

[19]	INTELLECTUAL PROPERTY PHILIPPINES		
[12]	INVENTION PUBLICATION		
[11]	Publication Number:	12014501428	Document Code: B1
[22]	Publication Date:	22/9/2014	
[21]	Application Number:	12014501428	Document Code: A
[22]	Date Filed:	20/6/2014	
[54]	Title:	MOUTHPIECE LINING PAPER, FORMED AS A FILM/FOIL, OF A FILTER CIGARETTE	
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[30]	Priority Data:	23/12/2011 AT20110001886	
[51]	International Class 8:	A24C 5/56 20060101AFI20180514BHPH;	
[57]	Abstract:	The invention relates to a mouthpiece lining paper of a filter cigarette, which mouthpiece lining paper is provided on surface regions to be adhesively bonded with a three-dimensional surface structure, that is to say with a surface which has elevations (2, 12.1, 22) and/or depressions (23), wherein said elevations (2, 12.1, 22) and depressions (23) protrude from and are set back from the film/foil surface only locally, respectively. The mouthpiece lining paper is a film/foil (1). In one preferred embodiment, a row of elevations (2, 12.1, 22) and/or depressions (23) runs along an edge of the mouthpiece lining paper of the type which runs along the overlap region of the mouthpiece lining paper with itself on the finished cigarette.	

Mouthpiece lining paper, formed as a film/foil, of a
filter cigarette

The invention relates to a mouthpiece lining paper
5 formed as a film/foil, of a filter cigarette.

In this document, "foil" means a thin sheet of plastic,
which per se is not constructed from fibers in the same
way as paper or textiles, but is essentially a
10 monolith. The word "film" could also be used instead of
"foil".

Five essential parts of a conventional filter cigarette
are the tobacco strand, the cigarette paper wrapping
15 this, the filter, the filter wrapping paper directly
wrapping this, and the mouthpiece lining paper.

The mouthpiece lining paper, often also designated as
"tipping paper" or, in brief, "tipping", is that part
20 of the filter cigarette which is touched by the lips of
the person smoking the cigarette when the filter
cigarette is being smoked. It wraps the filter part and
usually also projects slightly in the longitudinal
direction of the filter cigarette into the longitudinal
25 region of the tobacco strand and encases the cigarette
paper there. It is connected to the filter wrapping
paper and to the cigarette paper by means of an
adhesive bond. The filter part and tobacco strand part
are connected mechanically in the cigarette machine by
30 this adhesive bond being made. The mouthpiece lining
paper is mostly, in actual fact, a paper, but it may
also be a foil. If the mouthpiece lining paper is
formed as a foil, it may be composed, for example, of
cellulose hydrate. In the present document, the
35 designation "mouthpiece lining paper" is used, even if
this is not formed by an actual paper, but by a foil.

In the cigarette machine, the mouthpiece lining paper
is connected to the filter wrapping material and to the

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cigarette paper by adhesive bonding. The mutually overlapping ends of the filter wrapping paper wound around the cigarette are likewise connected to one another by adhesive bonding. The adhesive used is, as
5 a rule, a glue which, after being applied to the body to be adhesively bonded, increases in viscosity and in adhesiveness, above all, as a result of the transfer of water to this.

- 10 In a conventional cigarette machine, the mouthpiece lining paper is unrolled from a reel (roll), is drawn in the junctured state around what is known as a prebreaker (a sharp edge of a ceramic body), is provided on the individual surface regions with a glue
15 layer, is cut into individual pieces and is connected by adhesive bonding to a filter part of double length and to two tobacco strand parts resting against the latter on the end face on both sides and also, in an overlap region, to itself, in that it is wound around
20 these parts to an extent such that it overlaps itself over a short distance. Finally, the body thus formed is divided into two cigarettes in that it is cut through in the longitudinal center of the filter part of double length. US 4361156 A describes, for example, the
25 processing path of the mouthpiece lining paper in the cigarette machine from unwinding from the reel, through prebreaking to the application of glue and up to combination with the further parts of the cigarette.
- 30 An important limiting factor for the quantity of cigarettes which can be produced per unit time by a cigarette machine is the time duration which must elapse from the application of glue to the mouthpiece lining paper until the adhesive strength brought about
35 by the glue between the individual layers is so good that these layers no longer have to be held against one another mechanically from outside and layers do not

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come loose when the cigarettes are maneuvered any further.

