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(71) Applicant (for all designated States except US): **PHILIP MORRIS PRODUCTS S.A.** [CH/CH]; Quai Jeanrenaud 3, CH-2000 Neuchâtel (CH).

(72) Inventors: **SCOTT, George, R.**; 13381 Drakewood Road, Midlothian, VA 23113 (US). **GARTHAFFNER, Martin, T.**; 5200 Newbyswood Trail, Chesterfield, VA 23832 (US). **SPIERS, Steven, F.**; 10348 Ashburn Road, Richmond, VA 23235 (US). **RINEHART, Steven, R.**; 13920 Brandy

Oaks Place, Chesterfield, VA 23832 (US). **SMITH, Barry, S.**; 9751 Jamescrest Drive, Hopewell, VA 23860 (US). **EVANS, James, D.**; 13708 Mountcastle Place, Chesterfield, VA 23832 (US).

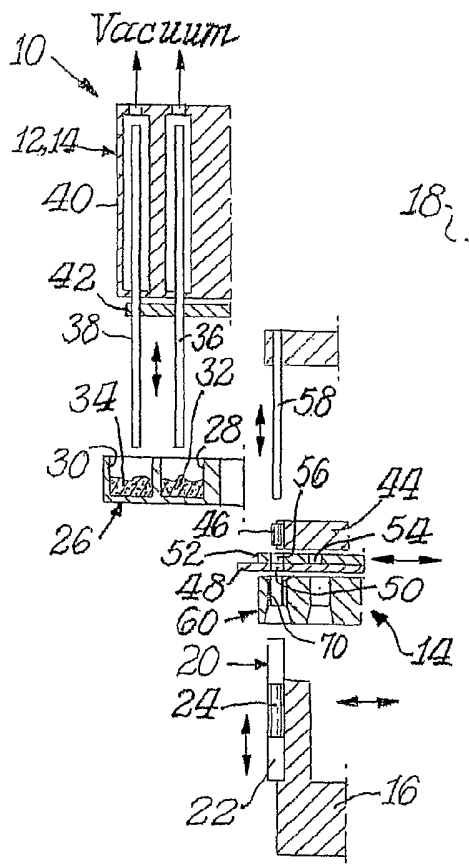
(74) Agent: **MARLOW, Nicholas, Simon**; Reddie & Grose, 16 Theobalds Road, London WC1X 8PL (GB).

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(54) Title: VERTICAL FILTER FILLING MACHINE AND PROCESS



(57) Abstract: Process and apparatus (10) for the mass production of compound cigarette filters function to deposit granular filter material (32) (34) into the open ends of vertically oriented filter tubes (20). Predetermined amounts of diverse granular material (32) (34) are withdrawn by suction from sources (26) of such material, and these amounts are deposited into the tubes (20). Solid filter segments (46) seal the granular material (32) (34) within the tube (20). After one half of each filter tube (20) is filled with granular material and sealed, the tube (20) is inverted and the opposite end is filled in substantially the same manner. When cut in half each filter tube (20) produces two cigarette filters.



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VERTICAL FILTER FILLING MACHINE AND PROCESSCross Reference Related to Application

The present application claims the benefit of provisional
5 application Serial No. 60/625,747, filed November 5, 2004, for all useful
purposes, and the specification and drawings thereof are included herein
by reference.

Background of the Invention

10 US Patents 3,517,480 and 3,603,058 illustrate and describe machines
for the production of composite cigarette filters by directly flowing
granular filter material from a storage hopper into a vertically oriented
filter tube made of paper. Similarly, US Patent Application Publication
2002/0119874A1 describes another machine for producing compound cigarette
15 filters that includes a series of rotating plates with cavities therein
into which the granular filter material is deposited. The cavities
ultimately are aligned with an open paper ended filter tube to facilitate
deposit of the granular material into the tube. These machines have the
disadvantage of often destroying the integrity of the paper filter tubes
20 into which filter materials are deposited. They also deposit imprecise
amounts of granular material and produce undesired amounts of fine dust
and the like.

Summary of the Invention

25 Accordingly, one of the objects of the present invention is a
vertical filter filling machine and process for producing multiple cavity
cigarette filters in a highly efficient and economical manner at high
rates of production.

Another object of the present invention is a vertical filter
30 filling machine and process having the ability to assemble very small
filter components less than three millimeters in length.

Another object of the present invention is a vertical filter
filling machine and process for producing multiple cavity cigarette

filters which includes precise dosing of reduced smoking constituent materials and/or flavoring materials.

Still another object of the present invention is a vertical filter filling machine and process for producing compound cigarette filters with
5 minimal or no cross contamination of filter material whereby extremely clean filters are produced.

Another object of the present invention is a vertical filter filling machine and process for producing compound cigarette filters with precise dosing of granular material while eliminating granular material
10 scatter on the filters being produced at extremely high production rates.

Another important object of the present invention is maintaining the integrity of the paper filter tubes when filling the tubes with granular materials and discrete solid filter segments.

In accordance with the present invention a preformed filter tube of
15 paper with hollow ends and a solid center of cellulose acetate or similar material is formed into two multiple cavity cigarette filters. The filter tube is vertically oriented and moves along a generally circular path where metered amounts of granular filter material are precisely deposited in the tubes after which a plug of cellulose acetate or similar
20 material is placed in the tube to thereby seal the granular material. A second deposit of different granular material may also be placed in the tube as well as a second plug to seal that material. Subsequently, the tube is inverted and the remaining half is filled with granular material and sealed in the same manner. Cutting the tube midway through the solid
25 center thereof produces two individual multiple cavity cigarette filters. Specifically, the process of producing compound cigarette filters according to the present invention comprises the steps of placing a filter tube with hollow ends and a solid filter center in a substantially vertical position. A predetermined amount of granular material is
30 withdrawn by suction from a source of such material, and the predetermined amount of material is deposited into an upper open end of the filter tube directly against the solid center. Next, a solid filter segment is placed into the upper open end of the filter tube directly against the granular material to thereby seal the material in place.

Throughout the entire filling process, the integrity of filter tube, usually made of thin easily crumpled paper, is maintained by initially depositing the filter materials into an internal alignment tube placed within the filter tube and then pushing the filter materials
5 directly into the filter tube without any significant relative movement between the filter materials and the interior walls of the filter tube. Moreover, as the solid filter segment exits the internal alignment tube into the filter tube, the filter tube moves in a downward direction at a speed that matches the downward speed of the segment. This coordinated
10 movement prevents sliding of the segment against the inside surface of the filter tube which might otherwise cause the filter tube to wrinkle or buckle.

Additionally, a predetermined amount of a second granular material may be deposited into the upper open end of the filter tube directly
15 against the solid filter segment already in place. A second solid filter segment may then be placed into the upper open end of the filter tube directly against the second granular material to thereby seal the second material in place.

The process of the present invention also includes inverting the
20 filter tube and filling the other end of the tube with granular material and solid filter segments in the same manner as the first end.

Moreover, the solid filter segments placed against the granular material may be produced from an extended solid filter segment which is sliced into two pieces during the process to thereby produce each of the
25 two solid filter segments. Both the solid filter center and solid filter segments may comprise cellulose acetate tow.

In accordance with the present invention, apparatus for producing compound cigarette filters comprises a rotating tube flute plate for holding and transporting a plurality of filter tubes along a circular
30 path. Each filter tube has opposite hollow ends and a solid filter center, and the tubes are held by suction in vertically orientation flutes on the tube flute plate. A plurality of vertically orientated fill tubes with suction applied thereto withdraw predetermined amounts of granular material from a rotating bin of such material and deposit one

predetermined amount into the upper open end of each filter tube directly against the solid filter center upon termination of the suction on the fill tubes. A rotating segment plate holds a plurality of solid filter segments, and a plurality of rotating plungers vertically push the solid
5 filter segments out of the plate into the upper open ends of the filter tubes directly against the granular material in each filter tube to thereby seal the material in the tube.

The integrity of the filter tube is maintained throughout the filling process by initially placing the filter materials into an
10 internal alignment tube and then pushing those materials out of the alignment tube after the filter tube is placed over the alignment tube, and in doing so using the aforementioned coordinated movement to avoid relative motion between the materials being pushed and the paper tube which receives the pushed material.

Preferably, a second plurality of vertically oriented fill tubes with suction applied thereto withdraw predetermined amounts of a second granular material from the rotating bin. One predetermined amount of the second granular material is deposited into the open upper end of each
15 filter tube directly against the solid filter segment already in place upon termination of the suction on the second fill tubes. A rotating second segment filter plate holds a plurality of second solid filter segments and the plurality of plungers vertically push the second solid filter segments out of the second filter segment plate into the upper
20 open ends of the filter tubes directly against the second granular material in each filter tube to thereby seal the second material in the
25 tubes.

The rotating bin of granular material preferably includes several compartments with each compartment containing a different granular material.

30 In the preferred embodiment of the present invention, the rotating tube flute plate, the rotating bin of granular material, the plurality of vertically orientated fill tubes and second fill tubes, the rotating filter segment plate and second filter segment plate, and the plurality of rotating plungers collectively comprise an upper wheel assembly

rotating about a central vertical axis. A substantially identical lower wheel assembly also rotates about the same central vertical axis. A conveyor system removes half filled filter tubes from the upper wheel assembly, inverts the tubes and places them on the rotating tube flute plate of the lower wheel assembly. The other ends of the filter tubes are then filled with granular material and solid filter segments on the lower wheel assembly.

In the apparatus of the present invention a segment flute plate holds a plurality of extended length solid filter segments. A rotating cutter moveable between the solid filter segment plate and the second solid filter segment plate cuts the extended length solid filter segment after positioning thereof in the solid segment plate and the second solid segment plate to thereby form the solid filter segments and the second solid filter segments.

In accordance with the present invention, the multiple cavity dual filters may be removed and directly delivered to a tipping machine where wrapped tobacco rods at both ends of the filter are attached with tipping paper. Cutting the filter in half produces two cigarettes. This arrangement eliminates the need to store and deliver the dual filters to a distant tipping machine.

