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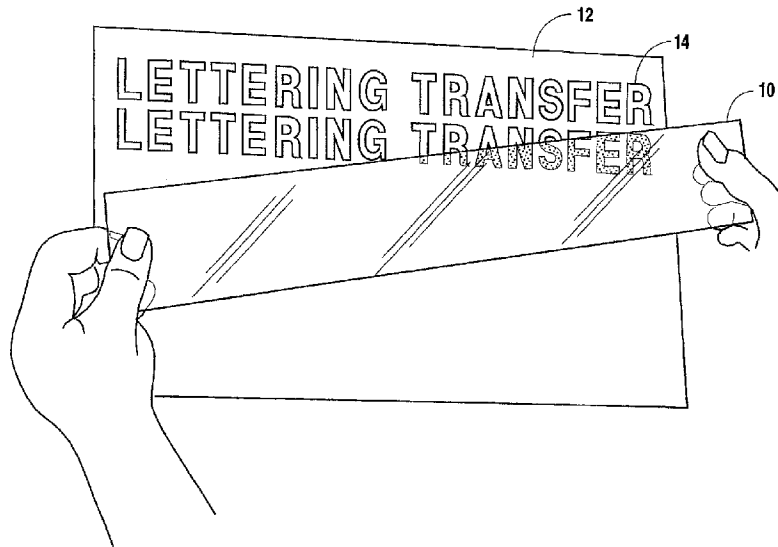
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(30) 1996/01/16 (08/586,229) US

(54) **PROCEDE DE TRANSFERT DE MOTIFS VINYLE D'UNE
MATIERE DE SUPPORT HOTE SUR UN SUBSTRAT**

(54) **A METHOD FOR TRANSFERRING VINYL DESIGNS FROM A
HOST BACKING MATERIAL TO A SUBSTRATE**



(57) L'invention porte sur un procédé permettant de transférer des motifs à légende (14), pourvus de deux cotés, l'un adhésif et l'autre non adhésif, d'un support hôte (12) sur un substrat, en utilisant un seul morceau de feuille de transfert réutilisable (10), pourvue de deux faces, l'une adhésive et l'autre non adhésive. On applique, la face adhésive de la feuille de transfert réutilisable (10) sur le coté non adhésif d'un motif à légende (14), puis l'on procède aux étapes suivantes consistant à enlever le motif à légende (14) ayant adhéré à la feuille de transfert réutilisable (10), du support hôte

(57) A method for transferring signage designs (14) having an adhesive and non-adhesive side from a host backing (12) to a substrate using a single piece of reusable transfer sheet (10) having an adhesive and non-adhesive side whereby the adhesive side of the reusable transfer sheet (10) is applied against the non-adhesive side of a signage design (14) followed by the steps of removing the signage design (14), now adhered to the reusable transfer sheet (10), from the host backing (12), placing the signage design (14) against a substrate by asserting sufficient pressure against the non-adhesive



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(12), à placer le motif à légende (14) sur un substrat en exerçant une pression suffisante sur la face non adhésive de la feuille de transfert réutilisable (10) pour faire en sorte que le coté adhésif du motif à légende (14) adhère au substrat, à ôter la feuille de transfert réutilisable (10) du coté non adhésif du motif à légende (14) ayant adhéré au substrat, et à répéter les étapes de transfert, de positionnement et de collage d'autres motifs à légende en utilisant la même feuille de transfert réutilisable (10).

side of the reusable transfer sheet (10) to ensure that the adhesive side of the signage design (14) adheres to the substrate, removing the reusable transfer sheet (10) from the non-adhesive side of the signage design (14), now adhered to the substrate, and repeating the steps of transfer, placement, and adherence of other signage designs with the same reusable transfer sheet (10).

PCT

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<p>(21) International Application Number: PCT/US97/00665 (22) International Filing Date: 16 January 1997 (16.01.97) (30) Priority Data: 08/586,229 16 January 1996 (16.01.96) US (60) Parent Application or Grant (63) Related by Continuation US 08/586,229 (CIP) Filed on 16 January 1996 (16.01.96) (71)(72) Applicant and Inventor: LINGAMFELTER, Peter, Shaw [US/US]; 629 S. Hill Avenue, New Braunfels, TX 78130 (US). (74) Agent: CHAPMAN, Daniel, D.; Gunn, Lee & Miller, P.C., Suite 1650, 300 Convent Street, San Antonio, TX 78205- 3731 (US).</p>	<p>(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, HU, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, TJ, TM, TR, TT, UA, UG, US, UZ, VN, ARIPO patent (KE, LS, MW, SD, SZ, UG), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).</p> <p>Published <i>With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i></p>	
<p>(54) Title: A METHOD FOR TRANSFERRING VINYL DESIGNS FROM A HOST BACKING MATERIAL TO A SUBSTRATE</p>		
<p>(57) Abstract</p> <p>A method for transferring signage designs (14) having an adhesive and non-adhesive side from a host backing (12) to a substrate using a single piece of reusable transfer sheet (10) having an adhesive and non-adhesive side whereby the adhesive side of the reusable transfer sheet (10) is applied against the non-adhesive side of a signage design (14) followed by the steps of removing the signage design (14), now adhered to the reusable transfer sheet (10), from the host backing (12), placing the signage design (14) against a substrate by asserting sufficient pressure against the non-adhesive side of the reusable transfer sheet (10) to ensure that the adhesive side of the signage design (14) adheres to the substrate, removing the reusable transfer sheet (10) from the non-adhesive side of the signage design (14), now adhered to the substrate, and repeating the steps of transfer, placement, and adherence of other signage designs with the same reusable transfer sheet (10).</p>		

Title: A METHOD FOR TRANSFERRING VINYL DESIGNS FROM A HOST
BACKING MATERIAL TO A SUBSTRATE

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Field of the Invention:

Sign making, more specifically, utilizing a unique method of transferring vinyl sign designs from a host backing to a substrate.