5 If the layers to be adhesively bonded by glue tend to the rapid sorption of water onto their surface (adsorption) or into their volume (absorption), water is extracted very quickly from the applied glue during the glue coating process and the adhesive bond attains the required adhesive strength very quickly.

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This sorption of water from the glue takes place very quickly when genuine papers are used as the mouthpiece lining paper and as the filter wrapping material. However, foils made, for example, from cellulose hydrate are also likely to be used for these layers. 15 Foils, if only because of their low or absent porosity, generally do not have the ability to bind water quickly by sorption. Moreover, at the microscopic level, foils have a substantially smaller surface than papers, and also the surface of foils is hardly structured, in 20 contrast to that of paper. Foils made from cellulose hydrate admittedly absorb water, but not very quickly. If a foil of this type comes into contact with a large amount of water, moreover, it experiences disturbing 25 deformation.

When glue is used, therefore, foils cannot be adhesively bonded as quickly as papers. For this reason, hitherto, when foils have been used as 30 mouthpiece lining paper, the pertaining production rates of cigarette machines are well below those when genuine paper is used as mouthpiece lining paper. The attainable production rate is especially low if not only the mouthpiece lining paper is a foil, but also 35 the filter wrapping paper and/or the cigarette paper.

It was already proposed in 1929 in GB 294492 A to form the mouthpiece lining paper from a composite of two

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layers adhesively bonded to one another, to be precise of an outer foil and of an inner paper. The foil has the tactile and visual properties desired; the desired rapid bondability is achieved by means of the paper.

5 The disadvantage, above all, is that the composite material is relatively thick-walled and stiff and is consequently difficult to process. It is also relatively costly.

10 It was already proposed in 1930 in the documents GB 334271 A and GB 337501 A to form a mouthpiece lining paper from a foil composed of two interconnected layers of cellulose ester or cellulose ether, the outer layer being highly water-tight and containing visually
15 relevant additives, such as color pigments or metal powders, and the inner layer having additives which improve the adhesive bonding property to a paper by means of aqueous adhesives, particularly in that they impair the water-tightness. For this purpose, for
20 example, lithopone (white pigment of barium sulfate) or magnesium oxide is added to the inner layer. This set-up was ultimately unsuccessful, either because the adhesive bonding properties were not improved sufficiently for truly high-speed production in the
25 cigarette machine or because the mouthpiece lining paper was very stiff and was therefore difficult to process. Serious problems sometimes also arose because the mouthpiece lining paper formed in this way, when the sides to be adhesively bonded came into contact
30 with aqueous glue, was overly deformed in an undesirable way, to be precise was bent in the opposite direction to the desired direction.

It is proposed in GB 1 422 286 to form a mouthpiece
35 lining paper from a plastic foil and a lacquer coating applied to this, for example with the appearance of cork. In order to improve the adhesion of the lacquer coating on the foil, it is proposed to roughen, before

coating, the side of the foil which is to be coated. The problems in the cigarette machine regarding adhesive bonding by glue are not essentially changed by the lacquer coating.

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GB 2 199 726 A describes a mouthpiece lining paper which, for decoration reasons, has a "nonplanar marginal zone" only on that marginal region which, on the finished cigarette, runs around the cigarette on the tobacco strand side. For individual embodiments, it is additionally proposed to provide the mouthpiece lining paper with local embossing on said marginal region. So that forming can be assisted by means of a thermal process, it is suggested to use a mouthpiece lining paper which has a thermoplastic material fraction.

For legal reasons, above all, it is not seriously considered to use, for the adhesive bonding of mouthpiece lining papers formed by a foil, adhesives other than the glues which are customary for the adhesive bonding of paper and which harden as a result of the transfer of water.

The object on which the present invention is based is, therefore, to provide a mouthpiece lining paper which is formed from a foil and which is more flexible than the above-described multilayer mouthpiece lining papers having a foil layer and which at the same time can be connected more quickly by glue, which increases its viscosity and adhesive strength at the transfer of water, than previous mouthpiece lining papers constructed as a single-layer foil.

To achieve the object, it is proposed to provide the mouthpiece lining paper, at least on the surface regions to be adhesively bonded, with a three-dimensional surface structure, that is to say with a

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surface which has elevations and/or depressions, these elevations and depressions respectively rising out of the surface and being set back from this only locally (and not as a continuous coating or large-area removal). A positive effect upon adhesive bonding becomes noticeable when the projection or setback with respect to the original foil surface amounts to at least 0.5 μm , and if at least 2 height jumps occur per centimeter in any direction parallel to the surface.

