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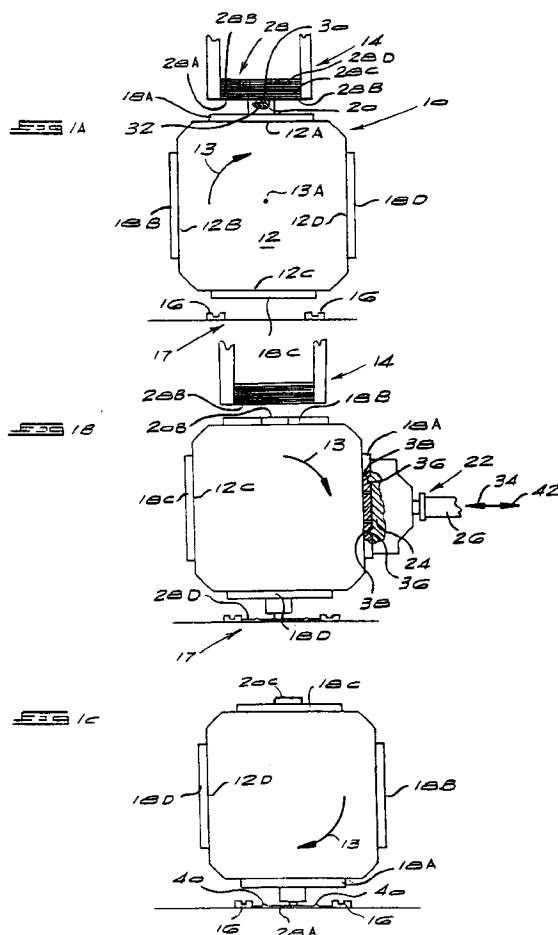
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(54) Creasing unit

(57) A creasing unit (10) is disclosed for creasing a pre-cut blank (28) for a hinge lid pack cigarette box. The creasing unit comprises a four-sided turret (12) carrying first, second, third and fourth crease-forming dies (18A, 18B, 18C, 18D). Lifting plates (20) are provided on each side of the turret for feeding blanks onto the crease-forming dies. A suction inlet (32) holds the blank in position on each crease forming die. A press (22) carries a complementary crease-forming die (24) for sandwiching the blank between the respective dies so as to sequentially form creased blanks (28A, 28B, 28C, 28D). The invention extends to a method of forming a crease in a precut blank.

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EUROPEAN SEARCH REPORT

Application Number
EP 94 30 7037

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.6)
X	US-A-4 674 998 (BENEDICENTI PIO GABRIELE) 23 June 1987 * column 3, line 20 - column 4, line 10; figures *	1-19	B31B1/25 B31B1/06
A	US-A-3 768 950 (IHDE R) 30 October 1973 * abstract; figures *	1,10	
X	US-A-4 537 588 (EHLSCHIED GUNTER ET AL) 27 August 1985 * the whole document *	1-4,10, 11	
A	EP-A-0 182 593 (MEAD CORP) 28 May 1986 * the whole document *	1,7	
A	DE-A-39 38 480 (HELL RUDOLF DR ING GMBH) 23 May 1991		
			TECHNICAL FIELDS SEARCHED (Int.Cl.6)
			B31B B29C B31F
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 24 January 1996	Examiner Pipping, L
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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