Description

This invention relates to a data storage media and, more particularly, to an improved write/protect tab assembly for a floppy disc jacket and a method for assembling same.

As is known, information can be recorded on and/or reproduced from a data storage medium in the form of a "floppy disc" by bringing a magnetic head into contact with the disc while rotating the disc at a high speed and, at the same time, moving the magnetic head in the radial direction of the disc.

Such a floppy disc is usually enclosed in a "jacket" to prevent damage to the disc during handling. A floppy disc jacket includes, among other things, a write/protect tab assembly which is intended to prevent inadvertent erasure of the information recorded on the disc.

For example, document US-A-4409630, issued to SAITO, discloses a write/protect tab assembly, wherein an assembled floppy disc jacket has a write/protect tab slidably mounted in a write/protect tab pocket. In the write/protect tab assembly of said US patent, as in other conventional write/protect tab assemblies, the write/protect tab does not become "encaptured" in the floppy disc jacket until the base and cover of the jacket are ultrasonically welded together during final assembly. Encaptured is defined as being held in place so that the write/protect tab will not fall out of the floppy disc jacket when handled. Accordingly, there are several instances before final assembly of the conventional jacket when, unfortunately, the write/protect tab merely falls out of the jacket base and disrupts production.

Most particularly, prior to ultrasonically welding the jacket cover to the base, but after inserting the floppy disc and temporarily positioning the cover, the disc is quality tested. If the disc is not up to particular quality standards, the cover must be removed from the base and the disc is discarded. Often, at this stage of production, the tab falls out during handling. When a new disc is placed in the jacket, the write/protect tab must be re-inserted in the tab pocket before the cover can be replaced on the base and the testing repeated. Of course, this type of assembly is time and cost inefficient.

Another important drawback of the conventional assembly is related to floppy disc manufacturer buying requirements. These manufacturers prefer to load their own floppy disc into the jacket, test the quality of the disc, and then ultrasonically weld the jacket cover to the base. They prefer to take no part in the pre-assembly process, including insertion of the write/protect tab into the tab pocket. Of course, the conventional assembly forces such a manufacturer to insert the write/protect tab, since it falls out if the jacket is shipped with the write/protect tab originally in place.

Document EP-A-185 364 having a publication date of 25/06/1986 relates to a U-shaped slider which is moved coplanar to a jacket base and pushed and expanded over an edge of the jacket base. Then the jacket cover is placed on the jacket base.

This structure capturess the tab relative to the base, in both the first and second positions, and therebetween.

Document GB-A-2090226 discloses a floppy disc jacket assembly including a jacket base and a write protect tab. Before the welding of the upper half on the base to form the jacket, the tab is integrally part of said base. Hence during the period preceding the welding of the upper half on the base said tab cannot be removed from said base. Later on when it is desired by the user, said tab is separated from the base by breaking of the connecting part and reinserted between said upper half and said bas in order to used as the conventional tab disclosed in document US-A-4409630.

In light of the above, the prior art still does not provide a floppy disc jacket assembly and a method for assembling same which are capable of the most cost- and time-efficient automated assembly.

Accordingly it is an object of the present invention to provide a floppy disc jacket assembly and a method for assembling same which are capable of simplifying the assembly process by encapturing the tab in the jacket base before the cover is in place.

It is another object of the present invention to provide a floppy disc jacket assembly and a method for assembling same, wherein the tab can be reliably encaptured throughout production without significant structural or esthetic changes being made to the jacket.

Finally, it is an object of the present invention to provide a floppy disc jacket assembly and a method for assembling same, wherein during production, a machine can simply and automatically move the write/protect tab into the encapturing position, where it thereafter remains until moved intentionally.

To achieve the foregoing and other objects of the invention and in accordance with the purposes of the invention there are provided a floppy disc jacket assembly and a method for assembling same as recited in claim 1 and 11.

The present invention eliminates the disadvantages of the prior art, such as time and cost consuming production of floppy discs and jackets, and provides automated assembly of write/protect tabs into floppy disc jackets.

The accompanying drawings, which are incorporated in and constitute a part of the specification,

illustrate embodiments of the invention and, together with the description, serve to explain the principles of the invention.

