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Collins et al.

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(54) **PRINT METHODOLOGY FOR APPLYING POLYMER MATERIALS TO ROOFING MATERIALS TO FORM NAIL TABS OR REINFORCING STRIPS**

(75) Inventors: **David Allan Collins**, Houston, TX (US); **George William Jackson**, Houston, TX (US); **Miguel E Madero O'Brien**, Mexico City (MX)

(73) Assignee: **Fast Felt Corporation**, Houston, TX (US)

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B05D 1/28 (2006.01)
B05D 3/06 (2006.01)
B32B 7/12 (2006.01)

(52) **U.S. Cl.** **427/428.18**; 427/508; 427/428.06

(58) **Field of Classification Search** 427/508, 427/186, 188, 256, 428.06, 428.18, 428.2; 52/746.11
See application file for complete search history.

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(57) **ABSTRACT**

A method and apparatus for applying nail tabs to roofing and building cover materials involving the steps of depositing tab material onto the surface of the roofing or building cover material, during or after its manufacture, resulting in a plurality of nail tabs from a lamination roll, and bonding the tabs to the surface of the material by pressure between the lamination roll and said surface. The method also encompasses depositing the tab material or pre-formed tabs by a pressure roll in contact with said surface. The tabs preferably are made substantially of a polymer material and may be hardened or cured by ultra-violet or visible light. The tabs may also be pre-formed and have adhesive backing.
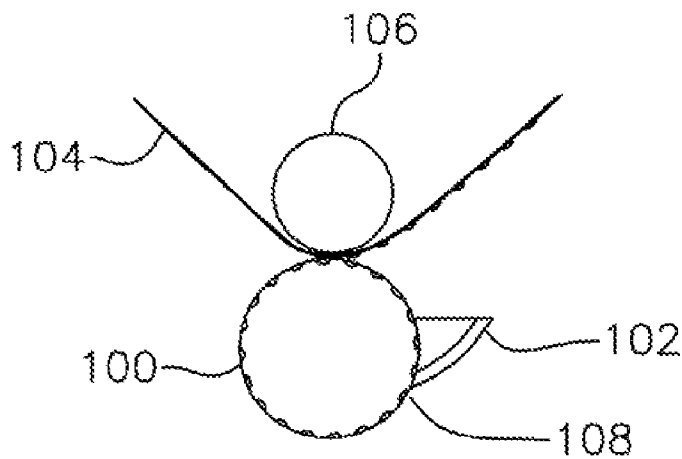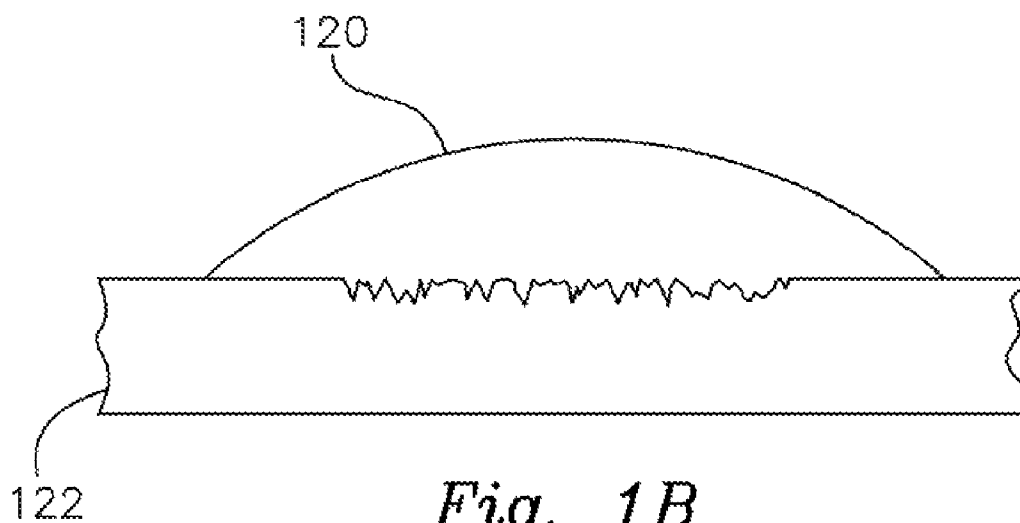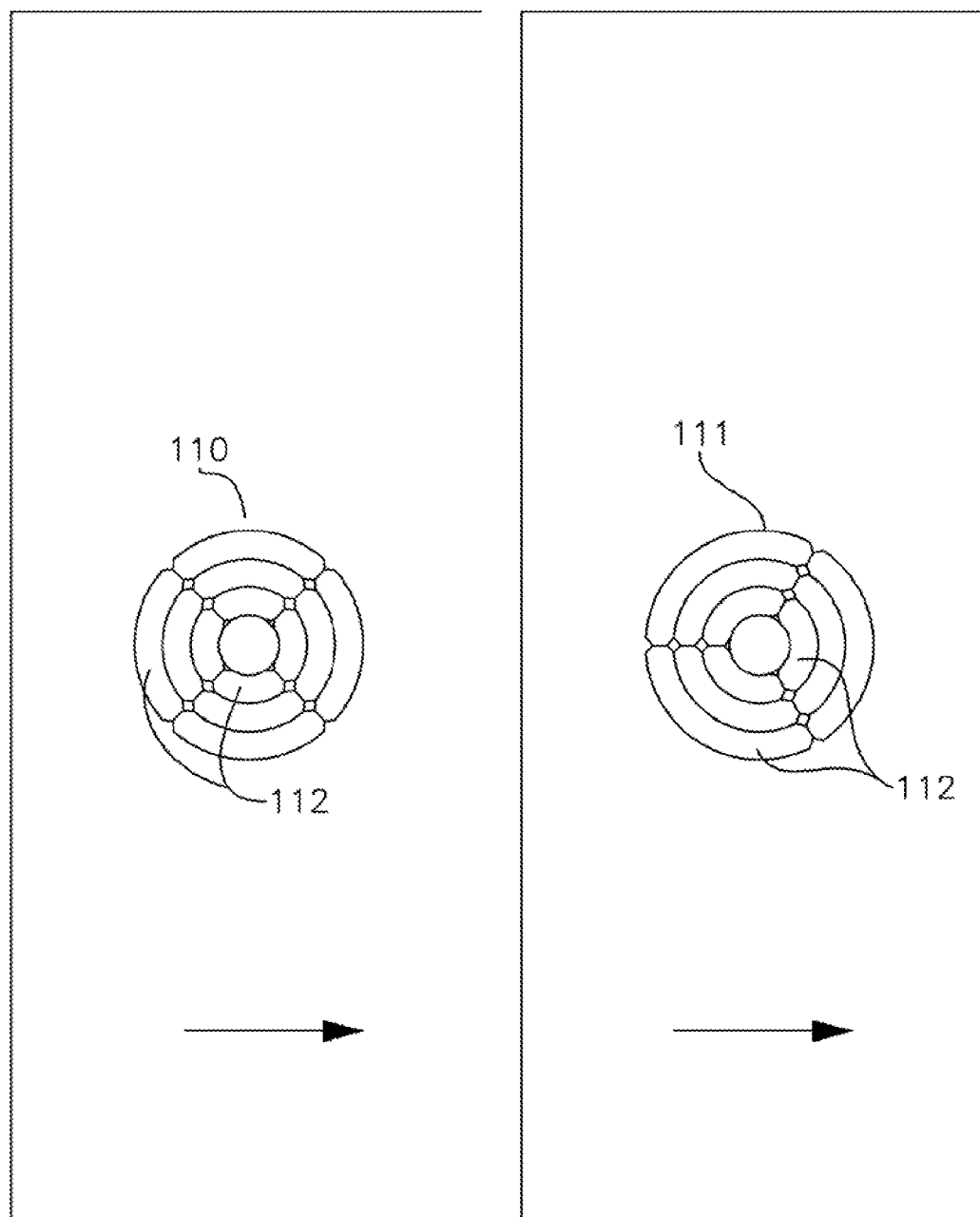
9 Claims, 10 Drawing Sheets

