

Specification:

Form for rotary printing, coating or embossing of sheet-like materials, and process for producing said form

The invention relates to a form for the rotary machine printing, coating or imprinting of web-shaped materials, wherein at a carrier having a cylindrical surface area an elastomer layer is attached which after curing at the outer circumference thereof is machined to give a cylindrical shape, and engraved. Furthermore the invention relates to a method for manufacturing the form.

Forms of the kind mentioned before are used for different applications. In an embodiment as a printing form, e.g. for letterpress printing, in particular for flexographic printing, the outer surface of the engraved elastomer layer forms the colour transferring surface. For this reason various requirements are made for the elastomer layer and the surface thereof, e.g. it must have a sufficient resistance against solvents eventually present in the printing paint, a good dynamic performance, and colour transfer performance, and a small swelling under the influence of printing paints, and after the printing process it must be easily and simply cleaned from the printing paint. The requirements are similar when the form is used for coating processes, e.g. as a transfer roller for flatbed printing, in particular off-set printing. The term "coating" is to be understood in

particular for the transfer of printing paints in the printing processes, in particular for flexographic printing, as well as the transfer of e.g. varnishes or glues onto web-shaped materials. Depending on the requirement a transfer across the complete surface, and also a transfer only onto selected surface areas is possible. When the form is used as an imprinting form the elastomer layer in particular has to comprise a good dimension stability, and wear resistance even at the common temperatures of the material to be imprinted in imprinting processes, as well as a good separating performance in order to imprint web-shaped materials with a sufficient economy. Independent from the envisioned application of the form in any case the elastomer layer must be well engraveable. The web-shaped materials to be printed with such a form, coated, or to be imprinted, as an example may be paper or textile webs, metal or plastic foils or compound materials comprising different materials.

Hitherto elastomer layers fulfilling all mentioned requirements on the form could only be produced by vulcanization of elastomer compounds onto temperature stable carriers at a high temperature. The temperatures required for the vulcanization, in practical operation at least 140°C, require the stock holding of appropriate devices for manufacturing the forms wherein particularly large printing forms having a length up to several meters and a circumference up to about 2 m require complicated heating devices. Therein correspondingly high energy costs are necessary for generating the required heat. As also the carrier onto which the elastomer layer is applied has to withstand the temperatures occurring during the vulcanization without damage the selection of material for the carrier is considerably restricted namely to materials having a sufficient temperature stability. For practical reasons almost only metallic carriers may be used, whereas plastic carriers which

would be preferred because of their smaller weight can hardly be used. Only premium glass fiber reinforced plastic materials may cope with the high temperatures occurring during the vulcanization over the required time span. Hollow cylindrical light weight carriers may be procured of these glass fiber reinforced plastic materials onto which the elastomer layer may be vulcanized, however, there is the disadvantage, that the possible variation in thickness of the carrier is very limited. Therefore only relatively small repeat length areas may be covered in hollow cylindrical forms with a defined inner diameter for a certain firm mandrel roller outer diameter. In practical experience it therefore happens, that in factories using the forms a very large number of different mandrel rollers have to be kept in stock. These mandrel rollers are expensive and require large warehouse space.

It is the object of the present invention to provide a form of the kind mentioned before which is to be produced in a simple and inexpensive way with the required features, and wherein for the carrier practically any materials may be used. It is a further object to provide a method of the kind mentioned before wherein the manufacturing of a form for the rotary machine printing, coating or imprinting of web-shaped materials is possible, which requires no high temperatures in its application, and wherein the selection of materials required by the carrier is not restricted by the necessity of a high temperature resistance. Therein also sleeve-shaped forms are to be produced with the method wherein a large repeat length area may be covered with a defined mandrel roller, i.e. wherein the thickness of the form may vary in relatively large ranges.

According to the invention the first part of the object is attained with a form of the aforementioned kind which

is characterized in that the elastomer layer is formed of a cold cure material.

Preferably the material forming the elastomer layer is a single-component or two-component silicone polymer or a single-component or two-component polyurethane or a mixture of two or more of the materials mentioned.

The object relating to the method according to the invention is attained in a method of the aforementioned kind which is characterized in that for forming the elastomer layer a cold cure material is used.

The term "cold cure" is to be understood such that the temperatures occurring in curing the material and/or to be applied must not exceed 80°C.

Preferred materials for the method according to the invention are stated in the claims 6 to 8.

