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(71) Applicant *(for all designated States except US)*: **PHARMAGRAPHICS (MIDWEST) L.L.C.** [US/US]; 800 Hilltop Drive, Itasca, IL 60143 (US).

(72) Inventors; and
(75) Inventors/Applicants *(for US only)*: **TRELEAVEN, Carl, W.** [US/US]; 3817 Buncombe Drive, Greensboro, NC 27407 (US). **GROSSKOPF, Glenn, A.** [US/US]; 269 Pohlman Court, Lake Zurich, IL 60047 (US).

(74) Agent: **MYERS, BIGEL, SIBLEY & SAJOVEC, P.A.**; P. O. Box 37428, Raleigh, NC 27627 (US).

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(54) Title: SELF-ADHESIVE LABELS HAVING TAB MEMBERS AND METHODS FOR FORMING THE SAME

(57) Abstract: A label assembly includes a release liner and a leaflet including a top panel and a bottom panel connected to the top panel. A tab member is disposed adjacent the leaflet but does not form a part of the leaflet. The tab member has an upper surface. A tab adhesive releasably adheres the tab member to the release liner. A laminate cover includes a first portion overlying the top panel and a second portion overlying the tab member. A laminate adhesive may releasably and resealably adhere the second portion of the laminate cover to the upper surface of the tab member. A leaflet adhesive may directly and releasably adhere the bottom panel of the leaflet to the release liner. A label may be formed by a method including forming a tab member releasably adhered to a release liner, and adhering a leaflet directly to the release liner adjacent the tab member. The method may further include applying a self-adhesive laminate web over the leaflet and the tab member, and diecutting the laminate web to form the label, the label including a laminate cover formed from the laminate web.

SELF-ADHESIVE LABELS HAVING TAB MEMBERS AND METHODS FOR FORMING THE SAME

Field of the Invention

The present invention relates to labels, and more particularly, to extended text, self-adhesive labels and methods for forming the same.

Background of the Invention

In the packaging of certain chemicals and pharmaceuticals, the manufacturer is often required or desires to provide a considerable amount of information concerning the chemical or pharmaceutical. In the case of pharmaceuticals, this is required by government regulations, however, the occasion may also arise, either separate from or in conjunction with government regulations, to provide the doctor, pharmacist or user with instructions on how the product should be used, what the product is, and safety precautions which should be followed in the use of the product. Similarly, it is often desirable to provide information in multiple languages so that a given product or packaging may be distributed in multiple locations or regions.

Sometimes the literature, which is generally in the form of folded leaflets, is placed within a box along with the container carrying the chemical or pharmaceutical (referred to as "inserts"). The placement of leaflets within the box is expensive and a cumbersome operation to perform. Also, it is difficult to insure by later inspection that the proper literature has been inserted in the proper package. Most all products are packaged in outer cartons and many are not compatible with inserts. Further, the use of folded cartons is under scrutiny by environmental groups, as involving excessive packaging. In an effort to meet this challenge, many companies seek alternatives to folding cartons that carry containers inside.

A different approach to solving this problem has developed over the last several years in which the folded literature is releasably attached to the face of the container (referred to as "outserts"), either directly to the container itself, or to a base label which, in turn, is secured to the container. The literature may then be removed by the customer. In such cases, the portion of the label remaining must carry both an "identification" of the product, for example, information such as trademark, manufacturer, etc., as well as certain "statutory information" (for example, lot number and expiration date).

It is often desirable to provide an extended text label with resealability. Resealability may allow the user to open the label, inspect or remove the interior pages thereof, and thereafter reclose and reseal the label. The interior pages, if not removed, may then be referred to again later. Additionally, the various panels of the label are retained in a closed configuration so that they do not dangle and interfere with the handling of and detract from the appearance of the associated article.

Summary of the Invention

According to a first aspect of the present invention, a label assembly includes a release liner and a leaflet. The leaflet includes a top panel and a bottom panel connected to the top panel. A tab member is disposed adjacent the leaflet but does not form a part of the leaflet. The tab member has an upper surface. A tab adhesive releasably adheres the tab member to the release liner. The label further includes a laminate cover including a first portion overlying the top panel and a second portion overlying the tab member. A laminate adhesive releasably and resealably adheres the second portion of the laminate cover to the upper surface of the tab member. The label assembly may include a release varnish coating the upper surface of the tab member, wherein the laminate adhesive releasably and resealably engages the varnish coating.

According to a further aspect of the present invention, a label assembly includes a release liner and a leaflet including a top panel and a bottom panel connected to the top panel. A leaflet adhesive directly and releasably adheres the bottom panel to the release liner. A tab member is disposed adjacent the leaflet but does not form a part of the leaflet. The tab member has an upper surface. A tab adhesive releasably adheres the tab member to the release liner. The label further includes a laminate cover including a first portion overlying the top panel and a

second portion overlying the tab member. A laminate adhesive adheres the second portion of the laminate cover to the upper surface of the tab member.

In each of the foregoing labels, the laminate cover may include a third portion extending beyond an edge of the leaflet opposite the tab member, wherein the third portion is directly and releasably adhered to the release liner by the laminate adhesive. The tab member may be disposed substantially immediately adjacent the leaflet, may be spaced apart from the leaflet, or may include a portion underlying the leaflet. The leaflet may include a booklet. The tab adhesive and the leaflet adhesive may form a common adhesive patch.

The laminate cover may include a third portion extending beyond an edge of the leaflet opposite the tab member and a second tab member underlies the third portion has an upper surface. A second tab adhesive releasably adheres the second tab member to the release liner. The third portion is adhered to the upper surface of the second tab member by the laminate adhesive. The second tab member may be disposed substantially immediately adjacent the leaflet, may be spaced apart from the leaflet, or may include a portion underlying the leaflet.

The leaflet may include an interior panel disposed between the top and bottom panels and connected to the top panel along a first fold adjacent the tab member. The bottom panel is connected to the top panel along a second fold opposite the first fold.

According to a further aspect of the present invention, a label assembly includes a release liner and a leaflet including a top panel and a bottom panel connected to the top panel. The top panel includes an extended flap extending beyond the bottom panel. A tab member is disposed adjacent the leaflet but does not form a part of the leaflet. The tab member has an upper surface. The tab member and the leaflet are relatively disposed such that the extended flap overlies the tab member. A tab adhesive releasably adheres the tab member to the release liner. The label further includes a laminate cover including a first portion overlying the top panel and a second portion overlying the extended flap. An extended flap adhesive adheres the extended flap to the upper surface of the tab member. Preferably, the extended flap adhesive releasably and resealably adheres the extended flap to the upper surface of the tab member. Preferably, the label assembly includes a leaflet adhesive directly and releasably adhering the bottom panel of the leaflet to the release liner.

According to a further aspect of the present invention, a label assembly includes a release liner and a leaflet including a top panel, a bottom panel connected

to the top panel, and an auxiliary top panel connected to the bottom panel along a fold. The auxiliary top panel overlies only a part of the top panel. A tab member is disposed adjacent but does not form a part of the leaflet. The tab member has an upper surface and is disposed adjacent the fold connecting the bottom panel and the auxiliary top panel. A tab adhesive releasably adheres the tab member to the release liner. A laminate cover includes a first portion overlying the top panel and a second portion overlying the tab member. A laminate adhesive adheres the second portion to the upper surface of the tab member. The label assembly may further include a tear line formed in the laminate cover and the top panel adjacent an end of the leaflet opposite the fold between the bottom panel and auxiliary top panel.

According to a further aspect of the present invention, a method for forming a label includes forming a tab member releasably adhered to a release liner. A leaflet is adhered directly to the release liner adjacent the tab member.

Preferably, the method further includes the steps of applying a self-adhesive laminate web over the leaflet and the tab members and diecutting the laminate web to form the label, the label including a laminate cover formed from the laminate web. The method may include applying an adhesive deadener to the adhesive of the laminate web prior to the step of applying the laminate web over the leaflet. The method may include applying a varnish coating to the tab member.

The method may include providing a composite web including the release liner and a self-adhesive stock web. The stock web is diecut to form the tab member therein. A waste matrix including portions of the stock web not forming a part of the tab member is removed such that the tab member remains adhered to the release liner. A patch of adhesive is applied directly to the release liner at a location adjacent the tab member. The leaflet is applied to the adhesive patch such that the leaflet is directly adhered to the release liner by the adhesive patch.

The method may include providing the release liner and applying a first patch of adhesive to the release liner. A non-adhesive stock web is married to the release liner and the first patch of adhesive. The stock web is diecut to form the tab member therein, the tab member overlying and adhered to the release liner by at least a portion of the first adhesive patch disposed between the tab member and the release liner. A waste matrix including portions of the stock web not forming a part of the tab member is removed. A second patch of adhesive is applied directly to the release liner at a location adjacent the tab member. The leaflet is applied to the second

adhesive patch such that the leaflet is directly adhered to the release liner by the second adhesive patch.

The method may include providing a release liner and a self-adhesive stock web. A hole is formed in the stock web. The stock web is married to the release liner. A patch of adhesive is applied directly to the release liner at a location which, after the stock web is married to the release liner, is within the hole in the stock web. The leaflet is applied to the adhesive patch such that the leaflet is directly adhered to the release liner by the adhesive patch. The stock web is diecut to form the tab member adjacent the adhesive patch. A waste matrix including portions of the stock web not forming a part of the tab member is removed.

The method may include providing a release liner and applying a patch of adhesive directly to the release liner. A non-adhesive stock web is provided and a hole is formed therein. The stock web is married to the release liner such that a first portion of the adhesive patch is disposed in the hole and a second portion of the adhesive patch is covered by the stock web adjacent the hole. The leaflet is applied to the adhesive patch such that the leaflet is directly adhered to the release liner by at least a portion of the first adhesive portion. The stock web is diecut to form the tab member adjacent the adhesive patch, the tab member being adhered to the release liner by at least a portion of the second adhesive portion. A waste matrix including portions of the stock web not forming a part of the tab member is removed.

The method may include providing a release liner and applying a first patch of adhesive to the release liner. The tab member is applied to the first adhesive patch. A second patch of adhesive is applied directly to the release liner at a location which, after the tab member is applied to the first adhesive patch, is disposed adjacent the tab member. The leaflet is applied to the second adhesive patch such that the leaflet is directly adhered to the release liner by the second adhesive patch.

The method may include providing a release liner and applying a self-adhesive tab member to the release liner. A patch of adhesive is applied directly to the release liner at a location which, after the tab member is applied to the release liner, is disposed adjacent the tab member. The leaflet is applied to the second adhesive patch such that the leaflet is directly adhered to the release liner by the adhesive patch.

Objects of the present invention will be appreciated by those of ordinary skill in the art from a reading of the Figures and the detailed description of the preferred

embodiments which follow, such description being merely illustrative of the present invention.

Brief Description of the Drawings

Figure 1 is a side elevational view of a label according to a first embodiment of the present invention disposed on a release liner;

Figure 2 is a top plan view of the label of **Figure 1** on the release liner;

Figure 3 is a schematic diagram of an apparatus for forming the label of **Figure 1**;

Figure 4 is a top plan view of an intermediate construction formed by the apparatus of **Figure 3**;

Figure 5 is a second intermediate construction formed by the apparatus of **Figure 3**;

Figure 6 is a schematic diagram of an alternative apparatus for forming the label of **Figure 1**;

Figure 7 is a schematic diagram of a further alternative apparatus for forming the label of **Figure 1**;

Figure 8 is a top plan view of an intermediate construction formed by the apparatus of **Figure 7**;

Figure 9 is a top plan view of a second intermediate construction formed by the apparatus of **Figure 7**;

Figure 10 is a schematic diagram of a further alternative apparatus for forming the label of **Figure 1**;

Figure 11 is a side elevational view of a label according to a further embodiment of the present invention;

Figure 12 is a side elevation view of a label according to a further embodiment of the present invention;

Figure 13 is a side elevation view of a label according to a further embodiment of the present invention;

Figure 14 is a side elevation view of a label according to a further embodiment of the present invention;

Figure 15 is a side elevation view of a label according to a further embodiment of the present invention;

Figure 16 is a side elevation view of a label according to a further embodiment of the present invention;

Figure 17 is a side elevation view of a label according to a further embodiment of the present invention;

Figure 18 is a side elevation view of a label according to a further embodiment of the present invention;

Figure 19 is a side elevation view of a label according to a further embodiment of the present invention;

Figure 20 is a side elevation view of a label according to a further embodiment of the present invention;

Figure 21 is a side elevation view of a label according to a further embodiment of the present invention; and

Figure 22 is a side elevation view of a label according to a further embodiment of the present invention.

