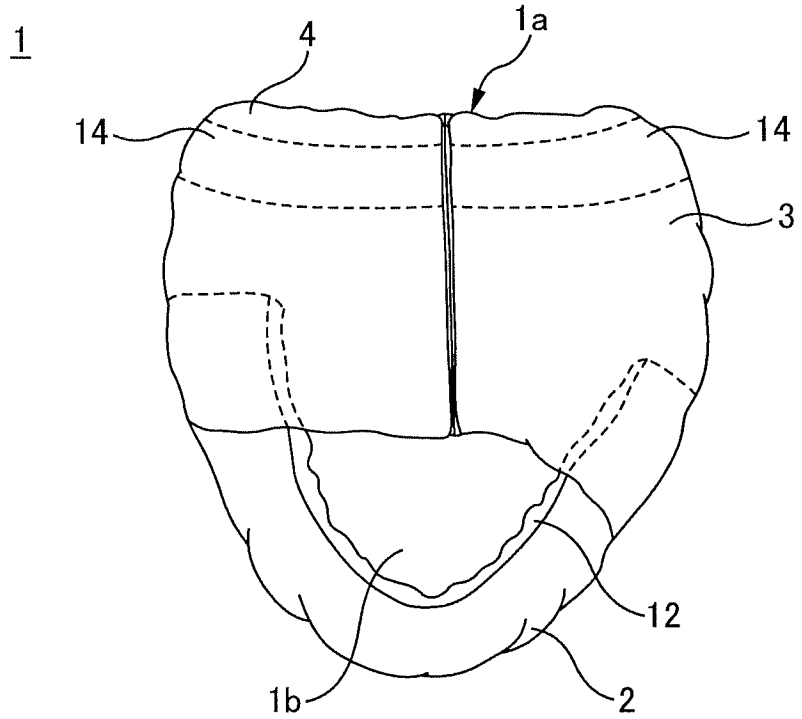


FIG. 1A

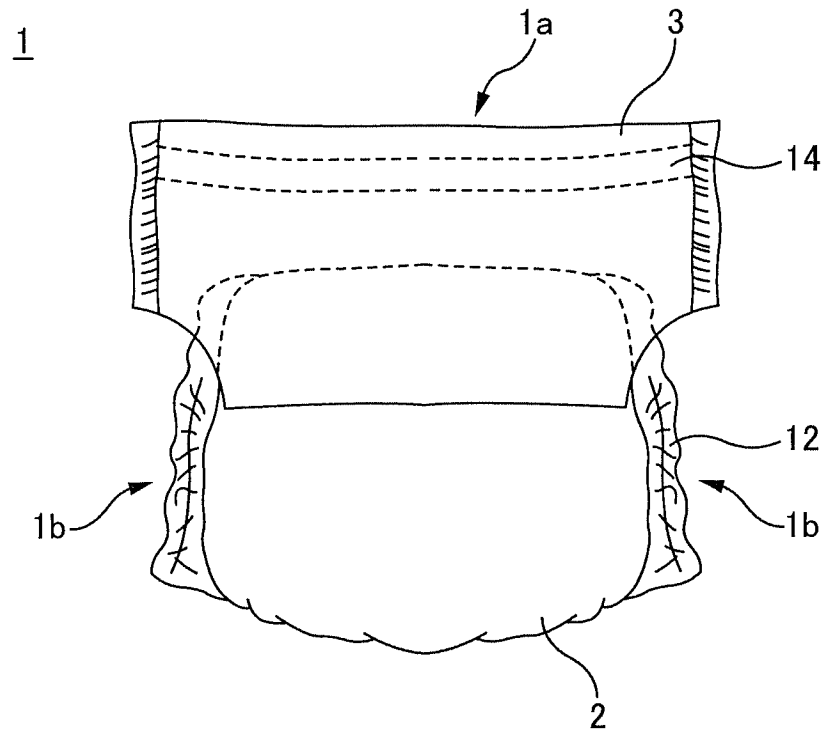


FIG. 1B

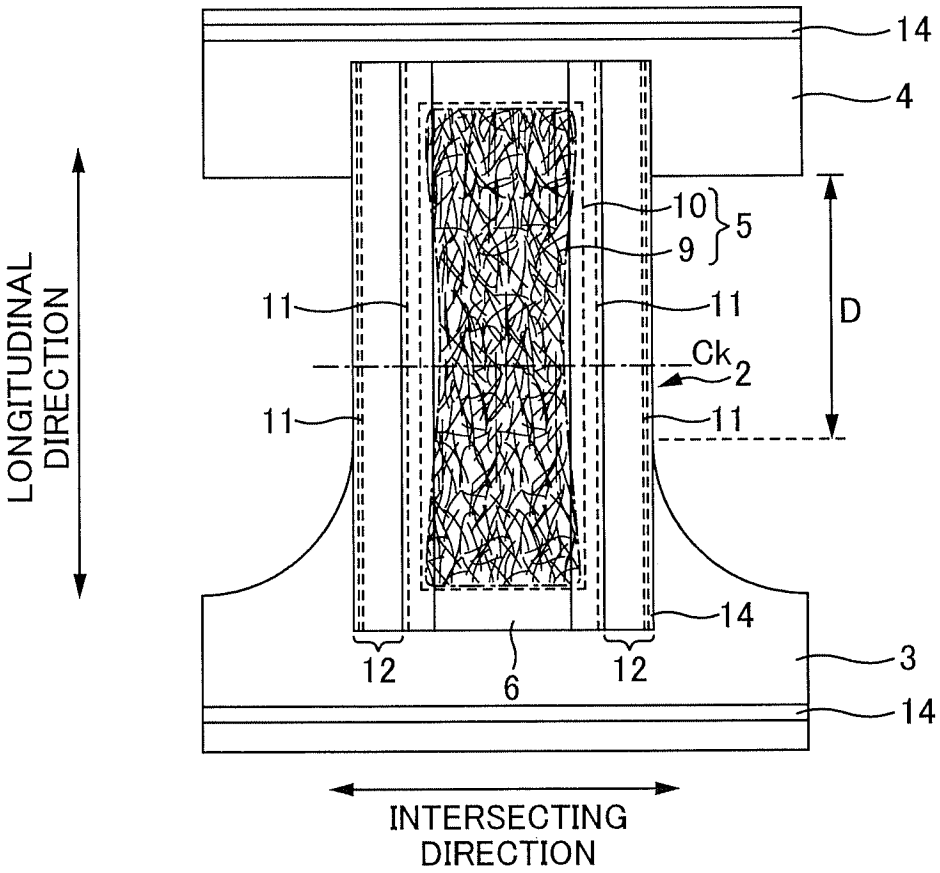

14
4
10
9
5
D
11
11
Ck
2
11
11
14
12
6
12
3
14
LONGITUDINAL DIRECTION
INTERSECTING DIRECTION

FIG. 1C

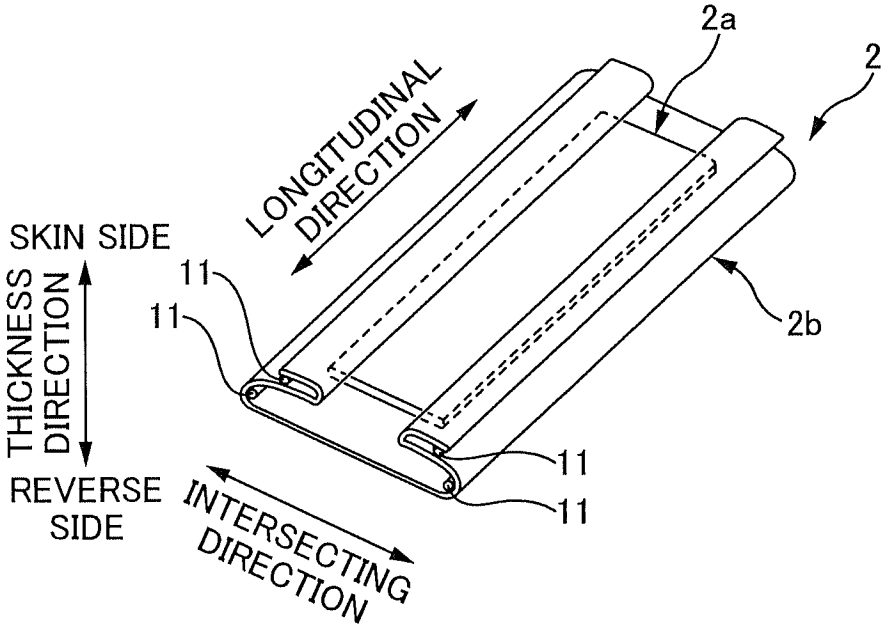

