

PATENT COOPERATION TREATY

PCT

INTERNATIONAL PRELIMINARY REPORT ON PATENTABILITY

(Chapter II of the Patent Cooperation Treaty)

(PCT Article 36 and Rule 70)

Applicant's or agent's file reference PG20268PC00	FOR FURTHER ACTION See Form PCT/PEA/416	
International application No. PCT/SE2014/050719	International filing date (day/month/year) 13.06.2014	Priority date (day/month/year)
International Patent Classification (IPC) or national classification and IPC INV. A61F13/551		
Applicant SCA Hygiene Products AB		
1. This report is the international preliminary examination report, established by this International Preliminary Examining Authority under Article 35 and transmitted to the applicant according to Article 36. 2. This REPORT consists of a total of <u>6</u> sheets, including this cover sheet. 3. This report is also accompanied by ANNEXES, comprising: a. ☒ (sent to the applicant and to the International Bureau) a total of <u>6</u> sheets, as follows: ☒ sheets of the description, claims and/or drawings which have been amended and/or sheets containing rectifications authorized by this Authority, unless those sheets were superseded or cancelled, and any accompanying letters (see Rules 46.5, 66.8, 70.16, 91.2, and Section 607 of the Administrative Instructions). ☐ sheets containing rectifications, where the decision was made by this Authority not to take them into account because they were not authorized by or notified to this Authority at the time when this Authority began to draw up this report, and any accompanying letters (Rules 66.4bis, 70.2(e), 70.16 and 91.2). ☐ superseded sheets and any accompanying letters, where this Authority either considers that the superseding sheets contain an amendment that goes beyond the disclosure in the international application as filed, or the superseding sheets were not accompanied by a letter indicating the basis for the amendments in the application as filed, as indicated in item 4 of Box No. I and the Supplemental Box (see Rule 70.16(b)). b. ☐ (sent to the International Bureau only) a total of (indicate type and number of electronic carrier(s)) , containing a sequence listing, in the form of an Annex C/ST.25 text file, as indicated in the Supplemental Box Relating to Sequence Listing (see paragraph 3ter of Annex C of the Administrative Instructions).		
4. This report contains indications relating to the following items: ☒ Box No. I Basis of the report ☐ Box No. II Priority ☐ Box No. III Non-establishment of opinion with regard to novelty, inventive step and industrial applicability ☐ Box No. IV Lack of unity of invention ☒ Box No. V Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement ☐ Box No. VI Certain documents cited ☐ Box No. VII Certain defects in the international application ☐ Box No. VIII Certain observations on the international application		
Date of submission of the demand 10.09.2015	Date of completion of this report 14.06.2016	
Name and mailing address of the international preliminary examining authority:  European Patent Office D-80298 Munich Tel. +49 89 2399 - 0 Fax: +49 89 2399 - 4465	Authorized officer O'Sullivan, Paul Telephone No. +49 89 2399-3076 	

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Box No. I Basis of the report

1. With regard to the **language**, this report is based on
- ☒ the international application in the language in which it was filed
 - ☐ a translation of the international application into , which is the language of a translation furnished for the purposes of:
 - ☐ international search (under Rules 12.3(a) and 23.1(b))
 - ☐ publication of the international application (under Rule 12.4(a))
 - ☐ international preliminary examination (under Rules 55.2(a) and/or 55.3(a) and (b))
2. With regard to the **elements*** of the international application, this report is based on (*replacement sheets which have been furnished to the receiving Office in response to an invitation under Article 14 are referred to in this report as "originally filed" and are not annexed to this report*):

Description, Pages

1-13 as published

Claims, Numbers

1-15 filed with the demand for preliminary international examination

Drawings, Sheets

1/3-3/3 as published

☐ a sequence listing - see Supplemental Box Relating to Sequence Listing.

