

**FOIL LAMINATE AND A PROCESS
FOR THE PRODUCTION THEREOF**

This invention relates to a foil laminate and a process for the production thereof. In particular, the invention relates to a laminate in which an outer layer provides a holographic effect.

It is known, for example, from British Patent Specification No. 2 205 533 A to provide a decorative holographic material having an activatable adhesive surface. The earlier decorative material may be applied to fabric either as such or when the fabric is in the form of an article of clothing to provide a holographic transfer. The earlier invention provides for a water impermeable material between the holographic and adhesive elements so that the transfer is washable. Nevertheless, the transfer is such that it stiffens the area where it is applied and provides a rigid item even where the fabric to which it is applied is flexible.

We have now found surprisingly that a flexible laminate in which an outer and visible layer provides a holographic effect can be produced by laminating together a plastics-coated flexible substrate such as a plastics-coated fabric and a metal foil bearing a holographic pattern and a plastics size by bringing

together the substrate and foil with their plastics layers in contact and applying heat and pressure.

Accordingly, the present invention in one aspect provides a process for the production of a flexible laminate in which an outer and visible layer provides a holographic effect, which process comprises bringing together a metal foil bearing a holographic image, and having a layer of plastics size, and a flexible substrate in which at least an outer layer comprises a plastics material which is compatible with said size sufficient to enable the plastics material and size to adhere together under conditions of temperature and pressure which do not destroy the holographic effect, the substrate and foil being brought together with their plastics layers adjacent each other, and applying to the combination heat and pressure at a level and for a time sufficient to adhere the foil to the substrate but insufficient to destroy the holographic effect.

In the process of the invention, the metal foil bearing a holographic image may be any flexible metal foil, but preferably is an aluminium foil. Such foils are commercially available as hot stamping foils bearing a holographic pattern which are produced to provide a foil to be applied to a rigid substrate, typically a rigid plastics material. The rigid substrate provides a support for the foil so that the

holographic effect may be stabilised. Typically, the size of a commercial foil is a pvc (polyvinyl chloride), which is preferred for the foils used in the invention, but other plastics size layers may be employed in the present invention provided they can be adhered to a compatible plastics material as described above.

Also, the foil used in the process of the invention preferably includes a release layer on that surface of the metal foil which does not carry the layer of plastics size. That release layer can serve to provide additional protection for the holographic pattern and is removed after treatment in the process of the invention and before the holographic effect is required. A typical release layer may comprise a polymeric material such as Cellophane (registered Trade Mark).

In the process of the invention the flexible substrate may be any such substrate provided only that it is flexible and comprises said compatible plastics material. Preferably, however, the substrate is a woven or non-woven web, typically a fabric.

More preferably, the substrate is one which is not only flexible but also stretchable. Typically, the fabric may be a commercially-available Lycra (registered Trade Mark) fabric or any other similar fabric based on a viscose polymer.

Furthermore, the plastics material may be any such material provided it is compatible as defined above. Preferably, however, the plastics material is a polyurethane and the flexible substrate typically may comprise 70% viscose and 30% polyurethane by content.

Generally speaking, the flexible substrate is one which has an uncoated surface on its reverse side to that carrying the said plastics material. Thus, typically the substrate is a fabric having an uncoated inner surface.

In carrying out the process of the invention, the foil and substrate are fed to a laminating station at which heat and pressure can be brought to bear on their combination. The feeding to the laminating station may be on a continuous or batch basis depending on the requirements of the process being effected. Thus, typically the foil and substrate may be supplied continuously or intermittently from rollers on which they may be stored.

The laminating station may comprise any form of apparatus or device which can supply heat and pressure under the above general requirements. Furthermore, the construction and arrangement of the station may be varied to suit continuous or batch operation. Thus, in one preferred aspect of the invention the laminating station may comprise at least two rollers between which

the foil and substrate may be fed to be pressed together and heated. Alternatively, in another preferred aspect the foil and substrate may be brought together in a heated press which typically may comprise upper and lower heated plates which can be brought together under pressure.

