articles which has a front wall (9), two lateral walls (10) located on opposite sides of the front wall (9) and a bottom wall (11) contacting the tips of the tobacco articles; the stiffener (8) also having a connecting system for connecting the bottom wall (11) to the lateral walls (10) of the stiffener (8) being based on lateral tabs (13) of the bottom wall to prevent movement of the two lateral walls (10) with respect to the bottom wall (11).



Description

TECHNICAL FIELD

[0001] The present invention relates to a package of tobacco articles comprising a sealed inner package.

[0002] The present invention may be applied to advantage to a rigid packet of cigarettes, to which the following description refers purely by way of example.

BACKGROUND ART

[0003] Rigid, hinged-lid packets of cigarettes are currently the most widely marketed, by being easy to produce and easy and practical to use, and by effectively protecting the cigarettes inside.

[0004] A rigid, hinged-lid packet of cigarettes comprises an inner package comprising a foil-wrapped group of cigarettes; and a rigid outer container housing the inner package. The outer container comprises a cup-shaped container housing the group of cigarettes and having an open top end; and a cup-shaped lid hinged to the container to rotate, with respect to the container, between an open position and a closed position opening and closing the open end respectively.

[0005] A sealed (i.e. airtight) inner package has recently been proposed comprising a cigarette extraction opening closed by an open-close sealing flap (the sealing flap is applied with non-dry, re-stick glue enabling it to be stuck repeatedly in the closed position closing the cigarette extraction opening).

[0006] Patent US6237760A1 and Patent Application DE102009060134A1 describe two examples of a sealed inner package containing a group of cigarettes and having a cigarette extraction opening closed by an open-close sealing flap. The group of cigarettes inside the sealed inner package is enclosed in a stiffener inserted inside the sealed inner package, directly contacting the cigarettes, and which comprises a front wall contacting the cylindrical lateral walls of the cigarettes; two lateral walls on opposite sides of the front wall and contacting the cylindrical lateral walls of the cigarettes; and a bottom wall contacting the tips of the cigarettes.

[0007] Patent Application WO2011110272A1 describes a packing method for producing a sealed inner package containing a group of cigarettes. As a whole, the packing method described is substantially conventional, by causing the group of cigarettes to intercept a flat sheet of packing material, so that the sheet of packing material folds into a 'U' about the group of cigarettes.

[0008] To improve the efficiency of the packing cycle described in Patent Application WO2011110272A1, Patent Application WO2011110272A1 proposes a further packing method for producing a sealed inner package containing a group of cigarettes. This further method is based on the so-called 'flow-pack' method, in which a tubular wrapping is formed about a succession of groups of cigarettes by continuously and longitudinally heat-

sealing a web of packing material folded into a tube; and the tubular wrapping is heat-sealed and cut transversely, upstream and downstream from each group of cigarettes, into individual sealed inner packages.

[0009] When forming the tubular wrapping using the packing method described in Patent Application WO2011110272A1, however, each group of cigarettes may possibly fall out of shape, i.e. the cigarettes in the group may shift out of position, thus resulting in the formation of an irregularly shaped sealed inner package which is inevitably rejected.

[0010] Patent Application WO2013053408A1 belongs to the state of the art according to Art. 54(3) EPC and discloses a package of tobacco articles comprising a sealed inner package provided with a stiffener, which is located inside the sealed inner package contacting the group of tobacco articles and has a connecting system for connecting a bottom wall to lateral walls, to prevent movement of the two lateral walls with respect to the bottom wall.

DESCRIPTION OF THE INVENTION

[0011] It is an object of the present invention to provide a package of tobacco articles comprising a sealed inner package, and which is designed to eliminate the above drawbacks and at the same time is cheap and easy to produce.

[0012] According to the present invention, there is provided a package of tobacco articles comprising a sealed inner package, as claimed in the accompanying Claims.

BRIEF DESCRIPTION OF THE DRAWINGS

[0013] A number of non-limiting embodiments of the present invention will be described by way of example with reference to the attached drawings, in which:

Figure 1 shows a front view in perspective of a packet of cigarettes, in accordance with the present invention, in a closed configuration;

Figure 2 shows a front view in perspective of the Figure 1 packet of cigarettes in an open configuration;

Figure 3 shows a rear view in perspective of the Figure 1 packet of cigarettes in a closed configuration; Figure 4a shows a front view in perspective of a sealed inner package of the Figure 1 packet of cigarettes;

Figures 4b and 4c show front and rear views in perspective respectively of the Figure 4a sealed inner package prior to folding lateral heat-seal fins;

Figure 5 shows a view in perspective of a group of cigarettes enclosed in the Figure 4 sealed inner package;

Figure 6 shows a view in perspective of a stiffener inserted inside the Figure 4 sealed inner package; Figure 7 shows a longitudinal section of the Figure

6 stiffener;

Figure 8 shows a view in perspective of the Figure 6 stiffener, illustrating the way in which a tab on the bottom wall is folded;

Figure 9 shows a spread-out view of a blank from which to form the Figure 6 stiffener;

Figures 10-31 show alternative embodiments of the Figure 6 stiffener and/or the blank from which to form the Figure 6 stiffener;

Figure 32 shows a schematic view in perspective, with parts removed for clarity, of a packing machine for producing the Figure 1 packet of cigarettes;

Figures 33 and 34 show two schematic views in perspective, with parts removed for clarity, of a packing unit of the Figure 32 packing machine, for producing the sealed inner package in Figure 4;

Figure 35 shows a schematic plan view, with parts removed for clarity, of the packing unit in Figures 33 and 34;

Figure 36 shows a schematic plan view of material flow on the Figure 33 and 34 packing unit;

Figure 37 shows a schematic view in perspective of how the Figure 9 blank is folded to form the Figure 6 stiffener;

Figure 38 shows a schematic section, with parts removed for clarity, of a coupling conveyor of the Figure 33 and 34 packing unit;

Figure 39 shows a schematic view in perspective, with parts removed for clarity, of a packing conveyor of the Figure 33 and 34 packing unit;

Figure 40 shows a schematic view in perspective of material flow on an end portion of the Figure 39 packing conveyor;

Figures 41, 42 and 43 show three schematic views in perspective, with parts removed for clarity, of a variation of the Figure 33 and 34 packing unit.

PREFERRED EMBODIMENTS OF THE INVENTION

[0014] Number 1 in Figures 1, 2 and 3 indicates as a whole a rigid packet of cigarettes. Packet 1 of cigarettes comprises a cup-shaped outer container 2, which is made of cardboard, has a hinged lid, and houses a sealed inner package 3 (Figure 2). Sealed inner package 3 encloses a parallelepiped-shaped group 4 of cigarettes (Figure 5) and, at the top and front, has a central cigarette extraction opening 5 extending over part of a front wall and part of a top wall of sealed inner package 3. The cigarettes in group 4 are cylindrical with a longitudinal axis. Sealed inner package 3 comprises a reclosable (i.e. 'open-close') sealing flap (i.e. sealing panel) 6 designed to seal extraction opening 5 and coated on the underside with non-dry, re-stick glue (i.e. non-dry glue allowing the sealing flap to be detached and re-attached repeatedly). That is, sealing flap 6 normally adheres to sealed inner package 3 to seal extraction opening 5, and can be detached temporarily from sealed inner package 3 to free, and so withdraw a cigarette through, extraction

opening 5.

[0015] In the embodiment shown in the attached drawings, sealing flap 6 is applied externally to the packing material of sealed inner package 3. In alternative embodiments, sealing flap 6 is either formed in two-layer packing material of sealed inner package 3, or is in the form of a frame applied to the inside of the packing material of sealed inner package 3.

[0016] As shown more clearly in Figure 4, sealing flap 6 has a grip tab 7 with no re-stick adhesive and located close to, normally beneath, extraction opening 5.

[0017] As shown in Figures 6, 7 and 8, sealed inner package 3 comprises a U-shaped stiffener (i.e. tray) 8 made of cardboard (identical to that of outer container 2) and which is inserted inside sealed inner package 3, contacting group 4 of cigarettes. Stiffener 8 comprises a front wall 9 positioned contacting the cylindrical lateral walls of the cigarettes in group 4; two lateral walls 10 on opposite sides of front wall 9 and positioned contacting the cylindrical lateral walls of the cigarettes in group 4; and a bottom wall 11 positioned contacting the tips of the cigarettes in group 4. Front wall 9 preferably has a top recess 12 located at cigarette extraction opening 5, so that front wall 9 does not overlap cigarette extraction opening 5.

[0018] Each lateral wall 10 comprises a lateral tab 13, which is folded 90° with respect to lateral wall 10 onto bottom wall 11. Bottom wall 11 comprises a bottom tab 14, which is folded 180° with respect to and onto bottom wall 11; and bottom tab 14 comprises an appendix 15, which is folded 90° with respect to bottom tab 14 onto front wall 9.

[0019] Stiffener 8 has no glue, and comprises a jointing system to hold bottom wall 11 and lateral walls 10 in position. The jointing system comprises a U-shaped through slit 16 formed through front wall 9, along the fold line between front wall 9 and bottom wall 11; and a U-shaped projection 17 formed on bottom tab 14, along the fold line between bottom tab 14 and appendix 15. Projection 17 on bottom tab 14 is inserted through slit 16 in front wall 9 (by elastically deforming projection 17) to form a joint, between projection 17 and through slit 16, which holds bottom wall 11 and lateral walls 10 in position, by requiring significant deformation for its release. Through slit 16 is formed by making a U-shaped cut through front wall 9, along the fold line between front wall 9 and bottom wall 11. Likewise, projection 17 is formed by making a U-shaped cut through appendix 15, along the fold line between appendix 15 and bottom tab 14.

[0020] In the finished packet 1 of cigarettes, stiffener 8 serves to reinforce and maintain the shape of sealed inner package 3, to prevent sealed inner package 3 from collapsing, when some of the cigarettes are removed, and so complicating withdrawal of the remaining cigarettes and, in particular, opening and closing of sealing flap 6. When producing sealed inner package 3, on the other hand, and as described in detail below, stiffener 8 serves to hold the cigarettes in group 4 together in the

right position.

[0021] Figure 9 shows a blank 18, which is folded to form the stiffener 8 in Figures 6, 7 and 8. Figure 8 clearly shows the cuts defining through slit 16 and projection 17.

[0022] Figure 10 shows a variation of the Figure 9 blank 18. The Figure 10 blank 18 differs from the Figure 9 blank 18 by comprising a 'logo', which is visible in positive form at top recess 12 (i.e. at the part of stiffener 8 visible through extraction opening 5 of sealed inner package 3), and in negative form at bottom tab 14 and appendix 15 (in this way, the Figure 10 blank 18 can be formed from a continuous web of cardboard with no waste).

[0023] Figures 11 and 12 show an alternative embodiment of the Figure 6, 7 and 8 stiffener 8, which differs from the Figure 6, 7 and 8 stiffener 8 by comprising an appendix 15 reduced to a minimum in size.

[0024] Figures 13 and 14 show an alternative embodiment of the Figure 6, 7 and 8 stiffener 8, which is formed from the blank 18 shown in Figure 15, and which differs from the Figure 6, 7 and 8 stiffener 8 by having no appendix 15, and by the tip of bottom tab 14 being inserted (by elastically deforming bottom tab 14) through slit 16 to form a joint between bottom tab 14 and through slit 16.

[0025] Figures 16 and 17 show an alternative embodiment of the Figure 6, 7 and 8 stiffener 8, which is formed from the blank 18 shown in Figure 18, and which differs from the Figure 6, 7 and 8 stiffener 8 by having no through slit 16 and no projection 17, and by front wall 9 having a through slit 19 (typically inverted-U-shaped) through which appendix 15 is fitted (by elastically deforming through slit 19). In other words, the jointing system comprises the inverted-U-shaped through slit 19 in front wall 9; and appendix 15 on bottom tab 14, which is folded 90° with respect to bottom tab 14 onto front wall 9, at and to fit inside through slit 19. Figure 19 shows a variation of the Figure 18 blank 18, which differs from the Figure 18 blank 18 by comprising a 'logo', which is visible in positive form at top recess 12 (i.e. at the part of stiffener 8 visible through extraction opening 5 of sealed package 3), and in negative form at bottom tab 14 and appendix 15 (in this way, the Figure 19 blank 18 can be formed from a continuous web of cardboard with no waste).

[0026] Figures 20, 21 and 22 show an alternative embodiment of the Figure 6, 7 and 8 stiffener 8, which is formed from the blank 18 shown in Figure 23, and which differs from the Figure 6, 7 and 8 stiffener 8 by having no appendix 15, no through slit 16, and no projection 17, and by lateral tabs 13 having slits 20 into which bottom tab 14 fits (by elastically deforming lateral tabs 13).

[0027] Figures 24, 25 and 26 show three alternative embodiments of the Figure 9 blank 18, which differ from the Figure 9 blank 18 by having no bottom tab 14, no appendix 15, no through slit 16, and no projection 17; by lateral tabs 13 having slits 20; and by bottom wall 11 having two slits 21. When lateral tabs 13 are superimposed on bottom wall 11, each slit 20 fits inside a corresponding slit 21 (by elastically deforming relative lateral tab 13).

[0028] Figure 27 shows an alternative embodiment of the Figure 6, 7 and 8 stiffener 8, which differs from the Figure 6, 7 and 8 stiffener 8 by having no bottom tab 14, no appendix 15, no through slit 16, and no projection 17, and by bottom wall 11 having two slits 21. When lateral tabs 13 are superimposed on bottom wall 11, the tip of each lateral tab 13 deforms elastically to fit inside a corresponding slit 21.

[0029] Figure 28 shows an alternative embodiment of the Figure 6, 7 and 8 stiffener 8, which differs from the Figure 6, 7 and 8 stiffener 8 by having no bottom tab 14, no appendix 15, no through slit 16, and no projection 17; by the two lateral tabs 13 being connected to opposite ends of bottom wall 11, and being folded 90° with respect to bottom wall 11 onto lateral walls 10; and by each lateral wall 10 comprising a lateral wing 22, which is folded 180° with respect to and onto lateral wall 10 to enclose a corresponding lateral tab 13. Each lateral wing 22 has two projections 23, which (by deforming elastically) fit through corresponding through slits 24 in front wall 9 to form a joint between projections 23 and through slits 24.

[0030] Figures 29 and 30 show an alternative embodiment of the Figure 6, 7 and 8 stiffener 8, which differs from the Figure 6, 7 and 8 stiffener 8 by having no appendix 15, no through slit 16, and no projection 17; and by bottom tab 14 being folded 90° with respect to bottom wall 11.

[0031] Figure 31 shows an alternative embodiment of the Figure 9 blank 18, which differs from the Figure 9 blank 18 by having no bottom tab 14, no appendix 15, no through slit 16, and no projection 17; and by each lateral tab 13 being glued by glue 25 to bottom wall 11. In other words, in all the embodiments shown in Figures 6-30, stiffener 8 has no glue, and comprises a jointing system to hold bottom wall 11 and lateral walls 10 in position; whereas, in the Figure 31 embodiment, stiffener 8 has no jointing system, but has two areas of glue 25 to hold bottom wall 11 and lateral walls 10 in position. In an alternative embodiment (not shown) perfectly equivalent to the one in Figure 31, the two lateral tabs 13 are connected to opposite ends of bottom wall 11, are folded 90° with respect to bottom wall 11 onto lateral walls 10, and are glued by glue 25 to lateral walls 10.

[0032] Choosing which of the above embodiments of stiffener 8 to employ depends on the relationship between the thickness of group 4 of cigarettes (and therefore the size of bottom wall 11 of stiffener 8) and the size of recess 12 (which, to avoid waste, also affects the shape and size of bottom tab 14 and appendix 15).

[0033] Number 26 in Figure 32 indicates as a whole a packing machine for producing packet 1 of cigarettes in Figures 1, 2 and 3. Packing machine 26 comprises a packing section 27 for producing sealed inner packages 3; and a follow-up packing section 28 for producing outer containers 2 by folding rigid blanks 29 about the sealed inner packages 3 from packing section 27.

[0034] As shown in Figure 33, packing section 27 comprises a forming unit 30 for producing groups 4 of ciga-

rettes, and for producing stiffeners 8 by folding blanks 18; a coupling unit 31 for fitting groups 4 of cigarettes with respective stiffeners 8; and a packing unit 32 for producing sealed inner packages 3 by folding and heat-sealing a strip 33 of packing material (complete with extraction openings 5 and superimposed sealing flaps 6) about groups 4 of cigarettes fitted with respective stiffeners 8.

[0035] Forming unit 30 comprises a hopper 34 with four outlets; and a forming belt conveyor 35 supporting a number of forming pockets 36. Forming conveyor 35 feeds each forming pocket 36 from an input station 37, located in front of an outlet of hopper 34 and where a group 4 of cigarettes is expelled from the outlet of hopper 34 into forming pocket 36, to an output station 38 where the group 4 of cigarettes is expelled from forming pocket 36. Forming unit 30 also comprises a folding belt conveyor 39 supporting a number of folding pockets (not shown) and extending parallel to and alongside forming conveyor 35. Folding conveyor 39 feeds each folding pocket from an input station 40, where a blank 18 is fed into the folding pocket; through a number of folding stations, where blank 18 is folded (completely or partly) to form a stiffener 8; and to an output station 41, where the stiffener 8 is expelled from the folding pocket.

[0036] As shown in Figure 38, coupling unit 31 comprises a coupling conveyor 42, which is positioned perpendicular to forming conveyor 35 and folding conveyor 39, picks up each group 4 of cigarettes at output station 38 of forming conveyor 35, couples group 4 of cigarettes with a corresponding stiffener 8 at a coupling station 43 (located over and aligned vertically with output station 41 of folding conveyor 39), and feeds group 4 of cigarettes, fitted with stiffener 8, to an input station 44 of packing unit 32. Coupling conveyor 42 comprises an endless belt 45 fitted with a number of paddles 46, which push groups 4 of cigarettes along a slide surface 47 connecting output station 38 of forming conveyor 35 to input station 44 of packing unit 32.

[0037] Slide surface 47 is static (i.e. mounted in a fixed position) and is connected to an elevator 47a movable vertically between a bottom position (Figure 38), in which elevator 47a is located at output station 41 of folding conveyor 39, and a top position (not shown in Figure 38), in which elevator 47a is located at coupling station 43. Slide surface 47 has a through opening, through which a stiffener 8 is raised by elevator 47a. In actual use, elevator 47a is moved into the bottom position to pick up a stiffener 8, and is then raised to feed stiffener 8 into coupling station 43, where stiffener 8 intercepts and couples with a corresponding group 4 of cigarettes (i.e. as it moves along, group 4 of cigarettes impacts bottom wall 11 of stiffener 8, thus drawing stiffener 8 along with it). In a preferred embodiment, the end of slide surface 47 around the through opening is designed to finish folding bottom tab 14 and appendix 15 as stiffener 8 is pushed up by elevator 47a.

[0038] As shown in Figure 39, packing unit 32 com-

prises a packing conveyor 48, which feeds each group 4 of cigarettes (fitted with respective stiffener 8) along a straight packing path P. A fixed folding device 49 (shown schematically in Figure 35) winds strip 33 of packing material longitudinally, i.e. parallel to packing path P, about packing path P to bring the two opposite edges of strip 33 of packing material into contact and so form a tubular wrapping enclosing groups 4 of tobacco articles (fitted with respective stiffeners 8). Packing unit 32 also comprises a heat-sealing device 50 (shown schematically in Figures 35 and 40) located downstream from folding device 49, and which heat-seals the two opposite overlapping edges of strip 33 of packing material longitudinally, i.e. parallel to packing path P, to stabilize the tubular wrapping. Packing unit 32 also comprises a heat-sealing device 51 (shown schematically in Figures 35 and 40) located downstream from heat-sealing device 50, and which heat-seals and cuts the tubular wrapping transversely, i.e. perpendicularly to packing path P, upstream and downstream from each group 4 of cigarettes (fitted with respective stiffener 8), to complete sealed inner packages 3.

[0039] It is important to note that packing conveyor 48 feeds each group 4 of cigarettes (fitted with respective stiffener 8) transversely along packing path P, i.e. with the longitudinal axes of the cigarettes perpendicular to packing path P and to the longitudinal heat-seal, and parallel to the transverse heat-seals. Feeding groups 4 of cigarettes along the packing path in this way is extremely important, by enabling the formation of sealed inner packages 3 with the transverse heat-seals along the lateral walls, and with no heat-seals at all on the bottom wall and, more importantly, on the top wall in which extraction opening 5 is formed.

[0040] As stated, strip 33 of packing material is already complete with extraction openings 5 covered with open-close sealing flaps 6, which are formed and applied respectively at work stations (not shown) upstream from packing unit 32. On strip 33 of packing material, extraction openings 5 covered with open-close sealing flaps 6 are located on the opposite side of the tubular wrapping to the longitudinal heat-seal, and are centred between the two transverse heat-seals. In a different embodiment not shown, extraction openings 5 covered with open-close sealing flaps 6 may be located on the same side as the longitudinal heat-seal and, as opposed to being centred, may be more or less asymmetrical in shape and/or position.

[0041] As shown in Figure 39, packing conveyor 48 comprises a static (i.e. stationary) slide surface 52, along which each group 4 of cigarettes slides, and about which strip 33 of packing material is wound; and a push device 53 located over groups 4 of cigarettes, and which pushes each group 4 of cigarettes along packing path P. Push device 53 comprises a conveyor belt 54, which is located over each group 4 of cigarettes, extends parallel to packing path P, presses each group 4 of cigarettes against slide surface 52, and comprises paddles 55, which

project from conveyor belt 54 and are positioned upstream and downstream from, to define a seat for, each group 4 of cigarettes.