2a
2
LONGITUDINAL DIRECTION
SKIN SIDE
THICKNESS DIRECTION
REVERSE SIDE
11
11
2b
11
11
INTERSECTING DIRECTION

FIG. 2A

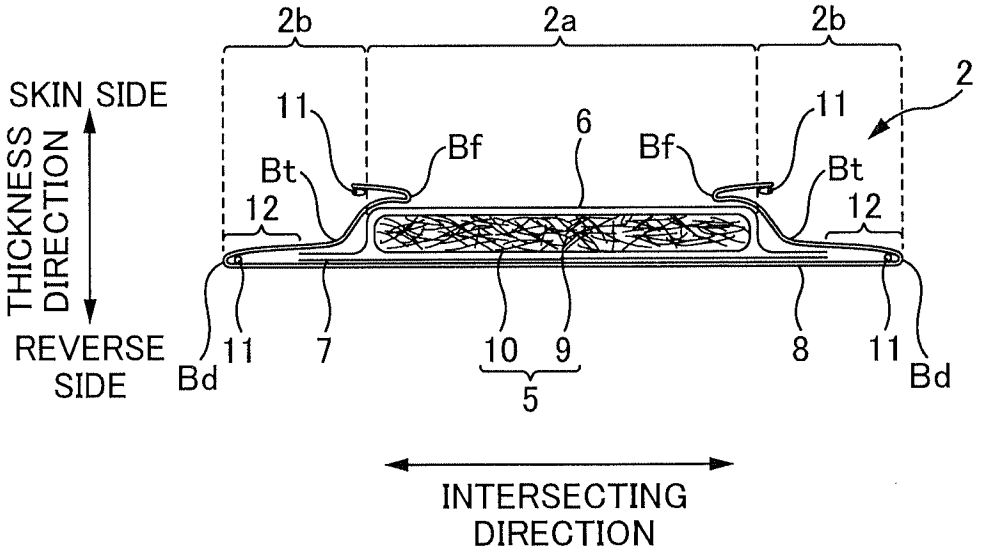

2b
2a
2b
2
SKIN SIDE
THICKNESS DIRECTION
REVERSE SIDE
11
Bf
6
Bf
11
Bt
Bt
12
12
Bd
11
7
10
9
8
11
Bd
5
INTERSECTING DIRECTION