It was a surprise that cold cure materials or material mixtures, in particular the specific materials according to the claims quoted are suitable for generating an elastomer layer of a form for the rotary machine printing, coating or imprinting of web-shaped materials although it was hitherto the unique opinion of the experts that an elastomer layer fulfilling all requirements could not be produced with cold cure materials. The essential advantage of the form and the method according to the invention is that the application of high temperatures and eventually even a heating device for lower temperatures are no longer required. Therefore to a far degree temperature related restrictions in the selection of materials for the carrier are no longer valid. Therefore completely new materials may be used for the carrier which hitherto were excluded for this purpose. In particular plastic materials come in mind which hitherto

could not be used because of their lower heat resistance in this area of the manufacture of forms in relation to metals. The use of plastic materials instead of metals for the carrier renders considerable reductions in weight which facilitates the transport and the handling of forms to a high degree. It is a further advantage that now the carriers may be produced with largely different material thicknesses when producing sleeve-shaped carriers and forms such that with a preset inner diameter of the carrier very different repeat lengths may be covered. Therein for the user of the sleeve-shaped forms the number of mandrel rollers to be kept in stock is reduced. At the same time the possibility remains to use metallic carriers as the elastomer layer of the cold cure materials cited sticks to a carrier of plastic material as well as to a carrier of metal after curing with a durability which is absolutely sufficient for practical operation.

The forms preferably are seamless forms; as an alternative the elastomer layer may be firstly generated in a flat shape, and then bent onto the carrier and e.g. bonded.

When the material for forming the elastomer layer is used in form of a single-component material it may be handled relatively easy and its stock holding, processing and application onto the carrier requires only a relatively small technical effort. At the other side single-component material have to be given a longer curing time or eventually heating devices for temperatures up to 80°C are required.

As an alternative the material can be used as a two-component material. As an advantage the curing time is shorter enabling a higher productivity and lower manufacturing costs for the form. At the other side the use

of two-component material requires a somewhat higher technical effort for the stock holding, processing and application, however, this is soon compensated when producing high numbers of forms.

Furthermore it is preferably provided that the material for forming the elastomer layer is attached to the carrier in a liquid or pasty state. By this state of the material during the application onto the carrier a simple handling will result contributing to a high productivity of the method and to its economy.

An embodiment of the alternative method described last provides that when using a single-component material this material is processed in a single-component dosing device, and that when using a two-component material the components of this material, and when using a mixture of two or more materials these materials are processed and prepared in a multi-component dose and mixing device. The use of such a device renders the process according to the invention technically relatively simple and reliable and provides for an inexpensive and low hazard operation and therein for a correspondingly inexpensive application of the method. Selectively a dynamic, driven mixing device or a static mixer can be used for the mixing operation.

Furthermore the process provides that the material for forming the elastomer layer is applied onto the surface area of the carrier in a rotational casting process. The rotational casting process for applying the elastomer layer onto the carrier is particularly advantageous because it requires no moulds and therefore enables the production of a seamless form with simple means. Rotational casting processes are known to the expert, e.g. in the coating technique.

In order to generate a reproducible layer thickness as uniform as possible when casting the material forming the elastomer layer onto the surface area of the carrier it is preferably provided that the casting is attained in form of a caterpillar like material string describing a helix. The helix form may be attained in a simple way by rotating the carrier about its longitudinal center axis, and by displacing the carrier and the device outputting the material string in relation to each other in longitudinal direction of the carrier. In this case for applying the method simple devices and driving means may be used which are to be manufactured and operated with low cost. Because of the liquid or pasty state of the material string which are described further above, and the rotation of the carrier the adjacent parts of the string will flow into each other and already form a homogenous layer free from gaps and bubbles with a relatively uniform layer thickness prior to the beginning of the curing process.

Alternately to the rotational casting process the material for forming the elastomer layer is to be applied onto the surface area of the carrier in a mould casting process. The mould casting process requires the production and the application of a mould, however, the mould casting process also offers the advantage that the surfaces of the elastomer layer after the casting process comprise a larger accuracy regarding the cylindrical outer circumference form in relation to the rotational casting process.

It has found to be advantageous for gaining optimal printing, transfer or imprinting qualities and tool lifes of the form to generate the elastomer layer with a thickness of between about 1 and 5 mm. Thereby the elastomer layer is advantageously thin resulting in a low consumption of material and contributing to low manufacturing

cost for the forms. Furthermore the relative small thickness of the elastomer layer minimizes the flexing work of the elastomer layer during operation substantially contributing to long tool lives of the forms.

