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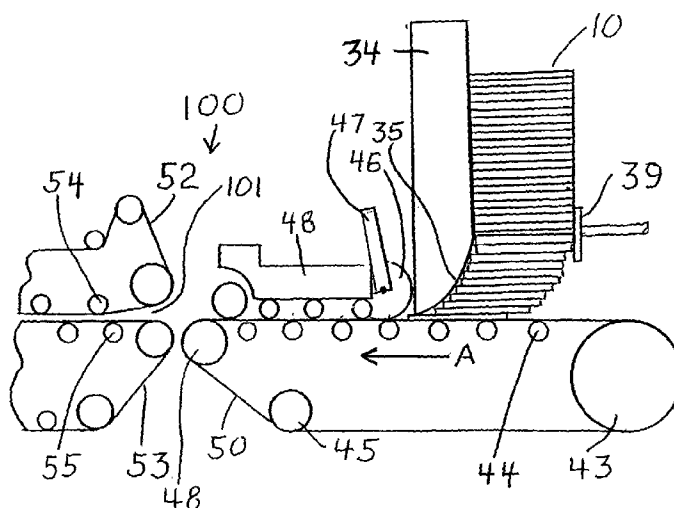
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(57) Abstract: A machine and method for producing beverage container holders of consistently high quality at high production rates and at an economical cost is disclosed herein. Beverage container holders (500) can be produced on the machine using the method disclosed herein at a rate of 50,000 beverage container holders per hour. The initial step of introducing the blanks 810) into the machine's conveying mechanism assures that the the blanks are properly aligned and have a predetermined spacing there between, which avoids jamming of the machine and the resulting work stoppage (Fig. 2). The process includes steps for pre-breaking or pre-folding the flaps (Fig. 5) which enable the final folding of the flaps to be performed with the necessary reliability and speed. All except the final step of the manufacturing process are performed while the blanks are being conveyed at a constant high rate along the length of the machine.

WO 03/018303 A1