Brief Description of the Drawings

Novel features and advantages of the present invention in addition to those noted above will be become apparent to persons of ordinary skill in the art from a reading of the following detailed description in conjunction with the accompanying drawings wherein similar reference characters refer to similar parts and in which:

Figure 1 is a diagrammatic top plan view of a vertical filter filling machine illustrating the various angular locations of sequential filter filling process planes 1-17 as the machine rotates one full revolution or cycle, according to the present invention;

Figure 2 is a diagrammatic general cross sectional view illustrating the various machine components as well as the direction of movement of each component;

Figure 3 is a diagrammatic sectional view along the initial process plane 1 of Figure 1 where fill tubes are moving down into a rotating bin of granular material and wherein filter tubes are loaded into position on a tube flute plate and filter segments are loaded into position on a segment flute plate;

Figure 4 is a diagrammatic sectional view taken along process plane 2 of Figure 1 where the fill tubes have moved down into the granular material and vacuum has drawn the granular material into the tubes;

Figure 5 is a diagrammatic sectional view taken along process plane 3 of Figure 1 where the fill tubes loaded with granular material have moved up, the tube flute plate is moving upwardly to position the filter tubes in an alignment plate and the tube flute plate and alignment plate are moving radially out;

Figure 6 is a diagrammatic sectional view taken along process plane 4 of Figure 1 where the tube flute plate has moved up to its stop position and completely inserted the filter tube into the alignment plate and over an internal alignment tube; the tube flute plate, filler tube and alignment plate have moved radially out to a stop position which positions the filter tube in vertical alignment with the inner fill tube; and the plunger has pushed the filter segment through the second segment plate into the first segment plate and into contact with the surface of the alignment plate;

Figure 7 is a diagrammatic sectional view taken along process plane 5 of Figure 1 where the internal vacuum on the segment flute plate is turned off, the plunger is moving up out of contact with the filter segment, and the rotating off-center granular bin is out beyond the vertical path of the fill tubes and fill tube support;

Figure 8 is a diagrammatic sectional view taken along process plane 6 of Figure 1 where the filter segment is cut into two pieces;

Figure 9 is a diagrammatic sectional view taken along process plane 7 of Figure 1 where the fill tubes have moved axially down and the inner tube is inside the filter tube for deposit of the granular material into the filter tube, and the second segment plate with the upper cut portion of the filter segment moves radially out until the inner hole thereof is

in alignment with the plunger and the lower cut portion of the filter segment in the first segment plate;

Figure 10 is a diagrammatic sectional view taken along process plane 8 of Figure 1 where the fill tubes move up until they clear the upper surface of the alignment plate;

Figure 11 is a diagrammatic sectional view taken along process plane 9 of Figure 1 where the filter tube, alignment plate and tube flute plate have moved radially to a stop position where the filter tube is in alignment with the plunger and lower cut filter segment portion in the first segment plate;

Figure 12 is a diagrammatic sectional view taken along process plane 10 of Figure 1 where the plunger moves down to thereby push the lower portion of the cut filter segment into the filter tube against the granular material therein;

Figure 13 is a diagrammatic sectional view taken along process plane 11 of Figure 1 where the plunger moves axially up to clear the second segment plate;

Figure 14 is a diagrammatic sectional view taken along process plane 12 of Figure 1 where the filter tube, tube flute plate and alignment plate have moved radially out to a position where the filler tube is in alignment with the outer fill tube, and the second segment plate with the upper cut portion of the filter segment moves radially in until the cut filter segment is in alignment with the plunger;

Figure 15 is a diagrammatic sectional view taken along process plane 13 of Figure 1 where the fill tubes have moved axially down to thereby position the outer fill tube inside the filter tube for deposit of the granular material into the filter tube;

Figure 16 is a diagrammatic sectional view taken along process plane 14 of Figure 1 where the fill tubes move up and return to their home positions;

Figure 17 is a diagrammatic sectional view taken along process plane 15 of Figure 1 where the filter tube, alignment plate and tube flute plate move radially to a position to thereby position the filter

tube in alignment with the plunger and the upper cut filter segment portion in the second segment plate;

Figure 18 is a diagrammatic sectional view taken along process plane 16 of Figure 1 where the plunger moves down to thereby push the upper portion of the cut filter segment through the first segment plate and into the filter tube against the granular material therein;

Figure 19 is a diagrammatic sectional view taken along process plane 17 of Figure 1 where the tube flute plate and filter tube move axially down to their home position while the plunger retracts to its home position;

Figure 20 is a diagrammatic sectional view taken along process plane 17 of Figure 1 where the filter tube is inverted by a series of bevel and cylindrical transfer drums and transported to a second wheel assembly that repeats the process steps shown in Figures 3 through 19 to thereby complete filter tube assembly of the second half of the filter tube;

Figure 21 is a simple diagrammatic view illustrating the concept of cigarette assembly immediately downstream from the vertical filing machine without the need for storing the filters;

Figure 22 is a diagrammatic sectional view similar to Figure 11, but illustrating a modified plunger with a compression spring;

Figure 23 is a diagrammatic sectional view similar to Figure 23 illustrating initial downward movement of the modified plunger;

Figure 24 is a diagrammatic view similar to Figures 22 and 23 illustrating the lowermost downward position of the plunger support plate but with a gap between the initial deposit of granular material and the first filter segment as it emerges from the alignment tube;

Figure 25 is a diagrammatic view similar to Figure 24 but with the compression spring of the plunger extended and thereby pushing the first filter segment firmly against the initial deposit of granular material; and

Figure 26 is an enlarged diagrammatic sectional view similar to Figure 17 but illustrating the modified plunger with the compression spring.

Detailed Description of the Invention

Referring in more particularity to the drawings, Figure 1 diagrammatically represents a top view of a vertical filter filling machine 10. Referring now also to Figure 20, the vertical filter filling machine 10 includes an upper wheel assembly 12 and a lower wheel assembly 14. Essentially the upper wheel assembly functions to fill the upper half of a filter tube with granular material and solid filter segments while the lower wheel assembly 14 fills the lower half of the filter tube with granular material and solid filter segments. The upper and lower wheel assemblies 12, 14 of the vertical filter filling machine 10 of the present invention are substantially identical in design and function and each includes a number of key components.

Referring now also to Figure 2, one of the key components of the machine 10 comprises a tube flute plate 16 that rotates about a central axis 18 of each wheel assemblies 12, 14. The flutes receive an detain filter tubes 20, each of which comprises a hollow cylindrical paper tube 22 with a central solid filter 24 such as a plug of cellulose acetate tow, or filter paper or other material including non-fibrous materials such as plastics. The filter tube when both ends are filled with granular material and solid filter segments forms a two-up dual filter which when combined with wrapped tobacco rods at each end thereof ultimately produces two complete cigarettes. When cut through the middle of the central solid filter, the cigarette filter has a length of approximately 30mm, but can be shorter or longer, if desired. As explained more fully below, the tube flute plate with the filter tubes secured thereto by vacuum moves in both axial and radial directions during the production of the filter.

Another key component of the vertical filter filling machine 10 comprises a rotating bin 26 of granular material having inner and outer troughs 28, 30 of different granular material 32, 34. The granular bin rotates off center during filter formation so that the bin is outside of several fill tubes 36, 38 which allows these tubes to move axially down for deposit of granular material into the filter tubes 20.

All machine elements that are shown in Figure 2, except for the granular bin 26, rotate about the axis 18 and are common to each of a plurality of assembly wheel stations. There are fifteen assembly wheel stations in the preferred embodiment. The material bin 26 rotates at a slightly different speed as the other elements, and about a different axis 19 that is off-set from axis 18 so that the material bin 26 and the feed tubes 36 and 38 come into vertical alignment for a portion of their rotation as they rotate during a cycle.

The rotational speeds of the material bin 26 and the feed tubes 36, 38 differ to ensure that the feed tubes 36, 38 pick up material from the material bin 26 at different locations along the material bin 26 from cycle-to-cycle.

The fill tubes 36, 38 together with a vacuum wheel 40 and a fill tube support 42 cooperate with the granular bin 26 for withdrawing and depositing granular material 32, 34 into the upper open end of the vertical filter tubes 20. The vacuum wheel 40 rotates about central axis 18 and functions to supply vacuum to the inner and outer fill tubes 36, 38. The fill tubes 36, 38 rotate with the vacuum wheel 40 about the axis 18, and the fill tubes are attached to the fill tube support 42 for axial movement with the tube support. The internal volume of the fill tubes controls the volume of granular material withdrawn into the tube. Each tube may include an adjustable internal stop for varying the volume by moving the stop closer to or further away from the open end of the tube. The stop is constructed to allow vacuum to pass therethrough, but does not allow the granular material to pass. The stop may comprise an internal, adjustable rod having slight clearance between it and the inner diameter of the fill tube.

An additional key element of the vertical filter filling machine includes a segment flute plate 44 that rotates about the central axis 18. The segment flute plate functions to hold extended length solid filter segments 46 before these segments are cut into two pieces and deposited into the filter tube 20 to seal the granular material in the tubes, as explained more fully below.

Another key element is a first segment plate 48 which also rotates about central axis 18. The first segment plate has a single opening 50 for receiving a first filter segment 51, explained more fully below.

The first segment plate 48 cooperates with a second segment plate 52 which also rotates about the central axis 18. The second segment plate 52 has inner and outer openings 54, 56, and this segment plate moves in a radial direction during filling of the filter tube 20. The outer opening 56 holds a second filter segment 57 while the inner opening allows a plunger 58 to pass there-through when inserting the first filter segment 51 into the filter tube 20. The plunger 58 also rotates about the vertical axis 18 and moves in an axial direction for pushing the solid filter segments 51, 57 into the filter tube 20.

The vertical filter filling machine 10 further includes an alignment plate 60 which also rotates about the vertical central axis 18. The function of the alignment plate is to receive the upper end of the filter tube 20 and thereby align the tube with the segment receiving openings in the first and second segment plates 48, 52. Within the alignment plate is an internal alignment tube or horn 70 which protects the inner walls of the filter tube 20 and maintains the integrity of the tube which is usually made of thin rather flimsy paper. The alignment tube or horn 70 prevents the filter tube 20 from wrinkling and/or buckling during the filling operation.

Preferably, the upper and lower wheel assemblies 12, 14 each include 15 subassemblies and each subassembly includes 12 filter tubes 20 thereby producing 180 half filled filters upon each revolution of the upper wheel assembly. The half-filled filters then transfer to the lower wheel assembly which functions to fill the other half of the filter tube. At production speeds of 30 revolutions per minute approximately 5,400 filters are produced each minute by the machine 10.

As noted above, Figure 1 diagrammatically illustrates the various process steps in the formation of a filter tube utilizing the vertical filter filling machine 10. The sequence of operation is broken down into 20 process planes specifically illustrated in Figures 2-20.

Figure 3 illustrates process plane 1 where the empty filter tubes 20 each comprising a hollow paper tube 22 with a central solid filter 24 of cellulose acetate are loaded onto the outside flutes of the tube flute plate 16 of machine 10. Suction applied to the flutes of plate 16 hold
5 the filter tubes 20 in vertical position on the outer circumference of the tube flute plate. Additionally, at this particular location, the extended length solid filter segments 46 are transferred onto the segment flute plate 44. The transfer of the filter tubes 20 and filter segments 46 onto the tube flute plate 16 and segment flute plate 44 may be
10 accomplished by external transfer drums (not shown) using known drum technologies.