FIG. 2B

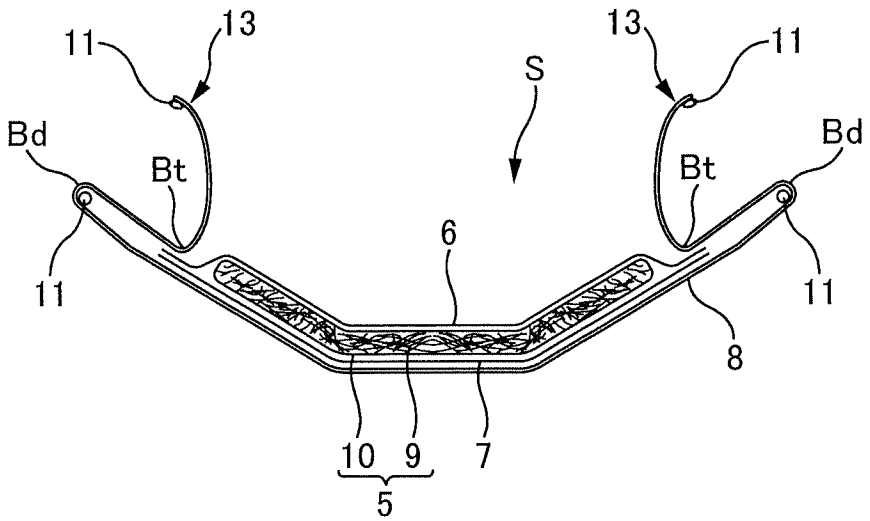

11
13
S
13
11
Bd
Bt
Bt
Bd
6
11
11
8
10
9
7
5

FIG. 3

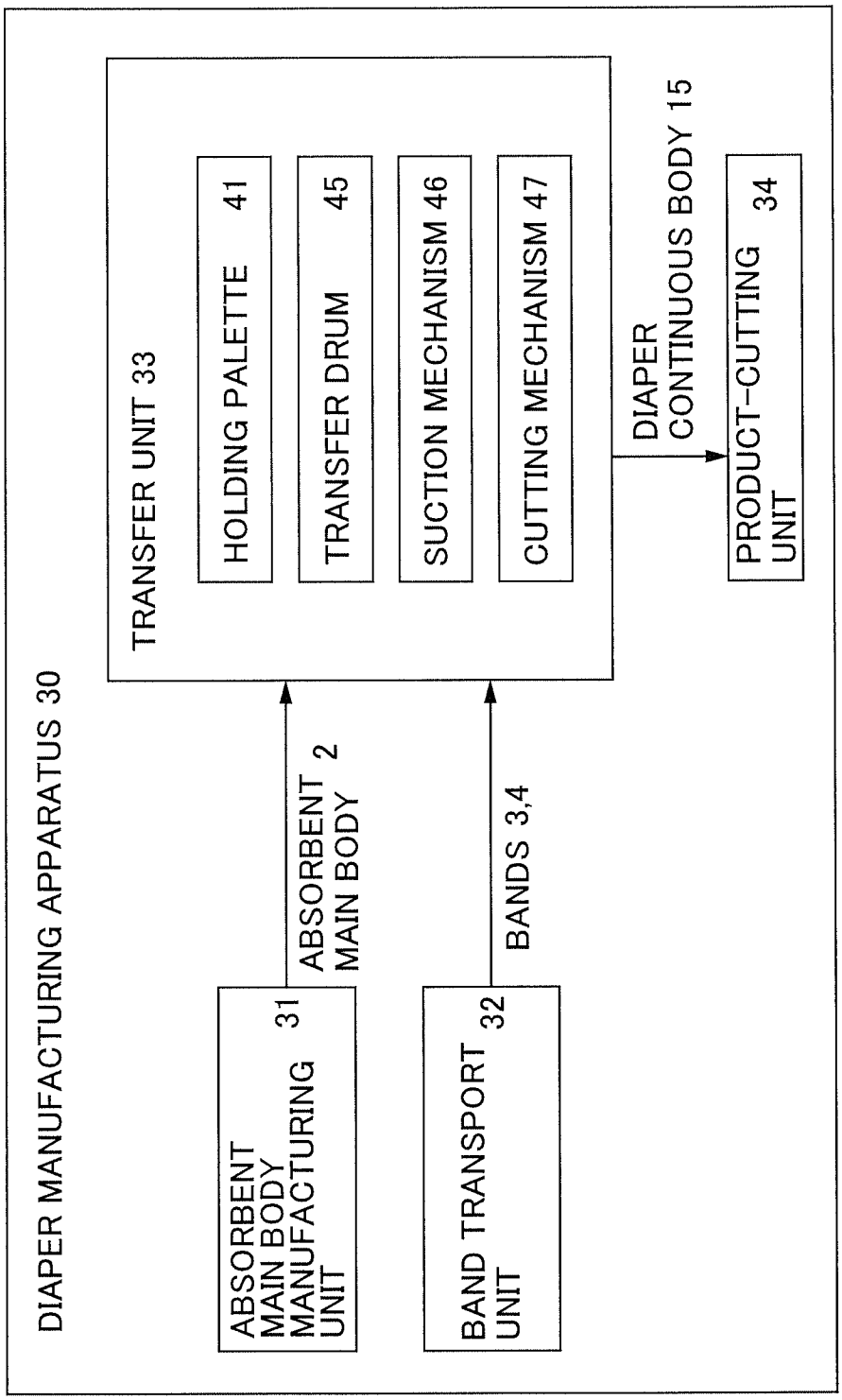

DIAPER MANUFACTURING APPARATUS 30
ABSORBENT MAIN BODY MANUFACTURING UNIT 31
BAND TRANSPORT UNIT 32
TRANSFER UNIT 33
HOLDING PALETTE 41
TRANSFER DRUM 45
SUCTION MECHANISM 46
CUTTING MECHANISM 47
PRODUCT-CUTTING UNIT 34
ABSORBENT MAIN BODY 2
BANDS 3,4
DIAPER CONTINUOUS BODY 15