[0042] Finally, packing unit 32 comprises a feed conveyor 56, which receives groups 4 of cigarettes from coupling conveyor 42 at input station 44, and feeds groups 4 of cigarettes onto slide surface 52. Feed conveyor 56 comprises two parallel, side by side conveyor belts 57 located beneath groups 4 of cigarettes, and on which groups 4 of cigarettes rest. Each conveyor belt 57 comprises paddles 58, which project from conveyor belt 57 and are positioned upstream and downstream from, to define a seat for, each group 4 of cigarettes.

[0043] In a preferred embodiment, packing unit 32 comprises two conveyor belts 59 positioned facing each other on opposite sides of packing path P, directly upstream from heat-sealing device 50. As strip 33 of packing material is wound, the two conveyor belts 59 press on opposite sides of the tubular wrapping to compress the two opposite longitudinal edges of the tubular wrapping transversely (i.e. the two conveyor belts 59 press on the longitudinally oriented bottom wall and top wall of each sealed inner package 3 in the making).

[0044] As shown more clearly in Figure 40, longitudinally heat-sealing (by means of heat-sealing device 50) the two opposite overlapping edges of strip 33 of packing material to stabilize the tubular wrapping produces a longitudinal fin 60, which initially projects perpendicularly from the tubular wrapping. In a preferred embodiment, heat-sealing device 50 forming the longitudinal heat-seal is connected to a folding device, which folds the longitudinal fin 60 ninety degrees and presses it onto the tubular wrapping. Likewise, each transverse heat-seal (by heat-sealing device 51) on the tubular wrapping produces a transverse fin 61, which initially projects perpendicularly from (i.e. from a lateral wall of) the corresponding sealed inner package 3. In a preferred embodiment, a folding device downstream from heat-sealing device 51 folds each transverse fin 61 ninety degrees and presses it onto the corresponding sealed inner package 3 (i.e. onto a lateral wall of the corresponding sealed package 3). Each transverse fin 61 is preferably fixed (heat-sealed or glued) to the corresponding sealed inner package 3 (i.e. to a lateral wall of the corresponding sealed package 3) so that it remains permanently contacting sealed inner package 3.

[0045] It is important to note that, whereas each transverse fin 61 must be fixed to remain permanently contacting the corresponding sealed inner package 3, the transverse heat-seals provide for holding the longitudinal fin 60 permanently contacting the corresponding sealed inner package 3.

[0046] Figures 4b and 4c show a sealed inner package 3 prior to folding (fixing) the two transverse fins 61, and Figure 4a a sealed inner package 3 after the two transverse fins 61 are folded (fixed).

[0047] In the Figure 32-40 embodiment, each group 4 of cigarettes is formed on forming conveyor 35 independently and separately from the corresponding stiffener 8;

each stiffener 8 is folded on folding conveyor 39 independently and separately from formation of the corresponding group 4 of cigarettes; and each pre-formed group 4 of cigarettes is coupled on coupling conveyor 42 with the corresponding pre-folded stiffener 8. As stated, forming conveyor 35 for forming groups 4 of cigarettes extends parallel to and alongside folding conveyor 38 for folding stiffeners 8; whereas coupling conveyor 42, on which each pre-formed group 4 of cigarettes is coupled with the corresponding pre-folded stiffener 8, is perpendicular to forming conveyor 35 and folding conveyor 38.

[0048] In the Figure 41-43 embodiment, on the other hand, each stiffener 8 is fed into a forming pocket 36 on forming conveyor 35, upstream from hopper 34; and each group 4 of cigarettes is transferred from hopper 34 into forming pocket 36 (containing stiffener 8) and directly into stiffener 8. In this embodiment, as opposed to extending parallel to and alongside forming conveyor 35, folding conveyor 39 for folding stiffeners 8 is located upstream from forming conveyor 35 to feed stiffeners 8, already folded, to the start of forming conveyor 35.

[0049] For the sake of simplicity, Figures 41-43 show a simplified stiffener 8 with only front wall 9 and lateral walls 10 (i.e. with no bottom wall 11). Though, clearly, stiffener 8 in the Figure 41-43 embodiment may also be as described with reference to Figures 6-31.

[0050] In one embodiment, packing unit 32 comprises a processing device for extracting air (by suction) from the tubular wrapping to form vacuum-sealed inner packages 3. Alternatively, in addition to extracting air by suction from the tubular wrapping, the processing device also injects inert gas to form controlled-atmosphere sealed inner packages 3.

[0051] In a different embodiment not shown, packing machine 26 only comprises packing section 27 for producing sealed inner packages 3, which are marketed as they are, without outer containers 2 (i.e. each packet 1 of cigarettes only comprises a sealed package 3, and has no outer container 2); or else a further packing machine (separate from and fully independent of packing machine 26) receives sealed inner packages 3 from packing machine 26, and forms outer containers 2 about sealed inner packages 3.

[0052] Sealed inner package 3 described above has numerous advantages.

[0053] Firstly, it can be produced using the 'flow-pack' method, ensuring the correct shape of group 4 of cigarettes. Essential to ensuring the correct shape of group 4 of cigarettes is the fact that stiffener 8 comprises a system for connecting bottom wall 11 to lateral walls 10, and for preventing bottom wall 11 from moving with respect to lateral walls 10 (or, conversely, preventing lateral walls 10 from moving with respect to bottom wall 11). This connecting system, in fact, increases the rigidity of stiffener 8 and so further prevents unwanted movements of the cigarettes in group 4, particularly when forming the tubular wrapping.

[0054] Moreover, in a preferred but non-limiting embodiment, the system connecting bottom wall 11 and lateral walls 10 has no glue, thus eliminating any glue inside sealed inner package 3, and the possibility of the substances in the glue somehow altering the taste and/or

[0055] Given its numerous advantages, the design of packet 1 of cigarettes described may also be used for producing a carton of cigarettes, which is substantially the same as packet 1 described, except that it contains a group of packets of cigarettes as opposed to a group of cigarettes, or for producing a packet of cigars or similar, which is substantially the same as packet 1 described, except that it contains a group of cigars or similar, as opposed to a group of cigarettes.

each lateral wall (10) comprises a lateral wing (22), which is folded 180° with respect to and onto the lateral wall (10);

the connecting system comprises at least two slits (24) formed through the front wall (9); and the connecting system comprises, for each lateral wing (22), at least one projection (23), which fits inside a corresponding slit (24) in the front wall (9) to form a joint between the projection (23) and the slit (24).

5. A package (1) according to any one of Claims 1 to 4, and comprising a hinged-lid outer container (2) housing the sealed inner package (3).

Claims

1. A package (1) of tobacco articles, comprising:

a group (4) of tobacco articles;
a sealed inner package (3) enclosing the group (4) of tobacco articles and having an extraction opening (5) from which to extract the tobacco articles and closed by a sealing flap (6); and
a stiffener (8) located inside the sealed inner package (3), contacting the group (4) of tobacco articles, and which comprises a front wall (9) contacting the cylindrical lateral walls of the tobacco articles; two lateral walls (10) located on opposite sides of the front wall (9) and contacting the cylindrical lateral walls of the tobacco articles; and a bottom wall (11) contacting the tips of the tobacco articles;
the package (1) being **characterized in that:**

the stiffener (8) comprises a connecting system for connecting the bottom wall (11) to the lateral walls (10) of the stiffener (8), to prevent movement of the two lateral walls (10) with respect to the bottom wall (11); and the bottom wall (11) comprises two lateral tabs (13), which are folded 90° with respect to the bottom wall (11) onto the lateral walls (10), and are secured mechanically to the lateral walls (10) by the connecting system.

2. A package (1) according to Claim 1, wherein the connecting system comprises glue (25) securing the lateral tabs (13) to the lateral walls (10).
3. A package (1) according to Claim 1, wherein the connecting system has no glue, and the lateral tabs (13) are secured to the lateral walls (10) by a mechanical joint.
4. A package (1) according to Claim 3, wherein:

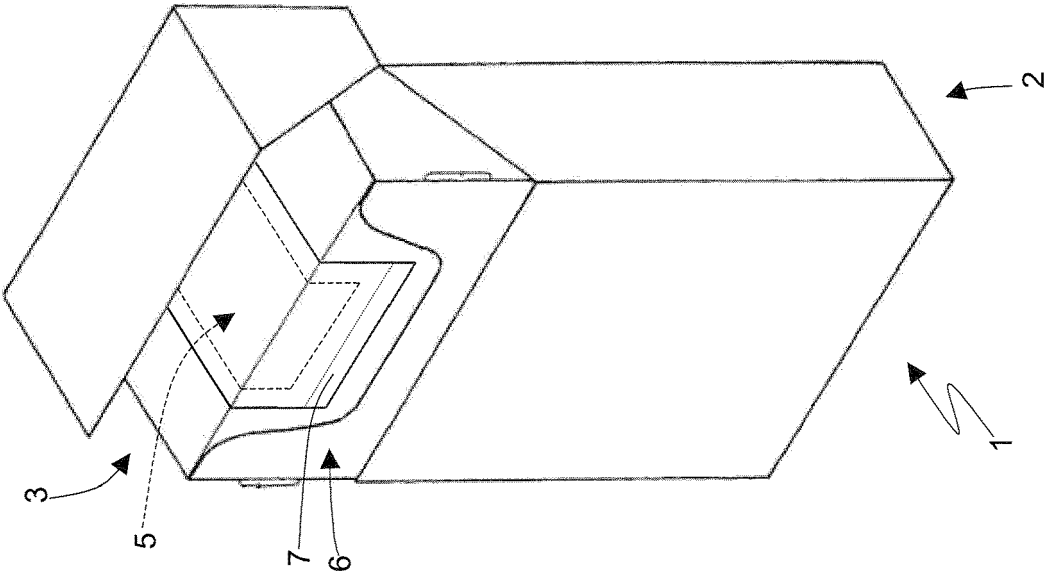


Fig. 2

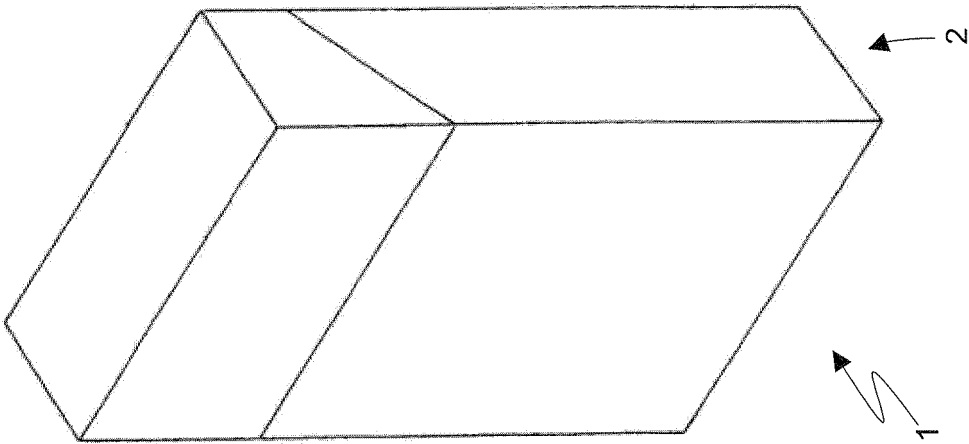


Fig. 1

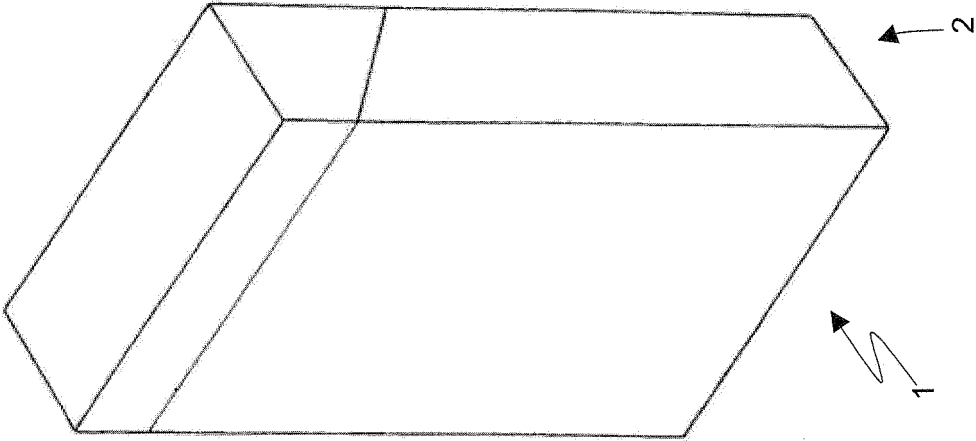


Fig. 3

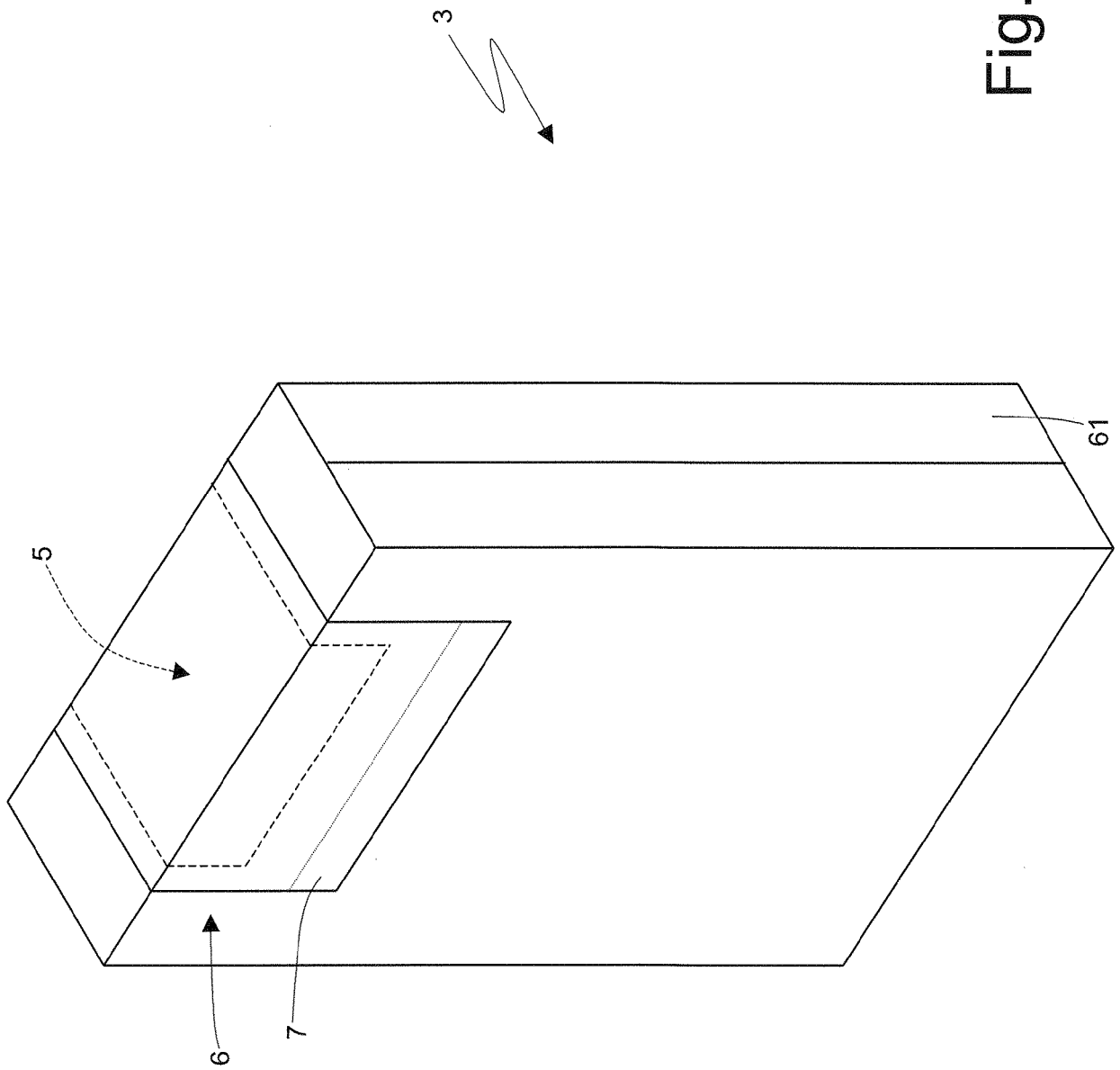
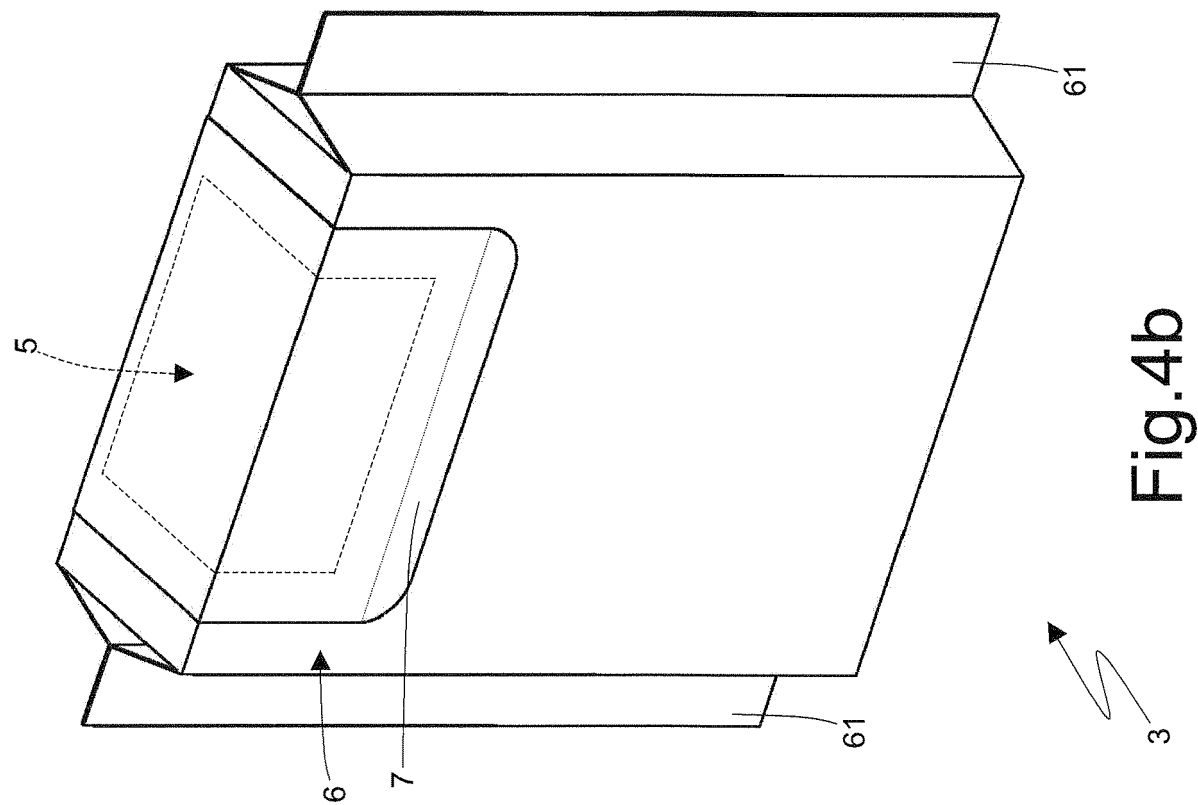
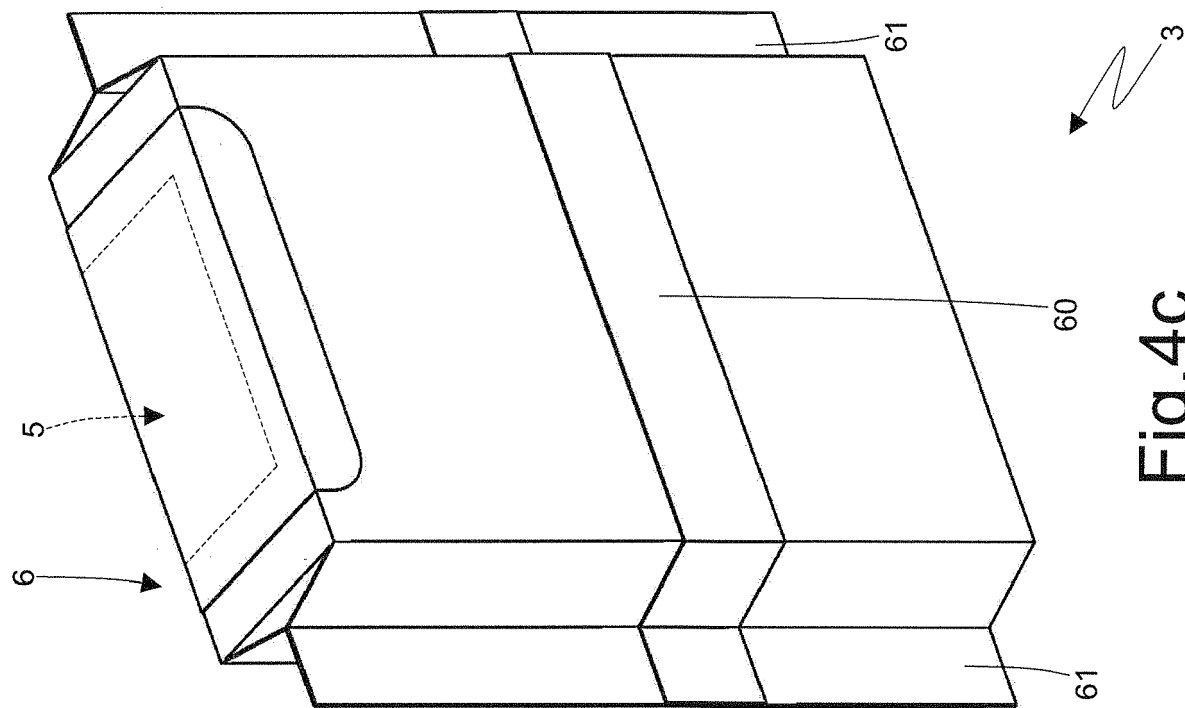


