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(54) **Manufacturing procedure for plastic or vinyl trimmings**

(57) Implemented according to operations involving the facing (III) between a front part (2), over which relief printing (I) in one or several colours has been applied, and a rear supporting part (3), preferably coinciding in shape and size, followed by heat welding attachment

(IV) of the front part (2) and the rear supporting part (3) along a series of points or lines (5), defining pass-through openings (4) or laps on the non-welded zones, and subsequent stamping (V) the assembly composed of the front part (2) and the rear supporting part (3) for obtaining the final trimming part.

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**Description**OBJECT OF THE INVENTION

The present invention refers to a manufacturing procedure for plastic or vinyl trimmings applicable to belts, suspenders, bracelets and so forth which uses high-frequency heat welding techniques for partially adhering a part with a printed drawing on its front side to a rear part, both parts being provided with openings allowing, for instance, for belts, suspenders, etc., to pass therethrough.

The procedure used for forming said trimming parts allows for the bonding of the front and the rear parts over specific areas, thereby saving considerable time and providing great accuracy in the finishing operation.

BACKGROUND OF THE INVENTION

Plastic material trimmings featuring various designs are greatly attractive, and the demand is greater for those showing flashy and colour-contrasting figures of popular comic, film and similar characters.

These plastic trimmings are normally applied over an adhesive material support which is then attached to folders, posters, etc., or else secured to a garment by means of a pin or similar fastening means.

Another type of plastic trimming, which is the object of this invention, involves the attachment of two opposite parts having the same shape and size and fitted with openings through which the trimming may be inserted in a belt, suspender or similar garment, one of the parts featuring the printed relief drawing in one or several colours.

The standard forming procedure for this type of trimming involves, in the first place, printing the drawing over one of the parts by means of a silk-screen process, followed by stamping this part jointly with a supporting part, of the same size, over which the first part is secured by sewing along the areas which so require and providing openings or laps in other areas.

This attachment process by sewing is time consuming and fails to provide a showy appearance, the attachment of this type of trimming being thus liable to improvement.

DESCRIPTION OF THE INVENTION

The present invention refers to a manufacturing procedure for plastic and vinyl trimmings of the type composed of respective parts having the same shape and size, the upper part thereof featuring a printed relief drawing and being partially attached to a supporting part located underneath by means of heat welding techniques, thus saving time and improving the finished appearance as compared to previously used techniques.

The process proceeds according to stages involving the printing of a drawing in one or several colours

over a plastic or vinyl heat-welded tag applied onto the front part, a first high frequency silk-screening being subsequently implemented which provides relief to the drawing.

A second high frequency printing follows wherein the front part is attached to the lower part, the latter preferably having a coinciding shape and perimeter, which attachment is implemented along defined lines or points which allow for voids or openings between the upper and lower parts for belts, tapes, suspenders or similar items to pass through.

Cutting or stamping follows, according to the desired perimeter shape.

The trimming parts so defined may present, for example, an end sector in the form of a lap, two openings for allowing the belt to pass through or three openings for two suspender bands to pass through, or any other appropriate solution for their attachment to the user's garment.

DESCRIPTION OF THE DRAWINGS

In order to complement the description set forth and help toward a better understanding of the characteristics of the invention, a single figure is attached to this specification, being an integral part thereof, wherein the manufacturing stages of the plastic or vinyl trimming are illustrated in a non-limiting manner.

PREFERRED EMBODIMENT OF THE INVENTION

In the light of said figure, a preferred form of embodiment is defined for the plastic or vinyl trimming part manufacturing process stages, which process proceeds according to the following established order in the operations required for obtaining the final product:

- Printing (I) in one or several colours (1) over a plastic or vinyl support (2) subject to heat welding.
- High-frequency printing (II) over the front side of the above mentioned part (2), which provides relief to the drawing previously defined on said part.
- Facing (III) of the front part (2) and the rear supporting part (3), the latter preferably coinciding in shape and size.
- Heat welding attachment (IV) of the front part (2) to the rear supporting part (3) along a series of points or lines (5), defining pass-through openings (4) or laps.
- Stamping (V) the assembly comprising the front part (2) and the rear supporting part (3) for obtaining the final trimming part.

This description need not be more extensive for any expert on the subject to grasp the scope of the invention and the advantages deriving therefrom.

The materials, shape, size and arrangement of the elements are liable to variation provided the essence of

the invention is not altered.

The terms used in describing this specification must at all times be taken in their broad, non-limiting sense.

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### Claims

1. Manufacturing procedure for plastic or vinyl trimmings, of the type involving printing (I) in one or several colours (1) over a plastic or vinyl support (2) subject to heat welding, followed by high-frequency printing (II) over the front side of the above mentioned part, which provides relief to the drawing previously defined on said front part (2) for subsequent partial attachment to a rear part (3), essentially characterized in that the following stages are implemented:
  - facing (III) of the front part (2) and the rear supporting part (3), the latter preferably coinciding in shape and size,
  - heat welding attachment (IV) of the front part (2) to the rear supporting part (3) along a series of points or lines (5), defining pass-through openings (4) or laps on the non-welded zones,
  - stamping (V) the assembly composed of the front part (2) and the rear supporting part (3) for obtaining the final trimming part.

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