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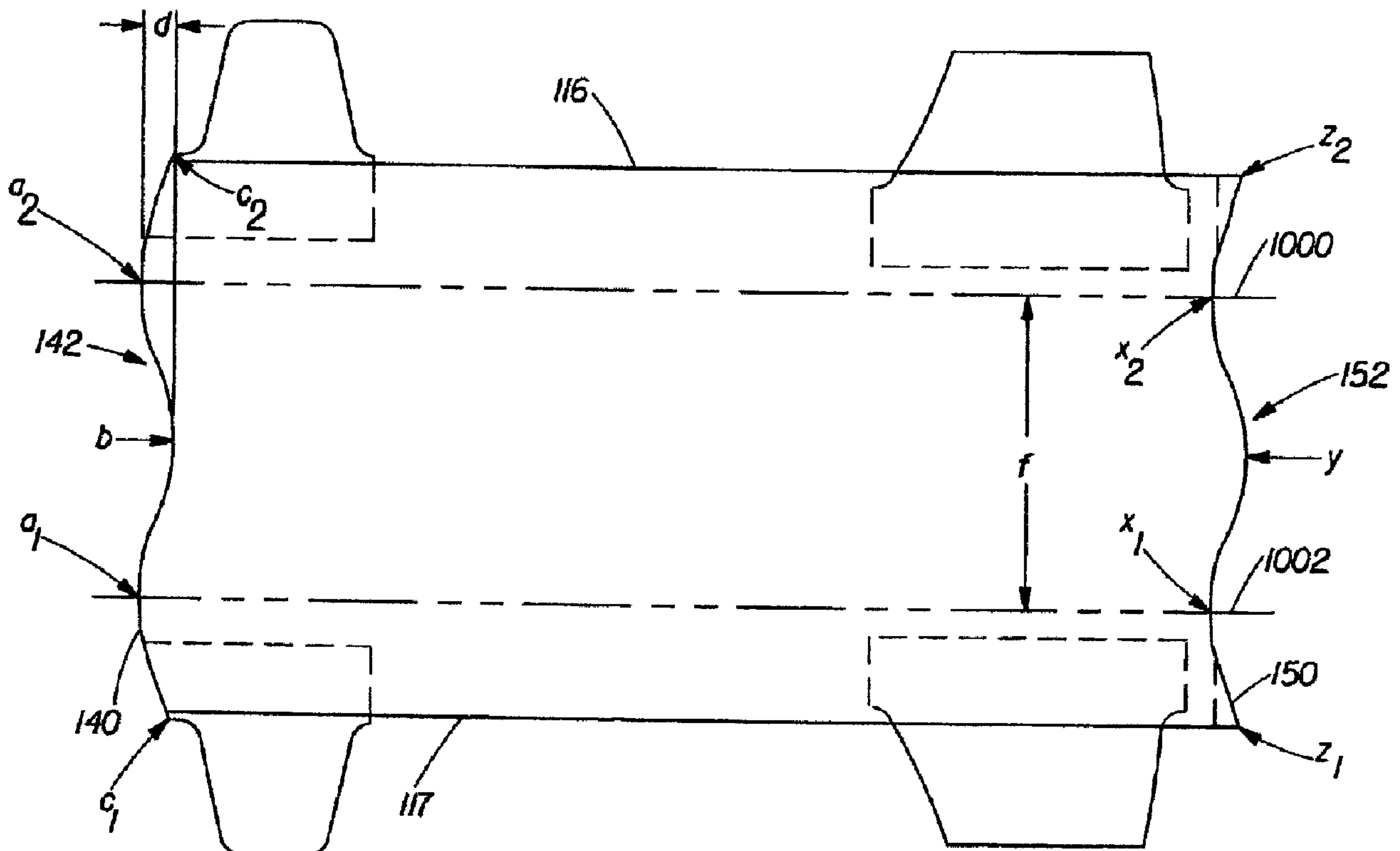
(72) Inventeurs/Inventors:
ERICKSON, GREGORY JOHN, US;
EDDY, JASON ROBERT, US;
FERRER, JOHN, US;
ROE, DONALD CARROLL, US

