

Title (en)  
Method of manufacturing documents with security marks.

Title (de)  
Verfahren zum Herstellen von Dokumenten mit Sicherheitsmarken.

Title (fr)  
Procédé de fabrication de documents avec marques de sécurité.

Publication  
**EP 0498040 B1 19950614 (DE)**

Application  
**EP 91118114 A 19911024**

Priority  
CH 40091 A 19910208

Abstract (en)  
[origin: EP0498040A1] In the process for manufacturing documents with security marks (7) using an adhesive (3) that can be activated by ultraviolet light or electron irradiation, a film web (2) bearing the security marks (7) is coated with an adhesive (3), which can be activated by UV light or electron irradiation, said adhesive (3) being subsequently activated by UV light or electron irradiation, and security marks (7) are punched out of the film web (2), said security marks being bonded to the substrate (5) immediately thereafter, still in the punching and bonding unit (6). A device is also disclosed for carrying out the process, in which one supporting surface of a matrix is coated with a release agent, in order to prevent the adhesion of the film strip (2), which is coated with adhesive (3), in the punching and bonding unit (6). <IMAGE>

IPC 1-7  
**B42D 15/00**; **B65H 39/14**; **B42D 15/02**

IPC 8 full level  
**B42D 15/00** (2006.01); **B42D 25/00** (2014.01); **B42D 25/29** (2014.01); **B65H 39/14** (2006.01)

CPC (source: EP US)  
**B41F 16/0053** (2013.01 - EP); **B42D 25/29** (2014.10 - EP); **B42D 25/324** (2014.10 - EP); **B42D 25/328** (2014.10 - EP);  
**B42D 25/41** (2014.10 - EP US); **B42D 25/46** (2014.10 - EP); **B42D 25/47** (2014.10 - EP US); **B65H 39/14** (2013.01 - EP);  
**B65H 2701/1912** (2013.01 - EP)

Cited by  
CN106079947A; EP1564022A3; EP1552956A1; CN100431850C; CN108472980A; JP2018535830A; WO2005068211A1; WO2005077667A3;  
WO2017076872A3; WO2004068240A3; US10814667B2

Designated contracting state (EPC)  
AT BE CH DE DK ES FR GB IT LI LU NL SE

DOCDB simple family (publication)  
**EP 0498040 A1 19920812**; **EP 0498040 B1 19950614**; AT E123713 T1 19950615; DE 59105725 D1 19950720; DK 0498040 T3 19951030;  
ES 2075295 T3 19951001

DOCDB simple family (application)  
**EP 91118114 A 19911024**; AT 91118114 T 19911024; DE 59105725 T 19911024; DK 91118114 T 19911024; ES 91118114 T 19911024