Detailed Description of Preferred Embodiments

The present invention now will be described more fully hereinafter with reference to the accompanying drawings, in which embodiments of the invention are shown. This invention may, however, be embodied in many different forms and should not be construed as limited to the embodiments set forth herein; rather, these embodiments are provided so that this disclosure will be thorough and complete, and will fully convey the scope of the invention to those skilled in the art. In the drawings, like numbers refer to like elements throughout. It will be understood that when an element such as a layer, region or substrate is referred to as being "on" another element, it can be directly on the other element or intervening elements may also be present. In contrast, when an element is referred to as being "directly on" another element, there are no intervening elements present. The thicknesses of layers of the labels as shown in the drawings may be exaggerated for clarity.

By "releasably adhered", it is meant that the referenced article (e.g., the laminate cover discussed below) may be removed from the associated article without inordinate effort (although some deliberate effort may be required) and without causing significant damage or destruction to either article (e.g., the laminate cover or the tab member). By "permanently adhered", it is meant that the referenced article may be removed from the associated article only by applying inordinate force and/or

causing significant damage or destruction to one or both of the articles. Such destruction may include substantial tearing of a layer. By "resealable", it is meant that the articles (e.g., the laminate cover and the varnish coated tab member discussed below) may be readhered to one another such that the adhesive bond will resist inadvertent separation and will require deliberate effort to re-separate the articles.

With reference to **Figures 1** and **2**, a label **100** according to a first embodiment of the present invention is shown therein disposed on a release liner **102**. The label **100** includes a multipanel, folded leaflet **101** releasably adhered to the release coated surface of the release liner **102** by an adhesive patch **104**. The label **100** further includes a tab member **120** releasably adhered to the release liner **102** by a second adhesive patch **106**. A laminate cover **130** extends over the leaflet **101** and the tab member **106** as well as a portion of the release liner **102**. The laminate cover **130** is adhered to the leaflet **101**, the tab member **120** and the release liner **102** by a laminate adhesive **132**. The construction of the label **100** will hereinafter be described in more detail.

The leaflet **101** is preferably formed from a unitary blank of paper or other suitable material. Suitable materials include coated two side litho stock from Potlatch Industries or 35 pound uncoated offset stock available from Fletcher Papers of Alpena, Michigan. The leaflet **101** includes a bottom panel **110** joined to a top panel **112** along a fold **111**. An intermediate panel **114** is joined to the bottom panel **110** along a fold **113** opposite the fold **111**. Further interior panels may be joined to the opposing edge of the interior panel **114**. The top panel **112** includes an extended flap **118** which extends beyond the fold **113** and terminates at an edge **119**. With reference to **Figure 2**, suitable indicia **125A, 125C** such as product identification, warnings, instructions, and/or lot and expiration prompts and/or data may be printed on the leaflet **101** and/or on the tab member **120**. Additionally, instructions for using the label **100** (e.g., instructions for opening the label **100**) **125B** may be printed on the leaflet **101** and/or the tab member **120** as well.

The bottom panel **110** of the leaflet is directly adhered to the release liner **102** by the adhesive **104**. The adhesive **104** is preferably a pressure-sensitive adhesive. Suitable adhesives include HL2203X, a permanent hot melt adhesive, available from H.B. Fuller Company of Minneapolis, MN.

The tab member **120** is a discrete piece which is not directly connected to the leaflet **101**. Preferably, the tab member is separately formed from the leaflet **101** as

discussed below. The tab member **120** may be formed of 2.3 mil biaxially oriented polypropylene film (provided on a release liner) available from Spinnaker of Troy, Ohio. As shown, a release varnish or lacquer **122** is disposed on the upper surface of the tab member **120**. Suitable release varnishes include FT33HG available from Northwest Coatings Corporation of Oak Creek, Wisconsin. Alternatively (not shown), the tab member **120** may be formed of a material which provides non-destructive releasability between the laminate adhesive **132** and the upper surface of the tab member **120**. With reference to **Figure 1**, the tab member **120** preferably has a length **L** of at least 1/2 inch, and more preferably, between about 3/4 inch and one inch.

The tab member **120** is directly adhered to the release liner **102** by the adhesive **106**. The adhesive **106** is preferably a pressure sensitive adhesive. Suitable adhesives include HL2203X permanent hot melt adhesive available from H.B. Fuller of Minneapolis, MN.

The laminate cover **130** is preferably transparent. Suitable materials include product number 201, a 1.3 mil clear polypropylene film available from American Paper and Film Company of West Chicago, Illinois. The laminate adhesive is preferably a pressure sensitive adhesive available from Rhom & Haas. The laminate cover **130** includes a central portion **130A** which is preferably substantially permanently secured to the top panel **112** (including the extended flap **118**) by the laminate adhesive **132**. A portion **130B** of the laminate cover **130** covers the tab member **120** and is releasably adhered thereto by the laminate adhesive **132**. A further portion **130C** of the laminate cover **130** extends beyond the fold **111** of the leaflet **101** and is directly and releasably secured to the release liner **102** by the laminate adhesive **132**.

As best seen in **Figure 1**, the leaflet **101** and the tab member **120** are relatively positioned such that the end edge **119** of the leaflet **101** is disposed substantially immediately adjacent the proximate edge of the tab member **120**. Preferably, the extended flap **118** is dimensioned to provide a gap **G** between the fold **113** and the tab member **120** of at least 1/8 inch, and more preferably, between about 3/16 inch and 1/4 inch. The adhesive patch **104** and the leaflet **101** are relatively positioned to provide a lengthwise gap **F** between the fold **111** and the proximate edge of the adhesive patch **104** of at least 1/8 inch, and more preferably, between about 3/16 inch and 1/4 inch.

The label **100** may be applied to a suitable container using conventional label application equipment, including automatic and semi-automatic label application equipment. When the label **100** is applied to the container, the adhesive **106**, the adhesive **104**, and the laminate adhesive **132** underlying the portion **130C** will substantially permanently adhere to the container. The end user may open the label to access the information on the inner pages of the leaflet **101** by inserting his or her finger beneath the extended flap **118** and lifting the laminate cover **130** upwardly. In this manner, the laminate portion **130B** (and the laminate adhesive **132** thereunder) may be peeled away from the varnish coated upper surface of the tab member **120**. The user may then inspect the pages of the leaflet **101** and, if desired, reseal the label **100** by readhering the laminate adhesive **132** coating the portion **130B** to the varnish coated tab member **120**.

The tab member **120** provides additional area, viewable when the label is closed, for indicia. Moreover, the tab member **120** provides a supportive backing to the laminate cover portion **130B** that may facilitate application of the label **100** to the container or other article. The tab member **120**, either by means of the selected material or the provision of the varnish coating **122**, ensures a prescribed and consistent release and resealability of the laminate cover portion **130B** so that these features are not adversely affected by the material of the container. Moreover, by forming the tab member **120** and the leaflet **101** separately as discussed below, the respective materials of the tab member and the leaflet may be chosen independently. The gaps **F** and **G** reduce any tendency of the label **100** to bind as it is applied to a curved container. Because the label **100** and the labels described hereinafter are resealable and configured in the manners shown, it is not necessary to form tear lines to allow opening of the labels.

With reference to **Figure 3**, an apparatus **150** for forming the label **100** is shown therein. A composite web **152** is unwound from an unwinding stand **151**. The composite web **152** includes the release liner **102** and a self-adhesive stock web **152A**. The self-adhesive stock web **152A** includes a layer of adhesive corresponding to the adhesive **106** and a web of material corresponding to the tab member **120**. Varnish corresponding to the varnish **122** is applied to the upper surface of the web **152A** by a printing station **154**.

A die cutter **156** die cuts a succession of tab portions **120A** (see **Figure 4**) in the web **152A**. A waste matrix **158A** consisting of those portions of the web **152A**

outside of the tab portions **120A** is pulled away and wound onto a winding stand **158**. In this manner, an intermediate construction as shown in **Figure 4** is formed. Each tab portion **120A** may have an extended length extending transversely across the width of the release liner **102** such that the labels may be formed "multiple up".

Thereafter, a printing station **159** (see **Figure 3**) prints a succession of adhesive patches **104A** between the tab portions **120A** to form a second intermediate construction as shown in **Figure 5**. Each adhesive patch **104A** corresponds to an adhesive layer **104** (see **Figure 1**) of a respective label **100** and is positioned with respect to the associated tab portion **120A** as appropriate to provide the desired relationship between the adhesive **104** and the tab member **120**. The adhesive applicator **159** is preferably a Flexocoat unit, Model number HMFPA-16 available from GRE Engineered Products of Switzerland.

A leaflet application station **142** (see **Figure 3**), for example, an Onserts unit available from Longford Equipment, Ltd. of Toronto, applies leaflets **101A** corresponding to the leaflet **101**. Each leaflet **101A** has a leading edge corresponding to the edge **119** and is applied such that this edge is disposed substantially immediately adjacent the proximate edge of the associated tab portion **120A**. Each leaflet **101A** may be a "multiple up" leaflet from which a plurality of side-by-side (extending transversely across the width of the release liner **102**) leaflets **101** are formed by cutting.

With further reference to**Figure 3**, a self-adhesive laminate web **144A** is unwound from a stand **144** and married to the release **102** and over the tab portions **120A** and the leaflets **101A** at nip rollers **144B**. Element **143** (adhesive deadener applicator) as shown in **Figure 3** is an optional station as discussed hereinbelow. A die cutter **145** die cuts the laminate web **144A,** the tab portion **120A** and the leaflet **101A** to form the label **100**. A waste matrix **146A** consisting of the portions of said elements outside of the label **100** is wound onto a stand **146**. The labels **100** and the release liner **102** may be wound onto a stand **148**.

With reference to **Figure 6**, an alternative apparatus **160** for forming the label **100** is shown therein. The release liner **102** is unwound from a stand **161**. An adhesive applicator **167** applies a succession of adhesive patches in a pattern corresponding to the adhesive underlying the tab portions **120A** as shown in **Figures 4** and **5**. The adhesive print station **167** is preferably as described above with respect to the adhesive print station **159**. A non-self-adhesive web stock **162A** corresponding

to the tab member **120** is unwound from a stand **162** and married to the release liner **102** and the adhesive patches thereon. A varnish application station **164** corresponding to the station **154** of **Figure 3** applies varnish to the web **162A** in locations ultimately corresponding to the tab portions **120A**. A die cutter **165** die cuts through the web **162A** and within the adhesive patches applied by the applicator **167** to form the intermediate construction as shown in **Figure 4**. A waste matrix **168A** consisting of the portions of the web **162A** and any adhesive outside of the tab portions **120A** is wound onto a stand **168**.

An adhesive application station **169** corresponding to the adhesive application station **159** of **Figure 3** applies the adhesive patches **104A** to form the intermediate construction as shown in **Figure 5**. Thereafter, the labels **100** are formed in the same manner as described above with regard to **Figure 3**, with like element numbers indicating the same elements.

With reference to **Figure 7,** an alternative apparatus **170** for forming the label **100** is shown therein. The release liner **102** is unwound from a stand **171**. Additionally, a composite web is supplied from a stand **172**. The composite web includes a self-adhesive face stock **172A** (corresponding to the tab member **120** and the adhesive **106** in the finished label **100**) mounted on a second release liner **102B**. The second release liner **102B** is removed from the web **172A** and wound onto a stand **173**. A die cutter **175** punches holes **H** (see **Figures 8** and **9**) in the web **172A**. The diecut step may be executed prior to removal of the release liner. The self-adhesive web **172A** is then married to the release liner **102** to form the intermediate construction as shown in **Figure 8**. Notably, the release liner **102** is exposed through the holes **H**, and transversely extending strips or "rungs" **120B** of the face stock **172A** material are disposed between the holes **H**.

A varnish applicator **174** (see **Figure 7**) corresponding to the varnish applicator **154** applies varnish to the web portions **120B**. An adhesive applicator station **179** corresponding to the adhesive applicator station **159** applies adhesive patches **104A** to the release liner **102** in the holes **H** to form the intermediate construction as shown in **Figure 9**. The web portions **120B** correspond to the tab members **120**. Therefore, the adhesive patches **104A** are positioned relative to the portions **120B** in the same manner as described with reference to **Figure 5**.

Thereafter, the labels **100** are formed in the same manner as described above with regard to the apparatus **150**, with like element numbers indicating the same

elements. However, the waste matrix **146B** will include those portions of the web **172A** not forming a part of the labels **100**. The leaflet adhesive or the leaflet adhesive and the leaflet may be applied to the release liner prior to marrying the self-adhesive face stock **172A** to the release liner.

With referenced to **Figure 10**, an alternative apparatus **180** for forming the label **100** is shown therein. The release liner **102** is unwound from a stand **181**. An adhesive applicator **189** corresponding to the adhesive applicator **159** applies patches of adhesive to the release liner **102**. In this case, the adhesive applicator **189** applies patches of adhesive corresponding to both the adhesive patch **104** and the adhesive **106** of the finished label **100**. A non-pressure-sensitive face stock **182A** formed of a material corresponding to the tab member **120** is unwound from a stand **182**. A die cutter **185** punches holes **H** (see **Figure 8**) in the web **182A**.