(73) Propriétaire/Owner:
THE PROCTER & GAMBLE COMPANY, US

(74) Agent: DIMOCK STRATTON LLP

(54) Titre : ARTICLE ABSORBANT PRESENTANT UNE DECOUPE DE CRAN OMBILICALE

(54) Title: ABSORBENT ARTICLE HAVING AN UMBILICAL NOTCH CUT



(57) Abrégé/Abstract:

A disposable absorbent article having a non-linear notch cut without the presence of a significantly laterally extending resulting piece. The resulting absorbent article having a front end edge and a back end edge which are complementary. The front end edge having at least three tangential points (a1, a2, b). Tangential point b is longitudinally inboard of a1 and a2. The back end edge

(57) **Abrégé(suite)/Abstract(continued):**

having at least three tangential points (x1, x2, y), wherein y is longitudinally outboard of x1 and x2. The absorbent article being longitudinally folded about a first fold line. The first fold line may be drawn between points a2 and x2. The absorbent article being longitudinally folded about a second fold line, said second fold line may be drawn between points a1 and x1.

Abstract

A disposable absorbent article having a non-linear notch cut without the presence of a significantly laterally extending resulting piece. The resulting absorbent article having a front end edge and a back end edge which are complementary. The front end edge having at least three tangential points (a1, a2, b). Tangential point b is longitudinally inboard of a1 and a2. The back end edge having at least three tangential points (x1, x2, y), wherein y is longitudinally outboard of x1 and x2. The absorbent article being longitudinally folded about a first fold line. The first fold line may be drawn between points a2 and x2. The absorbent article being longitudinally folded about a second fold line, said second fold line may be drawn between points a1 and x1.

ABSORBENT ARTICLE HAVING AN UMBILICAL NOTCH CUT

FIELD OF THE INVENTION

This invention relates to absorbent articles which are particularly adapted to newborn infants. More specifically, this invention relates to diapers having a U-notched cut without the presence of a significantly laterally extending resulting piece that may create a safety risk.

BACKGROUND OF THE INVENTION

Newborn infants are exceptionally prone to inflammation, infection and colonization of bacteria at the umbilicus as the residual, freshly cut umbilical cord offers an inviting site for bacterial invasion and frictional irritation by the overlying diaper. The rubbing movement of the conventional diaper on an umbilicus which is still raw, as the infant squirms, kicks and moves, often produces a sore place which causes the infant to be quite fretful. The umbilical area is noticeably reddish and inflamed. Also, the overlying diaper can serve as a carrier of bacteria to the unhealed, cut cord and bring about an infection.

Due to the aforementioned reasons, conventional diapers which are particularly adapted for newborns are often constructed with an opening that is located centrally along the width of the end edge of the front panel of the diaper. Said opening is commonly referred to as a U-notch, V-notch or non-linear notch. In the creation of said non-linear notch, a non-linear cutting device is used. More specifically, individual diapers are often made from a plurality of continuous web materials that are subsequently cut into discrete articles (i.e., diapers). During said conventional non-linear notch cuts, however, the diaper often has a significantly laterally extending resulting piece that may create a safety risk. What is needed is a diaper/cut design and process that provides a non-linear notch cut without the presence of a significantly laterally extending resulting piece.

SUMMARY OF THE INVENTION

A disposable absorbent article having a longitudinal axis and a lateral axis. The absorbent article further having a front end edge and a back end edge which are

complementary in shape and are formed by a non-linear notch cut; said front end edge having at least three tangential points (a_1 , a_2 , b). Tangential point b is longitudinally inboard of a_1 and a_2 . The front end edge having at least two edge points (c_1 , c_2), wherein:

- (i) c_1 and c_2 are longitudinally inboard of a_1 and a_2 , and
- (ii) c_1 and c_2 are longitudinally equal or outboard of b .

