

METHOD AND APPARATUS FOR PRODUCING A
LAMINATED VISCOELASTIC PRODUCT

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The present invention relates to a laminated product stamped out from a lamination formed by applying a viscoelastic material layer to one surface of a base material layer. Specifically, the present invention relates to a method and apparatus for producing this laminated product.

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Conventionally, as a method for producing a laminated product having a base element such as a metal, plastic or paper, and a viscoelastic element applied to one surface of the base element, commonly used is a fabrication process wherein the laminated product is stamped out by a press machine from a lamination formed by applying a viscoelastic material layer to one surface of a base material layer. Especially, when a thin small product should be stamped out, a push-back die machine is advantageously used; the push-back die machine being able to return a stamped-out product to a scrap part of a lamination so that the product can be temporarily supported on the scrap part. With reference to Fig. 10, an example of a conventional stamping out procedure for lamination by the push-back die machine will be explained below.

As shown in the drawing, a strip-shaped lamination 1 uncoiled from a roll state is intermittently fed between a die 2 and a stripper 3 of a push-back die machine. The die 2 and the stripper 3 fixedly hold the lamination 1, and move in the direction of an arrow



shown in the drawing under that condition, so as to advance a fixed punch 5 in a die hole 4 of the die 2. Thus, the lamination 1 is shorn by cutting edges 6 of both of the die 2 and punch 5, so that a laminated product formed by stamping out the lamination 1 into a predetermined configuration can be obtained. When this operation is continuously repeated, a large number of laminated products are stamped out from the strip-shaped lamination 1. A knock pin or a floater 7 is provided in the die hole 4 of the die 2 as a movable member which can be moved corresponding to the advance of the punch 5 into the die hole 4. In order to ensure flatness of the laminated product, each of an operational surface 8 of the punch 5 with the cutting edge 6 and an operational surface 9 of the knock pin 7 opposed to the operational surface 8 is formed to be a flat surface.

The knock pin 7 is normally placed so that the operational surface 9 thereof is somewhat retracted into the die hole 4 from the cutting edge 6 of the die 2 by biasing force of a spring (not shown) connected to the end portion opposite to the operational surface 9, and is pushed further into the die hole 4 against the force of the spring by the punch 5 advancing therein. After the laminated product has been stamped out, when the die 2 and the stripper 3 are returned and the punch 5 is moved out of the die hole 4, the knock pin 7 is returned to the initial position by the spring force so as to put the stamped-out laminated product again on a scrap part of the lamination 1. In this way, the strip-shaped lamination supporting the stamped-out laminated products in the somewhat raised condition can be obtained by the function of the knock pin 7.

A damping member for a metallic leaf spring (gimbal spring) which supports a magnetic head of a hard disk device is known as an example of a laminated product produced by the stamp-out process described



above. In the hard disk device, since the gimbal spring vibrates with the magnetic head when the disk starts, it is desirable to damp the vibration in as short time as possible so as to realize quick response of the device. As a damping means to this end, so called a constraining type damping member is employed, which has a construction wherein a small metallic plate, that is, a constraining plate made of the same material or preferably a material having the same stiffness as that of a leaf spring is affixed to the leaf spring through a viscoelastic element, and thus quickly damps the vibration of the leaf spring in cooperation with the viscoelastic element. This kind of damping member is stamped out from the lamination which has a metallic base material layer forming the constraining plate and a viscoelastic material layer applied to one surface of the base material layer, and which, in general, also has a release layer applied to the other surface of the viscoelastic material layer, into a predetermined configuration and dimensions by a pushback die machine.

In a stamp-out process performed by the conventional pushback die machine for stamping out a laminated product, such as the above-mentioned damping member, from the lamination formed by applying the viscoelastic material layer to the base material layer, when the punch is brought into contact with the viscoelastic material layer to shear the lamination, the base element of the laminated product is subjected to deformation along with the deformation of the viscoelastic material layer, and thus causes bent-edges thereof over the viscoelastic element. In the case of a damping member, when the bent-edges of the constraining plate as a base element extend up to the reverse side of the viscoelastic element, failure in adhesion or deterioration in damping function may be caused.