3. ☐ The amendments have resulted in the cancellation of:
- ☐ the description, pages
 - ☐ the claims, Nos.
 - ☐ the drawings, sheets/figs
 - ☐ the sequence listing (*specify*):
4. ☐ This report has been established as if (some of) the amendments annexed to this report and listed below had not been made, since either they are considered to go beyond the disclosure as filed, or they were not accompanied by a letter indicating the basis for the amendments in the application as filed, as indicated in the Supplemental Box (Rules 70.2(c) and (c-bis)):
- ☐ the description, pages
 - ☐ the claims, Nos.
 - ☐ the drawings, sheets/figs
 - ☐ the sequence listing (*specify*):
5. ☐ This report has been established:
- ☐ taking into account the **rectification of an obvious mistake** authorized by or notified to this Authority under Rule 91 (Rules 66.1(d-bis) and 70.2(e)).
 - ☐ without taking into account the **rectification of an obvious mistake** authorized by or notified to this Authority under Rule 91(Rules 66.4bis and 70.2(e)).

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6. ☒ With regard to top-up searches (Rules 66.1 *ter* and 70.2(f)):
- ☒ A top-up search was carried out by this Authority on 25.05.2016 (all discovered documents are listed in the Supplemental Box Relating to Top-up Search).
 - ☐ Additional relevant documents have been discovered during the top-up search.
 - ☐ No top-up search was carried out by this Authority because it would serve no useful purpose.
7. ☐ Supplementary international search report(s) from Authority(ies) has/have been received and taken into account in establishing this report (Rule 45bis.8(b) and (c)).

* If item 4 applies, some or all of those sheets may be marked "superseded".

Box No. V Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement

1. Statement

Novelty (N)	Yes: Claims	<u>1-15</u>
	No: Claims	
Inventive step (IS)	Yes: Claims	<u>1-15</u>
	No: Claims	
Industrial applicability (IA)	Yes: Claims	<u>1-15</u>
	No: Claims	

2. Citations and explanations (Rule 70.7):

see separate sheet

Re Item V

Reasoned statement with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement

Reference is made to the following documents:

- | | |
|----|--|
| D1 | WO 2013/162430 A1 (SCA HYGIENE PROD AB ET AL) 31 October 2013 (2013-10-31) |
| D2 | EP 2 737 886 A1 (UNICHARM CORP) 4 June 2014 (2014-06-04) |
| D3 | US 3 913 580 A (GINOCCHIO JAMES A) 21 October 1975 (1975-10-21) |
| D4 | US 2003/163109 A1 (OHBA KIYOE ET AL) 28 August 2003 (2003-08-28) |

Novelty & Inventive step

The amended claims filed with the demand appear to be novel and involve an inventive step. In this context, the examiner agrees with the assessment as laid out in the letter of the applicant dated 27.03.2015.

D1 discloses a method for manufacturing a packaging unit for hygiene articles having improved sealing properties, wherein the method comprises the steps of:

- providing a sheet having an inner surface and an outer surface, the inner surface comprising an edge zone comprising an inner edge portion and an outer edge portion, the sheet having at least one folding axis, the folding axis dividing the sheet into a first region and a second region;
- providing one of the inner edge portion and the outer edge portion of the edge zone of the first region with adhesive, such that the other of the inner edge portion and the outer edge portion of the edge zone of the first region is adhesive-free;
- providing one of the inner edge portion and the outer edge portion of the edge zone of the second region with adhesive, such that the other of the inner edge portion and the outer edge portion of the edge zone of the second region is adhesive-free in a complementary manner to the edge zone of the first region;

- folding the sheet about the folding axis, such that the edge portions carrying adhesive in the first region are brought in contact with the adhesive-free edge portions in the second region, and the edge portions carrying adhesive in the second region are brought in contact with the adhesive-free edge portions at the first region.

The method of D1 and that of present claim 1 **differ** in that the latter manufacturing method

1. further includes the step of providing at least one of the first central portion of the first region and the second central portion of the second region with a second adhesive, providing a release liner having a wrap-facing surface and a user-facing surface; bringing the wrap-facing surface of the release liner in contact with the inner surface of the wrapping sheet such that at least a portion of the wrap-facing surface of the release liner becomes permanently attached to the inner surface of the wrapping sheet in at least the first and the second central portions being provided with the second adhesive by means of the second adhesive; and

2. that the steps of applying the first resealable adhesive and the second adhesive are performed simultaneously.

The technical effect of this difference is that the manufacturing process is facilitated, and that a release liner may be applied to the inner surface of the wrapping sheet, facilitating the removal of the single wrap and the release liner in one step (description page 1, lines 7-19 and page 4, lines 16-20).