The front end edge having a contour segment from said point a_1 to said point c_1 which is a mirror image of a contour segment from said point a_1 to said point b . The said front end edge having a path length measured along said contour segment from point a_1 to point c_1 which is less than or equal to the path length measured along said contour segment from point a_1 to point b .

The back end edge having at least three tangential points (x_1 , x_2 , y), wherein y is longitudinally outboard of x_1 and x_2 . The said back end edge having at least two edge points (z_1 , z_2), wherein:

- (i) z_1 and z_2 are longitudinally outboard of x_1 and x_2 , and
- (ii) z_1 and z_2 are longitudinally equal or inboard of y .

The back end edge has a contour segment from said point x_1 to said point z_1 which is a mirror image of a contour segment from said point x_1 to said point y . The back end edge has a path length measured along said contour segment from point x_1 to point z_1 which is less than or equal to the path length measured along said contour segment from point x_1 to point y .

The absorbent article being longitudinally folded about a first fold line. The first fold line may be drawn between points a_2 and x_2 . The absorbent article being longitudinally folded about a second fold line, said second fold line may be drawn between points a_1 and x_1 .

Further, the absorbent article may have a longitudinal distance, d , which is measured between said tangential point b and said tangential point a_1 , wherein the longitudinal distance being from about 5 mm to about 25 mm, preferably 10 mm.

Further, the absorbent article may have a lateral distance, f , which is measured between said fold lines, wherein the lateral distance being from about 80 mm to about 100 mm, preferably 90 mm.

Further, the disposable absorbent article may be constructed as an open diaper or pant.

BRIEF DESCRIPTION OF THE DRAWINGS

While the specification concludes with claims particularly pointing out and distinctly claiming the subject matter that is regarded as the present invention, it is
5 believed that the invention will be more fully understood from the following description taken in conjunction with the accompanying drawings. None of the drawings are necessarily to scale.

FIG. 1 is a schematic, top view of continuous webs of materials having ears joined thereto, said webs being converted for the ultimate manufacturing of discrete absorbent
10 articles in accordance with the present invention;

FIG. 2 is a schematic, top view of the webs from FIG. 1 with folding lines being depicted;

FIG. 3 is a schematic, top view of the webs from FIG. 2 with a first portion being longitudinally folded about a first fold line;

15 FIG. 4 is a schematic, top view of the webs from FIG. 3 with a second portion being longitudinally folded about a second fold line;

FIG. 5 is a schematic, top view of the webs from FIG. 4 with non-linear cut-lines shown;

20 FIG. 6 is a schematic, top view of the webs from FIG. 5 being separated into individual absorbent articles;

FIG. 7 is a close-up of the encircled region of FIG. 6;

FIG. 8 is a schematic, top view of an absorbent article from FIG. 6 being unfolded;
and

25 FIG. 9 is a schematic, top view of the absorbent article from FIG. 8 showing critical dimensions in accordance with the present invention.

DETAILED DESCRIPTION OF THE INVENTION

Definitions:

The term "absorbent article" herein refers to devices which absorb and contain body exudates and, more specifically, refers to devices which are placed against or in proximity to the body of the wearer to absorb and contain the various exudates discharged from the body, such as: incontinence briefs, incontinence undergarments, absorbent inserts, diaper holders and liners, feminine hygiene garments and the like. Said absorbent article may have an absorbent core having a garment surface and a body surface; a liquid permeable topsheet positioned adjacent said body surface of said absorbent core; and a liquid impermeable backsheets positioned adjacent said garment surface of said absorbent core.

The term "disposable" is used herein to describe absorbent articles which generally are not intended to be laundered or otherwise restored or reused as absorbent articles (i.e., they are intended to be discarded after a single use and, preferably, to be recycled, composted or otherwise discarded in an environmentally compatible manner).

