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(54) **Procedure for the manufacture of envelopes with a sticker inside**

(57) Procedure for the production of envelopes (12) with stickers (11) inside. In the procedure, three continuous overlaid sheets (1,2,3) are used, the middle sheet (2) having an anti-tack coating.

The outer sheets (1,3) have their faces (4,5) that are in contact with the middle sheet (2), coated with adhesive. On the outer face (6) of outer sheet (1) the printing (7) is carried out and outer printed sheet (1) and mid-

dle sheet (2) are stamped thus rectangular shapes (8) and remains (9) are formed. The remains (9) are separated from the lower outer sheet (3).

The set of stickers is covered with a continuous fourth sheet (3a) that sticks to the free parts of the lower outer sheet (3). Central cuts are made at the sticking zones to form in each case, an envelope (12) with a sticker (11) inside.

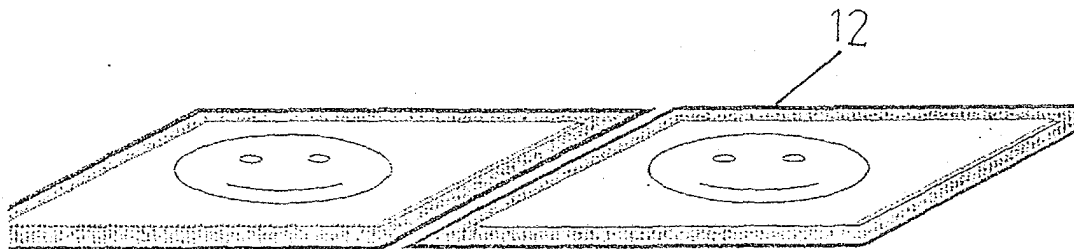


FIG 6

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DescriptionOBJECT OF THE INVENTION

[0001] The present invention has as its object a procedure for the mass production of envelopes with sticker inside.

BACKGROUND OF THE INVENTION

[0002] Currently, this type of sticker is introduced in envelopes for sale or as a gift for children. These stickers may be individual colour prints or belong to a small or large collection.

[0003] The manufacturing costs and introduction into envelopes are sometimes high and render unworkable this system of sales and/or gifts that is widely accepted by young children.

DESCRIPTION OF THE INVENTION

[0004] With the procedure of the invention, at the same time as the sticker is manufactured the envelope is obtained to form a single unit.

[0005] With this procedure, the amount of labour needed is considerably reduced and therefore the costs are also reduced. In accordance with the invention, the procedure comprises the stages of:

- Using three continuous overlaid rectangular sheets.
- The central sheet is anti-tack on both sides and is treated with silicone.
- The outer sheets have faces coated with adhesive, in contact with the middle sheet, which makes the three sheets can stick or detach from one another.
- On the outer face of at least one of the outer sheets, the printing of the sticker is carried out.
- Separate shapes are stamped continuously only on the outer printed sheets and on the middle sheet, the other outer sheet constituting backing paper.
- They are separated and the parts left over from the stamping are withdrawn which allows the sticky areas of the lower outer sheet to be exposed around each one of the stickers so constituted and shaped
- The upper part of the strip of stickers is covered with a continuous sheet and the sheets are passed through a pressure roller to stick the continuous upper sheet in each of the free zones, with the adhesive of the lower sheet.
- Central cuts are made through the sticking zones, thus shaping an envelope with a sticker inside.

BRIEF DESCRIPTION OF THE DRAWINGS

[0006]

Figure 1 shows a perspective view of the three base sheets used in the procedure of the invention.

Figure 2 represents the bound sheets printed on the upper face.

Figure 3 shows the upper and intermediate sheets stamped in regular portions

Figure 4 shows the leftover parts of the stamping of Figure 3.

Figure 5 represents the positioning of a fourth sheet stuck over Figure 4.

Figure 6 represents the constitution by cutting the envelopes with the sticker inside.

Figure 7 represents the number of envelopes that are continuously formed by the procedure of the invention.

DESCRIPTION OF THE PRACTICAL EMBODIMENT OF THE INVENTION

[0007] The procedure of the invention comprises using three overlaid sheets 1, 2 and 3, of equal width and continuous.

[0008] The middle sheet 2 is anti-tack and is coated with silicone on both sides.

[0009] Sheets 1 and 3 have their faces 4 and 5 coated with adhesive, specifically on the faces in contact with the intermediate sheet 2.

[0010] On the outer face 6 of sheet 1 and/or 3 the printing 7 is carried out and sheets 1 and 2 are stamped after performed the printing, forming rectangular shapes 8 and the remains 9 of the sheets 1 and 2 are separated to give the situation shown in figure 4.

[0011] In this figure 4, portions of adhesive 10 remain exposed that form the boundary of the sticker itself 11, on figure 4 there is a continuous sheet 3a of the same width as the other aforementioned sheets that is stuck by pressure over the adhesive of sheet 3.

