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**Ambidextrous fish scale-textured glove**

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## **ABSTRACT**

The described invention relates to an ambidextrous working glove having fish scale-textured inner and outer surfaces and methods of making same.

## **AMBIDEXTROUS FISH SCALE-TEXTURED GLOVE**

### **FIELD OF THE INVENTION**

The described invention relates to an ambidextrous working glove having fish scale-textured inner and outer surfaces and methods of making same.

### **CROSS REFERENCE**

The present application is a divisional of Australian patent application no. 2024203023, which is a divisional of Australian application no. 2022201607, which is a divisional of Australian application no. 2019261678, which is a divisional of Australian application no. 2013375908, which was the national phase entry of PCT/US2013/074919, the entire specifications of which are incorporated herein by cross-reference.

### **BACKGROUND**

Typical uses of working gloves include food processing, chemical handling, pesticide spraying, and the like. The thickness of working gloves should not hamper tactile sensation. However, the working gloves should be strong enough to resist rupture. It is desirable in working gloves to provide roughened or textured inner and outer surfaces, since working gloves with smooth surfaces make gripping items difficult for a wearer. A textured outer surface enables a wearer to adequately grip items that may be slippery. In addition, the inner surface of the glove is in close contact with the wearer's skin and does not absorb the wearer's perspiration. A textured inner surface may reduce the likelihood of slippage of the wearer's hand inside the working glove during use that may be caused by perspiration, wherein the textured inner surface may enable the perspiration to flow away from any pressured surface without "skating" of the glove over the surface of the wearer's hand.

Current attempts to form a glove with textured inner and outer surfaces have employed methods whereby a texture is imparted to the inner surface by using a textured form, and either treating the film forming the glove in a manner that erodes the film thereby creating texture on the outer surface, or by spraying particles onto the outer surface of the glove. Such methods are unsatisfactory, due to various factors, such as, for example, lack of dexterity, difficulty in donning, non-uniform thickness of the glove causing the glove to rupture during use.

Current working gloves frequently utilize donning powders, such as, for example, cornstarch or talc, to enable a wearer to don the glove more easily. However, donning powders can contaminate wounds, irritate skin, leave a residue on equipment and clothing, and mechanically interfere with some procedures that a user may perform while wearing the working glove.

Previous attempts to ameliorate the slippage of the glove caused by the wearer's perspiration have proved unsuccessful. For example, cotton flock linings frequently are only able to absorb small amount of perspiration before losing their effectiveness.

Additionally, present methods to impart a contact-reducing texture to the inner surface of the glove to ameliorate the effects of the wearer's perspiration and/or aid donning frequently reduce mechanical performance of the glove, leading to rupture of the glove.

Accordingly, there remains a need for a working glove with textured inner and outer surfaces, with improved dexterity, ease of donning and a reduced frequency of failure during use.

### SUMMARY

The present invention provides an ambidextrous working glove having fish scale-textured inner and outer surfaces and methods of making same.

In one embodiment, the present invention provides a method for making an ambidextrous working glove having fish scale-textured inner and outer surfaces comprising the steps of:

- a. providing a first polymer solution;
- b. providing a coagulant solution;
- c. providing a second polymer solution;

- d. providing at least one former having a fish scale-textured surface and dipping the at least one former into the coagulant solution to coat the at least one former with coagulant;
- 55 e. removing the at least one former from the coagulant solution and drying the coagulant coating on the at least one former;
- f. dipping the at least one former coated with coagulant into the first polymer solution, and allowing the first polymer solution to coat the at least one former;
- 60 g. removing the at least one former from the first polymer solution and drying the polymer coating on the at least one former, forming a film;
- h. washing the film on the at least one former, and dipping the film coated at least one former into a second polymer solution, and allowing the second polymer solution to coat the film; and
- 65 i. stripping the glove from the at least one former.

In one embodiment, the ambidextrous working glove of the present invention complies with at least one requirement selected from the group consisting of FFDC requirements for food handling, European Standard EN374-3, European Standard EN388:2003, European Standard EN374-2, European Standard  
70 EN420:2003, European Standard EN1186:2002, and European Standard EN421:2010.

In one embodiment, the ambidextrous working glove of the present invention complies with FFDC requirements for food handling.

In one embodiment, the ambidextrous working glove of the present invention  
75 complies with European Standard EN374-3.

In one embodiment, the ambidextrous working glove of the present invention complies with European Standard EN388:2003.

In one embodiment, the ambidextrous working glove of the present invention complies with European Standard EN374-2.

80 In one embodiment, the ambidextrous working glove of the present invention complies with European Standard EN420:2003.

In one embodiment, the ambidextrous working glove of the present invention complies with European Standard EN1186:2002.

85 In one embodiment, the ambidextrous working glove of the present invention complies with European Standard EN421:2010.

In one embodiment, the at least one former has a fish scale-textured surface that imparts a fish scale-texture to the ambidextrous working glove of the present invention. In one embodiment, the fish scale-textured surface of the at least one former imparts a fish scale-texture to the inner and outer surfaces of the  
90 ambidextrous working glove of the present invention.

In one embodiment, first polymer solution is a synthetic rubber copolymer solution. The synthetic rubber copolymer solution may be a solution comprising a copolymer of acetonitrile and butadiene.

In one embodiment, first polymer solution is a latex solution.

95 In one embodiment, second polymer solution is a solution that allows the ambidextrous working glove of the present invention to slide over a wearer's hand while the glove is being donned. In one embodiment, the second polymer solution is a polyurethane solution.

100 In one embodiment, the present invention provides an ambidextrous working glove having fish scale-textured inner and outer surfaces.

In one embodiment, the present invention provides at least one former for making an ambidextrous an ambidextrous working glove having fish scale-textured inner and outer surfaces wherein:

- 105 a. the surface of the at least one former is textured on the front and back of the region of the at least one former that forms the fingers of the ambidextrous working glove;
- b. the surface of the at least one former is textured on the region of the at least one former that forms the palm of the ambidextrous working glove;
- 110 c. the surface of the at least one former is textured on the region of the at least one former that forms the back of the ambidextrous working glove; and
- d. the surface of the at least one former is textured on the region of the at least one former that forms the region of the thumb that faces the palm of the ambidextrous working glove.

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**BRIEF DESCRIPTION OF THE DRAWINGS**

Figure 1 depicts one method by which one embodiment of the ambidextrous working glove of the present invention may be formed.

Figure 2 shows an at least one former that is utilized to form one embodiment of the ambidextrous working glove of the present invention.

- 120 Figure 3 shows the dimensions of the fish scale pattern etched or engraved into an at least one former used to make one embodiment of the ambidextrous working glove of the present invention.

Figure 4 shows a perspective view of an at least one former that is utilized to form one embodiment of the ambidextrous working glove of the present invention.

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Figure 5 shows a front view of an at least one former that is utilized to form one embodiment of the ambidextrous working glove of the present invention.

Figure 6 shows a rear view of an at least one former that is utilized to form one embodiment of the ambidextrous working glove of the present invention.

130 Figure 7 panel a) shows a left view of an at least one former that is utilized to form one embodiment of the ambidextrous working glove of the present invention. Panel b) shows a right view of an at least one former that is utilized to form one embodiment of the ambidextrous working glove of the present invention.

135 Figure 8 panel a) shows a top view of an at least one former that is utilized to form one embodiment of the ambidextrous working glove of the present invention. Panel b) shows a bottom view of an at least one former that is utilized to form one embodiment of the ambidextrous working glove of the present invention.

140 Figure 9 shows one embodiment of the ambidextrous working glove of the present invention on an at least one former prior to stripping from the former.

Figure 10 panel (a) shows the palm of one embodiment of the ambidextrous working glove of the present invention. Panel (b) shows the back of one embodiment of the wearable glove of the present invention.

145 Figure 11 shows the inner surface of one embodiment of the ambidextrous working glove of the present invention.

Figure 12 shows a perspective view of one embodiment of the ambidextrous working glove of the present invention.

150 Figure 13 shows a front view of one embodiment of the ambidextrous working glove of the present invention.

Figure 14 shows a rear view of one embodiment of the ambidextrous working glove of the present invention.

Figure 14 panel a) shows a left view of one embodiment of the ambidextrous working glove of the present invention. Panel b) shows a right view of one embodiment of the ambidextrous working glove of the present invention.

Figure 16 panel a) shows a top view of one embodiment of the ambidextrous working glove of the present invention. Panel b) shows a bottom view of one embodiment of the ambidextrous working glove of the present invention.

### DETAILED DESCRIPTION

160 In one embodiment, the ambidextrous working glove of the present invention is formed on at least one former, which may be suitably mounted on a desired carrier, such as a movable board or a conveyor chain, The at least one former is carried sequentially through a series of steps as illustrated schematically in Figure 1. In forming the ambidextrous working glove of the present invention, it is preferable to dip the at least one former into a bath of suitable coagulant material. The coagulant may control the thickness of the film of the first polymer solution that forms on the at least one former, that forms the ambidextrous working glove of the present invention. Alternatively, the coagulant may assist in the later removal of the ambidextrous working glove of the present invention from the at least one former. Alternatively, the coagulant solution may control the thickness of the film of the first polymer solution and may assist in the later removal of the ambidextrous working glove of the present invention from the at least one former. The at least one former is dipped into a slip dip bath of a first polymer solution to form a film on the at least one former. The film coated at least one former is passed through an oven to solidify the film. The solid film coated at least one former is then washed or leached to remove any contaminants, then the washed solid film coated at least one former is then dipped into a second polymer solution that coats the solid film coated at least one former. A bead is formed on the coated film on the at least one former, and the finished glove is then stripped from the at least one former.

In certain embodiments, the coated film may be treated before the finished glove is stripped from the at least one former. The treatment may be vulcanization. Alternatively, the coated film may be treated with at least one additional chemical. Examples of the at least one additional chemical may include  
185 antimicrobial agents, such as the antimicrobial coating disclosed in EP 1965719 A2.

Referring to Figure 1, an ambidextrous working glove having fish scale-textured inner and outer surfaces is made via a method comprising the steps of:

- a. providing a first polymer solution;
- 190 b. providing a coagulant solution;
- c. providing a second polymer solution;
- d. providing at least one former having a fish scale-textured surface and dipping the at least one former into the coagulant solution to coat the at least one former with coagulant;
- 195 e. removing the at least one former from the coagulant solution and drying the coagulant coating on the at least one former;
- f. dipping the at least one former coated with coagulant into the first polymer solution, and allowing the first polymer solution to coat the at least one former;
- 200 g. removing the at least one former from the first polymer solution and drying the polymer coating on the at least one former, forming a film;
- h. washing the film on the at least one former, and dipping the film coated at least one former into a second polymer solution, and allowing the second polymer solution to coat the film; and
- 205 i. stripping the glove from the at least one former.

In one embodiment, the finished gloves may then be further processed. Such further processing may include, for example, packaging, sterilization, and the like.

210 In one embodiment, prior to removal of the finished glove from the at least one former, the finished glove may be treated with at least one additional chemical. Examples of the at least one additional chemical may include antimicrobial agents, such as the antimicrobial coating disclosed in EP 1965719 A2. The inner surface of the finished glove may be treated with at least one additional chemical. Alternatively, the outer surface of the finished glove may be treated with at least  
215 one additional chemical. Alternatively, both the inner and outer surface of the finished glove may be treated with at least one additional chemical.

The first polymer solution may be any polymer suitable for forming a working glove that complies with at least one requirement selected from the group consisting of FFDCA requirements for food handling, European Standard  
220 EN374-3, European Standard EN388:2003, European Standard EN374-2, European Standard EN420:2003, European Standard EN1186:2002, and European Standard EN421:2010.

