

RTMP'S COPY

This Sheet Has Been Replaced

THIS SHEET HAS BEEN
REPLACED**METHODS AND APPARATUS FOR MAKING MULTI-LAYER
ABSORBENT PRODUCTS**

5 The present invention relates to methods and
apparatus for making absorbent products and to
absorbent products themselves. More specifically, the
present invention relates to absorbent products formed
from two or more layers of material.

Background of the Invention

10 The production of absorbent products such as
sanitary napkins is a highly developed art that
encompasses numerous techniques for cutting and
assembling various layers of materials into absorbent
product. As with any consumer product produced in high
volumes, two considerations are of paramount
15 importance, speed and efficiency. Speed is enhanced by
making the production process as continuous as
possible. Ideally rolls of material are fed into one
end of a production system and finished product
emerges. For example, U.S. Patent 4,432,746 discloses
20 a web segmenting apparatus that cuts a running web into
discrete articles. Other systems for cutting webs
either continuously or discontinuously are known.

25 One aspect of efficiency is the full utilization
of raw materials, thus sheet material should be cut to
minimize excess design scrap or trim waste. However,
many types of absorbent products are cut to shapes
specifically chosen to conform to the parts of the body



THIS SHEET HAS BEEN REPLACED

to which they are applied. For ~~example, U.S. patent~~
3,488,778 (Goujon et al.) discloses the pattern
required to fabricate panties. As seen in FIGS. 2-3 of
that patent, however, there is a great deal of material
wasted when this pattern is cut.

5

There is therefore a continuing need to provide
efficient processes for making absorbent articles.
Moreover, it would be desirable to construct absorbent
articles with as little waste material as possible. It
is therefore an object of this invention to provide
absorbent articles and apparatus and methods for making
them that utilize materials efficiently and that lend
themselves to being operated continuously.

10

Summary of the Invention

15

Methods of forming absorbent structures are
disclosed that include the steps of feeding a sheet of
material into a die and cutting substantially
ellipsoidal portions from the material at evenly spaced
intervals, thereby leaving substantially hyperbolic
portions between the ellipsoidal portions. At least
one ellipsoidal portion is then placed atop at least
one of the hyperbolic portions to create an absorbent
structure. By using the methods of the present
invention, an absorbent structure is formed with
substantially no waste by using the entire sheet of
material from which the absorbent structure is formed.
In a preferred embodiment, the methods of the present
invention include the step of feeding material of a
predetermined width into a rotary die to provide a
continuous process. In certain embodiments of the
invention, the additional step of spraying a powder
across the material is added. This permits an

20

25

30



5 absorbent powder or the like to be added to the
components of the absorbent structure. Most
preferably, the faces of the ellipsoidal and hyperbolic
portions that have been sprayed with a powder are
placed face to face to form an absorbent structure.

10 An alternative embodiment of the method of the
present invention includes the steps of feeding a first
sheet of material into a first die and cutting an
arcuate section from the material while simultaneously
feeding a second sheet of material into a second die
and cutting an arcuate section from this sheet of
material. The two arcuate sections are placed atop one
another to form a substantially ellipsoidally-shaped
overlapping section within an absorbent structure. In
15 this embodiment, rotary dies are again preferably used
and in certain embodiments, a powder may be applied to
the material.

20 The present invention also discloses products made
using the above-described method and apparatus
including 10 sanitary napkins, panty shields and
diapers. Thus, in a first embodiment, an improved
product is disclosed that comprises a hyperbolic-shaped
layer of material and an ellipsoidal-shaped layer of
material that is disposed atop the hyperbolic-shaped
25 layer wherein due to being cut from the same sheet of
material the hyperbolic and ellipsoidal layers have a
substantially identical curvature along at least part
of their perimeter.



Brief Description of the Drawings

FIG. 1 is a partial perspective view of a portion 20 of a rotary die apparatus as used with the present invention and products made thereby.

5 FIG. 2 is a partial perspective view of a portion of a rotary die apparatus, similar to that shown in FIG. 1, and also illustrating the application of a powder to cut sections of material.

10 FIG. 3 is a partial perspective view of a portion of a rotary die apparatus as used with the present invention, similar to that shown in FIG. 1, and also illustrating an alternate embodiment of products made thereby.

