

(12) **UK Patent Application** (19) **GB** (11) **2 145 941 A**

(43) Application published 11 Apr 1985

(21) Application No **8421521**

(22) Date of filing **24 Aug 1984**

(30) Priority data

(31) **3330866** (32) **26 Aug 1983** (33) **DE**

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(51) INT CL⁴
A41D 27/06 B32B 3/22 D06M 17/00

(52) Domestic classification
**B2E 1116 1700 402T 402U 427T 427U 438T 438U 439T
443T 473T 489T 489U 490T 490U 491T 491U 553T 553U
601T BDA M
U1S 1150 B2E**

(56) Documents cited
**EP 1474455 EP 0029241
EP 1420497**

(58) Field of search
**B2E
B5N**

(54) **Top cloth for articles of clothing as well as a manufacturing process and transfer unit for it**

(57) A top cloth is coated on one side with a patterned coating serving to stabilize it, comprising a lower adhesive layer of patterned heat-sealable plastics elements which are not interconnected and which adhere to the back of said top cloth, and an upper covering layer of non-hot sealable or substantially non-hot sealable material. The covering layer can extend substantially or continuously, over the lower patterned adhesive layer and beyond it and can in its areas between the pattern points of the lower layer not adhere to the top cloth or only slightly adhere thereto, while being easily wiped off, or it can be directly patterned and congruent with the adhesive pattern beneath it.