The term "diaper" herein refers to an absorbent article generally worn by infants and incontinent persons about the lower torso.

The term "pant", as used herein, refers to disposable garments having a waist opening and leg openings designed for infant or adult wearers. A pant may be placed in position on the wearer by inserting the wearer's legs into the leg openings and sliding the pant into position about the wearer's lower torso. A pant may be preformed by any suitable technique including, but not limited to, joining together portions of the article using refastenable and/or non-refastenable bonds (e.g., seam, weld, adhesive, cohesive bond, fastener, etc.). A pant may be preformed anywhere along the circumference of the article (e.g., side fastened, front waist fastened). While the term "pant" is used herein, pants are also commonly referred to as "closed diapers", "prefastened diapers", "pull-on diapers", "training pants" and "diaper-pants". Suitable pants are disclosed in U.S. Patent No. 5,246,433, issued to Hase, et al. on September 21, 1993; U.S. Patent No. 5,569,234, issued to Buell et al. on October 29, 1996; U.S. Patent No. 6,120,487, issued to Ashtora on September 19, 2000; U.S. Patent No. 6,120,489, issued to Johnson et al. on September 19, 2000; U.S. Patent No. 4,940,464, issued to Van Gompel et al. on July 10, 1990; U.S.

Patent No. 5,092,861, issued to Nomura et al. on March 3, 1992; U.S. Patent Application Publication No. 2003/0233082, entitled "Highly Flexible And Low Deformation Fastening Device", filed on June 13, 2002; U.S. Patent No. 5,897,545, issued to Kline et al. on April 27, 1999; U.S. Patent No. 5,957,908, issued to Kline et al on September 28, 1999. The term "machine direction (MD)" or "longitudinal" herein refers to a direction running parallel to the maximum linear dimension of the article and/or fastening material and includes directions within $\pm 45^\circ$ of the longitudinal direction.

The term "cross direction (CD)", "lateral" or "transverse" herein refers to a direction which is orthogonal to the longitudinal direction. The term "joined" encompasses configurations whereby an element is directly secured to another element by affixing the element directly to the other element, and configurations whereby an element is indirectly secured to another element by affixing the element to intermediate member(s) which in turn are affixed to the other element.

Description:

While absorbent articles are typically sold to the consumer as discrete articles packaged together, said absorbent articles are frequently manufactured from at least two continuous webs of materials. For example, FIG. 1 shows two exemplary continuous webs of materials, namely, a backsheet 13 and a topsheet 15. Said webs are unrolled and then sent through several unit operations (also known as converting). During such converting, discrete parts may be placed and joined to one or more of said webs. For instance, a first front ear 120 and a second front ear 122 may be joined interposed between backsheet 13 and topsheet 15. Said front ears will subsequently serve as attachment means during application of said absorbent article. Similarly, a first back ear 130 and a second back ear 132 may be joined to backsheet 15. Said back ears work in conjunction with said front ears to serve as attachment means during application of said absorbent article. One skilled in the art would appreciate that said ears may be joined to either or both webs in any combination and placement order. As can be seen in Fig. 1, at this stage (i.e., prior to longitudinal folding) a first longitudinal edge 116 and a second longitudinal edge 117 of said continuous web material 15 are currently positioned most longitudinally outboard from the longitudinal centerline 888. Within the region identified

as absorbent article 200, a first front ear 220 and a second front ear 222 may be similarly joined. Likewise, a first back ear 230 and a second back ear 232 may be similarly joined. Lastly, a first longitudinal edge 216 and a second longitudinal edge 217 of said continuous web material 15 are currently positioned most longitudinally outboard from the longitudinal centerline 888. Within the region identified as absorbent article 300, a first front ear 320 and a second front ear 322 may be similarly joined. Likewise, a first back ear 330 and a second back ear 332 may be similarly joined. Lastly, a first longitudinal edge 316 and a second longitudinal edge 317 of said continuous web material are currently positioned longitudinally outboard from the longitudinal centerline 888.