The first polymer solution may be any polymer suitable for forming a working glove that complies with European Standard EN374-3 for chemical resistance.  
225 Alternatively, the first polymer solution may be any polymer suitable for forming a working glove that complies with FFDCA requirements for food handling. Alternatively, the first polymer solution may be any polymer suitable for forming a working glove that complies with European Standard EN388:2003 for protective gloves against mechanical risks. Alternatively, the first polymer  
230 solution may be any polymer suitable for forming a working glove that complies with European Standard EN374-2. Alternatively, the first polymer solution may be any polymer suitable for forming a working glove that complies with European Standard EN420:2003. Alternatively, the first polymer solution may be any polymer suitable for forming a working glove that complies with

235 European Standard EN1186:2002. Alternatively, the first polymer solution may be any polymer suitable for forming a working glove that complies with European Standard EN421:2010.

In one embodiment, the first polymer solution is latex. In an alternate embodiment, the first polymer solution is a synthetic rubber copolymer solution.

240 The synthetic rubber copolymer may be a solution comprising a copolymer of acetonitrile and butadiene.

In one embodiment, the first polymer solution is a solution comprising a mixture of nitrile latex, sulphur, zinc oxide, titanium dioxide, zinc dibutyldithiocarbamate (ZDBC), ammonia, vultamol and potassium hydroxide.

245 In one embodiment, the solution the first polymer solution is a solution comprising a mixture of nitrile latex, sulphur, zinc oxide, titanium dioxide, ZDBC, ammonia, vultamol and potassium hydroxide is formed according to the mixture set forth in Table 1 below.

**Table 1**

<b>Chemical</b>	<b>Parts per hundred of rubber</b>
Nitrile latex (43% v/v, initial concentration)	100
Sulphur powder	1.34
Zinc oxide	1.74
Titanium dioxide	1.88

Chemical	Parts per hundred of rubber
ZDBC	1.05
Ammonia (12% v/v initial concentration)	3.60
Vultamol	0.23
Potassium hydroxide	0.87

250 In one embodiment, the first polymer solution is the solution comprising the copolymer of acetonitrile and butadiene disclosed in WO2007105122 A1.

In one embodiment, the first polymer solution is the solution comprising the copolymer of acetonitrile and butadiene disclosed in EP1435374 A2.

255 In one embodiment, the first polymer solution is the solution comprising the copolymer of acetonitrile and butadiene disclosed in EP1260549 A1.

In one embodiment, the first polymer solution is the solution comprising the copolymer of acetonitrile and butadiene disclosed in EP0925329 B1.

The first polymer solution may contain additional additives, such as, for example, colorants, preservatives, fragrances, and the like.

260 The coagulant solution may be a calcium nitrate solution. In one embodiment the coagulant solution is a 35% w/v solution of calcium nitrate. Alternatively, the coagulant solution may be the coagulant solution disclosed in EP1638423 B1.

In one embodiment, the at least one former has a fish scale-textured surface that imparts a fish scale-texture to the ambidextrous working glove of the present

265 invention. In one embodiment, the fish scale-textured surface of the at least one  
former imparts a fish scale-texture to the inner and outer surfaces of the  
ambidextrous working glove of the present invention. One of ordinary skill in  
the art can readily appreciate that not all surface textures on the at least one  
former are capable of imparting a surface texture to both the inner and outer  
270 surface of an ambidextrous working glove of the present invention.

In one embodiment, the measured thickness of the glove in a textured area is  
greater than the measured thickness of the glove measured in a non-textured area.  
The thickness of the glove may be measured by any suitable method, such as, for  
example, via the use of a micrometer.

275 In one embodiment, the textured surface measured thickness of the glove in a  
textured area is 10% greater than the measured thickness of the glove measured  
in a non-textured area. In an alternate embodiment, the measured thickness of  
the glove in a textured area is 15% greater than the measured thickness of the  
glove measured in a non-textured area. In an alternate embodiment, the  
280 measured thickness of the glove in a textured area is 20% greater than the  
measured thickness of the glove measured in a non-textured area. In an alternate  
embodiment, the measured thickness of the glove in a textured area is 25%  
greater than the measured thickness of the glove measured in a non-textured  
area. In an alternate embodiment, the measured thickness of the glove in a textured  
285 area is 30% greater than the measured thickness of the glove measured in a non-  
textured area. In an alternate embodiment, the measured thickness of the glove in  
a textured area is 35% greater than the measured thickness of the glove measured  
in a non-textured area. In an alternate embodiment, the measured thickness of  
the glove in a textured area is 40% greater than the measured thickness of the  
290 glove measured in a non-textured area. In an alternate embodiment, the  
measured thickness of the glove in a textured area is 45% greater than the  
measured thickness of the glove measured in a non-textured area. In an alternate  
embodiment, the measured thickness of the glove in a textured area is 50%  
greater than the measured thickness of the glove measured in a non-textured area.

295 In one embodiment, the textured inner and outer surfaces of the ambidextrous working glove of the present invention is formed by the direct transfer function of the surface texture of the at least one former. A preferred textured former surface for the ambidextrous working glove of the present invention has been found to be provided by at least one form that has a fish-scale textured finish.

300 Transfer texturing from such a surface provides a highly desirable textured interior and outer surfaces. The textured interior surface provides a highly desirable hand-engaging surface and the textured exterior surface provides highly desirable grip.

One of ordinary skill in the art can readily appreciate that the ability of the at

305 least one former to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the present invention can vary in response to a variety of factors including, but not limited to the polymer forming the film of the working glove, the thickness of the working glove, and the shape and/or depth of the texture of the at least one former.

310 In one embodiment, 100% of the surface of the former is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the present invention. In an alternate embodiment, less than 100% of the surface of the former is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the

315 present invention. In an alternate embodiment, 90% of the surface of the former is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the present invention. In an alternate embodiment, 80% of the surface of the former is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of

320 the present invention. In an alternate embodiment, 70% of the surface of the former is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the present invention. In an alternate embodiment, 60% of the surface of the former is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous

325 working glove of the present invention. In an alternate embodiment, 50% of the surface of the former is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the present invention. In an alternate embodiment, 40% of the surface of the former is textured to impart or transfer a texture to both the inner and outer surfaces of the

330 ambidextrous working glove of the present invention. In an alternate embodiment, 30% of the surface of the former is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the present invention. In an alternate embodiment, 20% of the surface of the former is textured to impart or transfer a texture to both the inner and outer

335 surfaces of the ambidextrous working glove of the present invention. In an alternate embodiment, 10% of the surface of the former is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the present invention.

In one embodiment, the surface of the at least one former is textured on the front and back of the region of the at least one former that forms the fingers of the

340 ambidextrous working glove of the present invention. In one embodiment, the surface of the at least one former is textured on the region of the at least one former that forms the palm of the ambidextrous working glove of the present invention. In one embodiment, the surface of the at least one former is textured

345 on the region of the at least one former that forms the back of the ambidextrous working glove of the present invention. In one embodiment, the surface of the at least one former is textured on the region of the at least one former that forms the region of the thumb that faces the palm of the ambidextrous working glove of the present invention.

350 In one embodiment, the texture transferred or imparted to the inner and outer surfaces of the ambidextrous working glove of the present invention does not weaken the glove. In one embodiment, the texture transferred or imparted to the inner and outer surfaces of the ambidextrous working glove of the present invention does not affect removal of the glove from the at least one former.

355 In one embodiment, an individual fish-scale in the textured surface of the at least one former is etched into the at least one former at a depth of about 0.4 mm, and is about 2.3 mm wide and 3.4 mm high.

Figures 2 to 8 show various views of an at least one former that is used to form one embodiment of the ambidextrous working glove of the present invention, 360 showing how the individual fish scales are etched into the at least one former.

The size of the at least one former determines the size of the ambidextrous working glove of the present invention. For example, a “small” former would be used to form a “small” glove, and so on.

Referring to Figure 3, showing an at least one former that is used to form one 365 “large” sized embodiment of the ambidextrous working glove of the present invention, the area of the former that is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the present invention is defined as follows: The width of the area shown by line “A” is 60 mm; the width of the area shown by line “B” is 96 mm; the width of the area shown by line “C” is 83 mm; the width of the area shown by line “D” is 88 370 mm; the width of the area shown by line “E” is 26 mm; the width of the area shown by line “F” is 17 mm; the width of the area shown by line “G” is 19 mm; the width of the area shown by line “H” is 16 mm; the width of the area shown by line “I” is 17 mm; the length of the area shown by line “J” is 50 mm; the length 375 of the area shown by line “K” is 195 mm; the length of the area shown by line “L” is 218 mm; the length of the area shown by line “M” is 207 mm; and the length of the area shown by line “N” is 95 mm. The width of the former indicated at line “A” is 97 mm; the width of the former indicated at line “B” is 115 mm; the width of the former indicated at line “C” is 122 mm; the width of 380 the former indicated at line “D” is 110 mm; the width of the former indicated at line “E” is 35.5 mm; the width of the former indicated at line “F” is 35 mm; the width of the former indicated at line “G” is 36 mm; the width of the former

indicated at line “H” is 34 mm; and the width of the former indicated at line “I” is 30 mm.

385 In an alternate embodiment, the former that is used to form one “small” sized embodiment of the ambidextrous working glove of the present invention, the area of the former that is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the present invention is defined as follows: The width of the area shown by line “A” is 45 mm; the width  
390 of the area shown by line “B” is 76 mm; the width of the area shown by line “C” is 73 mm; the width of the area shown by line “D” is 88 mm; the width of the area shown by line “E” is 16 mm; the width of the area shown by line “F” is 14 mm; the width of the area shown by line “G” is 15 mm; the width of the area shown by line “H” is 13 mm; the width of the area shown by line “I” is 13 mm;  
395 the length of the area shown by line “J” is 45 mm; the length of the area shown by line “K” is 172 mm; the length of the area shown by line “L” is 184 mm; the length of the area shown by line “M” is 172 mm; and the length of the area shown by line “N” is 85 mm. The width of the former indicated at line “A” is 82.5 mm; the width of the former indicated at line “B” is 95.5 mm; the width of  
400 the former indicated at line “C” is 106 mm; the width of the former indicated at line “D” is 88.5 mm; the width of the former indicated at line “E” is 29 mm; the width of the former indicated at line “F” is 29 mm; the width of the former indicated at line “G” is 31 mm; the width of the former indicated at line “H” is 30 mm; and the width of the former indicated at line “I” is 29 mm.

405 In an alternate embodiment, the former that is used to form one “medium” sized embodiment of the ambidextrous working glove of the present invention, the area of the former that is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the present invention is defined as follows: The width of the area shown by line “A” is 50 mm; the width  
410 of the area shown by line “B” is 86 mm; the width of the area shown by line “C” is 74 mm; the width of the area shown by line “D” is 79 mm; the width of the area shown by line “E” is 20 mm; the width of the area shown by line “F” is 16

mm; the width of the area shown by line “G” is 18 mm; the width of the area shown by line “H” is 15 mm; the width of the area shown by line “I” is 14 mm; 415 the length of the area shown by line “J” is 46 mm; the length of the area shown by line “K” is 182 mm; the length of the area shown by line “L” is 195 mm; the length of the area shown by line “M” is 186 mm; and the length of the area shown by line “N” is 95 mm. The width of the former indicated at line “A” is 89 mm; the width of the former indicated at line “B” is 105 mm; the width of the 420 former indicated at line “C” is 115 mm; the width of the former indicated at line “D” is 100 mm; the width of the former indicated at line “E” is 33 mm; the width of the former indicated at line “F” is 32 mm; the width of the former indicated at line “G” is 32.5 mm; the width of the former indicated at line “H” is 30 mm; and the width of the former indicated at line “I” is 27.5 mm.