On the contrary, when the punch is brought into contact with the base material layer of the lamination to shear the latter, the viscoelastic element of the laminated product is pulled into a clearance between the cutting edges and stamped out, in a larger area than that of the base element, and burrs are caused on the element on the side opposite to the viscoelastic element. When the product stamped out under such a condition is adhered on an objective body, the viscoelastic element protrudes from the periphery of the base element, thereby deteriorating the appearance thereof and causing the disadvantages of dust adhesion. In the case of a damping member, the dust adhesion, and subsequent sloughing onto the disk surface may result in the failure of the hard disk device, therefore, after the product has adhered on the object body, the protruding viscoelastic element must be cleaned and removed. Further, when the product must be peeled off again because of, e.g., the error of adhesion on the object, it is difficult to peel off the product due to the squeeze-out of the viscoelastic element from the periphery of the base element. Furthermore, in the aforementioned process, when the stamped-out product is returned to the scrap part of the lamination by the function of the knock pin, the base element of the product is disposed in a depressed state from the base material layer of the scrap part. Accordingly, when the product is taken out therefrom, it is normally adhered onto another body, and the scrap portion is removed. This requires a great deal of time.

In order to solve the aforementioned problems in the stamp-out process, an alternate approach would be one in which the base element and the viscoelastic element are independently stamped out, and then both are adhered to each other so as to form a laminated product. However, according to this method, the number of working processes and thus the working time and



production cost are increased, and defective products may be produced by an incorrect laminated operation, even if each member has been correctly stamped out.

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The present invention provides a method and apparatus for producing a laminated product having a base element and a viscoelastic element applied to one surface of the base element, from a strip of the laminated product material. The methods include the steps of: (a) providing a die having a die hole, the die hole having the desired profile of the laminated product; (b) providing a punch for insertion into the die hole, the punch having an operational surface; (c) providing a movable member having an operational surface and slidably mounted in the die hole and resiliently biased outwardly thereof; (d) providing a protruding edge member projecting from one of

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(i) the operational surface of the punch,

(ii) the operational surface of the movable member,

25 (iii) the die about the periphery of the die hole;

(e) locating the strip of laminated product material between said punch and the die hole of the die, with the viscoelastic element facing the protruding edge member; (f) advancing the operational surface of the punch into contact with the strip of laminated product material so that the viscoelastic layer contacts the protruding edge member; (g) penetrating the viscoelastic layer with the protruding edge; and (h) advancing the punch further into the die hole through the strip of laminated product material to punch a laminated product with a profile corresponding

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to the profile of the die hole, the laminated product being resiliently supported within the die hole by the movable member.

The method of the present invention may, in one
5 embodiment, include the further steps of: (i)
retracting the punch from the die hole; and (j)
releasably adhering the laminated product to the strip
of laminated product material.

The method of the present invention may, in
10 another embodiment, further include the step of
locating the protruding edge member so that the
viscoelastic element of the laminated product produced
thereby is recessed from a peripheral edge of the base
element forming a single layer portion of the laminated
15 product.

The present invention also provides a laminated
product having a base element and a viscoelastic
element applied to one surface of the base element,
produced by the method described herein. Further, the
20 present invention also provides a plurality of
laminated products, each having a base element and a
viscoelastic element applied to one surface of the base
element, with the plurality of laminated products
releasably adhered to a strip of laminated product
25 material, produced by the method of the present
invention.

The present invention further provides apparatus
for producing a laminated product having a base element
and a viscoelastic element applied to one surface of
30 the base element, from a strip of the laminated product
material. The apparatus includes a die having a die
hole, the die hole having the desired profile of the
laminated product. A punch is also provided for
insertion into the die hole, the punch having an
35 operational surface. A movable member is provided
having an operational surface, slidably mounted in the
die hole. Means are provided for resiliently biasing



the movable member outwardly thereof. The apparatus further includes a protruding edge member projecting from one of

- 5 (i) the operational surface of the punch,
- (ii) the operational surface of the movable member,
- (iii) the die about the periphery of the die hole.