15 FIG. 4 is a partial perspective view of a portion of a rotary die apparatus as used with the present invention, similar to that shown in FIG. 1, and also illustrating an another alternate embodiment of products made thereby.

20 FIG. 5 is a partial perspective view of a portion of a pair of rotary die apparatus as used with certain embodiments of the present invention, and also illustrating products made thereby.

Detailed Description of the Preferred Embodiments

25 The present invention most preferably takes advantage of the manufacturing efficiencies inherent in the use of a rotary die. As understood by those of ordinary skill, a rotary die permits a sheet of material to be continuously fed into the die and cut



into desired shapes. A typical rotary die useful with the present invention is in the form of a steel rule die that is formed around a cylinder. The surface of the cylinder may carry one or more of the shapes that are being cut. It will be understood, however, that a rotary die is not the only apparatus capable of using the general methods disclosed herein to form products as disclosed. Although productivity will be sacrificed, other types of dies can be readily implemented to cut the shapes disclosed herein. Accordingly, it will be realized that the embodiments of the present invention depicted in the accompanying figures are meant to illustrate preferred embodiments of the present invention.

As used herein the term "absorbent product" is meant to apply to any product that is used to absorb and retain body fluids. Examples of such products are sanitary napkins and panty shields, infant diapers and adult incontinent diapers, and wound dressings.

Referring now to FIG. 1, there is shown a strip of material 50 from which an absorbent structure will be formed. The material 50 can be either hydrophilic or hydrophobic and may be chosen from any of the materials used to construct absorbent products. Thus, for example, if the resulting structure is itself used as an absorbent product, the material 50 could be an absorbent web of cellulosic fiber. If, however, the resultant product were to be integrated with other layers, the methods and apparatus disclosed herein would be useful to form a top sheet or other non-absorbent portion of the resulting absorbent product.



The sheet of material 50 is preferably fed in between a pair of counter-rotating rollers 100, 101. The top roller 100 is most preferably a rotary die and has one or more die segments 102 formed on its surface. The lower roller 101 typically acts as a platen and has a smooth surface, however, in certain embodiments cooperating die portions may also be formed on the lower roller 101. The rollers 100,101 are in close proximity and as the material 50 passes between them, it is cut in the shape of the die segments 102. For each cut, however, two portions of material are formed. As seen in FIG. 1, if the die segment 102 is substantially elliptical in shape, the material is cut into a series of elliptical portions 52 with a series of hyperbolic portions 54 between the elliptical portions 52. As used herein, geometric terms such as elliptical and hyperbolic are meant in the general sense and are not intended to be limited to the precise mathematical curves described by such terms. It should be noted that in the preferred embodiment illustrated in FIG. 1 a small gap 103 in the cutting edge of the die segment 102 results in a connecting portion 53 that connects one elliptical portion 52 to one hyperbolic portion 54. The two portions 52,54 may be joined by any conventional means, e.g., pressure, heat bonding, adhesives, hydrogen bonding, or may be loosely overlaid and retained together by another structure.

One aspect of the present invention illustrated in FIG. 1 is that as the material 50 is cut, there is essentially no waste material or selvage between the elliptical portions 52 and the hyperbolic portions 54. In other words, the area of the two portions 52,54 is approximately 100% of the area of the uncut material 50. The present invention takes advantage of this



5 result by choosing the relative size and shape of each
portion 52,54 such that they may be overlaid upon one
another to produce a useful absorbent article. The
specific example shown in FIG. 1 is an absorbent
structure suitable for placement in the perineal area
of a user when the material 50 from which it is formed
is an absorbent material. The "hourglass" shape of the
hyperbolic portion 54 permits comfortable placement
over substantially the entire area, while the overlying
10 ellipsoidal portion provides additional absorbency in
the area where fluid discharge is typically the
greatest.