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FIG. 1

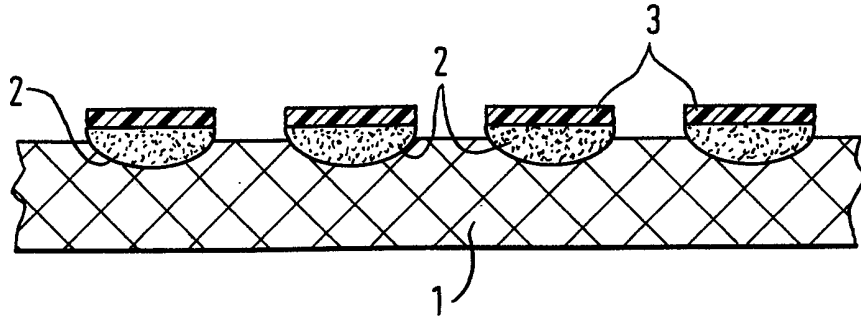


FIG. 2

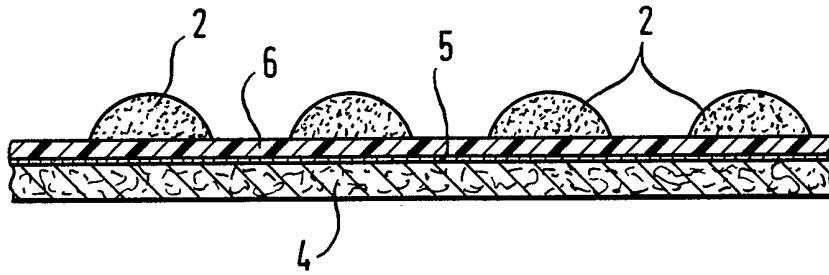


FIG. 3

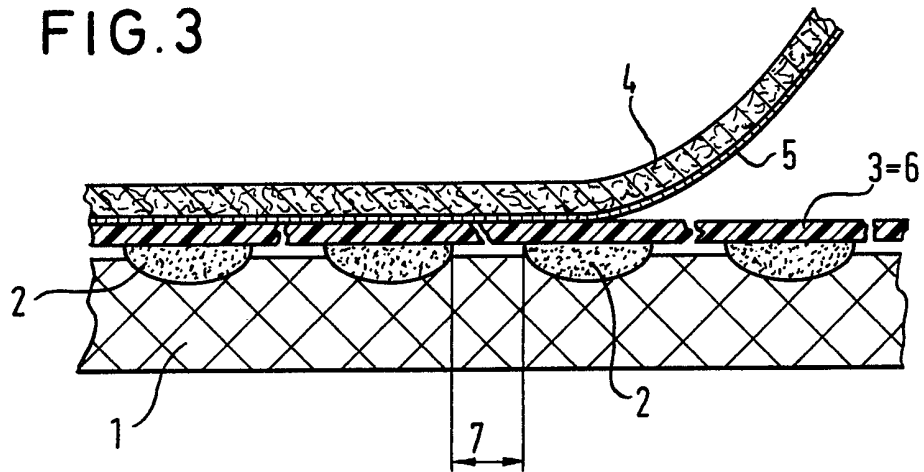
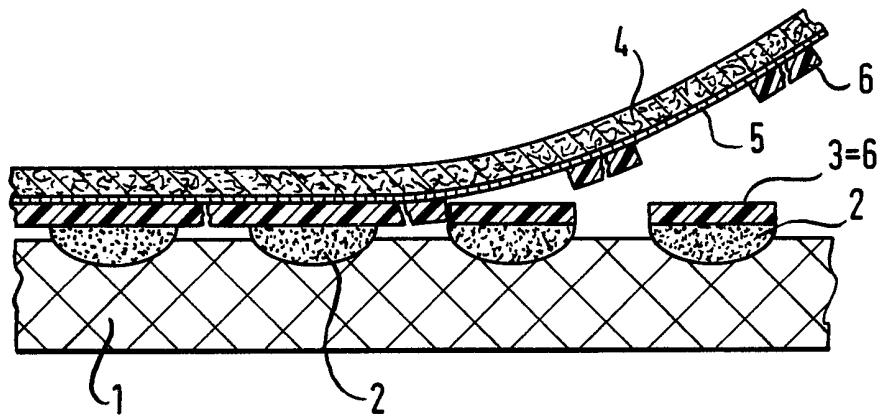


FIG. 4



SPECIFICATION

Top Cloth for Articles of Clothing as well as a Manufacturing Process and Transfer Unit for it

The invention concerns a top cloth, especially top
 5 cloth cut, for articles of clothing with a one-sided
 patterned coating for its stabilization. Such
 stabilized top cloths or top cloth cuts are used for
 smoothing or keeping smooth certain parts of
 10 articles of clothing, such as frontal areas, sleeves,
 collars, plates and the like.

For smoothing or keeping smooth clothes, today
 the so-called fixing linings are used almost
 exclusively. They consist of a fabric, a fleece,
 knitwear or woven textile and are coated with
 15 hot-sealable adhesives in patterned form. The fixing
 linings are affixed using fixing presses on the
 cuttings of the top cloth. Due to the lining the article
 of clothing is given a smooth pleasing appearance
 which also remains to a large extent under different
 20 climatic conditions. The article need only seldom be
 ironed to look good, shapely and smooth.

Since recently ever-increasing optimal softness
 has been demanded from the article, but without
 losing the effect of smoothness, ever lighter linings
 25 are being processed which have scarcely any
 handle. The patterned adhesive coating of
 especially light and thin lining materials, in view of
 the demand for the attainment of adequate
 connection with the top cloth, tends to penetrate
 30 through the lining. During fixing in the fixing press
 the linings remain hanging together with the affixed
 top shell on the top cloth of the press. In the case of
 the widely practised sandwich fixing in which two
 identical top cloth cuts are fixed in one working
 35 process with interposed linings in common, there is
 a so-called refastening process between the rear
 sides of the lining materials, i.e. the two linings tend
 to stick on their superimposed rear sides. Other
 problems also arise such as for example the
 40 agglutination of the backing materials with the back
 of the lining during the ironing of the article in the
 final processing stage. It is true that these defects
 can be largely eliminated by reducing the amount of
 adhesive; but then in many cases the adhesion is no
 45 longer sufficient.

To reduce the reaction tendency an adhesive
 coating on linings has become known in which the
 patterned arrangement of the adhesives has a
 double-layered composition. The lower layer resting
 50 directly on the lining has a lower thermoplastic flow
 than the actual adhesive layer placed upon it
 (DE—AS—25 36 911). Using such a double coating
 the reaction tendency and the refastening are
 reduced, but are not eliminated in full.

At all events however the affixing of fixing linings
 produces not only a smoothing effect but also a
 clear tautening of the handle of the article in the
 fixed area, a phenomenon which in the fashion
 trends today is increasingly undesirable. To do
 60 justice to the trend of fashion, recently there has
 been a return to the classical lining processing, in
 which the linings are no longer ironed on, but are
 sewn in as in the past. However this means
 accepting higher labour costs, since the old classical

65 sewing of the linings is considerably more costly for
 the production of an article of clothing which looks
 as smooth as a front-fused article.