10 Markedly better results are achieved when the projection or setback with respect to the original foil surface amounts to at least 1.5 μm and when at least 10 height jumps occur per centimeter in any direction
15 parallel to the surface.

Ideally, the foil surface has at least 5 height jumps per millimeter in any direction parallel to the surface. (This is equivalent to a maximum spacing
20 between the height jumps of 200 micrometers.)

By the surface being configured from elevations, depressions and intermediate height jumps, the surface is enlarged, and also the mechanical anchoring to one
25 another of the components to be connected during adhesive bonding is improved. Since the elevations and depressions are formed only locally, the flexibility and therefore the processability of the mouthpiece lining paper in the cigarette machine remain relatively
30 undisturbed by these. Since, when the layers to be connected are pressed onto one another, there remain between the elevations and in the depressions cavities, into which excess glue can flow and at which no pressure force takes effect, the pressure (that is to
35 say, the force per unit area) is increased at the actual contact points, with the result that the remaining glue layer becomes thinner and can therefore

transfer more quickly sufficient water to achieve sufficiently high adhesive strength.

5 The effect is improved, in general, the larger the height jumps are and the more height jumps are accommodated per unit area or length of foil. Very good effectiveness is achieved with height jumps from about 5 μm .

10 It is especially useful to provide a row of elevations and depressions according to the invention and of intermediate height jumps along at least one of those two margins of the mouthpiece lining paper which, on the finished cigarette, run parallel to the
15 longitudinal direction of the cigarette and delimit those surfaces where the mouthpiece lining paper overlaps itself on the finished cigarette, so that mouthpiece lining paper is glued to the mouthpiece lining paper there. Since local elevations and
20 depressions are present along at least one of these two margins, the problem, often occurring in cigarette production with foil mouthpiece lining paper and designated as "open seam", that the adhesive bonding of the mouthpiece lining paper to itself comes loose in
25 the overlap region is effectively overcome.

It is not absolutely necessary that said row of said elevations and depressions and intermediate height jumps extends over the entire length of the overlap
30 region (= the dimension of the mouthpiece lining paper in the cigarette longitudinal direction). However, such a row should extend at least from the two longitudinal ends of the overlap region in each case over a quarter of the total length of the overlap region.

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The various possibilities for producing the elevations and depressions according to the invention are discussed further below.

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The invention is explained in more detail by means of drawings:

5 Fig. 1 shows a stylized perspective illustration of a portion of a first mouthpiece lining paper according to the invention.

10 Fig. 2 shows a larger piece of the mouthpiece lining paper of fig. 1 on a scale reduced in comparison with fig. 1.

15 Fig. 3 shows a stylized lateral sectional view of a second mouthpiece lining paper according to the invention.

20 Fig. 4 shows, in an illustration like that in fig. 1, a portion of a third mouthpiece lining paper. That cutting plane at which an individual mouthpiece lining paper is separated from a continuous roll of a large number of mouthpiece lining papers is shown by the line 3 depicted by dots.

25 The mouthpiece lining paper according to fig. 1 and fig. 2 is composed of a foil 1 and of a pattern of local elevations 2 which may be formed by structural lacquer. The side of the foil 1 on which the elevations 2 are located is that which constitutes the inside of
30 the mouthpiece lining paper on the finished cigarette.

35 A structural lacquer in the context of this description is a lacquer known per se, by means of which a fine grid of a perceptibly raised structure can be printed on a surface, for example, for this purpose, 5 to 30 lines per cm which lie next to one another and which rise by 5 μm to 30 μm from non-printed surface regions can be printed. However, finer structures, for example

with 100 lines per cm which lie next to one another, can also be printed thereby.

Since the elevations 2 of the mouthpiece lining paper according to fig. 1 and fig. 2 have no continuous "hill ridges", but instead the individual elevations are spaced apart from one another in an island-like manner, the mouthpiece lining paper is scarcely changed, with respect to bending deformation about some axes, in comparison with mouthpiece lining paper which has no elevations 2. As demonstrated, above all, in fig. 2, it is not necessary for the entire surface of the foil to be provided with a pattern of elevations 2. It is sufficient to provide the elevations 2 along those lines which are especially important for the adhesive bonding of the mouthpiece lining paper. In particular, this is important on that surface region of the mouthpiece lining paper which is arranged around the contact region between the filter part and tobacco strand part, and on that surface region on which the mouthpiece lining paper overlaps itself after being wound around a double cigarette. No elevations 2 need to be provided on other surface regions, and there is also no need for gluing or for gluing everywhere there. This may afford visual and tactile benefits.