Fig. 4a



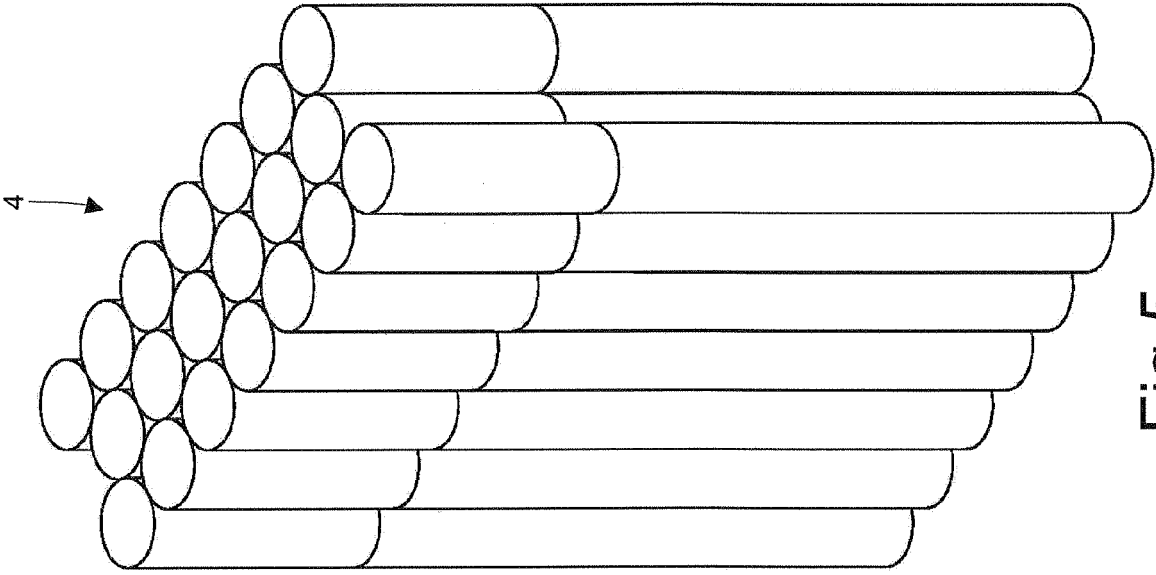


Fig. 5

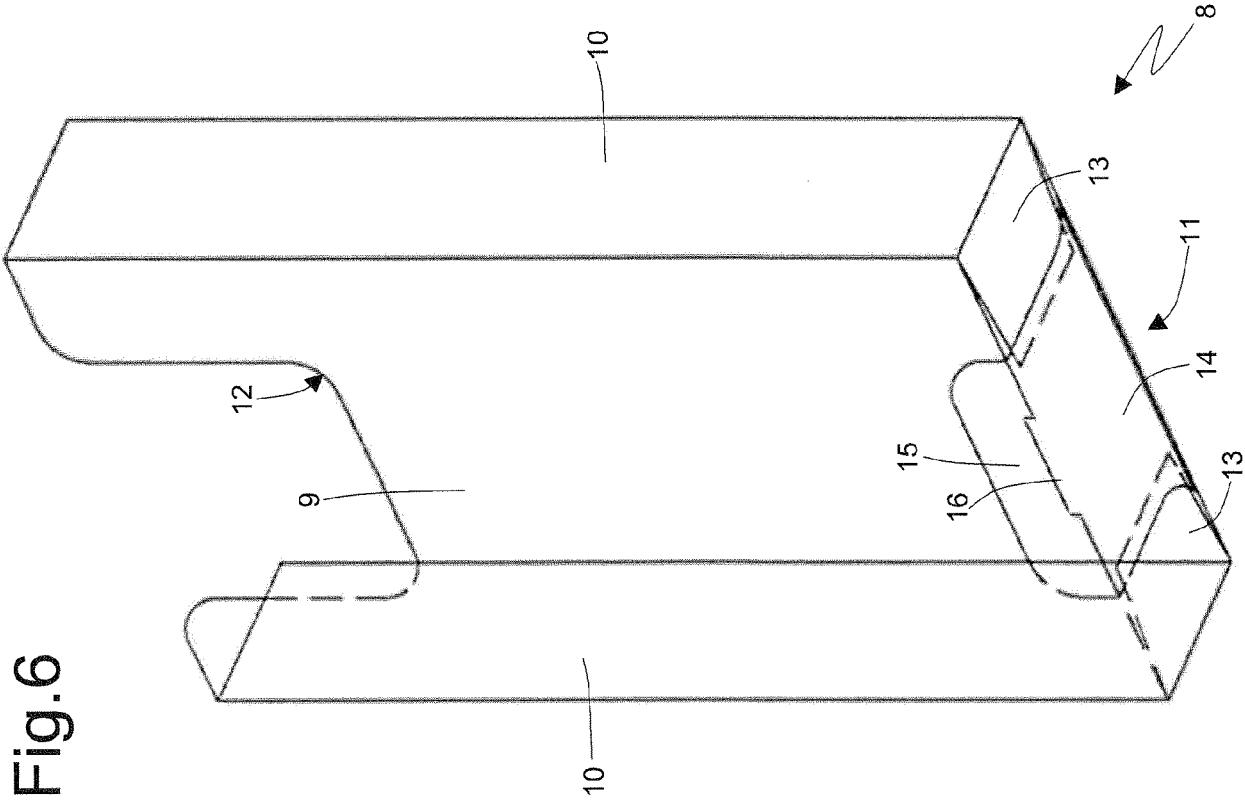


Fig. 6

Fig.7

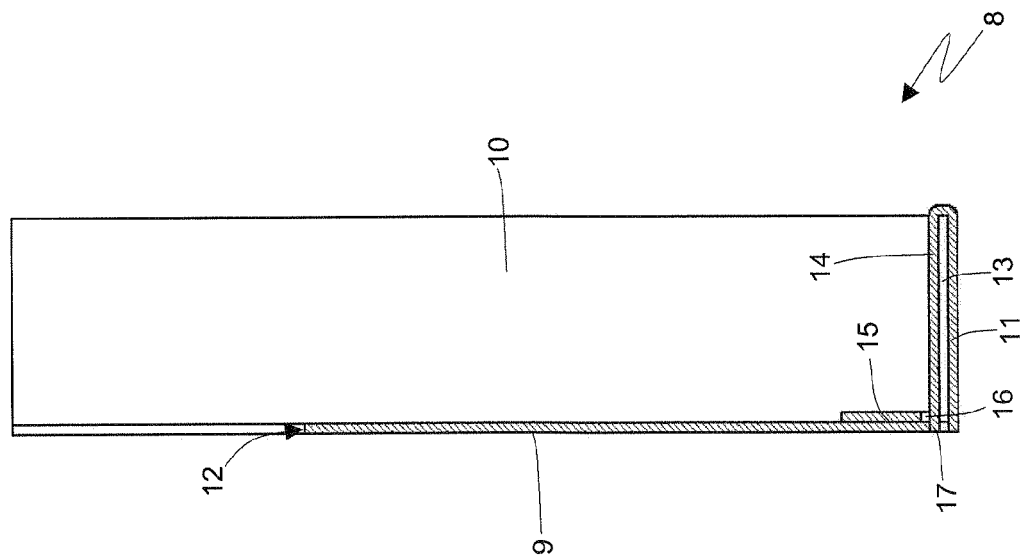
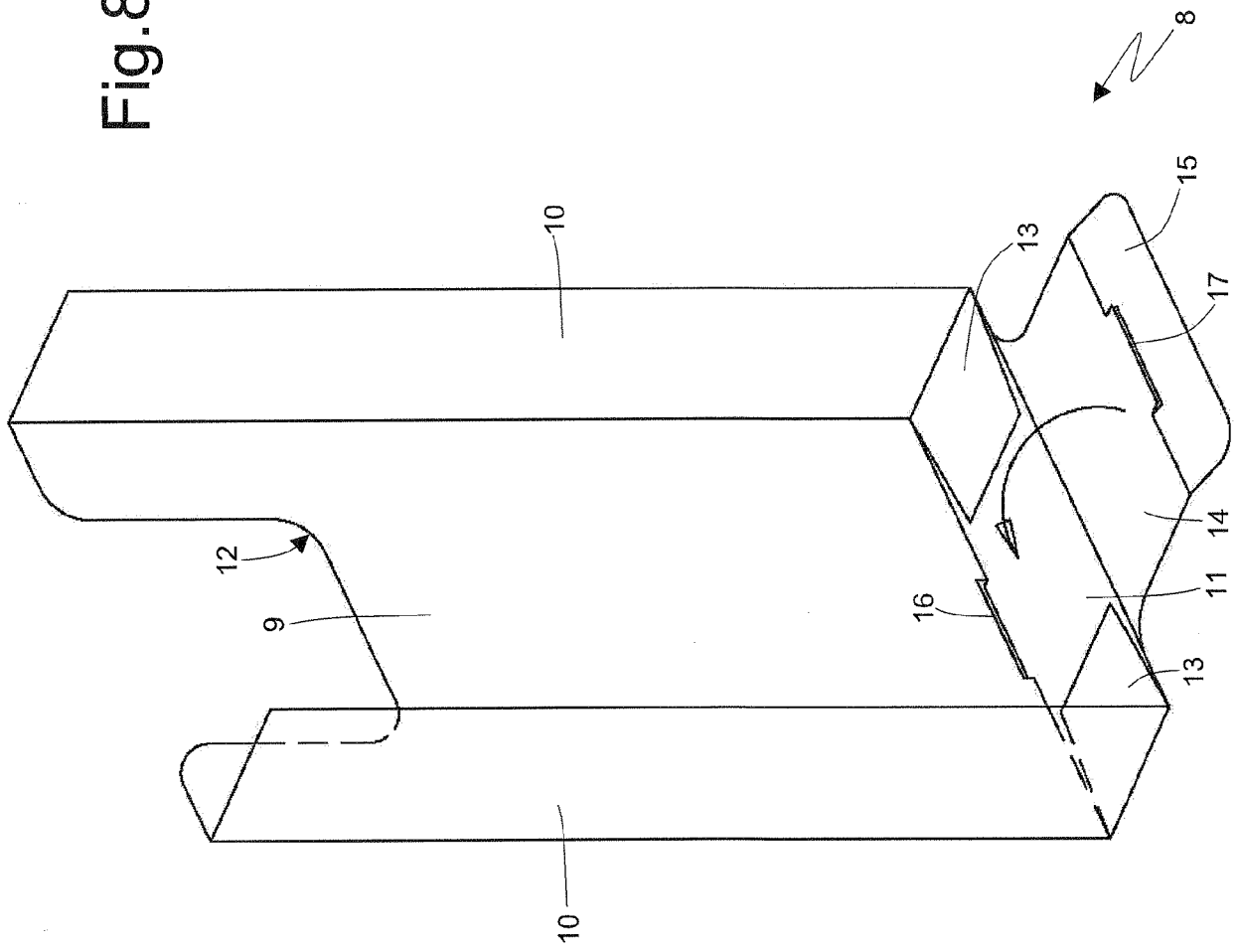