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Background of the Invention:

In the last 15 years or so, the use of vinyl for sign making, especially for designating letters or numbers, has become common. Sheets of vinyl, which are adhered to a protective (typically paper) backing host utilizing an adhesive, are cut into the desired shape and then transferred from their protective backing to a suitable substrate. These vinyl letters and/or numbers or other designs are frequently used on automobiles, planes, billboards, windows, sign substrates, and the like. The letters and/or numbers and/or devices come in various sizes and colors.

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Sign makers transfer the vinyl letters from the paper backing to the substrate through the use of transfer tape. Several companies that provide distribute tape are: Spartan International, Inc., 1845 Cedar Holt, MI 48842; R Tape Corp., #6 Ingersol Road, South Plainfield, NJ 07080; and Vector TM Graphics, 925 Sawmill River Road, Yonkers, NY 10710. The transfer tape comes in a roll and is usually opaque, sometimes non-opaque. The transfer tape is sticky on one side and is flexible. The sign maker removes the transfer tape from its roll and cuts it to a size sufficient to transfer the vinyl letters from their backing to the substrate. The transfer tape is pressed against the precut vinyl design and the pressure-sensitive adhesive picks up the vinyl off its backing. The vinyl designs are then ready to place against the substrate. Pressure against the transfer paper and vinyl applied evenly helps ensure good adhesion of the design to the substrate. Following the transfer, the transfer tape is pulled off the designs and then discarded.

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U.S. Patent No. 4,339,886 (Griffith, et al. 1982) discloses a lettering kit and alignment grid which utilizes the transfer of

a specific font style of letter from a host to an alignment grid with a subsequent use of a transfer sheet to move a number of designs from the alignment grid to a substrate. Griffith does not disclose a method for moving designs from a host backing to a substrate through multiple use of a transfer tape.

Heretofore, the transfer tape has not been capable of multiple transfers in duplicating the process of transferring the designs from the backing to the substrate. That is, heretofore, transfer tape has been "single use". Moreover, transfer tape has, heretofore, been self destructive. By self destructive it is meant that, if one portion of the adhesion side of the transfer tape is to touch another portion of the same side of the transfer tape, subsequent separation typically removes the adhesive layer from one of the two touching portions or destroys its adhesive ability.

Clearly, utility lies in the discovery of a medium to use in place of the heretofore available transfer tape which will allow multiple uses of the same piece of transfer tape for a multiplicity of transfers. Moreover, it is clear that utility will lie in the use of a transfer tape that is non-self destructive -- meaning that, if one adhesive portion of the transfer tape touches another, subsequent separation will not destroy the tackiness and ability of the tape to subsequently transfer vinyl from a protective host backing to a substrate. This "forgiveness" feature, for example, is useful in temporary storage or in the case of accidental contact of adhesive side to adhesive side. Utility also lies in the utilization of a clear transfer tape so as to allow better positioning of the design to the substrate, especially where registration marks or the like are applied to the substrate to assist in positioning. Last, utility lies in the use of a transfer tape that, between transfers, can be placed sticky side down onto a temporary backing medium to protect its adhesive side when not in use, but which may be released and reused for transfers without destroying its tackiness.

Thus, utility is provided in transfer tape that provides sufficient tack (adhesive) capabilities (including tack retention) such that it can be used repeatedly to transfer vinyl letters from a host backing to a substrate. Further utility lies in a transfer

tape sufficiently clear to allow proper positioning of the vinyl letter material to the substrate. Further utility lies in the use of a transfer tape that can be placed against foreign surfaces but which will release and allow re-adhesion to vinyl sign material capable to lift such material off its backing. Further utility lies in the use of a transfer tape that has a high shelf life, specifically one which, after one or more uses, may be set aside for a period of approximately 30 days and then reused to transfer vinyl sign material from a paper backing to a substrate.

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SUMMARY OF THE INVENTION

In summary, applicant's unique method provides for the use of a single piece of transfer tape for multiple transfers from a host backing directly to a substrate, with the transfer tape being forgiving, clear, having a high shelf life, and being non-self destructive. Such a method has been heretofore unavailable.

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BRIEF DESCRIPTION OF THE DRAWINGS

Figures 1-5 illustrate, in perspective views, the steps, set forth sequentially, of applicant's method.

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DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

Figs. 1-5 illustrate a typical transfer operation whose objective is to transfer vinyl designs (such as letters) from an adhesive backing to a substrate.

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Here, in Fig. 1, the user is illustrated holding a piece of appropriately sized transfer tape (10) stretched between his hands and poised to place it, adhesive side down, to vinyl sign material (12) with letters (14) cut out.

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Fig. 2 illustrates the application of transfer tape (10) to letters (14) by applying pressure, as through a squeegee (16).

Fig. 3 illustrates the user holding vinyl sign material (12) down as transfer tape (10) is lifted off, the lift off releasing letters (14) from the paper backing of vinyl sign material (12) and onto the adhesive side of transfer tape (10).

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Fig. 4 illustrates transfer tape (10) with all of vinyl letters (14) attached to the adhesive side thereof, having been

lifted off from their paper backing, with the user poised to place the letters on substrate (18) in their preferred location.

Fig. 5 illustrates the removal of transfer tape (10) from letters (14), letters (14) having been adhered to by the application of pressure, as through a squeegee (16) (see Fig. 2), being rubbed across the nonadhesive side of transfer tape (10) to force the letters (14) onto substrate (18). The removal of the transfer tape leaves letters (14) on the substrate (18). The removal is effected by a slow uniform pull of one end of the transfer tape (10) across the substrate, generally along the longitudinal axis of the transfer tape.