The punched web **182A** is married to the release liner **102** such that the portions **120B** are directly adhered to the release liner **102** by the adhesive patches laid by the adhesive applicator **189** corresponding to the adhesive patches **106**, and the adhesive patches laid by the adhesive applicator **189** corresponding to the adhesive patches **104** are received in the holes **H** to form the construction as shown in **Figure 9**.

A varnish applicator **184** corresponding to the varnish applicator **154** applies varnish to the portions **120B**. Thereafter, the construction of the label **100** is the same as described with reference to **Figure 3**, with like element numbers indicating the same elements. However, the waste matrix **146C** will differ from the waste matrix **146B** as described with reference to **Figure 7** in that the lengthwise extending portions may not be fully self-adhesive.

As a further alternative method (apparatus not shown), the label **100** may be formed by applying adhesive patches corresponding to the adhesive **104**, **106** to the release liner **102**. Pre-formed, non-self-adhesive tab portions corresponding to the tab members **120** are then blown onto the adhesive patches corresponding to the adhesive **106**. The tab portions may be blown onto the release liner using, for example, a blown on label applicator such as product number 2111 available from LabelAire of Fullerton, CA. Alternative means for applying the tab portions may be used as well. Leaflets are applied to the adhesive patches corresponding to the adhesive **104**, and the leaflets and tab portions are varnish coated, overlaminated and cut as described above. The foregoing method may be modified by blowing self-adhesive tab portions

onto the release liner rather than applying adhesive patches corresponding to the adhesive **106**.

Each of the foregoing methods using a self-adhesive overlaminate web may be further modified by applying the leaflets first to the respective self-adhesive overlaminate web rather than to the release liner.

With reference to **Figure 11**, a label **200** according to a further embodiment is shown therein mounted on a release liner **202**. The label **200** includes a leaflet **201** corresponding to the leaflet **101** except that the extended flap **218** thereof (forming a part of the top panel **212**) is further extended to include a portion **218A** which overlaps the tab member **220**. Preferably, the portion **218A** has an overlapping length **U** of at least 1/4 inch and, more preferably, between about 5/16 inch and 1/2 inch. The label **200** may be formed by any of the foregoing methods and apparatus.

With reference to **Figure 12**, a label **300** according to a further embodiment is shown therein mounted on a release liner **302**. The label **300** includes a leaflet **301** corresponding to the leaflet **101** except that the top panel **312** does not include an extended flap corresponding to the extended flap **218**. In order to prevent the laminate adhesive **332** coating the underside of the laminate portion **330D** of the laminate cover **330** in the gap **G** (i.e., the space between the tab member **320** and the fold **313**) from permanently adhering to the container once the label is applied, an adhesive deadener **335** is applied to this portion of the laminate adhesive **332**. Suitable adhesive deadeners include FT33HG available from Northwest Coatings, Inc. of Oak Creek, WI. While the deadened portion of the laminate adhesive **332** may extend partially over the tab member **320**, a portion of active (i.e., tacky and adherent) laminate adhesive of suitable size to hold the label **300** closed should engage the varnish **322** on the upper surface of the tab member **320**. The gap **G** preferably has the same preferred dimensions as described with regard to the label **100**.

The label **300** may be formed by any of the foregoing methods and apparatus. However, an adhesive deadener applicator **143** (see **Figures 3, 6, 7** and **10**) applies patches of adhesive deadener to the adhesive of the overlaminate web **144A** in locations corresponding to the adhesive deadener **335**. Suitable adhesive deadener applicators include a flexographic printer as described with regard to the printer **159**.

With reference to **Figure 13**, a label **400** according to a further embodiment is shown therein mounted on a release liner **402**. The label **400** is constructed in the same manner as the label **100** except as follows. The label **400** includes a booklet

401. The booklet 401 includes a bottom panel 410 releasably adhered to the release liner 402 by an adhesive patch 404 corresponding to the adhesive patch 104. A top panel 412 is joined to the bottom panel 410 along a fold 411. Interior panels 414 and 416 are joined along a fold 417 and to the bottom panel 410 and the top panel 412 by a glue strip 417 which joins the folds 411 and 415. At least one of the free edges 419 of the booklet 401 is disposed substantially immediately adjacent the proximate edge of the tab member 420. Preferably, a gap I is provided between the adhesive patch 404 and the adhesive 406 of the tab member 420. Preferably, the gap I is at least 1/8 inch, and more preferably, between about 3/16 inch and 1/4 inch. The label 400 may be formed using any of the foregoing methods.

With reference to **Figure 14**, a label 500 according to a further embodiment is shown therein on a release liner 502. The label 500 includes a booklet 501 corresponding to the booklet 401 except that each of the panels of the booklet 501 includes a portion 518A overlapping the tab member 520. Preferably, the portions 518A overlap the tab member 520 a distance V of at least 1/8 inch, and more preferably, between about 3/16 inch and 1/4 inch. The label 500 may be formed using any of the foregoing methods and apparatus.

With reference to **Figure 15**, a label 600 according to a further embodiment is shown therein mounted on a release liner 602. The label 600 includes a booklet 601 corresponding to the booklet 401. The booklet 601 and the tab member 620 are spaced apart to form a gap G, preferably having the preferred dimensions of the gap G as described with reference to **Figure 1**. An adhesive deadener 635 corresponding to the adhesive deadener 335 is applied to the undersurface of the laminate adhesive 632 underlying the portion 630D of the laminate cover 630. The label 600 may be formed in the same manner as the label 300.

With reference to **Figure 16**, a label 700 according to a further embodiment is shown therein mounted on a release liner 702. The label 700 includes a leaflet 701 corresponding to the leaflet 101 except that the top panel 712 includes an extended flap 718A which extends across both a gap G (preferably having the preferred dimensions as described for the gap G with reference to **Figure 1**) and the tab member 720. An adhesive layer 708 releasably secures the extended flap 718A to the release varnish 722. Alternatively (not shown), the tab member 720 may be formed of a material which releasably and resealably engages the adhesive layer 708, in

which case the varnish coating is omitted. The laminate cover **730** is substantially permanently secured to the entirety of the top panel **712** by the laminate adhesive **732**.

The label **700** may be formed using any of the foregoing methods and apparatus except that a further adhesive applicator applies adhesive to the upper surface of the tab member **720** (onto the varnish **722**) prior to the placement of the leaflet thereon. The adhesive applicator is preferably a flexographic printer as described above with regard to the printer **159**.

With reference to **Figure 17**, a label **800** according to a further embodiment is shown therein mounted on a release liner **802**. The label **800** includes a leaflet **801** and corresponds to the label **400** except that the adhesive gap **I** (see **Figure 13**) is omitted. Rather, a continuous and common adhesive layer **808** secures both the bottom panel **810** and the tab member **820** to the release liner **802**. The label **500** (**Figure 14**) may be similarly modified.

With reference to **Figure 18**, a label **900** according to a further embodiment is shown therein mounted on a release liner **902**. The label **900** corresponds to the leaflet **100** except that the label **900** further includes a second tab member **926** on the side of the leaflet **901** opposite the first tab member **920**. The tab member **926** is releasably secured to the release liner **902** by an adhesive patch **909**. A portion **930C** of the laminate cover **930** is substantially permanently secured to the upper surface of the tab member **926** by the laminate adhesive **932**. The fold **911** of the leaflet **901** is disposed substantially immediately adjacent the proximate edge of the tab member **926**.

With reference to **Figure 19**, a label **1000** according to a further embodiment is shown therein mounted on a release liner **1002**. The label **1000** corresponds to the label **900** except that the second tab member **1026** thereof underlaps the leaflet **1001**. Also, the tab member **1026** and the bottom panel **1010** are releasably secured to the release liner **1002** by a continuous and common adhesive patch **1007**. Preferably, the tab member **1026** underlaps the leaflet **1001** a distance **W** of at least 1/8 inch, and more preferably, between about 3/16 inch and 1/4 inch.

With reference to **Figure 20**, a label **1100** is shown therein on a release liner **1102**. The label **1100** corresponds to the label **900** except that the second tab member **1126** thereof is spaced apart from the leaflet **1101**. Preferably, a gap **G2** of at least 1/8 inch, and more preferably, between about 3/16 inch and 1/4 inch, is defined

between the fold **1111** of the leaflet **1101** and the proximate edge of the tab member **1126**.

Each of the foregoing labels may be modified to include a substantially immediately adjacent, underlapping or spaced apart second tab member as described with regard to the labels **900, 1000, 1100**. Suitable modifications to the above-described methods and apparatus for forming the labels **900, 1000, 1100** and such modified labels will be apparent to the those of ordinary skill in the art upon reading the description herein.

With reference to **Figure 21**, a label **1200** according to a further embodiment is shown therein mounted on a release liner **1202**. The label **1200** corresponds to the label **100** except as follows. The leaflet **1201** includes a bottom panel **1210** joined to a top panel **1212** along a fold **1211**. An interior panel **1214** is joined to the top panel **1212** along a fold line **1213** opposite the fold **1211**. The bottom panel **1210** has an end edge **1219** opposite the fold **1211**. The end edge **1219** is positioned substantially immediately adjacent the proximate edge of the tab member **1220**. Optionally, a dot, series of dots, or strip of adhesive **1203** is provided between the interior panel **1214** and the bottom panel **1210** to prevent undesirable movement between the leaflet panels as the label is applied to a container. The leaflet **1201** is economical and convenient to form.

With reference to **Figure 22**, a label **1300** according to a further embodiment is shown therein mounted on a release liner **1302**. The label **1300** corresponds to the label **1200** except as follows. The leaflet **1301** includes a bottom panel **1310** joined to a top panel **1312** along a fold **1311**, and an interior panel **1314** joined to the top panel **1312** along a fold **1313**. Additionally, an abbreviated auxilliary top panel **1316** is joined to the bottom panel **1310** along a fold **1315** opposite the fold **1311**. Preferably, the panel **1316** has a length **P** of at least 5/8 inch, and more preferably, of between about 3/4 inch and 1 inch. The laminate cover **1330** is substantially permanently adhered to the upper surfaces of the top panel **1312** and the auxiliary top panel **1316**. As shown, the tab member **1320** is disposed substantially immediately adjacent the fold **1315**. Alternatively (not shown), the tab member **1320** may underlap or be spaced apart from the leaflet **1301** as described with regard to the labels **500 (Figure 14)** and **300 (Figure 12)**. The laminate cover portion **1330B** is permanently adhered to the tab member **1320** (the varnish coating is omitted in this embodiment). A pair of parallel, spaced apart tear lines **1303A** formed through the laminate cover **1330** and

the top panel **1312** extend fully across the width of the label **1300** and define a tear strip **1303** therebetween and adjacent the fold **1311**. The leaflet **1301** may be accessed by removing the tear strip **1303**.

Optionally, each of the foregoing labels may be modified as follows to facilitate opening. The tab member may be back diecut through to the laminate cover to form a corner pull tab which is preferably fully severed from the remainder of the tab member by the cut line. The tab adhesive underlying the corner pull tab is deadened.

The foregoing is illustrative of the present invention and is not to be construed as limiting thereof. Although a few exemplary embodiments of this invention have been described, those skilled in the art will readily appreciate that many modifications are possible in the exemplary embodiments without materially departing from the novel teachings and advantages of this invention. Accordingly, all such modifications are intended to be included within the scope of this invention as defined in the claims. In the claims, means-plus-function clauses are intended to cover the structures described herein as performing the recited function and not only structural equivalents but also equivalent structures. Therefore, it is to be understood that the foregoing is illustrative of the present invention and is not to be construed as limited to the specific embodiments disclosed, and that modifications to the disclosed embodiments, as well as other embodiments, are intended to be included within the scope of the appended claims. The invention is defined by the following claims, with equivalents of the claims to be included therein.

What is Claimed is:

1. A label assembly comprising:

a) a release liner;

b) a leaflet including a top panel and a bottom panel connected to said top panel;

c) a tab member disposed adjacent but not forming a part of said leaflet, said tab member having an upper surface;

d) a tab adhesive releasably adhering said tab member to said release liner;

e) a laminate cover including a first portion overlying said top panel and a second portion overlying said tab member;

f) a laminate adhesive releasably and resealably adhering said second portion of said laminate cover to said upper surface of said tab member.

2. The label assembly of Claim 1 including a leaflet adhesive directly and releasably adhering said bottom panel of said leaflet to said release liner.

3. The label assembly of Claim 1 including a release varnish coating said upper surface of said tab member, wherein said laminate adhesive releasably and resealably engages said varnish coating.

4. The label assembly of Claim 1 wherein said tab member is formed of a material which releasably and resealably engages said laminate adhesive.

5. The label assembly of Claim 1 wherein said laminate cover includes a third portion extending beyond an edge of said leaflet opposite said tab member, wherein said third portion is directly and releasably adhered to said release liner by said laminate adhesive.

6. The label assembly of Claim 1 wherein said tab member is disposed substantially immediately adjacent said leaflet.

7. The label assembly of Claim 1 wherein said tab member is spaced apart from said leaflet.

8. The label assembly of Claim 7 wherein said laminate cover includes a third portion extending between said leaflet and said tab member, said third portion coated on its underside by a deadened adhesive.