Fig.8



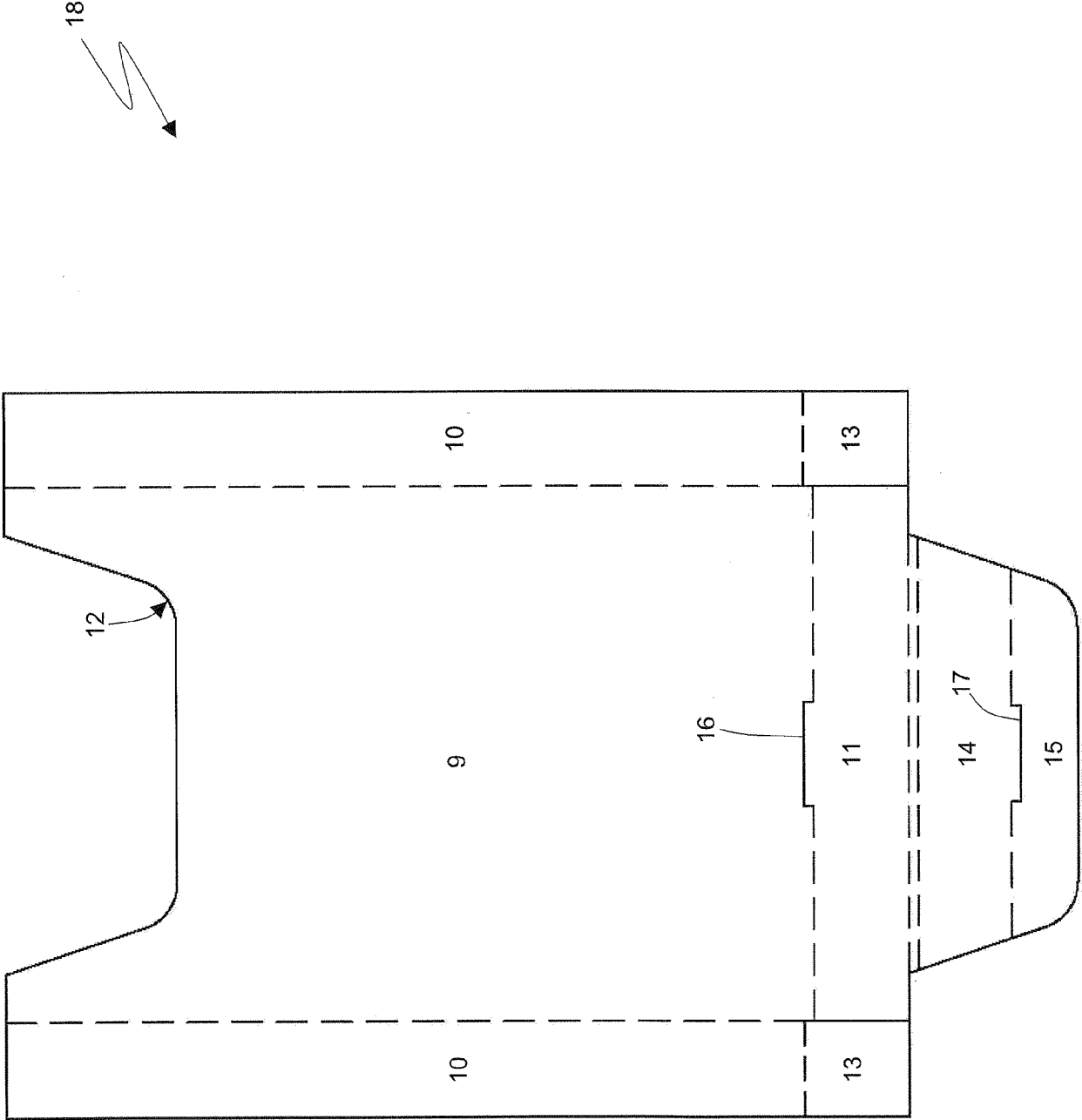


Fig. 9

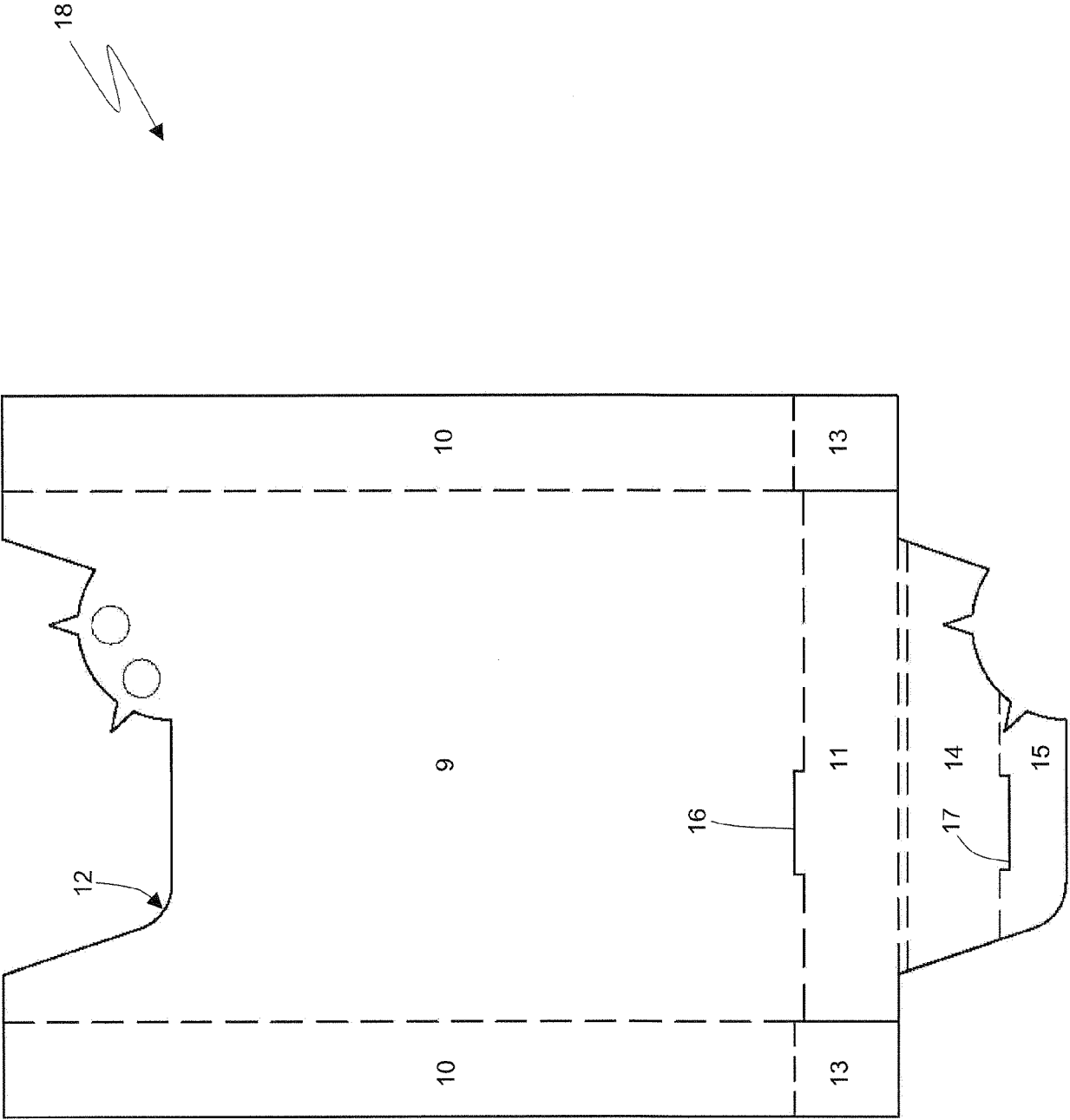


Fig. 10

Fig.11

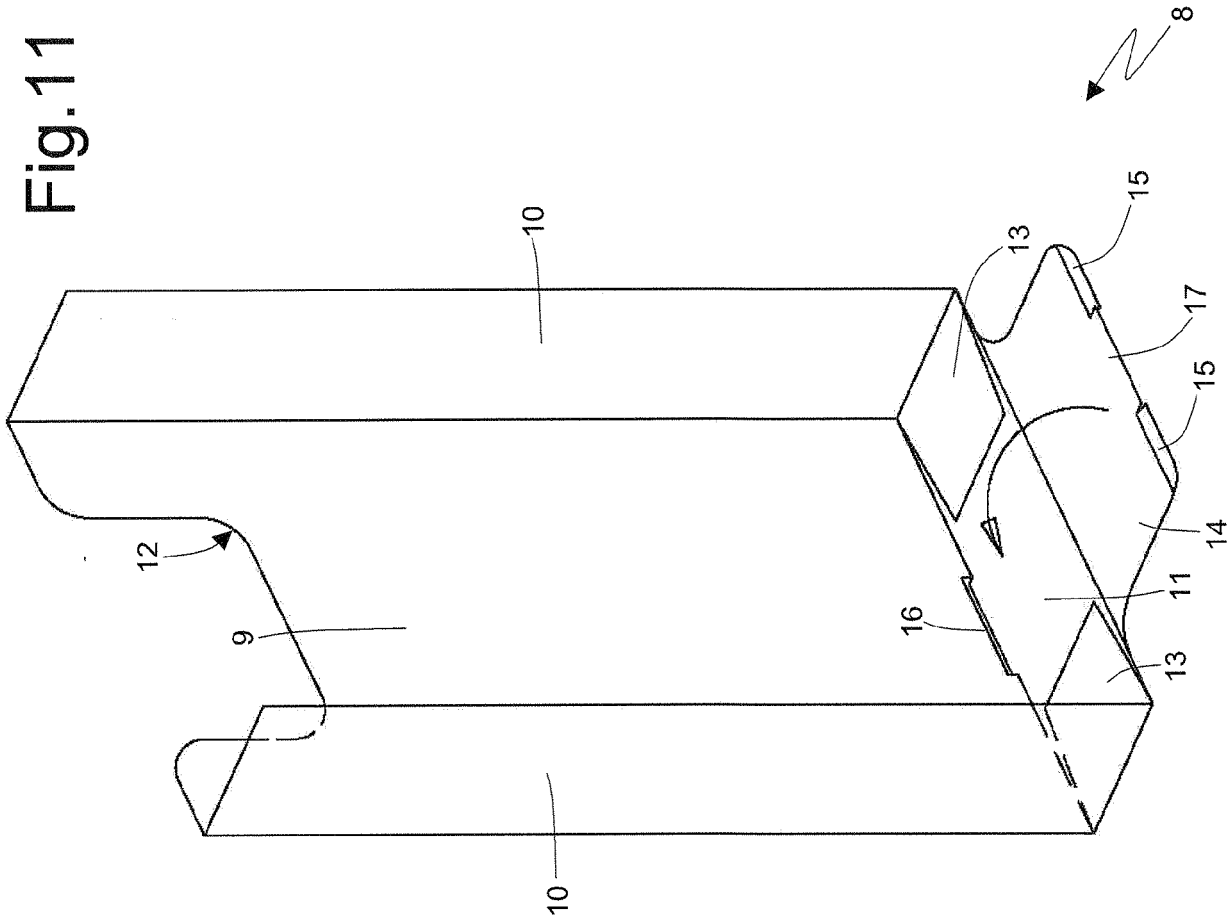


Fig.12

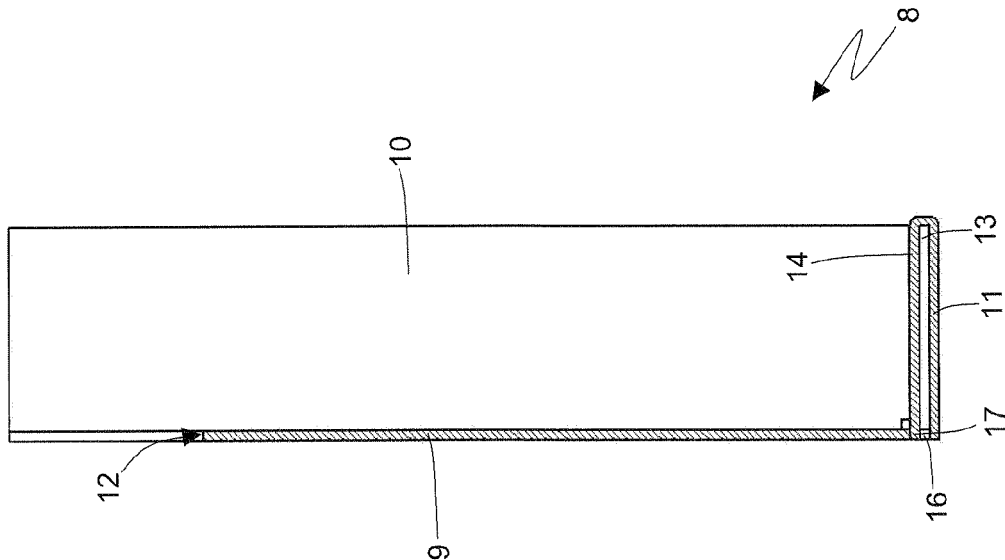


Fig.13

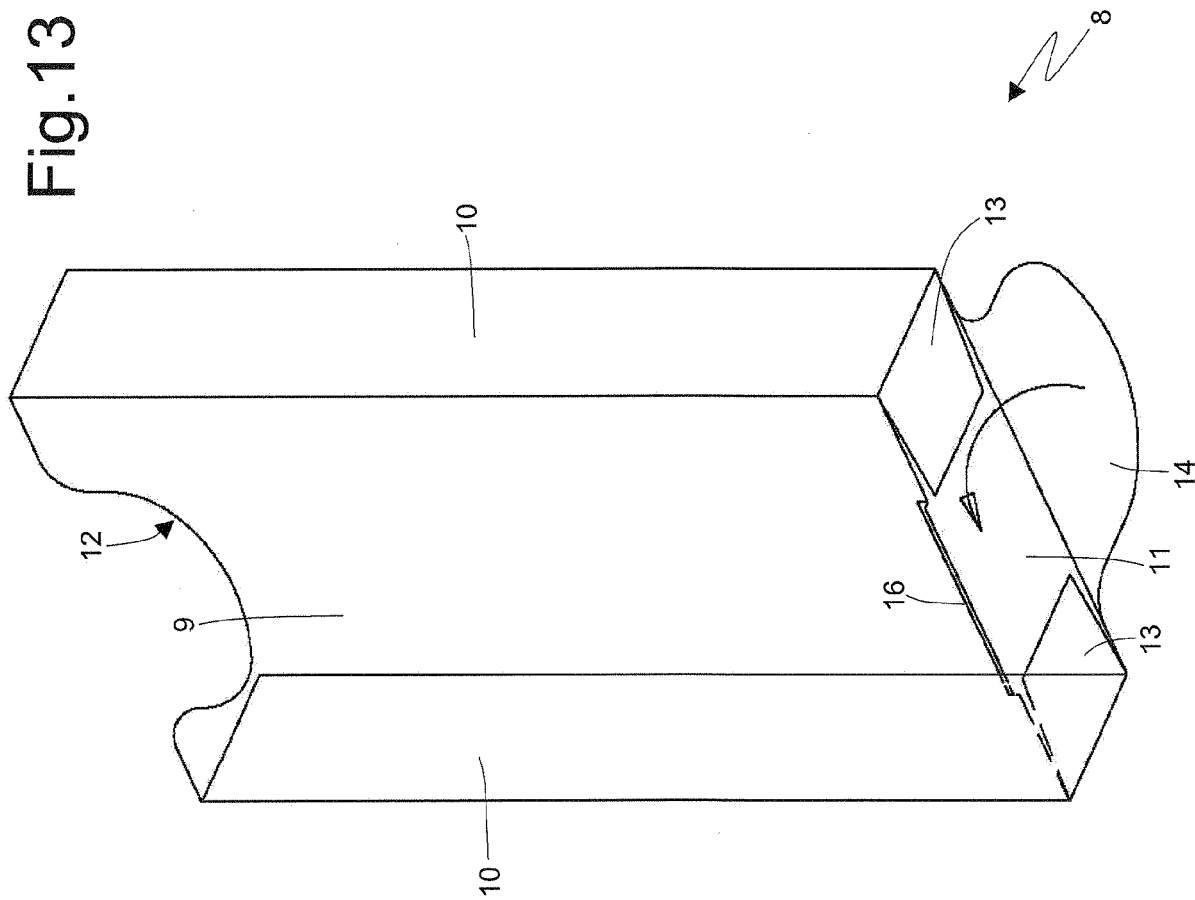
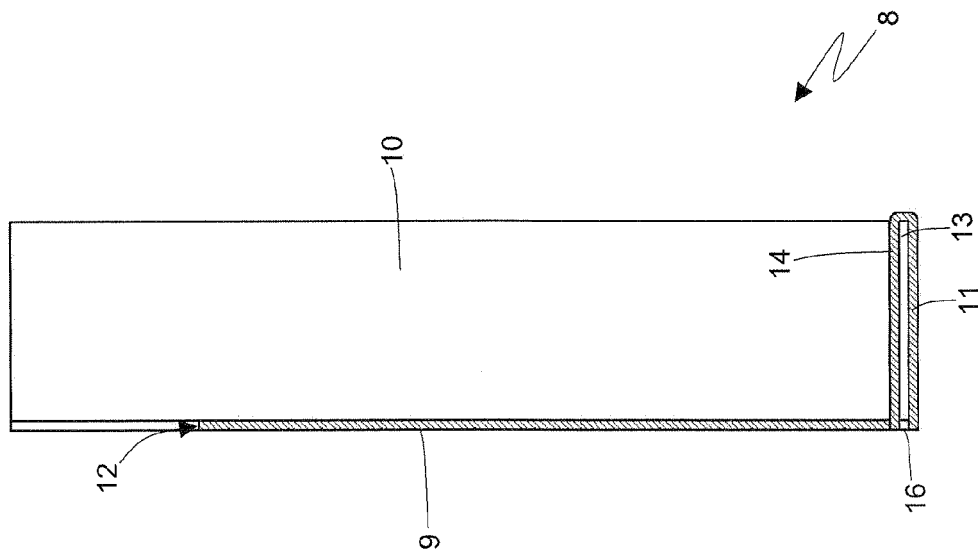


Fig.14



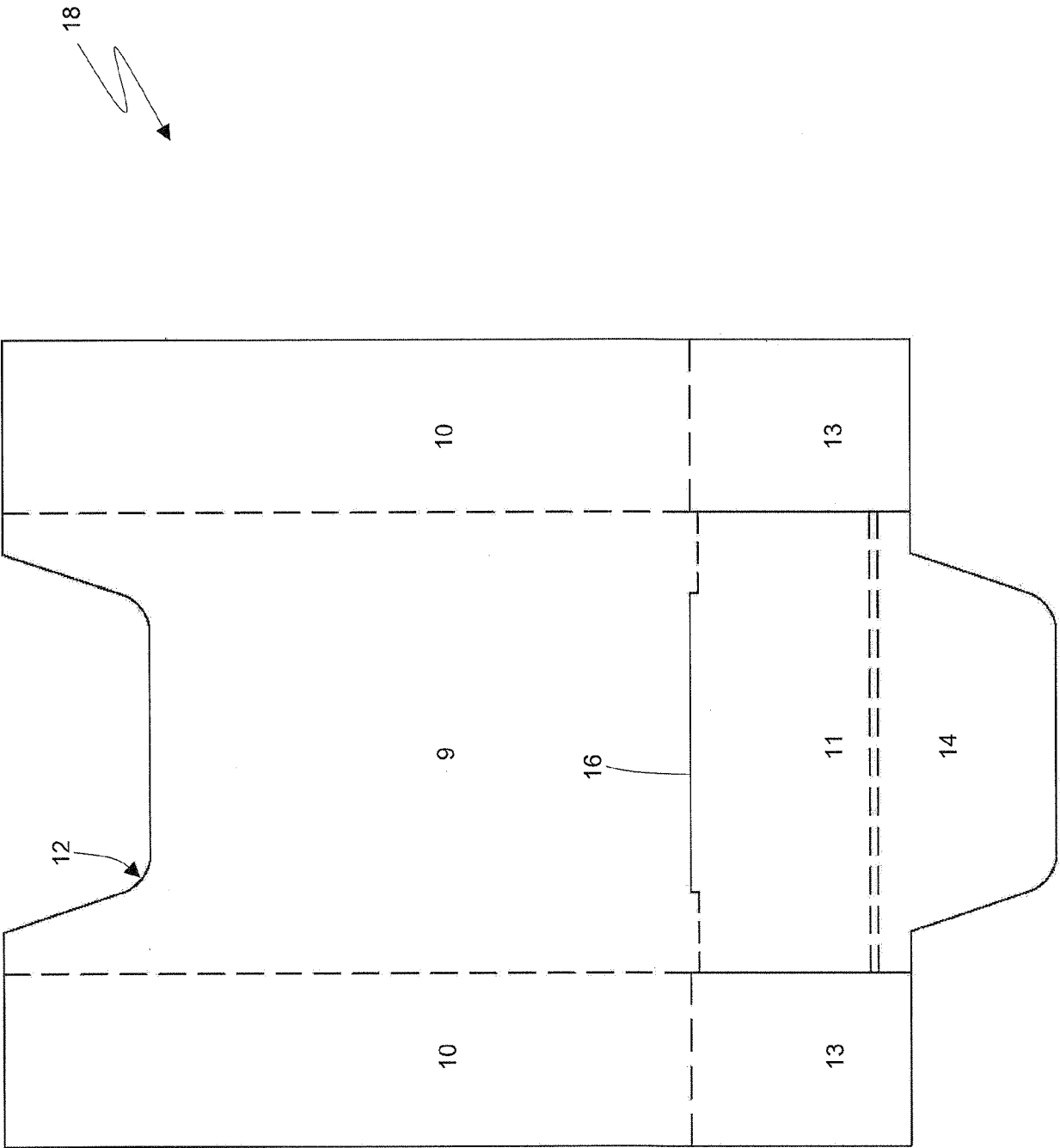


Fig.15

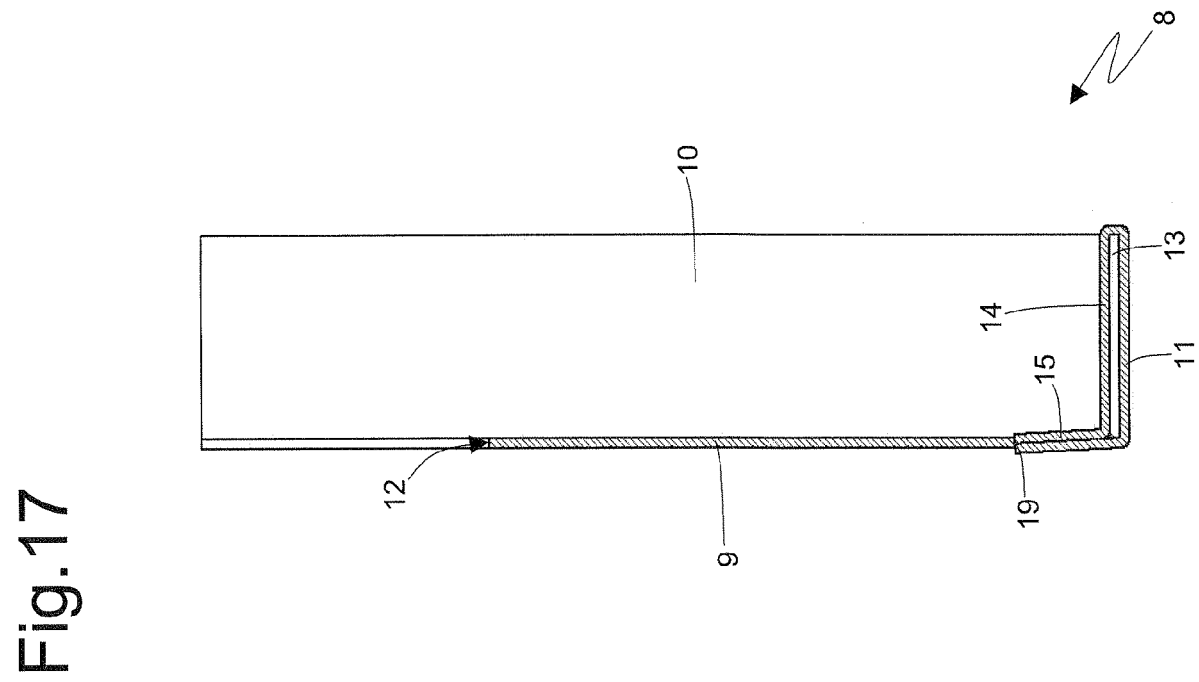
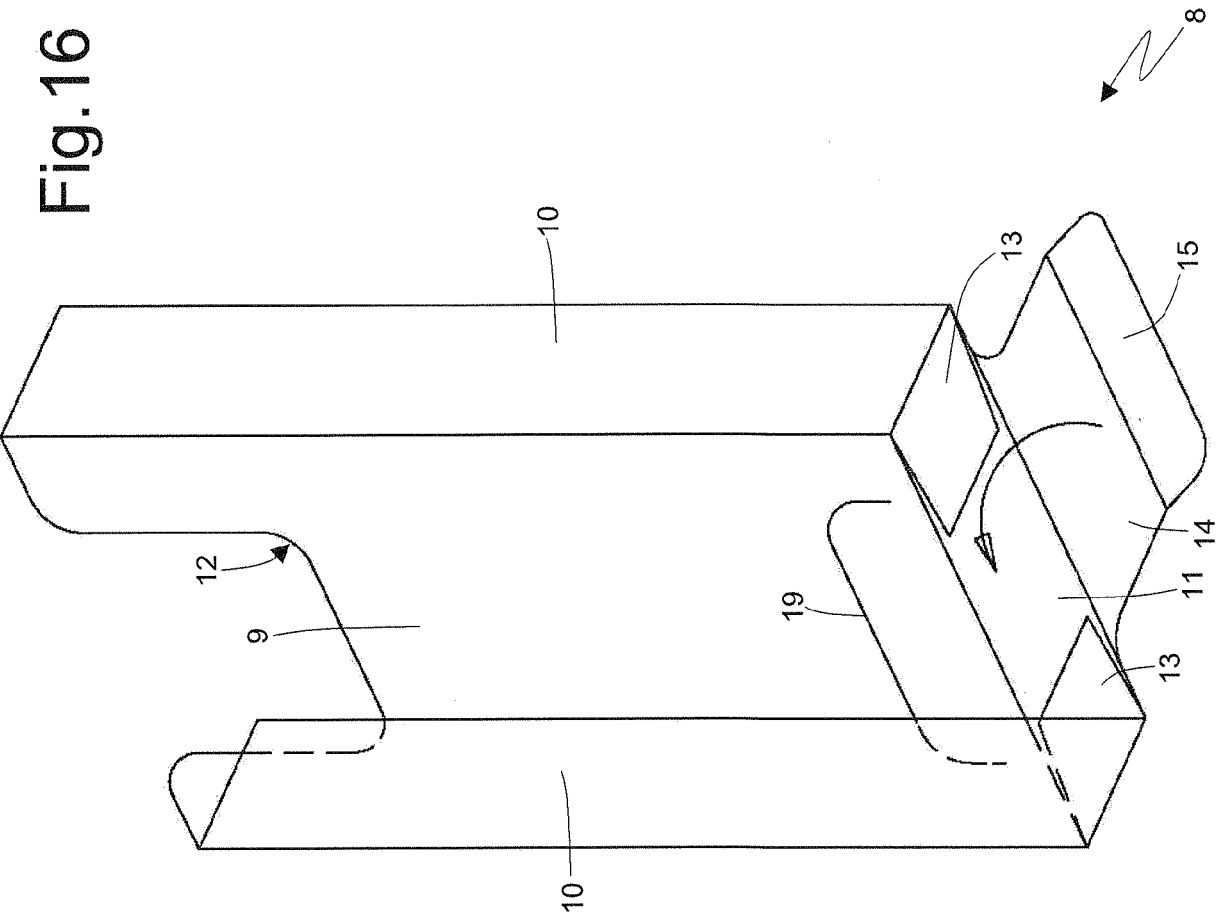