Fig. 1 is a top plan view of a data storage medium according to the present invention in the form of a floppy disc and jacket;

Fig. 2 is an exploded perspective view of a first, preferred embodiment of the write/protect tab assembly for a floppy disc jacket and method for assembling same according to the present invention;

Fig. 3 is an exploded perspective view of a second embodiment of the write/protect tab assembly for a floppy disc jacket and method for assembling same according to the present invention;

Fig. 4 is a rear view of the write/protect tab shown in Fig. 3;

Fig. 5 is an exploded perspective view of a third embodiment of the write/protect tab assembly for a floppy disc jacket and method for assembling same according to the present invention;

Fig. 6 is an exploded perspective view of a fourth embodiment of the write/protect tab assembly for a floppy disc jacket and method for assembling same according to the present invention;

Fig. 7 is an exploded perspective view of a fifth embodiment of the write/protect tab assembly for a floppy disc jacket and method for assembling same according to the present invention;

Fig. 8 is an exploded perspective view of a sixth embodiment of the write/protect tab assembly for a floppy disc jacket and method for assembling same according to the present invention;

Fig. 9 is an exploded perspective view of a seventh embodiment of the write/protect tab assembly for a floppy disc jacket and method for assembling same according to the present invention; and

Fig. 10 is an exploded perspective view of an eight embodiment of the write/protect tab assembly for a floppy disc jacket and method for assembling same according to the present invention.

Fig. 1 is a top plan view of a data storage medium according to the present invention indicated by reference numeral 10, generally including a floppy disc 12 and a floppy disc jacket 14.

Preferably, the floppy disc 12 is 88.9 mm in diameter, is composed of a thin polymer having a thickness of, for example, 0.08 mm, and is provided with a magnetic layer on at least one surface thereof, upon which a magnetic head (not shown) moves in contact.

The jacket 14 is preferably of a flat rectangular shape and includes a cover 16 and a base 18 arranged in substantially parallel relation. Both the cover 16 and the base 18 may be moulded or formed of a synthetic resin so as to completely enclose the floppy disc 12 sandwiched therebetween. The jacket 14 is further provided with a slidable member known as a write/protect tab 22 supported between an opening 23 in the cover 16 and a tab pocket 24 (see Fig. 2) formed in the base 18 for preventing inadvertent erasure of the information signals from the floppy disc 12.

Openings 20 and 21 are provided at the centres of the jacket 14 and the floppy disc 12, respectively, which are used in rotating the floppy disc 12 during operation.

Fig. 2 illustrates the first, preferred embodiment of the write/protect tab assembly 25 for a floppy disc jacket and method for assembling same according to the present invention. As can be seen, the write/protect tab 22 comprises a rectangular body 26 and two parallel arms 28 extending therefrom. Each arm 28 terminates outwardly in a projection 30 which cooperates with rounded projections 32 formed at the tab pocket 24 to produce incremental forward and backward movement of the tab 22 relative to the pocket 24. A latch 34 is also formed at the tab pocket 24 for temporarily receiving a recess 36 formed in the tab 22 and, accordingly, encapturing the tab 22 during production.

This first embodiment requires little structural modification of the write/protect tab 22 relative to the prior art structure. That is, the jacket base 18 and tab 22 remain substantially unchanged while the tab pocket 24 is slightly modified so that the tab 22 is encaptured in the pocket 24 when pushed in the forward/write position. The snap action that temporarily encaptures the tab 22 in the forward position prevents the tab 22 from sliding out from under the latch 34 on the base 18 until desired.

Figs. 3 and 4 illustrate a second embodiment of the write/protect tab assembly 25 for a floppy disc and method for assembling same according to the present invention. In this embodiment, recesses 38 are formed on either side of the tab 22 to interface with shelf-like projections 40 formed on the tab pocket 24. Formation of the recesses 38 in the tab can be accomplished by moulding a one piece tab or by joining two pieces to fabricate the tab 22. The tab 22 is first placed in the pocket 24 in the area without the shelf-like projections 40 and is then slid on over the shelf-like projections 40 to interface with the recesses 38.

Figs. 5-9 illustrate the third through seventh embodiments, respectively, of the write-protect tab assembly 25 for a floppy disc jacket and a method for assembling same according to the present invention. These embodiments share the common feature of fixedly attaching by various means a cap 42 to the write/protect tab 22 with the write/protect

tab pocket 24 being disposed between the write/protect tab 22 and the cap 42.

More particularly, as shown in Fig. 5, the cap 42 and the write/protect tab 22 are attached via snaps 44 formed on the cap 42, which are inserted through an opening 45 in the tab 22 and are received by corresponding recesses 46 formed at the sides of the write/protect tab 22.

In Fig. 6, the cap 42 and write/protect tab 22 are attached by press fitting the cap 42 into a corresponding opening 48 formed centrally of the rectangular body 26 of the write/protect tab 22.