At the same time an exact geometry, in particular an exact diameter and a precise concentric running is essential for a good printing, transfer or imprinting quality. In order to guarantee this accuracy it is provided that the elastomer layer after the curing thereof is machined by grinding to result in a cylindrical outer circumference shape.

In order to reduce the amount per form of the relatively expensive elastomer layer materials, and in order to influence the features, in particular the hardness and the resilience of the elastomer layer it is provided that at least one filler is added to the material for forming the elastomer layer prior to applying it onto the carrier. By varying the volume ratio between the material as such at the one side and the filler or the fillers at the other side the mechanical and chemical features of the elastomer layer may be influenced in the required way over a wide range.

At least one mineral is preferably used as the filler as minerals at the one side are relatively inexpensive, and at the other side are chemically inert versus the materials siliconpolymer and polyurethan.

A particularly suitable mineral for the use in the method according to the invention is aluminum hydroxide because of its chemical and physical features.

In case a form with a particularly low weight must be produced which is easy to handle and in particular inexpensive to transport preferably a sleeve of plastic

material is used as the carrier. The use of sleeves as carriers for printing forms is known as such, however, it was hitherto only used in the area of rotogravure printing forms or block sleeves with bent and bonded block plates. The sleeves at the inner circumference thereof may be selectively cylindrical or slightly conical as is known as such; the outer circumference of the finished form in any case has to be cylindrical.

In case a plastic material sleeve is used as the carrier this is preferably produced with a single or several layers of elastomer and/or duroplastic materials in form of foams and/or casting compounds. Therein these materials may be sensitive to temperatures as long as the form is not used as an imprinting form for imprinting hot materials like thermoplastic foils, as a vulcanization for the application of the outer elastomer layer as printing or transferring or imprinting surface is not required. Materials in particular in form of foams have a low density and therefore enable the production of sleeves with relatively large wall thicknesses without their weight being intolerably high. In this way the outer circumference of the forms may be varied over a large range while keeping the inner diameter of the sleeve constant whereby correspondingly large repeat length areas may be covered. The user of the forms has only to keep a relative low number of mandrel rollers in stock onto which the sleeve-like forms have to be attached for the printing or transfer or imprinting operation.

When forms have to be supplied to users which are prepared for the use of metal sleeves the carrier preferably is a hollow cylindrical sleeve of metal wherein the metal preferably is nickel.

Furthermore a compound construction of the carrier of plastic material and metal is possible.

In case a low weight of the forms is of no interest or if the user of the forms is not technically equipped for the use of sleeve forms also a metal cylinder may be used as the carrier, e.g. of aluminum or steel.

The engraving of the cured elastomer layer preferably is attained by laser engraving because this engraving method may be accomplished particularly fast and inexpensive, and because it may be accomplished under control of digitally stored data. Tests have shown that the surface of the elastomer layer of the form according to the invention may be engraved by laser beams. Thus the forms produced in the process mentioned fulfil particularly well the requirements for simple and fast engraving which fulfillment could not be predicted before. By a suitable selection of the degree of cross linking of the materials, and of kind and volume of the fillers eventually used the laser engravability of the elastomer layer may be set and optimized in the required way. In the ideal case the elastomer layer is directly vaporated and/or incinerated in a point without significant melting of the adjacent areas when it is hit by a focussed laser beam.

After all it may be stated that the method according to the invention with its embodiments enables the production of forms for the rotary printing, coating or imprinting of web-shaped materials fulfilling all practical requirements wherein the process may be accomplished with low technical effort and at low cost, and offers a freedom hitherto unknown regarding the selection of materials for the carrier and the geometric design thereof.

In the following four examples are quoted for the material composition which are suitable for forming an elastomer layer. The following per cent numbers always are weight per cent.

