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

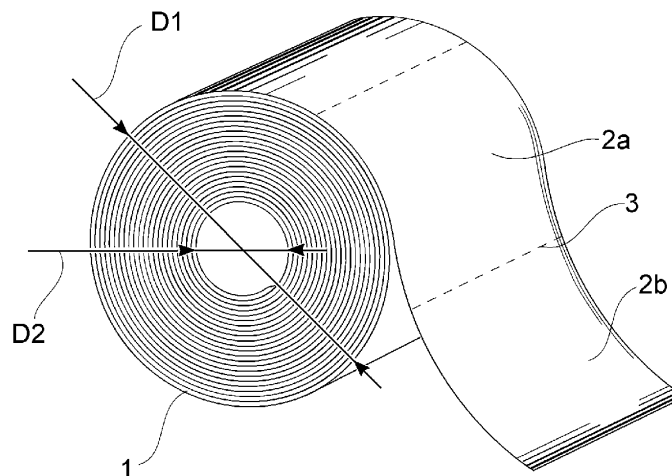


Fig. 1

(57) **Abstract:** This disclosure relates to a coreless roll of a tissue paper product, such as toilet paper or household towel, made of a spirally wound continuous web of tissue paper having a first end and a second end, the web of absorbent material being 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. The tissue paper product comprises at least two plies, at least one of the plies being an embossed ply with embossments. All of the plies of the tissue paper product are made of Conventional Wet Press (CWP) paper. The coreless roll has an outer diameter in the range of from 95 to 150 mm, a diameter of the inner hole being in the range of from 20 to 50 mm, and the density of the coreless roll being in a range of 110 to 160 kg/m³. The tissue paper product comprising glued areas, where the plies are ply-bonded to each other using an adhesive such as a lamination glue, and non-glued areas

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between the glued areas. At least some of the glued areas are glued embossed areas that comprise embossments of the embossed ply. A sum of areas of all glued embossed areas is at least 6% of a sum of the areas of all glued areas and of areas of all non-glued areas. Over at least 80% of the glued embossed areas, a maximum distance between adjacent embossments of the embossed ply is 2.5 mm or less, optionally 2.0 mm or less, or 1.5 mm or less.