FIG. 4

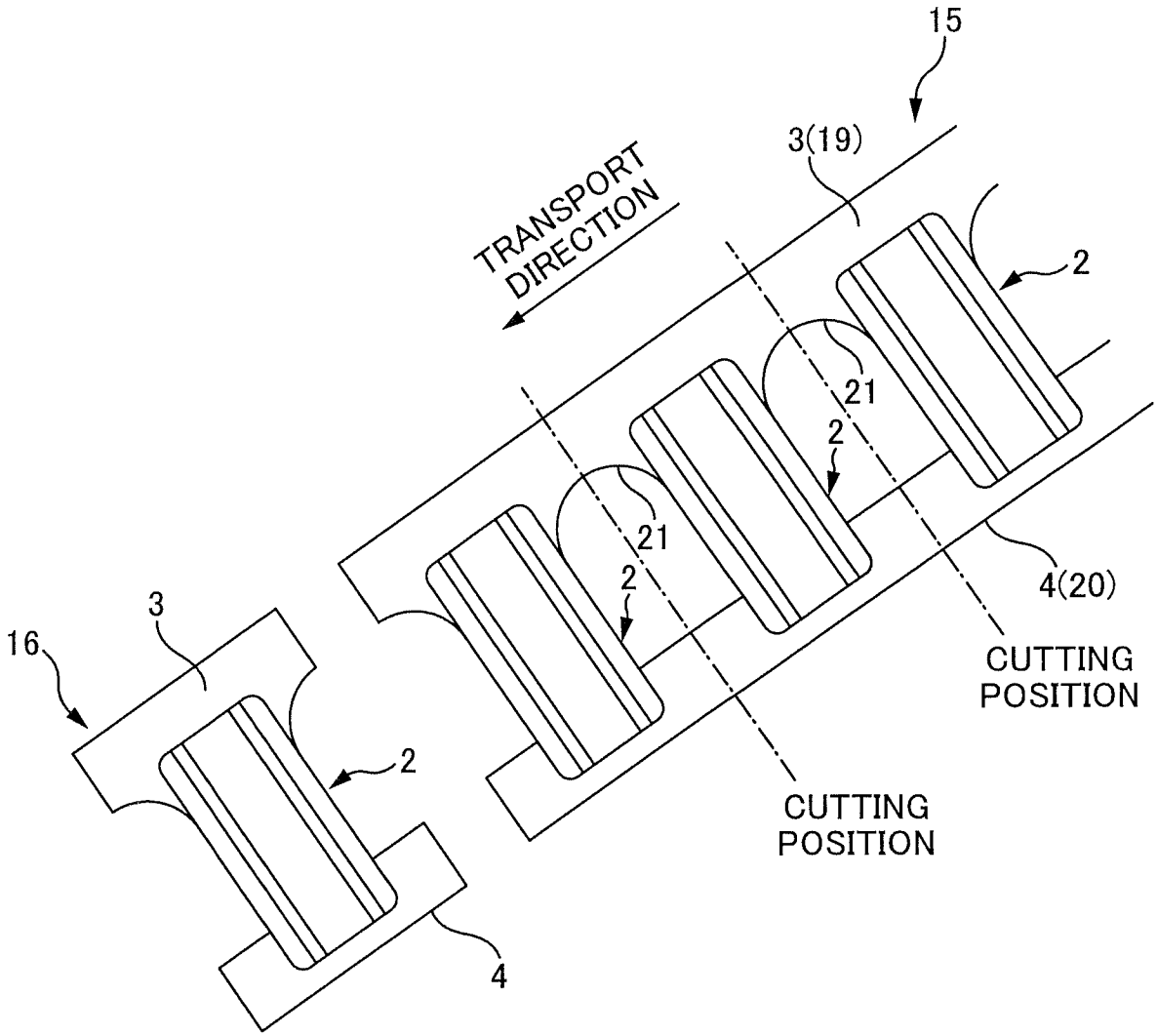

15
3(19)
TRANSPORT DIRECTION
2
21
2
21
2
4(20)
CUTTING POSITION
CUTTING POSITION
16
3
2
4

FIG. 5

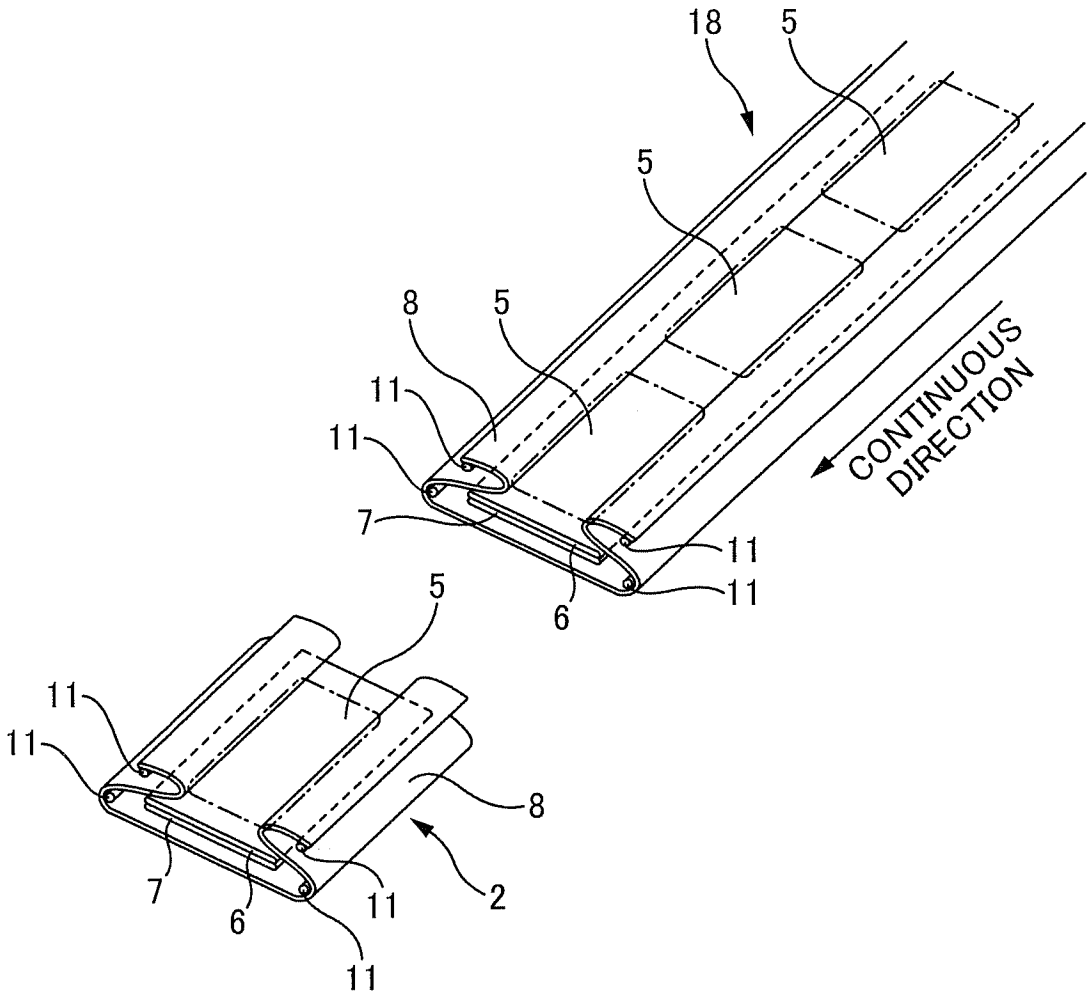


FIG. 6A

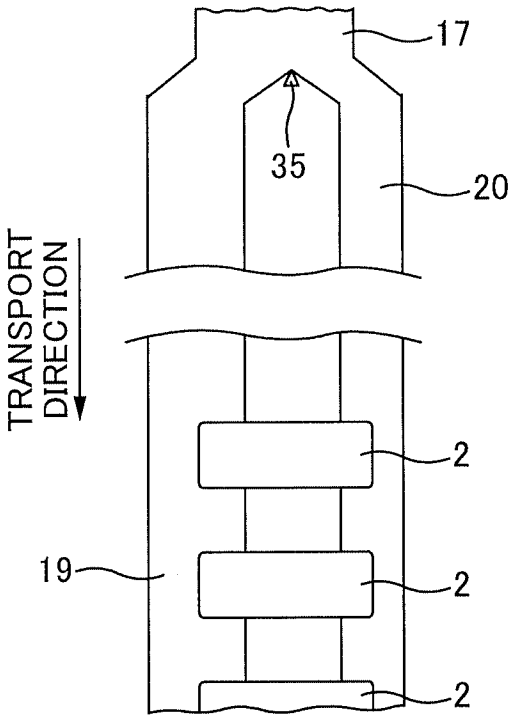

17
35
20