Example 1:

Single-component silicone polymer

reactive polydimethylsiloxane	40 - 90 %
non-reactive polydimethylsiloxane	5 - 30 %
amorphous mineral filler	2 - 40 %
amorphous silica	0,5 - 10 %
reactive silane acetate compounds	2 - 10 %

Example 2:

Two-component silicone polymer

Component A:

polysiloxane containing vinyl groups	40 - 90 %
amorphous silica	0,2 - 10 %
platinum catalyst	0,05 - 3 %
multifunctional vinyl compounds	0,2 - 4 %
amorphous mineral filler	5 - 50 %
zeolithe	0,5 - 10 %

Component B:

multifunctional silane compounds	2 - 20 %
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Example 3:

Single-component polyurethane

polyether polyol	40 - 80 %
amorphous mineral filler	5 - 40 %
carbon black	0,2 - 5 %
zeolithe	0,5 - 10 %
amorphous silica	0,5 - 5 %
amine catalyst	0,5 - 5 %
tin catalyst	0,1 - 1 %
multifunctional hydroxy compound	0,1 - 3 %
multifunctional amine compound	1 - 10 %
bifunctional hydroxy compound	0,5 - 5 %
modified isocyanate	10 - 40 %

Example 4:

Two-component polyurethane

Component A:

polyether polyol	30 - 80 %
amorphous mineral filler	5 - 50 %
carbon black	0,2 - 5 %
zeolithe	0,5 - 10 %
amorphous silica	0,1 - 5 %
amin catalyst	0,1 - 3 %
tin catalyst	0,1 - 1 %
multifunctional hydroxy compound	0,1 - 3 %
bifunctional hydroxy compound	0,15 - 5 %

Component B:

diphenylmethanediisocyanate preparation 5 - 30 %

Relating to a drawing in the following a device is described with the help of which forms according to the invention may be produced. The figures of the drawing illustrate:

Figure 1 a device for the production of forms in a simplified front view, and

Figure 2 the device of Figure 1 in a cross-section along the line II - II in Figure 1.

According to Figure 1 the device 1 consists of a machine base 10 whereupon like at a lathe at the left end a spindle head 11 and at the right end a tailstock 13 is positioned. The spindle head 11 is secured at the machine base 10; a rotatable spindle 12 projects out of the spindle head 11 to the right side. The tailstock 13 at the opposite front end of the machine base 10 is displaceable in longitudinal direction of the machine base 10 in a sliding guide 13', and secureable in required positions. An idling point 14 is rotatably supported at the tailstock 13 in alignment with the spindle 12.

Between the spindle 12 and the idling point 14 a mandrel roller 30 is supported by means of its axle stubs 31, 32 such when the spindle 12 is rotated the mandrel roller 30 is also rotating about its longitudinal center axis as indicated by the rotating arrow 39.

A sleeve 33 is arranged at the mandrel roller 30 with the sleeve e.g. pushed onto the mandrel roller 30 by a pressurized medium, and is removed therefrom in the same way.

Furthermore the device 1 comprises an application device 2 which is secured at a support frame 25. The support frame 25 at the lower end thereof is secured at a longi-

tudinal slide 26 which is movable along a sliding guide 26' (not visible) in parallel with the sliding guide 13' in longitudinal direction of the machine base 10. At the upper end of the supporting frame 25 a mixing head 22 is secured as a part of the application device which mixing head comprises a dynamic mixing element with an electrically driven drive unit 23. Several pipes 21 are guided to the mixing head 22, in the example present two feeding pipes and two recirculation pipes through which the components of an elastomer material are transported from reservoirs through at least partially elastic resilient pipe areas to the mixing head 22, and when required in particular when the extrusion is discontinued are reversed. In the mixing head 22 the elastomer material is processed and mixed and subsequently extruded through a nozzle 24 arranged below the mixing head 22 in form of a material string 34' onto the outer circumference of the sleeve 33. The application is attained in form of a helix wherein the mandrel roller 30 together with the sleeve 33 rotates in direction of the rotating arrow 39, and wherein the application device 2 is moved in direction of the arrow 29 by means of the longitudinal slide 26. The turning speed of the mandrel roller 30 with the sleeve 33, and the feeding speed of the longitudinal support 26 are correlated with each other such that the single turns of the material string 34' are put directly next to each other such that a homogenous coating 34 is attained at the complete surface of the sleeve 33. In the Figure 1 the right part of the sleeve 33 has already been provided with the coating 34, this coating process is continued as described before until the left end area of the sleeve 33 is reached at.

Figure 2 in the lower part thereof illustrates in a cross section the machine base 10. At the front part of its upper side which is on the right side of the drawing the machine base 10 carries the sliding guide 13' for

the tailstock 13 which is visible in the background. In the rear of the machine base 10 which is left in the drawing the sliding guide 26' for the longitudinal slide 26 is positioned wherein the sliding guide 26' in this case is formed of three guiding rails in total. The support frame 25 is fastened at the upper side of the longitudinal slide 26 with the support frame extending like a gallows upwards and thereupon to the front which is the right part of the drawing. At the free upper end of the support frame 25 the application device 2 is fastened. The connection between the application device 2 and the support frame 25 is attained at the mixing head 22. The feeding pipes 21 open into the mixing head 22, only two of the feeding pipes are visible here. Above the mixing head 22 the drive unit 23 thereof is visible in form of an electric motor.