At the next plane of operation shown in Figure 4 the fill tubes 36, 38 are moved downwardly into the granular materials 32, 34 within the troughs 28, 30 of the rotating off-center granular material bin 26.
15 Vacuum from the vacuum wheel 40 withdraws a predetermined amount of material 32 into inner fill tube 36 while a predetermined amount of material 34 is drawn into the outer fill tube 38. As an alternative to granular material, gels may be placed in one or both of the troughs 28, 30, and the fill tubes may be arranged to withdraw predetermined amounts
20 of such gels. Also, premeasured capsules of gels and other material may be individually positioned in the fill tube for subsequent deposit into the filter tube.

Figure 5 illustrates the next sequence in the operation of the vertical filter filling machine 10. Here, the fill tubes 36, 38, with
25 loaded granular materials therein have moved in an upward direction so that both tubes clear the top of the bin 26. At the same time the tube flute plate 16 is moving in an upward direction so that the filter tube 20 enters and is aligned by the alignment plate 60 and the internal alignment tube 70. Simultaneous with the upward movement of the filter
30 tube into the alignment plate, both the alignment plate and the tube flute plate move outwardly in a radial direction.

Figure 6 illustrates the next step in the sequence of operation of the vertical filter filling machine 10. At this position the tube flute plate 16 has moved up to its uppermost stop position and the filter tube

20 is completely inserted into the filter tube opening in the alignment plate 60 and around the internal alignment tube or horn 70. The tube flute plate 16, filter tube 20 and alignment plate 60 have now moved radially out to a stop position which places the open end of the filter tube 20 in vertical alignment with the inner fill tube 36. Simultaneous with such movement the plunger 58 pushes the extended length filter segment 46 into and through the outer opening 56 in the second segment plate 52 and into the opening 50 in the first segment plate 48 until the filter segment engages the surface of the alignment plate 60.

Figure 7 shows the next step in the sequence where the internal vacuum on the segment flute plate 44 is terminated and the plunger 58 moves up and out of contact with the filter segment 46. Also, due to the off-center axis of the rotating bin 26, the cross-section of the bin at this location is out beyond the vertical path of the fill tubes 36, 38 and the fill tube support 42. At the next step in the sequence shown in Figure 8 the extended length filter segment 46 is cut into two pieces by a rotary knife 66 which enters between the first and second segment plates 48, 52.

Figure 9 shows the next process step at plane 7 of Figure 1. Here the fill tubes 36, 38 have moved axially down and the inner fill tube 36 is inside the upper hollow end of the filter tube 20. Vacuum wheel 40 which holds the granular material 32 in the inner fill tube has been turned off and the granular material 32 flows into the filter tube. Positive air pressure can be used to increase granular flow from the inner fill tube 36. Also, the second segment plate 52 with the upper cut portion of the filter segment 46 moves radially out until the inner opening 54 of the second segment plate 52 is in line with the plunger 58 and the lower cut portion of the filter segment 51 in opening 50 of the first segment plate 48.

In the next sequence of operation shown in Figure 10, the fill tubes 36, 38 move in an upward direction until both tubes clear the upper surface of the alignment plate 60.

Figure 11 illustrates the next step in the sequence where the filter tube 20, alignment plate 60, and tube flute plate 16 move radially

in to a stop position where the filter tube 20 is in line with the plunger 58 and the lower cut filter segment portion 51 in the first segment plate 48.

In the next sequence shown in Figure 12 the plunger 58 moves in a downward direction and pushes the first filter segment 51 into the filter tube 20 against the granular material 32. The filter segment 51 is slightly compressed as it moves through the internal alignment tube 70, and when it exits the alignment tube it expands slightly into engagement with the side walls of the filter tube. At this point, the tube flute plate 16 may move in a downward direction at the same speed as the first filter segment. This operation maintains the integrity of the filler tube by eliminating any significant relative frictional movement between the filter segment 51 and the interior side walls of the filter tube 20. The plunger 58 then moves axially up to clear the second segment plate 52 as shown in Figure 13.

Next, as shown in Figure 14, the filter tube 20, tube flute plate 16 and alignment plate 60 have moved radially out to a stop position where the filter tube 20 is in line with the outer fill tube 38. The second segment plate 52 with the second filter segment 57 then moves radially in until the second filter segment 57 is in line with the plunger 58.

At the next location illustrated in Figure 15 the fill tubes 36, 38 have moved axially down and the outer fill tube 38 is inside the upper hollow end of the filter tube 20. Vacuum from vacuum wheel 40 holding the granular material 34 in the outer fill tube 38 is then turned off and the granular material 34 flows into the filter tube 20. Here again, positive air pressure may be used to increase the flow of granular material from the outer fill tube 38 into the upper hollow end of the filter tube. Next, the fill tubes 36, 38 move up and return to their home position as shown in Figure 16.

Figure 17 shows the next step in the sequence of operation where the filter tube 20, alignment plate 60 and tube flute plate 16 move radially in to a stop position where the filter tube is in alignment with the plunger 58 and the second filter segment 57 in the second segment

plate 52. The plunger 58 then moves down and pushes the second filter segment 57 through the opening 50 in first segment plate 48 and into the filter tube 20 against the granular material 34. This particular step is shown in Figure 18.

5 The filling of the upper half of the filter tube is now complete and at the next station the tube flute plate 16 and filter tube move axially down to the home position of the tube flute plate. Simultaneous therewith the plunger 58 retracts to its home position and internal vacuum on the tube flute plate is turned off which allows the filter tube
10 to be removed from the upper wheel assembly 12 and transferred to the lower wheel assembly 14 for filling of the other end of the filter tube.

Figure 20 illustrates plane 17 of Figure 1 where the filter tube 20 has been filled on one end and the filter tube has returned to its home position. In order to fill the opposite end of the filter tube a series
15 of cylindrical and bevel transfer drums 62, 64 can be used to remove the filter tube from the upper (first) wheel assembly 12, flip it end for end and deposit the filter tube on the lower (or second) wheel assembly 14 which simply repeats the above steps shown in Figures 3-19. After traveling around second wheel assembly 14 the finished filter tube with
20 both ends filled is removed from the vertical filter filling machine 10 for testing and storage. The second wheel assembly could be arranged to the side of the first wheel assembly 12, instead of below it, if desired.

In the preferred embodiment, each complete assembly wheel 12, 14 comprises 15 wheel assembly stations each with an arcuate extent of 24
25 degrees and centered about axis 18. Other embodiments may be constructed with different numbers of assembly wheel stations and different numbers of fill tubes, flutes and holes at each wheel assembly station.

Preferably, each wheel assembly 12, 14 includes a tube flute plate 16 which in the preferred embodiment has twelve (12) flutes along its
30 arcuate perimeter. A same number of flutes are provided along the arcuate perimeter of the segment flute plate 44. Each wheel assembly further includes twelve (12) alignment tubes 70, twelve (12) fill tubes 38, twelve (12) fill tubes 36 and twelve (12) plungers 58. Holes in first and second segment plates 48 and 52, through which the filling

materials pass, are through which the filling materials pass are also twelve (12)-count each for each assembly wheel station.

Each wheel assembly station includes twelve fill tubes 36 and 38, which for a given wheel assembly station are all supported by an independent slide system that is driven by an internal cam and lever system which imparts a predescribed axial (up and down) motion of the full tubes 36 and 38 as the wheel assembly is rotated through a complete cycle. Preferably, the fill tubes 36 and 38 do not move radially during a cycle.

Likewise, each wheel assembly station includes 12 plungers 58 that are similarly supported and controlled to execute their prescribed up and down motion per cycle.

Each wheel assembly station 12, 14 includes a second segment plate 52 which has an independent slide system that is driven by an internal cam which imparts a predescribed radial motion (in and out) as the respective wheel assembly is rotated through a complete cycle.

Preferably, the first segment plate 48 rotates about axis 18 without either radial or axial motion.

The tube flute plate 16 of each wheel assembly station is on an independent slide system and driven by a cam and lever to impart the prescribed axial motion (up and down) for the tube plate 16 as the respective assembly wheel station rotates through a complete cycle. The axial motion slide of the tube flute plate 16 and the alignment plate 60 are mounted on an independent slide system that is driven by an internal cam which imparts a predescribed concurrent radial motion (in and out) of tube flute plate 16 and the alignment plate 60 as the wheel assembly is rotated through a complete cycle.

As an alternative to filter storage, a tipping machine may be positioned to receive the finished filters as they are removed from the vertical fill machine 10. Wrapped tobacco rods are positioned at both ends of the finished filter and tipping paper is used to secure the rods to the filter. Cutting the filter in half produces two complete cigarettes. Figure 21 illustrates an arrangement that includes a vertical fill machine 10 for producing multiple cavity dual filters, as

explained above, and reference character 100 identifies a conventional tipping machine well known in the tobacco industry for taking dual filters and securing wrapped tobacco rods at the opposite ends of the filter with tipping paper. The thus formed tobacco/filter assembly is then cut in half at the central solid filter 24 at station 102 to produce two cigarettes each having a multiple cavity filter and a wrapped tobacco rod. U.S. Patent 5,135,008 and published applications U.S. 2003/0131856 A1 and U.S. 2005/094014 A1 illustrate and describe tipping machines and these documents are incorporated herein by reference in their entirety for all useful purposes.

Figures 22-26 illustrate another vertical filter filling machine 10A similar in many respects to machine 10 except for a modified plunger 58A. Otherwise, machines 10 and 10A are similar and both function to produce multiple cavity dual filters.

As described above, Figures 1-19 show the various movements that take place at each assembly station during rotation of the upper and lower assembly wheels 12, 14 and the filling of the filter tubes 20. As the assembly starts rotating from the position of Figure 11 to the position of Figure 12, the plungers 58 force the first solid filter segments 51 against the first granular materials 32. Figures 22-25 are similar sectional views showing the various movements of the modified plunger 58A of machine 10A and the operation of a compression spring 200 associated with each plunger.

The upper end of plunger 58A is secured to a plunger support plate 202 between an upper plunger stop bracket 204 and a lower plunger guide bracket 206. The plunger 58A includes a collar 208 secured thereto, and the compression spring 200 extends between the plunger stop bracket 204 and the collar 206 urging the plunger in a downward direction. The arrangement is such that the vertical movement of the plunger 58A relative to the plunger support plate 202 is limited to the distance 210. In order for a multiple filled cavity filter to function properly, it is important that each granular dose be packed tightly, and that each solid filter segment be tight against the granular dose. The compression

spring 200 of each plunger 58A functions to ensure that the solid filter segments 51, 57 and the granular materials 32, 34 are tightly packed.