In an especially preferred embodiment, the structural lacquer used is what is known as a soft-touch lacquer. This is a lacquer known per se, which, in the cured state, has a rubber-like consistency, that is to say has, where lacquer is concerned, an unusually low modulus of elasticity, an unusually high elasticity range and somewhat unusually high friction, so that the surfaces provided with it have a rubber-like or velvety feel. At the tops of the elevations formed by this lacquer, glue is squeezed away especially effectively, so that the glue layer becomes very thin there, with the result that local drying-out and therefore also the

growth of adhesive strength take place especially quickly. A further advantage is that it is possible to manage with smaller adhesive areas, since, due to the high coefficient of friction of the soft-touch lacquer, mouthpiece lining paper and filter wrapping paper virtually adhere to one another even on non-adhesively bonded surface regions, but in any event do not slip one on the other.

10 The formation of elevations from structural lacquer also has an advantageous effect upon the adhesive bonding of the mouthpiece lining paper to the filter wrapping paper or to the cigarette paper even when the elevations 2 lie only on the outside of the mouthpiece lining paper, that is to say on the side facing away from the filter wrapping paper or the cigarette paper. To be precise, because of the local elevations, when the mouthpiece lining paper is joined to the other layers the pressure force between the mouthpiece lining paper and the further layers is highly uneven over the contact surface. As a result, glue is squeezed away at the locations of higher pressure, and therefore the glue layer remaining there becomes very thin and consequently dries out more quickly and thus increases adhesion. In an embodiment which is especially advantageous as regards adhesive bonding, local elevations 2 are applied on both sides of the foil 1, but are offset to one another in the plane of the foil to an extent such that their bases located on the foil do not overlap one another, but instead are slightly spaced apart. When the mouthpiece lining paper is joined to the layers lying beneath it, the mouthpiece lining paper is deformed into a kind of undulating landscape, with the result that the adhesive surface is increased and a network of spaces, into which the excess glue can be squeezed, is provided.

Fig. 3 shows a mouthpiece lining paper according to the invention which is composed of a foil 1 and of a print which is formed by a lacquer layer 12 and by what are known as structural pigments adhering to this. The
5 structural pigments are grains which by virtue of their size project markedly from the lacquer layer 12 and thus form the local elevations 12.1 according to the invention. The structural pigments may typically have a diameter of about 5 to about 25 μm , while the lacquer
10 layer has a thickness of only 1 μm .

The structural pigments may already be contained in the lacquer or they may be applied in a separate operation to the lacquer layer which, if necessary, is still
15 moist. For example, they may be sprinkled as a dry powder of solid particles or they may be applied as dispersions of solid particles in a liquid matrix, in which case the liquid matrix, after being applied, can cure or evaporate.

20 It is especially advantageous to use as material for the structural pigments one which has a high inner surface and can absorb water well, that is to say can also be wetted well by water. Materials highly suitable
25 for this purpose are precipitated silicic acids (silica gel), zeolites (alumino-silicates), bentonites (natural clay minerals with a high inner surface), magnesium oxide (magnesia), lithopone (white pigment of barium sulfate).

30 In an especially advantageous version, the lacquer layer 12 or the structural lacquer from which the elevations 2 according to fig. 1 are formed may additionally also contain said materials with a high
35 inner surface as pigments which do not necessarily have to project.

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The lacquer layer 12 according to fig. 3 may, of course, also be formed from structural lacquer.

5 Instead of the elevations 2 being formed by the application of a foreign substance, they may also be formed by the shaping of the material of the foil itself, typically by embossing with punching-out or embossing rollers having corresponding patterns. What is advantageous in embossing is that there is no need
10 for a separate material to be applied. However, it may sometimes be a disadvantage that embossing not only deforms the inside of the mouthpiece lining paper, but also the outside, so that a structure is visible and perceptible there.