9. The label assembly of Claim 1 wherein said tab member includes a portion underlying said leaflet.

10. The label assembly of Claim 9 wherein said top panel includes an extended flap extending beyond said bottom panel and said portion of said tab member underlies said extended flap.

11. The label assembly of Claim 1 wherein said leaflet comprises a booklet.

12. The label assembly of Claim 1 wherein said tab adhesive and said leaflet adhesive form a common adhesive patch.

13. The label assembly of Claim 1 wherein said laminate cover includes a third portion extending beyond an edge of said leaflet opposite said tab member, said label further including:

a second tab member underlying said third portion, said second tab member having an upper surface; and

a second tab adhesive releasably adhering said second tab member to said release liner;

wherein said third portion is adhered to said upper surface of said second tab member by said laminate adhesive.

14. The label assembly of Claim 13 wherein said second tab member is disposed substantially immediately adjacent said leaflet.

15. The label assembly of Claim 13 wherein said second tab member is spaced apart from said leaflet.

16. The label assembly of Claim 13 wherein said second tab member includes a portion underlying said leaflet.

17. The label assembly of Claim 1 wherein:

said leaflet includes an interior panel disposed between said top and bottom panels and connected to said top panel along a first fold adjacent said tab member; and

said bottom panel is connected to said top panel along a second fold opposite said first fold.

18. A label assembly comprising:

a) a release liner;

b) a leaflet including a top panel and a bottom panel connected to said top panel;

c) a leaflet adhesive directly and releasably adhering said bottom panel to said release liner;

d) a tab member disposed adjacent but not forming a part of said leaflet, said tab member having an upper surface;

e) a tab adhesive releasably adhering said tab member to said release liner;

f) a laminate cover including a first portion overlying said top panel and a second portion overlying said tab member;

g) a laminate adhesive adhering said second portion of said laminate cover to said upper surface of said tab member.

19. The label assembly of Claim 18 wherein said laminate cover includes a third portion extending beyond an edge of said leaflet opposite said tab member, wherein said third portion is directly and releasably adhered to said release liner by said laminate adhesive.

20. The label assembly of Claim 18 wherein said tab member is disposed substantially immediately adjacent said leaflet.

21. The label assembly of Claim 18 wherein said tab member is spaced apart from said leaflet.

22. The label assembly of Claim 21 wherein said laminate cover includes a third portion extending between said leaflet and said tab member, said third portion coated on its underside by a deadened adhesive.

23. The label assembly of Claim 18 wherein said tab member includes a portion underlying said leaflet.

24. The label assembly of Claim 23 wherein said top panel includes an extended flap extending beyond said bottom panel and said portion of said tab member underlies said extended flap.

25. The label assembly of Claim 18 wherein said leaflet comprises a booklet.

26. The label assembly of Claim 18 wherein said tab adhesive and said leaflet adhesive form a common adhesive patch.

27. The label assembly of Claim 18 wherein said laminate cover includes a third portion extending beyond an edge of said leaflet opposite said tab member, said label further including:

a second tab member underlying said third portion, said second tab member having an upper surface; and

a second tab adhesive releasably adhering said second tab member to said release liner;

wherein said third portion is adhered to said upper surface of said second tab member by said laminate adhesive.

28. The label assembly of Claim 27 wherein said second tab member is disposed substantially immediately adjacent said leaflet.

29. The label assembly of Claim 27 wherein said second tab member is spaced apart from said leaflet.

30. The label assembly of Claim 27 wherein said second tab member includes a portion underlying said leaflet.

31. The label assembly of Claim 18 wherein:

said leaflet includes an interior panel disposed between said top and bottom panels and connected to said top panel along a first fold adjacent said tab member; and

said bottom panel is connected to said top panel along a second fold opposite said first fold.

32. A label assembly comprising:

a) a release liner;

b) a leaflet including a top panel and a bottom panel connected to said top panel, said top panel including an extended flap extending beyond said bottom panel;

c) a tab member disposed adjacent but not forming a part of said leaflet, said tab member having an upper surface, said tab member and said leaflet relatively disposed such that said extended flap overlies said tab member;

d) a tab adhesive releasably adhering said tab member to said release liner;

e) a laminate cover including a first portion overlying said top panel and a second portion overlying said extended flap;

f) an extended flap adhesive adhering said extended flap to said upper surface of said tab member.

33. The label assembly of Claim 32 wherein said extended flap adhesive releasably and resealably adheres said extended flap to said upper surface of said tab member.

34. The label assembly of Claim 33 including a release varnish coating said upper surface of said tab member, wherein said extended flap adhesive releasably and resealably engages said varnish coating.

35. The label assembly of Claim 1 wherein said tab member is formed of a material which releasably and resealably engages said extended flab adhesive.

36. The label assembly of Claim 32 including a leaflet adhesive directly and releasably adhering said bottom panel of said leaflet to said release liner.

37. The label assembly of Claim 32 wherein said laminate cover includes a third portion extending beyond an edge of said leaflet opposite said tab member, wherein said third portion is directly and releasably adhered to said release liner by said laminate adhesive.

38. The label assembly of Claim 32 wherein said laminate cover includes a third portion extending beyond an edge of said leaflet opposite said tab member, said label further including:

a second tab member underlying said third portion, said second tab member having an upper surface; and

a second tab adhesive releasably adhering said second tab member to said release liner;

wherein said third portion is adhered to said upper surface of said second tab member by said laminate adhesive.

39. The label assembly of Claim 38 wherein said second tab member is disposed substantially immediately adjacent said leaflet.

40. The label assembly of Claim 38 wherein said second tab member is spaced apart from said leaflet.

41. The label assembly of Claim 38 wherein said second tab member includes a portion underlying said leaflet.

42. A label assembly comprising:

a) a release liner;

b) a leaflet including a top panel, a bottom panel connected to said top panel, and an auxiliary top panel connected to said bottom panel along a fold, said auxiliary top panel overlying only a part of said top panel;

c) a tab member disposed adjacent but not forming a part of said leaflet, said tab member having an upper surface and being disposed adjacent said fold connecting said bottom panel and said auxiliary top panel;

d) a tab adhesive releasably adhering said tab member to said release liner;

e) a laminate cover including a first portion overlying said top panel and a second portion overlying said tab member; and

f) a laminate adhesive adhering said second portion to said upper surface of said tab member.

43. The label assembly of Claim 42 including a tear line formed in said laminate cover and said top panel adjacent an end of said leaflet opposite said fold between said bottom panel and auxiliary top panel.

44. The label assembly of Claim 42 including a leaflet adhesive directly and releasably adhering said bottom panel of said leaflet to said release liner.

45. The label assembly of Claim 42 wherein said laminate cover includes a third portion extending beyond an edge of said leaflet opposite said tab member, wherein said third portion is directly and releasably adhered to said release liner by said laminate adhesive.

46. The label assembly of Claim 42 wherein said laminate cover includes a third portion extending beyond an edge of said leaflet opposite said tab member, said label further including:

a second tab member underlying said third portion, said second tab member having an upper surface;

a second tab adhesive releasably adhering said second tab member to said release liner;

wherein said third portion is adhered to said upper surface of said second tab member by said laminate adhesive.

47. The label assembly of Claim 46 wherein said second tab member is disposed substantially immediately adjacent said leaflet.

48. The label assembly of Claim 46 wherein said second tab member is spaced apart from said leaflet.

49. The label assembly of Claim 46 wherein said second tab member includes a portion underlying said leaflet.

50. A method for forming a label, said method comprising the steps of:

forming a tab member releasably adhered to a release liner; and

adhering a leaflet directly to the release liner adjacent the tab member.

51. The method of Claim 50 including the steps of:

applying a self-adhesive laminate web over the leaflet and the tab member; and

diecutting the laminate web to form the label, the label including a laminate cover formed from the laminate web.

52. The method of Claim 51 including the step of applying an adhesive deadener to the adhesive of the laminate web prior to said step of applying the laminate web over the leaflet.

53. The method of Claim 50 including the step of applying a varnish coating to the tab member.

54. The method of Claim 50 comprising the steps of:

providing a composite web including the release liner and a self-adhesive stock web;

diecutting the stock web to form the tab member therein;

removing a waste matrix including portions of the stock web not forming a part of the tab member such that the tab member remains adhered to the release liner;

applying a patch of adhesive directly to the release liner at a location adjacent the tab member; and

applying the leaflet to the adhesive patch such that the leaflet is directly adhered to the release liner by the adhesive patch.

55. The method of Claim 54 including the steps of:

applying a self-adhesive laminate web over the leaflet and the tab member; and

diecutting the laminate web to form the label, the label including a laminate cover formed from the laminate web.

56. The method of Claim 50 comprising the steps of:

providing the release liner;

applying a first patch of adhesive to the release liner;

marrying a non-adhesive stock web to the release liner and the first patch of adhesive;

diecutting the stock web to form the tab member therein, the tab member overlying and adhered to the release liner by at least a portion of the first adhesive patch disposed between the tab member and the release liner;

removing a waste matrix including portions of the stock web not forming a part of the tab member;

applying a second patch of adhesive directly to the release liner at a location adjacent the tab member; and

applying the leaflet to the second adhesive patch such that the leaflet is directly adhered to the release liner by the second adhesive patch.

57. The method of Claim 56 including the steps of:

applying a self-adhesive laminate web over the leaflet and the tab member; and

diecutting the laminate web to form the label, the label including a laminate cover formed from the laminate web.

58. The method of Claim 50 comprising the steps of:

providing a release liner;

providing a self-adhesive stock web;

forming a hole in the stock web;

marrying the stock web to the release liner;

applying a patch of adhesive directly to the release liner at a location which, after the stock web is married to the release liner, is within the hole in the stock web;

applying the leaflet to the adhesive patch such that the leaflet is directly adhered to the release liner by the adhesive patch;

diecutting the stock web to form the tab member adjacent the adhesive patch; and

removing a waste matrix including portions of the stock web not forming a part of the tab member.

59. The method of Claim 58 including the steps of:

applying a self-adhesive laminate web over the leaflet and the stock web or the tab member; and

diecutting the laminate web to form the label, the label including a laminate cover formed from the laminate web.

60. The method of Claim 50 comprising the steps of:

providing a release liner;

applying a patch of adhesive directly to the release liner;

providing a non-adhesive stock web;

forming a hole in the stock web;

marrying the stock web to the release liner such that a first portion of the adhesive patch is disposed in the hole and a second portion of the adhesive patch is covered by the stock web adjacent the hole;

applying the leaflet to the adhesive patch such that the leaflet is directly adhered to the release liner by at least a portion of the first adhesive portion;

diecutting the stock web to form the tab member adjacent the adhesive patch, the tab member being adhered to the release liner by at least a portion of the second adhesive portion; and

removing a waste matrix including portions of the stock web not forming a part of the tab member.

61. The method of Claim 60 including the steps of:

applying a self-adhesive laminate web over the leaflet and the stock web or the tab member; and

diecutting the laminate web to form the label, the label including a laminate cover formed from the laminate web.

62. The method of Claim 50 comprising the steps of:

providing a release liner;

applying a first patch of adhesive to the release liner;

applying the tab member to the first adhesive patch;

applying a second patch of adhesive directly to the release liner at a location which, after the tab member is applied to the first adhesive patch, is disposed adjacent the tab member; and

applying the leaflet to the second adhesive patch such that the leaflet is directly adhered to the release liner by the second adhesive patch.

63. The method of Claim 62 including the steps of:

applying a self-adhesive laminate web over the leaflet and the tab member; and

diecutting the laminate web to form the label, the label including a laminate cover formed from the laminate web.

64. The method of Claim 50 comprising the steps of:

providing a release liner;

applying a self-adhesive tab member to the release liner;

applying a patch of adhesive directly to the release liner at a location which, after the tab member is applied to the release liner, is disposed adjacent the tab member; and

applying the leaflet to the second adhesive patch such that the leaflet is directly adhered to the release liner by the adhesive patch.

65. The method of Claim 64 including the steps of:

applying a self-adhesive laminate web over the leaflet and the tab member; and

diecutting the laminate web to form the label, the label including a laminate cover formed from the laminate web.