Recently processes have become known in which
 both the classical as well as the front fused linings
 70 are replaced by patterned plastic substances. In this
 working technology the top cloth cuts tend during
 the curing process to undergo yellowing and
 changes in colour tones as well as shrinkage
 reducing the volume of the top cloth, and the use of
 75 this printing technique is substantially limited solely
 to voluminous top cloths.

Equally known is a process in which extruded
 adhesive meshes are ironed on to the top cloth,
 having a double-layered design. On the side facing
 80 the top cloth the meshes become adhesively active
 under the influence of pressure and heat, but not on
 the other side. Here too there is a strong tautening
 of the handle and its use is also limited to
 voluminous top cloths. For when using less
 85 voluminous top cloths, the mesh structure is
 discernible on the top cloth side.

To be able to process even thin top cloths without
 loss of volume using a printing technology and to
 achieve a more textile handle, it is known from
 90 DE—A1 30 14 656 that on the rear side of top cloth
 cuts, thermosetting, high-viscosity dispersion
 pastes can be applied in pattern form which
 substantially only adhere on the top cloth rear side
 and do not penetrate into the top cloth. The
 95 patterned imprint serves as the bonding substance
 for flocks which are electrostatically injected. With
 this flocking process, after a two-stage curing a
 composite of top cloth and flock layers is obtained
 which are soft, supple and full-bodied and
 100 simultaneously cause the desired smoothing.
 However it is not possible almost completely to
 eliminate the tautening of the handle. In addition the
 two named printing technologies require high
 investment costs and demand from the garment
 105 maker knowledge of working techniques which are
 not part of his profession.

In this specification the terms "patterned coating"
 or "patterned elements" are used to mean a
 plurality of substantially coplanar elements
 110 arranged in a pattern, such as a raster-form.

The invention is therefore based on the object of
 forming a top cloth or top cloth cut with patterned
 coating so that using it, clothes are produced which,
 without the use of specially inserted stiffening
 115 linings in certain areas, have the desired
 smoothness of an article with lining, yet in the
 handle (the feeling of softness and the full-bodied
 quality when touched with the hand) have about the
 same softness as an article with the classically
 120 inserted lining. The invention is further based on the
 object of creating a process for the production of
 such a top cloth and the necessary aids to this end.

The first named object is inventively solved in that
 the coating of the top cloth has a patterned hot-
 sealable plastic-containing lower adhesive layer
 adhering to the top cloth which layer is not
 interconnected in the plane and a top layer adhering
 to said lower layer, which top layer is of non-hot
 125 sealable or substantially non-hot sealable material.

By a hot sealable substance a substance is defined here which in conditions such as those during ironing or affixing of such a substance on a substrate, e.g. a top cloth, and also under the given pressure and temperature conditions (pressures from 50 to 500 p/cm²=cN/cm², preferably 200 to 400 p/cm² and temperatures from 100 to 180°C, preferably 120 to 170°C) become adhesively active, i.e. in these conditions it can adhere to the objects or materials pressed upon it, and wherein this adhesive activity can again be obtained in such conditions, and thus full chemical curing of the adhesives does not occur during ironing or fixing.

By non-hot sealable or substantially non-hot sealable materials we mean all materials or raw materials which under ironing or fixing conditions are not or do not become adhesively active, and thus in these conditions are not hot-sealable.

A special advantage is the fact that the inventive top cloth also remains stable in dimensions even under changing climatic conditions, whereas uncoated cuttings often show a tendency to extend, especially on suspended articles of clothing. For articles with top cloths as in the invention, in which stiffening linings have been inserted in the classical way, this leads to the fact that the top cloth does not undulate at the seams and thus the article maintains its smooth state, which with articles of a non-inventive top cloth and with stiffeners classically inserted is seldom the case.

The inventive top cloth can be used for keeping smooth or stabilizing not only frontal areas but also seams, collars, lapels, tabs or the like of outerwear, where the article is to have a smooth fit and yet nevertheless a soft handle. It can also be used universally for blouses regardless of the colour design of the top cloth.

Expediently with the inventive top cloth the top layer extends in the same pattern as the lower adhesive layer, while both layers are placed with their patterns precisely matching. Such a top cloth is distinguished by its special softness and air permeability, so that when using it a good-breathing article is obtained.

