What is claimed is:

1. A toy comprising:

an internal ball structure comprising a highly resilient material capable of bouncing off a surface;

a plush fabric skin having a plush fabric exterior configured to completely cover the internal ball structure such that the plush fabric exterior does not significantly impact or dampen the ability of the internal bouncing ball structure to bounce when impacting a surface;

extremities comprising a pliable fabric sewn on to the plush fabric exterior of the plush fabric skin, wherein the pliable fabric is chosen to prevent causing the toy to carom or ricochet off the extremities;

facial features sewn over the plush fabric exterior of the plush fabric skin, wherein the facial features are configured to prevent dampening of a bounce of the toy; and

wherein the diameter of the internal ball structure allows for the toy to be grippable by a child.

2. The toy of claim 1, wherein the highly resilient material comprises polyurethane.

3. The toy of claim 2, wherein the polyurethane comprises toluene diisocyantate, polyether polyol, tin octoate, silicone oil, and color cream.

4. The toy of claim 1 wherein the plush fabric skin comprises a pile to give the plush fabric a fur-like texture.

5. The toy of claim 4 wherein the pile length is 3-50 mm.

6. The toy of claim 1 wherein the plush fabric skin comprises XTM fabric.

7. The toy of claim 1 wherein the plush fabric skin is attached to the interior ball structure in a manner that does not significantly affect bounce or liveliness by stretching the plush fabric skin over the internal ball structure and tightly sewing a closing seam.

8. The toy of claim 1, wherein the toy resembles an animal or cartoon character.

9. The toy of claim 1, wherein the plush fabric skin is designed to be spherical in shape and having a pocket for accepting the internal ball structure, wherein an open closing seam provides an opening into the pocket before the closing seam is closed to cover the internal ball structure, and wherein the closing seam has substantially the same length as the diameter of the internal ball structure.

10. A method of manufacture comprising:

forming an internal ball structure comprising a highly resilient material capable of bouncing off a surface;

cutting a sewing pattern to create a plurality of plush fabric portions;

sewing together the plurality of plush fabric portions according to the sewing pattern to form a spherical plush fabric skin;

leaving open a closing seam on the plush fabric skin, wherein the closing seam is substantially the same diameter as the diameter of an internal ball structure;

inserting the internal ball structure into the plush fabric skin through the closing seam;

tightly sewing the seam closed to cover the internal ball structure with the plush fabric skin;

cutting extremity portions in a pliable fabric according to the sewing pattern;

sewing the extremity portions to the plush fabric skin;

cutting facial features according to the sewing pattern; and

sewing the facial features over the plush fabric skin,

wherein the pliable fabric of the extremity portions is chosen to prevent causing the toy to carom or ricochet off the extremities, and

wherein the facial features are configured to prevent dampening of a bounce of the internal ball structure.

11. The method of claim 10, wherein the highly resilient material comprises polyurethane.

12. The method of claim 11, wherein the polyurethane comprises toluene diisocyantate, polyether polyol, tin octoate, silicone oil, and color cream.

13. The method of claim 10 wherein the plush fabric skin comprises a pile to give the plush fabric a fur-like texture.

14. The method of claim 13 wherein the pile length is 3-50 mm.

15. The method of claim 10 wherein the plush fabric skin comprises XTM fabric.

16. A toy comprising:

an internal ball structure comprising a highly resilient material capable of bouncing off a surface; and

a plush fabric skin having a plush fabric exterior configured to completely cover the internal ball structure such that the plush fabric exterior does not significantly impact or dampen the ability of the internal bouncing ball structure to bounce when impacting a surface

extremities comprising a pliable fabric sewn on to the plush fabric exterior of the plush fabric skin, wherein the pliable fabric is chosen to prevent causing the toy to carom or ricochet off the extremities;

facial features sewn over the plush fabric exterior of the plush fabric skin, wherein the facial features are configured to prevent dampening of a bounce of the internal ball structure,

wherein the plush fabric skin comprises a pile to give the plush fabric a fur-like texture, and wherein the pile length is 3-10 mm; and

wherein the diameter of the internal ball structure allows for the toy to be grippable by a child.

17. The toy of claim 1, wherein the toy is configured to bounce off a surface 55-70% of a height dropped.

18. The toy of claim 1, wherein the plush fabric skin is configured to stretch over the internal ball structure.