Fig.18

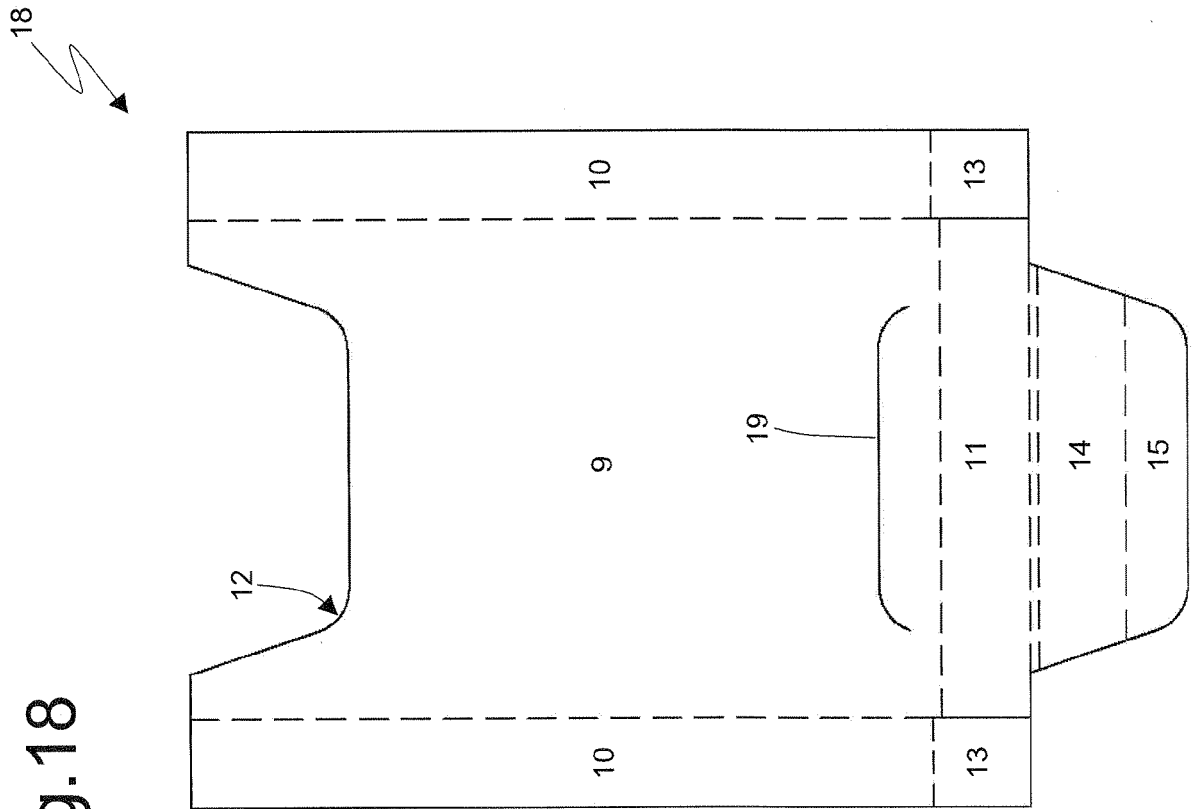


Fig.19

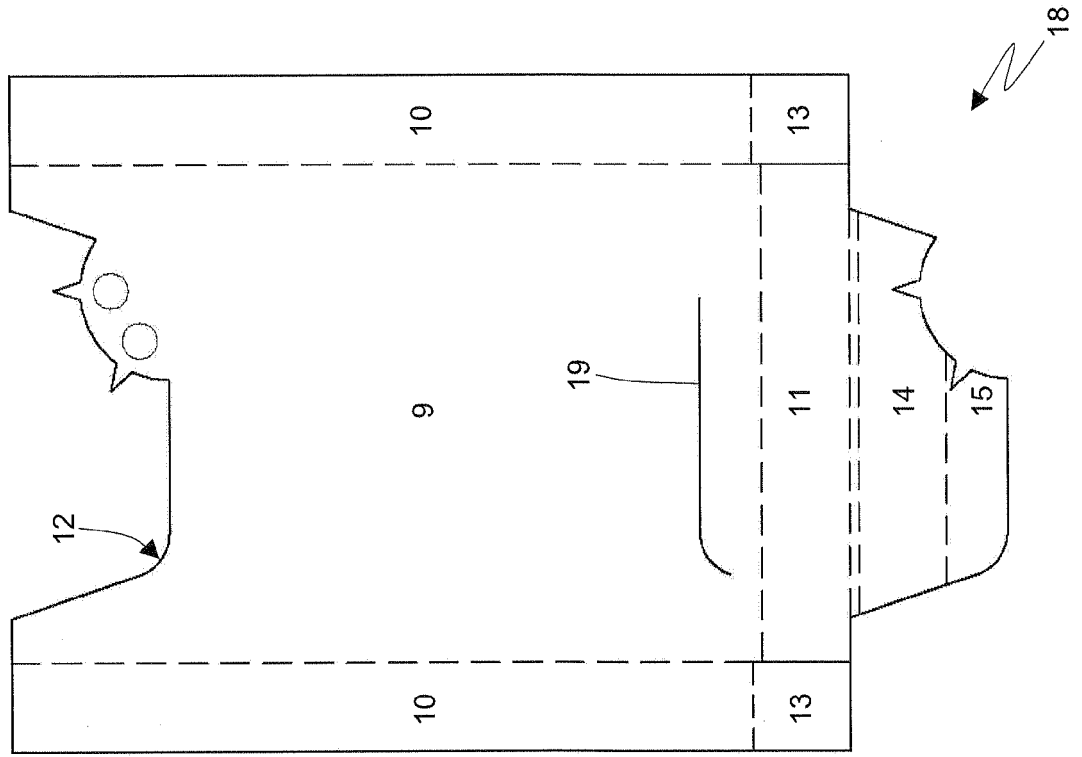


Fig.20

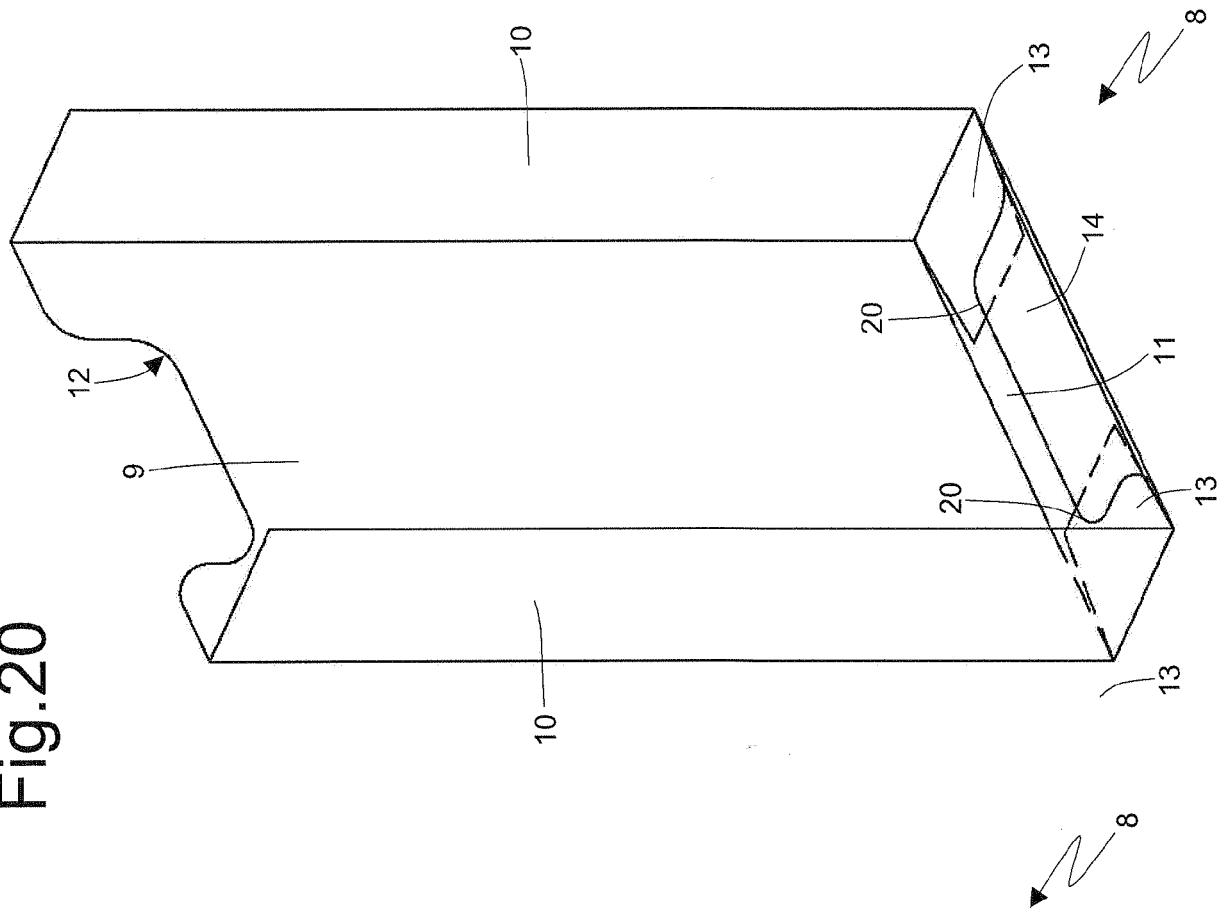


Fig.21

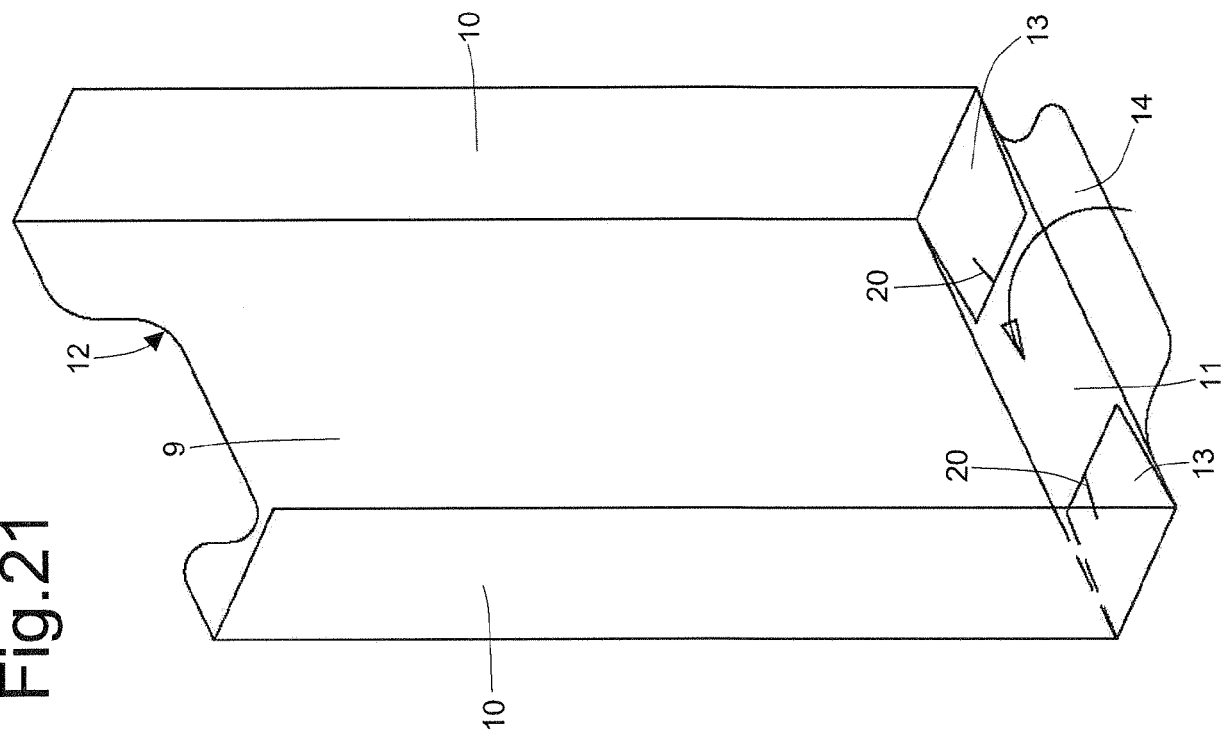


Fig. 23

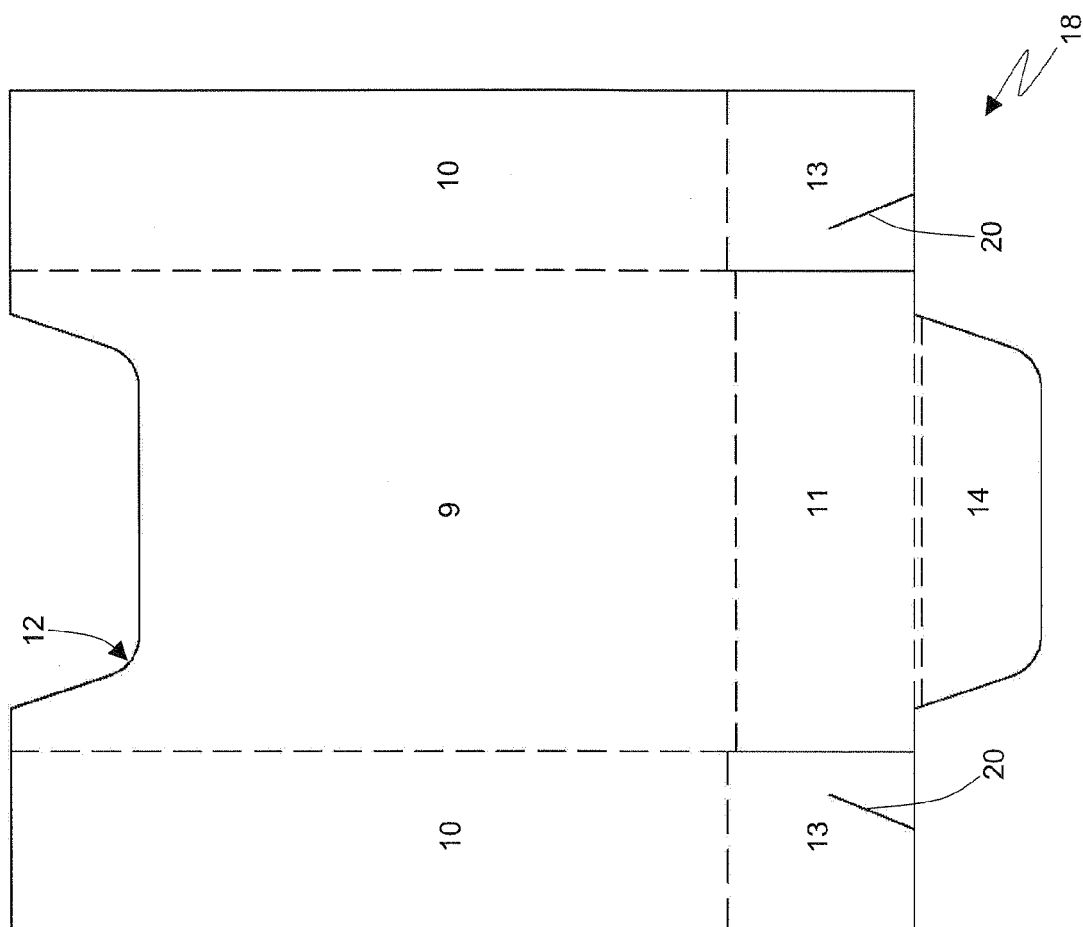
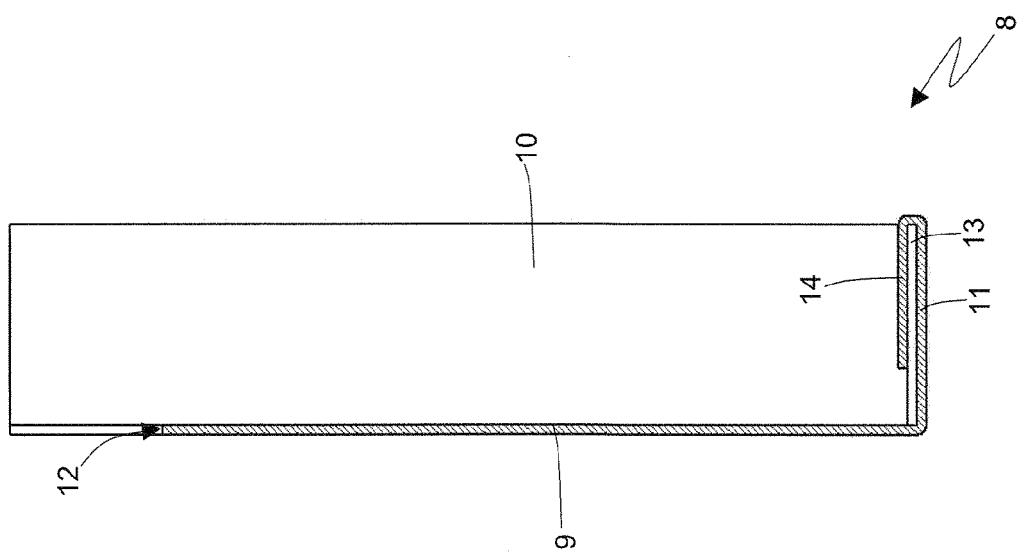


Fig. 22



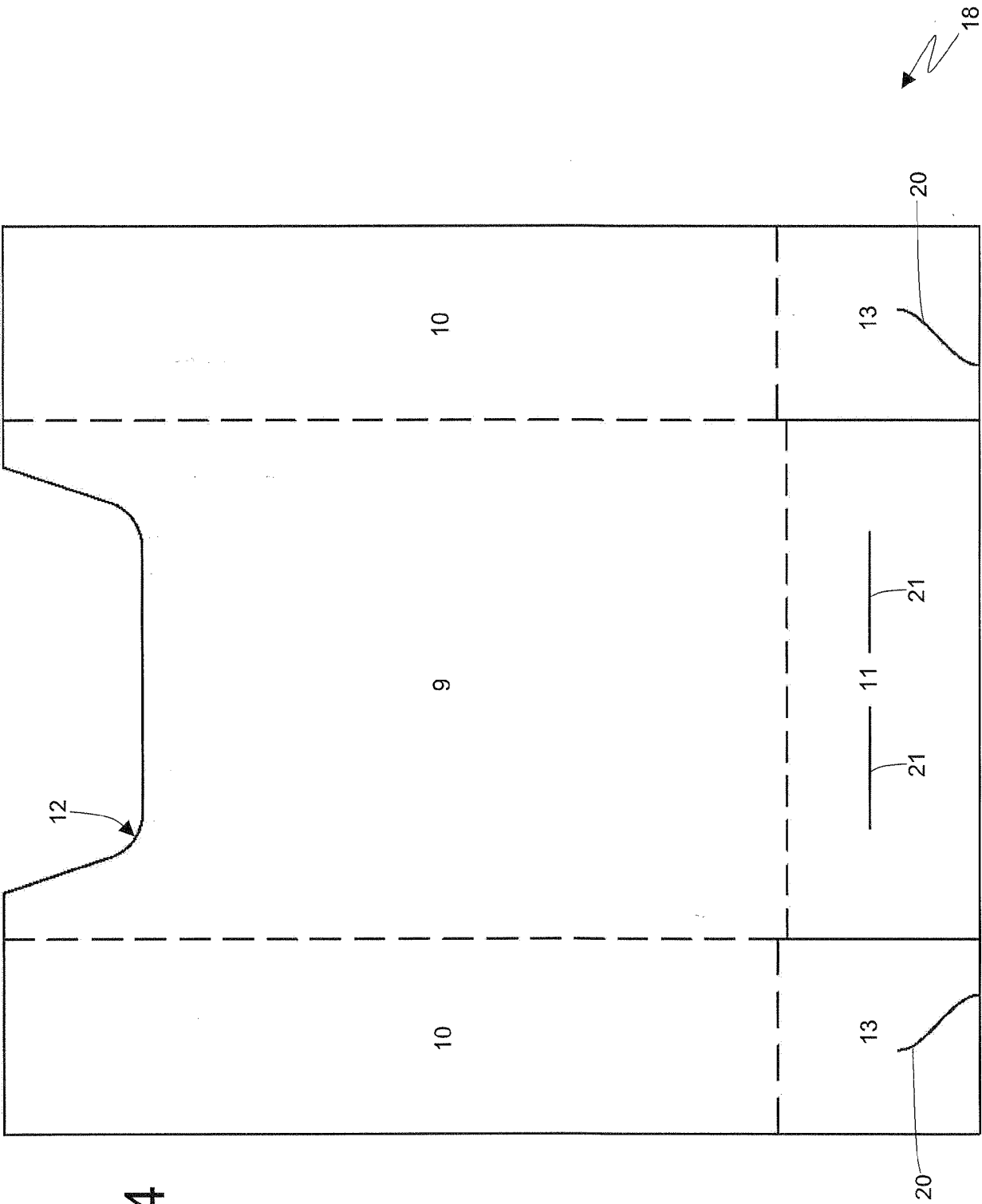


Fig. 24

Fig.26

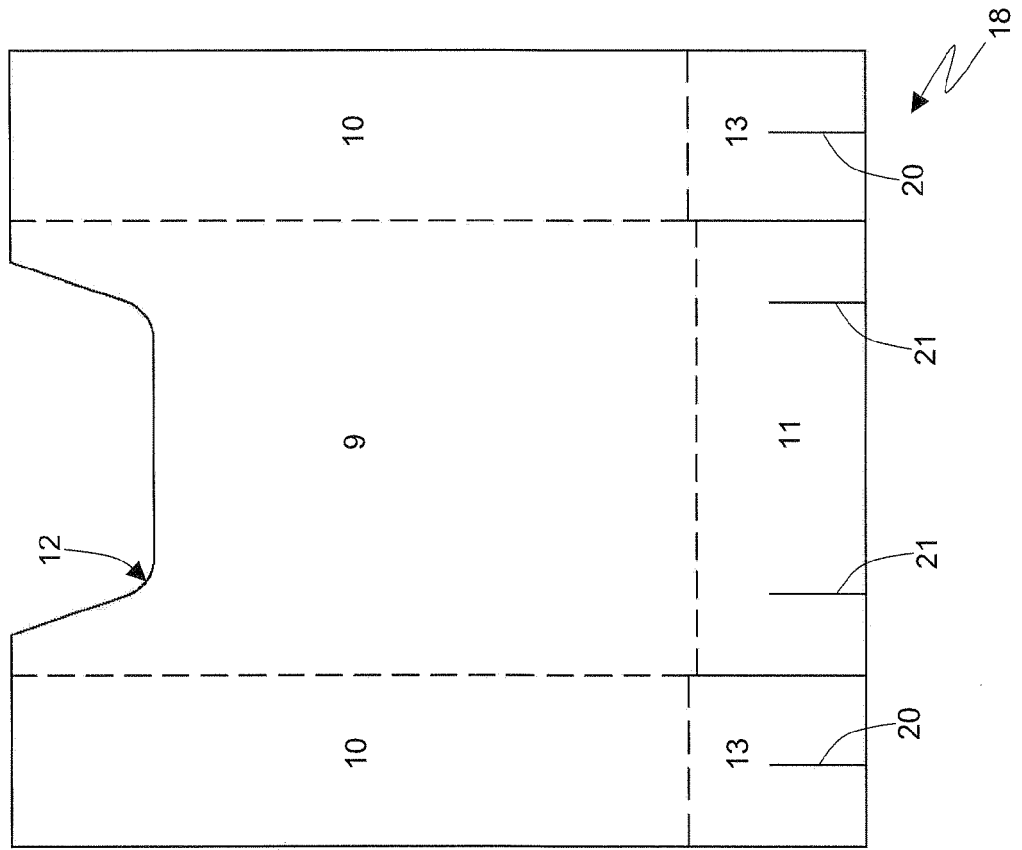
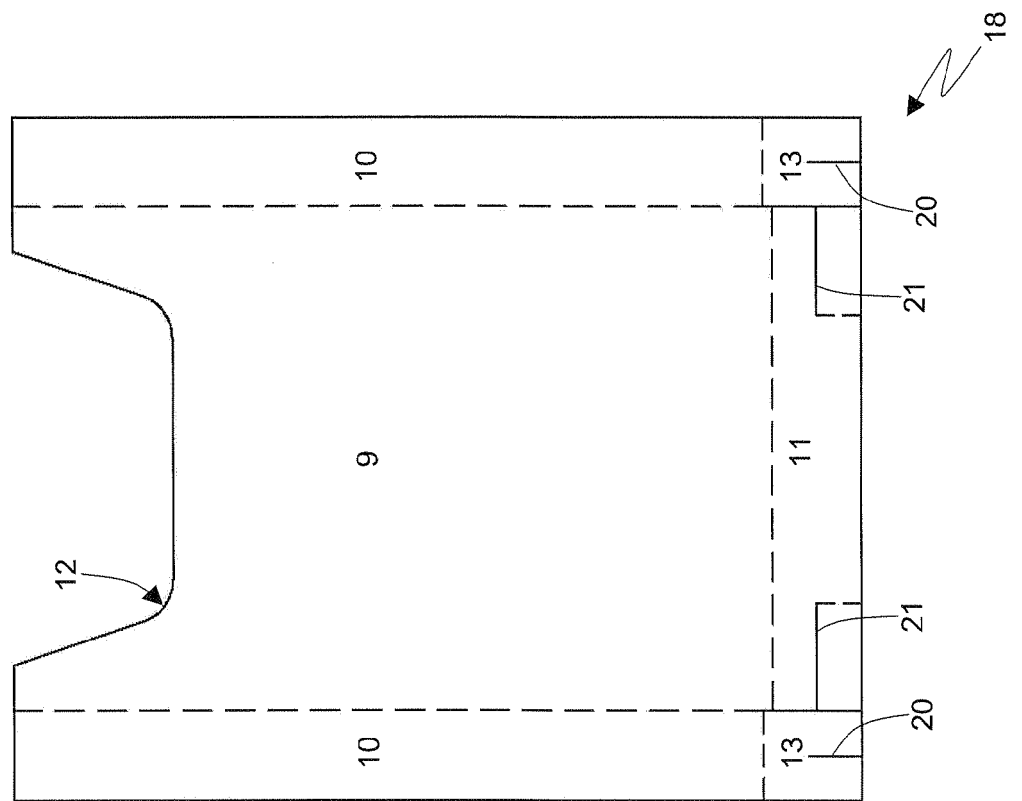


