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(54) Titre : STRUCTURE STRATIFIEE ADHESIVE REVETUE DE GEL DE SILICONE
(54) Title: SILICONE-GEL-COATED ADHESIVE LAYER STRUCTURE

(57) **Abrégé/Abstract:**

The present invention relates to a silicone-gel-coated, adhesive layer structure, comprising: a) a first layer consisting of a porous backing material, b) on one side of the porous backing material, an intermediate layer crosslinked by UV, which includes acrylic acid copolymer, and, c) on the intermediate layer, a layer made of a crosslinked, adhesive silicone gel. The present invention also relates to a method for the production of the silicone-gel-coated, adhesive layer structure and the use thereof.

ABSTRACT

The present invention relates to a silicone-gel-coated, adhesive layer structure, comprising: a) a first layer consisting of a porous backing material, b) on one side of the porous backing material, an intermediate layer crosslinked by UV, which includes acrylic acid copolymer, and, c) on the intermediate layer, a layer made of a crosslinked, adhesive silicone gel. The present invention also relates to a method for the production of the silicone-gel-coated, adhesive layer structure and the use thereof.

SILICONE-GEL-COATED ADHESIVE LAYER STRUCTURE

The present invention relates to a silicone-gel-coated, adhesive layer structure, a method for the production thereof as well as the use thereof.

BACKGROUND OF THE INVENTION

Silicone-coated, adhesive structures display a range of innovative properties which make them of particular interest for medical uses. Thus, a silicone-based adhesive agent (called silicone gel in the following) is gentler and more pleasant for the skin than conventional acrylate adhesives. Silicone gels can, for example, be removed easily and with minimal detachment of skin cells and hair, and at the same time provide an optimal and constant adhesive force over the entire duration of the application. Repeated use is likewise possible without difficulty. In addition, silicone gels display a very good adhesion to other components present in the structure, for example to an acrylic acid copolymer. A transfer onto the skin can thereby be reduced or even prevented entirely, whereby additional cleaning steps to remove adhesive agent residues from the patient's skin can be dispensed with. These properties make adhesive structures coated with silicone gel of great interest for use in medicine, above all for use on patients with sensitive and fragile skin.

In order to guarantee an optimal wearing comfort, the backing materials of adhesive structures used in medicine are usually manufactured from a soft and elastic material. In order to supply oxygen or moisture as well as possible to the patient's skin lying under the adhesive structure, porous backing materials are particularly advantageous, as they allow transport of oxygen and/or

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moisture to the patient's skin lying under the adhesive layer structure. However, the porosity of the backing material often leads to problems in the production of adhesive structures based on silicone gel. Before they are crosslinked, silicone gels are flowable compounds which, when coated directly onto a porous backing, permeate it and often even re-emerge on the opposite side, which is called bleeding through. This would lead to a coated structure which has a degree of stickiness on both sides, which is undesired as a rule.

Silicone-coated, adhesive structures are known, for example, from US 2006/0154053 A1, in which porous backings (stockings) are disclosed which have an adhesive layer made of a silicone or acrylate. Between the porous backing (the stocking) and the adhesive layer made of silicone or acrylate, there is additionally an intermediate layer made of a silicone elastomer.

Silicone-coated, porous backings are likewise known from US 2010/0267302 A1.

Furthermore, silicone-coated substrates which have an intermediate layer are known from US 2007/0128263 A1. The material and shape of the substrates are unknown, however.

DESCRIPTION OF THE INVENTION

The object of the present invention is to provide an adhesive layer structure which comprises a porous backing material and an adhesive layer made of a silicone gel on only one side of the porous backing material, wherein the silicone gel is to be prevented from permeating or bleeding through the porous backing material. In addition, a good bonding of the adhesive silicone gel layer to the layer structure

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is to be guaranteed, in order to reduce or ideally entirely prevent an undesired transfer. Furthermore, a method for producing such an adhesive structure is to be provided.

