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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**

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9, 2003, provisional application No. 60/474,194, filed
on May 29, 2003.

(51) **Int. Cl.**
B05D 1/28 (2006.01)
B05D 3/06 (2006.01)

(52) **U.S. Cl.** **427/428.06**; 427/508; 427/428.18;
427/428.2

(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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Primary Examiner—William Phillip Fletcher, III

(57) **ABSTRACT**

A method of making a composite roofing material and the
resulting material by depositing nail tabs made of a ther-
moplastic, thermosetting, adhesive or elastomer material, in
a liquid state, onto the base substrate of the composite
roofing material or onto the saturated or coated roofing
material, or onto a transfer surface to be pressed or lami-
nated onto the roofing material. A preferred embodiment
transfers the nail tabs onto an engraved transfer impression
roll and uses a pressurized applicator to inject the viscous tab
material into engraved patterns depressed in raised areas of
the impression roll., then deposits the material onto the
roofing material. A preferred embodiment also includes the
thermoplastic or thermosetting material in a liquid or vis-
cous state hardened or cured by either its exposure to the air
or by the use of ultra-violet or visible light.

8 Claims, 10 Drawing Sheets

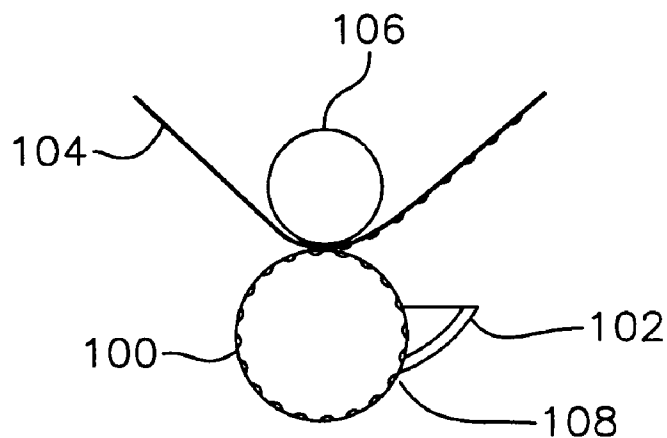


Fig. 1

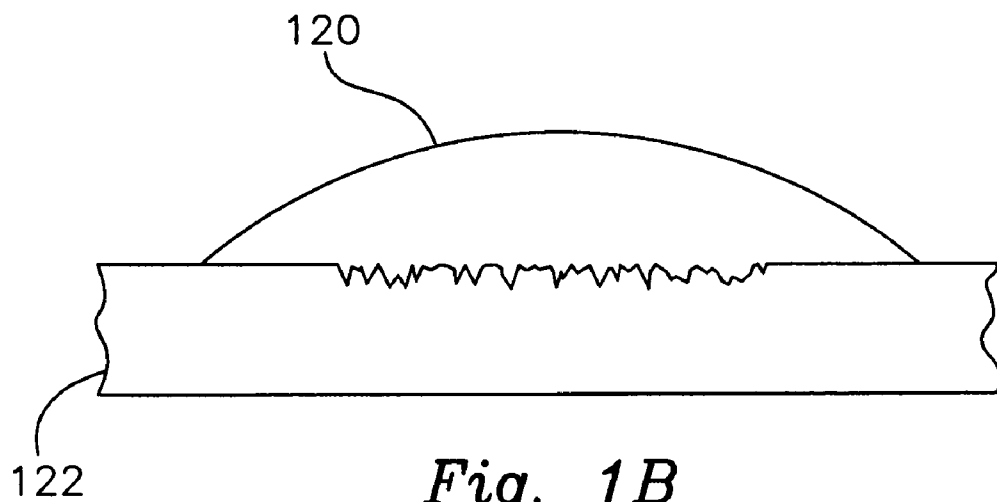


Fig. 1B

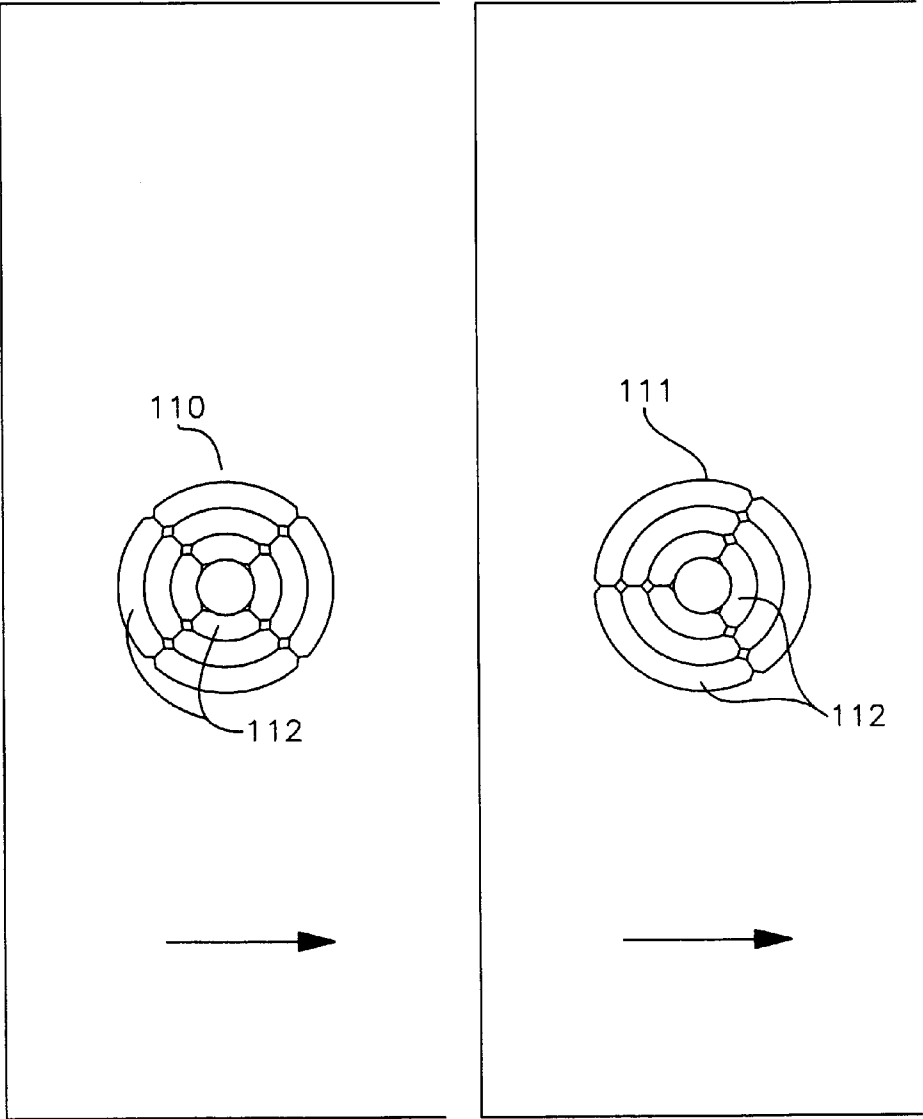


Fig. 1A

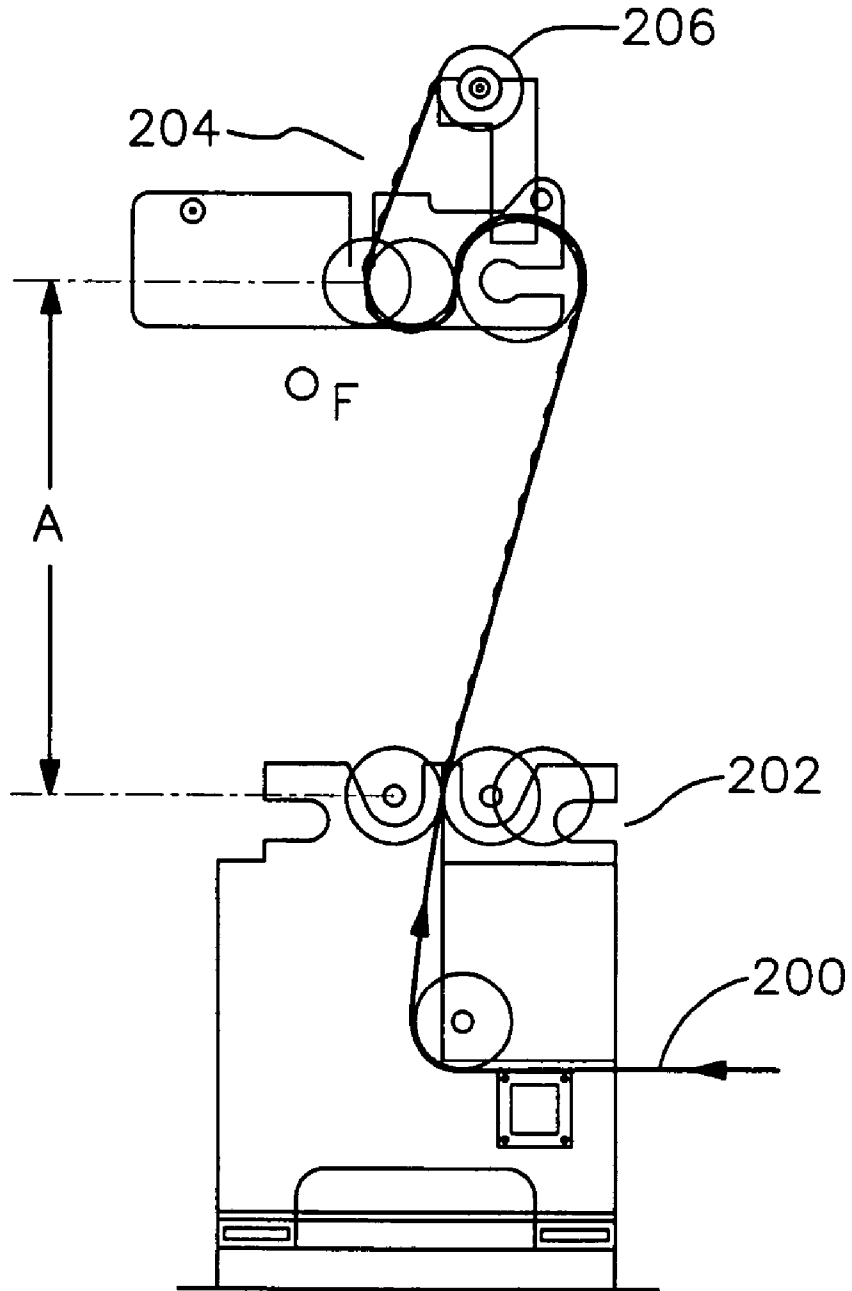


Fig. 2

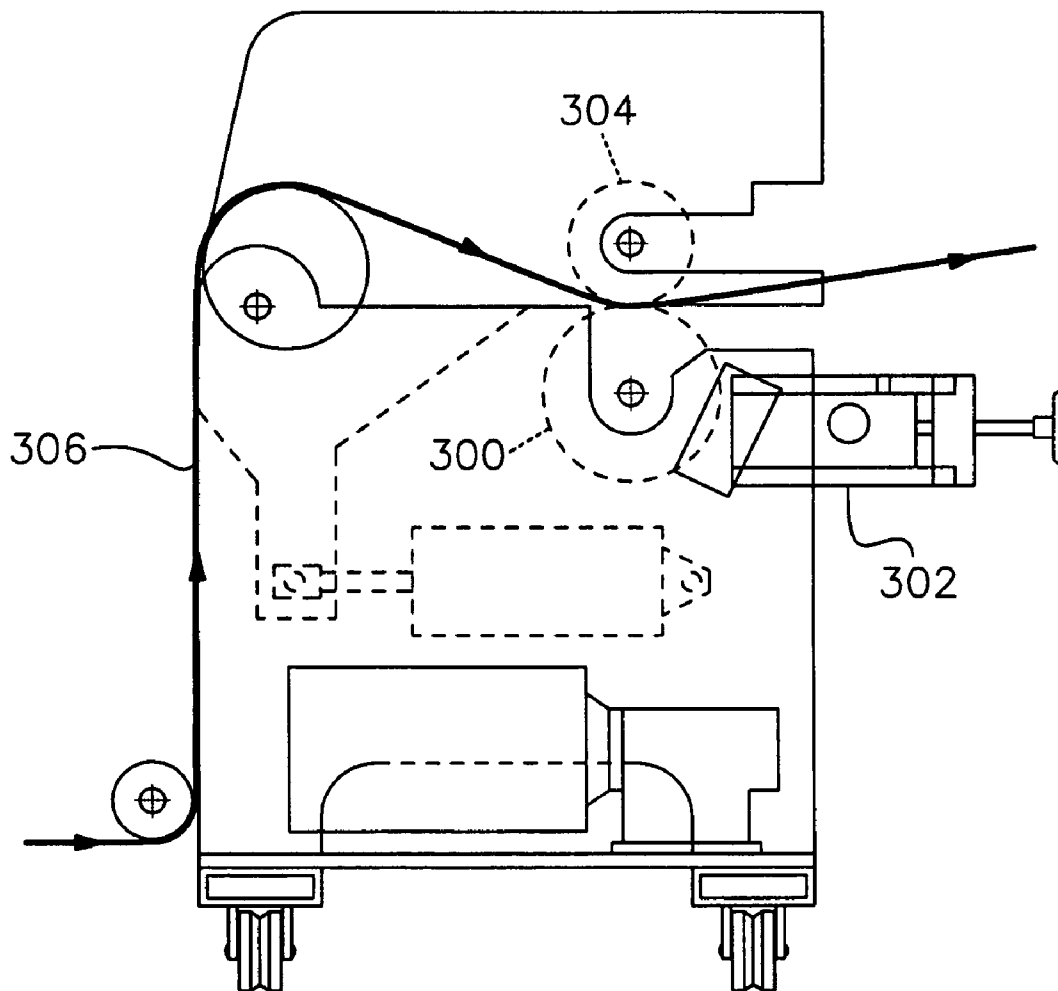


Fig. 3

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