After the filter tube 20 has received the first granular material 32 and the second segment plate 52 has moved the second segment 57 to the left, the plunger 58A is ready to force the first filter segment 51 into the filter tube. These positions are shown in Figure 22, and it should be noted that the compression spring 200 has forced the plunger collar into contact with the plunger guide bracket 206 and that a gap 210 exists between the upper end of the plunger 58A and the plunger stop bracket 204. As the plunger support plate 202 moves in a downward direction as shown in Figure 23, the plunger 58A forces the first solid filter segment 51 out of the first segment plate 48 and into the alignment tube or horn 70. Since the first solid filter segment 51 is forced through the alignment tube, the compression spring 200 contracts until the top surface of the plunger contacts the plunger stop bracket 204. A gap 210A now exists between the collar 208 and the plunger guide bracket 206.

As the plunger support plate 202 continues its downward movement shown in Figure 24, the solid contact between the upper end of the plunger 58A and the plunger stop bracket 204 forces the first solid filter segment 51 to slide down the inner surface of the alignment tube 70. Moreover, as the leading edge of the segment 51 reaches the top of the granular material 32, the tube flute plate 16 and the filter tube 20 thereon move down at a speed that matches the downward speed of the solid filter segment 51. This matched motion is shown in Figure 24 and it prevents excessive sliding of the segment 51 inside the filter tube 20. The possibility of wrinkling and/or buckling of the filter tube is substantially reduced thereby maintaining the integrity of the tube.

As shown in Figure 24, the filter segment 51 is partially out of the alignment tube 70 and is beginning to expand inside the filter tube 20. The gap 210A still exists because high force is still required to push the segment 51 through the alignment tube 70. Also, due to the accuracy of the amount of granular material 32 and the cut length of the filter segment 51, a possible gap could exist between the granular material and the solid filter segment 51. As the upper end of the

segment 51 reaches the end of the alignment tube 70, the friction between the segment and the side walls of the alignment tube decreases and the compression spring begins to extend thereby forcing the segment 51 to pack tightly against the granular material 32, as shown in Figure 25, so as to create a fully filled condition within the filter tube. Once the segment 51 is packed tightly against the granular material 32, a small gap may exist between the plunger collar 208 and the plunger guide bracket 206, depending upon the accuracy of the amount of granular material and the cut length of the filter segment 51.

A similar sequence of movement occurs when the second granular material 34 and the second solid filter segment 57 are deposited in the filter tube 20. Figure 26 shows the second filter segment 57 ready for insertion into the filter tube. Also, the same sequences occur after the filter tube is inverted and the other half is filled with granular materials 32, 34 and solid filter segments 51, 57.

It should be understood that the above detailed description while indicating preferred embodiments of the invention are given by way of illustration only since various changes and modifications within the spirit and scope of the invention will become apparent to those skilled in the art from the detailed description. For example, an alternative embodiment may comprise a linear and/or endless belt configuration that is arranged to execute assembly steps that are equivalent to those of the rotary configuration of the preferred embodiment.

Claims:

1. A process of producing a compound cigarette filter comprising the steps of:

5 placing a filter tube with hollow ends and a solid filter center in a substantially vertical position;

withdrawing by suction a predetermined amount of a first material from a source of such material;

10 depositing the predetermined amount of first material into an upper open end of the filter tube directly against the solid filter center; and

placing a solid filter segment into the upper open end of the filter tube directly against the first material to thereby seal the material in place.

15 2. A process as in claim 1 including the further step of maintaining the integrity of the filter tube while depositing the predetermined amount of material and placing the solid filter segment into the filter tube.

20 3. A process as in claim 2 wherein the integrity of the filter tube is maintained by positioning a hollow open ended tube within the filter tube and passing the material and the solid filter segment through the tube directly into the filter tube with minimal relative movement between the material and solid filler segment and the filter tube.

25 4. A process for producing a compound cigarette filter as in claim 1 wherein the first material is granular.

5. A process of producing a compound cigarette filter as in claim 1
30 including the further steps of:

withdrawing by suction a predetermined amount of a second material from a source of such material;

depositing the predetermined amount of the second material into the upper open end of the filter tube directly against the solid filter segment; and

5 placing a second solid filter segment into the upper open end of the filter tube directly against the second material to thereby seal the second material in place.

6. A process as in claim 5 including the further step of maintaining the integrity of the filter tube while depositing the predetermined
10 amounts of material and placing the filter segments into the filter tube.

7. A process as in claim 6 wherein the integrity of the filler tube is maintained by positioning a hollow open-ended tube within the filter tube and passing the materials and the solid filter segments through the
15 hollow tube directly into the filter tube with minimal relative movement between the materials and solid filler segments and the filter tube.

8. A process of producing a compound cigarette filter as in claim 5 wherein the first and second materials are granular.

20

9. A process of producing a compound cigarette filter as in claim 5 including the further steps of:

inverting the filter tube; and

25 filling the other end of the tube with first and second materials and solid filter segments in the same manner as the first end.

10. A process of producing a compound cigarette filter as in claim 5 including the further steps of:

providing an extended solid filter segment; and

30 slicing the extended solid filter segment into two pieces to thereby produce each of the two solid filter segments placed against the first and second materials.

11. A process of producing a compound cigarette filter as in claim 5 wherein the solid filter center and both solid filter segments comprise cellulose acetate tow.

5 12. A process of producing a compound cigarette filter as in claim 9 including the further steps of:

combining wrapped tobacco rods, one at each end of a finished filter, immediately after filling of the other end of the filter tube; and

10 thereafter cutting the filter at its midpoint to thereby form two complete cigarettes.

13. A process of producing a compound cigarette filter as in claim 5 including the step of:

15 transporting the filter tube along a circular path during filling of the tube with first and second materials and solid filter segments.

14. Apparatus for producing compound cigarette filters comprising:

20 a rotating tube flute plate for holding and transporting a plurality of filter tubes along a circular path, each filter tube having hollow ends and a solid filter center, with the tubes in vertical orientation;

a rotating bin of a first material;

25 a plurality of vertically oriented rotating fill tubes with suction applied thereto for withdrawing predetermined amounts of the first material from the rotating bin and depositing one predetermined amount into an upper open end of each filter tube directly against the solid filter center upon termination of the suction;

30 a rotating filter segment plate for holding a plurality of solid filter segments; and

a plurality rotating plungers for vertically pushing the solid filter segments out of the filter segment plate into the upper open ends of the filter tubes with one solid filter segment directly against the

first material in each filter tube to thereby seal the material in the tube.

15. Apparatus for producing compound cigarette filters as in claim 14
5 further comprising:

a plurality of hollow open ended alignment tubes, one within each filter tube for guiding the materials and filter segments into the filter tubes while maintaining the integrity of the filter tubes.

10 16. Apparatus as in claim 14 wherein the first material is granular.

17. Apparatus as in claim 14 for producing compound cigarette filters further comprising:

15 a second plurality of vertically oriented rotating fill tubes with suction applied thereto for withdrawing predetermined amounts of a second material from the rotating bin and depositing one predetermined amount of the second material into the open upper end of each filter tube directly against the solid filter segment upon termination of the suction;

20 a rotating second filter segment plate for holding a plurality of second solid filter segments; and

wherein the plurality of rotating plungers vertically push the second solid filter segments out of the second filter segment plate into the upper open ends of the filter tubes with one second filter segment directly against the second material in each filter tube to thereby seal
25 the second material in the tube.

18. Apparatus for producing compound cigarette filters as in claim 17 further comprising:

30 a plurality of hollow open ended alignment tubes, one within each filter tube for guiding the materials and filter segments into the filter tubes while maintaining the integrity of the filter tubes.

19. Apparatus as in claim 17 wherein the first and second materials are granular.

20. Apparatus for producing compound cigarette filters as in claim 17 wherein the rotating bin includes two compartments, one for each of the first and second materials.

5 21. Apparatus for producing compound cigarette filters as in claim 17 further comprising:

a segment flute plate for holding a plurality of extended length solid filter segments; and

10 a rotating cutter moveable between the solid segment plate and the second solid segment plate for cutting the extended length solid filter segment after positioning thereof in the solid segment plate and second solid segment plate to thereby form the solid filter segments and the second solid filter segments.

15 22. Apparatus for producing compound cigarette filters as in claim 17 wherein the rotating tube flute plate, the rotating bin of material, the plurality of vertically oriented fill tubes and second fill tubes, the rotating filter segment plate and second filter segment plate, and the plurality of rotating plungers collectively comprise an upper wheel
20 assembly rotating about a central vertical axis;

a substantially identical lower wheel assembly also rotating about the central vertical axis;

means for removing half filled filter tubes from the upper wheel assembly, inverting the filter tubes and placing them on the rotating
25 tube flute plate of the lower wheel assembly; and

whereby the other ends of the filter tubes are filled with material and solid filter segments on the lower wheel assembly.

23. Apparatus for producing compound cigarette filters as in claim 17
30 wherein the solid filter center of each filter tube and the solid filter segments and second solid filter segments comprise cellulose acetate tow.

24. Apparatus for producing compound cigarette filters as in 23 in combination with a tipping machine immediately downstream therefrom

constructed and arranged to combine wrapped tobacco rods, one at each end of each finish filter, and a cutter for severing each filter at its midpoint to form two complete cigarettes.

5 25. Apparatus for producing compound cigarette as in claim 17 wherein each of the plungers is spring biased and arranged to insure that the solid filter segments are solidly positioned against the first and second materials so as to create a fully filled condition within the filter tube.

10 26. A process of producing a multiple component cigarette filter comprising the steps of:

placing a filter tube with hollow ends and a solid filter center in a substantially vertical position;

15 positioning the filter tube over a hollow open ended alignment tube; and

passing filter components through the hollow open ended alignment tube directly into the filter tube while the alignment tube is within the filter tube.

20 27. A process as in claim 26 wherein the multiple components include at least a first granular material adjacent the solid filter center of the filter tube and a first solid filter segment adjacent the first granular material.

25 28. A process as in claim 27 wherein the first granular material and the first solid filter segment are sequentially passed through the hollow open ended alignment tube directly into the filter tube.

30 29. A process as in claim 26 including the further step of:
moving the filter tube in a downward direction at a speed approximately equal to the downward speed of the solid filter segment as it exits the hollow open ended alignment tube to thereby substantially

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eliminate movement of the solid filter segment relative to the filter tube once inside the filter tube.

30. A process as in claim 29 wherein the multiple components include at least a first granular material adjacent the solid filter center of the filter tube and a first solid filter segment adjacent the first granular material.

31. A process as in claim 30 wherein the first granular material and the first solid filter segment are sequentially passed through the hollow open ended alignment tube directly into the filter tube.

32. A process as in claim 30 including the further step of urging the solid filter segment against the granular materials after the solid filter segment is positioned within the filter tube.