425 In an alternate embodiment, the former that is used to form one “extra large” or “XL” sized embodiment of the ambidextrous working glove of the present invention, the area of the former that is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the present invention is defined as follows: The width of the area shown by line “A” 430 is 66 mm; the width of the area shown by line “B” is 92 mm; the width of the area shown by line “C” is 90 mm; the width of the area shown by line “D” is 95 mm; the width of the area shown by line “E” is 26 mm; the width of the area shown by line “F” is 17 mm; the width of the area shown by line “G” is 17 mm; the width of the area shown by line “H” is 17 mm; the width of the area shown by 435 line “I” is 16 mm; the length of the area shown by line “J” is 55 mm; the length of the area shown by line “K” is 208 mm; the length of the area shown by line “L” is 220 mm; the length of the area shown by line “M” is 208 mm; and the length of the area shown by line “N” is 105 mm. The width of the former indicated at line “A” is 101 mm; the width of the former indicated at line “B” is 440 115 mm; the width of the former indicated at line “C” is 134 mm; the width of the former indicated at line “D” is 116 mm; the width of the former indicated at line “E” is 37.5 mm; the width of the former indicated at line “F” is 38 mm; the

width of the former indicated at line “G” is 37.5 mm; the width of the former indicated at line “H” is 35 mm; and the width of the former indicated at line “I” is 31.5 mm.

In an alternate embodiment, the former that is used to form one “extra extra large” or “XXL” sized embodiment of the ambidextrous working glove of the present invention, the area of the former that is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the present invention is defined as follows: The width of the area shown by line “A” is 67 mm; the width of the area shown by line “B” is 101 mm; the width of the area shown by line “C” is 108 mm; the width of the area shown by line “D” is 103 mm; the width of the area shown by line “E” is 23 mm; the width of the area shown by line “F” is 22 mm; the width of the area shown by line “G” is 21 mm; the width of the area shown by line “H” is 20 mm; the width of the area shown by line “I” is 19 mm; the length of the area shown by line “J” is 54 mm; the length of the area shown by line “K” is 207 mm; the length of the area shown by line “L” is 222 mm; the length of the area shown by line “M” is 211 mm; and the length of the area shown by line “N” is 100 mm. The width of the former indicated at line “A” is 109 mm; the width of the former indicated at line “B” is 119 mm; the width of the former indicated at line “C” is 140 mm; the width of the former indicated at line “D” is 126 mm; the width of the former indicated at line “E” is 40 mm; the width of the former indicated at line “F” is 40 mm; the width of the former indicated at line “G” is 41 mm; the width of the former indicated at line “H” is 38 mm; and the width of the former indicated at line “I” is 38 mm.

In an alternate embodiment, the former that is used to form one “extra extra extra large” or “XXXL” sized embodiment of the ambidextrous working glove of the present invention, the area of the former that is textured to impart or transfer a texture to both the inner and outer surfaces of the ambidextrous working glove of the present invention is defined as follows: The width of the area shown by line “A” is 62 mm; the width of the area shown by line “B” is 103 mm; the width of

the area shown by line “C” is 112 mm; the width of the area shown by line “D” is 110 mm; the width of the area shown by line “E” is 24 mm; the width of the area shown by line “F” is 20 mm; the width of the area shown by line “G” is 20 mm; the width of the area shown by line “H” is 20 mm; the width of the area shown by line “I” is 18 mm; the length of the area shown by line “J” is 54 mm; the length of the area shown by line “K” is 205 mm; the length of the area shown by line “L” is 224 mm; the length of the area shown by line “M” is 212 mm; and the length of the area shown by line “N” is 105 mm. The width of the former indicated at line “A” is 124 mm; the width of the former indicated at line “B” is 144 mm; the width of the former indicated at line “C” is 156 mm; the width of the former indicated at line “D” is 136 mm; the width of the former indicated at line “E” is 40.5 mm; the width of the former indicated at line “F” is 39 mm; the width of the former indicated at line “G” is 40 mm; the width of the former indicated at line “H” is 37.5 mm; and the width of the former indicated at line “I” is 34 mm.

The textured inner and outer surfaces of one embodiment of the ambidextrous working glove of the present invention can be greater detail in Figures 9 to 11. A graphical representation of the fish-scale textured outer surface of an ambidextrous working glove of the present invention is shown in Figures 12 to 16.

In one embodiment, the ambidextrous working glove of the present invention has a measured thickness in a non-textured area selected from the range of thicknesses spanning from about 6mil to about 10 mil.

In one embodiment, the ambidextrous working glove of the present invention has a weight of about 20 g. In an alternate embodiment, the ambidextrous working glove of the present invention has a weight of about 19 g. In an alternate embodiment, the ambidextrous working glove of the present invention has a weight of about 18 g. In an alternate embodiment, the ambidextrous working glove of the present invention has a weight of about 17 g. In an alternate

embodiment, the ambidextrous working glove of the present invention has a weight of about 16 g. In an alternate embodiment, the ambidextrous working glove of the present invention has a weight of about 15 g. In an alternate  
505 embodiment, the ambidextrous working glove of the present invention has a weight of about 14 g. In an alternate embodiment, the ambidextrous working glove of the present invention has a weight of about 13 g. In an alternate embodiment, the ambidextrous working glove of the present invention has a weight of about 12 g. In an alternate  
510 embodiment, the ambidextrous working glove of the present invention has a weight of about 11 g. In an alternate embodiment, the ambidextrous working glove of the present invention has a weight of about 10 g.

In one embodiment, the ambidextrous working glove of the present invention complies with European Standard EN420:2003 and A1:2009 clause 5 sizing and  
515 dexterity regulations.

In one embodiment, the ambidextrous working glove of the present invention complies with European Standard BS EN374:2003 chemical and micro-organism protection regulations.

In one embodiment, second polymer solution is a solution that allows the  
520 ambidextrous working glove of the present invention to slide over a wearer's hand while the glove is being donned. In one embodiment, the second polymer solution is a polyurethane solution.

In one embodiment, the second polymer solution is a solution comprising polyurethane (10% v/v final concentration), and 12% ammonia (2% final  
525 concentration) in water.

In one embodiment, the second polymer solution forms a chlorinated film on the inner surface of the ambidextrous working glove of the present invention. In one embodiment, the second polymer solution forms a chlorinated film on the inner surface of the ambidextrous working glove of the present invention according to

530 the methods described in WO2010023634. In one embodiment, the second  
polymer solution is a polyisoprene solution. In one embodiment, the  
polyisoprene solution is the polyisoprene solution described in EP2381100 A1.

The present invention is further illustrated, but not limited by, the following  
examples.

535

### EXAMPLES

**Example 1: Testing Embodiments of the Ambidextrous Working Glove of  
the Present Invention for Resistance to Permeation by Chemicals According  
to BS EN 374-3:2003**

Samples of powder-free 8 mil black, 10 mil black and 8 mil blue nitrile gloves  
540 were tested in accordance with BS EN 374:2003 part 3. The results are shown in  
the tables below. The permeation performance levels are defined as follows:  
Level 1 is defined as an observed measured breakthrough time of greater than 10  
minutes. Level 2 is defined as an observed measured breakthrough time of  
greater than 30 minutes. Level 3 is defined as an observed measured  
545 breakthrough time of greater than 60 minutes. Level 4 is defined as an observed  
measured breakthrough time of greater than 120 minutes. Level 5 is defined as  
an observed measured breakthrough time of greater than 240 minutes. Level 6 is  
defined as an observed measured breakthrough time of greater than 480 minutes.

550 **Table 2: Results Obtained from 8-mil Powder-Free Black Nitrile Gloves Tested According to BS EN 374:2003, part 3, using Methanol as the Testing Agent**

Test/Property	Specimen	Results	Performance	
BS EN 374-3:2003 Chemical Permeation	Nitrile disposable gloves, Powder-free 8 mil black	Chemical: Methanol CAS No: 67-56-1 Detection system: GC FID Collection medium: Dry air Loop system: Open Test temperature: 23°C	The samples tested did not meet with the minimum breakthrough time for a performance level 1 to be achieved	
		Sample thickness (mm)		Breakthrough time (mins)
		1		1
		2		3
		3		<1
		Mean		1
Lowest result	<1			
Appearance of sample after testing	No change			

555 **Table 3: Results Obtained from 8-mil Powder-Free Black Nitrile Gloves Tested According to BS EN 374:2003, part 3, using n-Heptane as the Testing Agent**

Test/Property	Specimen	Results	Performance	
BS EN 374-3:2003 Chemical Permeation	Nitrile disposable gloves, Powder-free 8 mil black	Chemical: n-Heptane CAS No: 142-82-5 Detection system: GC FID Collection medium: Dry air Loop system: Open Test temperature: 23°C	Level 1	
		Sample thickness (mm)		Breakthrough time (mins)
		1		22
		2		56
		3		26
		Mean		34
Lowest result	22			
Appearance of sample after testing	No change			

560 **Table 4: Results Obtained from 8-mil Powder-Free Black Nitrile Gloves Tested According to BS EN 374:2003, part 3, using Acetonitrile as the Testing Agent**

Test/Property	Specimen	Results	Performance		
BS EN 374-3:2003 Chemical Permeation	Nitrile disposable gloves, Powder- free 8 mil black	Chemical: Acetonitrile CAS No: 75-05-8 Detection system: GC FID Collection medium: Dry air Loop system: Open Test temperature: 23°C		The samples tested did not meet with the minimum breakthrough time for a performance level 1 to be achieved	
		Sample thickness (mm)	Breakthrough time (mins)		
		1	0.29		<1
		2	0.27		<1
		3	0.26		<1
		Mean	0.27		<1
Lowest result	-	<1			
Appearance of sample after testing	No change				

565 **Table 5: Results Obtained from 8-mil Powder-Free Black Nitrile Gloves Tested According to BS EN 374:2003, part 3, using 40% Sodium Hydroxide as the Testing Agent**

Test/Property	Specimen	Results	Performance		
BS EN 374-3:2003 Chemical Permeation	Nitrile disposable gloves, Powder- free 8 mil black	Chemical: 40% Sodium hydroxide CAS No: 1310-73-2 Detection system: Conductivity Collection medium: De ionised water Loop system: Closed Test temperature: 23°C		Level 6	
		Sample thickness (mm)	Breakthrough time (mins)		
		1	0.32		>480
		2	0.32		>480
		3	0.32		>480
		Mean	0.32		>480
Lowest result	-	>480			
Appearance of sample after testing	No change				

**Table 6: Results Obtained from 10-mil Powder-Free Black Nitrile Gloves Tested According to BS EN 374:2003, part 3, using Methanol as the Testing Agent**

570

Test/Property	Specimen	Results		Performance	
BS EN 374-3:2003 Chemical Permeation	Nitrile disposable gloves, Powder-free 10 mil black	Chemical: Methanol CAS No: 67-56-1 Detection system: GC FID Collection medium: Dry air Loop system: Open Test temperature: 23°C		The samples tested did not meet with the minimum breakthrough time for a performance level 1 to be achieved	
		Sample thickness (mm)	Breakthrough time (mins)		
		1	0.38		1
		2	0.32		4
		3	0.35		<1
		Mean	0.35		2
Lowest result	-	<1			
Appearance of sample after testing	No change				

**Table 7: Results Obtained from 10-mil Powder-Free Black Nitrile Gloves Tested According to BS EN 374:2003, part 3, using n-Heptane as the Testing Agent**