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Means are provided for locating the strip of laminated product material between the punch and the die hole of the die, with the viscoelastic element facing the protruding edge member. Means are provided

15 for advancing the operational surface of the punch into contact with the strip of laminated product material so that the viscoelastic layer contacts the protruding edge member, thereby penetrating the viscoelastic layer with the protruding edge, and to advance the punch

20 further into the die hole through the strip of laminated product material to punch a laminated product with a profile corresponding to the profile of the die hole, the laminated product being resiliently supported within the die hole by the movable member.

25 In one embodiment of the apparatus of this invention, the advancing means further includes means for retracting the punch from the die hole thereby releasably re-adhering the laminated product to the strip of laminated product material.

30 In another embodiment of the apparatus of this invention, the apparatus of claim 15, wherein the protruding edge member is positioned so that the viscoelastic element of the laminated product produced thereby is recessed from a peripheral edge of the base

35 element, forming a single layer portion of the laminated product.



Figure 6a is a perspective view of a damping member stamped out by the method of the present invention;

Figure 6b is a sectional view of the damping member of Figure 6a taken along plane 6b-6b;

Figure 7 is a perspective view of a punch according to the present invention for producing the damping member shown in Figures 6a and 6b;

Figures 8a-8d are sequential views of a method for producing the damping member of Figures 6a and 6b using the punch of Figure 7;

Figure 9a is a perspective view of a strip of laminated product produced by the method shown in Figures 8a-8d;

Figure 9b is a cross sectional view of the strip of laminated product taken along line 9b-9b; and

Figure 10 is a cross sectional view of a conventional apparatus for producing a laminated product.

The present invention will be explained in further detail with reference to preferred embodiments shown in the attached drawings.

The method for producing a laminated product according to the embodiment of the present invention is performed, in one embodiment, by using a new punch having an operational surface, the configuration of which is different from that of the conventional punch 5, in the conventional push-back die machine (shown in Fig. 10). Referring to Fig. 1, this punch 10 is provided with an operational surface 12, the planar profile of which is generally similar to that of the base element of a laminated product to be stamped out. A protruding edge portion 14 projecting from the operational surface 12 is provided at the outer



peripheral edge of the operational surface 12, and thus forms a depression 16 of a predetermined volume on the operational surface 12. The depression 16 acts as an escape space of the viscoelastic element of the

5 laminated product in the stamp-out process described later. Accordingly, the configuration and volume of the viscoelastic element of the laminated product after stamped out are determined by the configuration and volume of the depression 16. Preferably, in this case,

10 the height of the protruding edge portion 14 is at least the same as the thickness of the viscoelastic element of the laminated product, and the area of a top surface 18 of the protruding edge portion 14, which is a part of the operational surface 12, is preferably 20

15 to 40% of the entire operational surface 12.

A laminated product 20 shown in Fig. 2 is stamped out by a push-back die machine having the punch 10. The laminated product 20 includes a base element 22 made of any suitable material including, but not

20 limited to, metal, plastic or paper, and a viscoelastic element 24 applied to one surface of the base element 22. Corresponding to the kind of material of the base element 22 and the viscoelastic element 24, the laminated product 20 can be used for the damping member

25 described above, or for, e.g., a heat-resisting film, a reinforcing tape, or a decorative film.

The base element 22 of the laminated product 20, which has a rectangular surface, is formed flat in entirety with minimal burrs on the peripheral edge.

30 From the view point of stamp-out processability, the thickness of the base element 22 is preferably 1 to 5000 μm . In accordance with the use of the laminated product 20, the viscoelastic element 24 can be composed of various materials. However, in the case that a

35 laminated product must have an adhesiveness such as the damping member, the viscoelastic element is preferably made of an adhesive material, but non-adhesive