Fig.25



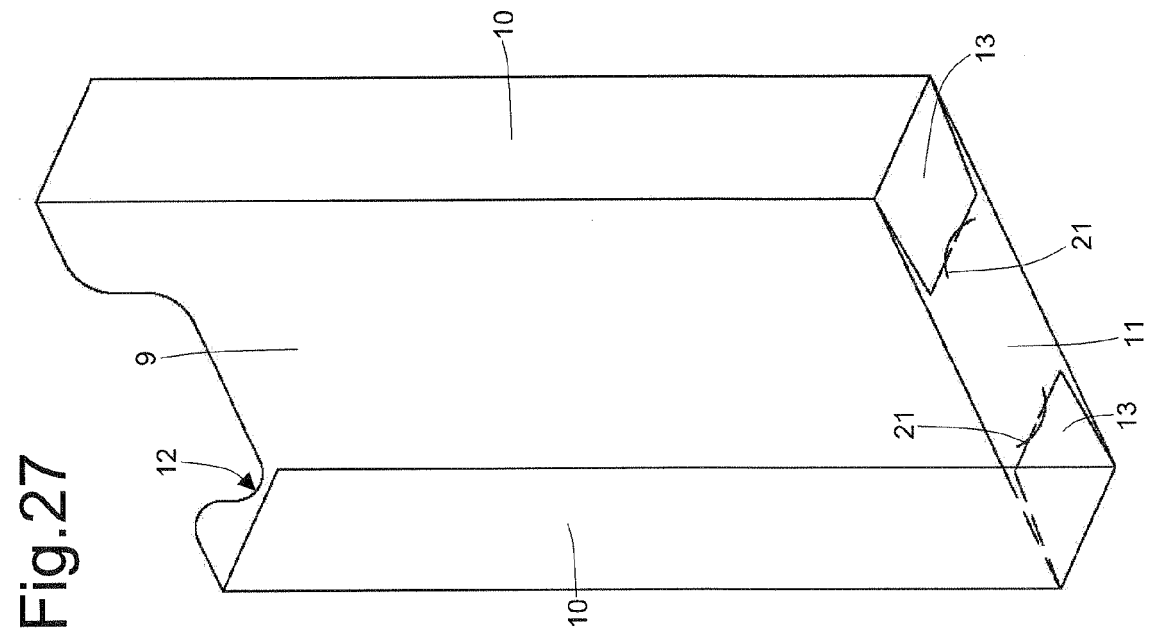
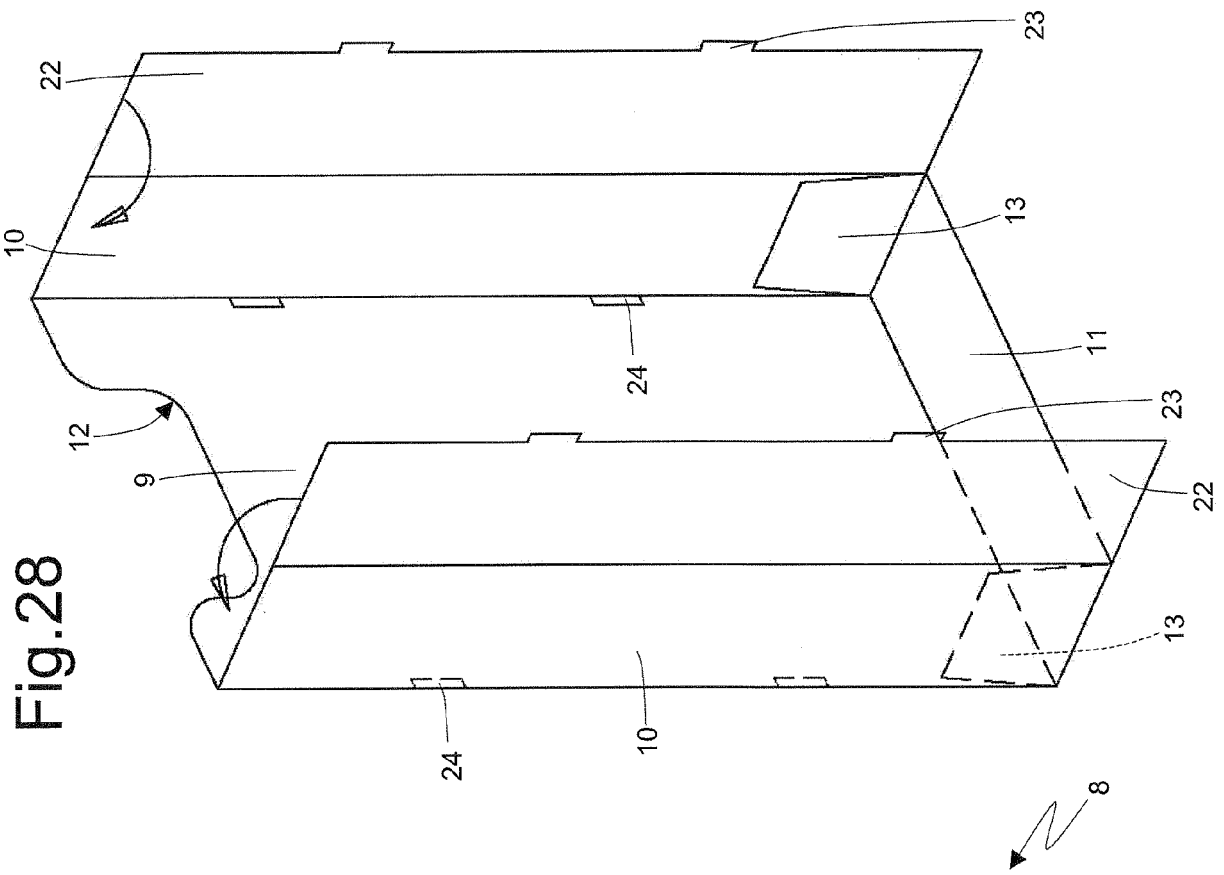


Fig. 29

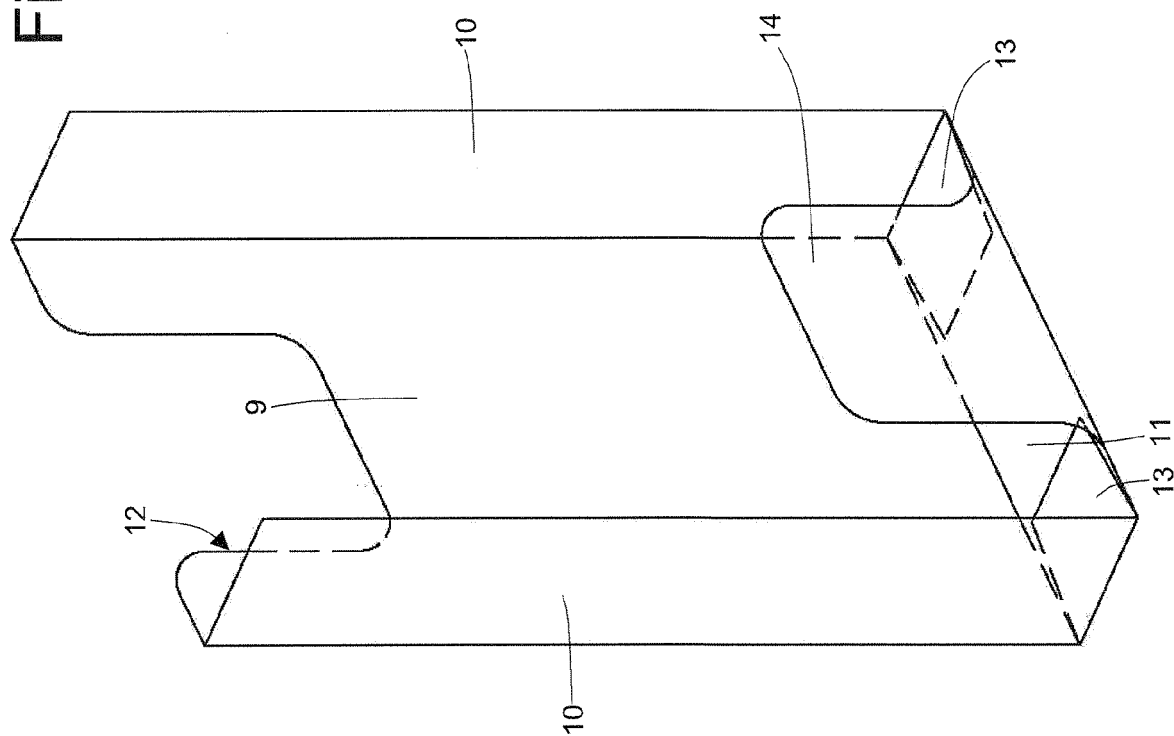
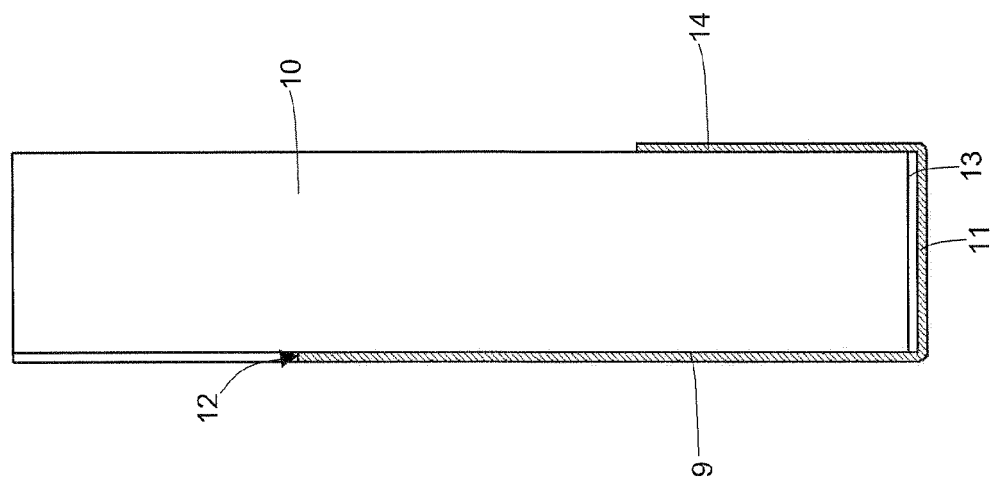


