

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property
Organization
International Bureau

(43) International Publication Date
06 January 2022 (06.01.2022)



(10) International Publication Number
WO 2022/003380 A1

(51) International Patent Classification:

D21H 27/00 (2006.01) D21H 27/30 (2006.01)
D21H 27/02 (2006.01) D21H 27/40 (2006.01)

(21) International Application Number:

PCT/IB2020/000583

(22) International Filing Date:

03 July 2020 (03.07.2020)

(25) Filing Language:

English

(26) Publication Language:

English

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(81) Designated States (*unless otherwise indicated, for every kind of national protection available*): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DJ, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IR, IS, IT, JO, JP, KE, KG, KH, KN, KP, KR, KW, KZ, LA, LC, LK, LR, LS, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC, SD, SE, SG, SK, SL, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, WS, ZA, ZM, ZW.

(54) Title: CORELESS ROLLS OF A TISSUE PAPER PRODUCT AND METHODS OF MANUFACTURING CORELESS ROLLS

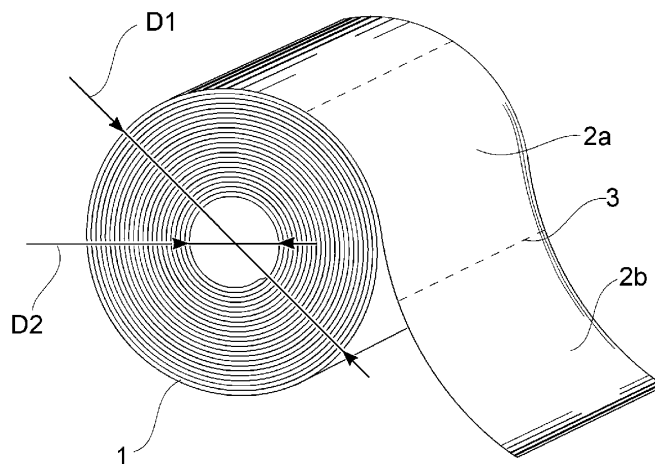


Fig. 1

(57) Abstract: This disclosure relates to a coreless roll of a tissue paper product, such as toilet paper, made of a spirally wound continuous web of tissue paper product having a first end and a second end and having an outer diameter in the range of 95 to 150 mm. The web of tissue paper product is wound such as to define an axially extending inner hole centrally positioned relative to the coreless roll and such that the first end is located on the outer side of the coreless roll and the second end is located at the inner hole. A diameter of the inner hole is in the range of 20 to 50 mm. A density of the coreless roll is in a range of 80 to 160 kg/m³. A caliper ratio of the roll is in a range of 10% to 80%. The tissue paper product comprises between two and six plies of Conventional Wet Press paper (CWP), wherein at least one of the plies is an embossed ply, and the plies are ply-bonded. The grammage of the tissue paper product is in a range of 24 g/m² to 125 g/m².

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(84) Designated States (*unless otherwise indicated, for every kind of regional protection available*): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, ST, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, KM, ML, MR, NE, SN, TD, TG).

Declarations under Rule 4.17:

— *as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii))*

Published:

— *with international search report (Art. 21(3))*