viscoelastic materials may also be used and adhered with a separate adhesive layer. One of the preferred examples is a foamed pressure-sensitive adhesive disclosed in Japanese Examined Patent Publication (Kokoku) No.57-17030. From the viewpoint of adhesion properties, the thickness of the viscoelastic element 24 is preferably 25 to 1000 μ m. The viscoelastic element 24 has a peripheral edge 26 thereof, which is preferably disposed on the applied surface and inside the outer peripheral edge of the base element 22. Therefore, a single-layer edge region 28 formed only by the base element 22 is defined at the entire peripheral edge of the base element 22. The single-layer edge region 28 is automatically formed by the function of the protruding edge portion 14 of the punch 10 in the stamp-out process. The squeeze-out of the viscoelastic element 24 from the peripheral edge of the base element 22 is prevented in the laminated product 20 having the single-layer edge region 28, so that disadvantages such as dust adhesion can be avoided. Further, when the laminated product 20 should be peeled off again, the single-layer edge region 28 serves as a catch and facilitates the peeling-off of the laminated product 20. Note, the width of the single-layer edge region 28, that is, the distance between the edge portion of the base element 22 and the peripheral edge portion 26 of the viscoelastic element 24 is preferably in the order from 0.03 to 10 mm. However, it will be recognized that distances substantially less than 0.03 mm, or even an embodiment where the edge of the viscoelastic element and the edge of the base element are substantially coextensive, may be achieved according to the present invention, if desired.

The operation of the push-back die machine having the punch 10 for stamping out the laminated product 20 will be explained with reference to Figures 3a-3d.



A strip-shaped lamination 30 formed by applying a viscoelastic material layer 24' to one surface of a base material layer 22' is intermittently fed between a die 32 and a stripper 34 of the push-back die machine.

5 During the stamp-out process, the lamination 30 is fixedly held between the die 32 and the stripper 34. At this time, the viscoelastic material layer 24' of the lamination 30 is disposed opposite to the punch 10.

The die 32 and the stripper 34 are moved as shown
10 by arrows in the drawing, so that the operational surface 12 of the punch 10 is brought into contact with the viscoelastic material layer 24' and the lamination 30 is held between the operational surface 12 of the punch 10 and the operational flat surface 38 of the
15 knock pin or floater 36 that is a movable member. The knock pin 36 is biased by a spring (not shown) towards the punch 10. During the time that the punch 10 advances into the die hole 33 of the die 32 and displaces the knock pin 36 relative to the die 32
20 against the spring force, the viscoelastic material layer 24' of the lamination 30 is compressed at the portion thereof which comes into contact with the protruding edge portion 14 of the punch 10, and the viscoelastic material layer 24' is housed within the
25 depression 16 in an un-compressed manner.

When the die 32 and the stripper 34 are further moved, the punch 10 and the knock pin 36 are relatively displaced deep in the die hole 33 while holding the lamination 30 therebetween. Following those action,
30 the lamination 30 is shorn between the cutting edge 40 of the punch 10 and the cutting edge 42 of the die 32, and thus forming the laminated product 20. At this time, the portion of the viscoelastic material layer 24', which comes into contact with the protruding edge
35 portion 14 of the punch 10, is almost completely removed by the compression. Consequently, in the laminated product 20, only the portion of the



viscoelastic material, layer 24' housed in the depression 16 of the punch 10 is formed as the viscoelastic element 24, and a single-layer edge region 28 formed only by the base element 22 is defined at the entire peripheral edge of the base element 22.

Therefore, in the stamp-out process, the base element 22 is subjected to the substantially same shearing action as in the case where only a single-layer of the base element 22 is stamped out, and thus minimizing burrs or bent-edges in the base element 22. At the same time, the flatness of the base element 22 can be maintained due to the flatness of the operational flat surface 38 of the knock pin 36.

After the laminated product 20 has been stamped out, when the die 32 and the stripper 34 are moved backward, the punch 10 is pulled out from the die hole 33, and the knock pin 36 is returned to the initial position in the die hole 33 by the spring force and thus puts the stamped-out laminated product 20 again on the scrap part of the lamination 30. Consequently, the laminated product 20 is held by the strip-shaped lamination 30 under the condition that the base element 22 is somewhat raised from the base material layer 22' of the scrap part.