Fig. 30



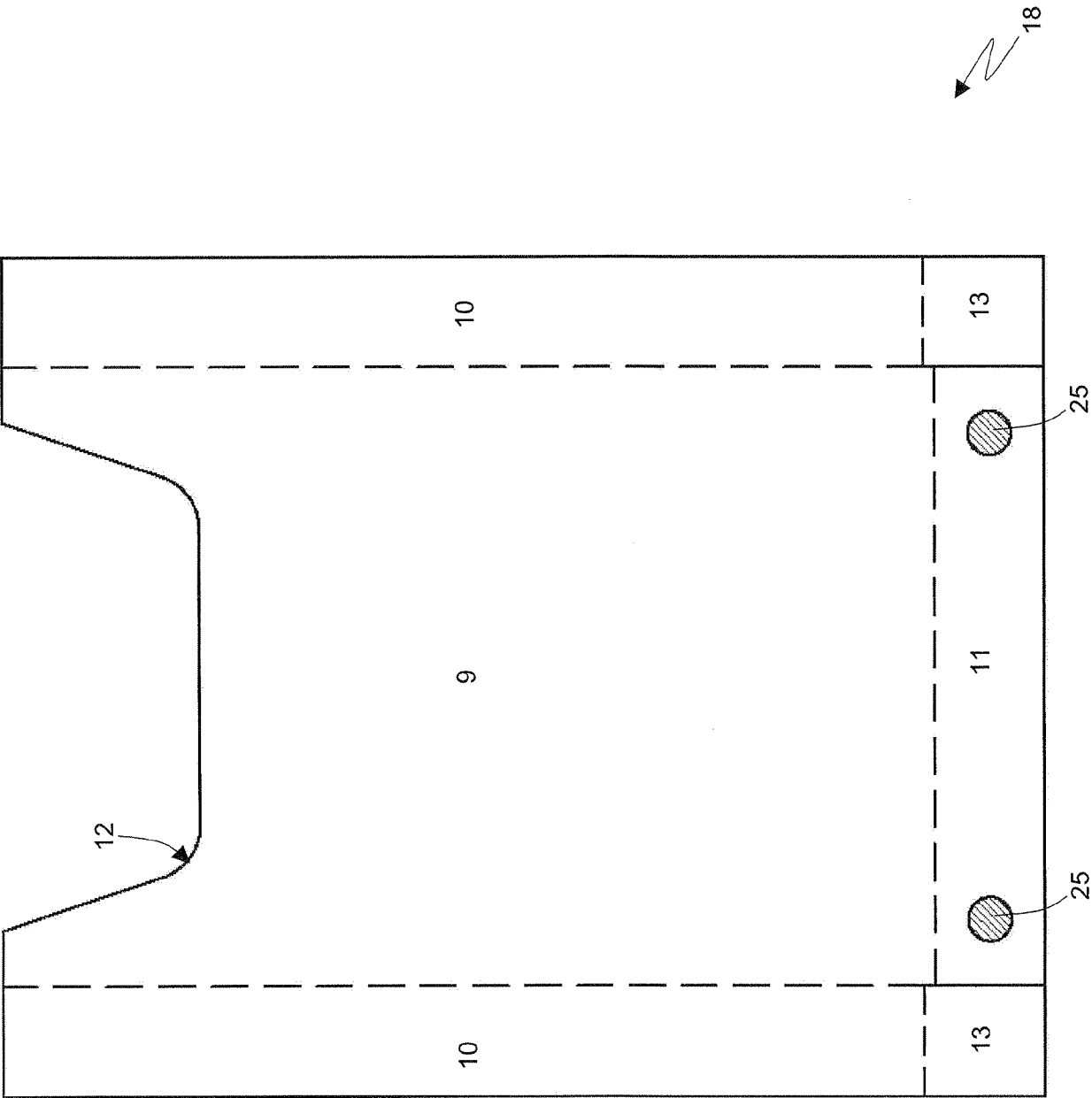


Fig.31

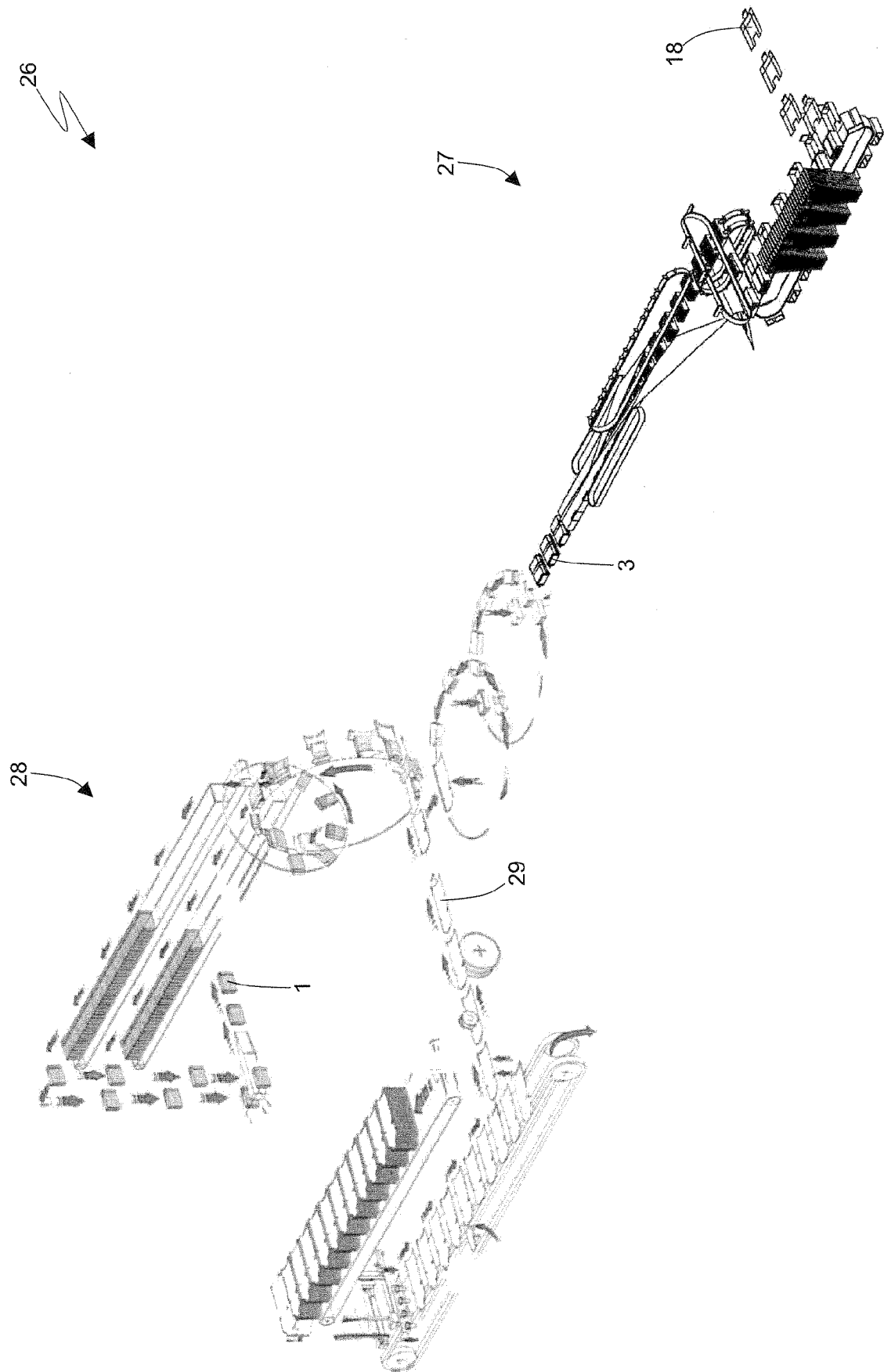


Fig.32

Fig.33

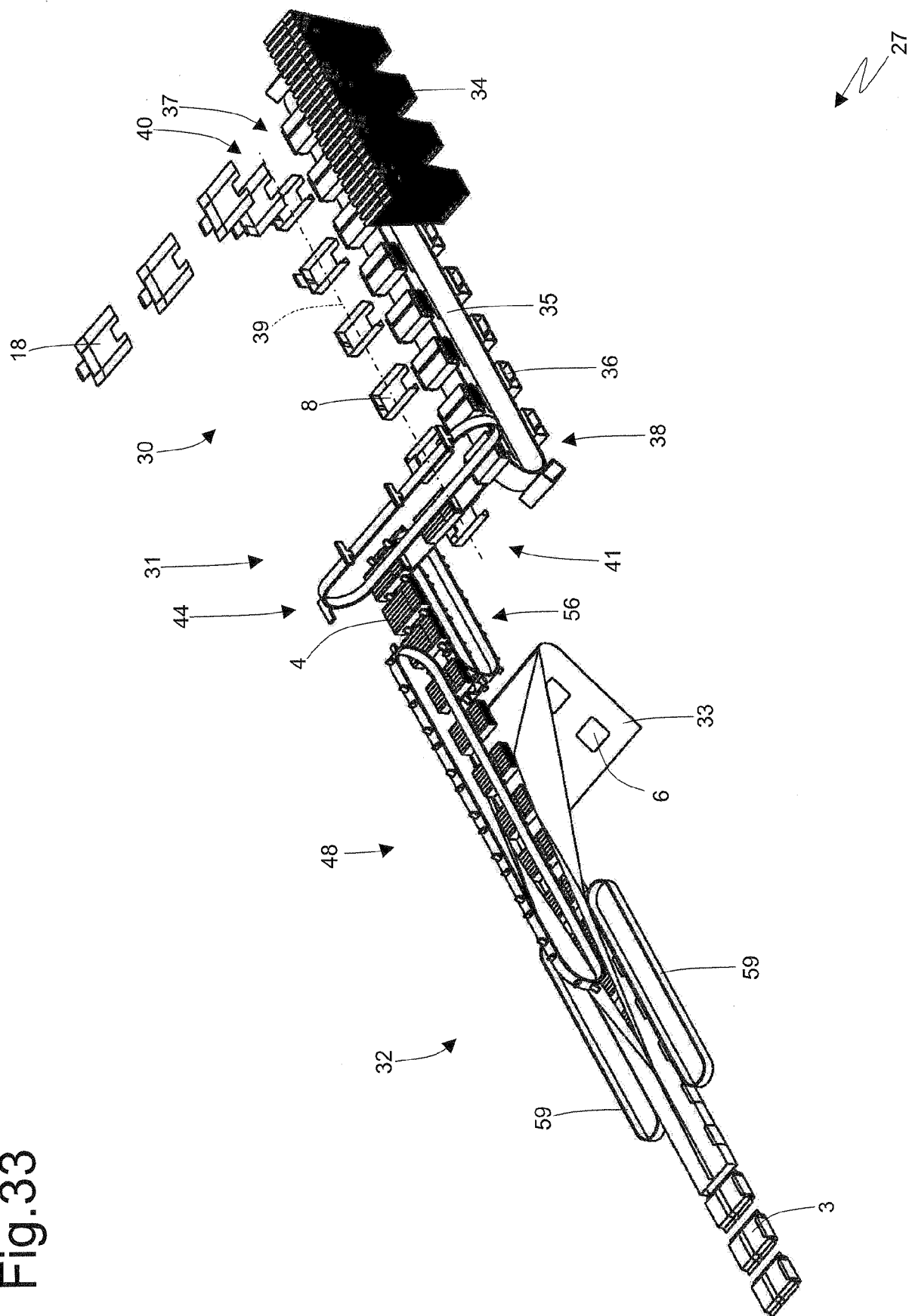


Fig.34

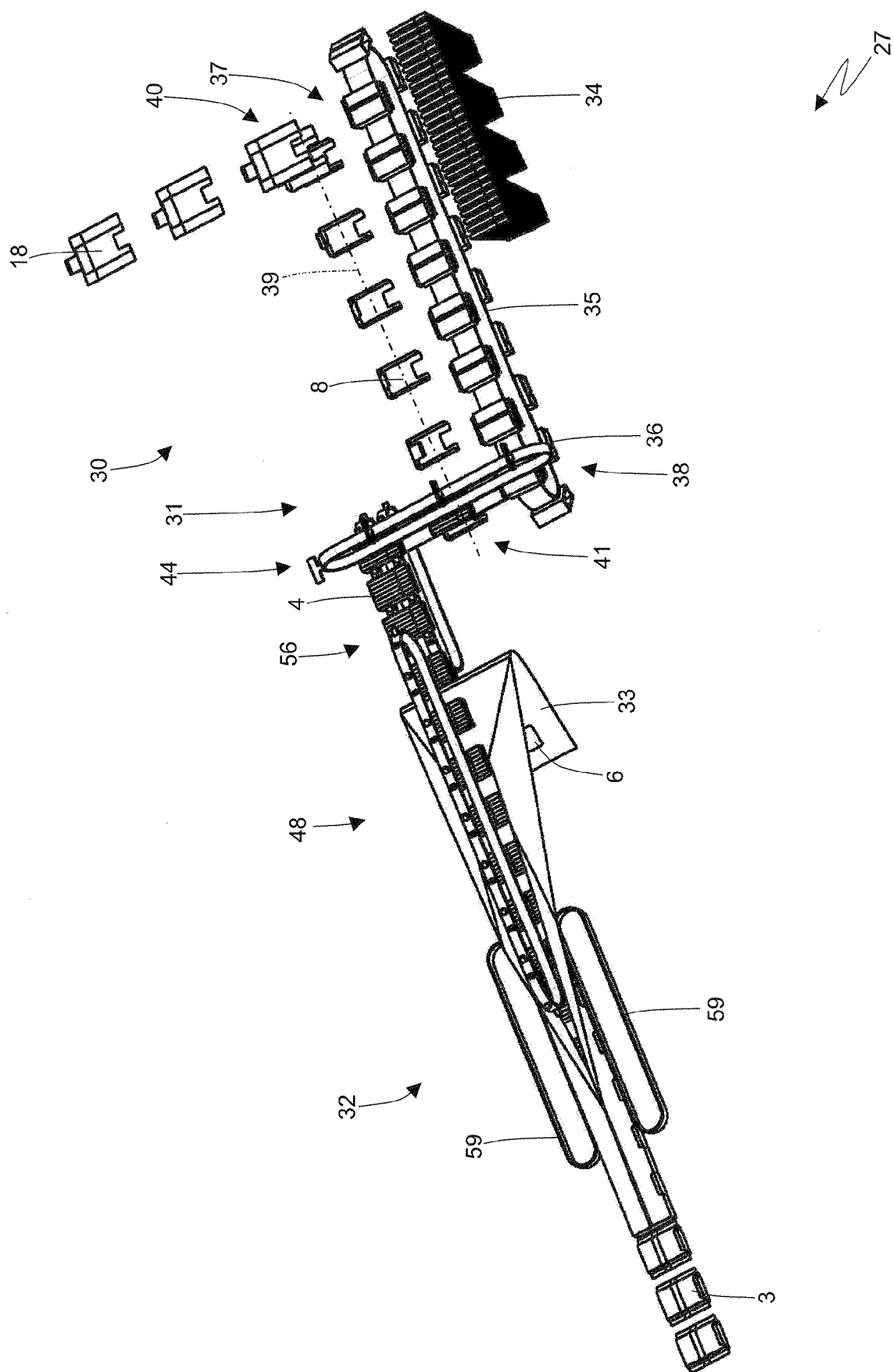
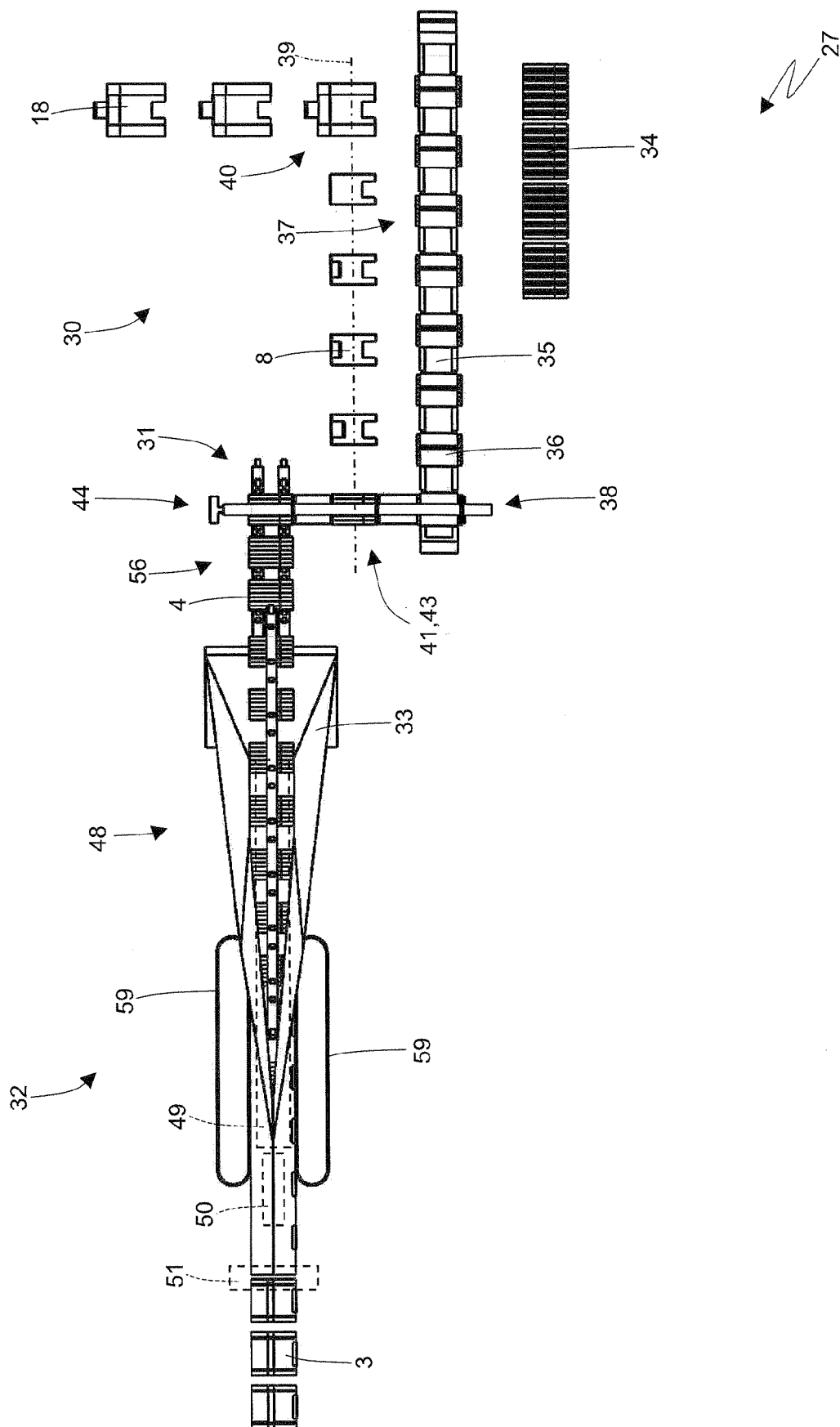


Fig. 35



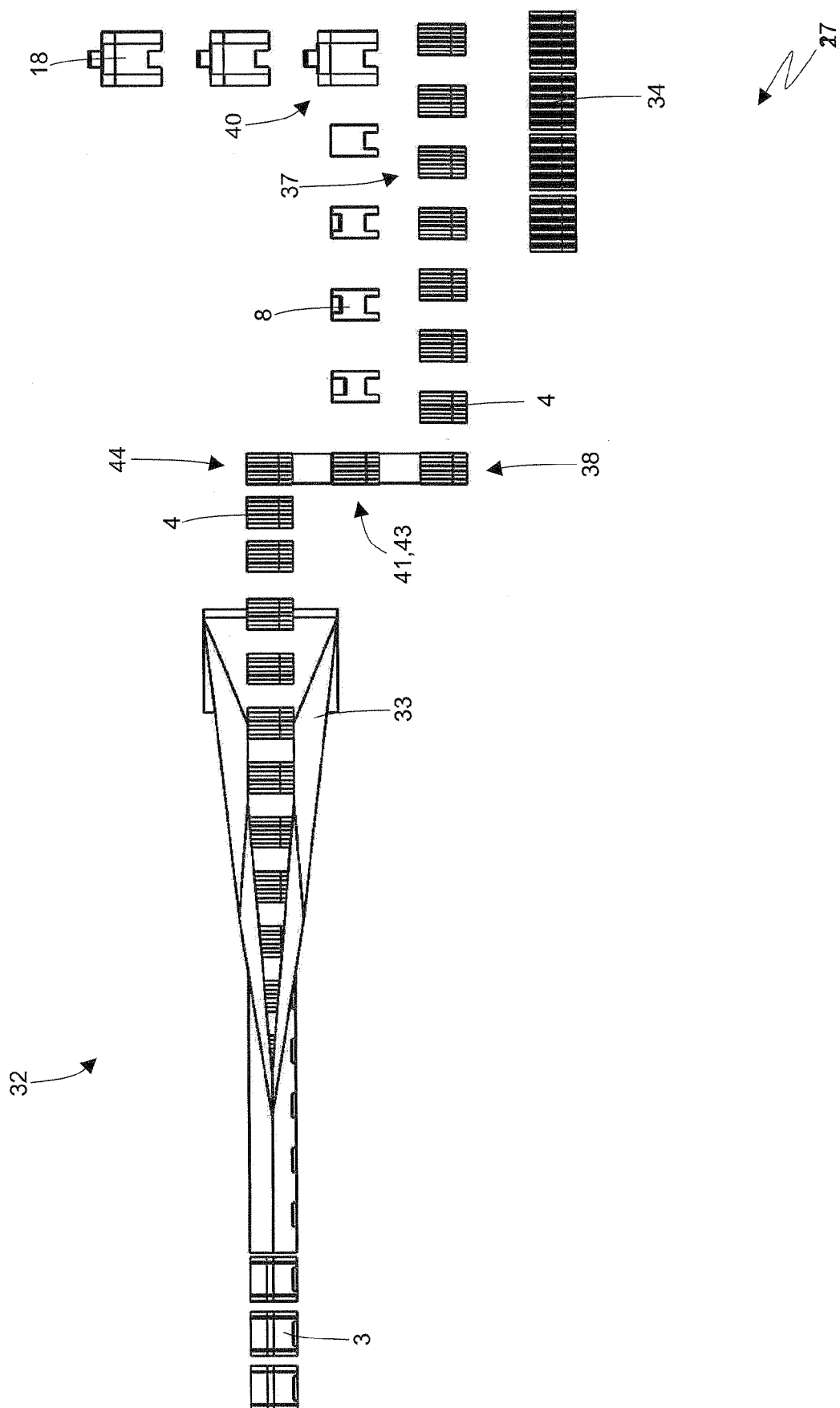
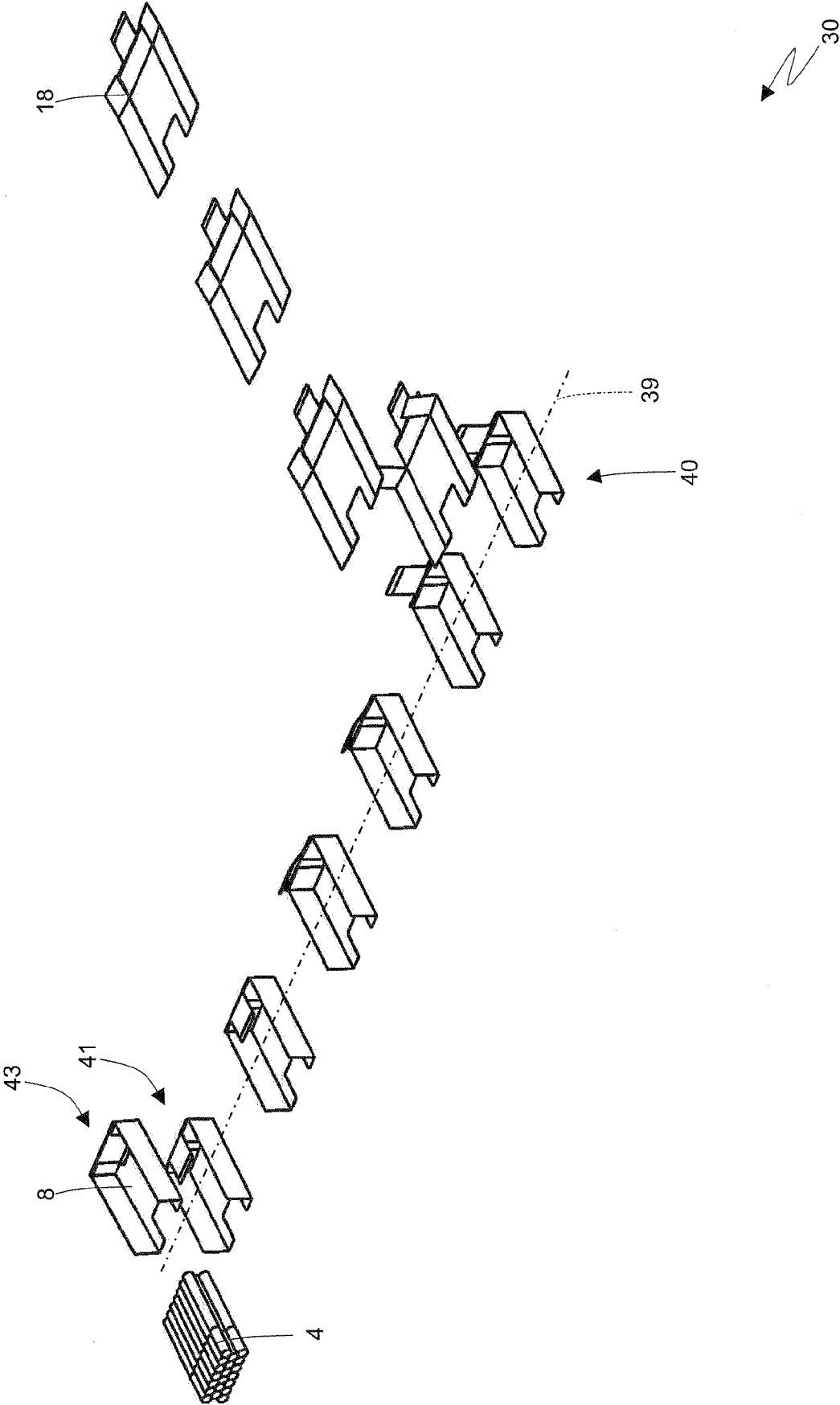