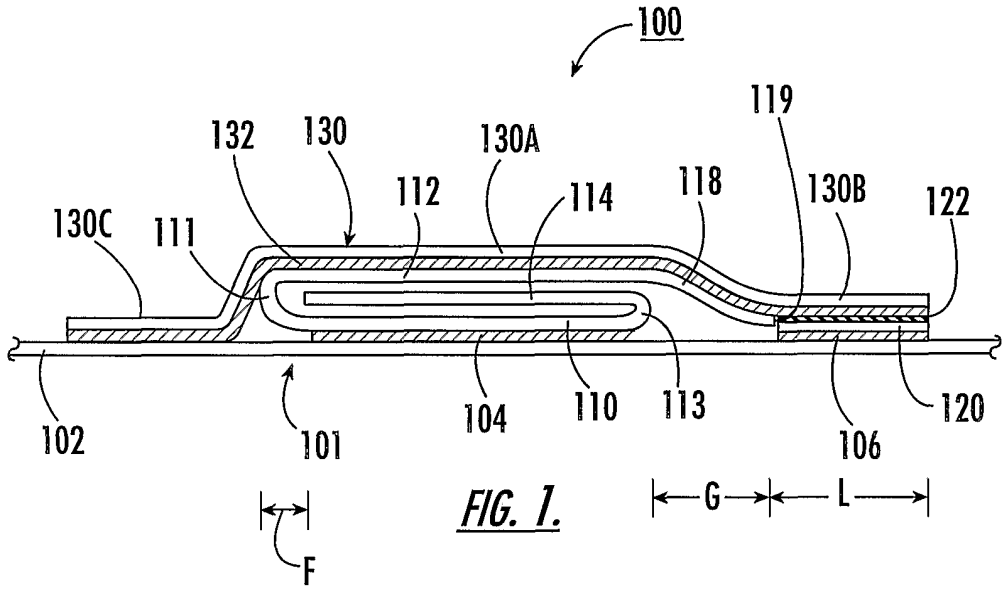

100
119
132
130
130A
112
114
118
130B
122
130C
111
102
101
104
110
113
106
120
F
G
L

FIG. 1.

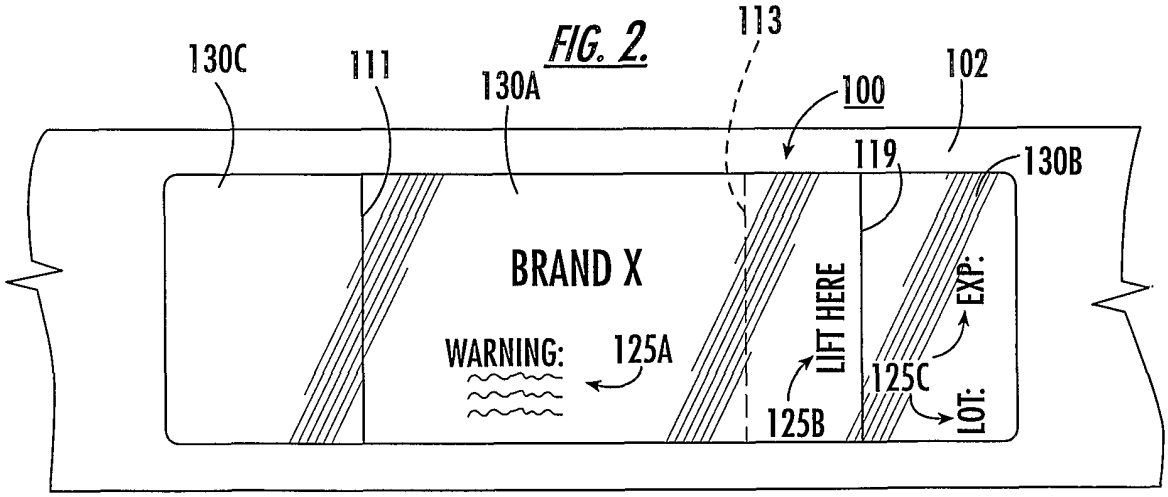

113
130C
111
130A
100
102
119
130B
BRAND X
WARNING:
125A
LIFT HERE
EXP:
125C
125B
LOT:

FIG. 2.

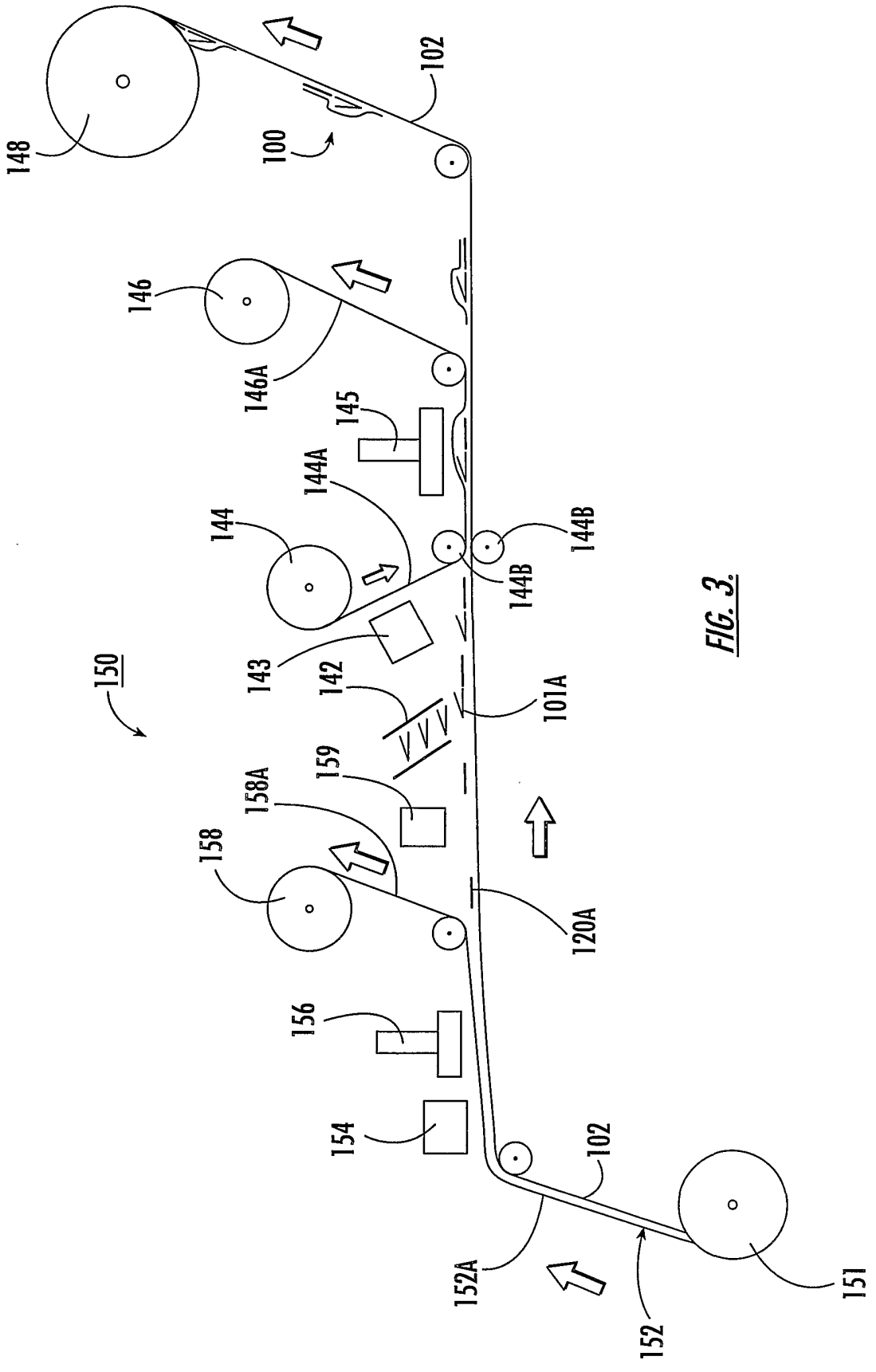

148
100
102
146
146A
145
144A
144
144B
144B
143
142
101A
150
159
158A
158
120A
156
154
102
152A
152
151

FIG. 3.

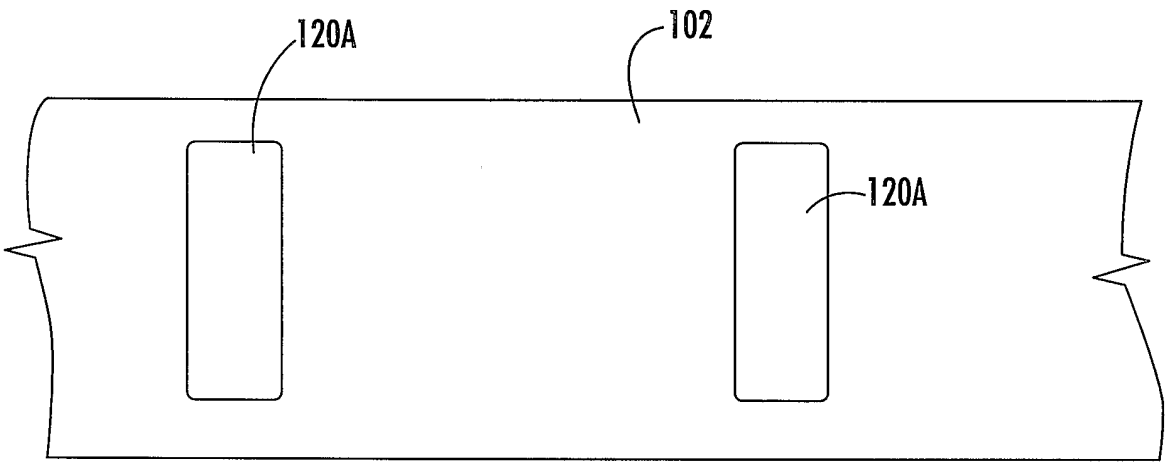


FIG. 4.

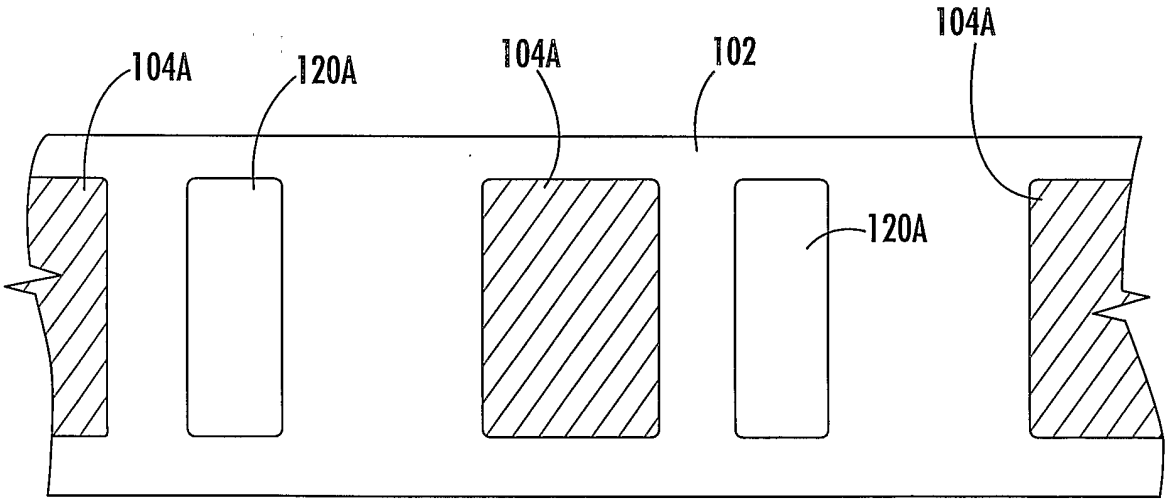


FIG. 5.