The aforementioned stamp-out procedure is repeated, and thus, as shown in Fig. 4, a plurality of laminated products 20 are formed in the strip-shaped lamination 30 under the condition that the base element 22 is somewhat raised from the base material layer 22' of the scrap part. The laminated products 20 can be stored, transported and sold under those conditions. Further, the laminated products 20 are releasably re-adhered to the strip and thus can be easily taken out from the lamination 30 because the base element 22 is raised from the base material layer 22' of the scrap part. In general, preferably a release layer is applied to the viscoelastic material layer 24' of the



lamination 30 and should be synchronously stamped out. According to the aforementioned procedure, by bringing the punch 10 into contact with the release layer, the laminated product 20 (with a release layer) having the
5 single-layer edge region 28 can be obtained in the same manner.

In the above embodiment, the laminated product 20 is obtained by using the punch 10 which has the protruding edge portion 14 and the depression 16 on the
10 operational surface 12. However, according to the present invention, a corresponding protruding edge 14' and depression may be provided on the operational surface 38 of the knock pin or floater instead of the punch (as shown in Figure 3e). Note, in this case, the
15 viscoelastic material layer of the lamination is disposed opposite to the knock pin, and the punch is brought into contact with the base material layer, and thus shearing the lamination. The arrangement of the knock pin or floater and the punch, and the operation
20 thereof, is substantially identical in all other respects to that shown in Figures 3a, 3b, 3c and 3d and substantially as described herein with respect thereto.

Another alternate embodiment of the present invention is shown in Figure 3f, wherein a protruding
25 edge 14'' projects from the die about the periphery of the die hole. Note, in this case, the viscoelastic material layer of the lamination is also disposed opposite to the knock pin, and the punch is brought into contact with the base material layer, and thus
30 shearing the lamination. The arrangement of the knock pin or floater and the punch, and the operation thereof, is substantially identical in all other respects to that shown in Figures 3a, 3b, 3c and 3d, as well as Figure 3e, and substantially as described
35 herein with respect thereto.

In the procedures, the base material layer is also subjected to substantially the same shearing action as



in the case where a single-layer is stamped out. Therefore, burrs and bent-edges are minimized in the base element of the product, and the flatness of the base element can be maintained by the flatness of the operational surface of the punch. Further, in the above embodiments, a press machine having a movable die and stripper and the fixed punch is used, but, on the contrary, a press machine having a movable punch moving relative to the fixed die and stripper can be used.

Various profiles shown in Figures 5a - 5f are proposed for the operational surface of the punch or the knock pin. The punch 44 shown in Figures 5a and 5b is used for cutting a strip-shaped lamination having the width generally same as width W of the punch 44 into pieces, the length of which is approximately L . In this case, single-layer edge regions of the base element are formed on both longitudinal edge portions of the laminated product. In this case, the lateral side edges of the laminated product do not have a single layer portion, but the viscoelastic layer extends fully to the edge of the base layer. The punch 46 shown in Figures 5c and 5d can stamp out a laminated product having a single-layer edge region with extremely narrow width of, e.g., approximately 0.1 mm. or less (e.g. flush around the entire periphery of the base layer). Also, in this case, the squeeze-out of the viscoelastic element can be prevented by the depression 48 formed on the operational surface of the punch 46. The punch 50 shown in Figures 5e and 5f is used for stamping out a laminated product having a relatively wide single-layer edge region on the two sides: In addition to those described above, the punch and the knock pin may be provided with another operational surface, the planar profile of which is circular, polygonal and other complicated shapes. Note, in any cases including the embodiment described above, to ensure a precision stamp-out process, at



least the cutting edge portions of the punch and the die are preferably made of a hardened material, such as carbide material.

Figures 6a and 6b show a damping member 52 according to the embodiment of the present invention, which is stamped out by the aforementioned procedure. The damping member 52 is used for damping a gimbal spring adapted to support the head of a hard disk device, and is formed by applying a viscoelastic material layer 56 made of a foamed pressure-sensitive adhesive to one surface of a constraining plate 54 made of hard metallic material such as stainless steel. Preferably, the constraining plate 54 is made of material having the same rigidity as that of an object to be damped (in this case, a gimbal spring), and has the thickness and surface area of such a degree that the damping function is not deteriorated by the weight thereof. The foamed pressure-sensitive adhesive disclosed in Japanese Examined Patent Publication (Kokoku) No. 57-17030 is preferably used for the viscoelastic element 56. This foamed pressure-sensitive adhesive has high adhesion (not less than 300g/25mm), high heat-resistance (100°C X not less than 1000 hours) and excellent damping properties.