TRANSPORT DIRECTION
2
19
2
2

FIG. 6B

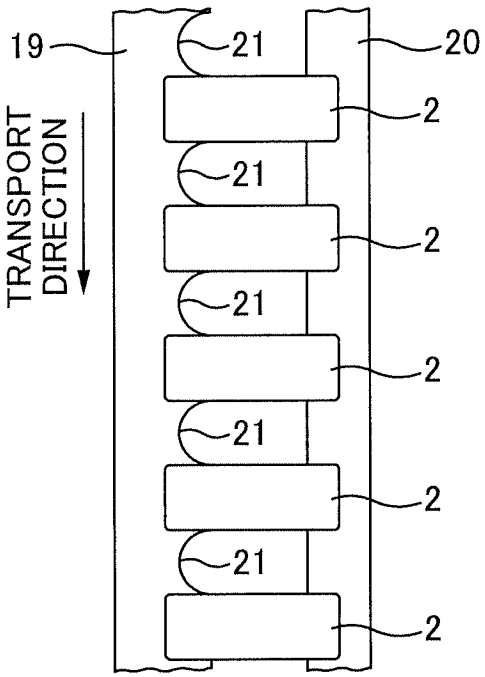

19
21
20
2
TRANSPORT DIRECTION
21
2
21
2
21
2
21
2

FIG. 6C

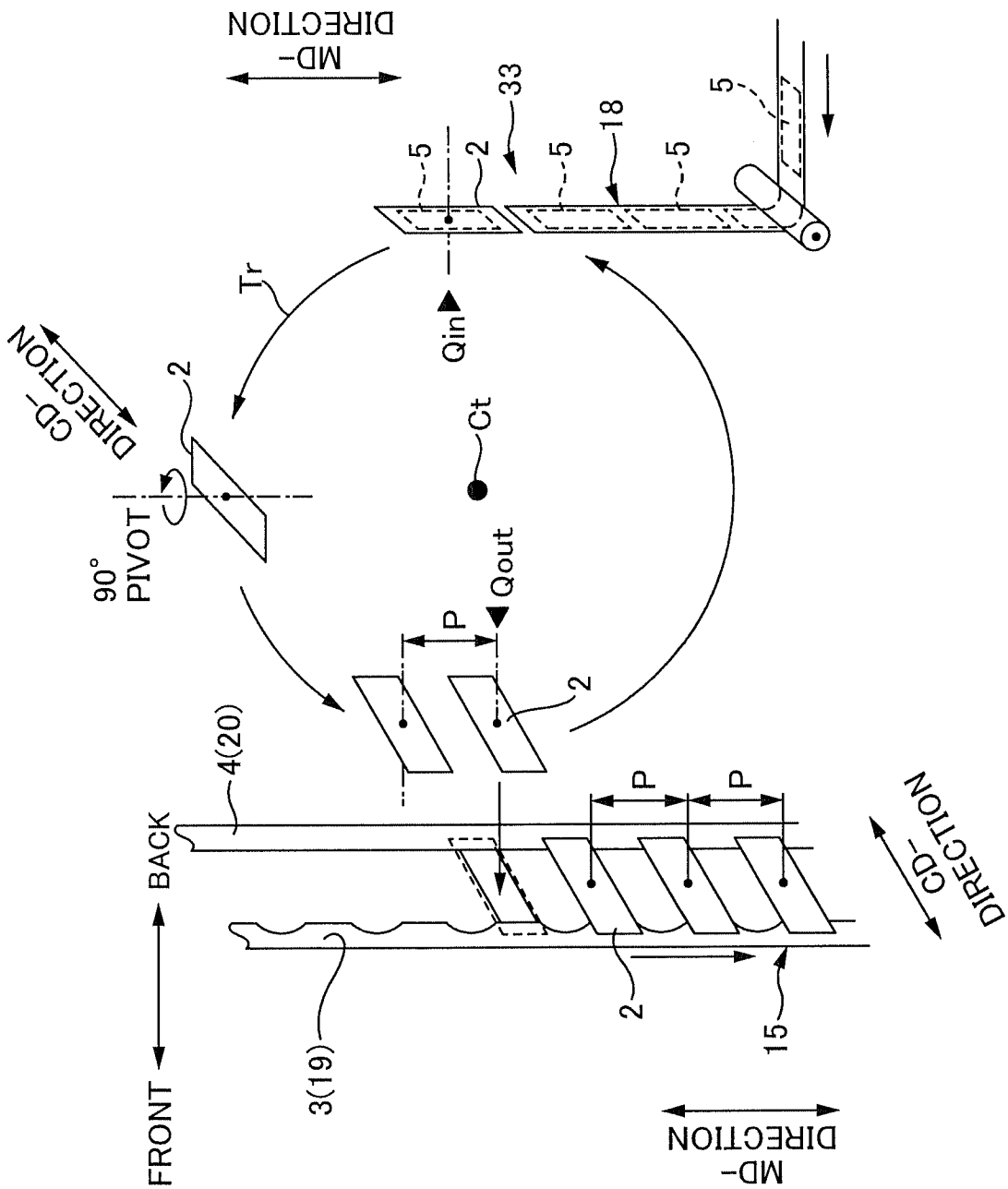

MD-
DIRECTION
33
18
5
2
Tr
Qin
Ct
CD-
DIRECTION
90°
PIVOT
Qout
P
4(20)
