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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.

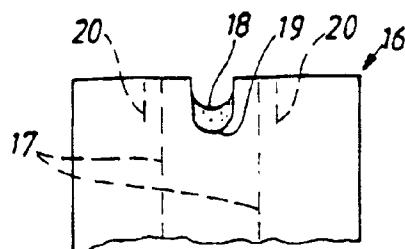


Fig. 2a

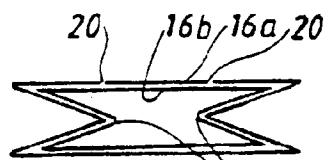


Fig. 2b¹⁷

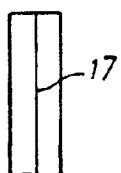


Fig. 2c



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EUROPEAN SEARCH REPORT

Application Number
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DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (Int.Cl.6)						
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim							
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A	US 3 330 100 A (FESCO) 11 July 1967 * the whole document *	1							
A	US 2 792 076 A (MEYERHOFER) 14 May 1957 * the whole document *	1							
			TECHNICAL FIELDS SEARCHED (Int.Cl.6)						
			A47L						
<p>The present search report has been drawn up for all claims</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Place of search</td> <td style="width: 33%;">Date of completion of the search</td> <td style="width: 34%;">- Examiner</td> </tr> <tr> <td>THE HAGUE</td> <td>14 December 1998</td> <td>Madsen, P</td> </tr> </table>				Place of search	Date of completion of the search	- Examiner	THE HAGUE	14 December 1998	Madsen, P
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THE HAGUE	14 December 1998	Madsen, P							
<p>CATEGORY OF CITED DOCUMENTS</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%; vertical-align: top;"> 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 </td> <td style="width: 50%; vertical-align: top;"> 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 </td> </tr> </table>				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
ON EUROPEAN PATENT APPLICATION NO.

EP 97 85 0091

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