Applicant's method then, is for the repetition of the above steps using the same piece of transfer tape for transferring vinyl signage designs which have an adhesive and nonadhesive side, the adhesive side adhering to a protective backing or host paper to a substrate, typically glass, metal, fiberglass, wood, stiff plastic, styrene, or the like, using a transfer member, the transfer member having an adhesive side and a nonadhesive side. One transfer member sufficient to practice applicant's method is presently being sold under the trademark MAGIC COVER®, the registered trademark of Kittrich Corporation, MAGIC COVER® Division, 4500 District Boulevard, Los Angeles, California 90058. Vinyl signage members are supplied to the sign industry by such companies as Spartan International, Inc., 1845 Cedar Holt, MI 48842; Vector TM Graphics, 925 Sawmill River Road, Yonkers, NY 10710; and Universal Products, Inc., 21 Industrial 57, Goddard, KS 67052. Typically the vinyl signage material is on a backing paper that comes in rolls about 15 inches wide in a variety of color and thicknesses, typically between 2 ml and 4 ml thick.

Applicant's preferred transfer member is the MAGIC COVER® self-adhesive, vinyl, decorative coverings from Kittrich that is available in clear. Another preferred embodiment uses 3 mil clear vinyl with a mix of water-based adhesives, about 30% shelf paper adhesive, and 70% book cover adhesive to coat the adhesive side of the vinyl. Such a tape is available under the trademark EXAC-TAC from Exac-Tac, 635 S. Hill Avenue, New Braunfels, Texas 78130. Heretofore, the Kittrich product has been provided to consumers to

affix to the surface of shelves, notebooks, pages, diplomas, posters, cards, books and manuals, newspapers clippings, and the like in order to provide protection and durability to the substrate while allowing viewing of the covered and protected document, shelf or sheet. The nature of the self-adhesive vinyl MAGIC COVER® member has been found to provide the surprising and beneficial advantages heretofore unrealized in existing transfer tape - namely, reusability, allowing repeated transfers utilizing the same transfer member. Heretofore, available transfer tape has been used for a single transfer (or, at most, two) of a design from its host paper backing to the substrate and then thrown away. Additional designs or transfers are done with additional sheets of transfer tape. Applicant has discovered a unique usage of the MAGIC COVER® material heretofore unused in the signage industry by applying its highly desirable adhesive characteristics to a unique method of repeatedly reusing the same transfer member for removing vinyl signage designs from protective host paper to a substrate.

An additional property applicant has discovered is the use of the transfer tape to transfer vinyl designs or other graphics to paper or cardboard without the transfer tape sticking to the paper or cardboard, as has prior art transfer paper.

Thus, applicant's method begins with the following materials: a properly sized transfer member, such as the MAGIC COVER®; and a sheet of vinyl signage material with the letters, numbers, or other pleasing designs cut out from the roll, typically by use of computers through devices and methods known in the trade.

Working in a clean, flat, well-lit area, the worker first applies the adhesive side of the transfer member, after having removed the backing paper (if it comes with backing paper) from the transfer member and laying the backing paper aside for storing the transfer member when not in use or other suitable clean storage surface. Applying the adhesive side of the transfer member to a first vinyl signage design is done with sufficient pressure against the back (nonadhesive) side of the transfer member to adhere the adhesive side of the transfer member to the nonadhesive side of the vinyl signage design. When this is completed, the transfer member is lifted to remove from the paper host material the vinyl signage

design. Application of the vinyl signage design to the substrate is the next step. This is done by applying the vinyl signage design in the appropriate location on the substrate and then applying smooth and uniform pressure across the transfer member, urging the adhesive side of the vinyl signage design against the surface of the substrate sufficiently to assure complete and uniform adhesion of the vinyl signage material to the substrate in its proper location. This concluded, removal of the transfer member from the nonadhesive side of the first vinyl side material is proper.

Applicant has discovered a novel method utilizing the heretofore undiscovered (for transfer purposes) material, MAGIC COVER[®] from Kittrich Corporation, which has the unique ability to retain sufficient adhesion and tackiness to be reused under normal working conditions, typically up to at least 15 times. Applicant has used a single piece 56 times, and it still had sufficient tackiness. Moreover, applicant provides the unique step of allowing the placement of the adhesive side of the transfer member to its original backing papers or other materials, such as vinyl signage design material, while still being capable of being released and reused for transfer purposes. Applicant's method allows the transfer tape to stick to itself when folded onto itself, and to retain its usefulness when pulled apart for reuse.

Applicant has performed the following tests, all utilizing the MAGIC COVER[®] material:

TEST 1

Utilizing 3 ml Vector vinyl sign material provided by Vector Graphics, Inc. of Yonkers, New York 10710, letters were cut into 4" height for transfer from the host paper backing material to a coroplast, a corrugated plastic sheet approximately 1/4" thick, in a clean, dry state. Applicant measured and cut a piece of MAGIC COVER[®] 6" high and 18" in length. The paper backing was removed and transfer, according to the steps set forth above, was repeated. The vinyl is precut and the undesired vinyl is removed. A series of 15 words containing 6 letters prespaced on the vinyl backing material was transferred and accurately positioned, one set

below the other, on the substrate in approximately 8 minutes. It was observed during this test that, throughout the 15 transfers, there was no discernable loss in the ability of the transfer paper to pick up additional signage material (vinyl or any other like adhesive sign material) after the first signage material was transferred.