BACK
FRONT
3(19)
15
MD-
DIRECTION
CD-
DIRECTION

FIG. 7

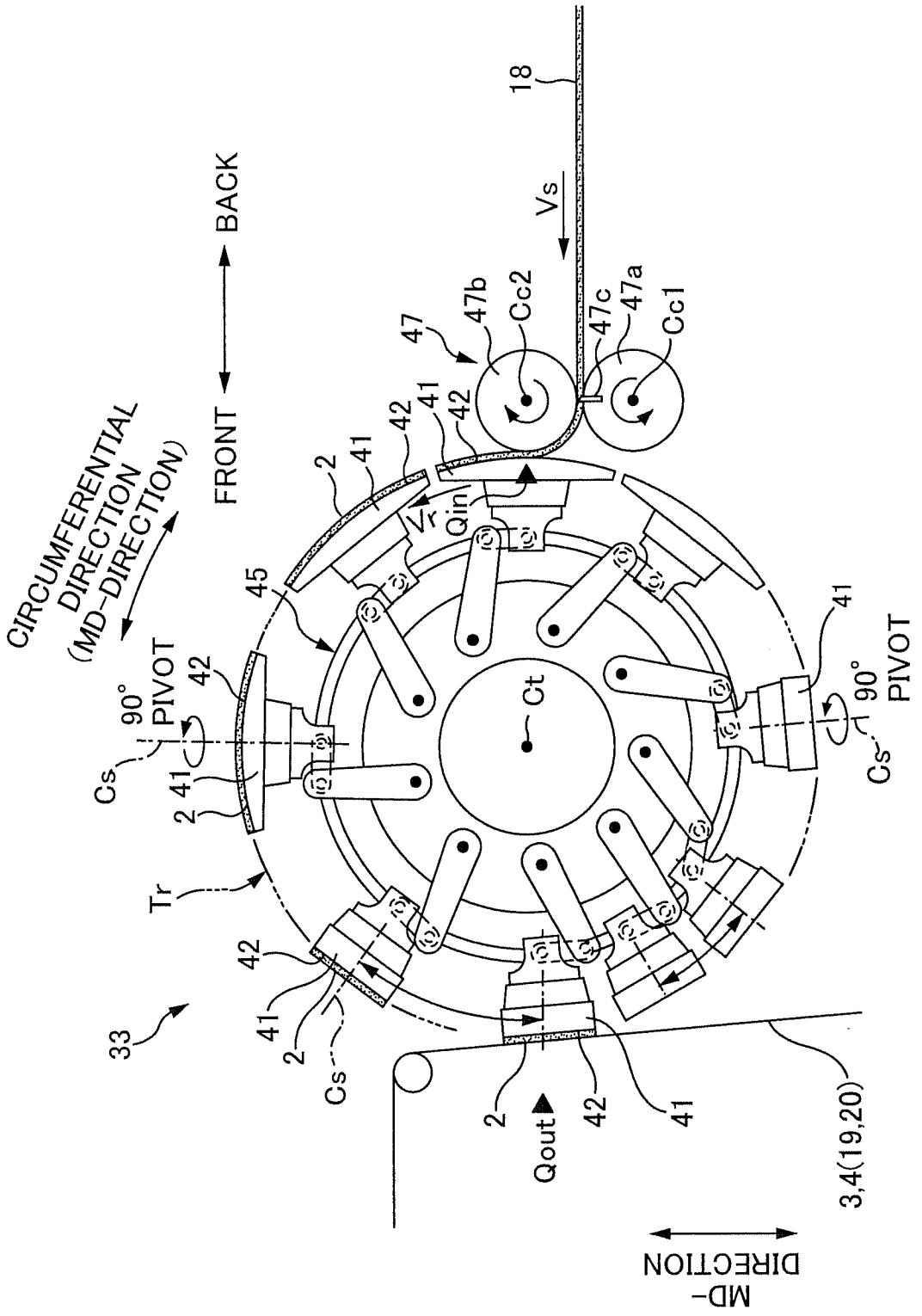

CIRCUMFERENTIAL DIRECTION (MD-DIRECTION)
FRONT
BACK
18
Vs
47
47b
Cc2
47c
47a
Cc1
41
42
2
Vr
Qin
45
Ct
90° PIVOT
Cs
Tr
33
Qout
3,4(19,20)
MD-DIRECTION