In Fig. 7, the cap 42 and the write/protect tab 22 are attached via ultrasonic welding at their interface using a plurality of energy directors 50 which are known in the art.

In Fig. 8, the cap 42 and the write/protect tab 22 are attached by inserting a pair of swedging posts 52 formed in the cap 42 into corresponding circular openings 54 formed in the write/protect tab 22.

Further, in Fig. 9, the cap 42 and the write/protect tab 22 are attached by glue 55 applied at their interface.

Fig. 10 illustrates an eighth embodiment of the write/protect tab assembly 25 for a floppy disc jacket and a method for assembling same according to the present invention. In this embodiment, the tops of the sides of the tab 22 are slidingly encaptured by two guides 56 formed inwardly on the sides of the tab pocket 24.

In comparison with the prior art assembly and method described above, the present invention requires only simple modification of existing tooling and equipment, and does not visually or operationally change the write/protect protect tab characteristics. For example, after the jacket cover and base are welded together, a consumer or a technician is unable to perceive a difference in operation or the way the tab actually locks in the jacket.

In addition, the present invention offers much greater liberties in terms of how the write/protect tab can be handled during production. As discussed above, traditionally there were several areas in the assembly process where the tab would fall out when installed prior to securing the base to the cover, for example during quality testing of the floppy disc. With floppy disc acceptability levels presently ranging from 40% to 80%, the advantage of the tab being encaptured when the cover and base are separated can clearly be seen.

Further, as suggested above, since floppy disc manufacturers prefer to load their own floppy discs and prefer not to perform any preassembly such as insertion of the write/protect tab, the present invention allows shipment of a floppy disc jacket preassembled with the tab in place.

Finally, with the present invention, the actual initial method of placing the tab into the jacket base does not change. However, once in place, a finger on an assembly machine can, e.g., simply move the tab according to the first embodiment under the latch where it remains through the rest of the assembly process. In regard to the remaining embodiments two through eight, the write/protect tab is also reliably encaptured throughout production.

Claims

1. A floppy disc jacket assembly (14) including a substantially planar jacket base (18) and a write/protect tab (22) slidably mounted for movement from a first position to a second position parallel to the plane of the jacket base (18) in a tab pocket (24) formed in the jacket base (18), characterized by means (32, 34, 36, 38, 40, 44, 46, 48, 50, 52, 54, 55, 56) formed on the jacket base (14) and the write/protect tab (22) for encapturing said write/protect tab (22) relative to the jacket base (18) only in the first position before an upper half (16) is mounted on said jacket base (18), to prevent the tab from moving in a direction substantially perpendicular to the plane of the jacket base (18) only in the first position.

2. The assembly as recited in claim 1, characterized in that the encapturing means comprises :
   a latch (34) formed on the jacket base (18) for receiving a recess (36) formed in the write/protect tab (22) when said write protect tab (22) is slid into the first position.

3. The assembly as recited in claim 1, characterized in that the means for encapturing comprises :
   guides (56) formed at the tab pocket (24) for receiving in sliding relation the sides of the write/protect tab (22) when said write protect tab (22) is slid in the first position.

4. The assembly as recited in claim 1, characterized in that the means for encapturing comprises :
   shelf-like projections (40) formed on the tab pocket (24) for receiving corresponding elongated recesses (38) formed on the write/protect tab (22) when said write protect tab (22) is slid in the first position, said shelf like projections (40) being formed only on determined portions of the lateral edges of said tab pocket (24) corresponding to said first position of said write protect tab (22).

5. The assembly as recited in claim 1, character-

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...o pocket 24 being disposed between the write/protect tab 22 and the cap 42.

More particularly, as shown in Fig. 5, the cap 42 and the write/protect tab 22 are attached via snaps 44 formed on the cap 42, which are inserted through an opening 45 in the tab 22 and are received by corresponding recesses 46 formed at the sides of the write/protect tab 22.

In Fig. 6, the cap 42 and write/protect tab 22 are attached by press fitting the cap 42 into a corresponding opening 48 formed centrally of the rectangular body 26 of the write/protect tab 22.

In Fig. 7, the cap 42 and the write/protect tab 22 are attached via ultrasonic welding at their interface using a plurality of energy directors 50 which are known in the art.

In Fig. 8, the cap 42 and the write/protect tab 22 are attached by inserting a pair of swedging posts 52 formed in the cap 42 into corresponding ircular openings 54 formed in the write/protect tab 22.

Further, in Fig. 9, the cap 42 and the write/protect tab 22 are attached by glue 55 applied at their interface.