33. A method of producing a multi-component cigarette filter of alternating flowable material and solid elements, comprising the steps of:

moving a filter tube in alternating fashion between a dispenser of flowable material and a dispenser of solid elements; and
delivering each solid element via the solid element dispenser to a location along the filter tube without significant motion between the filter tube and the solid element.

34. A method as in claim 33 including the step of protecting the filter tube with a hollow open ended alignment tube during the solid element dispensing step.

35. A method as in claim 34 including the step of:
positioning the filter tube over the hollow open ended alignment tube during the solid element dispensing step; and
passing the solid element through the hollow open ended alignment tube into the filter tube.

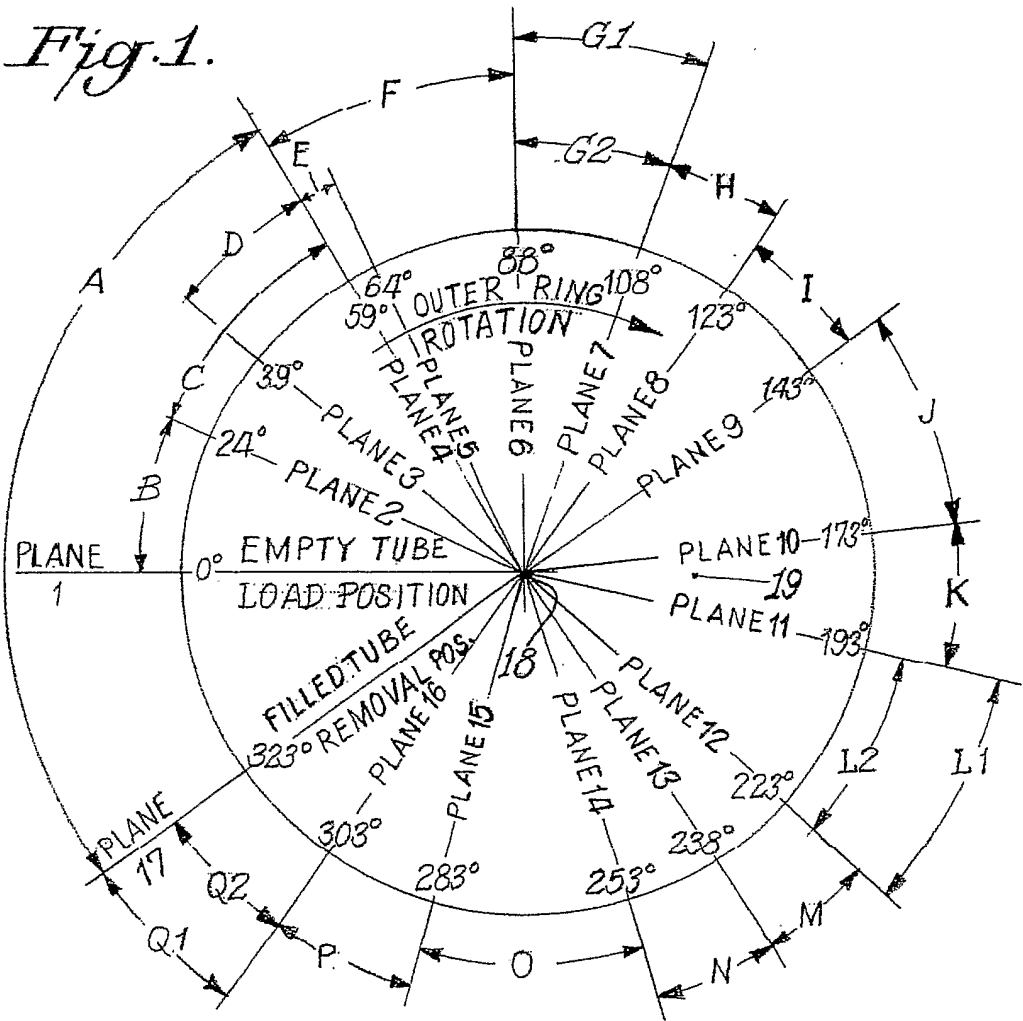


Fig. 2.

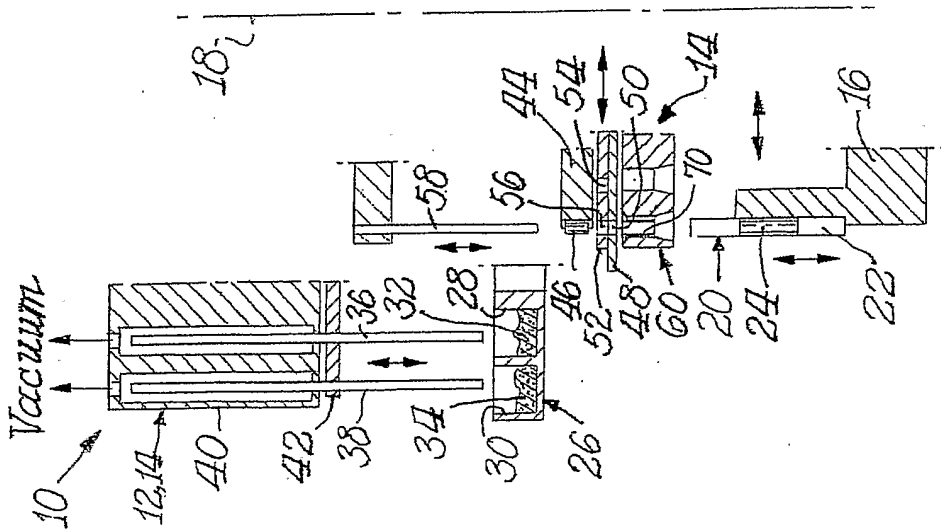


Fig. 3.

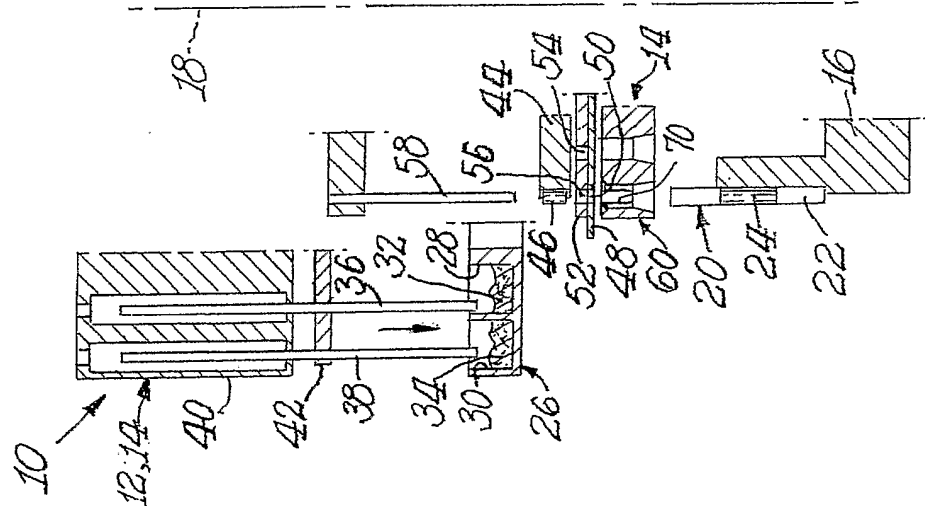
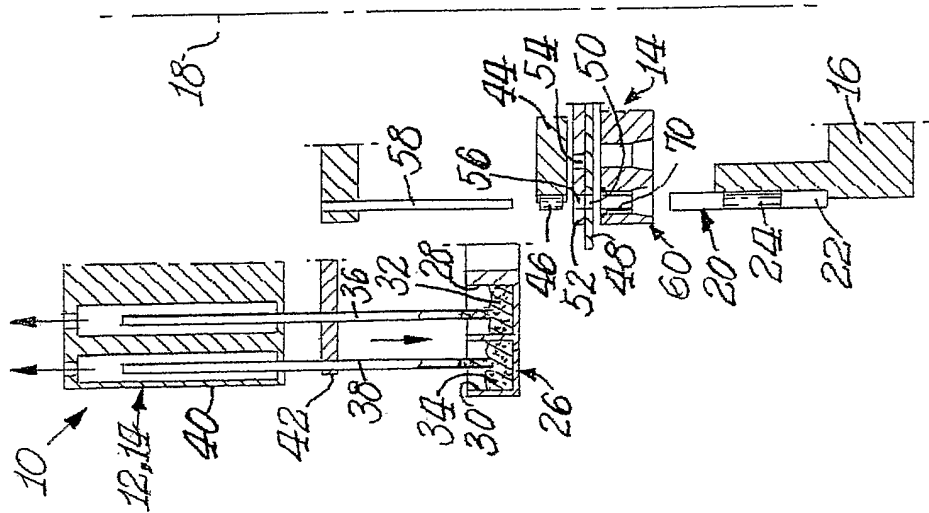
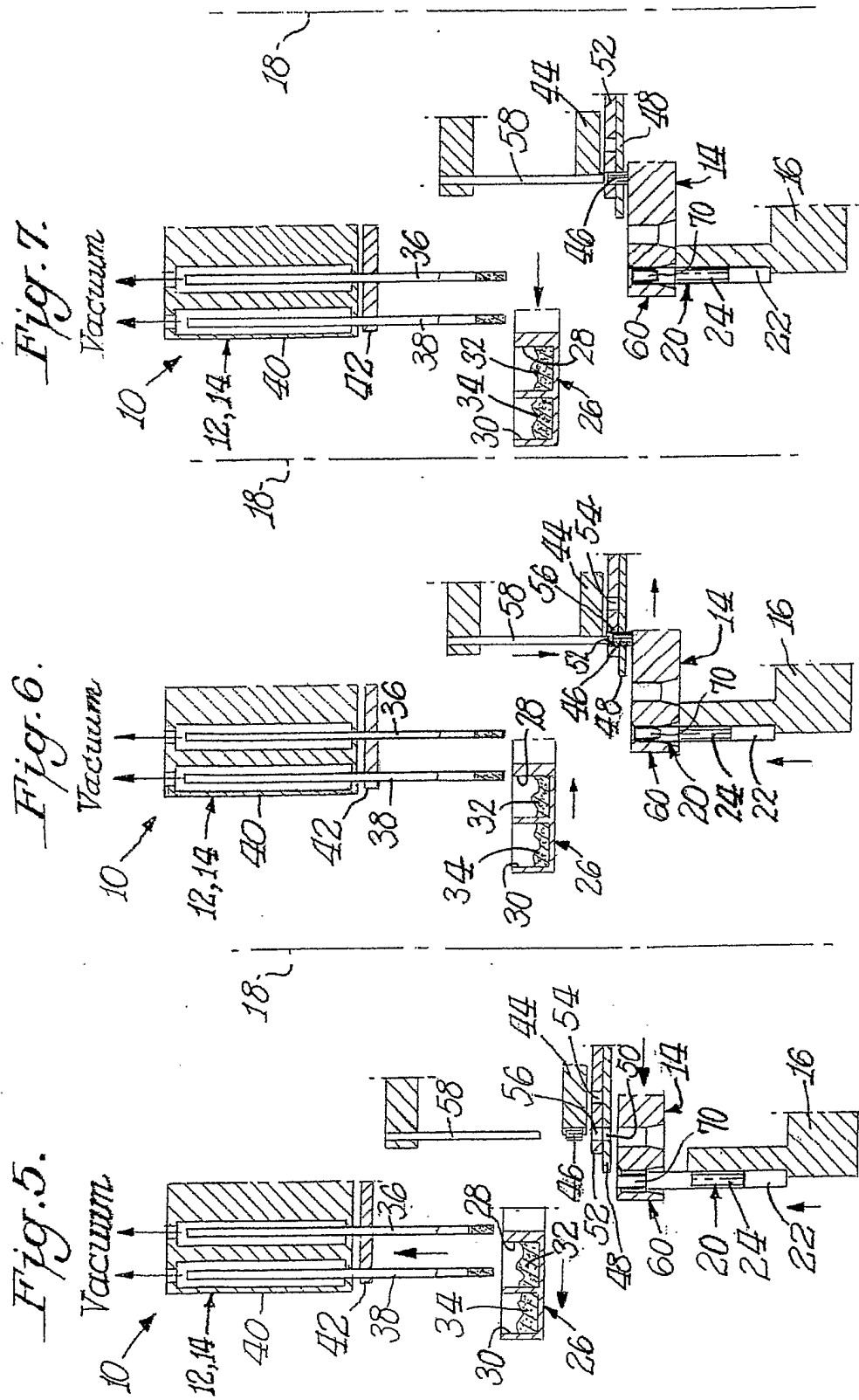