Generally, the process of the invention is effected at a temperature below about 170°C because at that temperature and above commercially-available foil materials tend to lose their holographic colours. Preferably also, the temperature at which treatment is effected is at least above about 140°C e.g. above about 143°C , with a preferred range being about 150°C to about 160°C , since below 140°C wrinkling tends to occur, especially when using stretchable fabric as substrate. However, most preferably the temperature is about 150°C since a colour shift to pastel colours may take place as temperatures in excess of 150°C are employed. Accordingly, unless a particular pastel effect is required the temperature is kept to the lower end of the preferred range to maximise the brightness of the holographic colours.

As to pressure, it is preferred to use as high a pressure as is possible within the limits of the press or other apparatus employed. Typically, a pressure of at or above about 200 gm/cm^2 may be used, for example,

a pressure of about 200 to about 210 gm/cm² such as a pressure of about 208 gm/cm² which may be applied in a 1000 kg press with a plate area of 0.4 m x 1.2 m.

Generally speaking, in the process of the invention, the heat and pressure are applied for a sufficient time to enable laminate formation to take place. Thus, a variety of dwell times may be employed, although a dwell time of about 30 seconds is preferred, especially under the conditions mentioned above.

In the process of the invention the foil may be used to provide a holographic pattern or other holographic effect. Thus, for example, as an alternative to an overall pattern, the foil may embody a variety of holographic images, either single images or a plurality thereof. Typically, the or each image may be a holographic photo-release image, for example, of a pop-star or the like.

In another aspect, the invention also provides a flexible laminate in which an outer and visible layer provides a holographic effect, which laminate comprises a layer of metal foil bearing a holographic image, a layer of a flexible substrate and an adhesive layer between the substrate and the foil which comprises at least one plastics material or a mixture of at least two compatible plastics materials.

The flexible laminate as defined above generally

may be produced by the process of the invention. Also, the flexible laminate may typically have one or more of the features defined herein in connection with that process.

Generally speaking, the flexible laminate of the invention or produced by the process of the invention has a variety of uses all of which may require a flexible material to display a holographic effect. Thus, for example, the flexible laminate may be used in the theatre for background, props or clothing, for other clothing such as skinwear or protective clothing e.g. for cyclists, for marine equipments such as sails for windsurfing boards, or toys.

The fabric of the invention is a fully flexible laminate which generally has the same or a similar high degree of flexure as the flexible substrate from which it is made. Thus, the laminate should always be capable of a high degree of flexure and a treated fabric, for example, should be capable of behaving as a fabric so that clothing can be made therefrom essentially as easily as from the original fabric.

The invention will now be described by way of example only with reference to the following specific Example.

Example

A 150 gsm Lycra fabric comprising 70% viscose and 30% polyurethane by content and which was clean and free from dust and grease was fed to the top surface of the lower plate of a Hashima HP124AP 1000 kg fully automatic flat fusing press having a fusing plate area of 0.40 m x 1.2 m preheated to 150°C. There was then fed over the Lycra fabric an aluminium holographic hot stamping foil with a pvc sizing (supplied by Applied Holographics as E39 with pvc 68 sizing), the pvc sizing facing downwards onto the fabric. The pressure of the fusing press was then set to 1000 kg and the upper plate of the press brought down on the combination disposed over the lower plate. The upper and lower plates were held together for 30 seconds at 150°C and then the pressure was released and the fused laminate removed.

The laminate was allowed to cool and the release layer of the original foil was removed. The result was a flexible laminate exhibiting a very pleasing holographic effect and behaving essentially as the original fabric. The holographic effect was as bright as that of the original foil, the foil appeared to be bonded down into the fabric, and the holographic effect was permanent and fast. Thus, it was impossible to wash or scrape off the holographic layer even when the

fabric was stretched, although stretching to a high degree would begin to destroy the fabric itself.

It is of course to be understood that the invention is not limited to the specific details given above and numerous variations may be made within the scope of the claims which follow.