TEST 2

The same steps of Test 1 were repeated except that, between each transfer, the transfer member was firmly placed, adhesive side down, on the protective backing paper that the vinyl signage material was removed from. Between each step, the transfer member had to be removed from the backing material; and no discernable curling of the transfer material or loss of tackiness or ability to effect proper adhesion to the vinyl signage material was noticed.

TEST 3

The same steps of Test 1 were repeated except that, prior to the application of the vinyl signage material to the substrate, the substrate material surface to receive the vinyl is sprayed with a mist coating of water, the vinyl letters are applied and squeegeed with sufficient pressure.

Applicant notes that, compared to presently existing transfer tape (which loses its adhesion when it touches the water on the substrate), applicant's unique step allows for repeated use of the same transfer member, even when it has been dampened with water picked up from the substrate.

COMPARISON TESTS

Applicant's comparison test method consists of the following steps:

- A) cutting vinyl letters, all the same size (4" high and 18" long) from the same roll of vinyl;
- B) preparing the substrate (in this case, clean styrene) onto which letters are to be transferred by wiping with a clean, wet rag and allowing to dry;

- C) placing transfer tape (6" x 18") over letters;
D) applying constant pressure to transfer tape through the application of 12 lbs. of weight on a 40 square inch patch to pick up the letters;
5 E) making 8 passes of the weight at a constant speed over the transfer tape (a pass is the weight going over the tape one time, one way);
F) lifting the transfer tape slowly, with uniform pressure, with letters on tape;
10 G) placing transfer tape, with letters, onto styrene (no additional pressure applied);
H) using same weight and patch (as in D above) to apply pressure;
I) making 8 passes of the weight at a constant speed over
15 the transfer tape (a pass is the weight going over the tape one time, one way); and
J) pulling transfer tape up.

RESULTS

20. 1. The above process (A-J) was repeated using one 6" x 18" piece of MAGIC COVER® a total of 15 times with 100% effectiveness each time.
2. The piece of MAGIC COVER® used in "1" was then folded together (in half), opened and used in the same process (A-J above
25 1 time) with 100% effectiveness.
3. The above process (A-J) was done using one 6" x 18" piece of Vector™ System 3 Premium Application Tape 3 times: the first time with 100% effectiveness, the second time with 70% effectiveness, and the third and subsequent attempts yielding 0%
30 effectiveness. The Vector™ System 3 Premium Application Tape was useless as a transfer tape after the second use. Vector™ System 3 Premium Application Tape is a transfer tape with the same weight, color, and adhesiveness (and other properties) as many other transfer tapes used in the sign industry. There are many brand
35 names of transfer tape with their product interchangeable with other companies' transfer tapes.

4. The tests were all done under the same conditions and variables and by the same individual.

5. The word "effectiveness" as used above means applying transfer tape, lifting letters, and reapplying transfer tape with letters on it to the substrate, then lifting the transfer tape off of the letters and leaving 0-100% of the letters on the designated substrate (100% being all the letters, 50% being half the letters, etc.), as desired, without letters sticking to the transfer tape or not releasing from the transfer tape when appropriate.

6. The "letters" in the above process could be any shape, design, numbers, or the like. The purpose was to use identical shapes and sizes in all testing under the same conditions. The term vinyl signage designs is used to denote numbers, letters, or any vinyl designs.

7. A second decorative covering that has been found to be effective as a transfer tape according to applicant's novel method is sold under the registered trademark TYE-TAC®. TYE-TAC® is the registered trademark of Tye-Sil Corporation Ltd. of 5505 Des Grandes Prairies Boulevard, Montreal, Quebec Canada H1R 1B3 (a Canadian corporation).

Applicant also, utilizing the unique transfer tape as set forth above, provides a method for making a sign for display purposes wherein the method includes providing a flexible sheet having an adhesive-coated side and a nonadhesive side, the nonadhesive side having a signage or design thereon, the nonadhesive side being capable of repeatedly releasably adhering to the support surface. The utility lies in the fact that the sign technician, in mounting the flexible sheet having the signage design thereon to a support surface, may inadvertently misposition it. Additionally, the utility lies on the sign being of a temporary nature, where the sheet can be removed from the support surface and either placed on a storage board or folded onto itself, with the adhesive side of one portion of the sign touching the adhesive side of the other, so the adhesive does not pick up dust, etc. Utility also lies in the method of making a sign using the forgiving flexible sheet in that, if during the handling of the sheet and placement of the sheet on the support surface the

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[REPLACEMENT PAGE]

adhesive side of one portion touches the adhesive side of a second portion, it can be straightened out for placement on the support surface without destroying the adhesiveness. In other words, Applicant provides in a tape with the unique properties set forth above, but with signage, designs, letters, etc., on the surface thereof, a novel method of making a sign for display purposes. It is known that Applicant's unique method can be practiced with the transfer tape set forth above with signage applied through one of four different ways: thermal color transfer, wax color transfer, rosin-based ink, and acrylic paint (paint jet).

The adhesive side of the single piece of transfer member may be placed against a holding surface and subsequently removed from that holding surface any time before, during or after applying the adhesive side of the single piece of the transfer member to a signage design. The transfer member may be removed from the support surface and remounted to the support surface for temporary storage.

The flexible sheet (the transfer sheet), with the vinyl signage thereon, can be mounted to a support surface and removed and remounted, without the vinyl coming off, if, for example, the signage is not in the proper position or otherwise misaligned.

Terms such as "left," "right," "up," "down," "bottom," "top," "front," "back," "in," "out," and like are applicable to the embodiments shown and described in conjunction with the drawings. These terms are merely for purposes of description and do not necessarily apply to the position or manner in which the invention may be constructed for use.

