

Title (en)  
METHOD FOR APPLYING A SEAL

Title (de)  
VERFAHREN ZUM AUFBRINGEN EINER SIEGELMARKE

Title (fr)  
PROCEDE POUR APPLIQUER UNE MARQUE

Publication  
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Application  
**EP 04764677 A 20040901**

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Abstract (en)  
[origin: WO2005037528A2] The invention relates to a method for applying a seal (13; 13') to a lightly coloured semifinished product (11') that is covered with a surface protection film (12') coloured in a partially transparent manner. According to said method, if the semifinished product has an average peak-to-valley height  $R_z$  of between 10 and 60 nm, the pressure rollers (21, 22') are provided with an embossed relief (23') consisting of an elastic material, by which means the surface protection film (12') is applied to the rough surface of the semifinished product (11'), in the region of the embossed relief (23'), with the adhesive layer thereof, and to the surface of the semifinished product (11'), only partially in the region of the protuberances, in the region outside the embossed relief (23'). For semifinished products with a low peak-to-valley height, a surface protection film with at least three layers is used, at least one of said three layers being a marking layer that has a lower stretchability than a carrier layer and is coloured in a partially transparent manner in such a way that it contrasts with the carrier layers. Before being applied to the semifinished product, the surface protection film is guided between an elastic counter-pressure roller and an embossing roller comprising at least one embossing die with raised sections corresponding to the contours of the seals, and is partially overstretched on said sections until the marking layer coloured in a partially transparent manner cracks, thus forming a long-lasting seal.

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