CLAIMS

1. A process for the production of a flexible laminate in which an outer and visible layer provides a holographic effect, which process comprises bringing together a metal foil bearing a holographic image, and having a layer of plastics size, and a flexible substrate in which at least an outer layer comprises a plastics material which is compatible with said size sufficient to enable the plastics material and size to adhere together under conditions of temperature and pressure which do not destroy the holographic effect, the substrate and foil being brought together with their plastics layers adjacent each other, and applying to the combination heat and pressure at a level and for a time sufficient to adhere the foil to the substrate but insufficient to destroy the holographic effect.
2. A process according to claim 1, wherein the metal foil bearing a holographic image is an aluminium foil.
3. A process according to claim 1 or claim 2, wherein the foil is a hot stamping foil bearing a holographic pattern.
4. A process according to any one of the preceding claims, wherein the size of the foil is a polyvinyl chloride.



5. A process according to any one of the preceding claims, wherein the foil includes a release layer on that surface of the metal foil which does not carry the layer of plastics size.

6. A process according to claim 5, wherein the release layer is removed after treatment by heat and pressure and before the holographic effect is required.

7. A process according to any one of the preceding claims, wherein the flexible substrate is a woven or non-woven web.

8. A process according to claim 7, wherein the flexible substrate is a fabric.

9. A process according to any one of the preceding claims, wherein the substrate is one which is not only flexible but also stretchable.

10. A process according to claim 8 or claim 9, wherein the fabric is a fabric based on a viscose polymer.

11. A process according to any one of the preceding claims, wherein the compatible plastics material is a polyurethane.

12. A process according to claim 11, wherein the flexible substrate comprises 70% viscose and 30% polyurethane by content.

13. A process according to any one of the preceding claims, wherein the foil and substrate are fed to a laminating station at which heat and pressure can be brought to bear on their combination.



14. A process according to claim 13, wherein the feeding to the laminating station is on a continuous or batch basis.

15. A process according to any one of the preceding claims, wherein the foil and the substrate are supplied continuously or intermittently from rollers on which they are stored.

16. A process according to any one of the preceding claims, wherein the foil and substrate are brought together between at least two rollers which provide the required pressing together and heating.

17. A process according to any one of claims 1 to 15, wherein the foil and substrate are brought together in a heated press which comprises upper and lower heated plates which can be brought together under pressure.

18. A process according to any one of the preceding claims, wherein the temperature conditions are below about 170°C and above about 140°C.

19. A process according to any one of the preceding claims, wherein the temperature is in the range of from about 150°C to about 160°C.

20. A process according to claim 19, wherein the temperature is about 150°C.

21. A process according to any one of the preceding



claims, wherein the pressure is at least about 200 gm/cm².

22. A process according to claim 21, wherein the pressure is from about 200 gm/cm² to about 210 gm/cm².

23. A process according to any one of the preceding claims, wherein the dwell time during which the temperature and pressure conditions apply is about 30 seconds.

24. A process according to any one of the preceding claims, wherein the foil is used to provide a holographic pattern or variety of holographic images, either single images or a plurality thereof.

25. A process according to claim 24, wherein the or each image is a holographic photo-release image.

26. A process according to claim 1 substantially as hereinbefore described.

27. A process according to claim 1 substantially as hereinbefore described with reference to the specific Example.

28. A flexible laminate when produced by a process according to any one of the preceding claims.

29. A flexible laminate in which an outer and visible layer provides a holographic effect, which laminate comprises a layer of metal foil bearing a holographic image, a layer of a flexible substrate and an adhesive layer between the substrate and the foil which



comprises at least one plastics material or a mixture of at least two compatible plastics materials.

30. A flexible laminate according to claim 29 when made by the process of any one of claims 1 to 27.

31. A flexible laminate according to claim 29 having one or more of the features of any one of claims 2 to 12, 24 or 25.

32. A flexible laminate substantially as hereinbefore described.