Fig. 10 illustrates an eighth embodiment of the write/protect tab assembly 25 for a floppy disc jacket and a method for assembling same according to the present invention. In this embodiment, the tops of the sides of the tab 22 are slidingly encaptured by two guides 56 formed inwardly on the sides of the tab pocket 24.

In comparison with the prior art assembly and method described above, the present invention requires only simple modification of existing tooling and equipment, and does not visually or operationally change the write/protect protect tab characteristics. For example, after the jacket cover and base are welded together, a consumer or a technician is able to perceive a difference in operation or the way the tab actually locks in the jacket.

In addition, the present invention offers much greater liberties in terms of how the write/protect tab can be handled during production. As discussed above, traditionally there were several areas in the assembly process where the tab would fall out when installed prior to securing the base to the cover, for example during quality testing of the floppy disc. With floppy disc acceptability levels presently ranging from 40% to 80%, the advantage of the tab being encaptured when the cover and base are separated can clearly be seen.

Further, as suggested above, since floppy disc manufacturers prefer to load their own floppy discs and prefer not to perform any preassembly such as insertion of the write/protect tab, the present invention allows shipment of a floppy disc jacket preassembled with the tab in place.

Finally, with the present invention, the actual initial method of placing the tab into the jacket base does not change. However, once in place, a finger on an assembly machine can, e.g., simply move the tab according to the first embodiment under the latch where it remains through the rest of the assembly process. In regard to the remaining embodiments two through eight, the write/protect tab is also reliably encaptured throughout production.

Claims

1. A floppy disc jacket assembly (14) including a substantially planar jacket base (18) and a write/protect tab (22) slidably mounted for movement from a first position to a second position parallel to the plane of the jacket base (18) in a tab pocket (24) formed in the jacket base (18), characterized by means (32, 34, 36, 38, 40, 44, 46, 48, 50, 52, 54, 55, 56) formed on the jacket base (14) and the write/protect tab (22) for encapturing said write/protect tab (22) relative to the jacket base (18) only in the first position before an upper half (16) is mounted on said jacket base (18), to prevent the tab from moving in a direction substantially perpendicular to the plane of the jacket base (18) only in the first position.

2. The assembly as recited in claim 1, characterized in that the encapturing means comprises :
   a latch (34) formed on the jacket base (18) for receiving a recess (36) formed in the write/protect tab (22) when said write protect tab (22) is slid into the first position.

3. The assembly as recited in claim 1, characterized in that the means for encapturing comprises :
   guides (56) formed at the tab pocket (24) for receiving in sliding relation the sides of the write/protect tab (22) when said write protect tab (22) is slid in the first position.

4. The assembly as recited in claim 1, characterized in that the means for encapturing comprises :
   shelf-like projections (40) formed on the tab pocket (24) for receiving corresponding elongated recesses (38) formed on the write/protect tab (22) when said write protect tab (22) is slid in the first position, said shelf like projections (40) being formed only on determined portions of the lateral edges of said tab pocket (24) corresponding to said first position of said write protect tab (22).

5. The assembly as recited in claim 1, character-

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ized in that the means for encapturing comprises :

shelf-like projections (40) formed only at determined portions of the lateral edges of said tab pocket (24) corresponding to said first position of said write/protect tab and a cap (42) attached to the write/protect tab (22), the shelf-like projections (40) being disposed between the write/protect tab (22) and the cap (42), when said write/protect tab (22) is slid in the first position.

6. The assembly as recited in claim 5, characterized in that the cap (42) and write/protect tab (22) are attached via snaps (44) formed on the cap (42) which are inserted through an opening (45) formed in the write/protect tab (22) and are received by corresponding recesses (46) formed in the write/protect tab (22).

7. The assembly as recited in claim 5, characterized in that the cap (42) and write/protect (22) are attached by press fitting the cap (42) into a corresponding opening (48) formed in the write/protect tab (22).

8. The assembly as recited in claim 5, characterized in that the cap (42) and write/protect tab (22) are attached via ultrasonic welding at their interface using energy directors (50) located on the cap (42).

9. The assembly as recited in claim 5, characterized in that the cap (42) and write/protect tab (22) are attached by inserting swedging posts (52) formed in the cap (42) into corresponding openings (54) formed in the write/protect tab (22).

10. The assembly as recited in claim 5, characterized in that the cap (42) and write/protect tab (22) are attached by glue (55) applied at their interface.