[0012] After shaping the aforementioned set, the cuts necessary are made to obtain each one of the envelopes 12 with the sticker 11 inside.

[0013] Figure 7 shows how the strip of envelopes is formed from the aforementioned sheets 1, 2, 3 and 3a.

[0014] The number of envelopes in production will depend on the units allowed by the useful width of the printing machine.

Claims

1. Procedure for the manufacture of a series of envelopes with stickers inside; which is **characterised in that** it comprises the stages of:

- using three continuous overlaid rectangular sheets, the middle sheet being anti-stick on both faces, which are also coated in silicone
- the outer sheets have faces that come into contact with the middle sheet coated with adhesive
- on the outer or free face of, at least, one of the outer sheets, the sticker itself is printed

- the outer printed sheet and the middle sheet are stamped, these shapes being separated, the other outer sheet constituting the respective backing
- the leftover parts from the stamping are withdrawn from the two outer and middle sheets, which exposes the zones of adhesive of the other backing sheet 5
- the set so constituted by a continuous sheet in the lower part of the strip of stickers and the set thus defined is passed through a pressure roller to stick the upper sheet to the free adhesive parts of the lower outer sheet 10
- central cuts are made in the sticking zones, in each case forming an envelope with its sticker inside. 15

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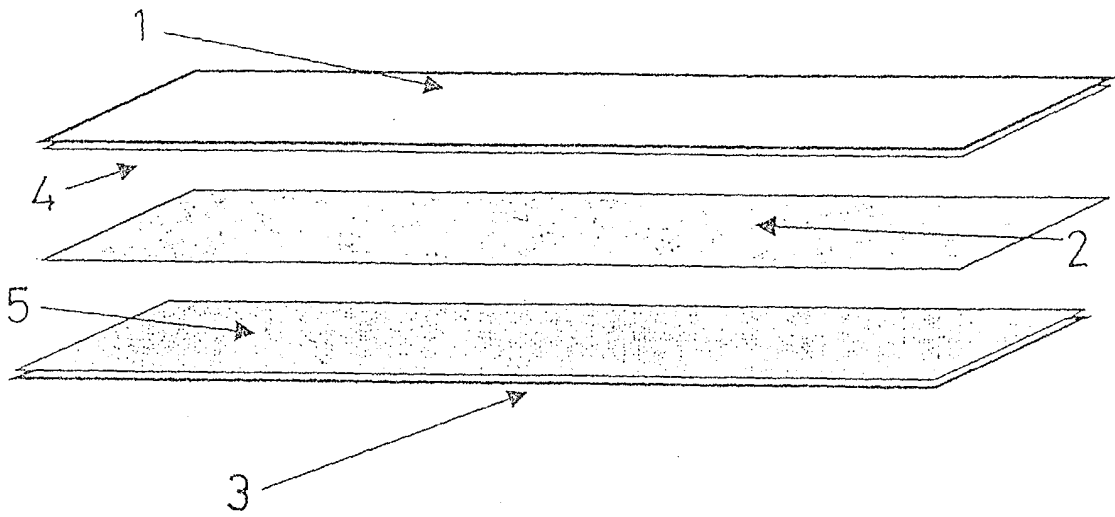