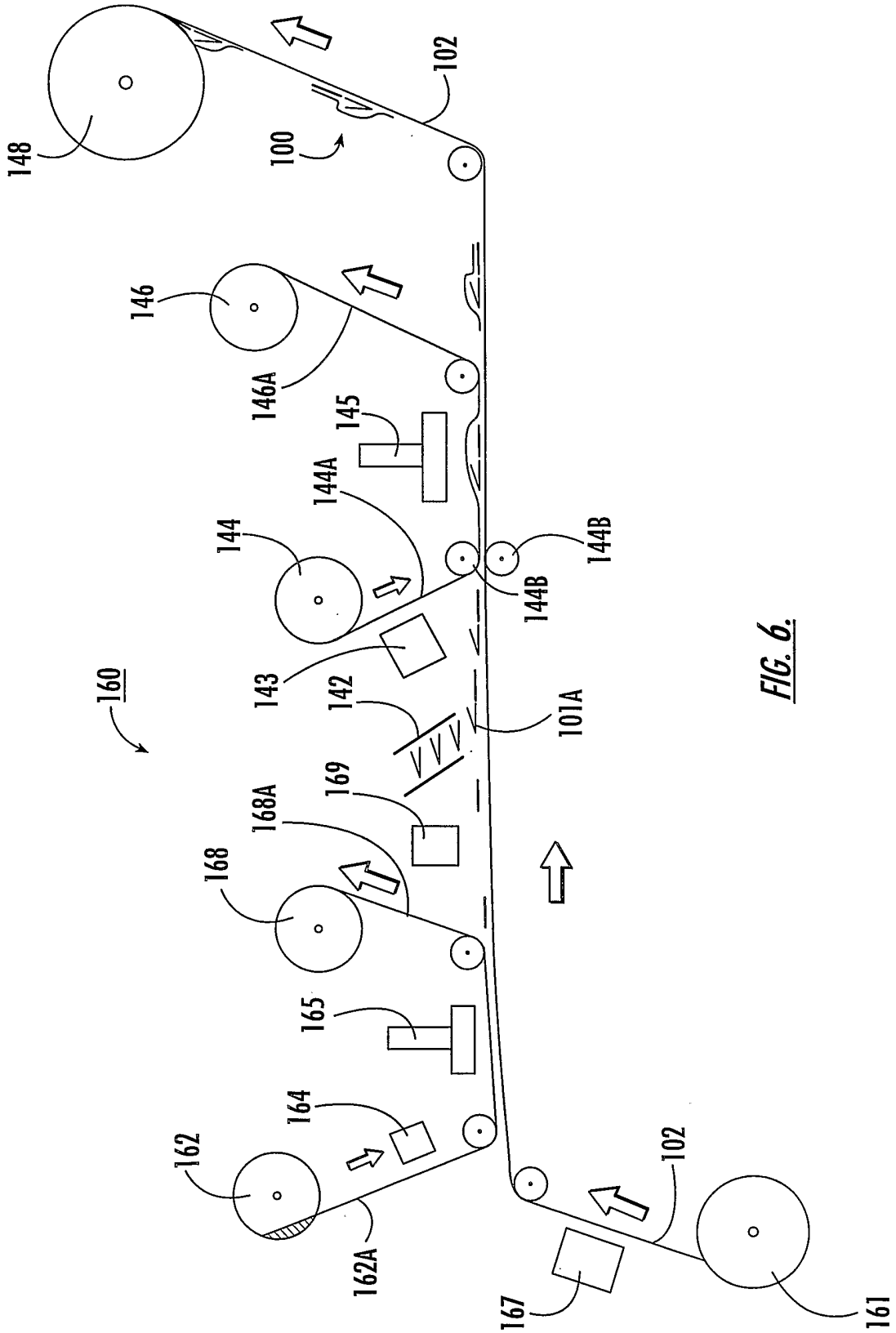

148
100
102
146
146A
145
144A
144
144B
144B
143
142
101A
160
169
168A
168
165
164
162
162A
167
102
161

FIG. 6.

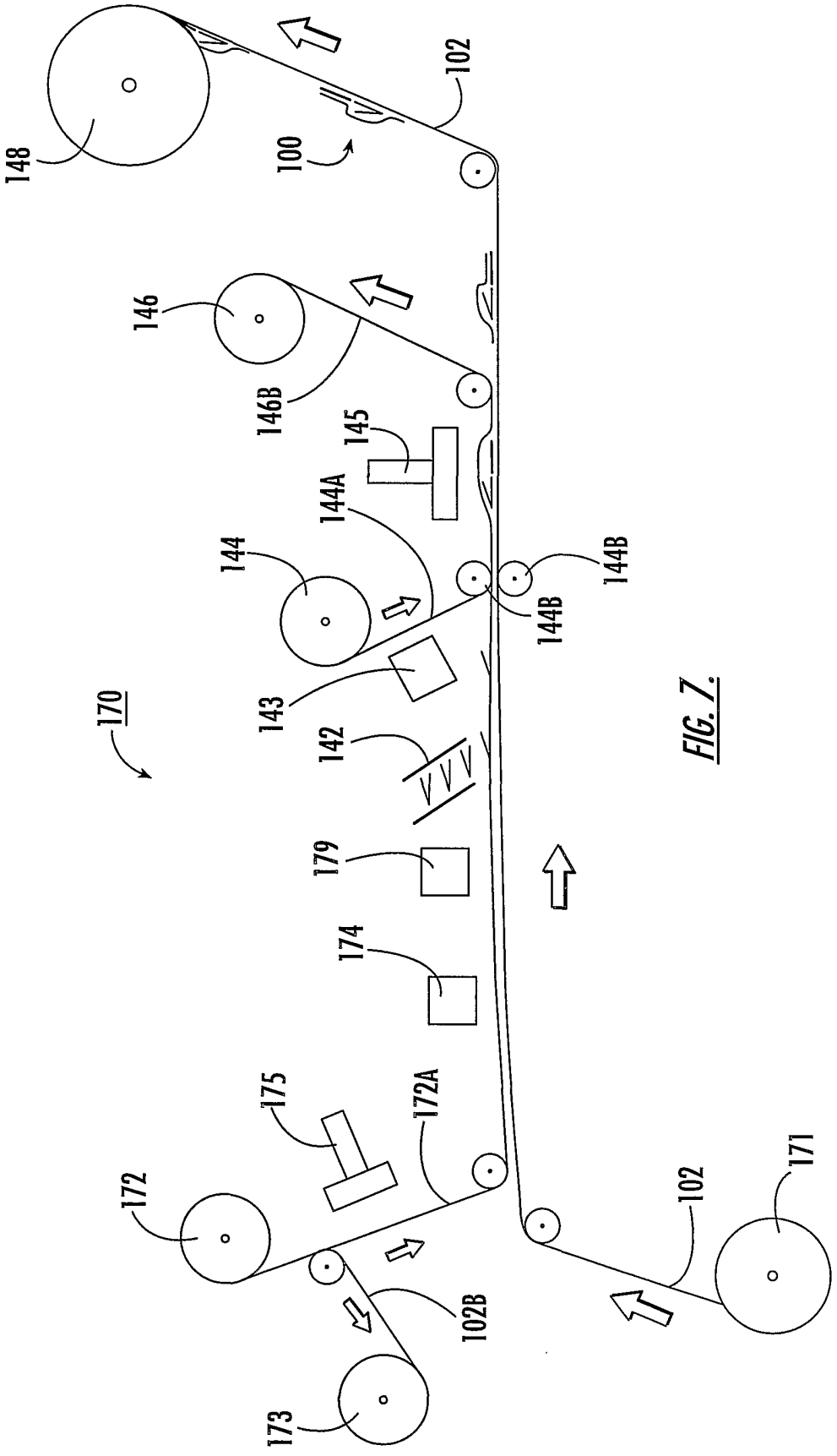

148
100
102
146
146B
145
144A
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144B
144B
143
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179
174
175
172A
172
102B
173
102
171

FIG. 7.

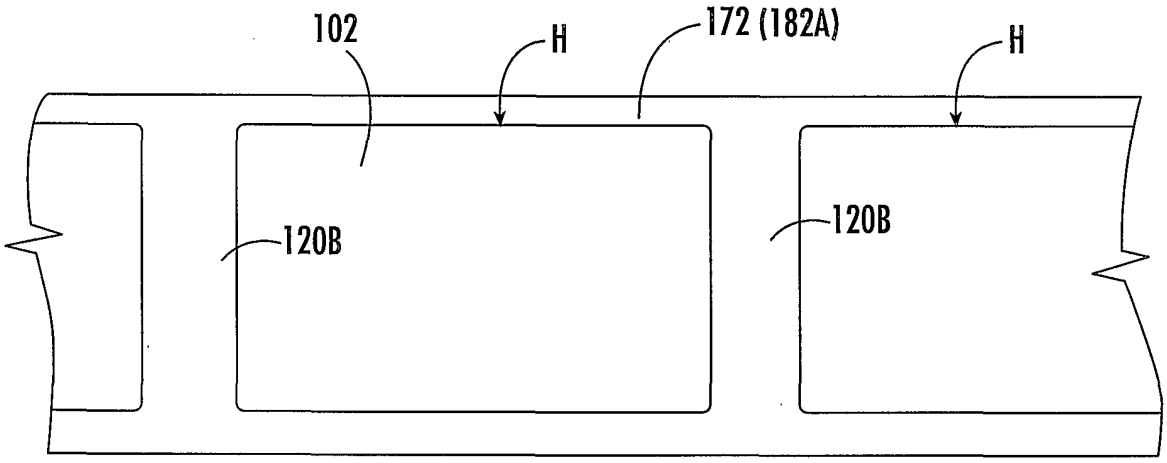


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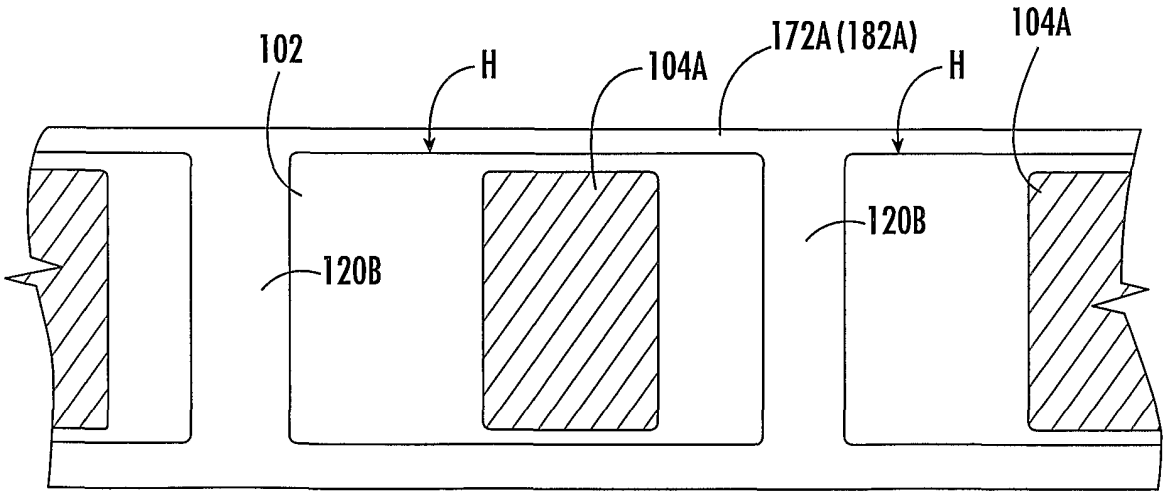


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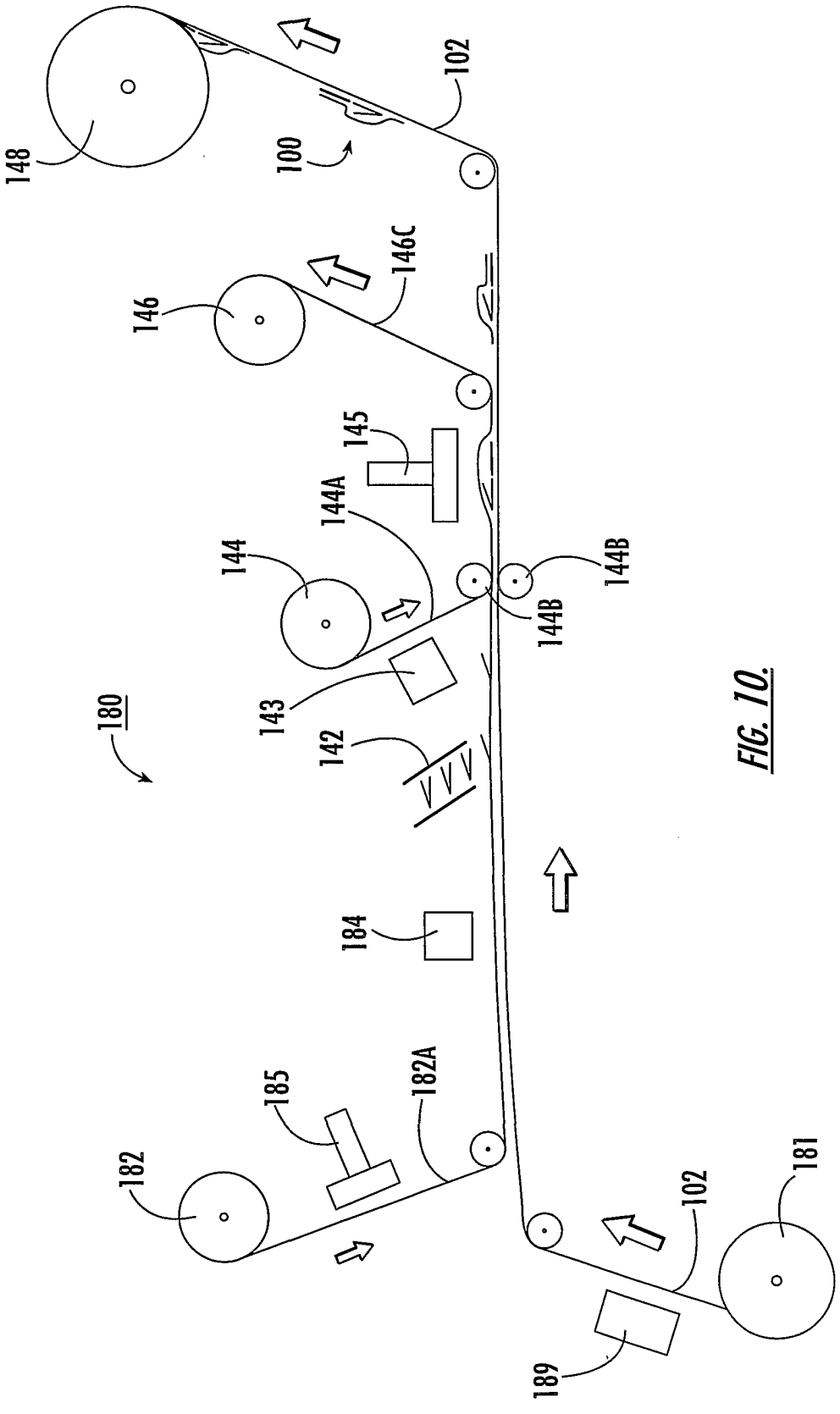

148
100
102
146C
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145
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144B
144B
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184
185
182A
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181
189

FIG. 10.