11. A method for assembling a write/protect tab (22) into a write/protect tab pocket (24) of a substantially planar floppy disc jacket base (18) so that the tab (22) can move from a first position to a second position parallel to the plane of the jacket base, characterized by the steps of forming means on the write/protect tab (22) for encapturing the tab (22) relative to the jacket base (18) to prevent the tab (22) from moving in a direction substantially perpendicular to the plane of the jacket base (18), only when the tab (22) is in the first position, moving the tab (22) in a direction perpendicular to the base (18) to engage the tab (22) and jacket base (18) in the second position, and moving the tab (22) parallel to the base to engage the means for encapturing such that the write/protect tab (22) does not fall out of the jacket base (18) while in the first position but before an upper jacket half (16) is mounted on said jacket base (18).

12. The method as recited in claim 11, characterized in that it further comprises the step of :

forming a latch (34) adjacent the tab pocket (24) for receiving the write/protect tab (22).

13. The method as recited in claim 11, characterized in that it further comprises the step of :

forming guides (56) at the tab pocket (24) for receiving in sliding relation the slides of the write/protect tab (22).

14. The method as recited in claim 11, characterized in that it further comprises the step of :

forming shelf-like projections (40) on the tab pocket (24) for receiving corresponding elongated recesses (38) , formed on the write/protect tab (22).

15. The method as recited in claim 11, characterized in that it further comprises the step of :

attaching a cap (42) to the write/protect tab (22) with the write/protect tab pocket (24) being disposed between the write/protect tab (22) and the cap (42).

16. The method as recited in claim 15, characterized in that the attaching step comprises the step of :

forming snaps (44) on the cap (42) for receiving corresponding recesses (46) formed in the write/protect tab (22).

17. The method as recited in claim 15, characterized in that the attaching step comprises the step of :

press fitting the cap (42) into a corresponding opening (48) formed in the write/protect tab (22).

18. The method as recited in claim 15, characterized in that the attaching step comprises the step of :

ultrasonically welding the cap (42) to the write/protect tab (22) using energy directors (50) located on the cap (42).

19. The method as recited in claim 15, characterized in that the attaching step comprises the step of :

inserting swedging posts (52) formed on

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the cap (42) into corresponding openings (54) formed in the write/protect tab (22).

20. The method as recited in claim 15, characterized in that the attaching step comprises the step of :

gluing the interface of the cap (42) and write/protect tab (22).

Revendications

1. Enveloppe (14) pour disque souple, comprenant une base sensiblement plane (18) d'enveloppe et une patte (22) de protection contre l'écriture montée afin qu'elle puisse coulisser d'une première position à une seconde position parallèlement au plan de la base (18) de l'enveloppe dans un logement (24) de patte formé dans la base (18) de l'enveloppe, caractérisée par des dispositifs (32, 34, 36, 38, 40, 44, 46, 48, 50, 52, 54, 55, 56) formés sur la base (14) de l'enveloppe et la patte (22) de protection contre l'écriture et destinés à capturer la patte (22) de protection contre l'écriture par rapport à la base (18) de l'enveloppe uniquement dans la première position avant qu'une moitié supérieure (16) soit montée sur la base (18) de l'enveloppe de manière que la patte ne puisse pas se déplacer en direction sensiblement perpendiculaire au plan de la base (18) de l'enveloppe uniquement dans la première position.

2. Enveloppe selon la revendication 1, caractérisée en ce que les dispositifs de capture comprennent :

un verrou (34) formé sur la base (18) de l'enveloppe et destiné à loger une cavité (36) formée dans la patte (22) de protection contre l'écriture lorsque cette patte (22) est glissée dans la première position.

3. Enveloppe selon la revendication 1, caractérisée en ce que les dispositifs de capture comprennent :

des guides (56) formés au niveau du logement (24) de la patte et destinés à loger les côtés de la patte (22) de protection contre l'écriture de manière qu'elle puisse coulisser, lorsque la patte (22) coulisse vers la première position.

4. Enveloppe selon la revendication 1, caractérisée en ce que les dispositifs de capture comprennent :

des saillies (40) en forme d'étagères formées dans le logement (24) et destinées à coopérer avec des cavités allongées correspondantes (38) formées sur la patte (22) de protection contre l'écriture lorsque cette patte (22) est glissée dans la première position, les saillies (40) analogues à des étagères étant formées uniquement sur des parties prédéterminées des bords latéraux du logement (24) de patte correspondant à la première position de la patte (22).

5. Enveloppe selon la revendication 1, caractérisée en ce que les dispositifs de capture comprennent :

des saillies (40) en forme d'étagères formées uniquement à des parties prédéterminées des bords latéraux du logement (24) de patte correspondant à la première position de la patte de protection contre l'écriture et un capuchon (42) fixé à la patte (22), les saillies (40) en forme d'étagères étant placées entre la patte (22) et le capuchon (42) lorsque la patte (22) de protection contre l'écriture est glissée dans la première position.