FIG1

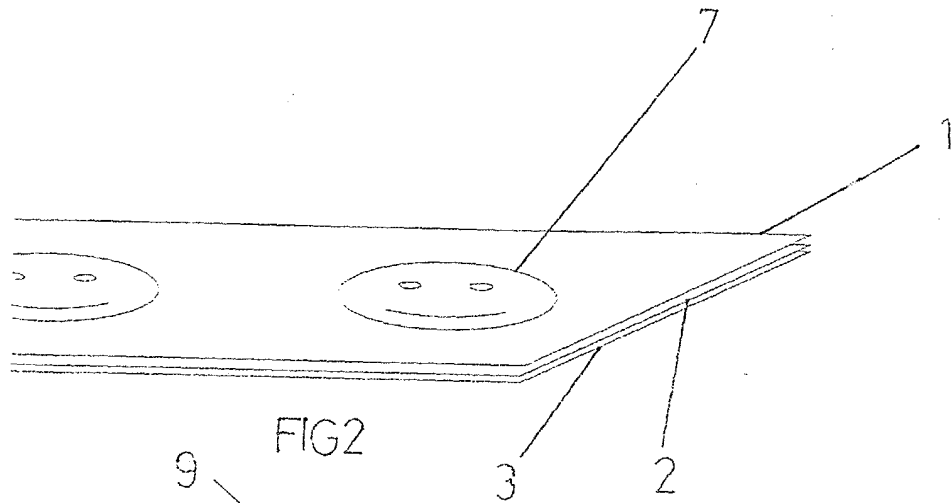


FIG2

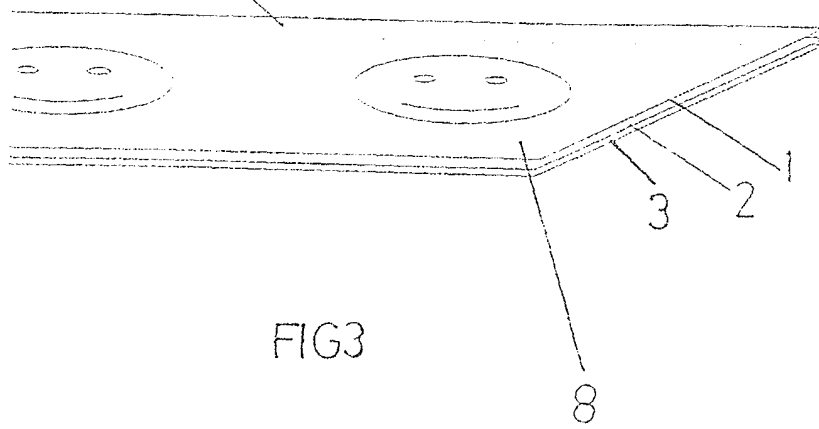


FIG3

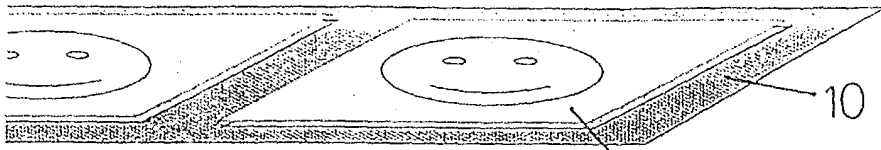


FIG 4

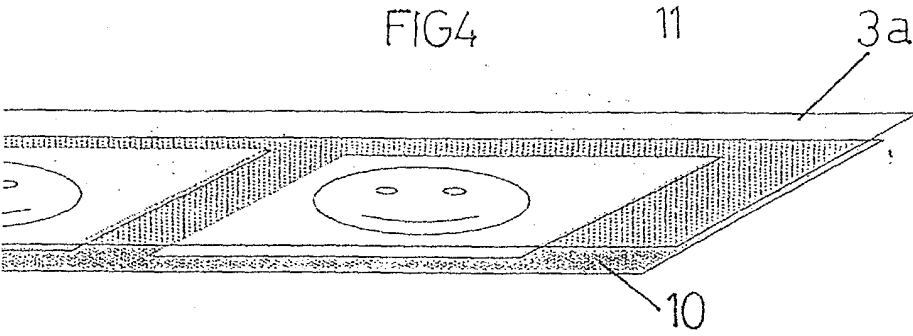


FIG 5

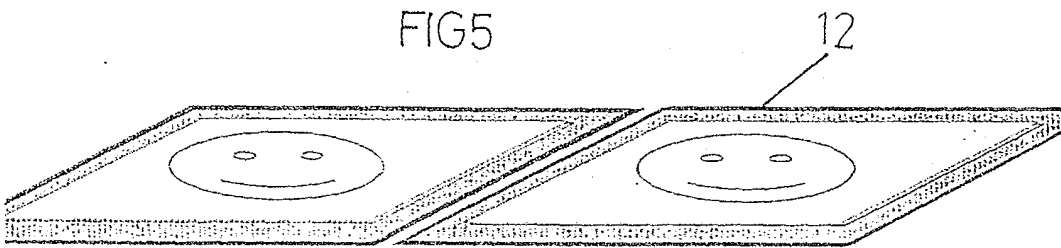


FIG 6

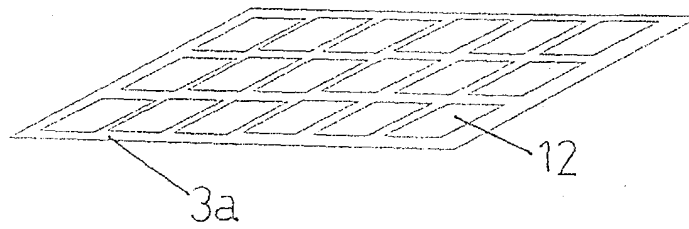


FIG 7



European Patent
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EUROPEAN SEARCH REPORT

Application Number
EP 03 38 0112

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.7)
A	DE 21 12 886 A (ADREMA PITNEY BOWES GMBH) 21 September 1972 (1972-09-21) * page 2, paragraph 3 - page 3, last line; figures 1,2 *	1	B65B11/50 B31D1/02
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			TECHNICAL FIELDS SEARCHED (Int.Cl.7)
			B65B B31D
The present search report has been drawn up for all claims			
Place of search MUNICH		Date of completion of the search 22 August 2003	Examiner Johne, 0
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	

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**ANNEX TO THE EUROPEAN SEARCH REPORT
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EP 03 38 0112

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP file on
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22-08-2003

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