Although the invention has been described in connection with the preferred embodiment, it is not intended to limit the invention's particular form set forth, but on the contrary, it is intended to cover such alternatives, modifications, and equivalences that may be included in the spirit and scope of the invention as defined by the appended claims.

CLAIMS

What Is Claimed Is:

1. A method for transferring precut vinyl signage designs having an adhesive and a nonadhesive side from a host backing to a substrate, the method using a single piece of a transfer member having an adhesive and a nonadhesive side, the method including the steps of:

a) weeding the unwanted vinyl from the host backing, leaving a first image design on the host backing;

b) applying the adhesive side of the single piece of the transfer member to the first signage design with sufficient pressure to adhere the nonadhesive side of the signage design to the adhesive side of the single piece of the transfer member;

c) removing the single piece of the transfer member along with the first signage design from the host backing;

d) urging the first signage design against the substrate by asserting sufficient pressure against the nonadhesive side of the single piece of the transfer member to ensure that the adhesive side of the first signage design adheres to the substrate;

and

e) removing the single piece of the transfer member from the nonadhesive side of the first signage design, leaving the signage design bonded to the substrate; and

f) Repeating steps a through d, reusing the same single piece of the transfer member as utilized in step a) to effect subsequent transfers of second and subsequent signage designs.

2. The method as set forth in Claim 1 further including the step of misting the surface of the substrate with water prior to the application of the first, second, or any subsequent signage designs.

3. The method as set forth in Claim 1 further including the step of placing the adhesive side of the single piece of the transfer member to a holding surface and subsequently removing the single piece of the transfer member, the placing and removing step occurring at anytime before, during, or after step b).

4. The method as set forth in Claim 1 further including the step of adhering one portion of the single piece of the transfer member to a second portion of the single piece of the transfer member by folding the single piece of the transfer member together,
5 the adhering step including the step of unfolding the single piece of the transfer member.

5. The method as set forth in Claim 2 further including the step of placing the adhesive side of the single piece of the transfer member to a holding surface and subsequently removing the
10 single piece of the transfer member, the placing and removing step occurring at anytime before, during, or after step b).

6. The method as set forth in Claim 4 further including the step of placing the adhesive side of the single piece of the transfer member to a holding surface and subsequently removing the
15 single piece of the transfer member, the placing and removing step occurring at anytime before, during, or after step b).

7. The method as set forth in Claim 4 further including the step of misting the surface of the substrate with water prior to the application of the first, second, or any subsequent signage
20 designs.

8. The method as set forth in Claim 1, wherein the signage design is vinyl, and paper comprises the host backing.

9. The method as set forth in Claim 1 as applied to a paper or cardboard substrate.

25 10. A method for making a sign for display purposes, the method including the steps of:

providing a flexible sheet having an adhesive side and a nonadhesive side, the nonadhesive side having a precut vinyl signage display thereon, the adhesive side being capable of
30 repeatedly releasably adhering itself to a support surface;

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[REPLACEMENT PAGE]

mounting the flexible sheet to the support surface for display purposes; and

subsequently removing and remounting the flexible sheet to the support surface.

5 11. The method as set forth in Claim 10 further providing the step of temporarily storing the flexible sheet on a storage board by applying the adhesive surface to the storage board, said temporary mounting step being utilized following the providing step.

10 12. The method for making a sign for display purposes as set forth in Claim 10 further providing the step of folding a first portion of the flexible sheet so that the adhesive side is contacted with the adhesive side of a second portion of the flexible sheet for temporary storage purposes.