These objects are achieved by a silicone-gel-coated, adhesive layer structure which comprises a first layer consisting of a porous backing material, a crosslinked or uncrosslinked intermediate layer on only one side of the porous backing material and a layer made of a crosslinked, adhesive silicone gel on the intermediate layer. Moreover, these objects are achieved by a method for producing the silicone-coated, adhesive layer structure in which an intermediate layer material is applied, partially or completely covering it, to a porous backing material, the intermediate layer material is optionally crosslinked, a silicone gel is applied to the crosslinked or uncrosslinked intermediate layer material and the silicone gel is then crosslinked. The intermediate layer acts as a barrier layer for the silicone gel and prevents the silicone gel from permeating or bleeding through the porous backing material. In addition, the intermediate layer brings about a good bonding of the silicone gel to the layer structure.

The layer structure according to the invention is preferably a medical product, particularly preferably a roll plaster, in particular a roll plaster for securing medical instruments to the skin of a person or animal.

The adhesive layer structure, as well as the production and use thereof is described more precisely in the following with reference to their various embodiments.

Silicone-coated, adhesive layer structure

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According to the invention, the adhesive layer structure comprises a first layer consisting of a porous backing material, a crosslinked or uncrosslinked intermediate layer on one side of the porous backing material and a layer made of a crosslinked, adhesive silicone gel on the intermediate layer.

The porous backing material

In order to facilitate a best possible wearing comfort, according to the invention the backing material is manufactured from a soft and elastic material.

The backing material can be produced from natural material or plastic. In particular, viscose, rayon, cellulose, polyethylene, polypropylene, polyamide, polyester, polyacetate, polyurethane or a mixture thereof comes into consideration here. The backing material is preferably manufactured from polyester.

In order to guarantee a best possible transport of oxygen and moisture through the adhesive layer structure to the skin of the person or animal, the backing material according to the invention is porous.

According to an embodiment, the above-named materials are present in the form of a non-woven material, fabric, knitted fabric, foam material or a film. The above-named materials are preferably present in the form of a non-woven material.

Intermediate layer material

In order to prevent the adhesive silicone gel from permeating or bleeding through the porous backing, there is an intermediate layer between the porous backing and the silicone gel layer. The intermediate layer material is preferably present on only the side

of the porous backing material facing the silicone gel; the other side of the porous backing material is free from intermediate layer material. The intermediate layer can be present crosslinked or uncrosslinked.

According to an embodiment, the porous backing material is completely covered with the crosslinked or uncrosslinked intermediate layer.

According to a further embodiment, the porous backing material is partially covered with the crosslinked or uncrosslinked intermediate layer. By partially, within the framework of this invention, is meant any uniformly distributed coverage of the porous backing material with the intermediate layer material which is not complete.

The side of the porous backing material covered with the intermediate layer material is covered with the intermediate layer material in the range of from 30 to 100%, preferably 40 to 100%, more preferably 50 to 100%, still more preferably 60 to 100%, most preferably 70 to 100%, in particular 80 to 100%.

According to the invention, the crosslinked or uncrosslinked intermediate layer is present on the porous backing material in a quantity of from 10 to 500 g/m², preferably 10 to 400 g/m², more preferably 10 to 300 g/m², still more preferably 10 to 200 g/m², particularly preferably 10 to 100 g/m², most preferably 33 g/m².

The presence of the intermediate layer according to the invention has the result that the adhesive silicone gel can be prevented from permeating or bleeding through even when the intermediate layer material only partially covers the porous backing material, as the flowability of the silicone gel comes to a halt due to crosslinking

before the silicone gel can flow in the uncovered areas of the porous backing material to the porous backing material.