FIG. 8

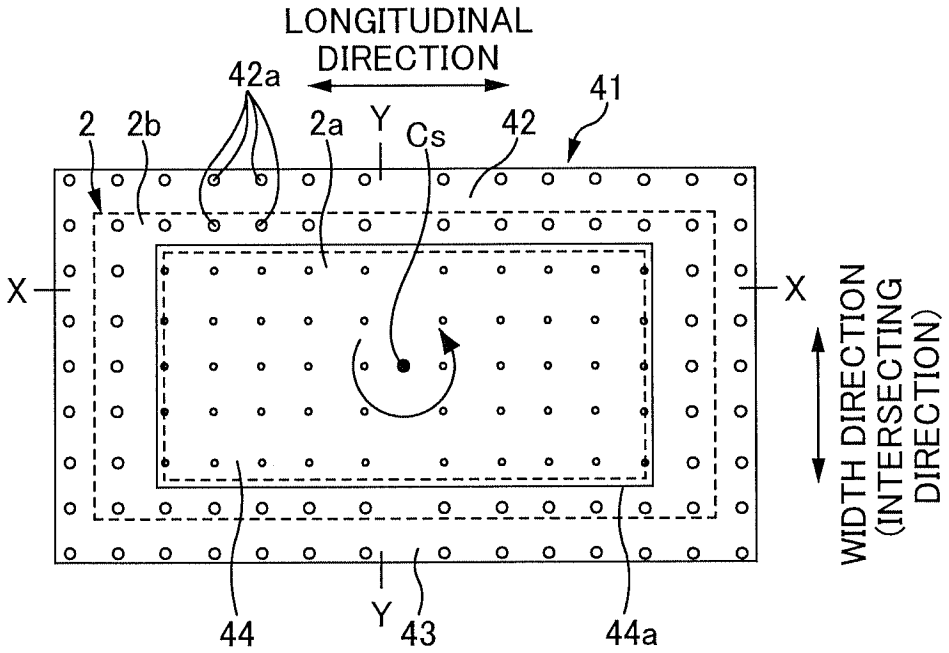


FIG. 9A

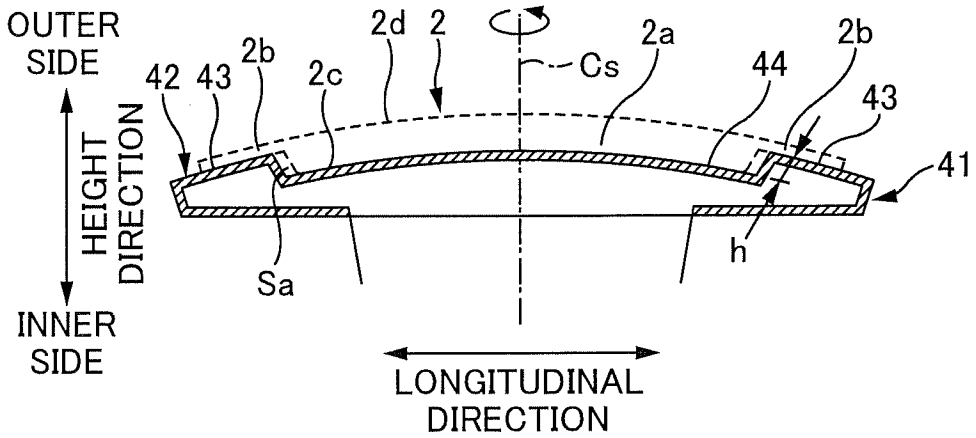


FIG. 9B

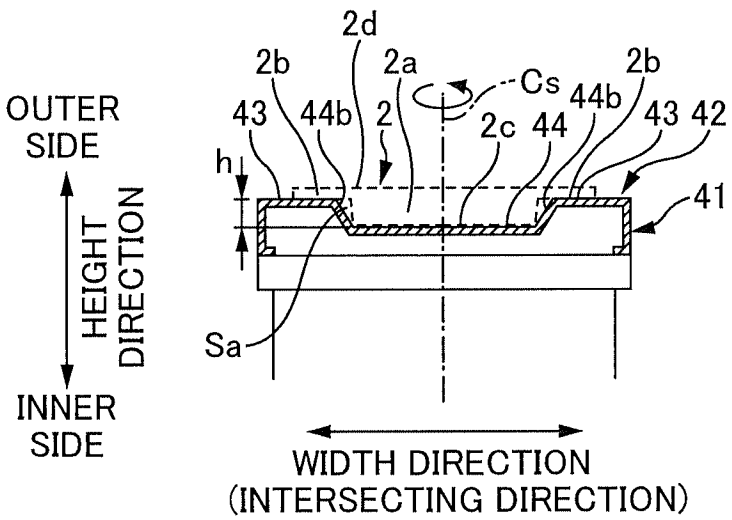


FIG. 9C

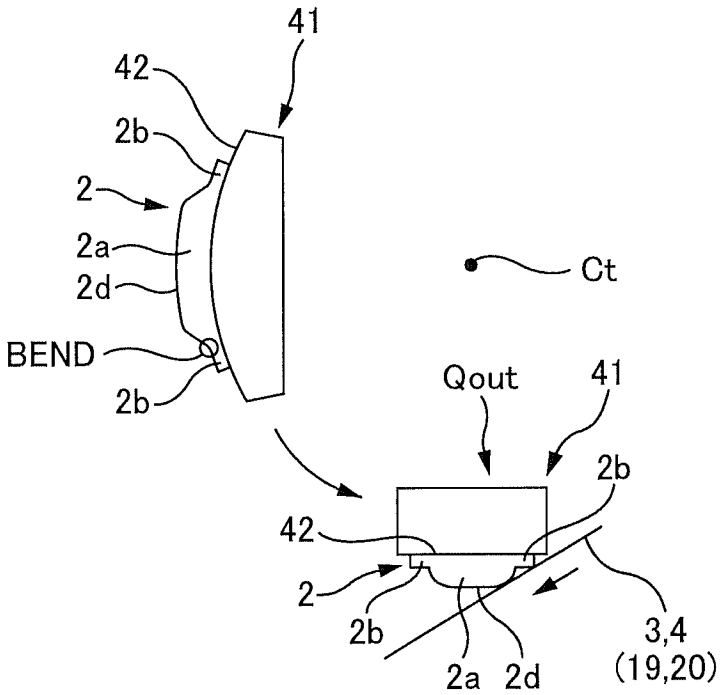


FIG. 10A

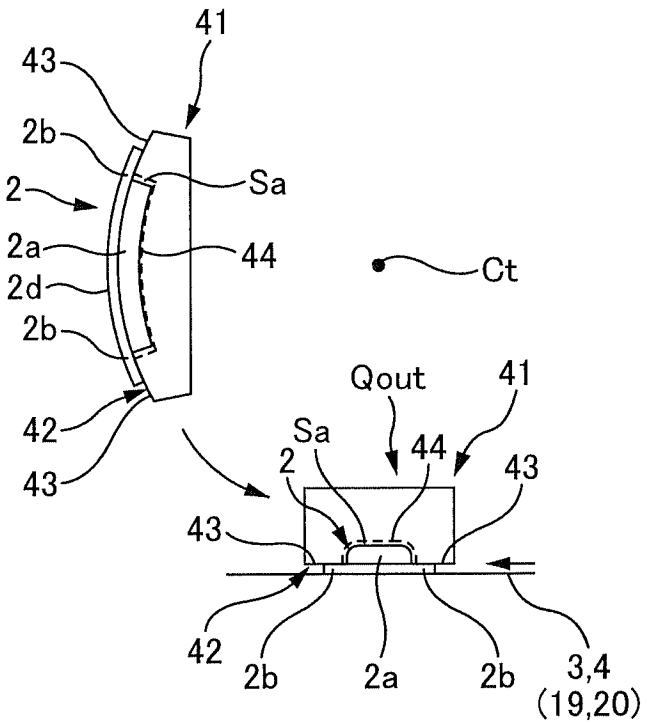


