CLAIMS

1. A method for manufacturing an adhesive patch including a support, a pressure-sensitive adhesive agent layer provided on one surface of the support, a release sheet which is releasably attached to the pressure-sensitive adhesive agent layer, and a weakened part which is formed in the release sheet, the weakened part being for easily dividing the release sheet into two parts, the adhesive patch in which a pinching piece forming sheet is fixed on the release sheet such that the pinching piece forming sheet covers the weakened part, and portions of the pinching piece forming sheet which are other than the at least one fixed portion function as pinching pieces, and in the pinching piece forming sheet, a weakened part for easily dividing the release sheet into two parts is formed at a position corresponding to the weakened part of the release sheet,

the method comprising:

a first step of forming a pressure-sensitive adhesive agent layer on a support;

a second step of fixing a pinching piece forming sheet on a release sheet;

a third step of forming a weakened part in the release sheet and the pinching piece forming sheet; and

a fourth step of releasably adhering the release sheet on which the pinching piece forming sheet is fixed, which is obtained in the third step, to the pressure-sensitive adhesive agent layer on the support which is obtained in the first step.

2. The method according to claim 1, wherein the two fixed

portions between the release sheet and the pinching piece forming sheet which are obtained in the second step, are positioned such that the fixed portions are spaced from the weakened part on the right and left of the weakened part.

3. The method according to claim 1, wherein the one fixed portion between the release sheet and the pinching piece forming sheet which is obtained in the second step, is positioned on the weakened part.

4. The method according to any one of claims 1 to 3, wherein the fixing in the second step is carried out by a heat-sealing method.

5. A method for manufacturing an adhesive patch including a support, a pressure-sensitive adhesive agent layer provided on one surface of the support, a release sheet which is releasably attached to the pressure-sensitive adhesive agent layer, and a weakened part which is formed in the release sheet, the weakened part is for easily dividing the release sheet into two parts, the adhesive patch in which a pinching piece forming sheet is fixed on the release sheet such that the pinching piece forming sheet covers the weakened part, and portions of the pinching piece forming sheet which are other than the at least one fixed portion function as pinching pieces, and in the pinching piece forming sheet, a weakened part for easily dividing the release sheet into two parts is formed at a position corresponding to the weakened part of the release sheet,

the method comprising:

a first step of unwinding a first continuous web which will be the support from a first original roll, to form a pressure-sensitive adhesive agent layer on the first continuous web;

a second step of unwinding a second continuous web which will be the release sheet from a second original roll, unwinding a third continuous web which will be the pinching piece forming sheet from a third original roll, and superposing the third continuous web on the second continuous web to fix both sheets;

a third step of forming a weakened part in the second continuous web and the third continuous web which are fixed;

a fourth step of releasably adhering the second continuous web to which the third continuous web is fixed, that has been obtained in the third step, to the pressure-sensitive adhesive agent layer on the first continuous web, that has been obtained in the first step, so as to form a laminated body; and

a fifth step of cutting out the laminated body obtained in the fourth step to a predetermined size, to form the desired adhesive patch.

6. The method according to claim 5, wherein the two fixed portions between the second continuous web and the third continuous web which are obtained in the second step, are positioned such that the fixed portions are spaced from the weakened part on the right and left of the weakened part.

7. The method according to claim 4, wherein the one fixed portion between the second continuous web and the third continuous web which is obtained in the second step, is positioned on the weakened part.

8. The method according to any one of claims 5 to 7, wherein the fixing in the second step is carried out by a heat-sealing method.

9. An apparatus for manufacturing an adhesive patch including a support, a pressure-sensitive adhesive agent layer provided on one

surface of the support, a release sheet which is releasably attached to the pressure-sensitive adhesive agent layer, and a weakened part which is formed in the release sheet, the weakened part being for easily dividing the release sheet into two parts, the adhesive patch in which a pinching piece forming sheet is fixed on the release sheet such that the pinching piece forming sheet covers the weakened part, and portions of the pinching piece forming sheet which are other than the at least one fixed portion function as pinching pieces, and in the pinching piece forming sheet, a weakened part for easily dividing the release sheet into two parts is formed at a position corresponding to the weakened part of the release sheet,

the apparatus comprising:

a spreading and adhering unit which spreads and adheres a pressure-sensitive adhesive agent on a first continuous web which is unwound from a first original roll, to be the support, to form a pressure-sensitive adhesive agent layer;

a fixing unit which superposes a second continuous web which is unwound from a second original roll, to be the release sheet, and a third continuous web which is unwound from a third original roll, to be the pinching piece forming sheet, to fix both sheets;

a weakened part forming unit which forms a weakened part in the second continuous web and the third continuous web fixed by the fixing unit;

a laminated body forming unit which releasably attaches the second continuous web to which the third continuous web is fixed, which has passed through the weakened part forming unit, on the

pressure-sensitive adhesive agent layer on the first continuous web, which has passed through the spreading and adhering unit, so as to form a laminated body; and

a cutting unit which cuts out the laminated body obtained by the laminated body forming unit, to a predetermined size, so as to form the adhesive patch.

10. The apparatus according to claim 9, wherein the fixing unit is configured such that the two fixed portions between the second continuous web and the third continuous web which are obtained by the fixing unit, are positioned so as to be spaced from the weakened part on the right and left of the weakened part formed by the weakened part forming unit.

11. The apparatus according to claim 9, wherein the fixing unit is configured such that the one fixed portion between the second continuous web and the third continuous web which is obtained by the fixing unit, is positioned on the weakened part formed by the weakened part forming unit.