A further embodiment of the inventive top cloth may also be expedient in which the covering layer extends continuously without pattern over the lower patterned adhesive layer below it and extends beyond the latter. The covering layer may not abut the top cloth substantially or may only adhere to it slightly in its areas between the pattern points of the adhesive layer. The release of the covering layer from the top cloth should be made possible in the intermediate areas by mechanical influences, such as beating, brushing, wiping or the like.

The patterned adhesive layer may consist of hot melt adhesive (hot sealable) material, e.g. on the basis of copolyamides, copolyesters, and/or low pressure polyethylenes or the like which are applied as powder or as paste and can be formed therefrom, whereas the top covering layer acting as the barrier against reactivation of the lower adhesive layer consists of material which is substantially nonadhesive up to 180°C and may e.g. be formed from an aqueous pasty substance which can contain

finely dispersed plastics, mineral fillers or mixtures thereof.

The invention further concerns a process for the production of the inventive top cloth which is characterized in claim 11. In this process firstly on a flat substrate the two layers with which the top cloth is to be coated are moved to each other in the reverse position, i.e. the non-hot sealable covering layer on the support layer and above the latter and hot sealable adhesive layer, whereupon the layer carrier (normally a flat substrate) is placed as a transfer unit with its patterned adhesive layer downwards on the top cloth, and the adhesive layer is made to adhere firmly by using pressure and heat on the top cloth. The carrier is now removed from the transferred coating. The basic layer now forming the covering layer on the top cloth can be made to drop off the top cloth by mechanical means such as wiping, beating, brushing or the like in its areas adhering on the pattern of the adhesive layer. To facilitate the removal of the carrier layer from the basic layer after its application on said top cloth, before the application of the basic layer on the carrier layer, an anti-adhesive agent may expediently be applied on said carrier layer. But it is also possible to coordinate the adhesion of the basic layer on the carrier and on the adhesive layer so well that the basic layer only detaches itself from the layer carrier in its areas sitting on said patterned adhesive layer and that otherwise it is removed with the layer carrier in the residual areas between the pattern of the adhesive layer. In this case the beating, wiping and the brushing can be omitted.

The invention also concerns the above transfer unit for effecting the named process, consisting of a layer carrier, a unilaterally applied not-hot sealable or substantially non-hot sealable base layer applied on said layer carrier, while the basic layer extends continuously, i.e. unpatterned, over the support, having on said basic layer a patterned hot-sealable adhesive layer.

It is an advantage if the baselayer forming the later covering layer on the carrier layer, when being removed from the layer carrier after the application of the two layers on the top cloth, is partly withdrawn, i.e. with the areas between the pattern, in so far as it is ensured that the patterns of the adhesive layer remain fully covered by the residual portion of the basic layer, to avoid any agglutination of the coated top cloth and/or cutting with the other fabric areas or with other substances.

The drawings show an especially expedient embodiment of the inventive top cloth and of the inventive process for its production, which will be described in more detail below:

Fig. 1 shows the embodiment of the inventive top cloth in schematically enlarged section;

Fig. 2 reveals the transfer unit for the application of the inventive coating as in the embodiment of fig. 1 in schematically enlarged section;

Figs. 3 and 4 disclose the coating of the top cloth as in the embodiment of fig. 1 in the same schematic section. Fig. 3 shows the later wiping of the intermediate areas between the adhesive pattern, but fig. 4 does not.

In the embodiment shown in fig. 1, the top cloth cut 1 is covered with a hot-sealable adhesive layer 2 on a plastic basis in polka dot pattern. The pattern dots of this layer are covered by superimposed dots of a covering layer 3 made of non-hot sealable material. On the dots 2 placed on the top cloth 1 there is a congruent layer 3. The dot pattern may have rod form.

By the use of pressure and heat the dots of the lower adhesive layer 2 are made to adhere on the top cloth cut 1 and on the dots of the superimposed covering layer 3.

Fig. 2 shows a transfer unit for the application of the two adjacent layers 2 and 3 on the top cloth 1.

This transfer unit consists of a layer carrier or substrate 4 in the form of a cutting made of sulfate paper or the like on which an anti-adhesive layer 5 is applied. On this anti-adhesive layer there is a continuously extending, i.e. non-patterned, base layer 4 stretching over the substrate 4, and made of non-heat sealable or substantially non-heat sealable material. To be able to obtain this flat base layer in the identical layer thickness, it can for example be printed on as paste or powder using a patterned film screen and then be coated smooth with a flat rubber lip, a steel blade or a rotary or fixed smoothing roller. The closed fabric base layer thus produced is then dried to form a slightly porous and rough film, which owing to its nature and its flatness adheres well enough on the substrate 4 and/or on the anti-adhesive layer 5 applied thereon.