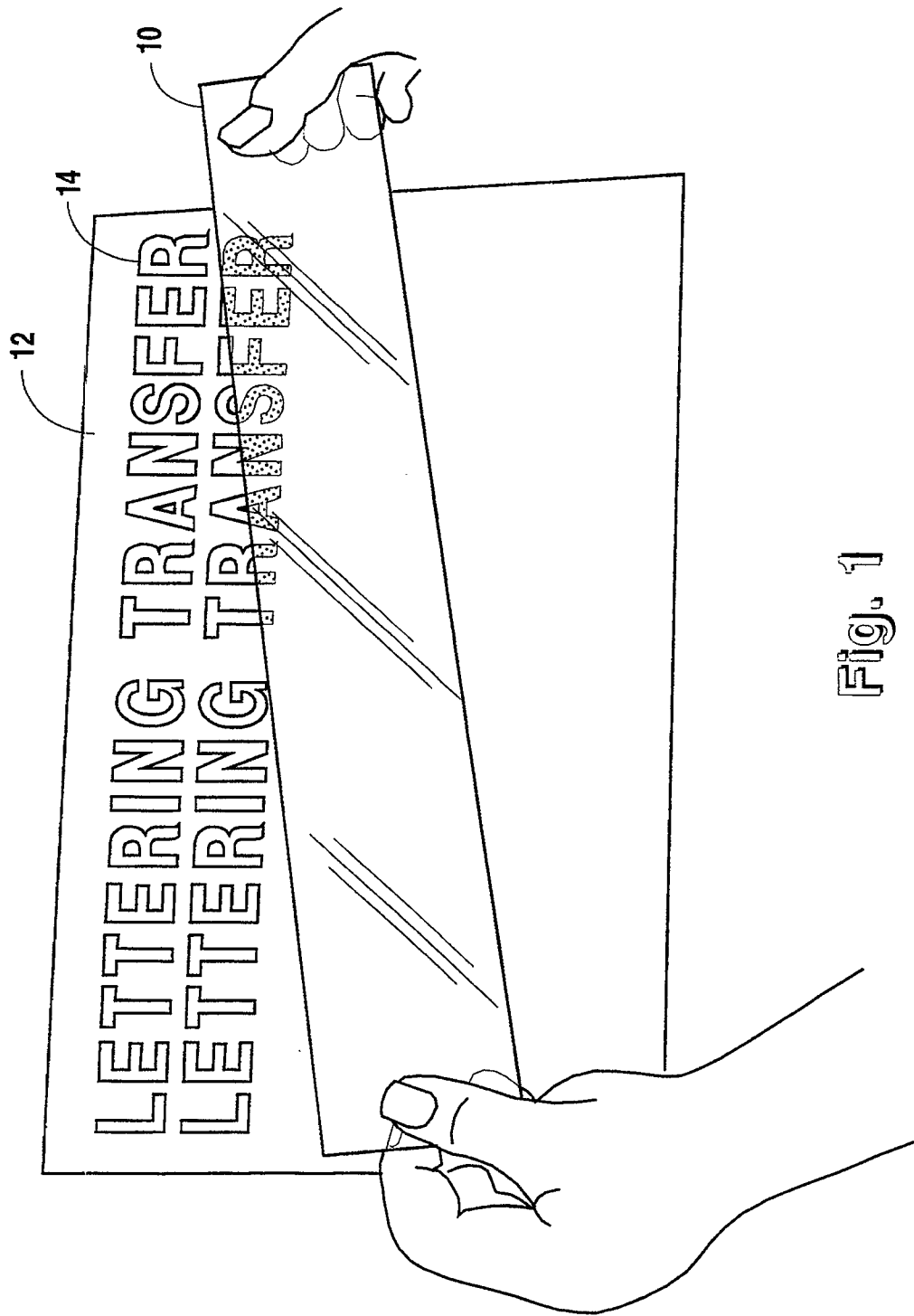


Fig. 1

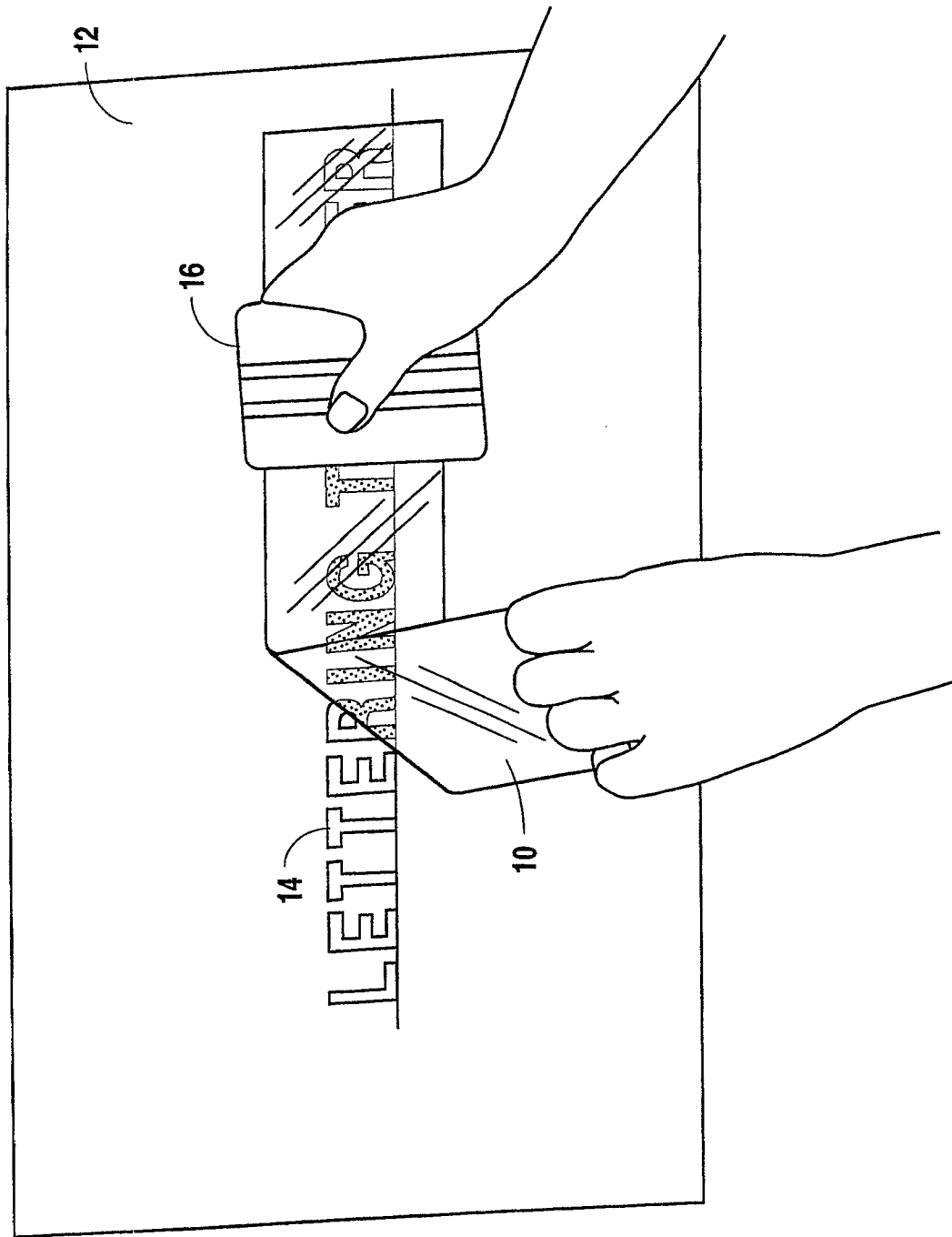


