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(54) **Method for producing an end closure for a vacuum cleaner dust bag**

(57) This invention relates to a method for producing an end closure for a vacuum cleaner dust bag by manufacturing in a first stage a tube shaped work piece comprising an outer layer and one or several lined layers. The work piece is in a second stage severed mainly perpendicular to the length direction of the tube shaped work piece and the outer layer is (16a) in connection with said severing operation is provided with one or several cuts or recesses extending from the cut edge in or

der to form a flap (26). In a third stage parts of the end area of the work piece are successively folded inwardly and in connection therewith the lined layer or layers (16b) are folded inwardly or are removed within a portion of the area defined by the flap in order to uncover a part of the inwardly facing side (area 27) of the outer layer. The flap is then provided with glueing material on the uncovered surfaces and is arranged to overlap at least one of the the remaining inwardly folded end areas of the work piece.

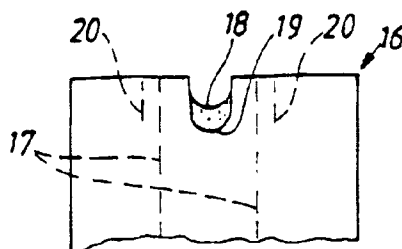


Fig. 2a

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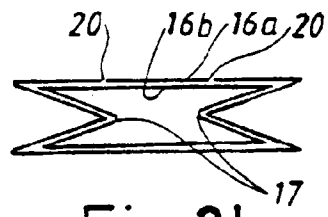


Fig. 2b

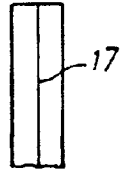


Fig. 2c



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EUROPEAN SEARCH REPORT

Application Number
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Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.6)
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The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int.Cl.6)
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Place of search		Date of completion of the search	Examiner
THE HAGUE		14 December 1998	Madsen, P
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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**ANNEX TO THE EUROPEAN SEARCH REPORT
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EP 97 85 0091

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