575

Test/Property	Specimen	Results		Performance	
BS EN 374-3:2003 Chemical Permeation	Nitrile disposable gloves, Powder-free 10 mil black	Chemical: n-Heptane CAS No: 142-82-5 Detection system: GC FID Collection medium: Dry air Loop system: Open Test temperature: 23°C		Level 3	
		Sample thickness (mm)	Breakthrough time (mins)		
		1	0.32		92
		2	0.35		77
		3	0.32		99
		Mean	0.33		89
Lowest result	-	77			
Appearance of sample after testing	No change				

**Table 8: Results Obtained from 10-mil Powder-Free Black Nitrile Gloves Tested According to BS EN 374:2003, part 3, using Acetonitrile as the Testing Agent**

Test/Property	Specimen	Results	Performance		
BS EN 374-3:2003 Chemical Permeation	Nitrile disposable gloves, Powder-free 10 mil black	Chemical: Acetonitrile CAS No: 75-05-8 Detection system: GC FID Collection medium: Dry air Loop system: Open Test temperature: 23°C	The samples tested did not meet with the minimum breakthrough time for a performance level 1 to be achieved		
		Sample thickness (mm)		Breakthrough time (mins)	
		1		0.31	<1
		2		0.37	<1
		3		0.32	<1
		Mean		0.33	<1
Lowest result	-	<1			
Appearance of sample after testing	No change				

580

**Table 9: Results Obtained from 10-mil Powder-Free Black Nitrile Gloves Tested According to BS EN 374:2003, part 3, using 40% Sodium Hydroxide as the Testing Agent**

Test/Property	Specimen	Results	Performance		
BS EN 374-3:2003 Chemical Permeation	Nitrile disposable gloves, Powder-free 10 mil black	Chemical: 40% Sodium hydroxide CAS No: 1310-73-2 Detection system: Conductivity Collection medium: De ionised water Loop system: Closed Test temperature: 23°C	Level 6		
		Sample thickness (mm)		Breakthrough time (mins)	
		1		0.30	>=80
		2		0.32	>=80
		3		0.35	>=80
		Mean		0.32	>=80
Lowest result	-	>=80			
Appearance of sample after testing	No change				

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**Table 10: Results Obtained from 8-mil Powder-Free Blue Nitrile Gloves Tested According to BS EN 374:2003, part 3, using Methanol as the Testing Agent**

Test/Property	Specimen	Results	Performance	
BS EN 374-3:2003 Chemical Permeation	Nitrile disposable gloves, Powder-free 8 mil blue	Chemical: Methanol CAS No: 67-56-1 Detection system: GC FID Collection medium: Dry air Loop system: Open Test temperature: 23°C	The samples tested did not meet with the minimum breakthrough time for a performance level 1 to be achieved	
		Sample thickness (mm)		Breakthrough time (mins)
		1		<1
		2		<1
		3		<1
		Mean		<1
Lowest result	<1			
Appearance of sample after testing	Discoloured			

590 **Table 11: Results Obtained from 8-mil Powder-Free Blue Nitrile Gloves Tested According to BS EN 374:2003, part 3, using n-Heptane as the Testing Agent**

Test/Property	Specimen	Results	Performance	
BS EN 374-3:2003 Chemical Permeation	Nitrile disposable gloves, Powder-free 8 mil blue	Chemical: n-Heptane CAS No: 142-82-5 Detection system: GC FID Collection medium: Dry air Loop system: Open Test temperature: 23°C	Level 5	
		Sample thickness (mm)		Breakthrough time (mins)
		1		256
		2		258
		3		260
		Mean		258
Lowest result	256			
Appearance of sample after testing	No change			

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**Table 12: Results Obtained from 8-mil Powder-Free Blue Nitrile Gloves Tested According to BS EN 374:2003, part 3, using Acetonitrile as the Testing Agent**

Test/Property	Specimen	Results	Performance		
BS EN 374-3:2003 Chemical Permeation	Nitrile disposable gloves, Powder-free 8 mil blue	Chemical: Acetonitrile CAS No: 75-05-8 Detection system: GC FID Collection medium: Dry air Loop system: Open Test temperature: 23°C		The samples tested did not meet with the minimum breakthrough time for a performance level 1 to be achieved	
		Sample thickness (mm)	Breakthrough time (mins)		
		1	0.22		<1
		2	0.25		<1
		3	0.21		<1
		Mean	0.23		<1
Lowest result	-	<1			
Appearance of sample after testing	No change				

600

**Table 13: Results Obtained from 8-mil Powder-Free Blue Nitrile Gloves Tested According to BS EN 374:2003, part 3, using 40% Sodium Hydroxide as the Testing Agent**

Test/Property	Specimen	Results	Performance		
BS EN 374-3:2003 Chemical Permeation	Nitrile disposable gloves, Powder-free 8 mil blue	Chemical: 40% Sodium hydroxide CAS No: 1310-73-2 Detection system: Conductivity Collection medium: De ionised water Loop system: Closed Test temperature: 23°C		Level 6	
		Sample thickness (mm)	Breakthrough time (mins)		
		1	0.26		>480
		2	0.22		>480
		3	0.24		>480
		Mean	0.24		>480
Lowest result	-	>480			
Appearance of sample after testing	No change				

605 **Example 2: Testing Embodiments of the Ambidextrous Working Glove of  
the Present Invention for Sizing and Dexterity According to EN 420:2003 +  
A1:2009 Clause 5**

610 Samples of powder-free 8 mil black, 10 mil black and 8 mil blue nitrile gloves  
were tested in accordance with EN 420:2003 + A1:2009 Clause 5. The results  
are shown in the tables below. The permeation performance levels are defined as  
follows: For sizing, the minimum size for a size 6 glove is 220 mm; the  
615 minimum size for a size 7 glove is 230 mm; the minimum size for a size 8 glove  
is 240 mm; the minimum size for a size 9 glove is 250 mm; the minimum size for  
a size 10 glove is 260 mm; the minimum size for a size 11 glove is 270 mm. For  
dexterity, level 1 is defined as a wearer picking up an 11mm diameter pin; level 2  
615 is defined as a wearer picking up a 9.5mm diameter pin; level 3 is defined as a  
wearer picking up an 8mm diameter pin; level 4 is defined as a wearer picking up  
a 6mm diameter pin; level 5 is defined as a wearer picking up a 5mm diameter  
pin.

**Table 14: Results Obtained from 8-mil Powder-Free Black Nitrile Gloves**

EN 420: 2003 +A1: 2009 CLAUSE / TEST	EN 420: 2003 + A1: 2009 REQUIREMENT	TEST RESULTS	UoM (See note 1)	RESULT
5.1 Glove length	See table 2	Size Length / mm XXL (11) L: 305, R: 290	± 0.3 mm	PASS
5.3 Comfort and fit	See table 2	Size: XXL (11) Wearer hand size Left: L: 11, C: 8.5 Right: L: 11, C: 8.5 Comments on fit: Thumb slightly long	N/A	PASS
5.2 Dexterity	See table 2	Size Minimum pin diameter / mm XXL (11) 5.0	N/A	Level 5

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**Table 15: Results Obtained from 10-mil Powder-Free Black Nitrile Gloves**

EN 420: 2003 +A1: 2009 CLAUSE / TEST	EN 420: 2003 + A1: 2009 REQUIREMENT	TEST RESULTS	UoM (See note 1)	RESULT
5.1 Glove length	See table 2	Size Length / mm XXL (11) L: 307, R: 303	± 0.3 mm	PASS
5.1 Comfort and fit	See table 2	Size: XXL (11) Wearer hand size Left: L: 11, C: 8.5 Right: L: 11, C: 8.5 <i>Comments on fit: Thumb slightly long</i>	N/A	PASS
5.2 Dexterity	See table 2	Size Minimum pin diameter / mm XXL (11) 5.0	N/A	Level 5

**Table 16: Results Obtained from 8-mil Powder-Free Blue Nitrile Gloves**

EN 420: 2003 +A1: 2009 CLAUSE / TEST	EN 420: 2003 + A1: 2009 REQUIREMENT	TEST RESULTS	UoM (See note 1)	RESULT
5.1 Glove length	See table 2	Size Length / mm XXL (11) L: 290, R: 294	± 0.3 mm	PASS
5.1 Comfort and fit	See table 2	Size: XXL (11) Wearer hand size Left: L: 11, C: 8.5 Right: L: 11, C: 8.5 <i>Comments on fit: Thumb slightly long</i>	N/A	PASS
5.2 Dexterity	See table 2	Size Minimum pin diameter / mm XXL (11) 5.0	N/A	Level 5

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Publications cited throughout this document are hereby incorporated by reference in their entirety. Although the various aspects of the invention have been illustrated above by reference to examples and preferred embodiments, it will be appreciated that the scope of the invention is defined not by the foregoing description but by the following claims properly construed under principles of patent law.

630

**Forms:**

- 635 1. A method for making an ambidextrous working glove having fish scale-textured inner and outer surfaces comprising the steps of:
- a. providing a first polymer solution;
  - b. providing a coagulant solution;
  - c. providing a second polymer solution;
  - 640 d. providing at least one former having a fish scale-textured surface and dipping the at least one former into the coagulant solution to coat the at least one former with coagulant;
  - e. removing the at least one former from the coagulant solution and drying the coagulant coating on the at least one former;
  - 645 f. dipping the at least one former coated with coagulant into the first polymer solution, and allowing the first polymer solution to coat the at least one former;
  - g. removing the at least one former from the first polymer solution and drying the polymer coating on the at least one former, forming a film;
  - 650 h. washing the film on the at least one former, and dipping the film coated at least one former into a second polymer solution, and allowing the second polymer solution to coat the film; and
  - i. stripping the glove from the at least one former.
- 655 2. The method of form 1, wherein the ambidextrous working glove complies with at least one requirement selected from the group consisting of FFDC requirements for food handling, European Standard EN374-3, European Standard EN388:2003, European Standard EN374-2, European Standard

EN420:2003, European Standard EN1186:2002, and European Standard EN421:2010.

- 660 3. The method of form 1, wherein the first polymer solution is a synthetic rubber copolymer solution.
4. The method of form 4, wherein the synthetic rubber copolymer solution is a solution comprising a copolymer of acetonitrile and butadiene.
5. The method of form 1, wherein the first polymer solution is latex.
- 665 6. The method of form 1, wherein the second polymer solution is a solution that allows the ambidextrous working glove of the present invention to slide over a wearer's hand while the glove is being donned.
7. The method of form 1, wherein the second polymer solution is a polyurethane solution.
8. The method of form 1, wherein the film has a thickness selected from the  
670 range of thicknesses spanning from about 6mil to about 10 mil.
9. The method of form 1, wherein the at least one former has a fish scale-textured surface that imparts a texture to the inner and outer surfaces of the ambidextrous working glove.
- 675 10. The method of form 9, wherein the surface of the at least one former is textured on the front and back of the region of the at least one former that forms the fingers of the ambidextrous working glove.
11. The method of form 9, wherein the surface of the at least one former is textured on the region of the at least one former that forms the palm of the ambidextrous working glove.
- 680 12. The method of form 9, wherein the surface of the at least one former is textured on the region of the at least one former that forms the back of the ambidextrous working glove.
13. The method of form 9, wherein the surface of the at least one former is textured on the region of the at least one former that forms the region of the  
685 thumb that faces the palm of the ambidextrous working glove.
14. An ambidextrous working glove formed by the method of form 1.