Fig. 36

Fig.37



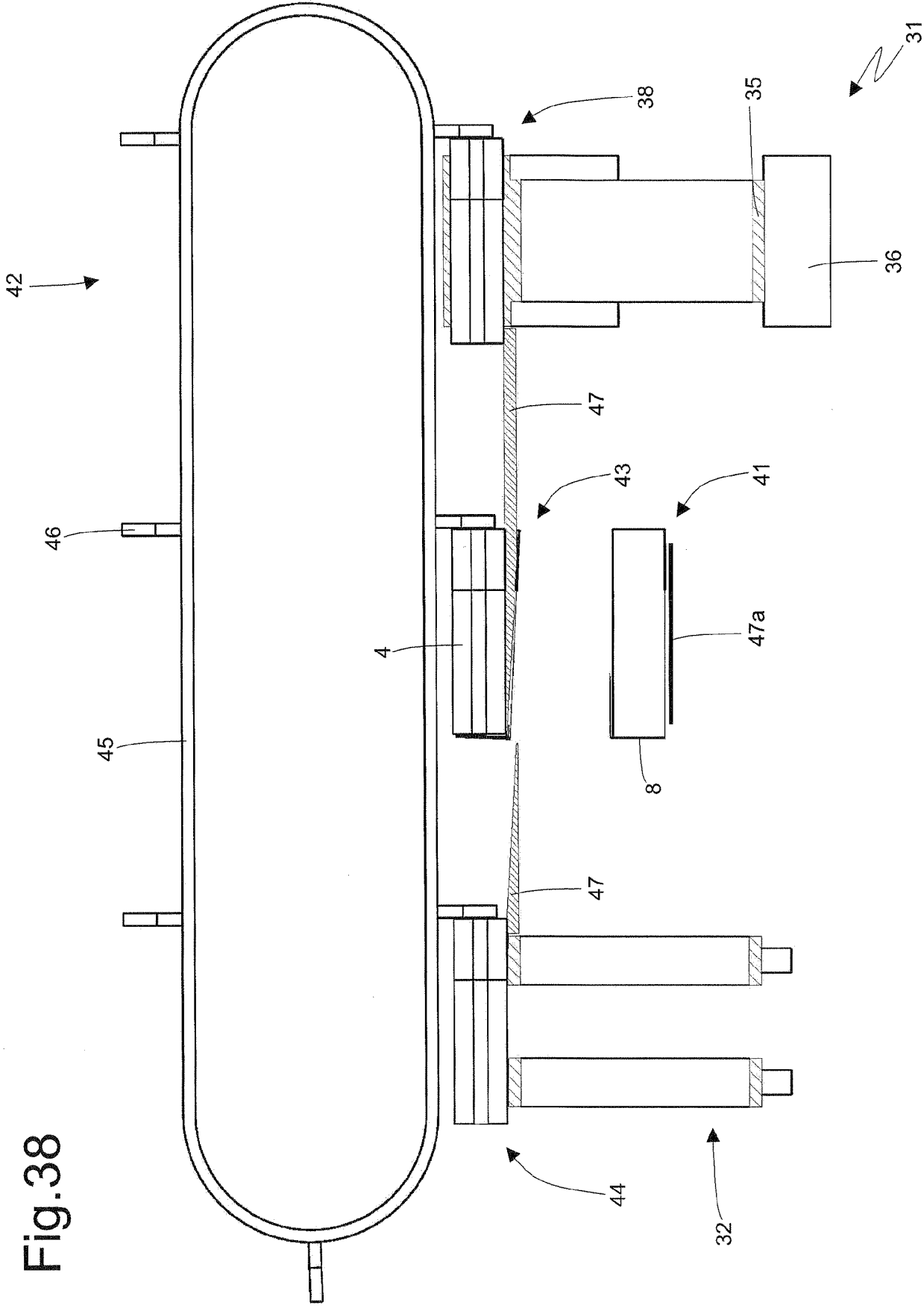


Fig. 38

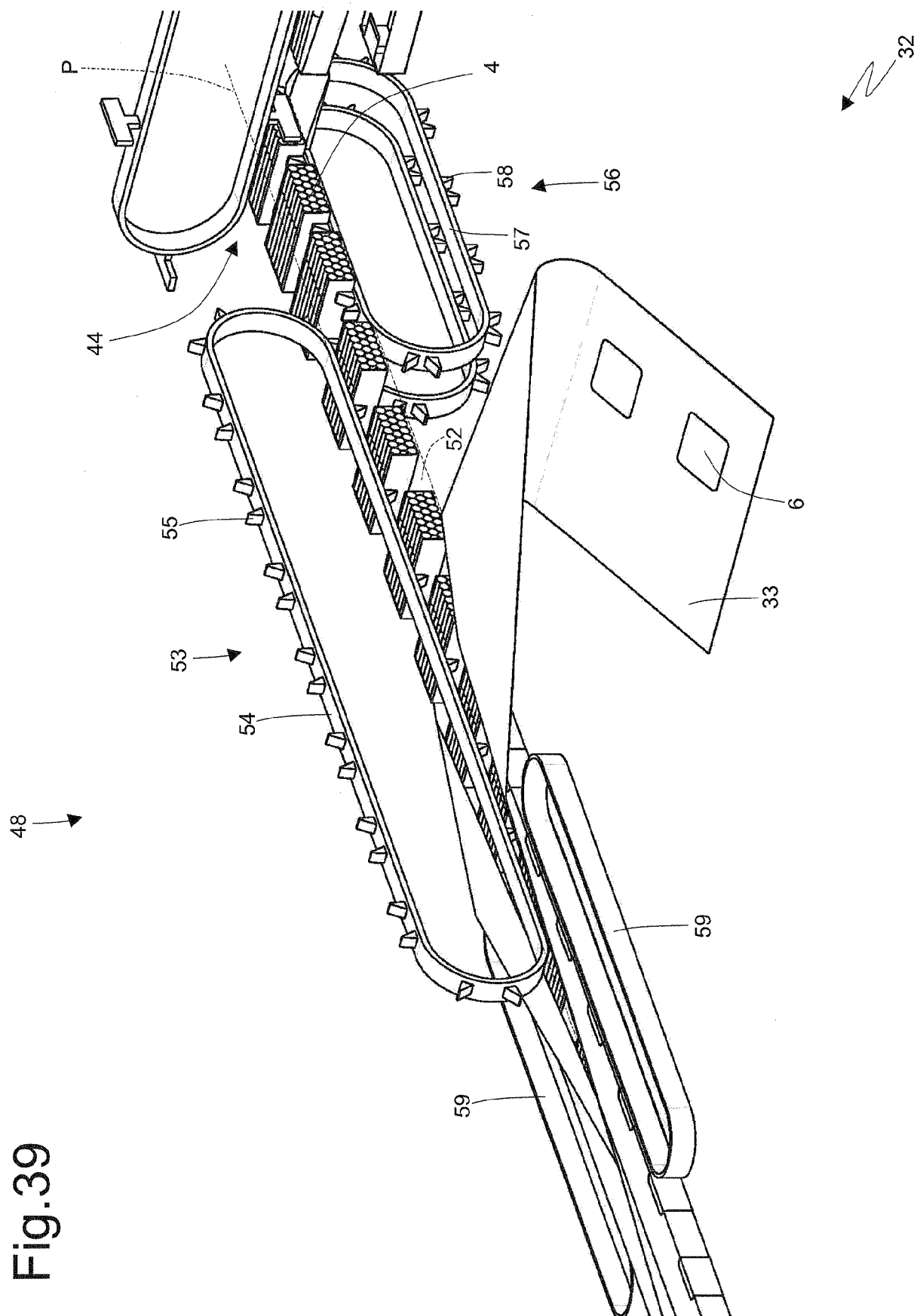


Fig. 39

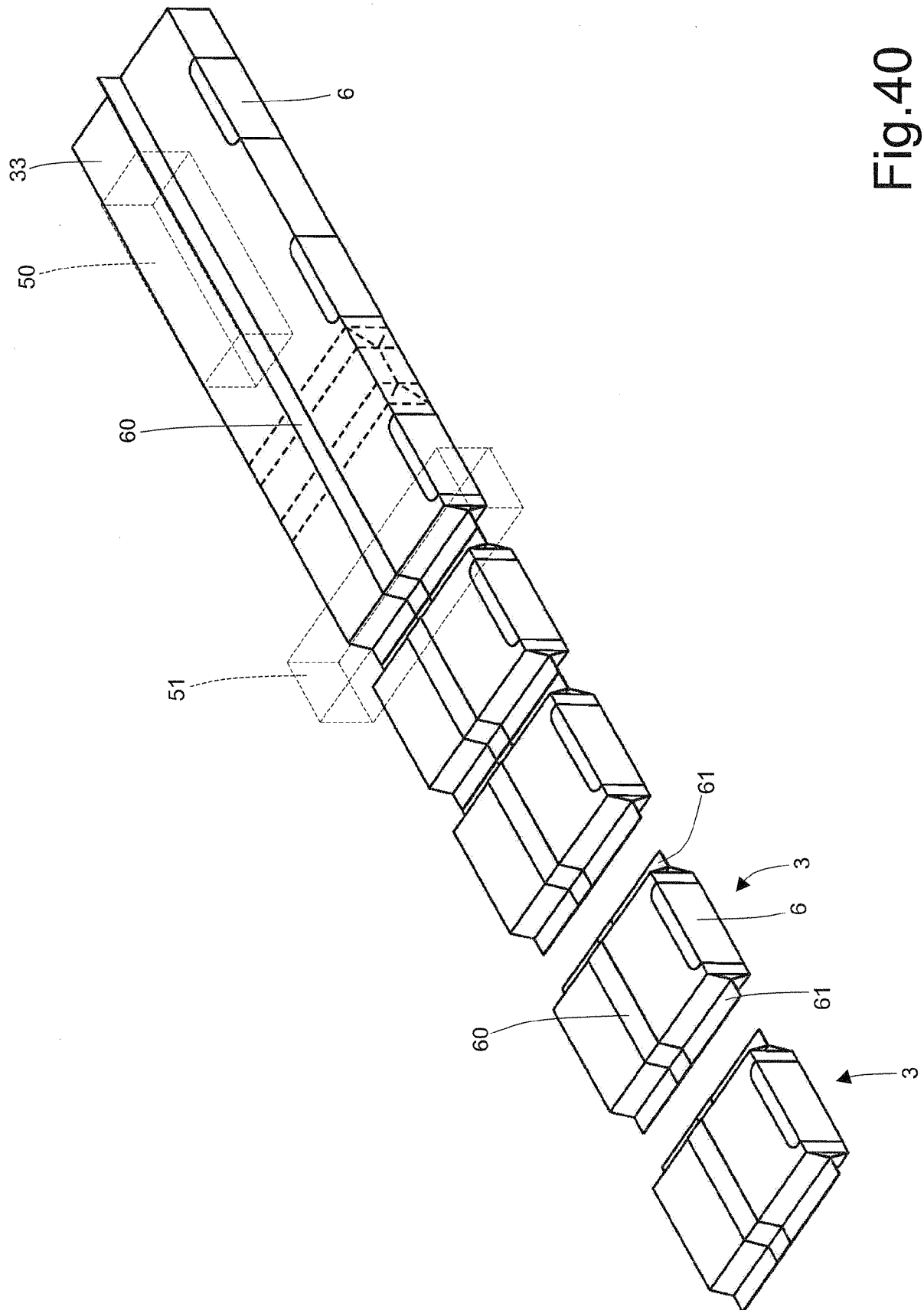


Fig. 40

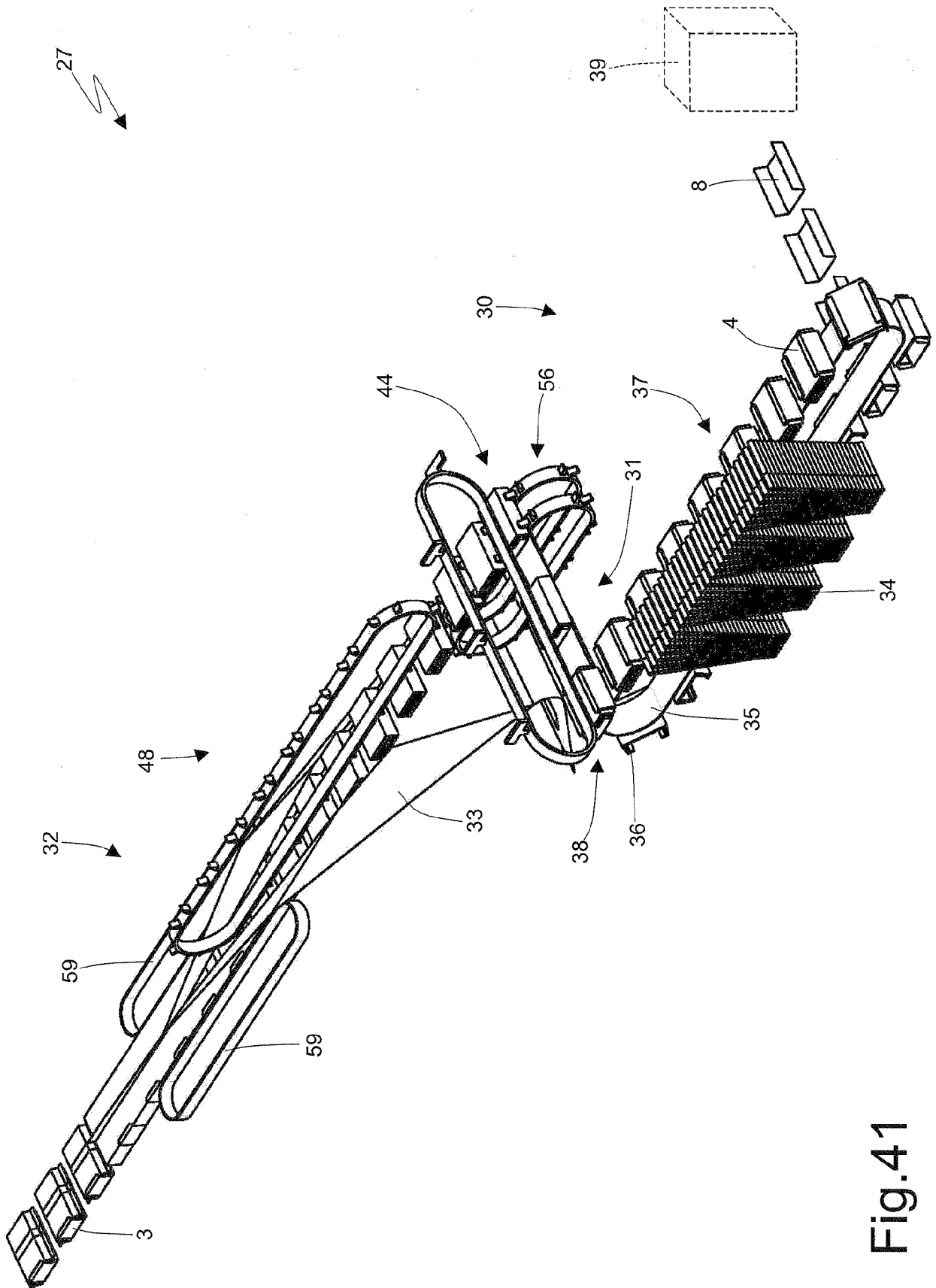
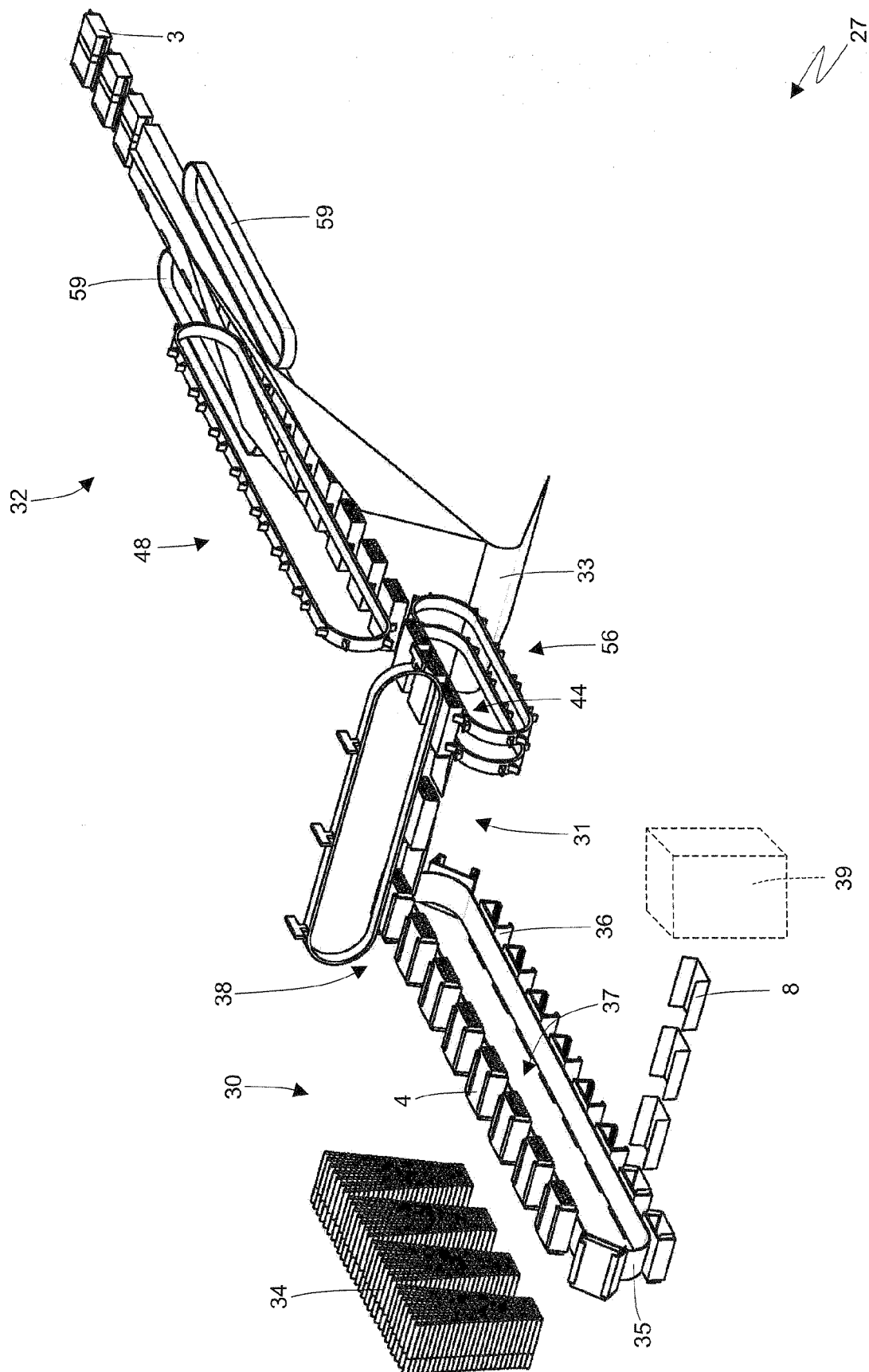


Fig. 41

Fig.42



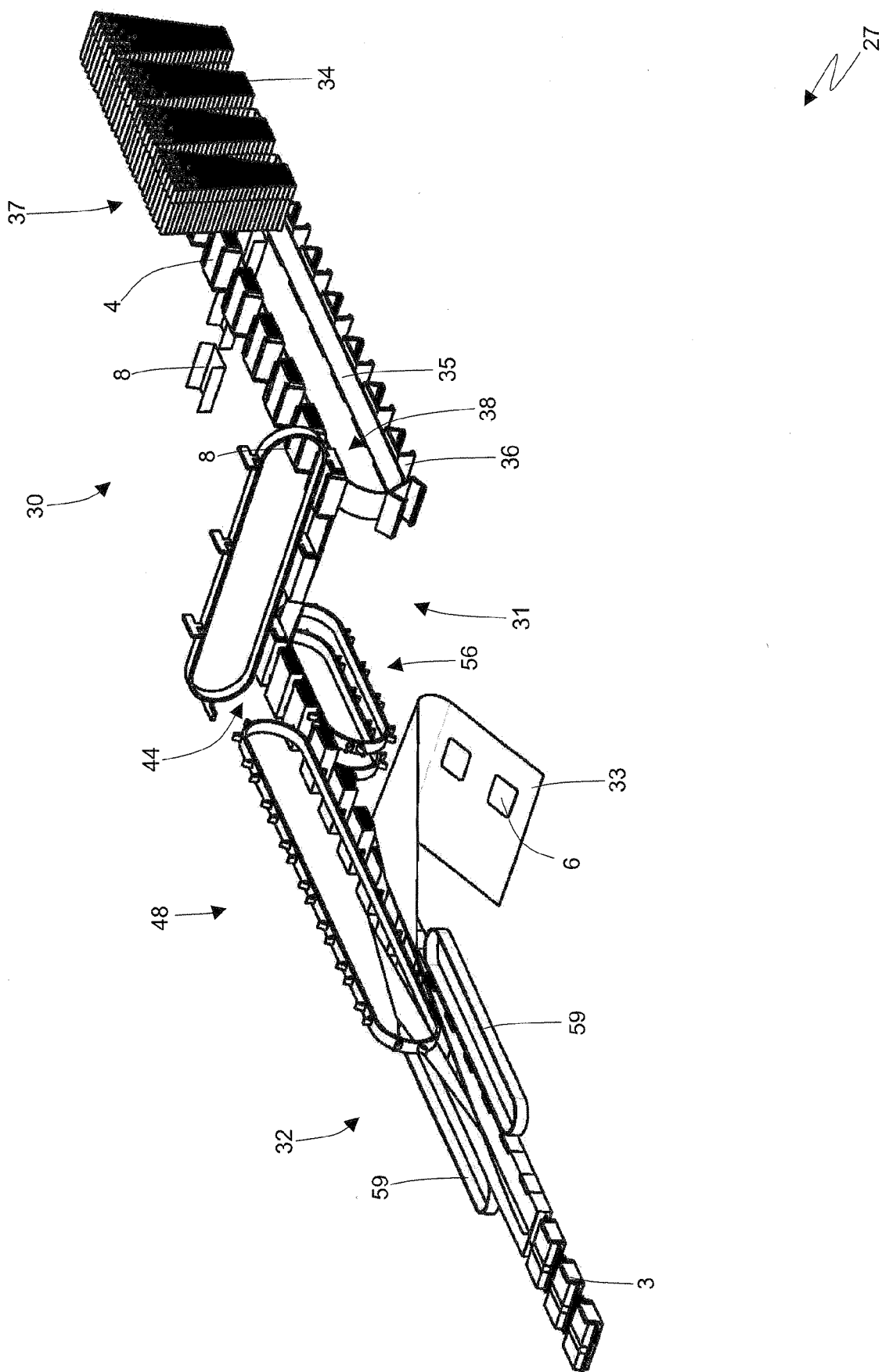


Fig. 43



EUROPEAN SEARCH REPORT

 Application Number
 EP 17 16 1209

5

10

15

20

25

30

35

40

45

50

55

2

EPO FORM 1503 03.82 (P04C01)

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
A,D	US 6 237 760 B1 (PARKER MICHAEL PATRICK [GB] ET AL) 29 May 2001 (2001-05-29) * abstract; figures 1-15 * * column 4, line 45 - column 7, paragraph 3 *	1-5	INV. B65D75/58 B65D77/02 B65D85/10
A,D	DE 10 2009 060134 A1 (FOCKE & CO [DE]) 16 June 2011 (2011-06-16) * abstract; figures 1-4 * * paragraph [0034] - paragraph [0046] *	1-5	
A	WO 98/49072 A1 (ROTHMANS BENSON & HEDGES [CA]; KEAVENEY BENEDICT [CA]; DAVIDSON KENNET) 5 November 1998 (1998-11-05) * abstract; figures 1,2,10-17 * * page 10, paragraph 2 - page 12, last line *	1-5	
A,D	WO 2011/110272 A1 (FOCKE & CO [DE]; STEINKAMP IRMIN [DE]; BUSE HENRY [DE]; WIEGE THOMAS [DE]) 15 September 2011 (2011-09-15) * the whole document *	1-5	TECHNICAL FIELDS SEARCHED (IPC) B65D
A,P	WO 2013/053408 A1 (FOCKE & CO [DE]; BUSE HENRY [DE]) 18 April 2013 (2013-04-18) * abstract; figures 5-7 *	1-5	
The present search report has been drawn up for all claims			
Place of search Munich		Date of completion of the search 5 April 2017	Examiner Segerer, Heiko
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

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

EP 17 16 1209

5

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP file on
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

05-04-2017

10

15

20

25

30

35

40

45

50

55

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US 6237760 B1	29-05-2001	AT 198729 T	15-02-2001
		AU 727891 B2	04-01-2001
		BG 63748 B1	29-11-2002
		BG 103507 A	31-01-2000
		BR 9713374 A	21-03-2000
		CA 2270624 A1	28-05-1998
		CN 1237941 A	08-12-1999
		CZ 9901818 A3	14-02-2001
		DE 69703940 D1	22-02-2001
		DE 69703940 T2	07-06-2001
		DK 0942880 T3	05-02-2001
		EP 0942880 A1	22-09-1999
		ES 2153657 T3	01-03-2001
		GR 3035405 T3	31-05-2001
		HK 1022130 A1	21-09-2001
		HU 0000225 A2	28-06-2000
		IL 130016 A	21-04-2002
		JP 3798030 B2	19-07-2006
		JP 2001504070 A	27-03-2001
		KR 20000057201 A	15-09-2000
		NZ 335656 A	24-11-2000
		PL 333427 A1	06-12-1999
		PT 942880 E	29-06-2001
		RU 2189928 C2	27-09-2002
		TR 9901112 T2	23-08-1999
		US 6237760 B1	29-05-2001
		WO 9822368 A1	28-05-1998
DE 102009060134 A1	16-06-2011	CN 102892686 A	23-01-2013
		CN 104608950 A	13-05-2015
		DE 102009060134 A1	16-06-2011
		EP 2509889 A1	17-10-2012
		EP 2599734 A1	05-06-2013
		JP 5784035 B2	24-09-2015
		JP 2013513527 A	22-04-2013
		KR 20120105022 A	24-09-2012
		PL 2599734 T3	30-11-2016
		RU 2012128653 A	20-01-2014
US 2012241339 A1	27-09-2012	US 2012241339 A1	27-09-2012
		US 2014311930 A1	23-10-2014
		WO 2011069575 A1	16-06-2011
WO 9849072 A1	05-11-1998	AU 6915998 A	24-11-1998
		CA 2203597 A1	24-10-1998
		CN 1224401 A	28-07-1999
		EP 0914283 A1	12-05-1999

EPO FORM P0459

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

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

EP 17 16 1209

5

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
The members are as contained in the European Patent Office EDP file on
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

05-04-2017

10

15

20

25

30

35

40

45

50

55

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
		JP 2000513686 A	17-10-2000
		KR 20000016659 A	25-03-2000
		NO 986084 A	17-02-1999
		TW 370504 B	21-09-1999
		WO 9849072 A1	05-11-1998
		ZA 9803207 B	22-10-1998

WO 2011110272 A1	15-09-2011	AR 080337 A1	28-03-2012
		CO 6612274 A2	01-02-2013
		DE 102010019867 A1	15-09-2011
		EP 2544958 A1	16-01-2013
		JP 2013521198 A	10-06-2013
		RU 2012142984 A	20-04-2014
		WO 2011110272 A1	15-09-2011
		ZA 201206665 B	29-05-2013

WO 2013053408 A1	18-04-2013	CN 103958369 A	30-07-2014
		CN 106315012 A	11-01-2017
		DE 102011119344 A1	11-04-2013
		EP 2766282 A1	20-08-2014
		EP 2826724 A2	21-01-2015
		JP 2014531373 A	27-11-2014
		KR 20140074393 A	17-06-2014
		RU 2014118594 A	20-11-2015
		US 2015027916 A1	29-01-2015
		WO 2013053408 A1	18-04-2013

REFERENCES CITED IN THE DESCRIPTION

This list of references cited by the applicant is for the reader's convenience only. It does not form part of the European patent document. Even though great care has been taken in compiling the references, errors or omissions cannot be excluded and the EPO disclaims all liability in this regard.

Patent documents cited in the description

- US 6237760 A1 [0006]
- DE 102009060134 A1 [0006]
- WO 2011110272 A1 [0007] [0008] [0009]
- WO 2013053408 A1 [0010]