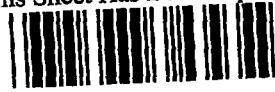
Referring now to FIG. 2, an embodiment of the
present invention similar to that shown in FIG. 1 is
15 illustrated that includes the addition of a powder to
the portions 52,54 of material 50 formed after cutting.
In the preferred embodiment illustrated, a powder
depositing device 110 such as a sprayer is positioned
above the array of cut portions 52,54. A powdered
20 material 55 is applied as shown to both the portions
52,54, preferably over an area of less than their full
width. When the portions 52,54 are brought together,
the powdered material 55 is substantially entrapped
between the layers of the portions 52,54. This
25 embodiment would therefore permit the addition of a
superabsorbent powder to increase the absorbency and
fluid retention characteristics of the resulting
absorbent structure. Alternatively, other powdered
materials such as antibiotics, disinfectants or
30 deodorizers may be added. Additionally, although
powdered materials represent a preferred embodiment, it
will be understood that non-powdered sprayable
materials including liquids, sols and gels may also be
applied in the manner shown in FIG. 2. Finally, the



spraying of the powdered material or other material may be undertaken in different patterns or performed intermittently. In the latter instance, it is possible to synchronize the intermittent spray with the movement of the portions 52,54 such that only selected ones of either the elliptical or the hyperbolic portions 52,54 are sprayed.

FIGS. 1-2 illustrate embodiments of the present invention wherein the elliptical portions 52 extend across the full width of the material such that their endpoints are located along the edges of the material 50. However, as shown in FIG. 3, embodiments of the present invention are also contemplated wherein the radius of curvature of the die segments 102 on the rotary die roller 101 is greater than that shown in FIGS. 1-2. As a result, the elliptical portions 152 cut in this embodiment do not come to a "point" but instead have square edges. As a result, the hyperbolic portions 154 of this embodiment also have a greater radius of curvature, i.e., they are less curved. However, as seen in FIG. 3, the portions 152,154 will again overlies each other without any waste and form a useful absorbent structure that is of double thickness in certain areas.

Another alternate embodiment of the present invention is illustrated in FIG. 4. In this embodiment, the design of the die segments 102' on the rotary die roller 101 are somewhat different from those shown in FIGS. 1-3 and described above. In this embodiment, an elliptical portion 102a' is provided at one end of a straight segment 102b'. As described above, a small gap 103' is left in the elliptical portion 102a'. Thus, as shown in FIG. 3, as the



material 50 moves beneath the rotary die roller 101
elliptical portions 252 of a relatively small radius of
curvature that do not extend across the entire width of
the material 50 are formed. A hyperbolic (and
5 partially rectangular) portion 254 remains between and
preferably connected to the elliptical portions 252.
By folding the elliptical portion 252 in the manner
illustrated to overlie the hyperbolic portion 254, an
absorbent structure results that has a double thickness
10 over a relatively small area. It will be recognized
that the products made using this embodiment of the
invention are made with no waste and, depending on
their size, would be particularly useful as either an
infant diaper or an incontinent adult diaper. The
15 double thickness portion of the structure is preferably
positioned to lie near the area of waste discharge when
worn. If desired the square portion may be adapted by
folding or further cut to be secured to the rest of the
structure and surround the hips of the wearer. Of
20 course, sanitary napkins, panty shields and other
absorbent products can be made in accordance with this
embodiment of the invention.

In addition to the hyperbolic/elliptic shapes
described above, new and useful improvements can be
25 made using the embodiment of the invention illustrated
in FIG. 5. As illustrated, in a preferred version of
this embodiment of the invention, two sets of identical
rollers 200,201 are arranged as a pair of rotary dies
that are each fed a length of material 50. The upper
30 roller 200 of each pair has at least one arcuate die
segment 202 formed on its surface. As a result, as
each of the two lengths of material 50 passes between
the sets of rollers 200,201, it is cut to form a
plurality of arcuate portions 260,260' as shown. Most



preferably, these arcuate portions 260,260' have parallel sides and extend across the full width of the material 50. By orienting the curvature of each of the arcuate portions 260,260' in opposite directions, i.e.,
5 turned 180°, when they are laid upon one another a substantially hyperbolic absorbent structure results that is similar to that formed using the embodiment illustrated in FIG. 1 in that an elliptic section of double thickness is centrally located.