According to an embodiment, the intermediate layer material comprises an acrylic acid copolymer. According to a preferred embodiment, the intermediate layer consists of the acrylic acid copolymer. According to a more preferred embodiment, the acrylic acid copolymer is produced from monomers of the group consisting of acrylic acid, butyl acrylate, 2-ethylhexyl acrylate, 2-hydroxyethyl acrylate, dioctyl acrylate, methyl acrylate, ethyl acrylate, tert-butyl acrylate and mixtures thereof.

Silicone gel

The adhesive layer structure furthermore comprises an adhesive silicone gel applied to the crosslinked or uncrosslinked intermediate layer. The intermediate layer material and the adhesive silicone gel are preferably present on only one side of the porous backing material; the other side of the porous backing material is free from intermediate layer material and adhesive silicone gel.

Silicone gel, within the framework of this invention, means a silicone material composed of at least one silicone base material and a catalyst. Silicone base material, within the framework of this invention, means a silicone material in the uncrosslinked or slightly crosslinked state, which yields a silicone gel as a mixture with at least one catalyst. The silicone base material can be present in monomeric or polymeric form. The catalyst serves to crosslink the silicone base material.

Silicone base materials according to the invention are, for example, vinyl-functional polydimethylsiloxanes or hydrogen-functional

siloxanes, for example hydromethyl siloxanes. The catalyst is selected from usual catalysts known to a person skilled in the art which are used to crosslink silicone gels. The catalyst preferably comprises a noble metal. The catalyst particularly preferably comprises platinum, palladium or nickel, in particular platinum. In particular, the so-called Karstedt's catalyst is used. Commercially available silicone systems which comprise a silicone base material and a catalyst are preferably used, wherein the silicone base material and the catalyst are present spatially separate from each other, with the result that no undesired crosslinking begins. The components are not mixed with each other until shortly before application of the silicone gel to the intermediate layer. Silicone systems used according to the invention are, for example, the MED 6342 silicone system from NuSil Technology LLC or the Silpuran™ 2110 A/B silicone system from Wacker Chemie AG.

According to an embodiment, the adhesive silicone gel is present on the crosslinked or uncrosslinked intermediate layer in a quantity of from 10 to 500 g/m², preferably 50 to 200 g/m², most preferably 80 to 120 g/m², in particular 100 g/m².

The silicone-coated, adhesive layer structure according to the invention is preferably a medical product, such as for example a roll plaster or a tape.

The silicone-coated, adhesive layer structure according to the invention is particularly preferably used for securing to the skin of a person or animal. It can serve, for example, to secure medical instruments to the skin of the person or animal.

Method

The invention furthermore relates to a method for producing the adhesive layer structure according to the invention.

According to the invention, an intermediate layer material is first applied to a porous backing material. The intermediate layer material is preferably applied to only one side of the porous backing material, wherein the other side of the porous backing material is free from intermediate layer material.

According to an embodiment, the intermediate layer material is applied, completely covering it, to the porous backing material. According to another embodiment, the intermediate layer material is applied, partially covering it, to the porous backing material. Optionally, the intermediate layer material is crosslinked after application to the porous backing material. Then a silicone gel is applied to the crosslinked or uncrosslinked intermediate layer material. The silicone gel is preferably applied only to the intermediate layer material and not to the side of the porous backing material free from intermediate layer material, with the result that one side of the porous backing material is free from intermediate layer material and silicone gel. Finally, the silicone gel is crosslinked.

Application of the intermediate layer

According to an embodiment, the intermediate layer material is applied in an uncrosslinked or crosslinked form directly, completely or partially covering it, to the porous backing material, and then optionally (further) crosslinked.

According to a preferred embodiment, the intermediate layer material is not applied to the porous backing immediately, but to a substrate

material first, for example siliconized release liner. The intermediate layer material is then applied, completely or partially covering it, to the porous backing from this substrate material by means of transfer coating, for example laminating.

Optionally, the intermediate layer material is crosslinked after application to the porous backing material and before the silicone gel is applied to the intermediate layer.