Fig. 2

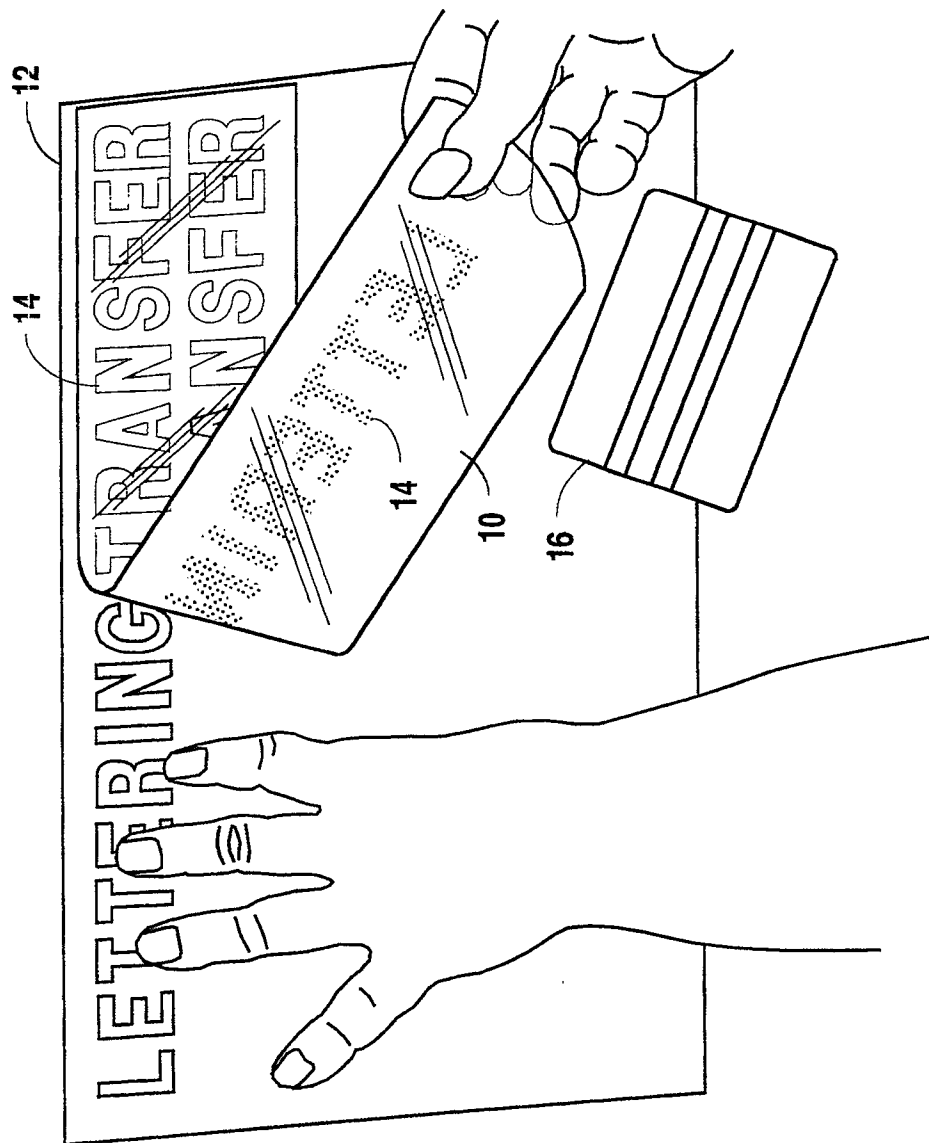


Fig. 3

