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(71) Applicant: **SOCIETE DES PRODUITS NESTLE S.A.**
[CH/CH]; Avenue Nestlé 55, 1800 Vevey (CH).

(72) Inventors: **PELLEGRINI, Stéphane**; 3, rue Champs Gauty, 25160 Montperreux (FR). **GALANTINE, Charles**; Chemin du Jura 16, 1470 Estavayer-le-Lac (CH). **MORRAL, ROCA, Jose**; Joaquim Mir no 12 Caldes de Montbui, 08140 Barcelona (ES).

(74) Agent: **NAVARRO FERNANDEZ, Maria, Isabel**; SOCIETE DES PRODUITS NESTLE S.A. Avenue Nestlé 55, 1800 VEVEY (CH).

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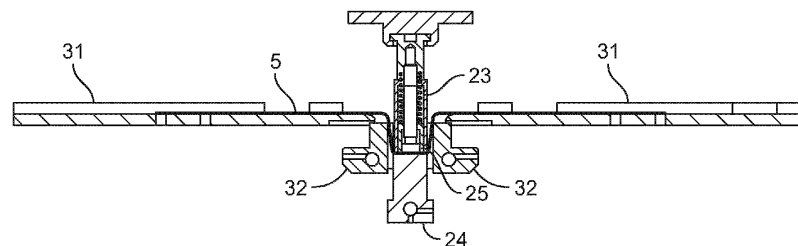


FIG. 12

(57) Abstract: The present invention is directed to a process for manufacturing a flexible package suitable for containing a food or beverage ingredient and suitable for use with a food or beverage preparation machine, wherein said process comprises punching a flexible flat blank sheet between a plunger and a cavity that are movable relative to one another. According to the invention, the plunger has a concave end side and convex lateral sides, and the profile curvature of its end side is identical to the profile curvature of each of its lateral sides.

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