On this flat base layer 6 the hot sealable adhesive layer 2 is applied in polka dot pattern. It can also be printed on as paste or powder, e.g. using a film screen of e.g. 25 mesh or of a similar mesh.

The transfer unit shown in fig. 2 of the embodiment can be turned through 180° and placed with its punctiform adhesive layer 2 downwards on the top cloth cut 1 which is to be coated, after which, by the use of pressure and heat, the dots of the adhesive layer are made to adhere on the top cloth cut 1. Then the substrate 4 with its anti-adhesive layer 5 can be removed from the base layer 6 forming the covering layer on the top cloth cut, so that now the dots of the adhesive layer 2 and above them the still fairly continuous unpatterned base layer 6 forming the covering layer are disposed on the top cloth cut (see fig. 3). The base layer 6 consisting of substantially non-hot sealable material is made so that it can be caused to drop off the top cloth 1 in its areas between the dots of adhesive layer 2, e.g. by mechanical influences such as wiping, beating or the like, so that it remains on the subordinated dots of the adhesive layer 2 only in the form of the punctiform covering layer shown in fig. 1. Then the treatment in the processing of the top cloth in the usual course of garment production suffices to effect a thorough removal of the non-anchored intermediate areas of the covering and/or base layer. But it is also possible to adjust the adhesion of the base layer directly so that it is detached from the carrier only in its areas which rest in patterned form on the adhesive layer while the intermediate areas remain suspended on said carrier (see. fig. 4).

The base layer 6 forming the covering layer 3 can consist of material which is substantially non-adhesive at temperatures up to 180°C, and which is applied as powder or as a paste, e.g. a pasty substance of finely dispersed plastic filler which is dispersable in water and is non-adhesive up to 180°C, made of mineral fillers, mixtures thereof or the like. The plastic can be a PVC powder, and can be applied in aqueous dispersion in combination with a thickener and a fatty acid or its salt. Advantageously the dispersion contains further silicons which should preferably be cross-linkable. As the thickener, a thickener on the basis of polymer acrylic acids or their salts can be used. But the dispersion can also contain instead or additionally starch, carboxymethylcellulose, hydroxyethylcellulose, gelatine or mixtures thereof as the thickener.

If the covering or base layer consists of or contains mineral fillers, pulverized silicic acid, talcum powder, calcium carbonate powder or the like can be used as the fillers. Lastly pastes can also be used whose volatile parts contain solvents. Thus e.g. cross-linkable polyurethane dissolved in a solvent or cross-linkable polyacrylate dispersed in water mixed with mineral fillers or fillers on a plastic basis as well as fatty acids or their salts and cross-linkable silicons can be used.

As the layer carrier or substrate for the transfer coating, primarily use is made of sulfate paper with an anti-adhesive coat (silicon paper). But instead of silicon paper, sheets, for example viscose foil sheets are usable when thin, which may also have an anti-adhesive layer of silicon.

Flocking materials such as those described in DE—OS 3014 656 are not considered for the formation of the non- or substantially non-hot sealable covering or base layer, or are only considered under certain conditions.

105 EXAMPLE

Sulfate paper siliconized on one side, of 50 g/m² in weight, is printed with paste using an 11 mesh film screen in patterned form. This paste has the following composition in parts by weight (PW):

- 110 20 PW suspension PVC (K value under DIN 53726 about 65) grain size less than 60 microns more than 97%
- 6 PW behenic acid
- 10 PW ammoniacal alkaline aqueous solution of
- 115 10% polyacrylic acid (pH=11)
- 30 PW aqueous polymethacrylic acid dispersion 30%
- 7.2 PW silicon finish VP 1419 E from Wacker-Chemie GmbH, Munich (FRG)
- 120 2.8 silicon cross-linker VP 1420 from Wacker-Chemie GmbH, Munich (FRG)
- 84 PW water

The pasty applied printing is smoothly applied over the entire width of the paper by a rotating and a fixed smoothing roller to form a flat base layer. Then the paper sheet passes via a dryer, where the base layer is dried at about 150°C and is cross-linked. The dry coating weight of the base layer is between 15 and 20 g/m².

