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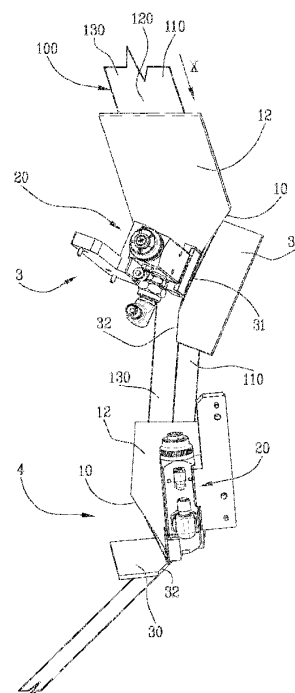
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(54) **METHOD AND MACHINE FOR MAKING MULTILAYER TUBES FOR TOBACCO INDUSTRY PRODUCTS**

(57) A machine for making multilayer tubes of the tobacco industry comprises: a first folding station (3, 4) configured to fold a first longitudinal strip (110) of the continuous web (100) onto a second longitudinal strip (120) of the web (100) to obtain a multilayer web; a forming station (5) for forming a continuous tube by continuously wrapping the multilayer web around a longitudinal axis; a cutting station for cutting the continuous tube into a succession of tubes (200); wherein the folding station (3, 4) has a first deflector edge (10) for deflecting the first longitudinal strip (110) and a second deflector edge (11) to deflect simultaneously the remaining longitudinal strip (120, 130) of the continuous web (100), the first and second deflector edges (10, 11) being angled to each other.

Fig.3





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The present search report has been drawn up for all claims			
Place of search Munich		Date of completion of the search 8 April 2020	Examiner Sundqvist, Stefan
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

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Place of search Munich		Date of completion of the search 8 April 2020	Examiner Sundqvist, Stefan
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

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Application Number

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CLAIMS INCURRING FEES

The present European patent application comprised at the time of filing claims for which payment was due.

☐ Only part of the claims have been paid within the prescribed time limit. The present European search report has been drawn up for those claims for which no payment was due and for those claims for which claims fees have been paid, namely claim(s):

☐ No claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for those claims for which no payment was due.

LACK OF UNITY OF INVENTION

The Search Division considers that the present European patent application does not comply with the requirements of unity of invention and relates to several inventions or groups of inventions, namely:

see sheet B

☒ All further search fees have been paid within the fixed time limit. The present European search report has been drawn up for all claims.

☐ As all searchable claims could be searched without effort justifying an additional fee, the Search Division did not invite payment of any additional fee.

☐ Only part of the further search fees have been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the inventions in respect of which search fees have been paid, namely claims:

☐ None of the further search fees have been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the invention first mentioned in the claims, namely claims:

☐ The present supplementary European search report has been drawn up for those parts of the European patent application which relate to the invention first mentioned in the claims (Rule 164 (1) EPC).



**LACK OF UNITY OF INVENTION
SHEET B**

Application Number

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The Search Division considers that the present European patent application does not comply with the requirements of unity of invention and relates to several inventions or groups of inventions, namely:

1. claims: 1-7, 14-21, 28

Deflector means for a first folding in a method and a machine for making multilayer tubes.

2. claims: 8, 9, 23

A further folding in a method and a machine for making multilayer tubes (claims 8 as dependent on claim 1, claim 9 as dependent on claim 8; claim 23 as dependent on claim 15).

3. claims: 10, 12, 22, 25

Detecting and setting a transverse position of the continuous web in a method and a machine for making multilayer tubes (claims 10 and 12 as dependent on claim 1; claims 22 and 25 as dependent on claim 15).

4. claims: 11, 24

Measuring at least one diameter of a tube in a method and a machine for making multilayer tubes (claim 11 as dependent on claim 1; claim 24 as dependent on claim 15).

5. claims: 13, 26, 27

Application and detection of an adhesive substance in a method and a machine for making multilayer tubes (claim 13 as dependent on claim 1; claims 26 and 27 as dependent on claim 15).

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