The objective technical problem solved by the present invention is thus the provision of an improved manufacturing process whereby a release liner may be attached to the inner surface of the wrapping sheet, without being affected by the presence of the adhesive edge portions.

Neither of the cited documents D2-D4 relate to wrapping sheets. Instead, D2 and D4 describe application of the adhesive to the garment-facing surface of the backsheet of an absorbent article, wherein the adhesive is arranged for securing the absorbent article to the underwear of the user, while D3 describes application of the construction adhesive to the inner surface of the backsheet. D3 mentions that two different adhesive regions are formed, and that the adhesive regions may comprise two different adhesives, and may be formed during a single step (col. 5, 1.1-3).

The person skilled in the art, starting from D1 as closest prior art and desiring to solve the above-mentioned objective technical problem, would not look to D2-D4 for the solution since these documents do not even deal with wrapping materials.

Furthermore, although some of the other documents cited in the Search Report do

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deal with wrapping articles, none of them disclose the combination of a release liner with the simultaneous application of the adhesives which distinguish the claimed subject-matter over D1.

It follows that the subject-matter of claim 1 and consequently of the claims dependent thereon involves an inventive step.

European Patent Office
D-80298 München
Germany



Göteborg: March 27, 2015
Our ref: PG20268PC00

TO THE INTERNATIONAL PRELIMINARY EXAMINING AUTHORITY

Re: International PCT Application No. PCT/SE2014/050719
Applicant: SCA Hygiene Products AB

Dear Sirs,

These submissions are in response to the Written opinion issued February 16, 2015. The Applicant kindly requests that the following argumentation and the amended claims are taken into consideration when issuing the IPRP.

The Examiner finds that claims 1-16 are novel, but lack inventive step in view of WO 2013/162430 (D1), EP 2,737,886 (D2), US 3,913,580 (D3) and US 2003/0163109 (D4).

Please find enclosed an amended set of claims, wherein amendments have been made in order to overcome the Examiner's objections. In particular, claim 1 has been limited by including the features of claim 2.

D1 discloses a method for manufacturing a packaging unit for hygiene articles having improved sealing properties, wherein the method comprises the steps of:

- providing a sheet having an inner surface and an outer surface, the inner surface comprising an edge zone comprising an inner edge portion and an outer edge portion, the sheet having at least one folding axis, the folding axis dividing the sheet into a first region and a second region;
- providing one of the inner edge portion and the outer edge portion of the edge zone of the first region with adhesive, such that the other of the inner edge portion and the outer edge portion of the edge zone of the first region is adhesive-free;
- providing one of the inner edge portion and the outer edge portion of the edge zone of the second region with adhesive, such that the other of the inner edge portion and the outer edge portion of the edge zone of the second region is adhesive-free in a complementary manner to the edge zone of the first region;
- folding the sheet about the folding axis, such that the edge portions carrying adhesive in the first region are brought in contact with the adhesive-free edge portions in the second region, and the edge portions

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carrying adhesive in the second region are brought in contact with the adhesive-free edge portions at the first region.

The difference between the method of D1 and the method according to the present invention is that the manufacturing method further includes the step of providing at least one of the first central portion of the first region and the second central portion of the second region with a second adhesive, providing a release liner having a wrap-facing surface and a user-facing surface; bringing the wrap-facing surface of the release liner in contact with the inner surface of the wrapping sheet such that at least a portion of the wrap-facing surface of the release liner becomes permanently attached to the inner surface of the wrapping sheet in at least the first and the second central portions being provided with the second adhesive by means of the second adhesive; and that the steps of applying the first resealable adhesive and the second adhesive are performed simultaneously.

The technical effect of this difference is that the manufacturing process is facilitated, and that a release liner may be applied to the inner surface of the wrapping sheet.

The objective technical problem solved by the present invention is thus how to modify the manufacturing process of D1 such that the manufacturing process is improved, and such that a release liner may be attached to the inner surface of the wrapping sheet, without being affected by the presence of the adhesive edge portions.

Neither of the cited documents D2-D4 relate to wrapping sheets. Instead, D2 and D4 describe application of the adhesive to the garment-facing surface of the backsheet of an absorbent article, wherein the adhesive is arranged for securing the absorbent article to the underwear of the user, while D3 describes application of the construction adhesive to the inner surface of the backsheet. D3 mentions that two different adhesive regions are formed, and that the adhesive regions may comprise two different adhesives, and may be formed during a single step (col. 5, l. 1-3).

