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**Cram et al.**

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(54) **TAPE ROLL LINER/TAB, APPLICATION APPARATUS AND METHOD**

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(\*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

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**Related U.S. Application Data**

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(58) **Field of Search** ..... 428/98, 906, 192; 156/190, 184, 269, 265, 270, 185, 302; 242/583, 526, 580, 531, 531.1, 532, 532.3; 206/53, 411; 225/90

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(57) **ABSTRACT**

A method and apparatus of forming coreless rolls of pressure sensitive adhesive tape involves the use of a mandrel assembly having a specific circumferential tape supporting segment thereon for winding tape. The circumferential tape supporting segment has a tape engaging surface portion that, in a radial orientation, is compressible yet sufficiently stiff to support the tape as it is successively wound about the mandrel to form a tape roll, and that is sufficiently pliant to permit ready axial removal of a wound tape roll from the shaft. The innermost wrap of pressure sensitive adhesive tape about the mandrel is masked by an adhesive liner. That liner is formed from one portion of a liner/tab segment which had been applied to the tape previously, and prior to winding, the tape is severed, and the remainder of that liner/tab forms an end tab on the outermost end of the previously formed coreless tape roll.

**18 Claims, 20 Drawing Sheets**