The constraining plate 54 of the damping member 52 is formed flat as a whole, and provided with a through-hole 58 for wiring at the center thereof. The viscoelastic element 56 has a peripheral edge portion 60 thereof which is disposed on the applied surface of the constraining plate 54 and inside the periphery of the constraining plate 54. Consequently, a single-layer edge region 62 formed only by the constraining plate 54 is defined at the entire periphery of the damping member 52. Therefore, the damping member 52 can prevent the deterioration of damping properties by the flatness of the constraining plate 54, and can minimize the squeeze-out of the viscoelastic element 56



from the periphery of the constraining plate 54 by arrangement of the single-layer edge region 62 and thus minimizes the fear of dust adhesion, and thereby improving the reliability of the hard disk device.

5 For producing the damping member 52, a punch 64 (or knock pin) shown in Fig. 7 is used. The punch 64 is provided with an operational surface 66 having the planar profile generally similar to that of the constraining plate 54, and a protruding edge portion 68
10 projects from the operational surface 66 at the outer periphery of the operational surface 66. A die hole 70 which acts as a die for forming a through-hole 58 of the constraining plate 54 is formed at the generally center of the operational surface 66, and a protruding
15 edge portion 72 which projects from the operational surface 66 is formed around the die hole 70. Consequently, a depression 74 for housing the viscoelastic element 56 in the stamp-out process of the damping member 52 is formed on the operational surface
20 66 of the punch 64 by the protruding edge portions 68 and 72.

Figures 8a - 8d show an operation of a push-back die machine having the punch 64 in a stamp-out process of the damping member 52. However, the explanation of
25 each step is substantially the same as that in the case of Figures 3a - 3d and thus omitted. Note, in the case shown in Figures 8a - 8d, the lamination 76, from which the damping member 52 is obtained, includes a release layer 78' further applied to a viscoelastic material
30 layer 56'. The release layer 78' is made of, e.g., a PET (polyethylene terephthalate) film, a paper, a polyethylene film, or a polypropylene film, which are treated for releasability. In the damping member 52, because the pressure-sensitive adhesive, such as a
35 foamed pressure sensitive adhesive, composing the viscoelastic element 56 has high adhesion, it is advantageously to stamp out the lamination under the



condition that the release layer 78' is laminated thereon, so as to prevent the adhesion between the viscoelastic element 56 and the punch 64. Further, the push-back die machine shown in Fig. 8 has a punch 80 at a predetermined position in a knock pin 82, which is adapted to form a through-hole 58 in the damping member 52. When the punch 64 and the knock pin 82 are advanced into the die hole according to the movement of the die 32 and the stripper 34, the punch 80 protrudes from the operational surface of the knock pin 82, and thus punches out the through-hole 58 in the constraining plate 54 in cooperation with the die hole 70 of the punch 64. At this time, the single-layer edge region 62 is also defined around the through-hole 58 by the function the protruding edge portion 72 provided around the die hole 70 (see Fig. 6).

According to the aforementioned process, a plurality of damping matters 52 are formed in the strip-shaped lamination 76 under the condition that the constraining plates 54 are somewhat raised from the base material layer 54' of the scrap part, as shown in Figures 9a and 9b. To hold the damping members 52 in the strip-shaped lamination and to peel off the release layer 78 when each damping member 52 is taken out, an adhesive tape (not shown) is preferably attached to the release layer 78' of the lamination 76. Alternatively, if desired, each laminated product may be fully stamped out from the strip-shaped lamination 30.

