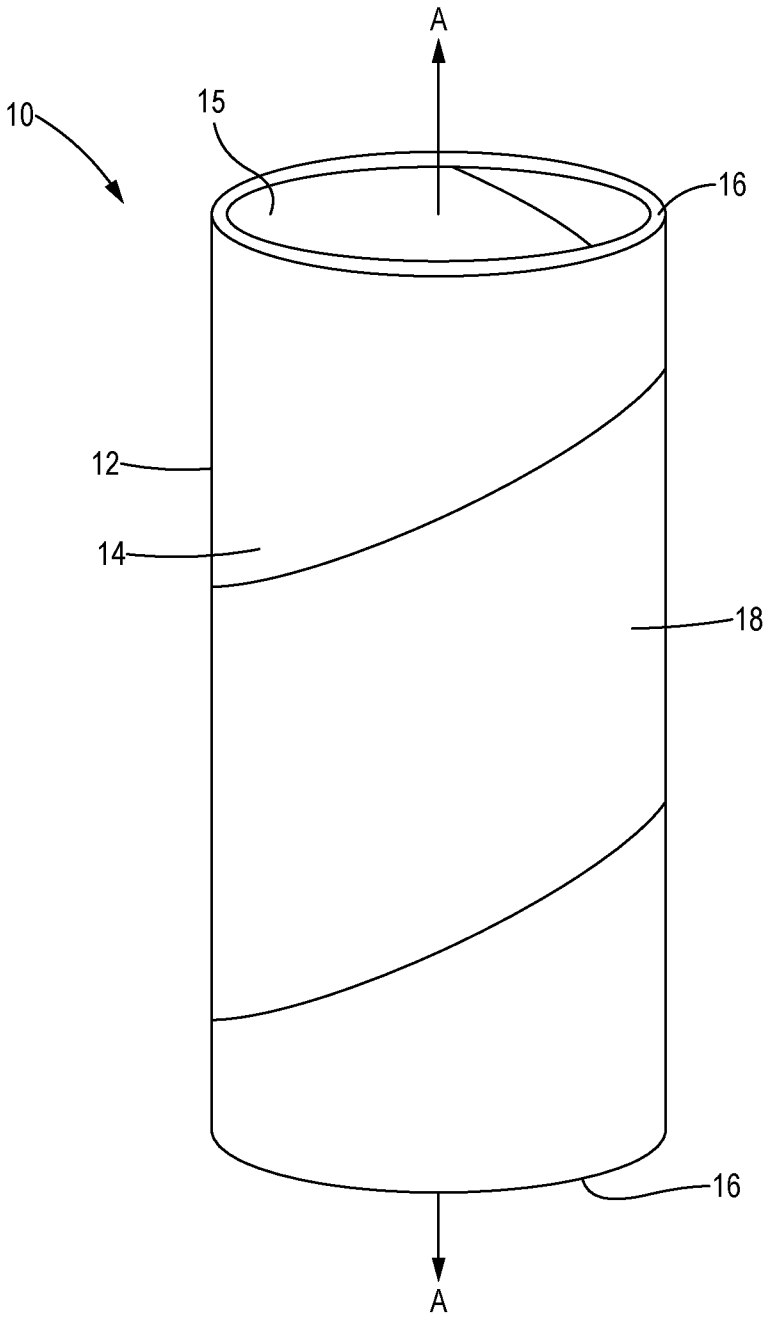



FIG. 1

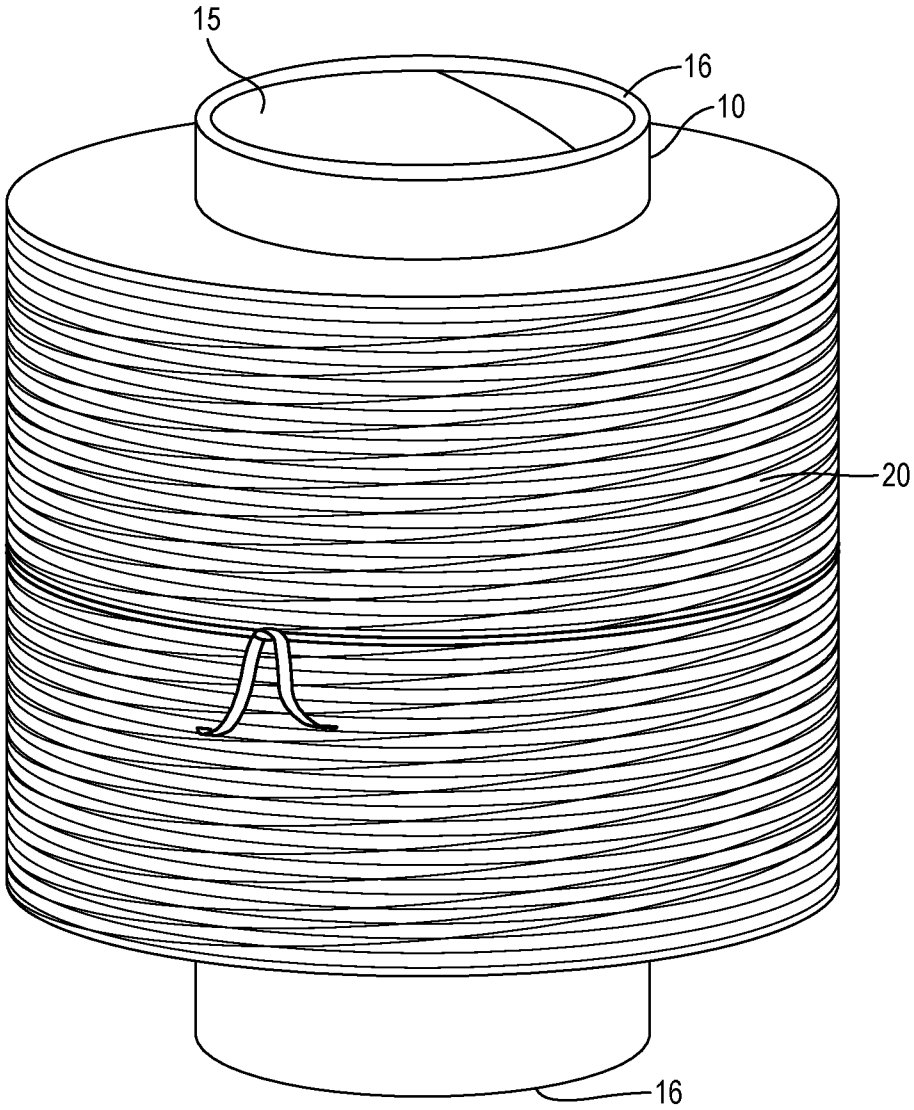



FIG. 2

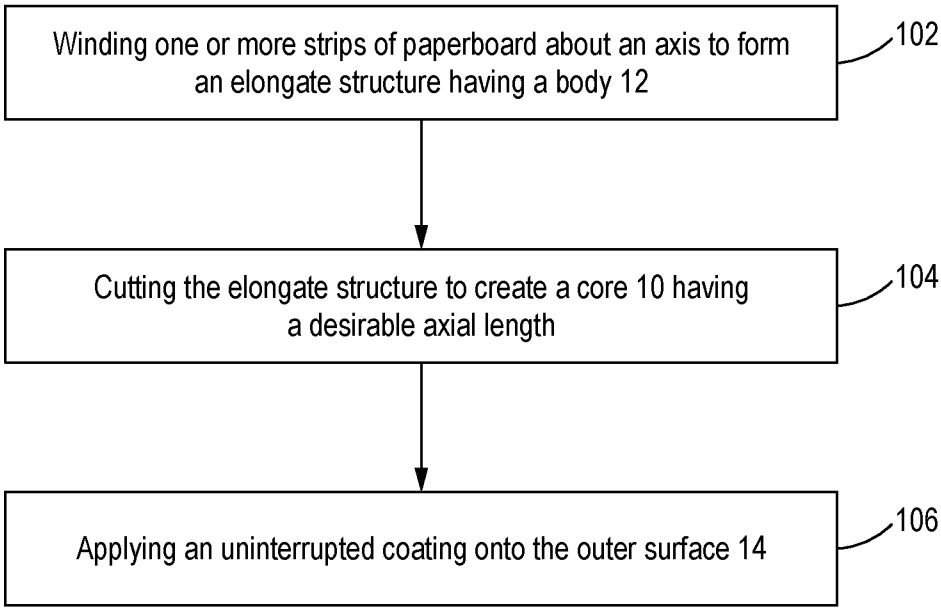

Winding one or more strips of paperboard about an axis to form an elongate structure having a body 12
102
Cutting the elongate structure to create a core 10 having a desirable axial length
104
Applying an uninterrupted coating onto the outer surface 14
106