Once the ears are joined, said webs are folded along at least two longitudinally extending axes 1000, 1002 in directions as indicated by arrows 1010 and 1012, respectively. FIG. 2 shows said fold lines 1000 and 1002 being located longitudinally outboard of the longitudinal centerline 888 and longitudinally inboard of said first and second longitudinal edges. Said longitudinal centerline 888 extends in the MD direction.

FIG. 3 shows the webs 13, 15 of FIG. 2 being folded about the first longitudinally extending axis 1000 in a direction as indicated by arrow 1010. After being folded, the first longitudinal edges 116, 216, 316 are moved longitudinally inboard. Further, a first fold edge 118 is formed within the region identified as absorbent article 100. Similarly, first fold edges 218 and 318 are formed within regions 200 and 300, respectively.

FIG. 4 shows the webs 13, 15 of FIG. 3 being folded about the second longitudinally extending axis 1002 in a direction as indicated by arrow 1012. After being folded, the second longitudinal edges 117, 217, 317 are moved longitudinally inboard. Further, a second fold edge 119 is formed within the region identified as absorbent article 100. Similarly, second fold edges 219 and 319 are formed within regions 200 and 300, respectively.

FIG. 5 shows the webs 13, 15 of FIG. 4 being cut along cut-lines 2000. Said cut-lines 2000 may be non-linear across the longitudinal axis of said webs. The geometrical criticalities of said cut-lines 2000 will be discussed later. Said cut-lines may be a 100% severing of said webs or a less than 100% perforation of said webs. Said cut-lines may be created by any suitable technique including, but not limited to, rotary knife blade, reciprocating knife blade, air knife and laser.

FIG. 6 shows the cut webs 13, 15 of FIG. 5 being separated into discrete absorbent articles 100, 200, 300. Once separated, said discrete absorbent articles have complementary front and back end edges. For example, absorbent article 100 has a front end edge 140 and a back end edge 150. The geometries of said edges complement one another. More specifically, front end edge 140 has a U-notched portion 142 so as to provide physical clearance to the naval of the newborn wearer, while said back end edge 150 has a U-shaped protruding section 152 which positions itself up the backside of the wearer. The geometries of said edges must be complementary otherwise a scrap piece requiring removal during processing would result. FIG. 7 shows a close-up view of a region within FIG. 6 so as to provide a more detailed view of the folded and cut portion along back end edge 150.

FIG. 8 shows absorbent article 100 of FIG. 6 being unfolded similar to that of the unfolding performed by a consumer after removing said article from its packaging. In this unfolded state, first longitudinal edge 116 and second longitudinal edge 117 are now most longitudinally outboard. Along the back end edge 150, a laterally extending piece of material 199 is formed and shaped as a result of the prior fold and U-notch cut. In this exemplary novel embodiment, said laterally extending piece of material 199 is not aesthetically displeasing nor does it present a safety concern as discussed above. So long as the u-notch cut conforms to criticalities depicted in FIG. 9, the resulting extending piece 199 will not present such a safety concern.

FIG. 9 shows the unfolded absorbent article of FIG. 8 with the various critical dimensions highlighted. For example, front end edge 140 has at least three tangential points identified as a_1 , a_2 , and b , wherein b is longitudinally inboard of a_1 and a_2 . Further, front end edge 140 has at least two edge points identified as c_1 and c_2 , wherein (i) c_1 and c_2 are longitudinally inboard of a_1 and a_2 and (ii) c_1 and c_2 are longitudinally equal or outboard of b . Additionally, contour segment a-c (measured along the contour of end edge 140 between point a and point c) is a mirror image of contour segment a-b [measured along the contour of front end edge 140 between point a and point b]. Lastly, path length of contour segment a-c is less than or equal to the path length of contour segment a-b. As it relates to the complementary cut of back end edge 150, back end edge 150 has at least three tangential points identified as x_1 , x_2 and y , wherein y is