15. A former for making an ambidextrous an ambidextrous working glove having fish scale-textured inner and outer surfaces wherein:
- 690 a. the surface of the at least one former is textured on the front and back of the region of the at least one former that forms the fingers of the ambidextrous working glove;
- b. the surface of the at least one former is textured on the region of the at least one former that forms the palm of the ambidextrous working glove;
- 695 c. the surface of the at least one former is textured on the region of the at least one former that forms the back of the ambidextrous working glove; and
- d. the surface of the at least one former is textured on the region of the at least one former that forms the region of the thumb that faces the palm of the ambidextrous working glove.

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**Claims:**

1. An ambidextrous glove, comprising:  
an outer surface having an external textured gripping pattern including protruding ridges present on a first exterior side and a second exterior side of the glove, the second exterior side being opposite the first exterior side, the external textured gripping pattern extending along a palm to each finger and extending along a thumb region; and  
an inner surface, located on a surface opposite the outer surface, having an internal textured gripping pattern that is the reverse of the external textured gripping pattern, the internal textured gripping pattern including channels and configured to contact a wearer's hand when the glove is donned, the internal textured gripping pattern extending along the palm to each finger with the channels being interconnected to enable perspiration from a wearer's hand to flow therethrough; wherein  
the glove is formed of one or more polymers.
2. The glove of claim 1, wherein the protruding ridges are interconnected.
3. The glove of claim 1 or 3, wherein a first measured thickness of the ambidextrous working glove measured in a textured area between the first interior surface of the ambidextrous working glove and the first exterior surface of the working glove is greater than a second measured thickness of the ambidextrous working glove measured in a non-textured area between the first interior surface of the ambidextrous working glove and the first exterior surface of the working glove.
4. The glove of any one of claims 1 to 3, wherein the channels provide a contact-reducing texture to the inner surface.
5. The glove of any one of claims 1 to 4, wherein the glove is powder-free, and is formed from a first solution comprising a copolymer and of a second solution that allows the glove to slide over a wearer's hand while the glove is being donned.

6. The glove of any one of claims 1 to 5, wherein the glove is comprised of a plurality of layers.
7. The glove of any one of claims 1 to 6, wherein the external textured gripping pattern present on the thumb region is positioned on the thumb region facing the finger region.
8. The glove of any one of claims 1 to 7, further comprising a non-textured portion on the first exterior surface and a non-textured portion on the first interior surface, the non-textured portions being located between each of the four fingers of the ambidextrous working glove and on a thumb facing away from the four fingers.
9. A method for making a textured ambidextrous glove comprising:  
dipping a former into a first polymer solution, the former having a textured surface comprising a pattern of channels and configured to impart the pattern to an inner surface of the ambidextrous glove and the reverse of the pattern, comprising protruding ridges, to an outer surface of the ambidextrous glove;  
dipping the former into a first polymer solution;  
removing the former from the first polymer solution, the first polymer of the first polymer solution coating the former;  
drying the former coated with the first polymer, the first polymer forming a film;  
dipping the former coated with the film of the first polymer into a second polymer solution; and  
stripping the resulting textured ambidextrous glove from the former to invert the textured ambidextrous glove such that the surface of the textured ambidextrous glove contacting the former becomes the outer surface.
10. The method of claim 9, wherein before dipping the former into the first polymer solution, the method further comprises:  
dipping the former into a coagulant solution;  
removing the former from the coagulant solution, the coagulant of the coagulant solution coating the former; and  
drying the former coated with the coagulant.

11. The method of claim 9 or 10, wherein the second polymer solution is a polyurethane solution.
12. The method of any one of claims 9 to 11, wherein the former imparts the pattern to the inner surface of the ambidextrous glove and the reverse of the pattern to the outer surface of the ambidextrous glove via direct transfer function.
13. The method of any one of claims 9 to 12, wherein the first polymer solution is a synthetic rubber copolymer solution.
14. The method of any one of claims 9 to 12, wherein the first polymer solution is latex.
15. The method of any one of claims 9 to 14, wherein the film of the first polymer has a thickness selected from a range of 6 mil to about 10 mil.
16. The method of any one of claims 9 to 15, further comprising:  
dipping the former coated with the film of the first polymer into a leaching tank; and  
vulcanizing the film of the first polymer.
17. A former for making an ambidextrous glove comprising:  
a first region for forming the fingers of the ambidextrous glove;  
a second region for forming a thumb of the ambidextrous glove;  
a third region for forming a palm and a back of the ambidextrous glove; and  
a textured surface comprising a pattern of channels, the textured surface being located on:  
a front and a back of the first region;  
a portion of the second region that faces the third region; and  
the third region; wherein  
the textured surface is configured to impart the pattern of channels to an inner surface of the ambidextrous glove and a reverse of the pattern that comprises protruding ridges to an exterior surface of the ambidextrous glove.

18. The former of claim 17, wherein the channels are etched into the former at a depth of approximately 0.4 millimeters.
19. The former of claim 17 or 18, wherein the surface of the former is non-textured on the region of the former that forms the space between each of the fingers.
20. The former of any one of claims 17 to 19, wherein the surface of the former is non-textured on the region of the former that forms the region of the thumb that faces away from the palm.