FIG. 10B

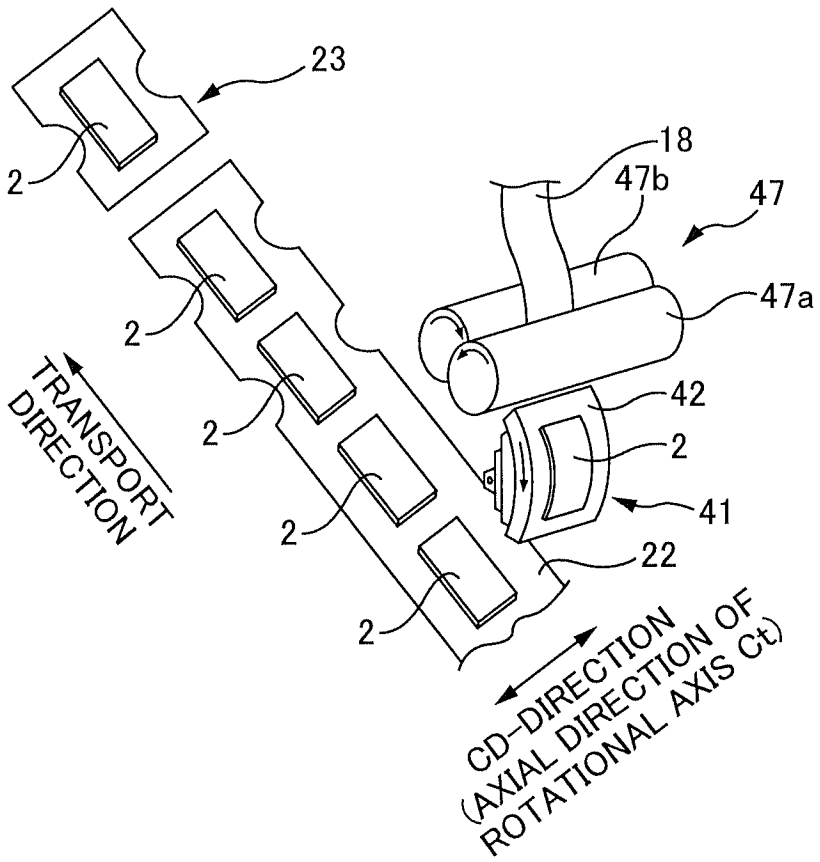


FIG. 11A

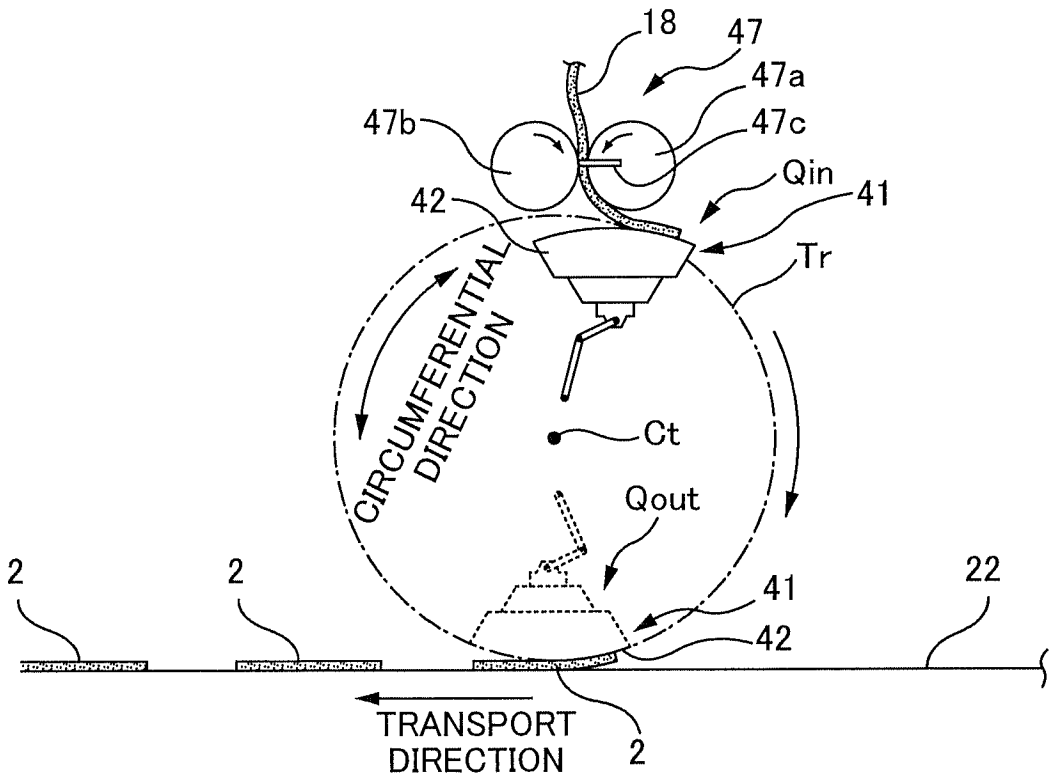
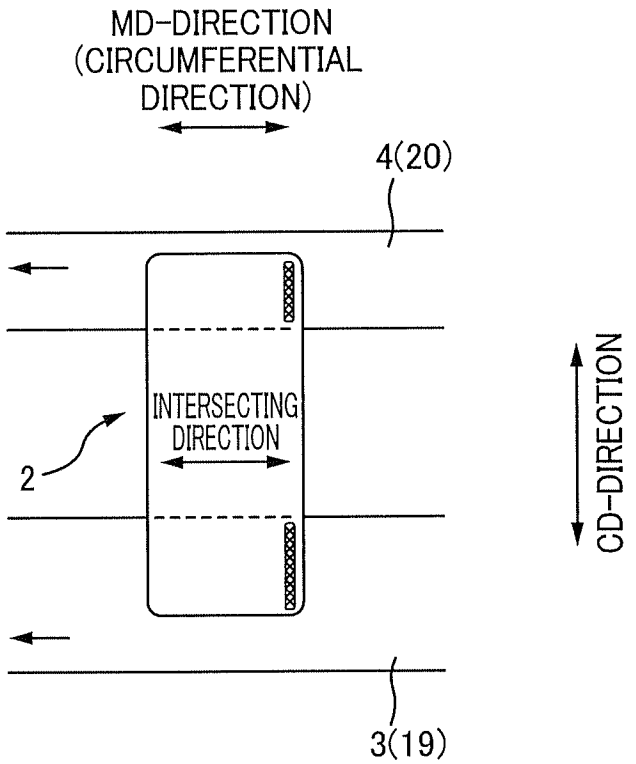
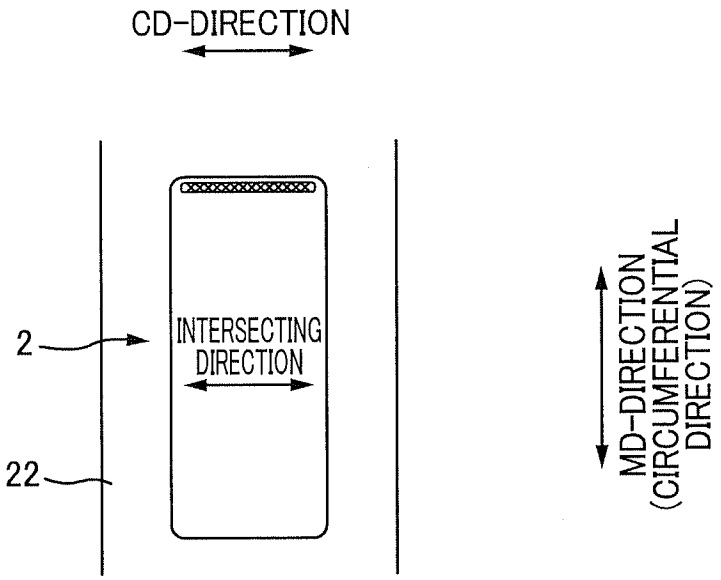


FIG. 11B



EXAMPLE OF
PRESENT INVENTION

FIG. 12A



VARIANT

FIG. 12B