longitudinally outboard of x_1 and x_2 . Further, back end edge 150 has at least two edge points identified as z_1 and z_2 , wherein (i) z_1 and z_2 are longitudinally outboard of x_1 and x_2 and (ii) z_1 and z_2 longitudinally equal or inboard of y . Additionally, contour segment x - z (measured along the contour of back end edge 150 between point x and point z) is a mirror image to contour segment x - y [measured along the contour of back end edge 150 between point x and point y]. Lastly, path length of contour segment x - z is less than or equal to the path length of contour segment x - y . Finally, fold line 1000 may be drawn between points a_2 and x_2 and fold line 1002 may be drawn between points a_1 and x_1 .

While the present invention may be appreciated as long as the above geometrical criticalities are met, it may be desirable to design a disposable diaper to have a longitudinal distance, d , between tangential point b and tangential points a_1 , a_2 range from about 5 mm to about 25 mm, preferably 10mm. Further, it may be desirable to have a lateral distance, f , between said fold lines range from about 80 mm to about 100 mm, preferably 90 mm.

All documents cited in the Detailed Description of the Invention are, not to be construed as an admission that it is prior art with respect to the present invention.

While particular embodiments of the present invention have been illustrated and described, it would be obvious to those skilled in the art that various other changes and modifications can be made without departing from the spirit and scope of the invention. It is therefore intended to cover in the appended claims all such changes and modifications that are within the scope of this invention.

For example, one skilled in the art would appreciate that the present invention may be practiced with absorbent articles having a variety of type of fasteners. Further, the absorbent article may be an open diaper or a pant.

For example, the front ears may be moved longitudinally inboard so as not to be severed during the U-notch cut, unlike that shown the exemplary embodiment of FIGS. 5-9 wherein a portion of the front ears is severed and left sandwiched between the material layers of the preceding diaper.

CLAIMS:

1. A method of making disposable wearable absorbent articles comprising:
providing a continuous web of liquid impermeable backsheet material; and
cutting across the continuous web of backsheet material with non-linear cuts to form backsheets for individual disposable wearable absorbent articles, wherein each of the non-linear cuts forms a front end edge configured to fit a navel of a wearer, the front end edge includes an umbilical notch disposed in a laterally central portion of the front end edge, each of the non-linear cuts also forms a back end edge, the back end edge includes a protruding section disposed in a laterally central portion of the back end edge, and the front end edge is complementary in shape with the back end edge.
2. The method of claim 1, wherein the cutting includes cutting the continuous web of backsheet material with non-linear cuts wherein each of the non-linear cuts forms the front end edge that includes a U-shaped umbilical notch.
3. The method of claim 1, wherein the cutting includes non-linear cuts that completely sever the continuous web of backsheet material.
4. The method of claim 1, including providing a continuous web of liquid permeable topsheet material wherein the cutting includes cutting the continuous web of topsheet material to form topsheets for individual disposable wearable absorbent articles, wherein the topsheets and the backsheets together form the front end edges of the articles.
5. The method of claim 1, including providing a continuous web of liquid permeable topsheet material wherein the cutting includes cutting the continuous web of topsheet material to form topsheets for individual disposable wearable absorbent articles, wherein the topsheets and the backsheets together form the back end edges of the articles.
6. The method of claim 1, including folding the web of backsheet material along a first longitudinal fold line, which is parallel to a longitudinal centerline of the articles, wherein the folding along the first longitudinal fold line is before the cutting.

7. The method of claim 6, including folding the web of backsheet material along a second longitudinal fold line, which is parallel to a longitudinal centerline of the articles, wherein the folding along the second longitudinal fold line is before the cutting.