**Covco (H.K.) Limited**

**Patent Attorneys for the Applicant/Nominated Person  
SPRUSON & FERGUSON**

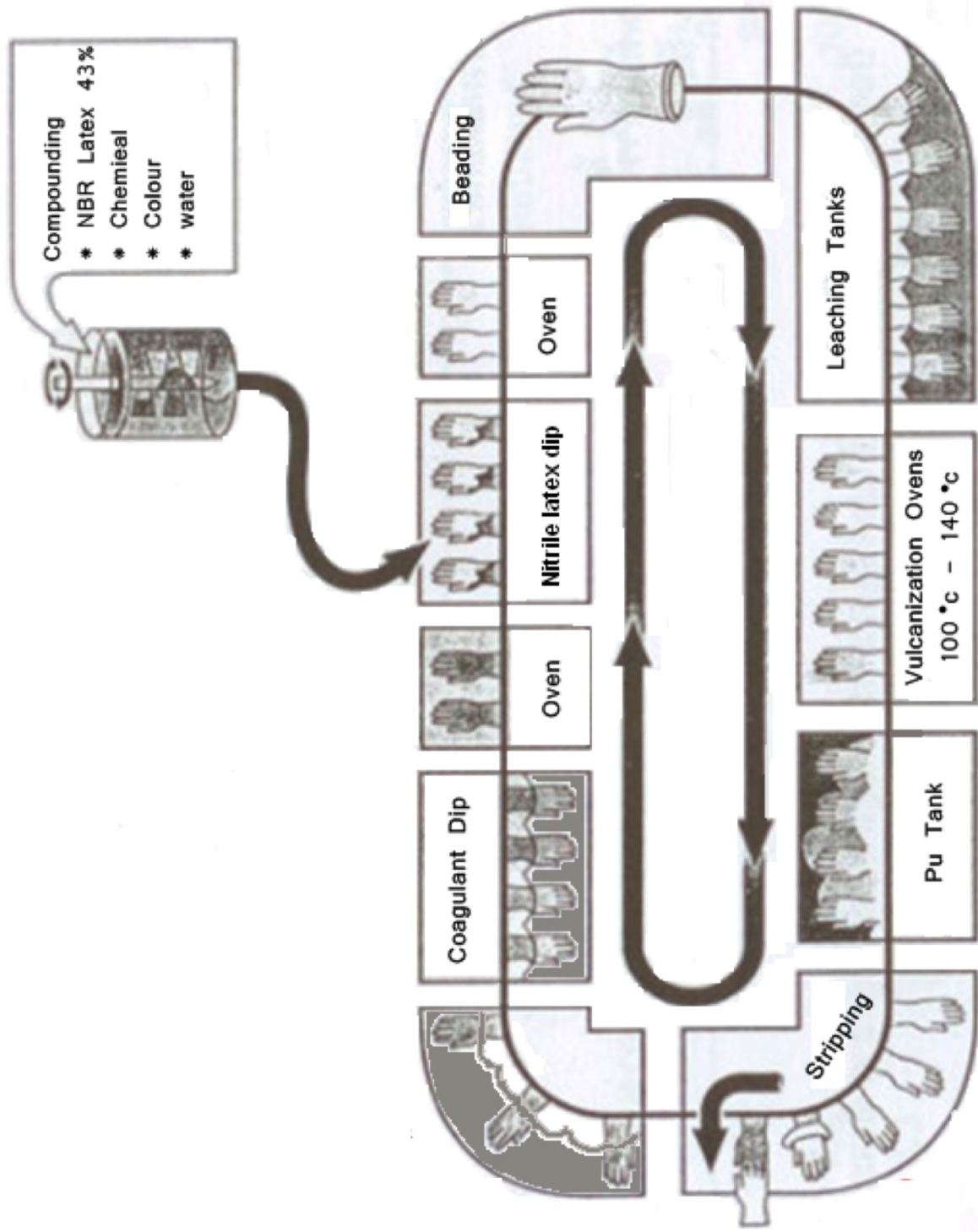


Figure 1

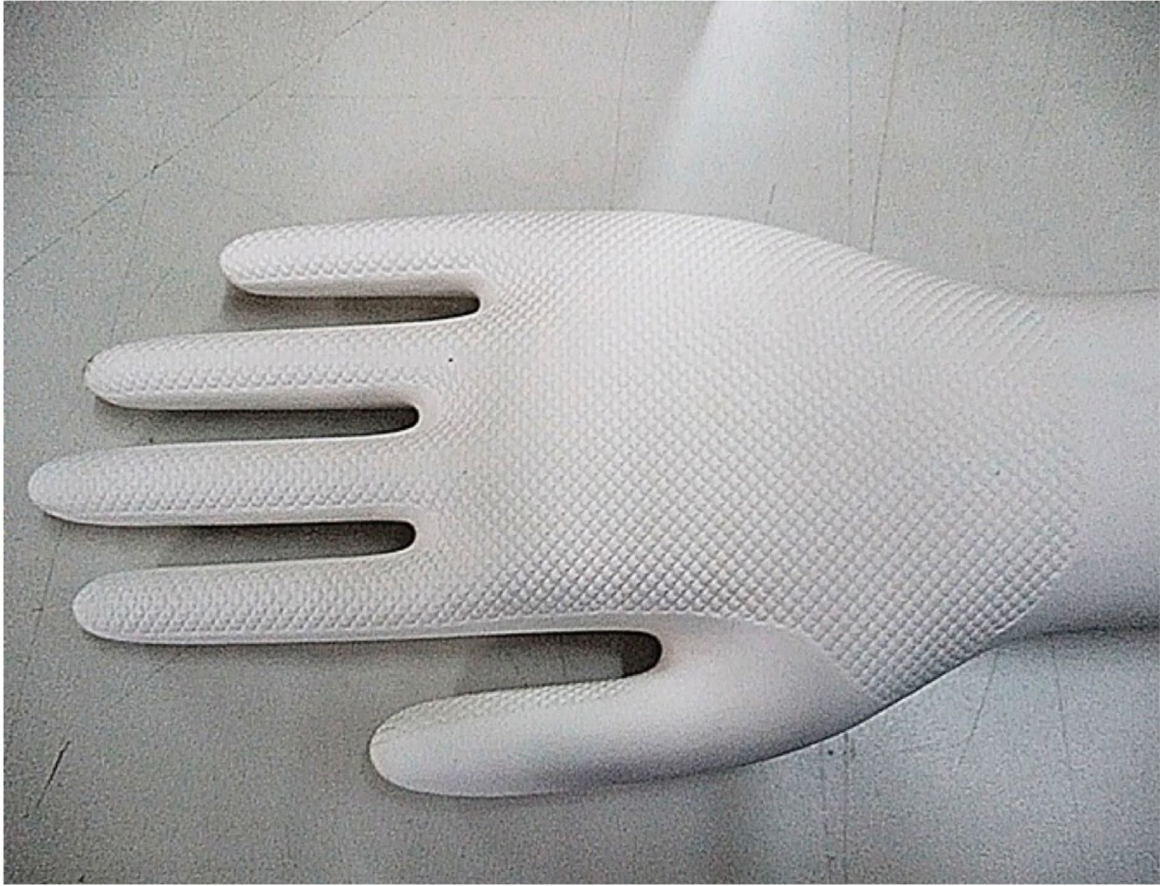


Figure 2

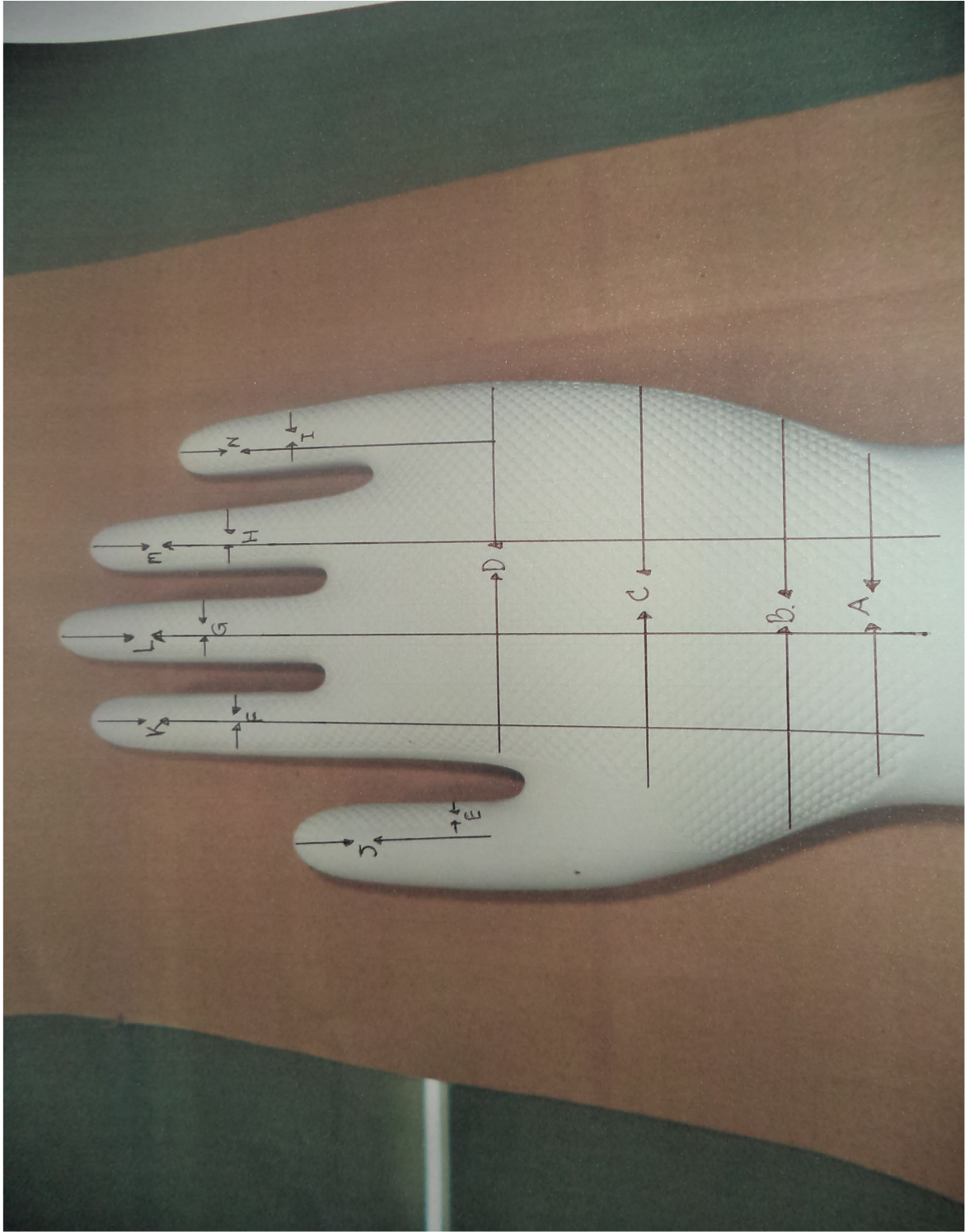


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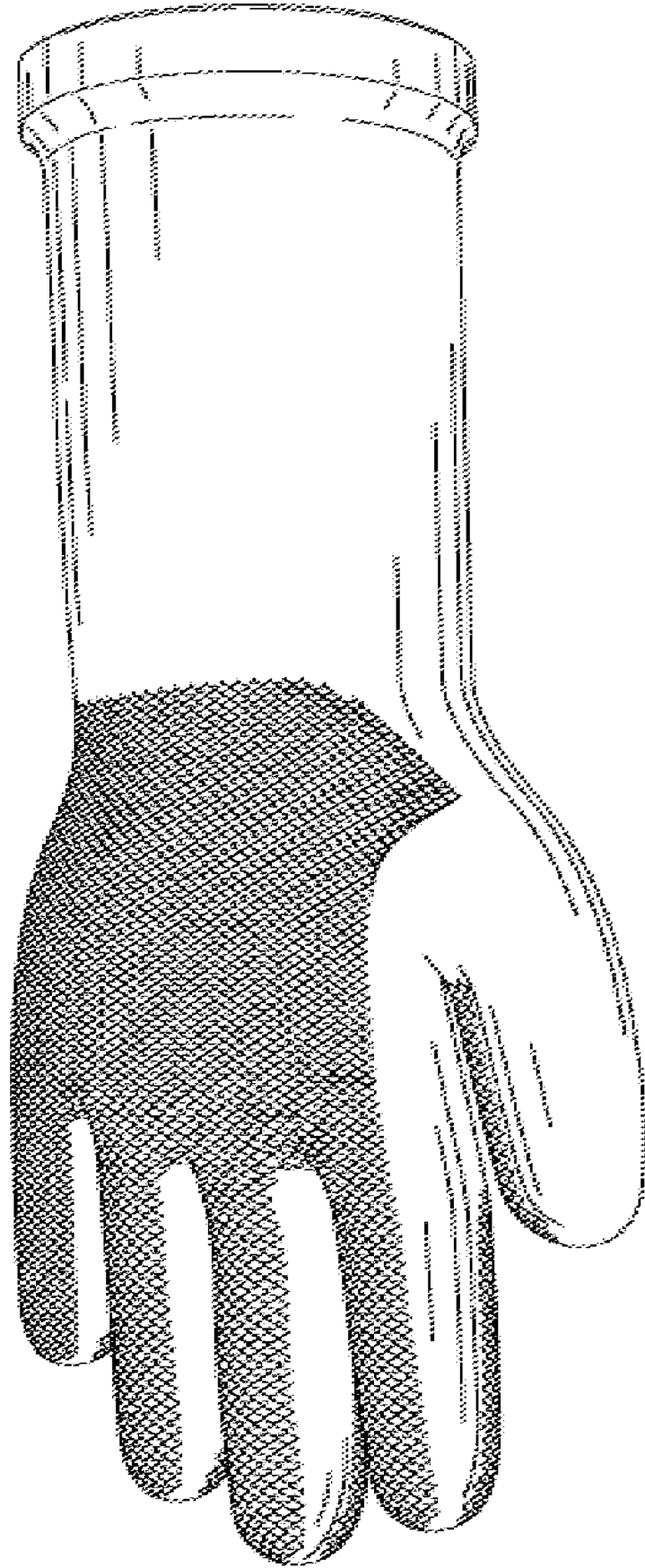


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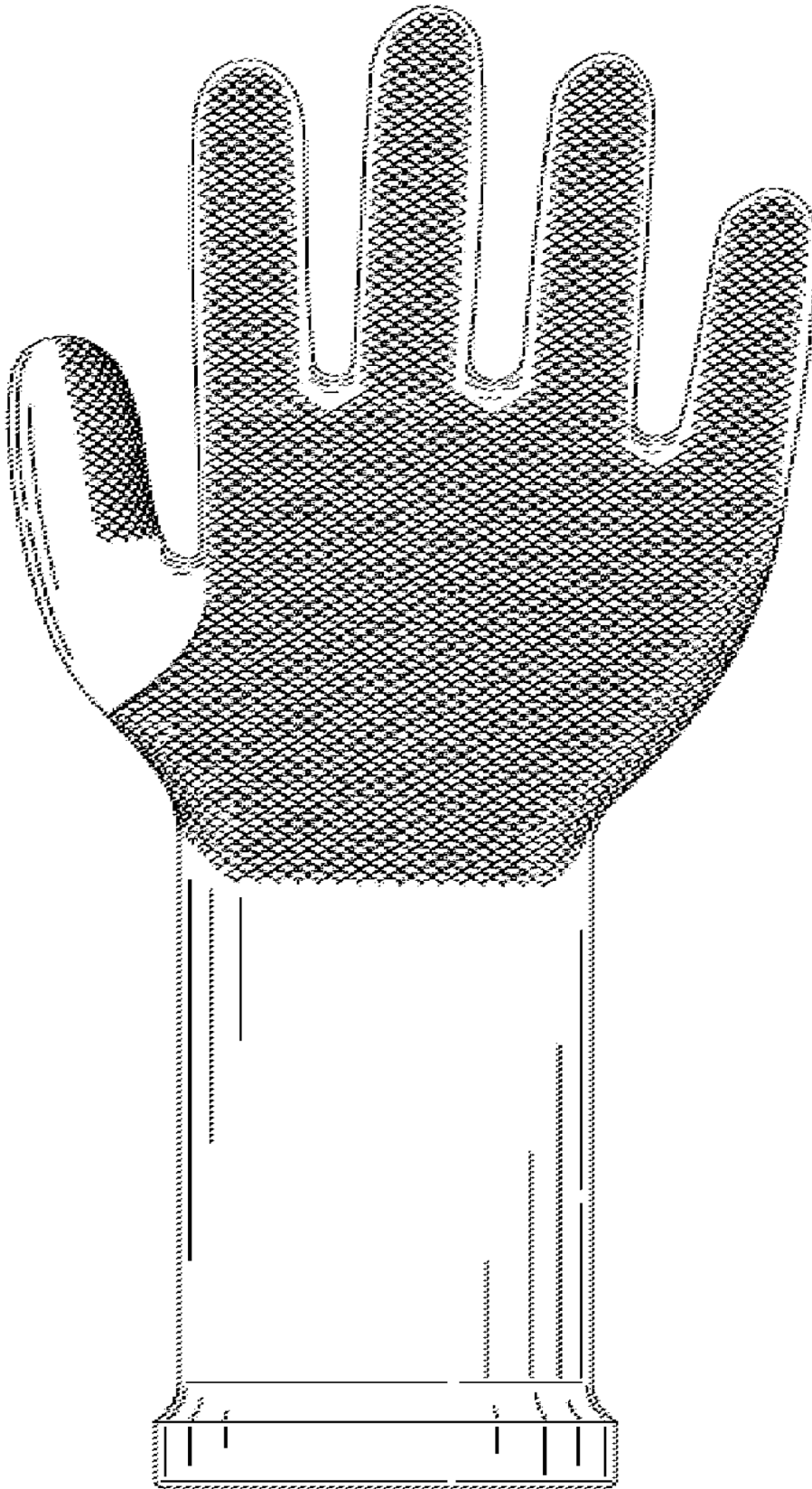