The person skilled in the art, starting from D1 and searching for a way to solve the above-mentioned objective technical problem, would not even find D2-D4, since these documents do not related to packaging units. Further, should the person skilled in the art be aware of D2-D4, he would most likely not combine the teachings of D1 with the teachings of D2-D4, since these documents relate to completely different components of the absorbent article.

The Applicant believes that it has been shown that the invention as defined by the amended claims 1-15 enclosed hereto is inventive in view of the cited prior art. It is therefore respectfully requested that a positive IPRP is issued acknowledging novelty and inventive step of the amended claims. However, should further issues remain, a new Written opinion is respectfully requested before issuance of the IPRP.

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Yours faithfully,

Valea AB (Association No. 258)

Natalie Ljungdahl

Encl. Amended claims (mark-up and clear)

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AMENDED CLAIMS (CLEAR)

1. A method for forming a wrapping material for hygiene articles from a continuous web of wrapping sheets (1, 100, 200), each wrapping sheet (1, 100, 200) having an inner surface (2, 102, 202) and an outer surface (3, 103, 203), said inner surface (2, 102, 202) comprising an edge zone (4, 104, 204) comprising an inner edge portion (5, 105, 205, 8, 108, 208) and an outer edge portion (6, 106, 206, 7, 107, 207), said wrapping sheet (1, 100, 200) having at least one first folding axis (9, 109, 209), said first folding axis (9, 109, 209) dividing said wrapping sheet (1, 100, 200) into a first region (10, 110, 210) and a second region (11, 111, 211), wherein said first region (10, 110, 210) comprises a first central portion, and said second region (11, 111, 211) comprises a second central portion; said method comprising the steps of:
 - a. providing one of said inner edge portion (5, 105, 205) and said outer edge portion (6, 106, 206) of said edge zone of said first region (10, 110, 210) with a first resealable adhesive (12), such that the other of said inner edge portion (5, 105, 205) and said outer edge portion (6, 106, 206) of said edge zone of said first region (10, 110, 210) is adhesive-free;
 - b. providing one of said inner edge portion (8, 108, 208) and said outer edge portion (7, 107, 207) of said edge zone of said second region (11, 111, 211) with a first resealable adhesive (12), such that the other of said inner edge portion (8, 108, 208) and said outer edge portion (7, 107, 207) of said edge zone of said second region (11, 111, 211) is adhesive-free in a complementary manner to said edge zone of said first region (10);
 - c. providing at least one of said first central portion of said first region (10, 110, 210) and said second central portion of said second region (11, 111, 211) with a second adhesive (13);
 - d. providing a release liner (15, 115, 215) having a wrap-facing surface (16, 116, 216) and a user-facing surface (17, 117, 217);
 - e. bringing said wrap-facing surface (16, 116, 216) of said release liner (15, 115, 215) in contact with said inner surface (2, 102, 202) of said wrapping sheet (1, 100, 200) such that at least a portion of said wrap-facing surface (16, 116, 216) of said release liner (15, 115, 215) becomes permanently attached to said inner surface (2, 102, 202) of said wrapping sheet (1, 100, 200) in at least said first and said second central portions being provided with said second adhesive (13) by means of said second adhesive (13);

AMENDED SHEET

characterized in that said steps a-c are performed simultaneously.