6. Enveloppe selon la revendication 5, caractérisée en ce que le capuchon (42) et la patte (22) sont fixés par des organes d'enclenchement (44) formés sur le capuchon (42) et qui pénètrent dans une ouverture (45) formée dans la patte (22) et sont logés par des cavités correspondantes (46) formées dans la patte (22).

7. Enveloppe selon la revendication 5, caractérisée en ce que le capuchon (42) et la patte (22) sont fixés par emmanchement à force du capuchon (42) dans une ouverture correspondante (48) formée dans la patte (22).

8. Enveloppe selon la revendication 5, caractérisée en ce que le capuchon (42) et la patte (22) sont fixés par soudage par ultrasons à leur interface à l'aide d'organes (50) de direction d'énergie placés sur le capuchon (42).

9. Enveloppe selon la revendication 5, caractérisée en ce que le capuchon (42) et la patte (22) sont fixés par introduction de plots (52) déformables réalisés sur le capuchon (42) dans des ouvertures correspondantes (54) formées dans la patte (22).

10. Enveloppe selon la revendication 5, caractérisée en ce que le capuchon (42) et la patte (22) sont fixés par de la colle (55) appliquée à leur interface.

11. Procédé de montage d'une patte (22) de protection contre l'écriture dans un logement (24) prévu pour cette patte dans une base sensible-

ment plane (18) d'une enveloppe de disque souple afin que la patte (22) puisse se déplacer d'une première position à une seconde position parallèlement au plan de la base de l'enveloppe, caractérisé en ce qu'il comprend les étapes suivantes :

la formation, sur la patte (22) de protection contre l'écriture seulement, d'un dispositif placés sur des parties prédéterminées des bords latéraux du logement (24) qui correspondent à la première position de la patte (22), afin que la patte (22) soit capturée par rapport à la base (18) et que la patte (22) ne puisse pas se déplacer en direction sensiblement perpendiculaire au plan de la base (18), uniquement lorsque la patte (22) est dans la première position, le déplacement de la patte (22) en direction perpendiculaire à la base (18) afin que la patte (22) et la base (18) soient mises en coopération dans la seconde position, et le déplacement de la patte (22) parallèlement à la base afin qu'elle mette en coopération le dispositif de capture, si bien que la patte (22) ne tombe pas de la base (18) lorsqu'elle est dans la première position, même avant que la moitié supérieure (16) de l'enveloppe ne soit montée sur la base (18).

12. Procédé selon la revendication 11, caractérisé en ce qu'il comprend en outre l'étape suivante :

la formation d'un verrou (34) près du logement (24) de patte destiné à loger la patte (22) de protection contre l'écriture.

13. Procédé selon la revendication 11, caractérisé en ce qu'il comporte en outre l'étape suivante :

la formation de guides (56) dans le logement (24) pour la coopération par coulissement avec des glissières de la patte (22) de protection contre l'écriture.

14. Procédé selon la revendication 11, caractérisé en ce qu'il comporte en outre l'étape suivante :

la formation de saillies (40) en forme d'étagères dans le logement (24) pour la coopération avec des cavités allongées correspondantes (38) formées sur la patte (22) de protection contre l'écriture.

15. Procédé selon la revendication 11, caractérisé en ce qu'il comprend en outre l'étape suivante :

la fixation d'un capuchon (42) à la patte (22), le logement (24) de patte étant placé entre la patte (22) et le capuchon (42).

16. Procédé selon la revendication 15, caractérisé en ce que l'étape de fixation comprend l'étape suivante :

la formation, sur le capuchon (42), d'organes (44) d'enclenchement destinés à coopérer avec des cavités correspondantes (46) formées dans la patte (22).

17. Procédé selon la revendication 15, caractérisé en ce que l'étape de fixation comprend l'étape suivante :

l'emmanchement à force du capuchon (42) dans une ouverture correspondante (48) formée dans la patte (22).

18. Procédé selon la revendication 15, caractérisé en ce que l'étape de fixation comprend l'étape suivante :

le soudage par ultrasons du capuchon (42) sur la patte (22) à l'aide d'organes (50) directeurs d'énergie placés sur le capuchon (42).

19. Procédé selon la revendication 15, caractérisé en ce que l'étape de fixation comprend l'étape suivante :

l'introduction de plots déformables (52) réalisés dans le capuchon (42) dans des ouvertures correspondantes (54) formées dans la patte (22) de protection contre l'écriture.