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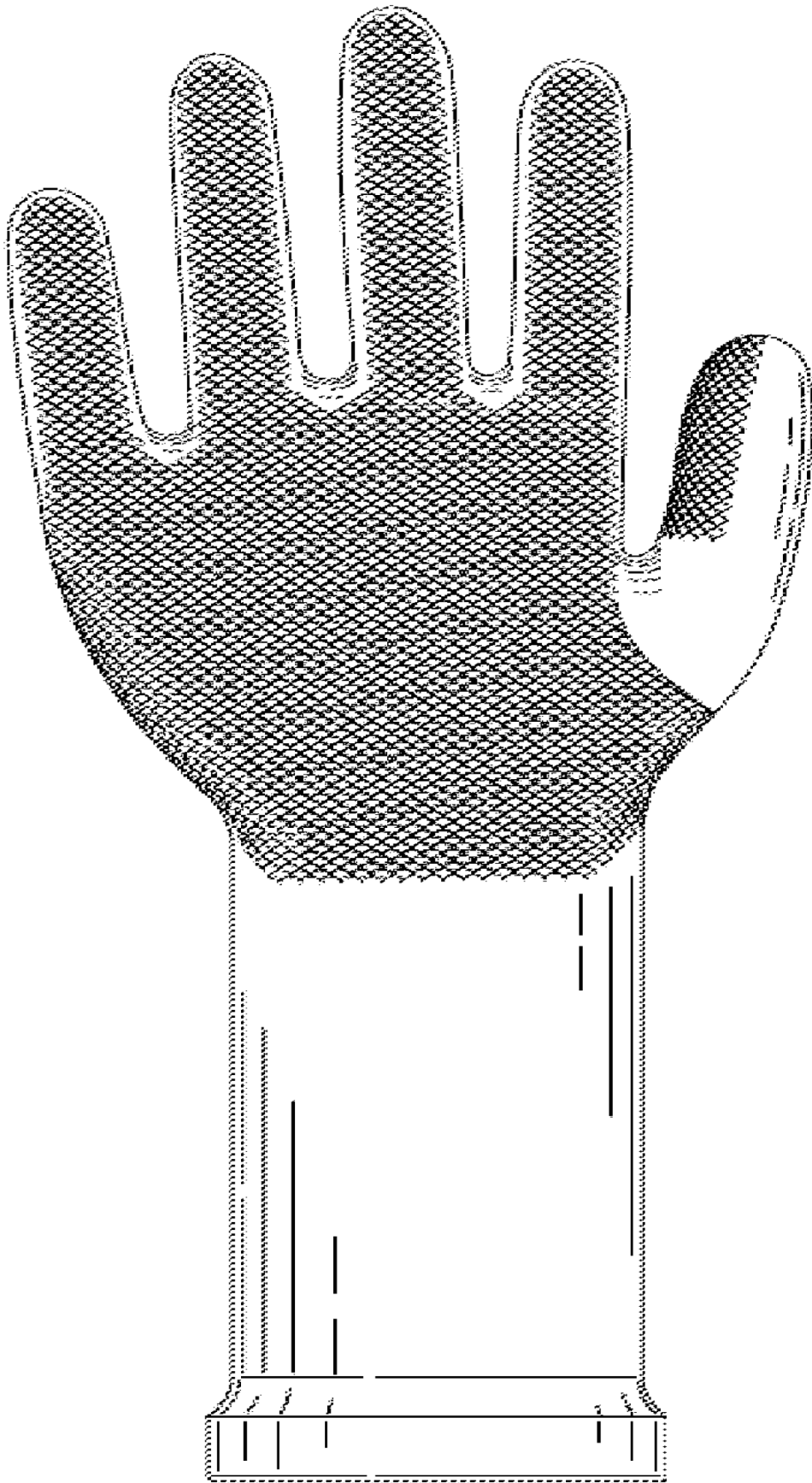
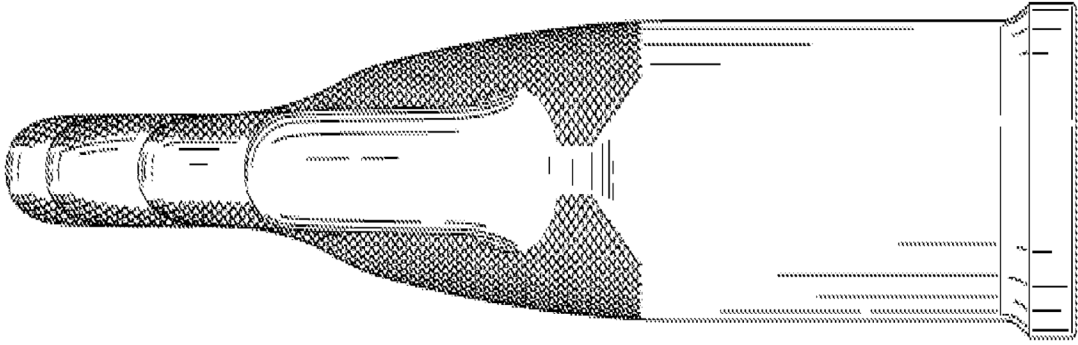


Figure 6

### Ambidextrous Textured Glove

a)



b)

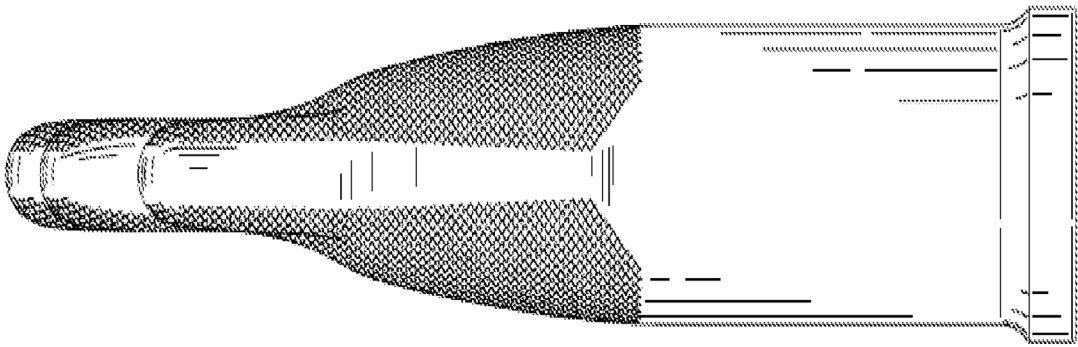
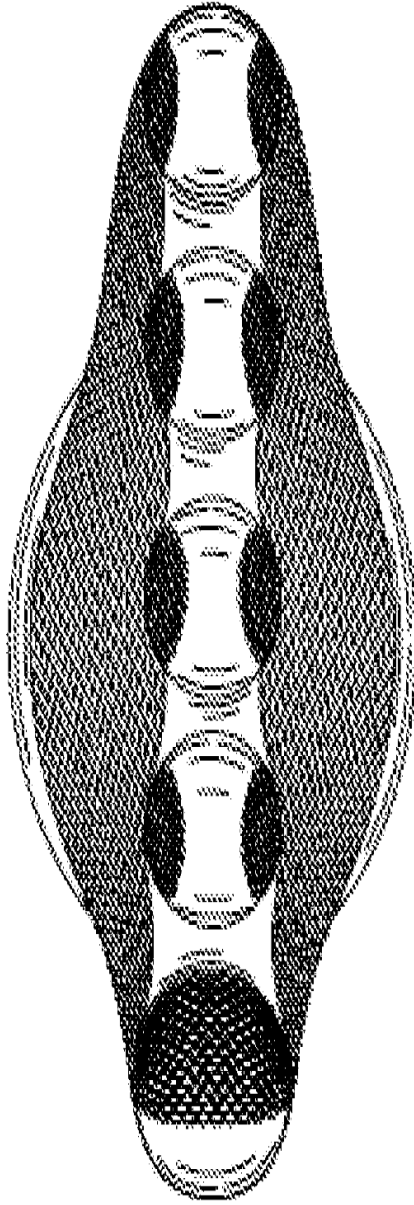


Figure 7

Ambidextrous Textured Glove

a)



b)

