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(71) Applicant(s):
Securency International Pty Ltd
(Incorporated in Australia)
Potter Street, Craigieburn, Victoria 3064,
Australia

(72) Inventor(s):
Odisea Batistatos
Gary Fairless Power

(74) Agent and/or Address for Service:
Appleyard Lees
15 Clare Road, HALIFAX, West Yorkshire,
HX1 2HY, United Kingdom

(54) Abstract Title: **Radiation curable embossed ink security devices for security documents**

(57) A security document and a method of manufacturing a security document are provided in which a radiation curable ink (18) is applied to at least one side of a substrate (11) including at least one region of transparent plastics material forming a window or half-window area (16; 26). The ink is embossed while soft and cured with radiation (242) to form an embossed security device (19) within the window or half-window area including one or more of a diffractive structure, a lens structure or other security element having a relief structure.