15 Instead of elevations, depressions may, of course, also be formed by the shaping of the foil material, in particular by embossing. Embossing of the mouthpiece lining paper is a highly advantageous method
20 particularly for the adhesive preparation of the overlap region of a mouthpiece lining paper, since the outside and inside of the mouthpiece lining paper are connected to one another at the overlap region. By embossing, the mouthpiece lining paper can be shaped in
25 this region such that a pattern of elevations on the inside of the mouthpiece lining paper is fixed together with a complementary pattern of depressions on the outside of the mouthpiece lining paper, in such a way that, in joining together, elevations project from the
30 inside of one surface margin of the mouthpiece lining paper into depressions on the outside of the other surface margin of the mouthpiece lining paper, thus resulting in the two margins being held approximately in a form fit against slipping one on the other.

35 Depressions may, of course, also be formed effectively on the mouthpiece lining paper by the removal of the

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foil material and/or of the material of a coating applied, where appropriate, to the foil.

5 This removal may take place, for example, by means of a laser, the advantage of this being that especially fine and clearly defined patterns of depressions can be formed, and that the cut surfaces formed can be at a very steep angle to the plane of the foil, and that laser treatment acts upon the cut surfaces in a similar
10 way to a chemical activator which improves the adhesive strength.

However, depressions may also be formed by mechanical roughening, for example by brushing, abrading or
15 drawing the foil over a fine comb having sharp teeth or by sand blasting.

In an especially advantageous version, a lacquer layer which has pigments with a high inner surface and with
20 good wettability by water is first applied to the foil, and the cured lacquer layer is then scored or roughened, for example, by means of the abovementioned methods or is partially removed by laser, so that it acquires an especially large furrowed surface in which
25 many of said particles lie completely freely with part of their surface.

Fig. 4 sketches an exemplary mouthpiece lining paper in which elevations 22 are formed by a combination of
30 punching-out and embossing, so as to raise out of the plane of the mouthpiece lining paper short, approximately rectangular material tongues which are still in direct material connection to the remaining mouthpiece lining paper only with one of their four
35 marginal lines. The depressions 23 according to fig. 4 are formed by the punching-out of material. In the example according to fig. 4, those surface regions of a mouthpiece lining paper which are folded one over the

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other in the cigarette machine and adhesively
adhesively bonded to one another are provided with
depressions 23 formed as punched-out portions or with
elevations 22 formed by partial punching-out and
5 embossing. Since the elevations rise out of the inside
of the mouthpiece lining paper and since the
depressions 23 are arranged with the same grid
dimensioning as the elevations 22, and since the
dimensions of the base of the elevations 22 are
10 somewhat smaller than the dimensions of the base of the
depressions 23, the elevations 22 can engage into the
depressions 23 when the mouthpiece lining paper is
being wound in the cigarette machine. Good mechanical
anchoring of the two overlapping marginal regions of
15 the mouthpiece lining paper against their slipping out
of place one on the other is consequently achieved. It
is advantageous not to arrange on the same side, in all
the material tongues which form the elevations 22,
those marginal sides on which the material tongue are
20 connected to the remaining foil 1, but instead to
arrange individual material tongues so as to be rotated
in relation to other material tongues about axes normal
to the plane of the foil 1. This improves securing
against the slipping of the two overlapping regions out
25 of place in all directions in the plane of connection.
Since the boundary surfaces, lying at an inclination to
the plane of the foil 1, of the elevations 22 and
depressions 23 are also adhesive surfaces, adhesive
bonding is, of course, also improved per se.

30
As a result of said measures, mouthpiece lining papers
which are formed from foil can be adhesively adhesively
bonded substantially more quickly by means of the same
glues which can be used for conventional mouthpiece
35 lining papers composed of paper.

The invention claimed is:



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1. A mouthpiece lining paper of a filter cigarette, which
mouthpiece lining paper is a foil and is provided on surface
5 regions to be adhesively bonded, on a side coming into
contact with adhesive, with a three-dimensional surface
structure, that is to say with a surface which has
elevations and/or depressions and intermediate height jumps,
these elevations and depressions respectively rising out of
10 the surface of the foil and being set back from the surface
of the foil only locally, wherein the elevations and/or
depressions are arranged solely at one or both margins of
the mouthpiece lining paper which, on the finished
cigarette, run along an overlap region of the mouthpiece
15 lining paper with itself.

2. The mouthpiece lining paper as claimed in claim 1,
wherein an elevation or setback with respect to the original
foil surface amounts to at least 0.5 μm , and in that at
20 least 2 height jumps occur per 1 cm of length along a
direction parallel to the foil surface.