Fig. 4.





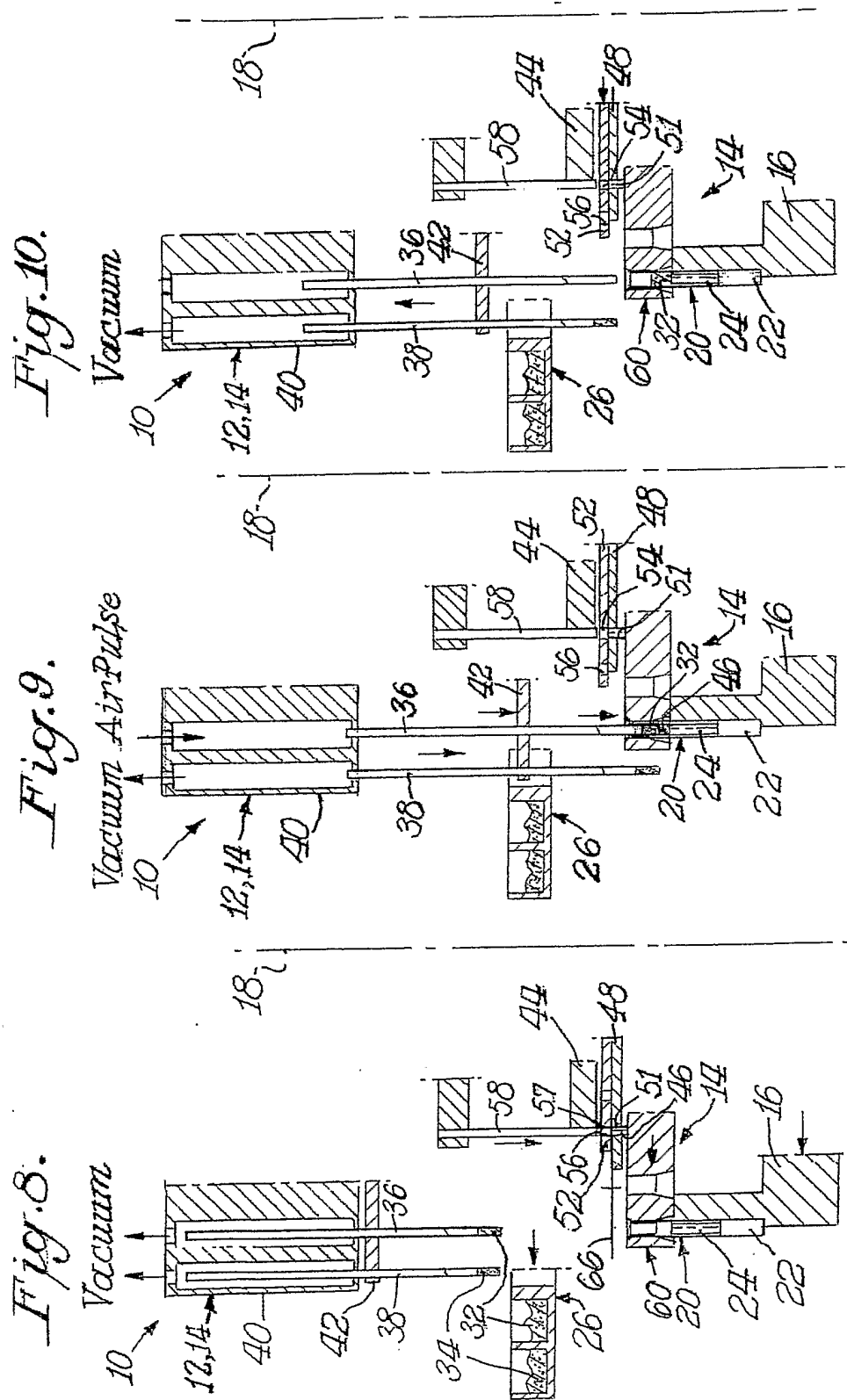


Fig. 11.

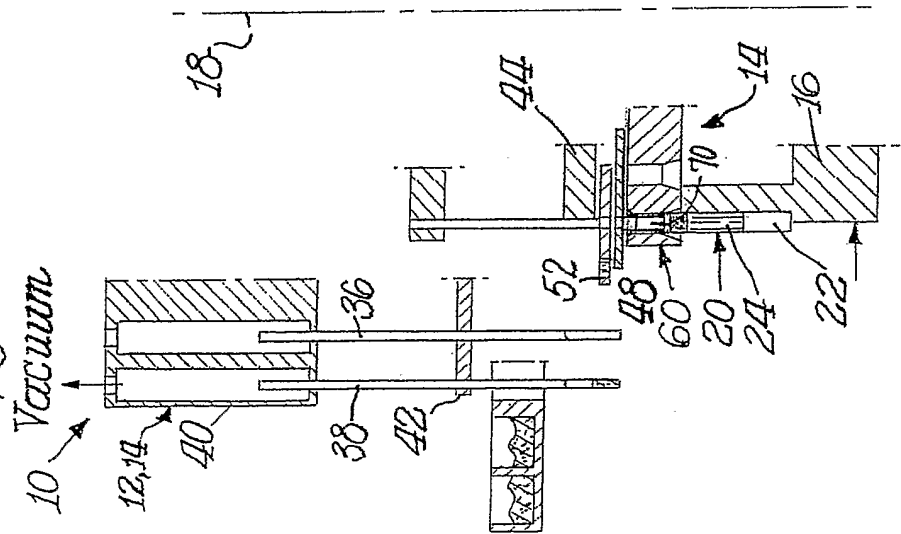


Fig. 12.

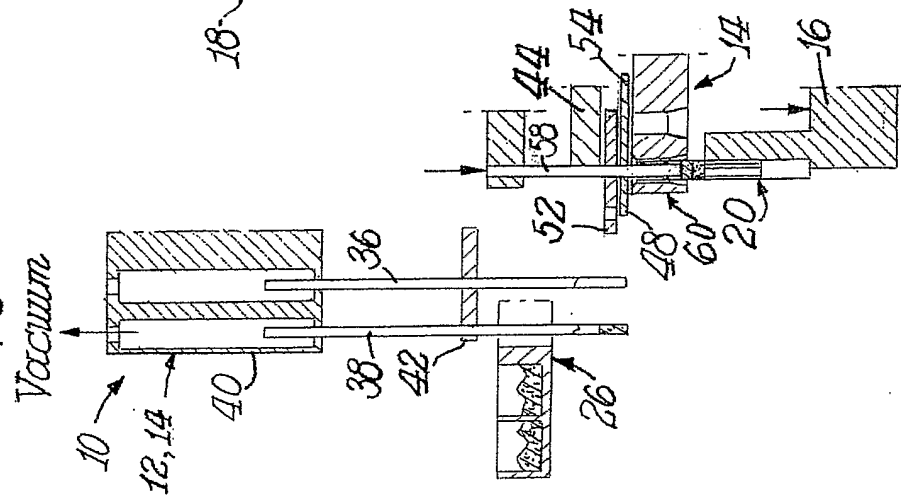


Fig. 13.

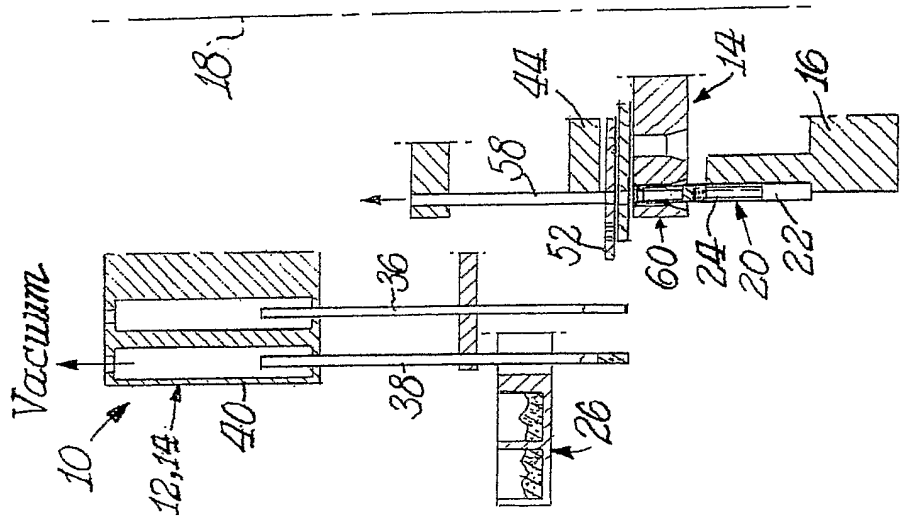


Fig. 14.