The nozzle 24 projects downwards from the mixing head 22 with the material string 34 for generating the elastomer layer 34 extruding downwards from the nozzle 24. The nozzle 24 is positioned in a small distance from the outer circumference surface of the sleeve 33 which is arranged at the mandrel roller 30. As it is illustrated in Figure 2 the mandrel roller 30 consists of metal, preferably steel, whereas the sleeve 33 consists of plastic material and therefore has only little weight. The turning direction of the mandrel roller 30 with the sleeve 33 during the application of the elastomer layer 34 is indicated by the turning arrow 39.

After finishing the coating 34 the sleeve 33 together with the associated mandrel roller 30 or separated therefrom is stored until the coating 34 is completely cured; thereupon the outer surface of the coating 34 is brought in an exact cylindrical shape preferably by a grinding operation. Thereupon the surface of the coating 34 is engraved preferably by laser engraving. The grinding as

well as the engraving of the elastomer layer 34 at the sleeve 33 may be accomplished with known devices such that no new technology is required in addition.

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Patent claims:

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1. Form for the rotary machine printing, coating or imprinting of web-shaped materials wherein at a carrier (33) having a cylindrical surface area an elastomer layer (34) is attached which after curing at the outer circumference thereof is machined and engraved to result in a cylindrical shape, characterized in that the elastomer layer (34) is formed of a cold cure material.
2. Form according to claim 1, characterized in that the material forming the elastomer layer (34) is a single-constituent or two-constituent silicone polymer.
3. Form according to claim 1, characterized in that the material forming the elastomer layer (34) is a single-constituent or two-constituent polyurethane.
4. Form according to one ore more of the preceeding claims, characterized in that the material forming the elastomer layer (34) is a mixture of two or more of the materials quoted in the claims 2 to 3.
5. Process for the manufacturing of a form for the rotary machine printing, coating or imprinting of web-shaped materials wherein at a carrier (33) having a cylindrical surface area an elastomer layer (34) is



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attached which after curing at the outer circumference thereof is machined and engraved to result in a cylindrical shape,
c h a r a c t e r i z e d i n
that for forming the elastomer layer (34) a cold cure material is used.

6. Process according to claim 5, characterized in that a single-constituent or two-constituent silicone polymer is used for forming the elastomer layer (34).
7. Process according to claim 5, characterized in that a single-constituent or two-constituent polyurethane is used for forming the elastomer layer (34).
8. Process according to one or more of the claims 5 to 7, characterized in that a mixture of two or more of the materials quoted in the claims 6 and 7 are used as a material for forming the elastomer layer (34).
9. Process according to one of the claims 5 to 8, characterized in that the material for forming the elastomer layer (34) is attached to the carrier (33) in a liquid or pasty state.
10. Process according to one of the claims 5 to 9, characterized in that when using a single-constituent material this material is processed in a single-constituent dosing device, and that when using a two-constituent material the constituents of this material, and when using a mixture of two or more materials these materials are processed and prepared in a multi-constituent dose and mixing device (2).
11. Process according to claim 9 or 10, characterized in that the material for forming the elastomer layer





(34) is applied onto the surface area of the carrier (33) in a rotational casting process.

12. Process according to claim 11, characterized in that the casting is attained in form of a caterpillar like material string (34) describing a helix.
13. Process according to claim 9 or 10, characterized in that the material for forming the elastomer layer (34) is applied onto the surface area of the carrier (33) in a mould casting process.
14. Process according to one of the claims 5 to 13, characterized in that the elastomer layer (34) is produced in a thickness of between about 1 and 5 mm.
15. Process according to one of the claims 5 to 14, characterized in that the elastomer layer (34) after the curing thereof is machined by grinding to result in a cylindrical outer circumference shape.
16. Process according to one of the claims 5 to 15, characterized in that at least one filler is added to the material for forming the elastomer layer (34) prior to applying it onto the carrier (33).
17. Process according to claim 16, characterized in that at least one mineral filler is used as the filler.
18. Process according to claim 17, characterized in that aluminum hydroxide is used as the mineral filler.
19. Process according to one of the claims 5 to 18, characterized in that a sleeve of plastic material is used as the carrier (33).