3. The mouthpiece lining paper as claimed in claim 1,
wherein an elevation or setback with respect to the original
25 foil surface amounts to at least 1.5 μm , and in that at
least 10 height jumps occur per 1 cm of length along a
direction parallel to the foil surface.

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4. The mouthpiece lining paper as claimed in claim 3, wherein the height jumps are at least 5 μ m.

5 5. The mouthpiece lining paper as claimed in claim 1, wherein individual elevations and depressions are spaced apart respectively from other elevations and depressions in an island-like manner.

10 6. The mouthpiece lining paper as claimed in claim 1, wherein the elevations are formed from structural lacquer.

7. The mouthpiece lining paper as claimed in claim 6, wherein the structural lacquer is a soft-touch lacquer.

15

8. The mouthpiece lining paper as claimed in claim 6, wherein local elevations made from structural lacquer are applied on both sides of the foil, elevations located on different sides of the foil being offset to one another in a plane of the foil to an extent such that their bases located on the foil do not overlap one another, but instead are spaced apart from one another.

20

9. A mouthpiece lining paper of a filter cigarette, which mouthpiece lining paper is a foil and is provided on surface regions to be adhesively bonded, on a side coming into contact with adhesive, with a three-dimensional surface structure, that is to say with a surface which has elevations and/or depressions, these elevations and

25

depressions respectively rising out of the surface of the foil and being set back from the surface of the foil only locally, wherein elevations are formed by structural pigments which are grains which, because of their size, rise out of a lacquer layer or structural lacquer layer applied to the surface of the foil.

10. The mouthpiece lining paper as claimed in claim 9, wherein the structural pigments are formed from a material having good water absorbency.

11. The mouthpiece lining paper as claimed in claim 9, wherein the pigments are formed from precipitated silicic acids, zeolites, bentonites, magnesium oxide or lithopone.

12. The mouthpiece lining paper as claimed in claim 6, wherein the elevations are located solely on that side of the mouthpiece lining paper which is to be arranged so as to face away from a filter wrapping paper when applied to a filter cigarette.

13. The mouthpiece lining paper as claimed in claim 1, further comprising two marginal surface regions which overlap one another on a finished cigarette, one marginal surface region is provided with a pattern of elevations and the other marginal surface region with a pattern of depressions, the elevations of the one marginal surface region being pluggable into the depressions of the other marginal surface region.

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14. A mouthpiece lining paper of a filter cigarette, which mouthpiece lining paper is a foil and is provided on surface regions to be adhesively bonded, on a side coming into
5 contact with adhesive, with a three-dimensional surface structure, that is to say with a surface which has elevations and/or depressions, these elevations and depressions respectively rising out of the surface of the foil and being set back from the surface of the foil only
10 locally, wherein the foil is composed of cellulose hydrate.

15. The mouthpiece lining paper as claimed in claim 14, wherein elevations and depressions were formed by shaping of the foil.

15

16. The mouthpiece lining paper as claimed in claim 15, wherein the elevations and depressions were formed by embossing.

20 17. The mouthpiece lining paper as claimed in claim 15, wherein elevations are formed by partially punching-out of surface regions and by these surface regions being folded open.

25 18. The mouthpiece lining paper as claimed in claim 14, wherein depressions were formed by punching-out of the foil material.

19. The mouthpiece lining paper as claimed in claim 14,

wherein depressions were formed by the removal of the foil material and/or of the material of a coating applied to the foil.

5 20. The mouthpiece lining paper as claimed in claim 19, wherein removal took place by laser.