2. The method according to claim 1, wherein said method further comprises the step of:
 - f. releasably affixing a hygiene article (18, 118, 218) to said user-facing
5 surface (17, 117, 217) of said release liner (15, 115, 215).
3. The method according to any one of the preceding claims, wherein step f occurs before step e.
4. The method according to any one of the preceding claims, wherein said method further comprises the step of:
 - 10 g. providing said user-facing surface (17, 117, 217) of said release liner with a third resealable adhesive;
wherein step g occurs before step f.
5. The method according to any one of the preceding claims, wherein said method further comprises the step of:
 - 15 h. folding said wrapping sheet (1, 100, 200) about said first folding axis (9, 109, 209) such that said edge portions carrying said first resealable adhesive in said first region (10, 110, 210) are brought in contact with said adhesive-free edge portions in said second region (11, 111, 211), and said edge portions carrying said first resealable adhesive in said second region
20 (11, 111, 211) are brought in contact with said adhesive-free edge portions at said first region (10, 110, 210).
6. The method according to any one of the preceding claims, wherein said wrapping sheet (100, 200) has a first and a second folding axis (109, 109', 209, 209') dividing said sheet into said first region (110, 210), said second region (111, 211)
25 and a third region (112, 212), said method further comprising the steps of:
 - i. providing a portion (105', 205', 106', 206') of said edge zone of said third region (112, 212) with said first resealable adhesive (12);
 - j. folding said wrapping sheet about said second folding axis (109', 209') such that said inner surface of said third region (112, 212) is brought in
30 contact with said outer surface of said first region (110, 210),
wherein step i is performed simultaneously with steps a-c, and wherein step j is performed after step h.

7. The method according to any one of the preceding claims, wherein said sheet of material is of substantially rectangular shape and comprises longitudinal edges, a first and a second transverse edge and corner portions, said edge zones of said first and second regions of said sheet of material being arranged along said longitudinal edges, and transverse edge zones being arranged along said first and second transverse edges.
8. The method according to claim 7, said method further comprising the step of:
- k. providing at least one of said first and said second transverse edge zones (204') of said wrapping sheet (200) with said first resealable adhesive (12).
9. The method according to claim 8, wherein step k is performed simultaneously with said steps a-c.
10. The method according to any one of claims 7-9, wherein at least one of said corner portions is free from adhesive such that a gripping tab is formed.
11. The method according to any one of the preceding claims, wherein said first resealable adhesive (12) and said third resealable adhesive are pressure-sensitive hot melt adhesives, and said second adhesive (13) is a construction adhesive.
12. The method according to any one of the preceding claims, wherein said release liner (15, 115, 215) is manufactured from paper, nonwoven or plastic film material.
13. The method according to any one of the preceding claims, wherein said release liner (15, 115, 215) is silicone-coated on said user-facing surface (17, 117, 217) of said release liner (15, 115, 215).
14. The method according to any one of the preceding claims, wherein said longitudinal extension of said release liner (15, 115, 215) is 60-100% of said longitudinal extension of said wrapping sheet (1, 100, 200).
15. The method according to any one of the preceding claims, wherein said sheet (1, 100, 200) and/or said release liner (15, 115, 215) is opaque and/or comprises print.

REIVINDICACIONES

1. Un método para formar un material envolvente para artículos de higiene de una red continua de hojas envolventes, cada hoja envolvente teniendo una superficie interior y una superficie exterior, dicha superficie interior comprendiendo una zona de borde que comprende una porción de borde interior y una porción de borde exterior, dicha hoja envolvente teniendo al menos un primer eje plegable, dicho primer eje plegable dividiendo dicha hoja envolvente en una primera región y una segunda región, en donde dicha primera región comprende una primera porción central, y dicha segunda región comprende una segunda porción central; dicho método comprendiendo las etapas de:

a. proporcionar una de dicha porción de borde interior y dicha porción de borde exterior de dicha zona de borde de dicha primera región con un primer adhesivo resellable, de manera que la otra de dicha porción de borde interior y dicha porción de borde exterior de dicha zona de borde de dicha primera región está libre de adhesivo;

b. proporcionar una de dicha porción de borde interior y dicha porción de borde exterior de dicha zona de borde de dicha segunda región con un primer adhesivo resellable, de manera que la otra de dicha porción de borde interior y dicha porción de borde exterior de dicha zona de borde de dicha segunda región está libre de adhesivo en una manera complementaria a dicha zona

de borde de dicha primera región;

c. proporcionar al menos una de dicha primera porción central de dicha primera región y dicha segunda porción central de dicha segunda región con un segundo adhesivo;

d. proporcionar un papel antiadherente teniendo una superficie orientada a la envoltura y una superficie orientada al usuario;

e. poner en contacto dicha superficie orientada a la envoltura de dicho papel antiadherente con dicha superficie interior de dicha hoja envolvente de manera que al menos una porción de dicha superficie orientada a la envoltura de dicho papel antiadherente se une permanentemente a dicha superficie interior de dicha hoja envolvente en al menos dicha primera y dicha segunda porción central proporcionándose con dicho segundo adhesivo por medio de dicho segundo adhesivo; caracterizado porque dichas etapas a-c se realizan de manera simultánea.