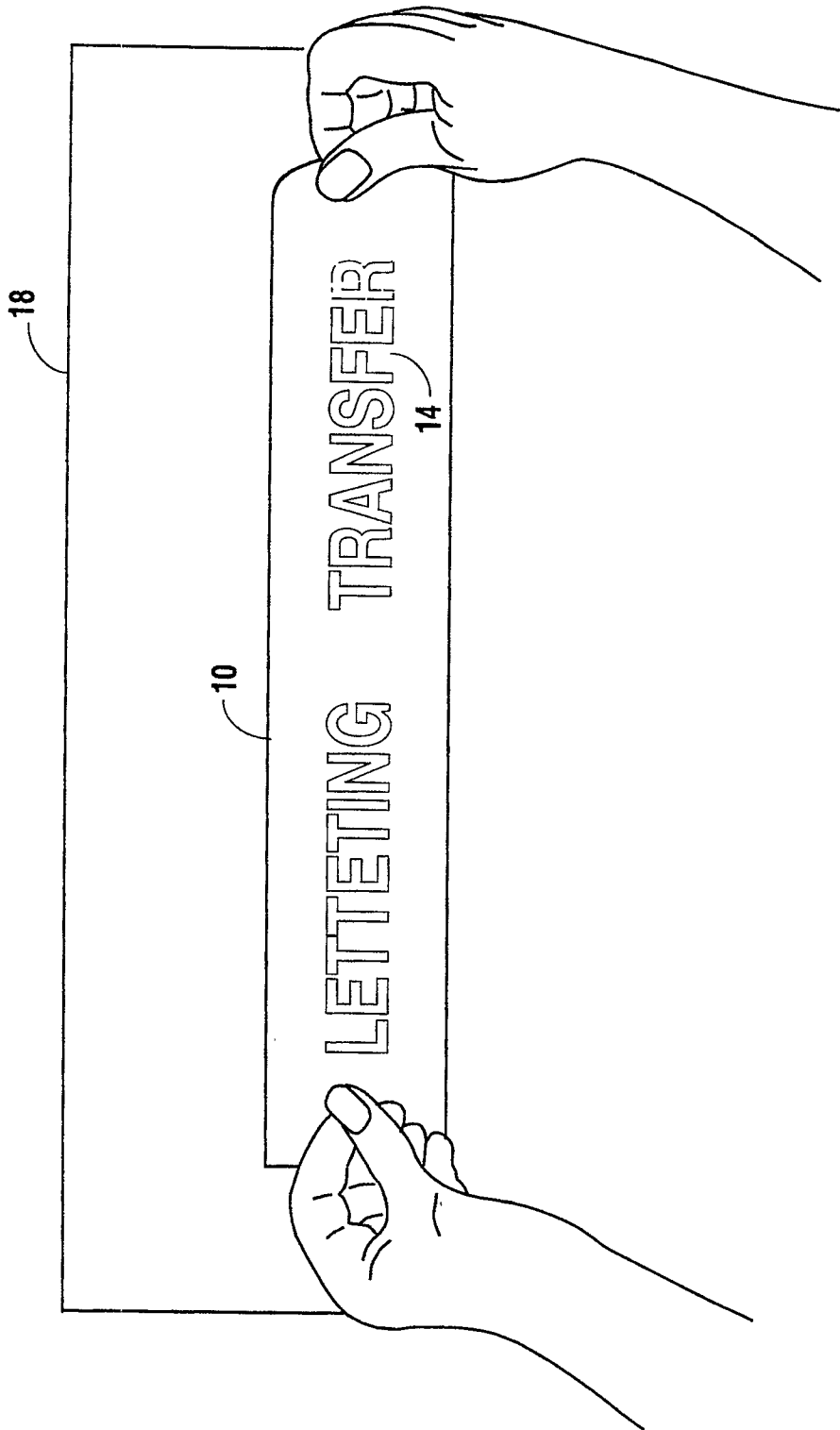


Fig. 4

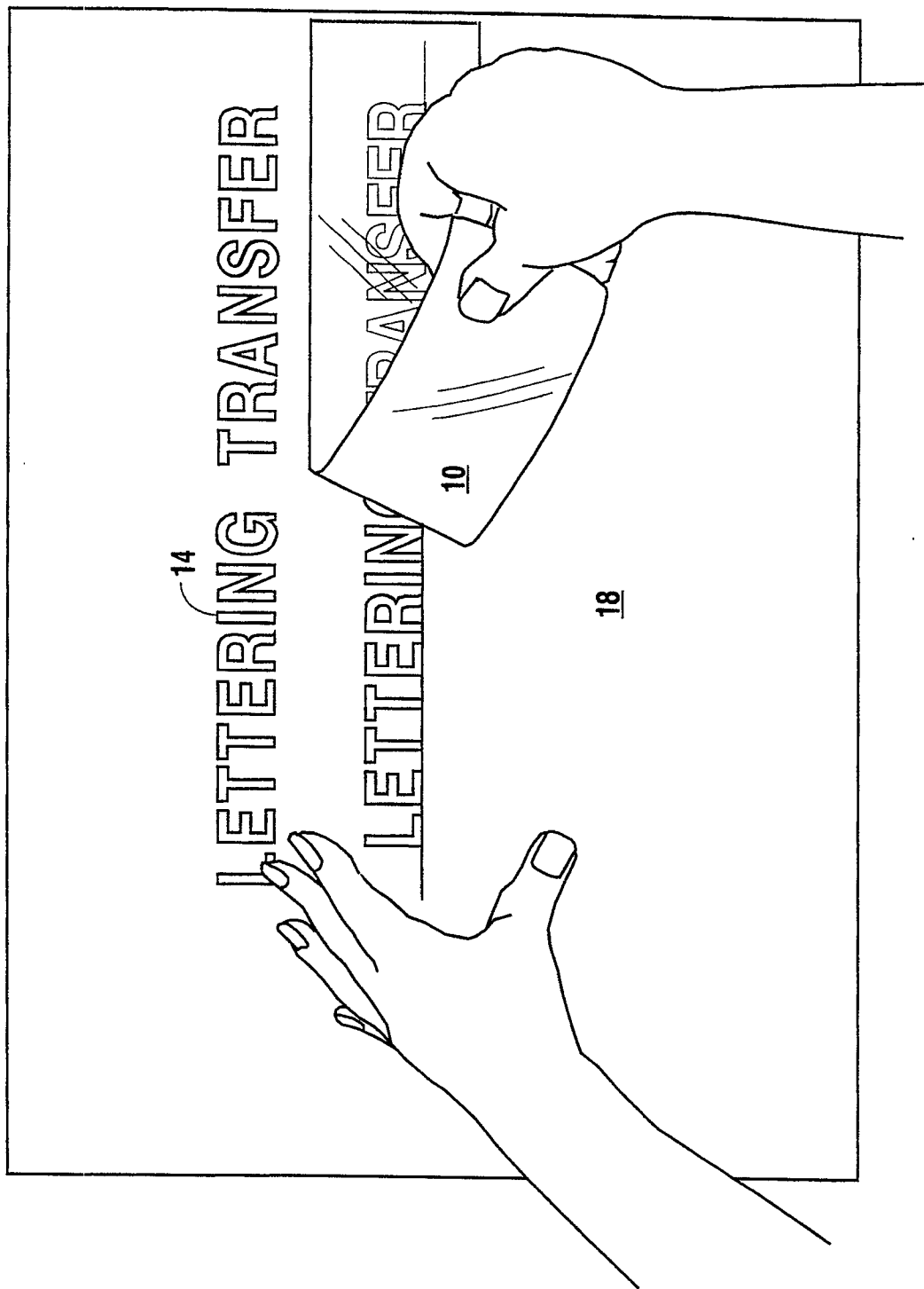


Fig. 5