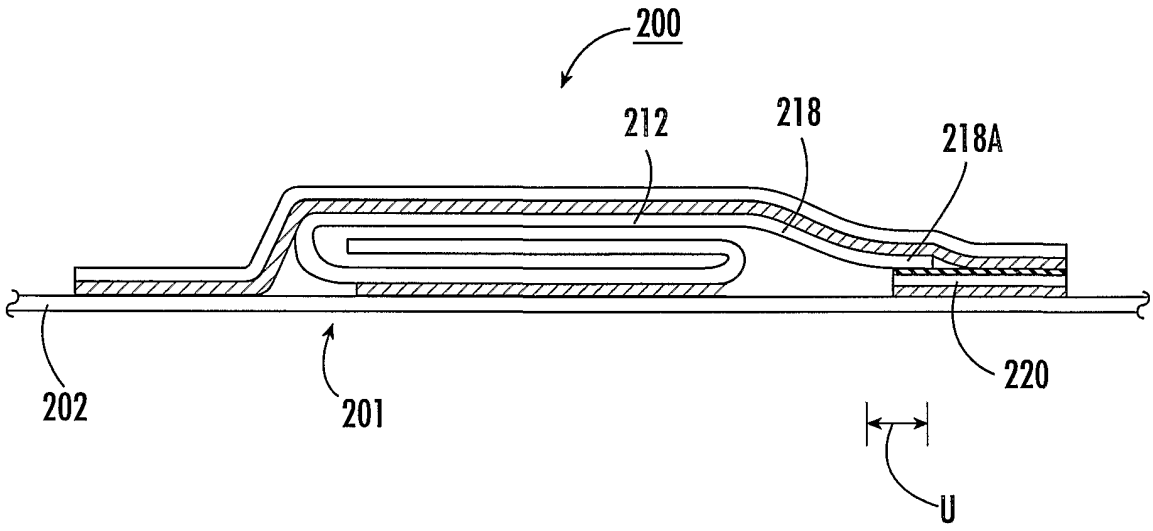


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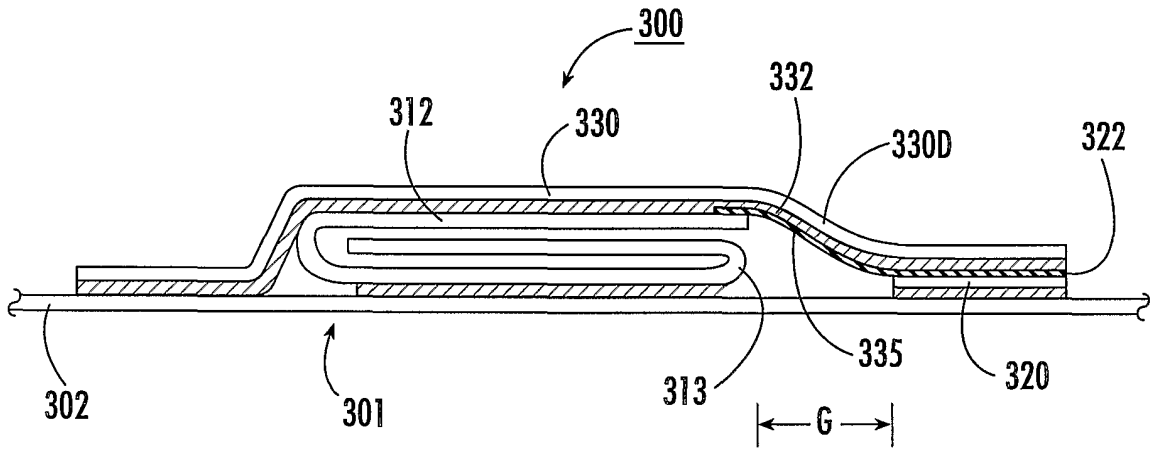


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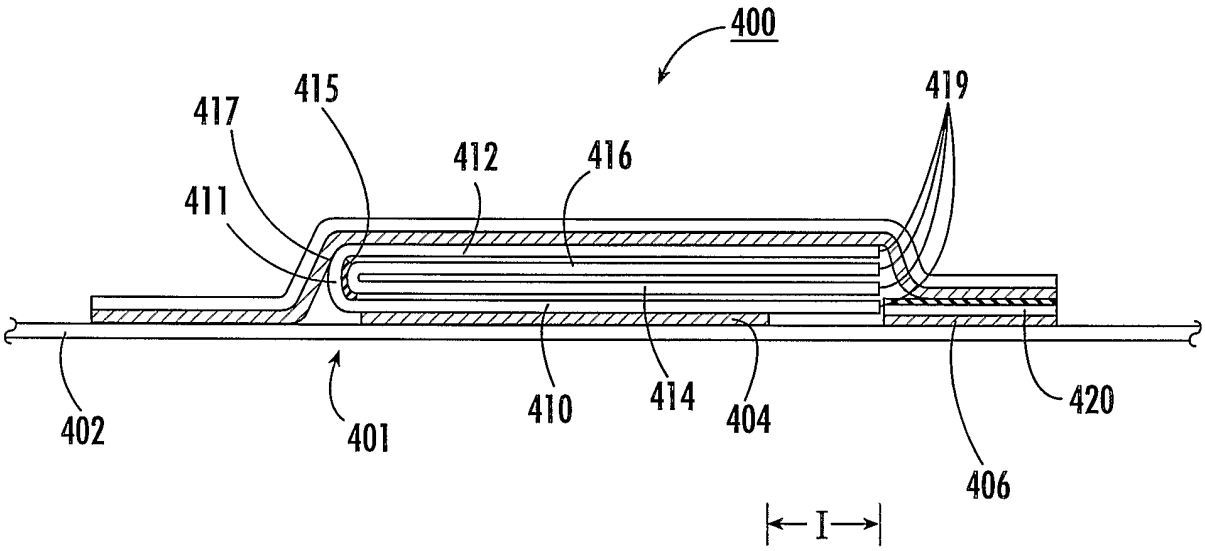


FIG. 13.

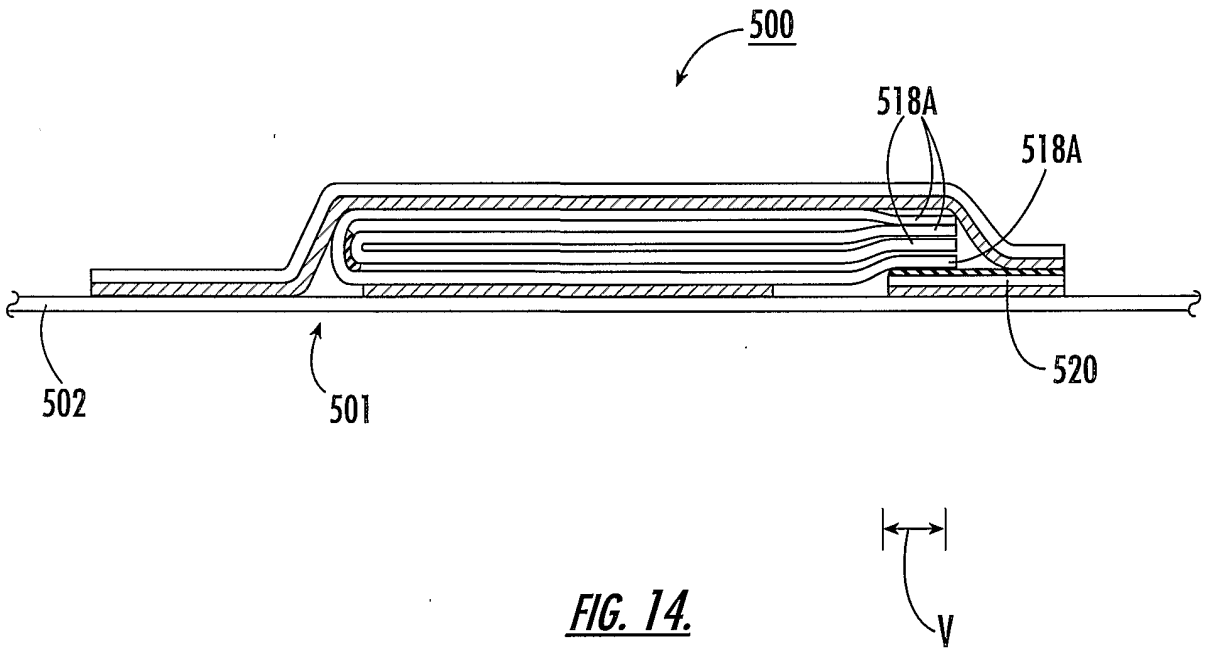


FIG. 14.

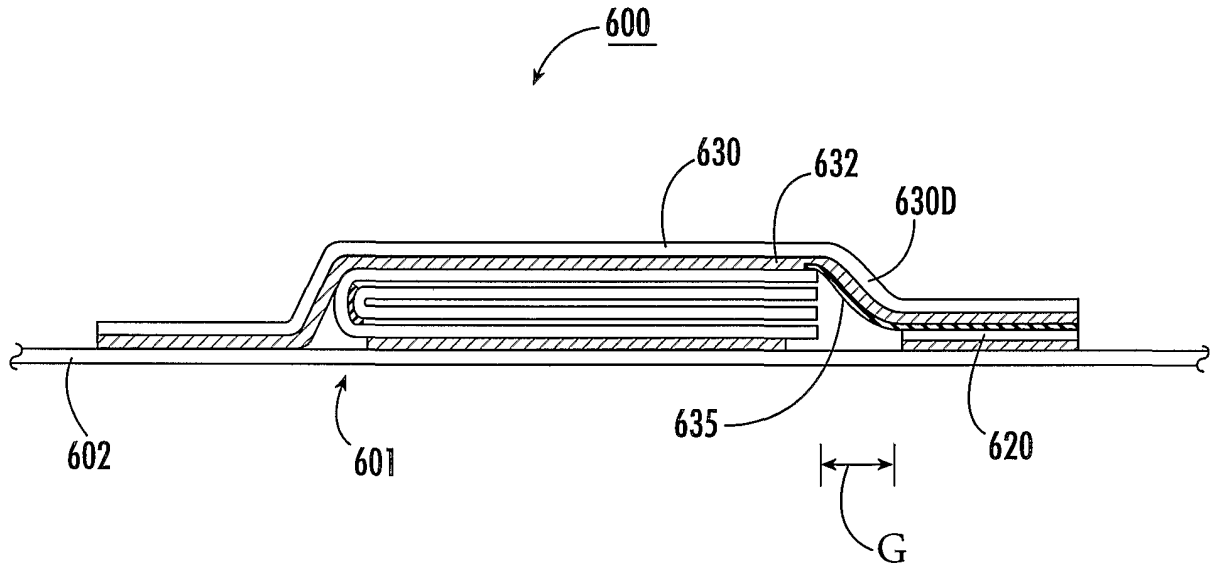


FIG. 15.

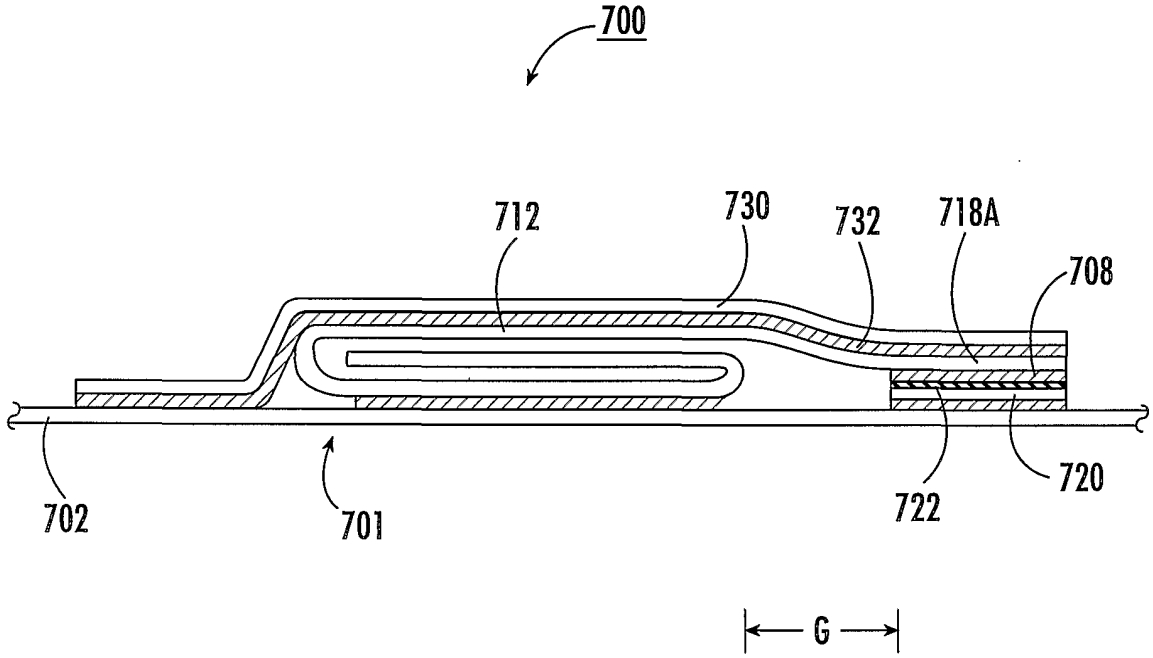


FIG. 16.