2. El método de conformidad con la reivindicación 1, caracterizado porque dicho método comprende además la etapa de:

f. fijar de manera liberable un artículo de higiene a dicha superficie orientada al usuario de dicho papel antiadherente.

3. El método de conformidad con cualquiera de las reivindicaciones precedentes, caracterizado porque la etapa f ocurre antes de la etapa e.

4. El método de conformidad con cualquiera de las

reivindicaciones precedentes, caracterizado porque dicho método comprende además la etapa de:

g. proporcionar dicha superficie orientada al usuario de dicho papel antiadherente con un tercer adhesivo resellable; caracterizado porque la etapa g ocurre antes de la etapa f.

5. El método de conformidad con cualquiera de las reivindicaciones precedentes, caracterizado porque dicho método comprende además la etapa de:

h. doblar dicha hoja envolvente alrededor de dicho primer eje plegable de manera que dichas porciones de borde que llevan dicho primer adhesivo resellable en dicha primera región se ponen en contacto con dichas porciones de borde libres de adhesivo en dicha segunda región, y dichas porciones de borde que llevan dicho primer adhesivo resellable en dicha segunda región se ponen en contacto con dichas porciones de borde libres de adhesivo en dicha primera región.

6. El método de conformidad con cualquiera de las reivindicaciones precedentes, caracterizado porque dicha hoja envolvente tiene un primer y un segundo eje plegable dividiendo dicha hoja en dicha primera región, dicha segunda región y una tercera región, dicho método comprendiendo además las etapas de:

i. proporcionar una porción de dicha zona de borde de dicha tercera región con dicho primer adhesivo resellable;

j. doblar dicha hoja envolvente alrededor de dicho segundo eje plegable de manera que dicha superficie interior de

dicha tercera región se pone en contacto con dicha superficie exterior de dicha primera región, caracterizado porque la etapa i se realiza de manera simultánea con las etapas a-c, y caracterizado porque la etapa j se realiza después de la etapa h.

7. El método de conformidad con cualquiera de las reivindicaciones precedentes, caracterizado porque dicha hoja de material es de forma sustancialmente rectangular y comprende bordes longitudinales, un primero y un segundo borde transversal y porciones de esquina, dichas zonas de borde de dichas regiones, primera y segunda, de dicha hoja de material disponiéndose a lo largo de dichos bordes longitudinales, y las zonas de borde transversales disponiéndose a lo largo de dicho primer y segundo borde transversal.

8. El método de conformidad con la reivindicación 7, dicho método comprendiendo además la etapa de:

k. proporcionar al menos una de dicha primera y dicha segunda zona de borde transversal de dicha hoja envolvente con dicho primer adhesivo resellable.

9. El método de conformidad con la reivindicación 8, caracterizado porque la etapa k se realiza de manera simultánea con dichas etapas a-c.

10. El método de conformidad con cualquiera de las reivindicaciones 7 a 9, caracterizado porque al menos una de dichas porciones de esquina está libre de adhesivo de manera que se forma una orejeta de sujeción.

11. El método de conformidad con cualquiera de las reivindicaciones precedentes, caracterizado porque dicho primer adhesivo resellable y dicho tercer adhesivo resellable son adhesivos fundidos en caliente sensibles a presión, y dicho segundo adhesivo es un adhesivo de construcción.

12. El método de conformidad con cualquiera de las reivindicaciones precedentes, caracterizado porque dicho papel antiadherente se elabora de papel, no tejido o material de película de plástico.

13. El método de conformidad con cualquiera de las reivindicaciones precedentes, caracterizado porque dicho papel antiadherente se reviste con silicona en dicha superficie orientada al usuario de dicho papel antiadherente.

14. El método de conformidad con cualquiera de las reivindicaciones precedentes, caracterizado porque dicha extensión longitudinal de dicho papel antiadherente es 60-100% de dicha extensión longitudinal de dicha hoja envolvente.

15. El método de conformidad con cualquiera de las reivindicaciones precedentes, caracterizado porque dicha hoja y/o dicho papel antiadherente son opacos y/o comprenden una impresión.