20. Process according to claim 19, characterized in that the sleeve is produced with a single or several layers of elastomer and/or duroplastic materials in form of foams and/or casting compounds.
21. Process according to one of the claims 5 to 18, characterized in that a sleeve of metal is used as the carrier (33).
22. Process according to claim 21, characterized in that the metal is nickel.
23. Process according to one of the claims 5 to 18, characterized in that a metal cylinder, preferably of aluminum or steel is used as the carrier (33).
24. Process according to one of the claims 5 to 23, characterized in that the engraving of the cured elastomer layer (34) is accomplished by laser engraving.

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Abstract:

The invention relates to a form for the rotary printing, coating or imprinting of web-shaped materials wherein an elastomer layer (34) is applied onto a carrier (33) with a cylindrical surface area with the layer machined and engraved at the outer circumference to result in a cylindrical shape after curing.

Furthermore the invention relates to a method for producing the form.

The form according to the invention is characterized in that the elastomer layer (34) is formed of cold cure material.

The engraving of the elastomer layer (34) preferably is attained by laser engraving.

(Figure 1 for the abstract!)

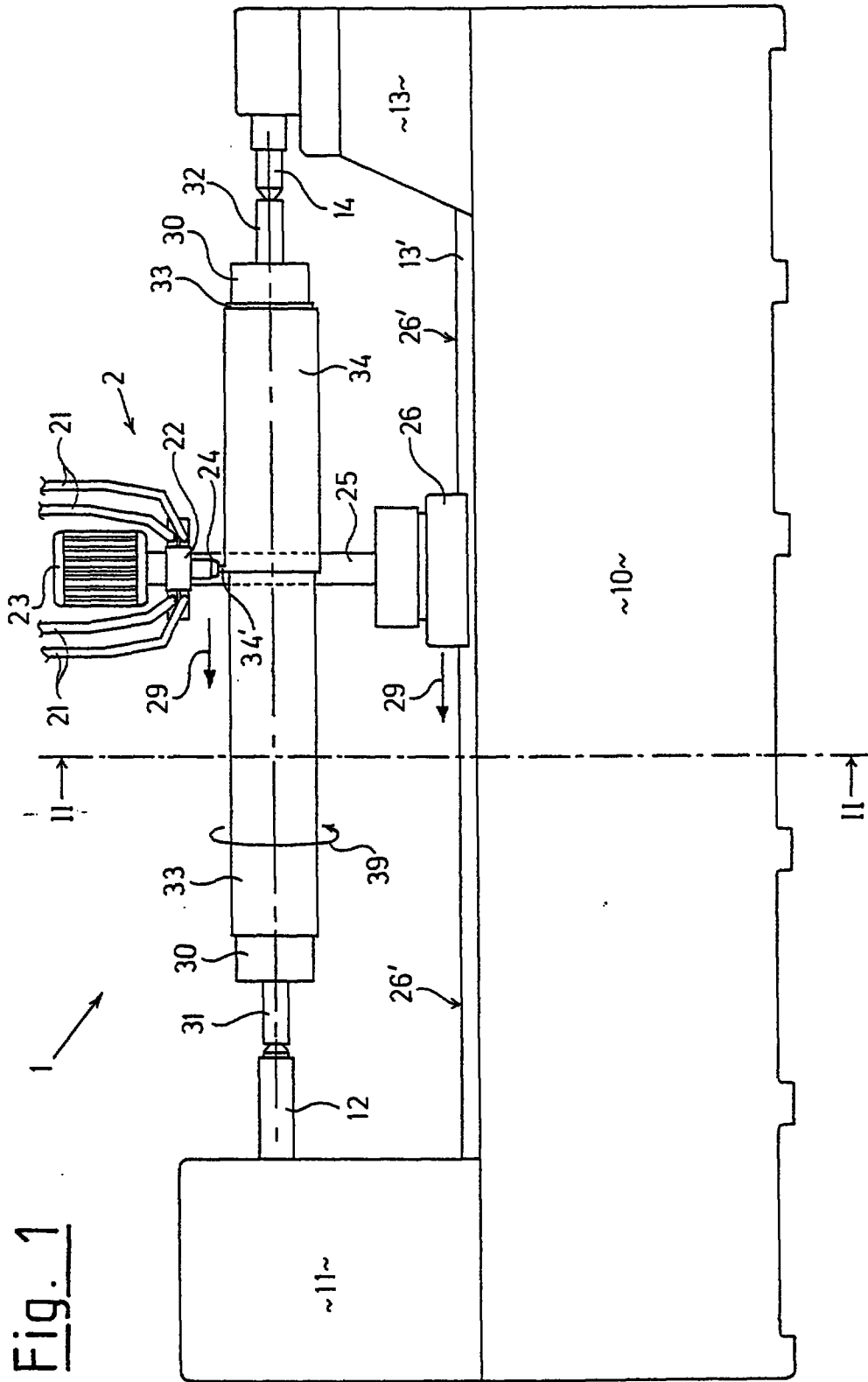
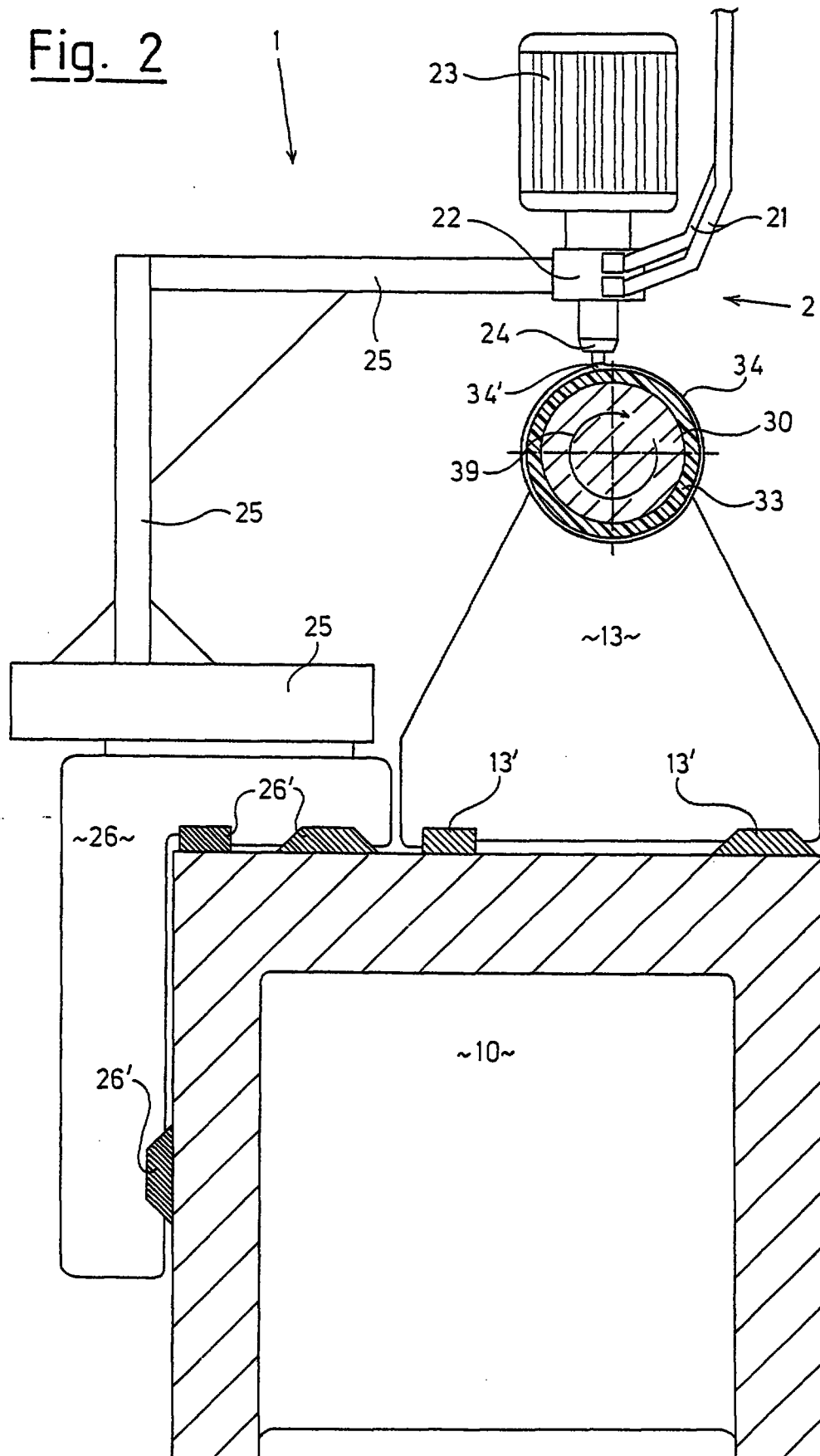
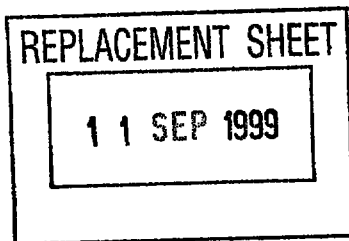