Fig. 1

Fig. 1B
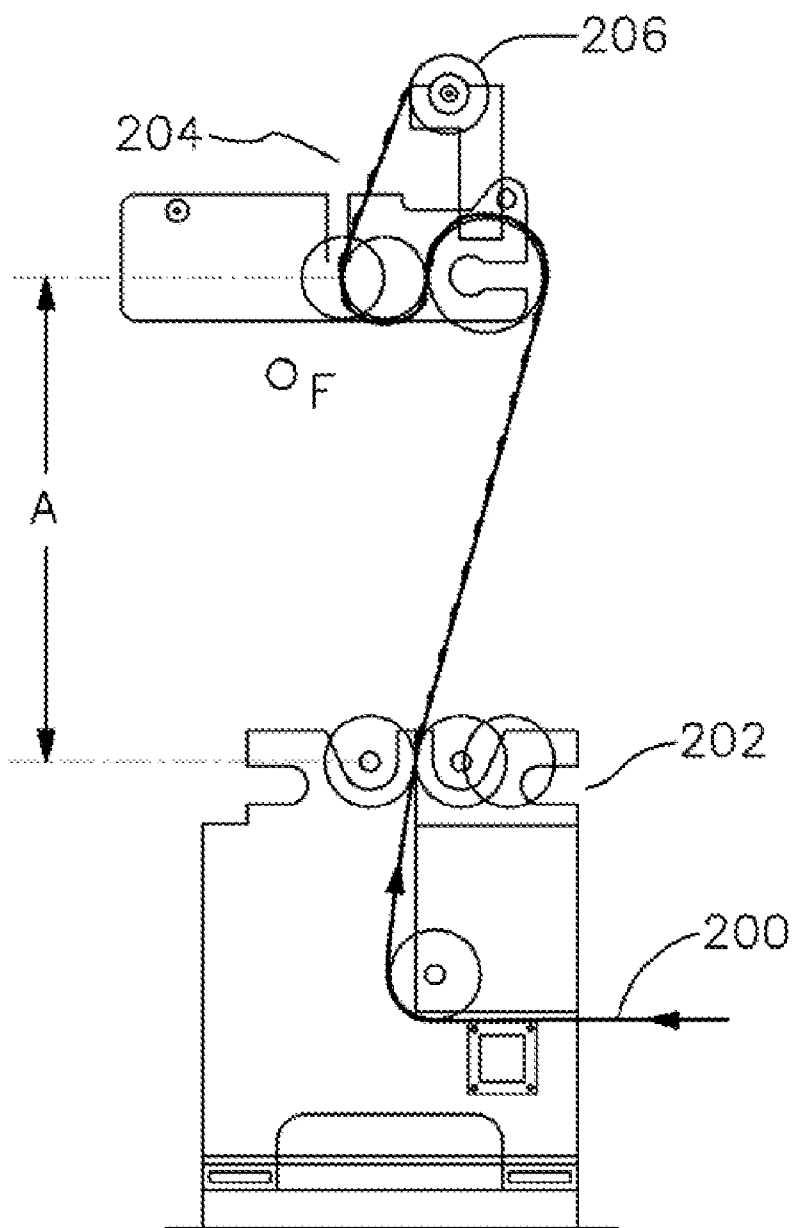
Fig. 1A
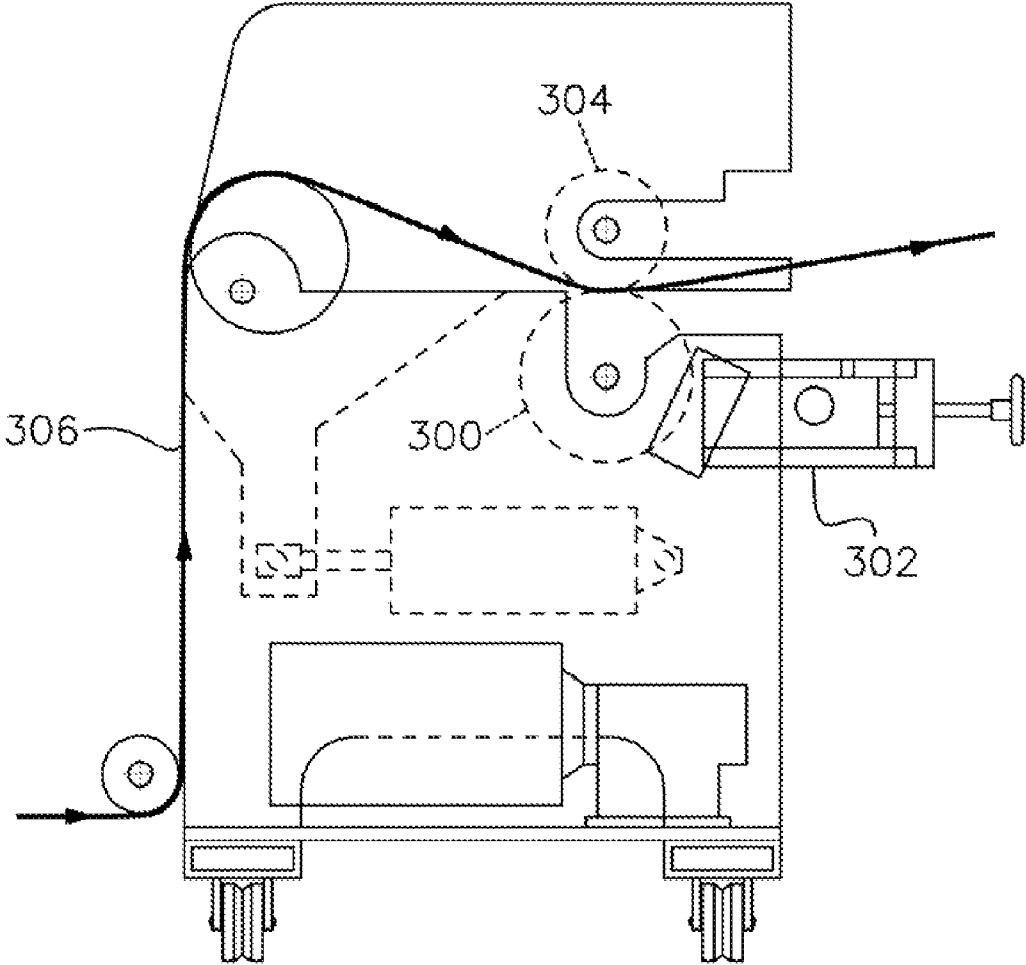
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200

Fig. 2

Fig. 3

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