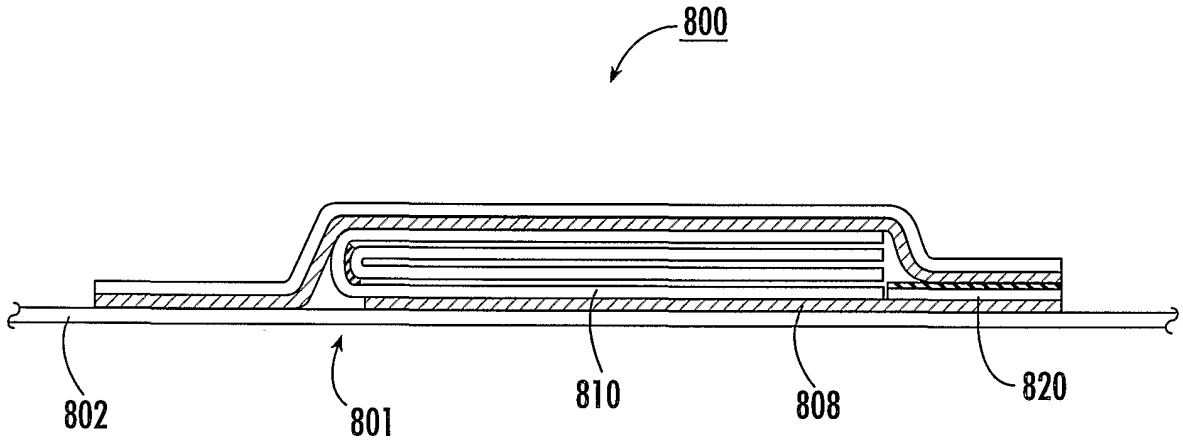


FIG. 17.

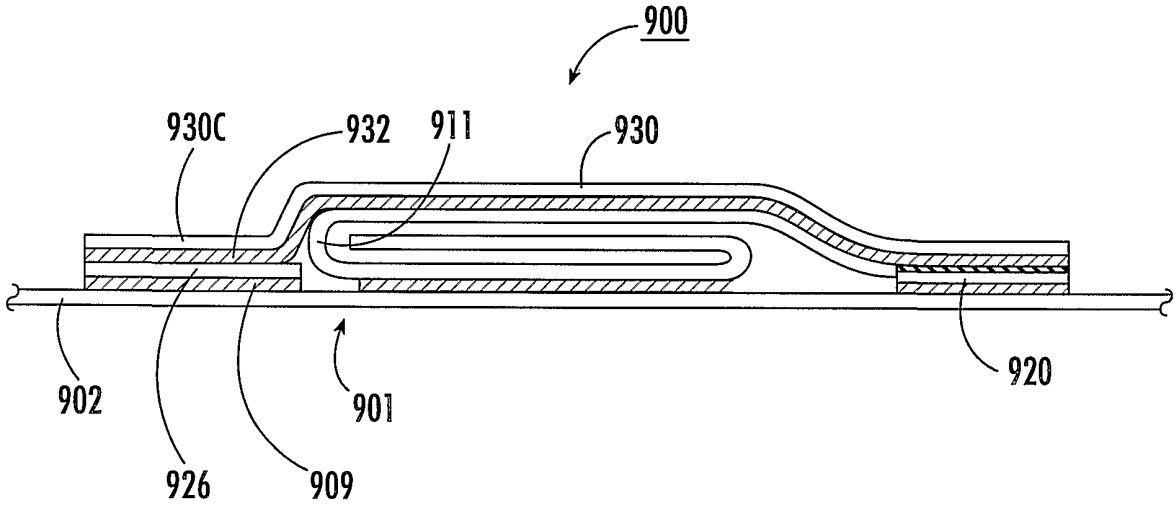


FIG. 18.

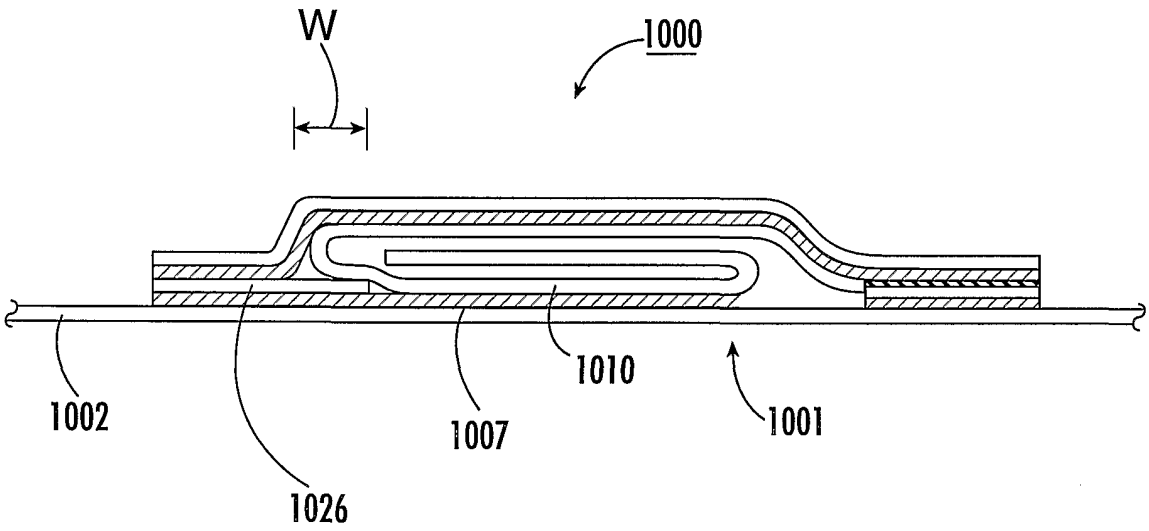


FIG. 19.

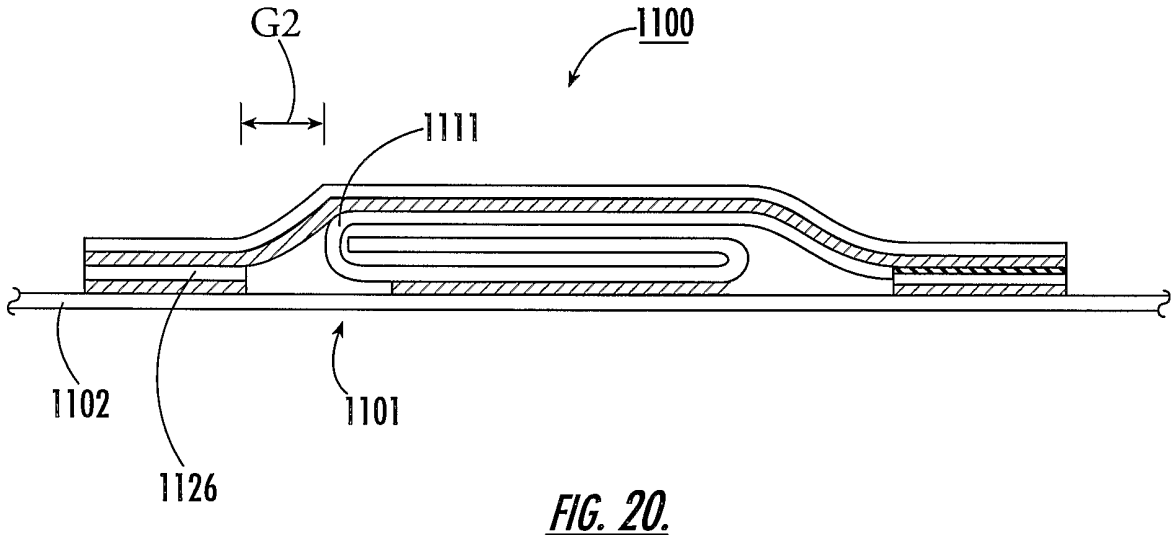


FIG. 20.

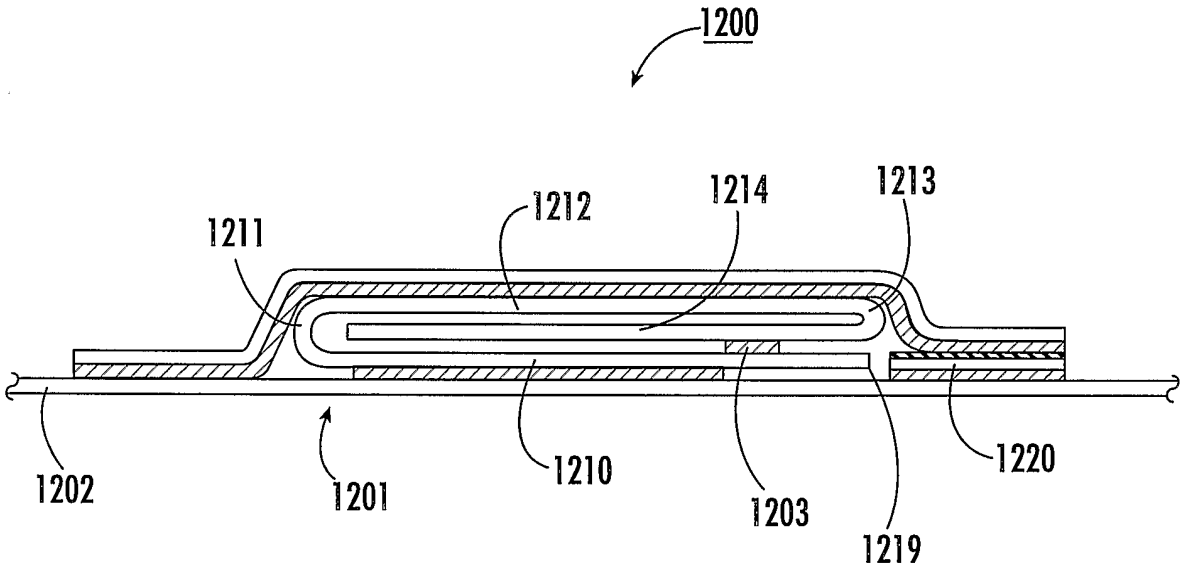


FIG. 21.

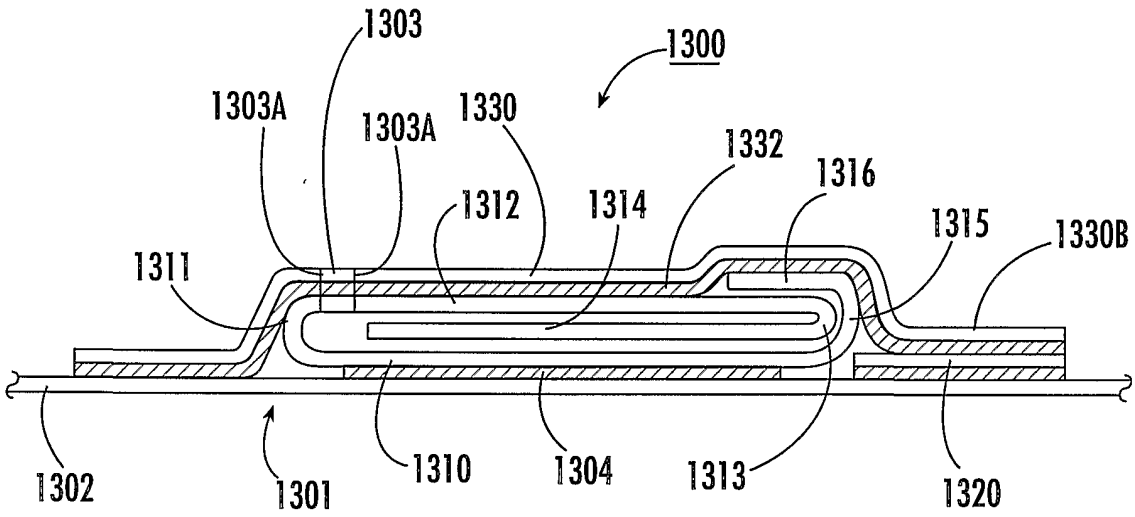
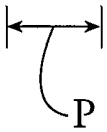

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FIG. 22.


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