As can be seen from the above description, according to the laminated products of the present invention, the squeeze-out of the viscoelastic element from the periphery of the base element can be eliminated, so that the appearance of the laminated product after being adhered can be improved, and the need for additional treatment is reduced. Further, according to the present invention, the method for producing a laminated product which has a base element



and a viscoelastic element applied to one surface of the base element is improved, so that burrs or bent-edges of the base element and squeeze-out of the viscoelastic element from the periphery of the base element can be minimized, and that the base material layer and the viscoelastic material layer can be stamped out together from the lamination in which both layers are adhered to each other. Therefore, the laminated product produced by the method of the present invention has no necessity for removing the viscoelastic element after being adhered to an objective body, and can be easily peeled off again therefrom. In this way, the handling of laminated layer products is improved and the production cost thereof is reduced. Further, in the damping member produced by the present method, the viscoelastic element is not squeezed out from the periphery of the constraining plate, so that the removing work such as cleaning is minimized, and that the deterioration of damping function and the problem of dust adhesion is minimized, and thus improving the reliability of a hard disk device.

The present invention has now been described with reference to several embodiments thereof. It will be apparent to those skilled in the art that many changes can be made in the embodiments described without departing from the scope of the invention. Thus, the scope of the present invention should not be limited to the structures described herein, but only by structures described by the language of the claims and the equivalents of those structures.



CLAIMS

1. A method for producing a laminated product having a base element and a viscoelastic element applied to one surface of the base element, from a strip of the laminated product material, the method including the steps of:

(a) providing a die having a die hole, the die hole having the desired profile of the laminated product;

(b) providing a punch for insertion into the die hole, the punch having an operational surface;

(c) providing a movable member having an operational surface and slidably mounted in the die hole and resiliently biased outwardly thereof;

(d) locating the strip of laminated product material between said punch and the die hole of the die, with the viscoelastic element facing the protruding edge member;

(e) advancing the operational surface of the punch into contact with the strip of laminated product material so that the viscoelastic layer contacts the protruding edge member;

(f) advancing the punch further into the die hole through the strip of laminated product material to punch a laminated product with a profile corresponding to the profile of the die hole, the laminated product being resiliently supported within the die hole by the movable member;



the Invention characterized by the steps of:

(g) providing a protruding edge member
projecting from one of

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(i) the operational surface of the
punch,

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(ii) the operational surface of the
movable member,

(iii) the die about the periphery of the
die hole; and

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(h) penetrating the viscoelastic layer with
the protruding edge.

2. The method of claim 1, further characterized
20 by the steps of:

(i) retracting the punch from the die hole;
and

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(j) releasably adhering the laminated product
to the strip of laminated product material.

3. The method of claim 1, further characterized
by the step of locating the protruding edge member so
30 that the viscoelastic element of the laminated product
produced thereby is recessed from a peripheral edge of
the base element forming a single layer portion of the
laminated product.

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4. Apparatus for producing a laminated product
having a base element and a viscoelastic element



applied to one surface of the base element, from a strip of the laminated product material, comprising:

5 (a) a die having a die hole, said die hole having the desired profile of the laminated product;

(b) a punch for insertion into said die hole, said punch having an operational surface;

10 (c) a movable member having an operational surface and slidably mounted in said die hole and including means for resiliently biasing said movable member outwardly thereof;

15 characterized in that the apparatus further comprises:

(d) a protruding edge member projecting from one of

20 (i) said operational surface of said punch,

(ii) said operational surface of said movable member,

(iii) said die about said periphery of said die hole,

30 (e) means for locating the strip of laminated product material between said punch and said die hole of said die, with the viscoelastic element facing said protruding edge member; and,

35 (f) means for advancing said operational surface of the punch into contact with the strip of laminated product material so that the



viscoelastic layer contacts said protruding edge member and thereby penetrate the viscoelastic layer with the protruding edge, and to advance the punch further into the into the die hole through the strip of laminated product material to punch a laminated product with a profile corresponding to the profile of the die hole, the laminated product being resiliently supported within the die hole by the movable member.

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5 5. The apparatus of claim 4, further characterized in that said advancing means further includes means for retracting the punch from the die hole thereby releasably adhering the laminated product to the strip of laminated product material.

6. The apparatus of claim 4, further characterized in that said protruding edge member is positioned so that the viscoelastic element of the laminated product produced thereby is recessed from a peripheral edge of the base element, forming a single layer portion of the laminated product.

25 7. A method for producing a laminated product as claimed in Claim 1 substantially as herein described with reference to the accompanying drawings.

8. Apparatus as claimed in Claim 4 substantially as herein described with reference to the accompanying drawings.



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