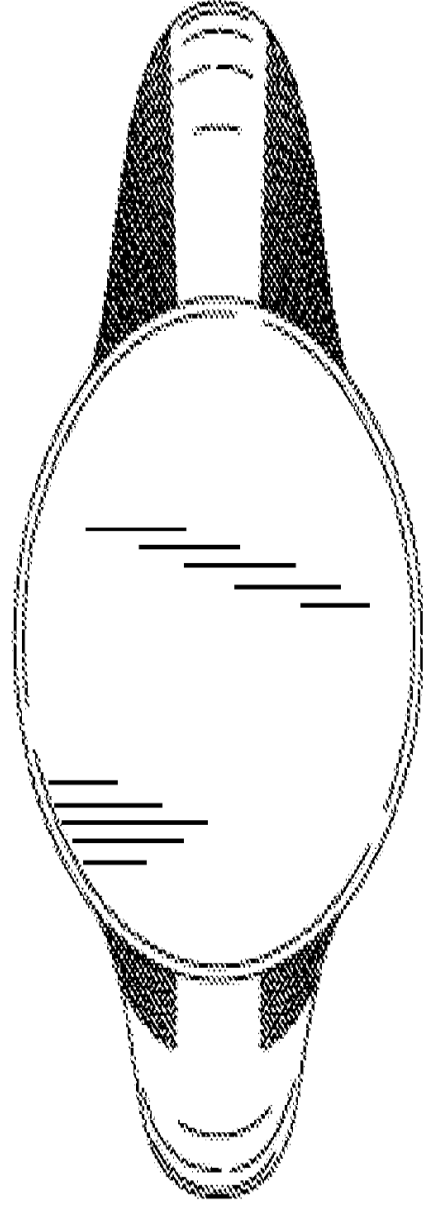


Figure 8



Figure 9

### Ambidextrous Textured Glove

2026201882 12 Mar 2026



Figure 10

### Ambidextrous Textured Glove



Figure 11

# Ambidextrous Textured Glove

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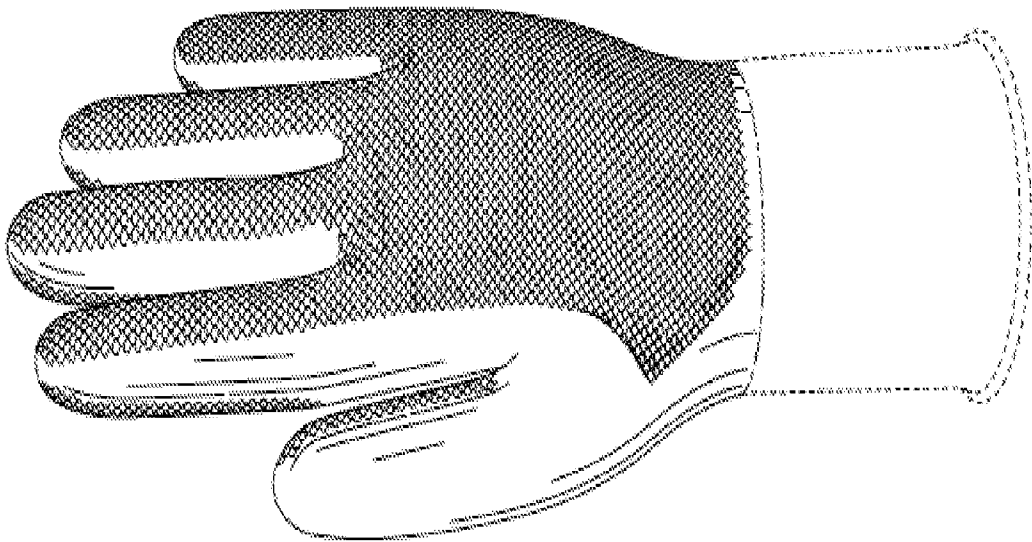
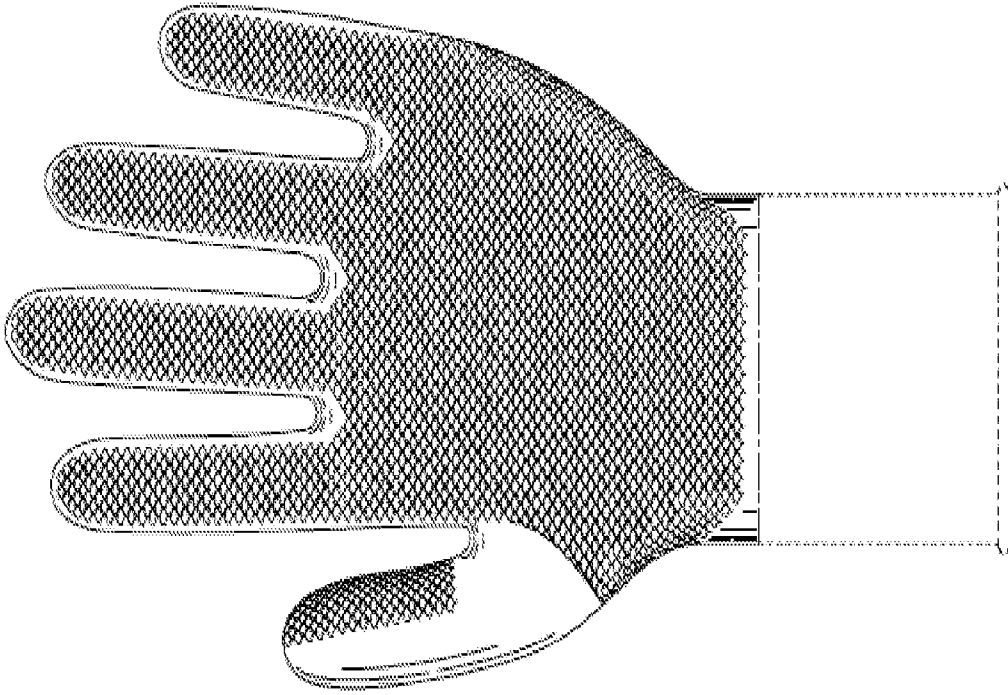


Figure 12

Ambidextrous Textured Glove



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Figure 13

# Ambidextrous Textured Glove

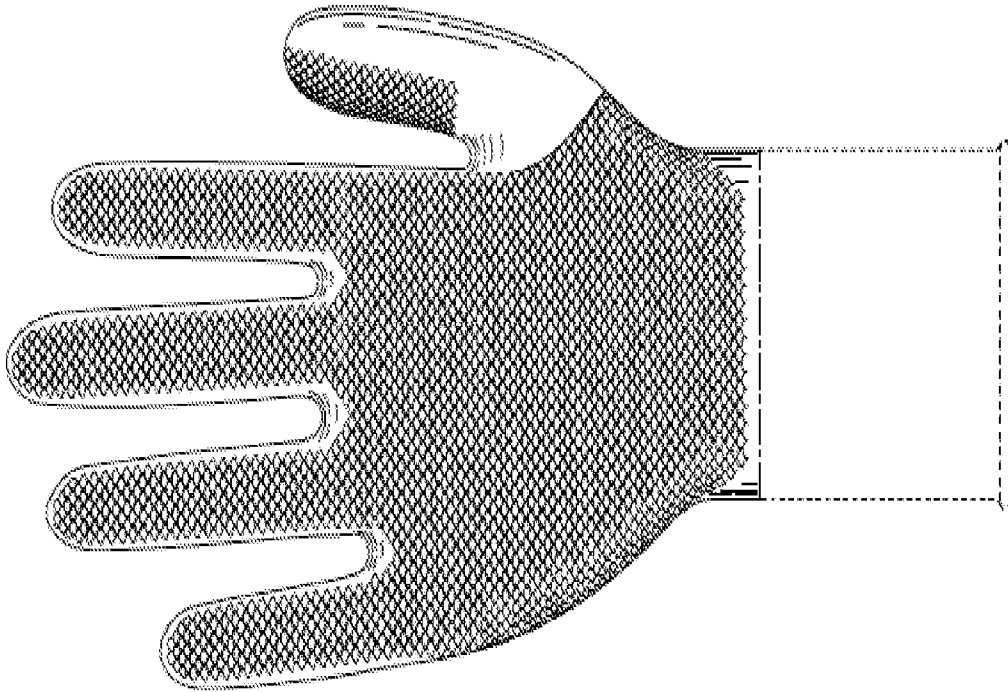


Figure 14

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# Ambidextrous Textured Glove

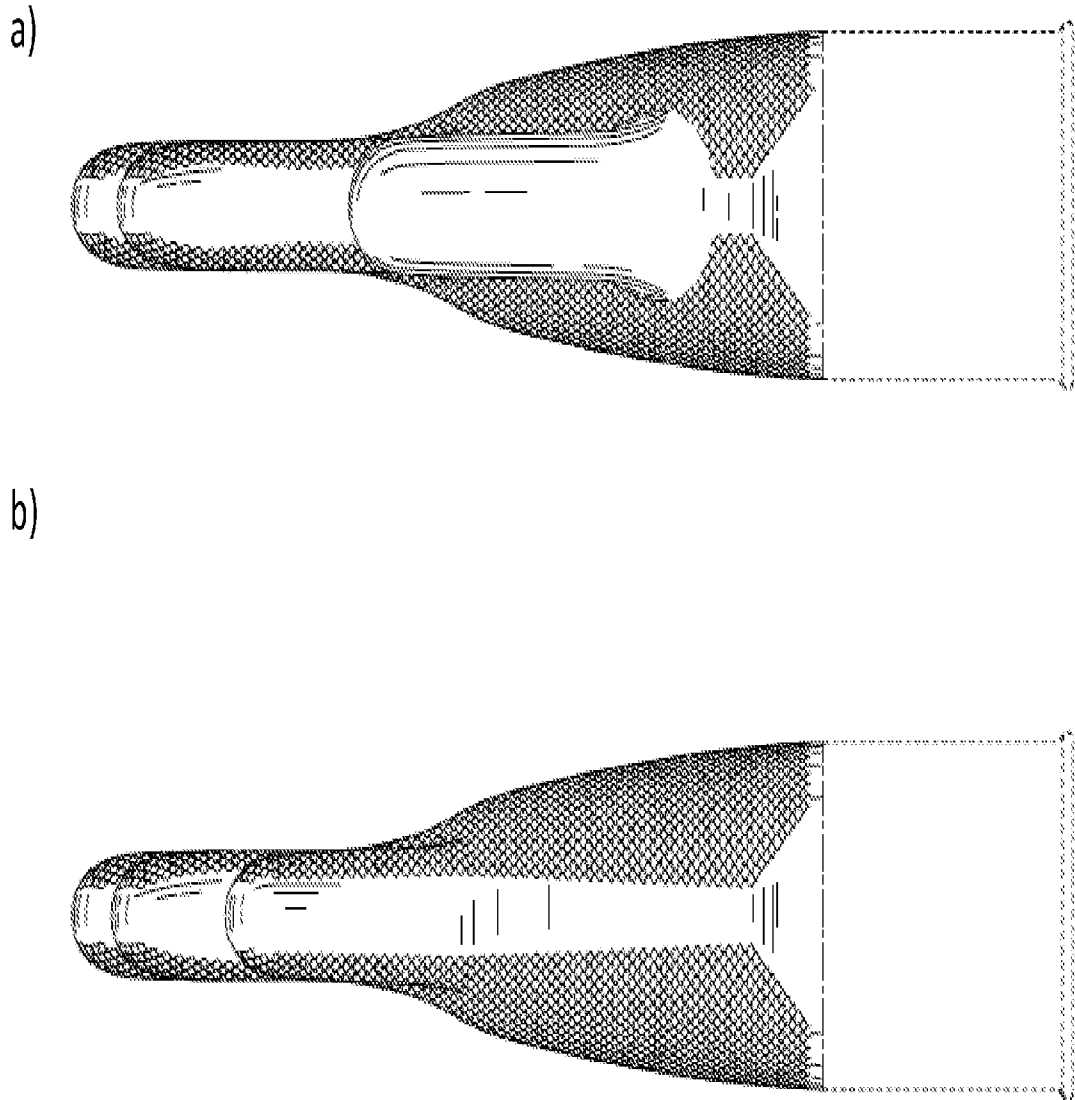
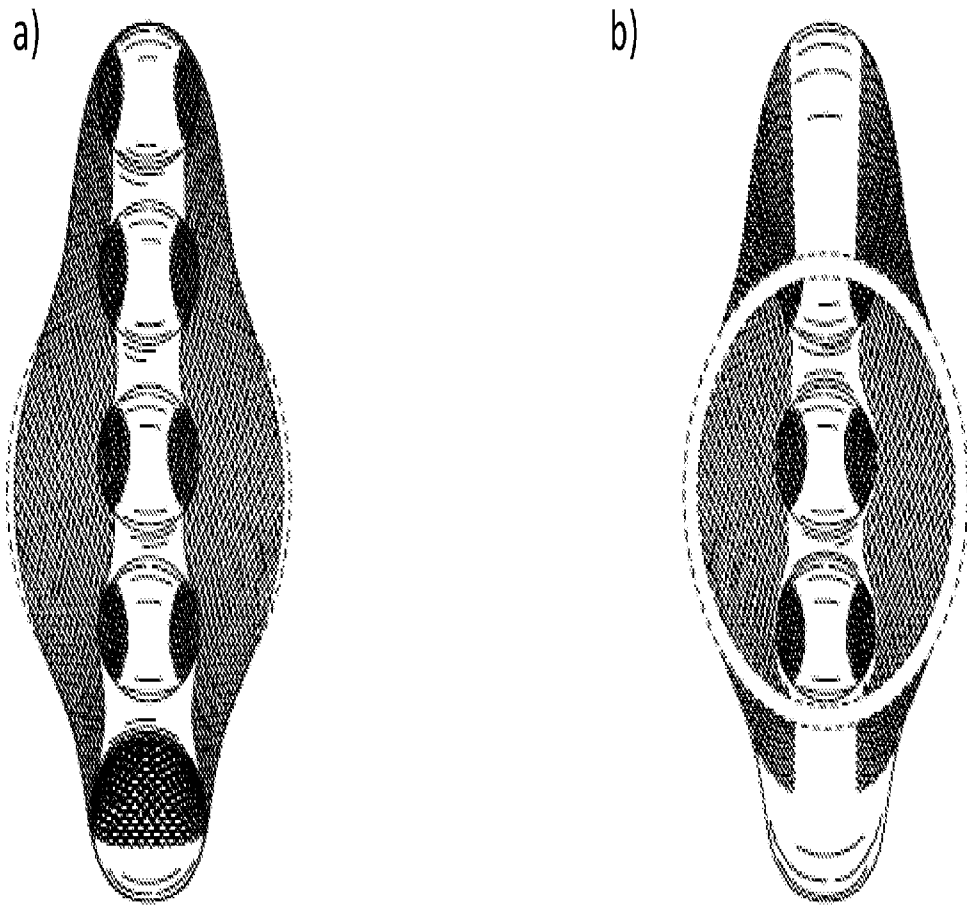


Figure 15

# Ambidextrous Textured Glove



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Figure 16