

CLAIMS

~~[Claim 1] A polishing cloth mainly comprising a nonwoven fabric formed by entangling the ultrafine fiber bundles including ultrafine fibers with an average single fiber diameter of 0.05 to 2.0 μm and a polymeric elastic material, wherein the average size of the surface fiber-napped portions constituted by the aforementioned ultrafine fiber bundles of the aforementioned nonwoven fabric in the width direction of the ultrafine fiber bundles is 50 to 180 μm .~~

~~[Claim 2] A polishing cloth, according to claim 1, wherein the average size of the surface fiber-napped portions in the width direction of the ultrafine fiber bundles is 50 to 120 μm .~~

~~[Claim 3] A polishing cloth, according to claim 1 or 2, wherein the surface roughness of the polishing cloth is 5 to 18 μm .~~

~~[Claim 4] A polishing cloth, according to any one of claims 1 through 3, wherein the CV of the ultrafine fiber is 1 to 30%.~~

~~[Claim 5] A method for producing a polishing cloth mainly comprising a nonwoven fabric formed by entangling the ultrafine fiber bundles including ultrafine fibers with an average single fiber diameter of 0.05 to 2.0 μm and a polymeric elastic material, wherein the average size of the surface fiber-napped portions constituted by the aforementioned ultrafine fiber bundles is 20 to 180 μm , comprising at least the following steps (1) through (56) in combination, wherein the number of islands-in-sea type composite fibers convertible into ultrafine fibers, which can be brought in by the needle punching of the following step (2), is 3 to 6 fibers/1 barb:~~

~~(1) a step of producing islands-in-sea type composite fibers convertible into ultrafine fibers with an average single fiber diameter of 0.05 to 2.0 μm ;~~

~~(2) a step of laminating fiber webs by a card and a crosslapper using said islands-in-sea type composite fibers, and obtaining a nonwoven fabric by needle punching;~~

~~(3) a step of shrinking said nonwoven fabric by hot water, to have a higher fiber density from the view point of denser surface fibers;~~

~~(34) a step of giving a polymeric elastic material to said nonwoven fabric by 10 to 200 mass% based on the mass of the ultrafine fibers obtained by converting the composite fibers;~~

~~(45) a step of buffing at least one surface; and~~

~~(56) a step of converting said islands-in-sea type composite fibers into ultrafine fibers.~~

~~[Claim 62] A method for producing a polishing cloth, according to claim 51, wherein the number of islands-in-sea type composite fibers brought in by needle punching is 3 to 4 fibers/1 barb.~~