In a second run the paper sheet is coated in 25 dot pattern with a paste which has the following composition in parts by weight (PW):

- 36 PW copolyamide powder 0—80 microns
- 5 6 PW stearin
14 PW suspension PVC (K value under DIN 53726 about 65) grain size less than 60 microns above 97%
14 PW ammoniacal alkaline solution of 10% polyacrylic acid in water
- 10 9 PW acronal 160 D (from BASF AG,FRG) (=40% aqueous dispersion on the basis of a non-cross-linked acrylic acid ester-acryl nitrile copolymerizate with high oil stability, hard film formation and good thermal stability up to about 60°C
- 15 72 PW water.
The patterned coating (adhesive layer) is also dried and then sintered. The dryer setting is 140°C. The applied weight of the adhesive coating is 15 g dry weight/m².
- 20 Cuttings are cut out of the paper sheet thus coated. The cuts are placed with the adhesive coat first on the back of the top cloth cuts. In a fixing press the coating is affixed at 165°C top plate temperature, 100°C lower plate temperature, 15
- 25 seconds fixing time and 300 p/m² on the top cloth cut. After opening the fixing press and cooling the ironed composite, the siliconized sulfate paper is removed. The top cloth now allows the base layer forming the covering layer on it in the areas
- 30 adhering on the pattern of the adhesive layer to be easily wiped from the top cloth by using a cloth or a clothes brush. There remains an exact patterned double coating on the back of the top cloth, which shows no more adhesion when a lining material is
- 35 ironed onto the top cloth. Even in the case of ironing folds in which the coated sides come to rest on each other, no more adhesion is found between the sides. The folded part opens by itself after ironing.
To avoid the necessity to wipe off the areas of the
- 40 base layer between the patterned dots of the adhesive layer after the removal of the carrier from the top cloth, a paste can be applied which forms a base layer, whose removal is done as in fig. 4. The paste composition is as follows:
- 45 20 PW suspension PVC (K value under DIN 53726 about 65), grain size less than 60 microns above 97%
3 PW magnesium stearate powder most finely dispersed
- 50 10.4 PW rohagit S from Röhm GmbH, Darmstadt FRG(=carboxyl group-containing extremely low viscosity acryl resin (acidic number 410 to 430 mg KOH/g, viscosity about 70 mPa.s (milli.Pascale.s) in a 3% aqueous solution adjusted to pH 9 using
- 55 ammonia).
4 PW concentrated ammonia
30 PW aqueous polymethylacrylic acid dispersion 30%
5 PW silicon finish 1419 E from Wacker-Chemie,
- 60 Munich FRG
1.6 PW silicon cross-linker VP 1420 from Wacker-Chemie GmbH, Munich FRG.
84 PW water
The cuts of the top cloth thus treated pass through
- 65 the make-up in the conventional way and are

processed into finished articles. For example the top cloth cut can be wholly provided with the inventive pattern coating and the insertion of a fixing lining in the garment is then unnecessary. But it is also

- 70 possible to provide the inventive coating only on the seam, revers, collar or lapel areas of a garment to achieve the desired stabilization, without having to accept any clear hardening of the handle. For example if the front of a jacket is provided in the
- 75 button hole area with this inventive coating, in addition a conventional lining not equipped with hot seal adhesive can be sewn in, without having to fear an undulating deformed formation of the
- 80 buttonhole edge. In this way the old and conventional modus operandi can be revived without any need for the high labour costs to remove the undulations.