20. Procédé selon la revendication 15, caractérisé en ce que l'étape de fixation comprend l'étape suivante :

le collage de l'interface du capuchon (42) et de la patte (22) de protection contre l'écriture.

Patentansprüche

1. Diskettenhüllenanordnung (14) mit einer im wesentlichen ebenen Hüllenbasis (18) und einem Schreibschutzschieber (22), der zur Bewegung aus einer ersten Position in eine zweite Position parallel zu der Ebene der Hüllenbasis (18) in einer in der Hüllenbasis (18) ausgebildeten Schiebertasche (24) verschiebbar angeordnet ist, gekennzeichnet durch eine an der Hüllenbasis (14) und dem Schreibschutzschieber (22) ausgebildete Einrichtung (32, 34, 36, 38, 40, 44, 46, 48, 50, 52, 54, 55, 56), die den Schreibschutzschieber (22) relativ zu der Hüllenbasis (18) nur in der ersten Position vor Anordnen einer oberen Hälfte (16) auf der Hüllenbasis (18) festhält, um eine Bewegung des Schiebers in einer zu der Ebene der Hüllenbasis (18) im wesentlichen senkrechten Richtung nur in der ersten Position zu verhindern.

2. Anordnung nach Anspruch 1, dadurch gekenn-

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zeichnet, daß die Festhalteeinrichtung aufweist:

eine an der Hüllenbasis (18) ausgebildete Raste (34), die in einer in dem Schreibschutzschieber (22) ausgebildeten Ausnehmung (36) aufnehmbar ist, wenn dieser in die erste Position geschoben wird.

3. Anordnung nach Anspruch 1, dadurch gekennzeichnet, das die Festhalteeinrichtung aufweist:

an der Schiebertasche (24) ausgebildete Führungen (56), die die Seiten des Schreibschutzschiebers (22) gleitend aufnehmen, wenn dieser in die erste Position geschoben wird.

4. Anordnung nach Anspruch 1, dadurch gekennzeichnet, daß die Festhalteeinrichtung aufweist:

an der Schiebertasche (24) ausgebildete bandähnliche Vorsprünge (40), die in entsprechenden an dem Schreibschutzschieber (22) ausgebildeten langen Ausschnitten (38) aufnehmbar sind, wenn dieser in die erste Position geschoben wird, wobei die bandähnlichen Vorsprünge (40) nur an bestimmten Teilen der Seitenränder der Schiebertasche (24) ausgebildet sind, die der ersten Position des Schreibschutzschiebers (22) entsprechen.

5. Anordnung nach Anspruch 1, dadurch gekennzeichnet, daß die Festhalteeinrichtung aufweist:

bandähnliche Vorsprünge (40), die nur an bestimmten Teilen der Seitenränder der Schiebertasche (24) ausgebildet sind, die der ersten Position des Schreibschutzschiebers entsprechen, und eine an dem Schreibschutzschieber (22) befestigte Abdeckung (42), wobei die bandähnlichen Vorsprünge (40) zwischen dem Schreibschutzschieber (22) und der Abdekkung (42) positioniert sind, wenn der Schreibschutzschieber (22) in die erste Position geschoben wird.

6. Anordnung nach Anspruch 5, dadurch gekennzeichnet, daß die Abdeckung (42) und der Schreibschutzschieber (22) durch an der Abdeckung (42) ausgebildete Rastnasen (44) befestigt sind, die durch eine in dem Schreibschutzschieber (22) ausgebildete Öffnung (45) eingeführt und von entsprechenden in dem Schreibschutzschieber (22) ausgebildeten Aussparungen (46) aufgenommen sind.

7. Anordnung nach Anspruch 5, dadurch gekennzeichnet, daß die Abdeckung (42) und der Schreibschutzschieber (22) durch Einpressen der Abdeckung (42) in eine entsprechende in dem Schreibschutzschieber (22) ausgebildete Öffnung (48) befestigt sind.

8. Anordnung nach Anspruch 5, dadurch gekennzeichnet, daß die Abdeckung (42) und der Schreibschutzschieber (22) durch Ultraschallschweißen an ihrer Grenzfläche unter Verwendung von an der Abdeckung (42) angeordneten Energieleitelementen (50) befestigt sind.

9. Anordnung nach Anspruch 5, dadurch gekennzeichnet, daß die Abdeckung (42) und der Schreibschutzschieber (22) durch Einführen von in der Abdeckung (42) ausgebildeten Festlegestiften (52) in entsprechende in dem Schreibschutzschieber (22) ausgebildete Öffnungen (54) befestigt sind.