10 The embodiment of the invention shown in FIG. 5 admits to many variations. For example, the two lengths of material 50 may be different types of material, or a powder or other form of another material may be sprayed on any part of the structure, as
15 illustrated, for example, in FIG. 2. it will be realized that it is also possible to create the structure shown in FIG. 5 using a substantially similar technique that includes only one rotary die 200,201. In such an embodiment, the alternate ones of the
20 arcuate shapes 260 cut from a single length of material 50 would be reversed relative to one another in a separate step to result in the ultimate orientation shown in FIG. 5.

25 Although certain embodiments of the present invention have been set forth herein with particularity, it will be realized by those of ordinary skill that numerous adaptations and modifications to the methods, apparatus and products disclosed herein are readily made. For example, dies other than the
30 rotary dies may be used to cut substantially similar shapes to result in products substantially similar to those illustrated. These embodiments, however, will not depart from the spirit of the inventive concepts

This Sheet Has Been Replaced



THIS SHEET HAS BEEN
REPLACED

PATENT - Docket No. PPC-450

disclosed herein. Accordingly, reference should be made to the appended claims in order to ascertain the full scope of the present invention.



What is claimed is:

1. A method of forming an absorbent structure comprising the steps of:
feeding a sheet of a material into a die;
cutting substantially ellipsoidal portions from the material at evenly spaced intervals, leaving substantially hyperbolic portions therebetween; and
placing at least one ellipsoidal portion atop at least one hyperbolic portion,
whereby substantially the entire sheet of material is used to form the absorbent structure.
2. The method of claim 1 wherein the material is of a predetermined width and the step of cutting the substantially ellipsoidal shape comprises cutting across the full width of the material.
3. The method of claim 1, wherein the step of feeding comprises feeding the material into a rotary die to continuously cut material.
4. The method of claim 1 further comprising the step of applying powder to the material.
5. The method of claim 4, wherein the step of applying powder to the material comprises applying powder to a surface of the ellipsoidal portion and a surface of the hyperbolic portion, and further comprises the step of placing said surfaces together to form an absorbent structure comprising a central layer of absorbent powder.
6. The method of claim 4, wherein the step of applying powder is carried out intermittently.

This Sheet Has Been Replaced



THIS SHEET HAS BEEN
REPLACED

PATENT - Docket No. PPC-450

7. The method of claim 1 wherein the material is of a predetermined width and the step of cutting the substantially ellipsoidal portions comprises cutting across less than the full width of the material.

8. A method of forming an absorbent structure comprising the steps of:

feeding a first sheet of material into a first die;
cutting an arcuate section from the material;
feeding a second sheet of material into a second

die;

cutting an arcuate section from the material;
placing at least one arcuate section atop another
arcuate section;

whereby a substantially ellipsoidally shaped overlapping section is formed.

9. The method of claim 8, wherein the steps of feeding the first and second sheets of material comprises the steps of feeding the material into a pair of rotary dies.

10. The method of claim 8 wherein the first and second sheets of material are of a predetermined width and the steps of cutting arcuate sections comprises cutting across the full width of the material.

11. The method of claim 8 further comprising the step of applying powder to the material.

12. A method of forming an absorbent structure comprising the steps of:

feeding a sheet of material into a die;
cutting at least two curved portions from the
material;
placing one of the curved portions atop the other,



whereby substantially the entire sheet of material is used with substantially no waste.

13. An absorbent product formed by the process of cutting substantially ellipsoidal portions from a sheet of material at evenly spaced intervals; and placing at least one of the ellipsoidal portions atop hyperbolic portions formed between ellipsoidal portions, whereby substantially the entire sheet of material is used with substantially no waste.

14. An absorbent product as claimed in claim 13 in the form of a sanitary napkin.

15. An absorbent product as claimed in claim 13 in the form of a panty shield.

16. An absorbent product as claimed in claim 13 in the form of a diaper.

17. An absorbent product comprising:
a hyperbolic-shaped layer of material; and
an ellipsoidal-shaped layer of material disposed atop the hyperbolic shaped layer,
wherein the hyperbolic and ellipsoidal layers are at least partially of substantially identical curvature.

18. An absorbent product comprising a first layer of material cut in a curved shape; and a second layer of material cut in a curved shape disposed atop the first, wherein the curved shape of the first and second layers is substantially identical and the layers are oriented 180° from one another.

19. The absorbent product of claim 18, wherein the curved shape comprises an arcuate segment.