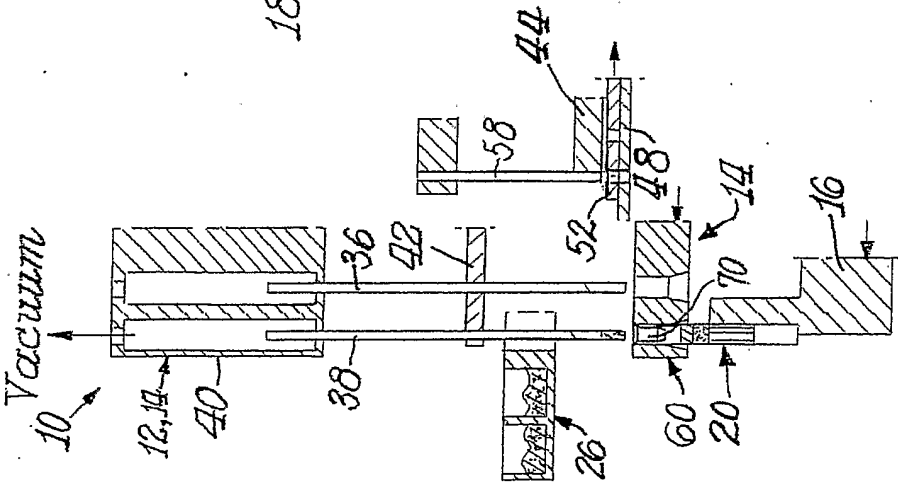


Fig. 15.

Air Pulse (If Req.)

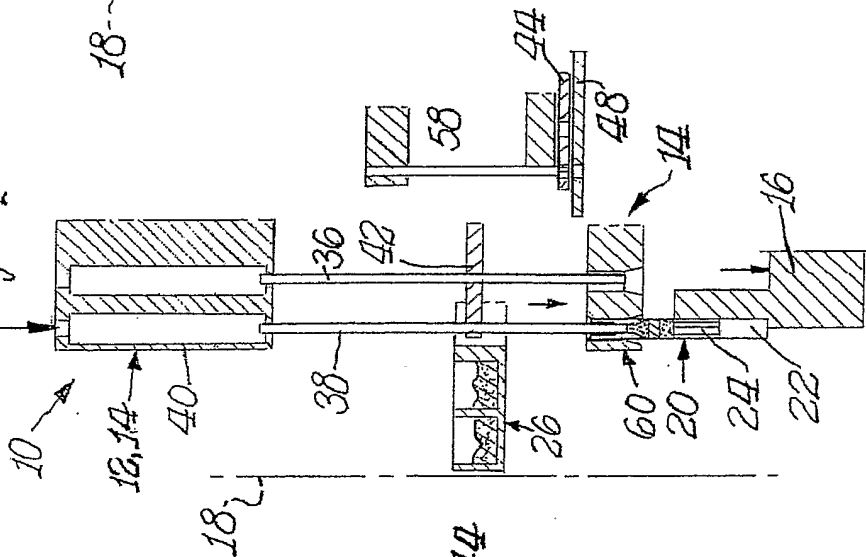
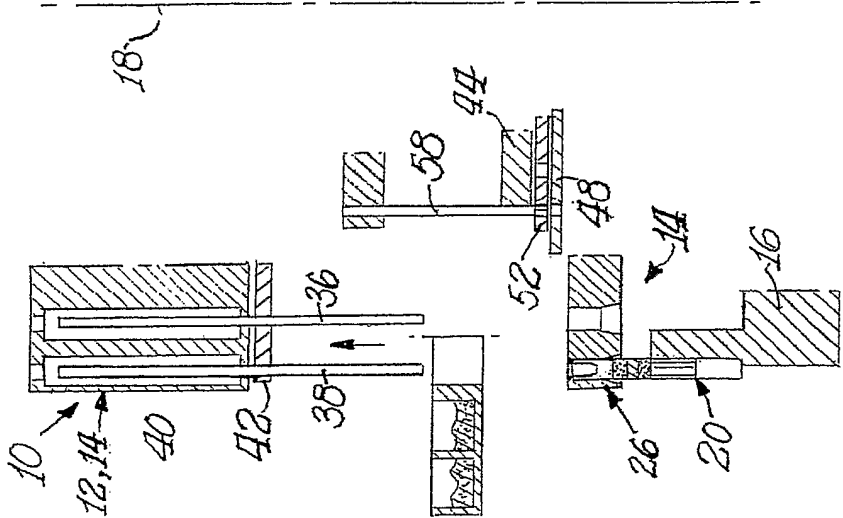


Fig. 16.



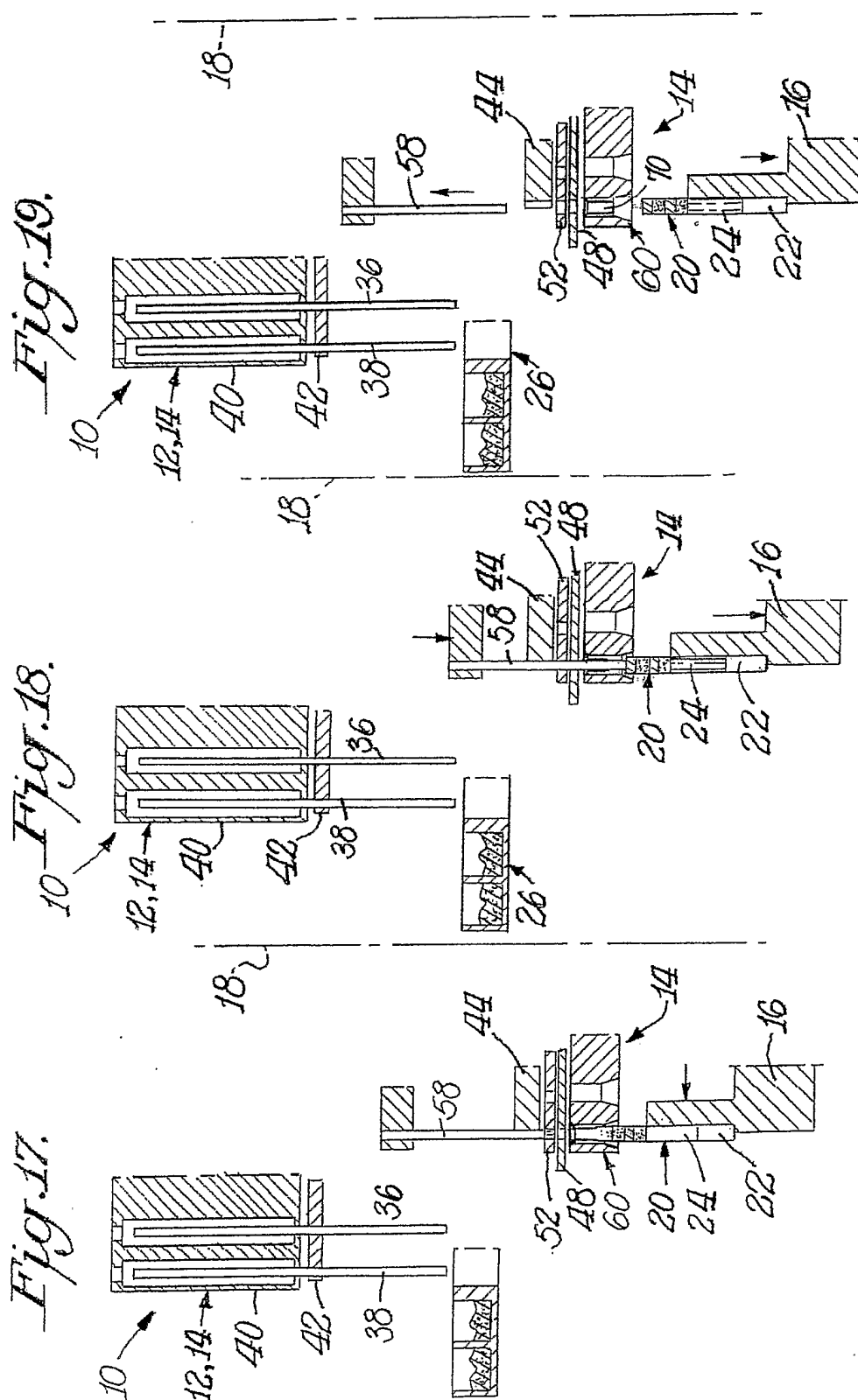


Fig. 20.

