The raised portions 11 provided on the outer surface 12, 14, 16 each comprise at least two stacked and joined layers.

The layers 31 -35, stacked upon and joined with each other, may be formed on the outer surface 14, 16, 12 by means of a printing process, for example. In this regard, a first layer 31 is printed on the outer surface 12, 14, 16. This first layer 31 forms the lowermost layer and is the layer adjacent the outer surface 12, 14, 16. Thereafter, a second layer 32 is printed on the first layer 31. The third layer 33 is then printed on the second layer 32, the fourth layer 34 is printed on the third layer 33, and the fifth layer 35 is printed on the fourth layer 34. In the embodiment illustrated, the fifth layer 35 is the topmost layer and is the layer farthest from the outer surface 12, 14, 16. The three-dimensional raised part may as well comprise another number of layers.

Due to the fact that the layers 31 – 35 are printed on the outer surface 12, 14, 16 and the raised portions 11 are formed by a plurality of layers 31 – 35, the three-dimensional raised portion can have any desired shape. In this manner, the shape and the design of the three-dimensional raised portion can be changed as desired in a production process and be adapted to the three-dimensional protrusion 10.

In the embodiment of Fig. 8, five layers are arranged one upon the other, respectively. The layers 31 – 35 vary in their width from B31 to B35. The width B31 of the layer 31 that is provided in contact with the outer surface 12, 14, 16 is the largest width. The width B35 of the layer 35 farthest from the outer surface 12, 14, 16 is the smallest width. The widths B32 – B34 of the layers 32 – 35, situated between the layers 31 and 35, vary in width between the widths B31 and B35 so that the raised portions 11 tape conically and are adapted to the three-dimensional protrusions 10 of the outer layer 2. Further, the lengths L of the layers and the thicknesses D of the layers can vary. The

outer layer 2 is applied on the outer surface 12, 14, 16 and on the raised portions 11 by means of an adhesive layer 4.

With reference to Fig. 9, it will be explained how the three-dimensional protrusions 10 are formed in the outer layer 2 by means of a thermoforming process. A web-shaped fabric 22 can be unwound from a roll and be heated in a heating oven 24. After having been heated in the heating oven 24, the web-shaped layer 22 is introduced into a forming means 26 in which the three-dimensional protrusions, in particular the rib-shaped three-dimensional protrusions, are formed in the web-shaped layer. This is effected by means of a pressing means having the shape of the three-dimensional protrusions. Downstream of the forming means 26, the web-shaped layer is severed into individual segments in a punching means 28 so that the outer layer 2 is formed. The outer layer 2 has the outer dimensions of the outer surfaces 12, 14, 16.

As an alternative, it is also possible to use plate material in a thermoforming process instead of the web-shaped layer, the plate material already having the dimensions of the respective outer surface 12, 14, 16. This plate material is heated and formed.

Thus, in a method for producing a piece of baggage, the following steps are carried out:

- producing a piece of baggage having at least one outer surface,

- producing at least one additional outer layer 2,

- forming rib-shaped protrusions 10 in the additional outer layer 2 by means of thermoforming, and

CLAIMS

1. A piece of baggage comprising at least one outer surface (12, 14, 16), wherein an additional outer layer (2) is arranged on said outer surface (12, 14, 16), said layer having at least one three-dimensional protrusion (10) formed therein by means of a thermoforming process and protruding from the outer surface (12, 14, 16), and wherein the outer surface (12, 14, 16) has a raised portion (11) adapted to the shape of the at least one three-dimensional protrusion (10), the outer layer (2) being arranged on the outer surface (12, 14, 16) such that the at least one three-dimensional protrusion (10) of the outer layer (2) overlies the raised portion (11) of the outer surface (12, 14, 16).

2. The baggage according to claim 1, wherein the or each three-dimensional protrusion (10) is rib-shaped.

3. The baggage according to claim 2, wherein the or each rib-shaped protrusion (10) is/are hollow.

4. The baggage according to any one of the preceding claims, wherein the outer layer is made of plastics material, leather or a textile fabric.

5. The baggage according to any one of the preceding claims, wherein the outer layer (2) is applied on the outer surface (12, 14, 16) by means of an adhesive layer (4).

6. The baggage according to any one of the preceding claims, wherein the or each three-dimensional protrusion (10) has a triangular cross-sectional shape.

7. A method for producing a piece of baggage, which comprises the following steps:

   - producing a piece of baggage having at least one outer surface (12, 14, 16),
   - producing at least one additional outer layer (2),
   - applying rib-shaped protrusions (10) into the additional outer layer (2) by means of thermoforming,

- fastening, preferably by adhesion, the outer layer (2) on the at least one outer surface (12, 14, 16),

wherein the outer surface (12, 14, 16) has a raised portion (11) adapted to the shape of the at least one three-dimensional protrusion (10), the outer layer (2) being arranged on the outer surface (12, 14, 16) such that the at least one three-dimensional protrusion (10) of the outer layer (2) overlies the raised portion (11) of the outer surface (12, 14, 16).