*FIG. 3*

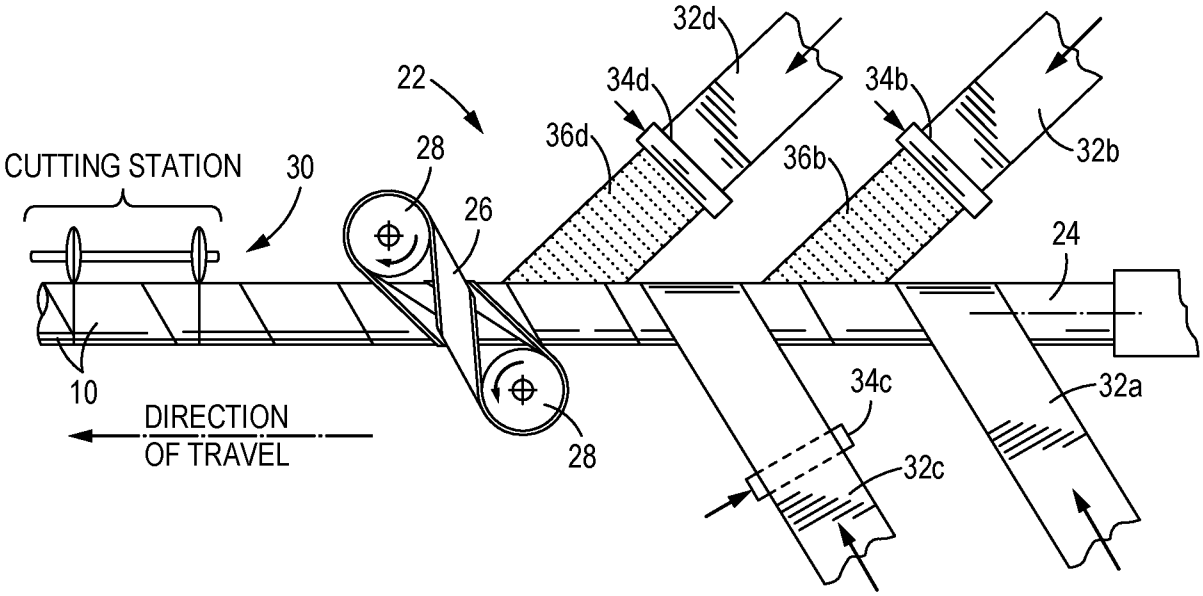

32d
22
34d
34b
36d
28
36b
32b
CUTTING STATION
30
26
24
10
34c
32a
DIRECTION
OF TRAVEL
28
32c

*FIG. 4*

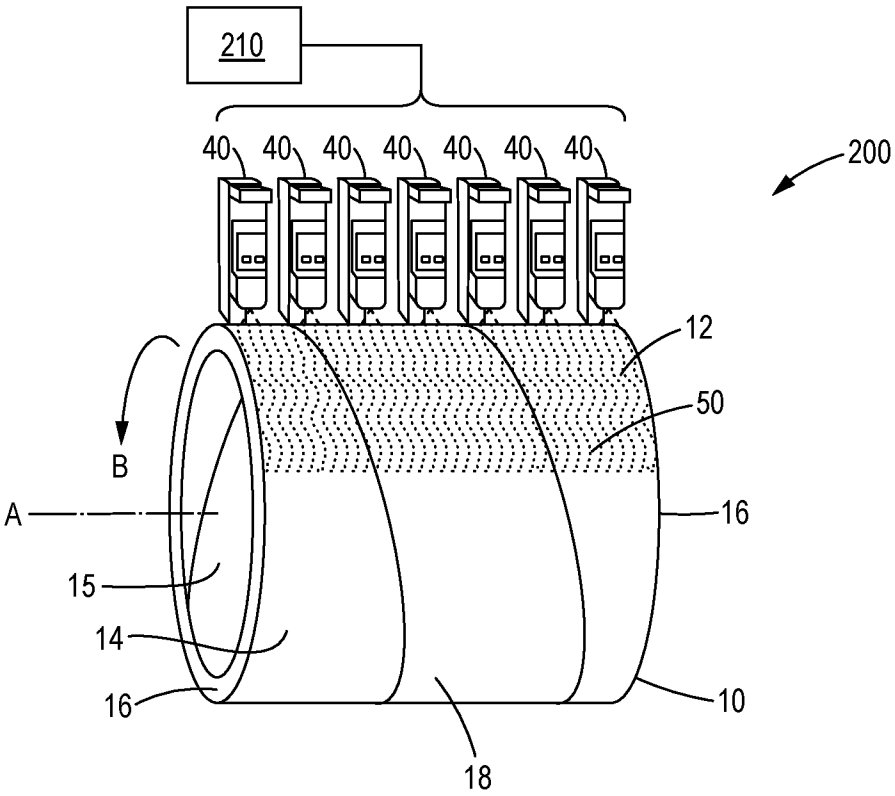



FIG. 5