21. The mouthpiece lining paper as claimed in claim 20, wherein removal took place by mechanical roughening.

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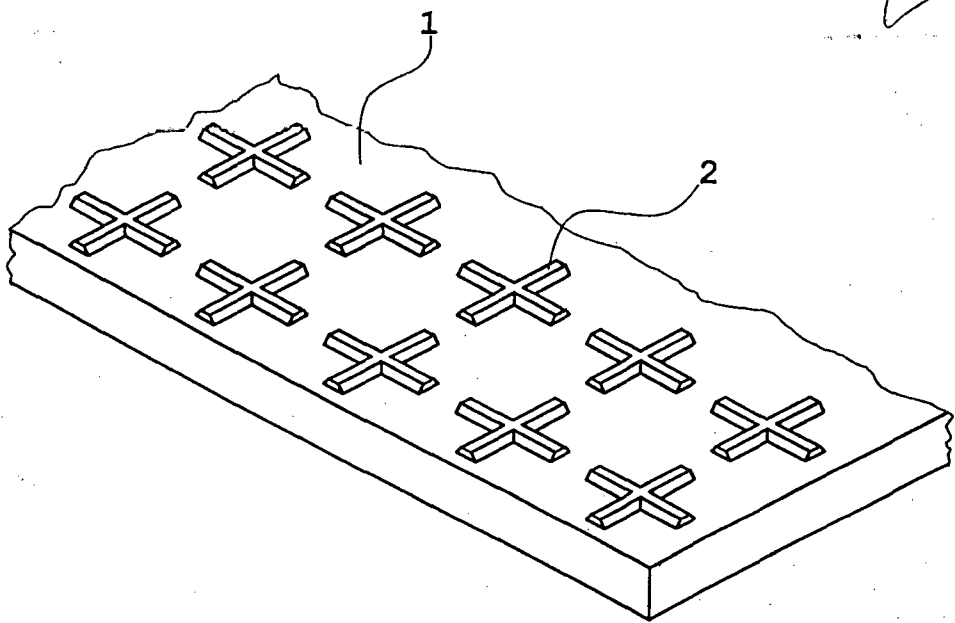
22. The mouthpiece lining paper as claimed in claim 21, wherein depressions were formed by a method wherein a lacquer layer which has pigments with good water absorbency is first applied to the foil and cured, and cured lacquer
15 layer is scored or roughened or is partially removed by laser.

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Fig. 1

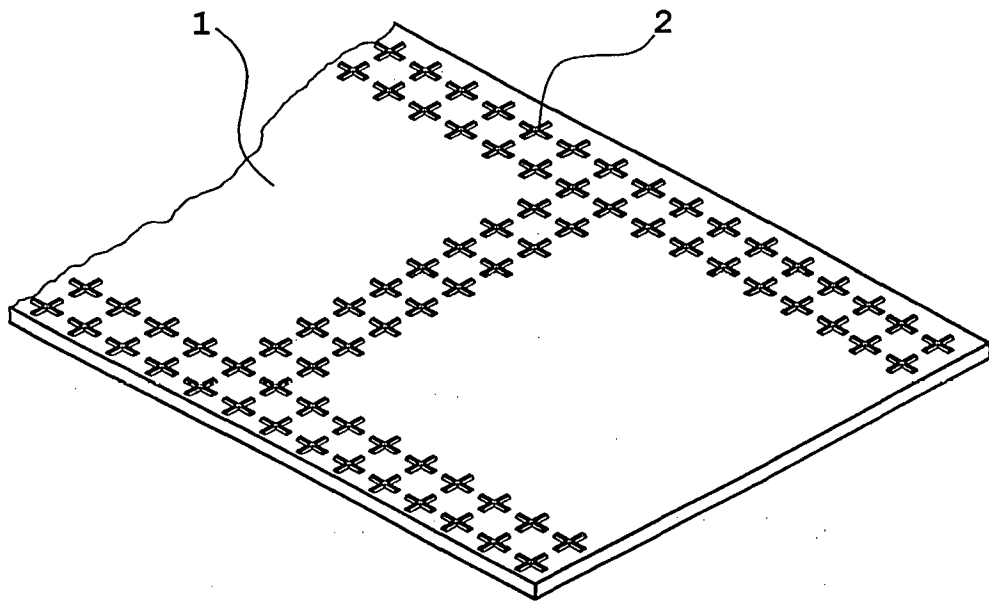


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By: *[Signature]*
ASTERIA I. MERCADO