According to an embodiment, the intermediate layer material is crosslinked thermally. According to the invention this comprises any crosslinking in which the energy needed is provided by heat (thermally). Thermal crosslinking within the framework of this invention therefore also comprises a crosslinking at ambient temperature, for example room temperature. The crosslinking duration is reciprocally dependent on the heat energy supplied (thus the temperature). The higher the crosslinking temperature, the shorter the crosslinking duration, and vice versa.

According to another embodiment, the intermediate layer material is crosslinked by UV radiation. According to the invention this comprises any crosslinking in which the energy needed is provided by UV radiation.

Hybrids of thermal and UV crosslinking likewise fall within the framework of this invention. Thus, for example, it is possible for the crosslinking to be effected at an increased temperature and for the intermediate layer additionally to be irradiated with UV radiation.

The intermediate layer material is preferably crosslinked through

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the porous backing material by means of UV radiation. The UV radiation is thus applied not directly to the intermediate layer material, but to the porous backing material. In this way, a particularly good bonding between porous backing material and the intermediate layer is guaranteed.

In the case of a transfer coating, the intermediate layer material is present preferably dissolved in a solvent, preferably water, benzine or acetone, before application to the substrate material. In this case, the intermediate layer material dissolved in the solvent is applied to the substrate material and the solvent is then removed, preferably evaporated. This can be effected, for example, in a circulating air flotation dryer at 180°C.

According to a preferred embodiment, the intermediate layer material present on the substrate material is crosslinked before being applied, completely or partially covering it, to the porous backing material by means of transfer coating. The crosslinking is effected thermally or by means of UV radiation. Hybrids of thermal and UV crosslinking likewise fall within the framework of this invention.

The intermediate layer material is generally applied to the porous backing material in a quantity of from 10 to 500 g/m², preferably 10 to 400 g/m², more preferably 10 to 300 g/m², still more preferably 10 to 200 g/m², particularly preferably 10 to 100 g/m², most preferably 33 g/m². Here, 30 to 100%, preferably 40 to 100%, more preferably 50 to 100%, still more preferably 60 to 100%, most preferably 70 to 100%, in particular 80 to 100%, of one side of the porous backing material is covered with the intermediate layer material.

Application of the silicone gel layer to the crosslinked or

uncrosslinked intermediate layer

After the intermediate layer has been applied to the porous backing material and optionally crosslinked, an adhesive silicone gel is applied to the crosslinked or uncrosslinked intermediate layer material. The silicone gel can be applied, for example, with a film applicator. The silicone gel is preferably applied only to the intermediate layer material and not to the side of the porous backing material free from intermediate layer material, with the result that one side of the porous backing material is free from intermediate layer material and silicone gel.

The adhesive silicone gel is applied to the crosslinked or uncrosslinked intermediate layer in a quantity of from 10 to 500 g/m², preferably 50 to 200 g/m², most preferably 80 to 120 g/m², in particular 100 g/m².

The silicone gel is crosslinked after application. According to a preferred embodiment, the silicone gel is crosslinked thermally. This can occur, for example, by the layer structure being guided through a drying tunnel. A person skilled in the art will set the precise crosslinking temperature and duration as a function of the respective silicone gel.

The silicone gel is preferably designed such that the layer structure adheres well to the skin of a patient, can be removed from the skin easily and with minimal detachment of skin cells and hair, displays an optimal and constant adhesive force over the entire duration of the application and at the same time is gentle and pleasant for the skin. Furthermore, the technical parameters are chosen such that the layer made of silicone gel has a very good anchoring to the intermediate layer lying underneath, with the result that a transfer

onto the skin can be reduced and ideally ruled out altogether.

The silicone gel is formed by mixing the silicone base material with the catalyst preferably only shortly before application to the intermediate layer, it is then applied to the intermediate layer in the desired quantity and subsequently crosslinked, preferably thermally. The mixing ratio of the components depends on the respective silicone base material and catalyst and can be set individually depending on the use.

