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

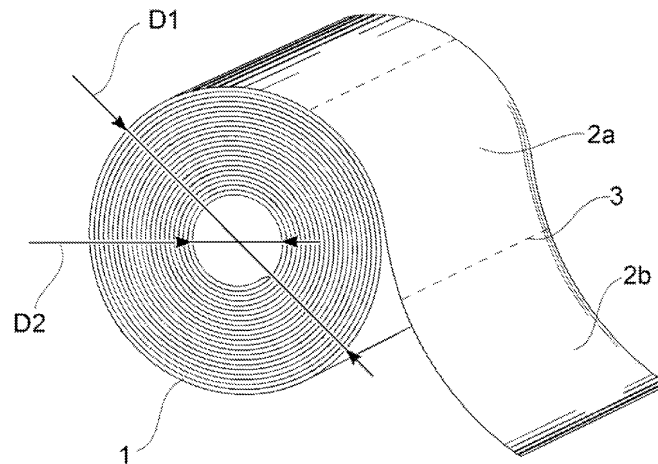


Fig. 1

(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 150 kg/m³. A caliper ratio of the roll is in a range of 10% to 80%. The tissue paper product comprises between two and four plies, wherein the plies are ply-bonded. At least one ply is made of Conventional Wet Press paper (CWP), and at least one ply is a structured ply. The grammage of the tissue paper product is in a range of 24 g/m² to 125 g/m².

[Continued on next page]

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