10. Anordnung nach Anspruch 5, dadurch gekennzeichnet, daß die Abdeckung (42) und der Schreibschutzschieber (22) durch auf ihre Grenzfläche aufgebrachten Kleber (55) befestigt sind.

11. Verfahren zur Montage eines Schreibschutzschiebers (22) in einer Schreibschutzschiebertasche (24) einer im wesentlichen ebenen Diskettenhüllenbasis (18) derart, daß der Schieber (22) aus einer ersten Position in eine zweite Position parallel zu der Ebene der Hüllenbasis bewegbar ist, gekennzeichnet durch folgende Schritte: Ausbilden von Einrichtungen an dem Schreibschutzschieber (22) nur an bestimmten Teilen der Seitenränder der Schiebertasche (24), die der ersten Position des Schreibschutzschiebers (22) entsprechen, zum Festhalten des Schiebers (22) relativ zu der Hüllenbasis (18), um eine Bewegung des Schiebers (22) in einer zu der Ebene der Hüllenbasis (18) im wesentlichen senkrechten Richtung nur dann zu verhindern, wenn der Schieber (22) in der ersten Position ist, Bewegen des Schiebers (22) in einer zu der Basis (18) senkrechten Richtung, um den Schieber (22) und die Hüllenbasis (18) in der zweiten Position in Verbindung zu bringen, und Bewegen des Schiebers (22) parallel zu der Basis, um die Festhalteeinrichtung in Eingriff zu bringen, so daß der Schreibschutzschieber (22) nicht aus der Hüllenbasis (18) herausfällt, während er in der ersten Position ist, jedoch bevor eine obere Hüllenhälfte (16) auf der Hüllenbasis (18) angeordnet wird.

12. Verfahren nach Anspruch 11, dadurch gekennzeichnet, daß es ferner folgenden Schritt umfaßt:

Ausbilden einer Raste (34) angrenzend an die Schiebertasche (24) zur Aufnahme des Schreibschutzschiebers (22).

13. Verfahren nach Anspruch 11, dadurch gekennzeichnet, daß es ferner folgenden Schritt umfaßt:

Ausbilden von Führungen (56) an der Schiebertasche (24) zur gleitenden Aufnahme der Gleitelemente des Schreibschutzschiebers (22).

14. Verfahren nach Anspruch 11, dadurch gekennzeichnet, daß es ferner folgenden Schritt umfaßt:

Ausbilden von bandähnlichen Vorsprüngen (40) an der Schiebertasche (24) zur Aufnahme in entsprechenden an dem Schreibschutzschieber ausgebildeten langen Ausschnitten (38).

15. Verfahren nach Anspruch 11, dadurch gekennzeichnet, daß es ferner folgenden Schritt umfaßt:

Befestigen einer Abdeckung (42) an dem Schreibschutzschieber (22), wobei die Schreibschutzschiebertasche (24) zwischen dem Schreibschutzschieber (22) und der Abdekkung (42) angeordnet ist.

16. Verfahren nach Anspruch 15, dadurch gekennzeichnet, daß der Befestigungsschritt folgenden Schritt umfaßt:

Ausbilden von Rastnasen (44) an der Abdeckung (42) zur Aufnahme in entsprechenden in dem Schreibschutzschieber (22) ausgebildeten Aussparungen (46).

17. Verfahren nach Anspruch 15, dadurch gekennzeichnet, daß der Befestigungsschritt folgenden Schritt umfaßt:

Einpressen der Abdeckung (42) in eine entsprechende in dem Schreibschutzschieber (22) ausgebildete Öffnung (48).

18. Verfahren nach Anspruch 15, dadurch gekennzeichnet, daß der Befestigungsschritt folgenden Schritt umfaßt:

Ultraschallschweißen der Abdeckung (42) an den Schreibschutzschieber (22) unter Verwendung von an der Abdeckung (42) angeordneten Energieleitelementen (50).

19. Verfahren nach Anspruch 15, dadurch gekennzeichnet, daß der Befestigungsschritt folgenden Schritt umfaßt:

Einführen von an der Abdeckung (42) ausgebildeten Festlegestiften (52) in entsprechende in dem Schreibschutzschieber (22) ausgebildete Öffnungen (54).

20. Verfahren nach Anspruch 15, dadurch gekennzeichnet, daß der Befestigungsschritt folgenden Schritt umfaßt:

Verkleben der Grenzfläche der Abdeckung (42) und des Schreibschutzschiebers (22).