EMBODIMENT EXAMPLES

Example 1

An elastic, porous polyester non-woven material (Sontara® from DuPont) is selected as backing material. The backing material is coated with a pressure-sensitive adhesive made of acrylic acid copolymer (Duro Tak™ 1154 from Henkel) by means of transfer coating. For the transfer coating, a siliconized release liner (G-liner™ silicone from Mondi) is first coated with 33 g/m² acrylate adhesive with a film applicator. The coated release liner is dried in a circulating air flotation dryer at 180°C and then irradiated with UV radiation of an intensity of 3.3 mJ/cm² and thus crosslinked. The adhesive side is irradiated directly here. Then the acrylate compound is applied to the polyester non-woven material by means of transfer coating from the release liner. The thus-formed coated polyester non-woven material is again conveyed through a radiation chamber and irradiated with UV light of an intensity of 265 mJ/cm². Here, the backing side is irradiated and thus the adhesive is crosslinked through the backing. Then the

coated non-woven material is coated with a two-component silicone gel (Silpuran™ 2110 A/B from Wacker Chemie AG). Here, the silicone gel is applied to the already present, crosslinked acrylate layer. The silicone gel is applied in an application weight of 100 g/m² with a film applicator. The coated non-woven material is guided through a drying tunnel at 150°C at 5 m/min and the silicone gel is thereby crosslinked. The coated non-woven material is finally covered with a siliconized release liner.

Example 2

To produce the adhesive layer structure, an elastic, porous polyester non-woven material (Sontara® from DuPont) is selected as backing material. The backing material is coated directly with a pressure-sensitive adhesive made of acrylic acid copolymer (acResin™ A 260 UV from BASF AG). The adhesive is a hot-melt adhesive. This is first liquefied at a temperature of 130°C in a drum melter and applied directly to the polyester non-woven material in an application quantity of 33 g/m² with the aid of a slot die. A subsequent drying was dispensed with. The coated non-woven material is irradiated with UV light as described in Example 1, in order to crosslink the adhesive. Then the coated non-woven material is coated with a two-component silicone gel (Silpuran™ 2110 A/B from Wacker Chemie AG). Here, the silicone gel is applied to the already present acrylate layer. The silicone gel is applied in an application weight of 100 g/m² with a film applicator. The coated non-woven material is guided through a drying tunnel at 150°C at 5 m/min and the silicone gel is thereby crosslinked. The coated non-woven material is finally covered with a siliconized release liner.

CLAIMS:

1. A silicone-gel-coated, adhesive layer structure, comprising:

- a) a first layer consisting of a porous backing material,
- b) on one side of the porous backing material, an intermediate layer crosslinked by UV, which includes acrylic acid copolymer, and,
- c) on the intermediate layer, a layer made of a crosslinked, adhesive silicone gel.

2. The adhesive layer structure according to claim 1, wherein the intermediate layer and the adhesive silicone gel are present only on one side of the porous backing material.

3. The adhesive layer structure according to claim 1 or 2, wherein the porous backing material includes any one of non-woven materials, fabrics, knitted fabrics, foam materials and films.

4. The adhesive layer structure according to claim 3, wherein the porous backing material is produced from natural material or plastic.

5. The adhesive layer structure according to claim 3, wherein the porous backing material includes viscose, rayon, cellulose, polyethylene, polypropylene, polyamide, polyester, polyacetate, polyurethane or a mixture thereof.

6. The adhesive layer structure according to any one of claims 1 to 5, wherein the crosslinked intermediate layer is present on the porous backing material in a quantity of from 10 to 500 g/m².

7. The adhesive layer structure according to any one of claims 1 to 5, wherein the crosslinked intermediate layer is present on the porous backing material in a quantity of from 10 to 400 g/m².

8. The adhesive layer structure according to any one of claims 1 to 5, wherein the crosslinked intermediate layer is present on the porous backing material in a quantity of from 10 to 300 g/m².