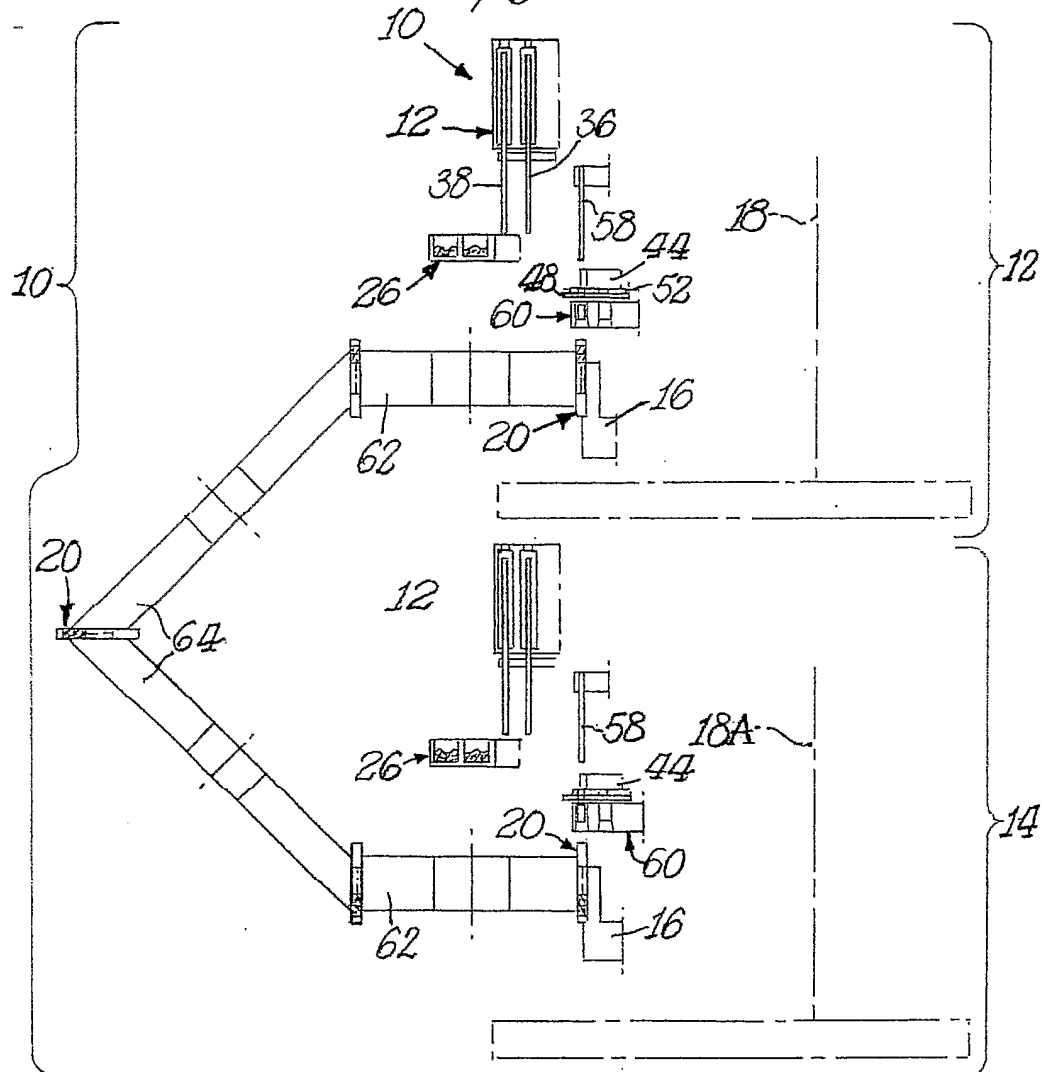
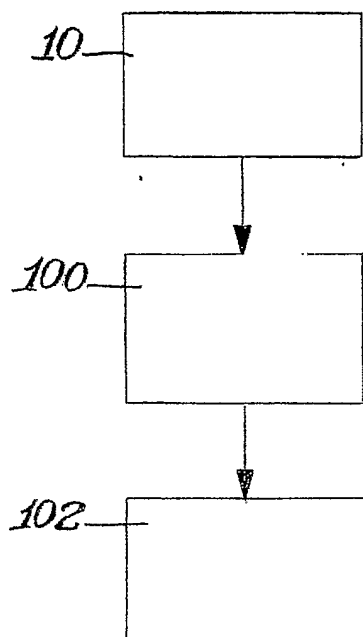
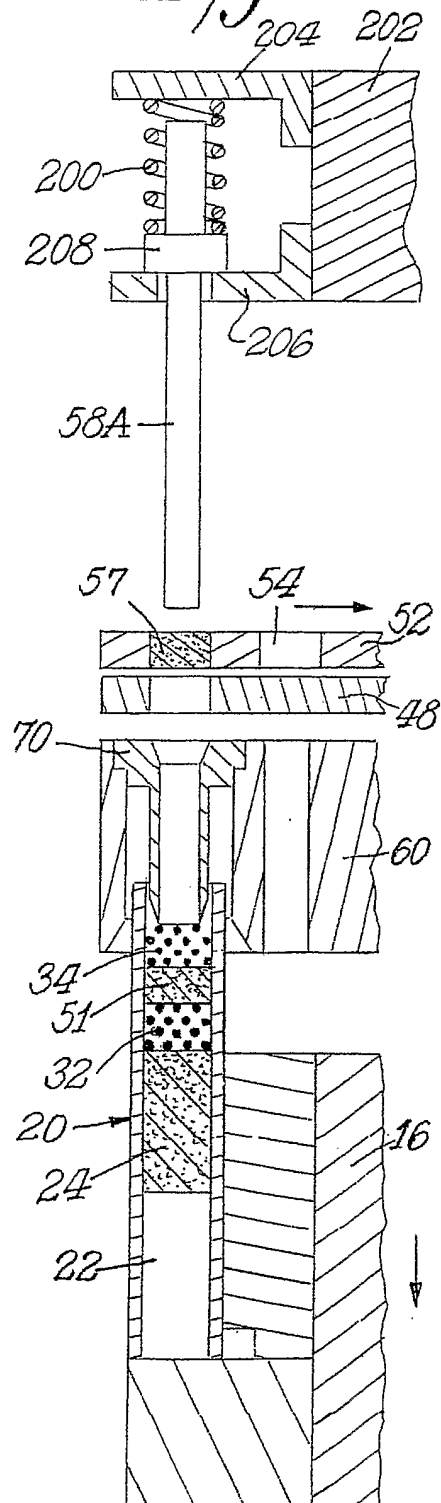
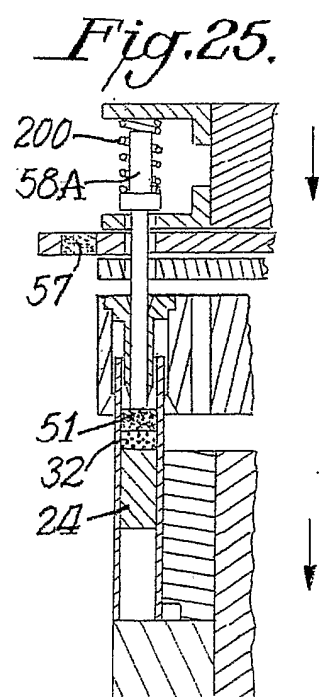
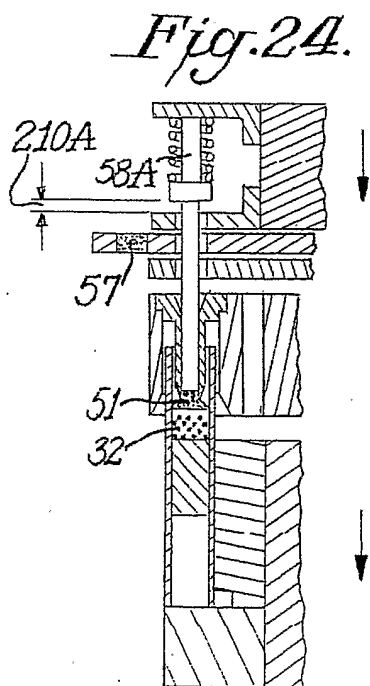
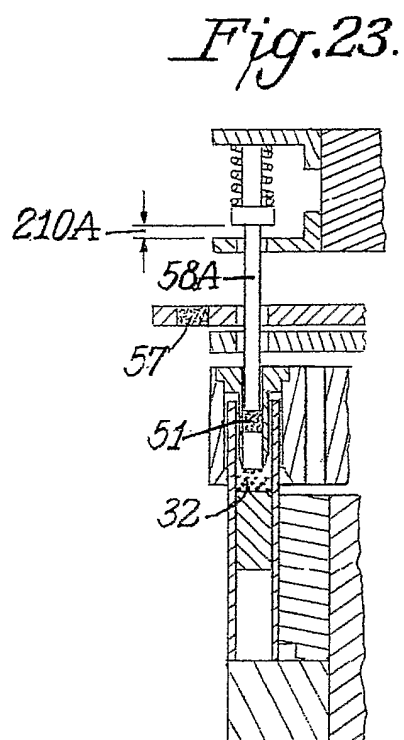
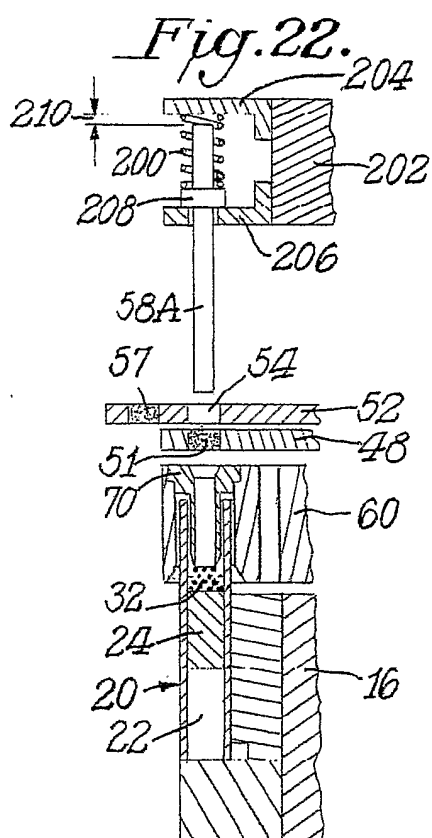


Fig.21.*Fig.26.*



INTERNATIONAL SEARCH REPORT

In ☐ national application No
PCT/IB2005/003409

A. CLASSIFICATION OF SUBJECT MATTER
A24D3/02

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
A24D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
P, X	WO 2005/102080 A (G.D SOCIETA' PER AZIONI; DRAGHETTI, FIORENZO; EUSEPI, IVAN; TURRINI, A) 3 November 2005 (2005-11-03) page 6, line 2 - page 8, line 6; figures 4-11	1-4, 12, 33
A	----- GB 1 243 977 A (HAUNI-WERKE KOERBER & CO. K.G) 25 August 1971 (1971-08-25) the whole document	1, 14
A	----- US 2002/153017 A1 (GEORGITSIS NIKOLAOS ET AL) 24 October 2002 (2002-10-24) the whole document	1, 14
A	----- US 2002/119874 A1 (HEITMANN UWE ET AL) 29 August 2002 (2002-08-29) cited in the application the whole document	1, 14, 26, 33
	----- -/--	

☒ Further documents are listed in the continuation of Box C.

☒ See patent family annex.

* Special categories of cited documents:

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"&" document member of the same patent family

Date of the actual completion of the international search

21 March 2006

Date of mailing of the international search report

11. 04. 2006

Name and mailing address of the ISA/

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

MARZANO MONTEROSSO

INTERNATIONAL SEARCH REPORT

In ☐ national application No
PCT/IB2005/003409

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 4 036 119 A (SCHUBERT ET AL) 19 July 1977 (1977-07-19) the whole document -----	26,33
A	US 3 566 753 A (JOACHIM MANTKE) 2 March 1971 (1971-03-02) abstract; figures -----	26,33

INTERNATIONAL SEARCH REPORT

national application No.
PCT/IB2005/003409

Box II Observations where certain claims were found unsearchable (Continuation of Item 2 of first sheet)

This International Search Report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claims Nos.:
because they relate to parts of the International Application that do not comply with the prescribed requirements to such an extent that no meaningful International Search can be carried out, specifically:
3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

see additional sheet

1. ☒ As all required additional search fees were timely paid by the applicant, this International Search Report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this International Search Report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this International Search Report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.
- ☒ No protest accompanied the payment of additional search fees.

FURTHER INFORMATION CONTINUED FROM PCT/ISA/ 210

This International Searching Authority found multiple (groups of) inventions in this international application, as follows:

1. claims: 1-25

Process and apparatus for producing a compound cigarette filter, comprising the step of placing a filter tube with hollow ends and a solid filter center in a vertical position and wherein said filter further comprises a first material and a solid filter segment, said first material being withdrawn by suction in a predetermined amount from a source of material.

2. claims: 26-35

Process of producing a multiple component cigarette filter comprising the steps of placing a filter tube with hollow ends and a solid filter center in a vertical position and depositing filter materials, comprising flowable materials and solid elements, either with the help of a hollow open ended alignment tube or by delivering each solid element without significant friction between the filter tube and the solid element.

INTERNATIONAL SEARCH REPORT
information on patent family members

International application No
PCT/IB2005/003409

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