CLAIMS

1. Top cloth, especially a top cloth cut for articles
- 85 of clothing, with a one-sided patterned coating for its stabilization, wherein the coating consists of a lower adhesive layer (2) of patterned, hot-sealable plastics elements which are not interconnected in the plane of the adhesive layer (2) and which adhere
- 90 to the rear of the top cloth and an upper covering layer (3) adhering to the layer (2), wherein said layer (3) consists of a non-hot-sealable or substantially non-hot-sealable material.
2. Top cloth, especially a top cloth cut as in claim
- 95 1, wherein said covering layer (3) is designed in the same pattern as the adhesive layer (2) below it and fits exactly with its pattern on the pattern of said lower adhesive layer.
3. Top cloth, especially a top cloth cut as in claim
- 100 1, wherein said covering layer (3) extends substantially or fairly continuously, i.e. without pattern, over the patterned adhesive layer (2) below it, and in its areas between the pattern points of the lower layer does not substantially adhere to top
- 105 cloth (1) or does so adhere only slightly.
4. Top cloth, especially a top cloth cut as in claim 3, wherein the covering layer (3) is made so that it is easily detachable in its areas (7) not adhering or only adhering slightly to said top cloth (1) between the pattern points, by mechanical influence such as beating, brushing, wiping, or the like from said top cloth.
5. Top cloth, especially a top cloth cut as in claim 1, wherein the patterned lower adhesive layer (2)
- 115 consists of an hot melt adhesive (hot sealable) material which is applied as a paste or a powder and is formed therefrom.
6. Top cloth, especially a top cloth as in claim 5, wherein the hot melt adhesive (hot sealable)
- 120 material of the lower adhesive layer (2) is based on copolyamides, copolyesters, and/or on low pressure polyethylenes.
7. Top cloth, especially a top cloth as in claim 1, wherein the upper covering layer (3) consists of a substantially non-adhesive material up to 180°C, and is formed from an aqueous-pasty substance which contains e.g. finely dispersed plastics which are not adhesive up to 180°C, mineral fillers or mixtures thereof.

8. Top cloth, especially a top cloth cut as in claim 7, wherein the plastic share of the cover layer is based on thermoplast or on duroplast.

9. Top cloth, especially a top cloth cut as in claim 7, wherein the covering layer (3) is formed from a dispersion of finely-dispersed plastic such as PVC in combination with water-soluble thickeners on the basis of salts of polymer acrylic acids, of starch, carboxymethylcellulose, hydroxyethylcellulose, gelatine or the like and fatty acids and/or their salts and cross-linkable silicones.

10. Top cloth, especially a top cloth cut as in claim 7, wherein the mineral fillers contained in the covering layer consist of powdery silicic acid, talcum powder, calcium carbonate powder or the like.

11. Process for the manufacture of a top cloth, especially of a top cloth cut as in claim 1, wherein firstly a layer carrier, e.g. siliconized paper, is covered on one side with a continuous, i.e. patternless base layer extending over this substrate side and only adhering slightly thereto, which later forms on the top cloth to be coated its covering layer and consists of substantially non-hot-sealable or non-hot-sealable material, in that then a patterned adhesive layer of hot-sealable plastic is applied thereon, in that next the layer carrier thus coated is applied as a transfer unit with its patterned adhesive layer downwards on the rear of said top cloth, while using pressure and heat to soften the adhesive layer and to affix it securely on said top cloth, whereupon the layer carrier is withdrawn from the base layer now forming the covering layer on the top cloth in its areas projecting in patterned form on the adhesive layer, whereby this base layer may remain adhering on said layer carrier in its areas adhering between the adhesive layer on the pattern.

12. Process as in claim 11, wherein before the

application of the base layer an anti-adhesive agent is applied on the layer carrier.

13. Process as in claim 11, wherein the base layer is produced on said layer carrier by applying a patterned print of the material forming the base layer, e.g. with the aid of a printing screen, and then smoothing said patterned print into a continuous, unpatterned, thin layer.

14. Process as in claim 11, wherein the base layer is applied in a flow-capable or pasty state and is solidified before the application of the adhesive layer.

15. Process as in claim 11, wherein the patterned adhesive layer is applied in the paste- or powder printing process as a paste or a powder.

16. Transfer unit for the process as in claim 11, wherein it consists of a flat layer carrier (4), a unilaterally applied and continuous, i.e. unpatterned base layer (6) extending over the layer carrier which is non-hot-sealable or substantially non-hot-sealable and a patterned hot-sealable adhesive layer (2) thereon, whereby the layer carrier is easily withdrawn after the fusing on of the layers transferred by it to the top cloth from the base layer piled on the adhesive pattern.

17. Transfer unit as in claim 16, wherein the base layer (6) is slightly porous and rough.

18. Transfer unit as in claim 16, wherein the layer carrier (4) bears below the base layer (6) an anti-adhesive layer (5).

19. A top cloth for articles of clothing substantially as described herein with reference to, and as illustrated in the accompanying drawings and as described with reference to the examples.

20. A process for making a top cloth for articles of clothing substantially as described herein with reference to, and as illustrated in the accompanying drawings and as described with reference to the example.