9. The adhesive layer structure according to any one of claims 1 to 5, wherein the crosslinked intermediate layer is present on the porous backing material in a quantity of from 10 to 200 g/m².

10. The adhesive layer structure according to any one of claims 1 to 5, wherein the crosslinked intermediate layer is present on the porous backing material in a quantity of from 10 to 100 g/m².

11. The adhesive layer structure according to any one of claims 1 to 5, wherein the crosslinked intermediate layer is present on the porous backing material in a quantity of 33 g/m².

12. The adhesive layer structure according to any one of claims 1 to 11, wherein the acrylic acid copolymer is produced from monomers including acrylic acid, butyl acrylate, 2-ethylhexyl acrylate, 2-hydroxyethyl acrylate, dioctyl acrylate, methyl acrylate, ethyl acrylate, tert-butyl acrylate or mixtures thereof.

13. The adhesive layer structure according to any one of claims 1 to 12, wherein one side of the porous backing material is 30 to 100% covered with the intermediate layer material.

14. The adhesive layer structure according to any one of claims 1 to 12, wherein one side of the porous backing material is 40 to 100% covered with the intermediate layer material.

15. The adhesive layer structure according to any one of claims 1 to 12, wherein one side of the porous backing material is 50 to 100% covered with the intermediate layer material.

16. The adhesive layer structure according to any one of claims 1 to 12, wherein one side of the porous backing material is 60 to 100% covered with the intermediate layer material.

17. The adhesive layer structure according to any one of claims 1 to 12, wherein one side of the porous backing material is 70 to 100% covered with the intermediate layer material.

18. The adhesive layer structure according to any one of claims 1 to 12, wherein one side of the porous backing material is 80 to 100% covered with the intermediate layer material.

19. The adhesive layer structure according to any one of claims 1 to 18, wherein the crosslinked, adhesive silicone gel layer is present on the crosslinked intermediate layer in a quantity of from 10 to 500 g/m².

20. The adhesive layer structure according to any one of claims 1 to 18, wherein the crosslinked, adhesive silicone gel layer is present on the crosslinked intermediate layer in a quantity of from 50 to 200 g/m².

21. The adhesive layer structure according to any one of claims 1 to 18, wherein the crosslinked, adhesive silicone gel layer is present on the crosslinked intermediate layer in a quantity of from 80 to 120 g/m².

22. The adhesive layer structure according to any one of claims 1 to 18, wherein the crosslinked, adhesive silicone gel layer is present on the crosslinked intermediate layer in a quantity of 100 g/m².

23. The adhesive layer structure according to any one of claims 1 to 22, wherein the adhesive layer structure is a medical product.

24. The adhesive layer structure according to any one of claims 1 to 22, wherein the adhesive layer structure is a roll plaster or a tape.

25. A method for producing the silicone-gel-coated, adhesive layer structure according to any one of claims 1 to 24, in which

a) an intermediate layer material is applied to a porous backing material, at least partially covering the porous backing material, wherein the intermediate layer material includes acrylic acid copolymer,

b) the intermediate layer material is crosslinked or further crosslinked by UV radiation,

c) a silicone gel is applied to the crosslinked intermediate layer material and

d) the silicone gel is crosslinked.

26. The method for producing a silicone-gel-coated, adhesive layer structure according to claim 25, wherein the intermediate layer material is applied to completely cover the porous backing material.

27. The method for producing a silicone-gel-coated, adhesive layer structure according to claim 25 or 26, in which the intermediate layer material is applied only to one side of the porous backing material in step a) and the silicone gel is applied only to the intermediate layer material in step c), with the result that one side of the porous backing material is free from intermediate layer material and silicone gel.

28. The method for producing a silicone-gel-coated, adhesive layer structure according to any one of claims 25 to 27, in which the intermediate layer material is applied to the porous backing material in step a) by first being applied to a substrate material and then being applied to the porous backing material from this substrate material by means of transfer coating.