12. The method according to any one of claims 9 to 11, wherein the fixing unit includes a heat-sealing device.

13. The apparatus according to claim 12, wherein

the heat-sealing device is a press type,

a first accumulation device and a second accumulation device which are capable of accumulating the second continuous web and the third continuous web are respectively provided on the upstream side of the heat-sealing device, and between the heat-sealing device and the laminated body forming unit, thereby, during fixing of the second

continuous web and the third continuous web by the heat-sealing device, the second continuous web and the third continuous web which are continuously fed from the second original roll and the third original roll are temporarily accumulated by the first accumulation device, and the second continuous web and the third continuous web which are accumulated by the second accumulation device are continuously fed to the downstream side.

CLAIMS

1. A method for manufacturing an adhesive patch including a support, a pressure-sensitive adhesive agent layer provided on one surface of the support, a release sheet which is releasably attached to the pressure-sensitive adhesive agent layer, and a weakened part which is formed in the release sheet, the weakened part is for easily dividing the release sheet into two parts, the adhesive patch in which a pinching piece forming sheet is fixed on the release sheet such that the pinching piece forming sheet covers the weakened part, and portions of the pinching piece forming sheet which are other than the at least one fixed portion function as pinching pieces, and in the pinching piece forming sheet, a weakened part for easily dividing the release sheet into two parts is formed at a position corresponding to the weakened part of the release sheet,

the method comprising:

a first step of unwinding a first continuous web which will be the support from a first original roll, to form a pressure-sensitive adhesive agent layer on the first continuous web;

a second step of unwinding a second continuous web which will be the release sheet from a second original roll, unwinding a third continuous web which will be the pinching piece forming sheet from a third original roll, and superposing and fixing the third continuous web on the second continuous web by a heat-sealing method by use a press type heat-sealing device, wherein a first accumulation device and a second accumulation device which are capable of accumulating the second continuous web and the third continuous web are respectively provided on the upstream side of the heat-sealing device, and between the heat-sealing device and the laminated body forming unit, thereby, during fixing of the second continuous web and the third continuous web by the heat-sealing device, the second continuous web and the third continuous web which are continuously fed from the second original roll and the third original

roll are temporarily accumulated by the first accumulation device, and the second continuous web and the third continuous web which are accumulated by the second accumulation device are continuously fed to the downstream side,

after the second step, a third step of forming a weakened part in the second continuous web and the third continuous web which are fixed;

a fourth step of releasably adhering the second continuous web to which the third continuous web is fixed, that has been obtained in the third step, to the pressure-sensitive adhesive agent layer on the first continuous web, that has been obtained in the first step, so as to form a laminated body; and

a fifth step of cutting out the laminated body obtained in the fourth step to a predetermined size, to form the desired adhesive patch.

2. The method according to claim 1, wherein the two fixed portions between the second continuous web and the third continuous web which are obtained in the second step, are positioned such that the fixed portions are spaced from the weakened part on the right and left of the weakened part.

3. The method according to claim 1, wherein the one fixed portion between the second continuous web and the third continuous web which is obtained in the second step, is positioned on the weakened part.

4. An apparatus for manufacturing an adhesive patch including a support, a pressure-sensitive adhesive agent layer provided on one surface of the support, a release sheet which is releasably attached to the pressure-sensitive adhesive agent layer, and a weakened part which is formed in the release sheet, the weakened part being for easily dividing the release sheet into two parts, the adhesive patch in which a pinching piece forming sheet is fixed on the release sheet such that the pinching piece forming sheet covers the weakened part, and portions of the pinching piece forming sheet which are other than the at least one fixed portion function as pinching pieces, and in the pinching piece forming sheet, a weakened part for easily dividing the release sheet into two parts is formed at a position corresponding to the weakened part of the release sheet,

the apparatus comprising:

a spreading and adhering unit which spreads and adheres a pressure-sensitive adhesive agent on a first continuous web which is unwound from a first original roll, to be the support, to form a pressure-sensitive adhesive agent layer;

a fixing unit which superposes a second continuous web which is unwound from a second original roll, to be the release sheet, and a third continuous web which is unwound from a third original roll, to be the pinching piece forming sheet, to fix both sheets;

a weakened part forming unit which forms a weakened part in the second continuous web and the third continuous web fixed by the fixing unit;

a laminated body forming unit which releasably attaches the second continuous web to which the third continuous web is fixed, which has passed through the weakened part forming unit, on the pressure-sensitive adhesive agent layer on the first continuous web, which has passed through the spreading and adhering unit, so as to form a laminated body; and

a cutting unit which cuts out the laminated body obtained by the laminated body forming unit, to a predetermined size, so as to form the adhesive patch,

wherein the fixing unit includes a press type heat-sealing device, and

wherein a first accumulation device and a second accumulation device which are capable of accumulating the second continuous web and the third continuous web are respectively provided on the upstream side of the heat-sealing device, and between the heat-sealing device and the laminated body forming unit, thereby, during fixing of the second continuous web and the third continuous web by the heat-sealing device, the second continuous web and the third continuous web which are continuously fed from the second original roll and the third original roll are temporarily accumulated by the first accumulation

device, and the second continuous web and the third continuous web which are accumulated by the second accumulation device are continuously fed to the downstream side.

5. The apparatus according to claim 4, wherein the fixing unit is configured such that the two fixed portions between the second continuous web and the third continuous web which are obtained by the fixing unit, are positioned so as to be spaced from the weakened part on the right and left of the weakened part formed by the weakened part forming unit.

6. The apparatus according to claim 4, wherein the fixing unit is configured such that the one fixed portion between the second continuous web and the third continuous web which is obtained by the fixing unit, is positioned on the weakened part formed by the weakened part forming unit.