Fig. 2



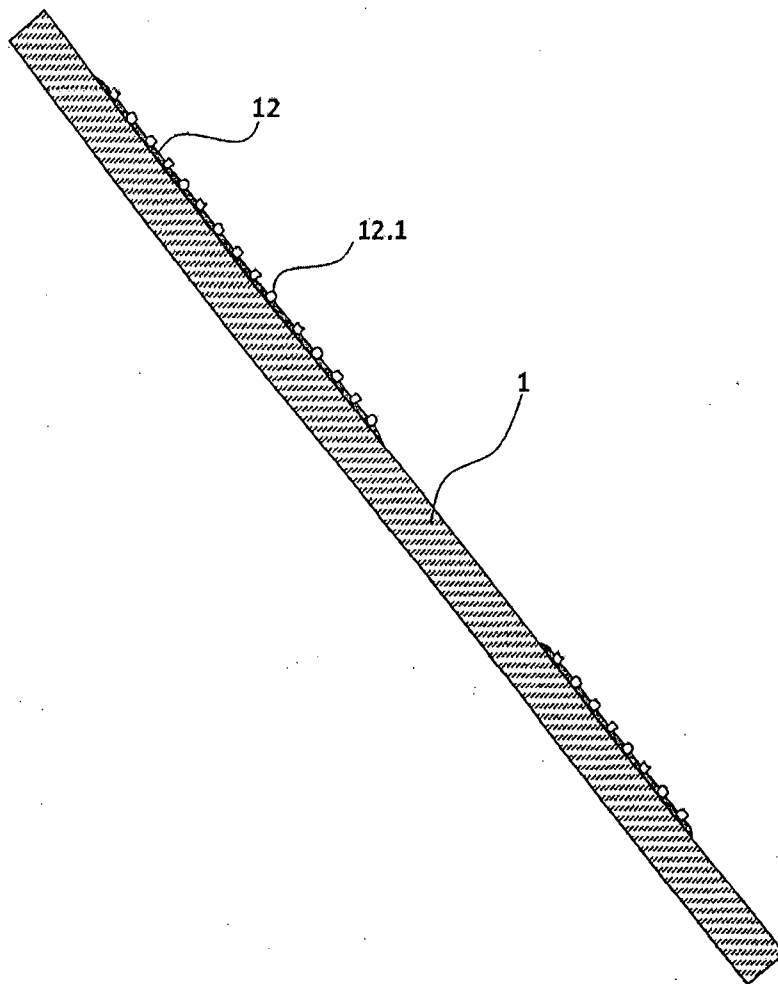
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Asteria I. Mercado
ASTERIA I. MERCADO

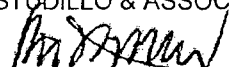
Fig. 3



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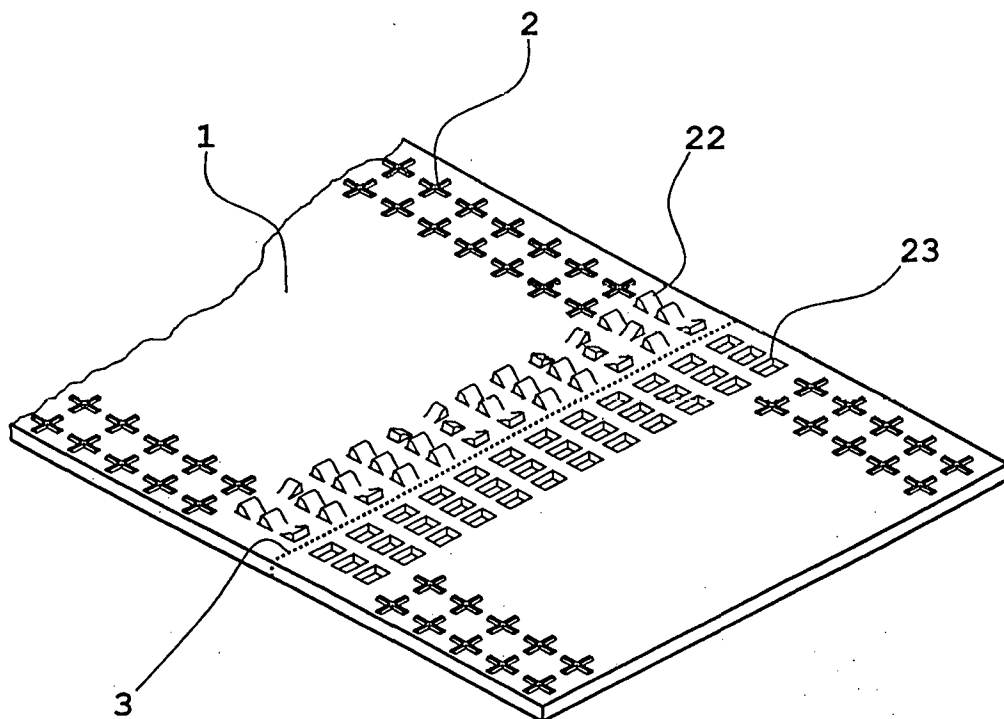
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Fig. 4



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