Fig. 2





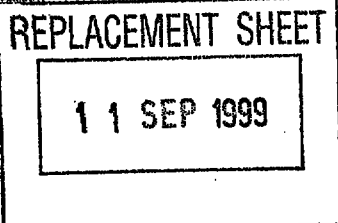
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Patent claims:

1. Form for the rotary machine printing, coating or imprinting of web-shaped materials, wherein to a carrier (33), having a cylindrical surface area, an elastomer layer (34) is attached, which layer (34) is formed of a cold cure material, wherein the said material is a single-constituent or two-constituent silicone polymer or a single-constituent or two-constituent polyurethane, wherein the said elastomer layer (34) after curing is machined at its outer circumference to result in a cylindrical shape and is then engraved, with the outer surface of the engraved elastomer layer (34) being the printing-ink- or coating-transferring surface.
2. Form according to claim 1, characterized in that the material forming the elastomer layer (34) is a mixture of two or more of the materials quoted in the claim 1.
3. Process for the manufacturing of a form for the rotary machine printing, coating or imprinting of web-shaped materials, wherein to a carrier (33), having a cylindrical surface area, an elastomer layer (34) is attached, for the forming of which layer (34) a cold cure material is used, wherein as the said material a single-constituent or two-constituent silicone polymer or a single-constituent or two-constituent polyurethane is used, wherein the said



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elastomer layer (34) after curing is machined at its outer circumference to result in a cylindrical shape and is then engraved, with the outer surface of the engraved elastomer layer (34) then being used as the printing-ink- or coating-transferring surface.

4. Process according to claim 3, characterized in that a mixture of two or more of the materials quoted in the claim 3 are used as a material for forming the elastomer layer (34).
5. Process according to one of the claims 3 or 4, characterized in that the material for forming the elastomer layer (34) is attached to the carrier (33) in a liquid or pasty state.
6. Process according to one of the claims 3 to 5, characterized in that when using a single-constituent material this material is processed in a single-constituent dosing device, and that when using a two-constituent material the constituents of this material, and when using a mixture of two or more materials these materials are processed and prepared in a multi-constituent dose and mixing device (2).
7. Process according to claim 5 or 6, characterized in that the material for forming the elastomer layer (34) is applied onto the surface area of the carrier (33) in a rotational casting process.
8. Process according to claim 7, characterized in that the casting is attained in form of a caterpillar like material string (34) describing a helix.
9. Process according to claim 5 or 6, characterized in that the material for forming the elastomer layer (34) is applied onto the surface area of the carrier



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(33) in a mould casting process.

10. Process according to one of the claims 3 to 9, characterized in that the elastomer layer (34) is produced in a thickness of between about 1 and 5 mm.
11. Process according to one of the claims 3 to 10, characterized in that the elastomer layer (34) after the curing thereof is machined by grinding to result in a cylindrical outer circumference shape.
12. Process according to one of the claims 3 to 11, characterized in that at least one filler is added to the material for forming the elastomer layer (34) prior to applying it onto the carrier (33).
13. Process according to claim 12, characterized in that at least one mineral filler is used as the filler.
14. Process according to claim 13, characterized in that aluminium hydroxide is used as the mineral filler.
15. Process according to one of the claims 3 to 14, characterized in that a sleeve of plastic material is used as the carrier (33).
16. Process according to claim 15, characterized in that the sleeve is produced with a single or several layers of elastomer and/or duroplastic materials in form of foams and/or casting compounds.
17. Process according to one of the claims 3 to 14, characterized in that a sleeve of metal is used as the carrier (33).
18. Process according to claim 17, characterized in that nickel is used as the metal.



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19. Process according to one of the claims 3 to 14, characterized in that a metal cylinder, preferably of aluminium or steel is used as the carrier (33).
20. Process according to one of the claims 3 to 19, characterized in that the engraving of the cured elastomer layer (34) is accomplished by laser engraving.