29. The method for producing a silicone-gel-coated, adhesive layer structure according to claim 28, in which the intermediate layer material

a1) is present in a solvent before application to the substrate material,

a2) the intermediate layer material is applied to the substrate material and

a3) the solvent is then at least partially evaporated and the intermediate layer material present on the substrate material is crosslinked by UV radiation after step a3) and before application to the porous backing material.

30. The method for producing a silicone-gel-coated, adhesive layer structure according to claim 29, wherein the solvent includes any one of water, benzine or acetone.

31. The method for producing a silicone-gel-coated, adhesive layer structure according to claim 29, wherein the solvent is completely evaporated.

32. The method according to any one of claims 25 to 31, in which the porous backing material includes any one of non-woven materials, fabrics, knitted fabrics, foam materials and films.

33. The method according to any one of claims 25 to 31, wherein the porous backing material is produced from natural material or plastic.

34. The method according to any one of claims 25 to 31, wherein the porous backing material includes viscose, rayon, cellulose, polyethylene, polypropylene, polyamide, polyester, polyacetate, polyurethane or a mixture thereof.

35. The method according to any one of claims 25 to 34, in which the acrylic acid copolymer is produced from monomers including acrylic acid, butyl acrylate, 2-ethylhexyl acrylate, 2-hydroxyethyl acrylate, dioctyl acrylate, methyl acrylate, ethyl acrylate, tert-butyl acrylate or mixtures thereof.

36. The method according to any one of claims 25 to 35, in which the intermediate layer material is applied to the porous backing material in a quantity of from 10 to 500 g/m².

37. The method according to any one of claims 25 to 35, in which the intermediate layer material is applied to the porous backing material in a quantity of from 10 to 400 g/m².

38. The method according to any one of claims 25 to 35, in which the intermediate layer material is applied to the porous backing material in a quantity of from 10 to 300 g/m².

39. The method according to any one of claims 25 to 35, in which the intermediate layer material is applied to the porous backing material in a quantity of from 10 to 200 g/m².

40. The method according to any one of claims 25 to 35, in which the intermediate layer material is applied to the porous backing material in a quantity of from 10 to 100 g/m².

41. The method according to any one of claims 25 to 35, in which the intermediate layer material is applied to the porous backing material in a quantity of 33 g/m².

42. The method according to any one of claims 25 to 41, in which the crosslinked, adhesive silicone gel layer is applied to the crosslinked intermediate layer in a quantity of from 10 to 500 g/m².

43. The method according to any one of claims 25 to 41, in which the crosslinked, adhesive silicone gel layer is applied to the crosslinked intermediate layer in a quantity of from 50 to 200 g/m².

44. The method according to any one of claims 25 to 41, in which the crosslinked, adhesive silicone gel layer is applied to the crosslinked intermediate layer in a quantity of from 80 to 120 g/m².

45. The method according to any one of claims 25 to 41, in which the crosslinked, adhesive silicone gel layer is applied to the crosslinked intermediate layer in a quantity of 100 g/m².

46. The method according to any one of claims 25 to 45, in which 30 to 100% of one side of the porous backing material is covered with the intermediate layer material.

47. The method according to any one of claims 25 to 45, in which 40 to 100% of one side of the porous backing material is covered with the intermediate layer material.

48. The method according to any one of claims 25 to 45, in which 50 to 100% of one side of the porous backing material is covered with the intermediate layer material.

49. The method according to any one of claims 25 to 45, in which 60 to 100% of one side of the porous backing material is covered with the intermediate layer material.

50. The method according to any one of claims 25 to 45, in which 70 to 100% of one side of the porous backing material is covered with the intermediate layer material.

51. The method according to any one of claims 25 to 45, in which 80 to 100% of one side of the porous backing material is covered with the intermediate layer material.

52. The silicone-gel-coated, adhesive layer structure according to any one of claims 1 to 24 as a medical product for use in securing medical instruments to skin of a person or an animal.