8. A method of making disposable wearable absorbent articles comprising:

providing a continuous web of liquid impermeable backsheet material; and

cutting the continuous web of backsheet material with non-linear cuts to form backsheets for individual disposable wearable absorbent articles, wherein each of the non-linear cuts forms a front end edge configured to fit a navel of a wearer, the front end edge includes an umbilical notch disposed in a laterally central portion of the front end edge, and the cutting produces no scrap pieces of the backsheet material.

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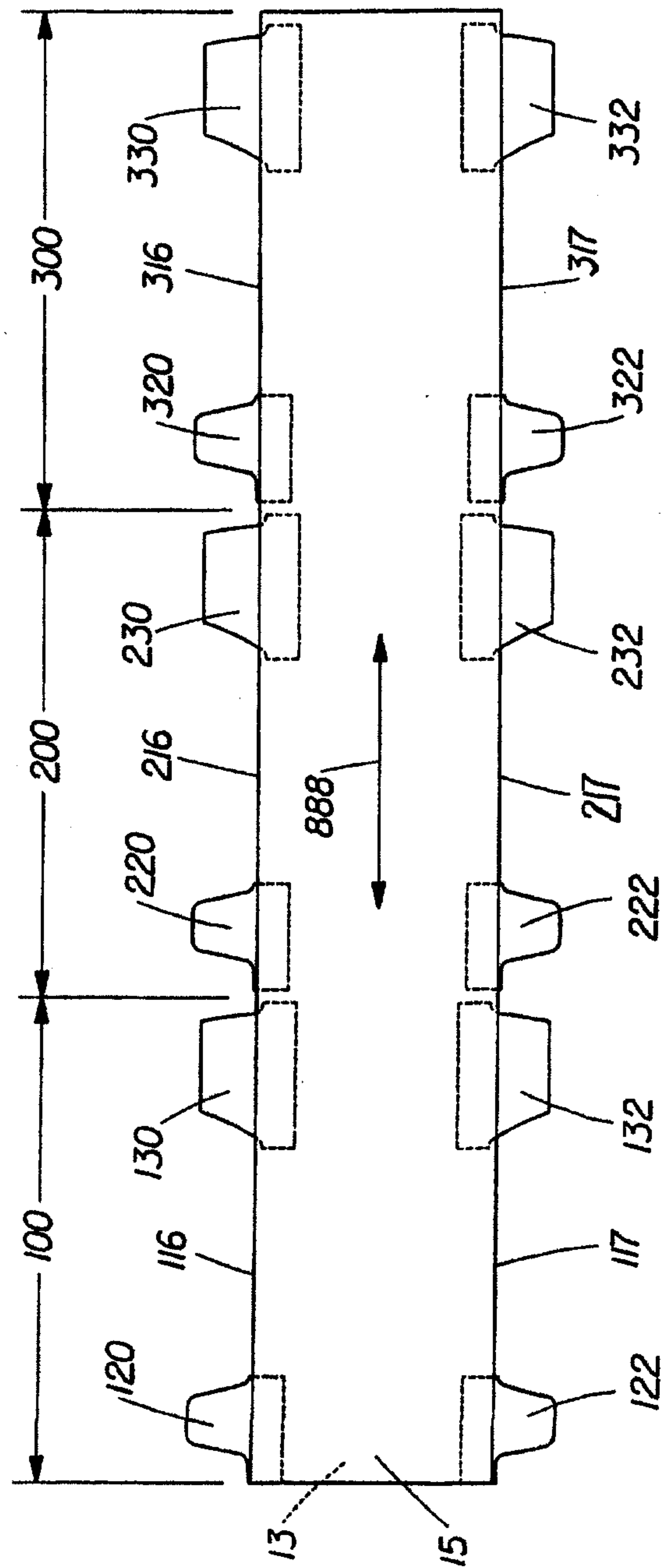


Fig. 1

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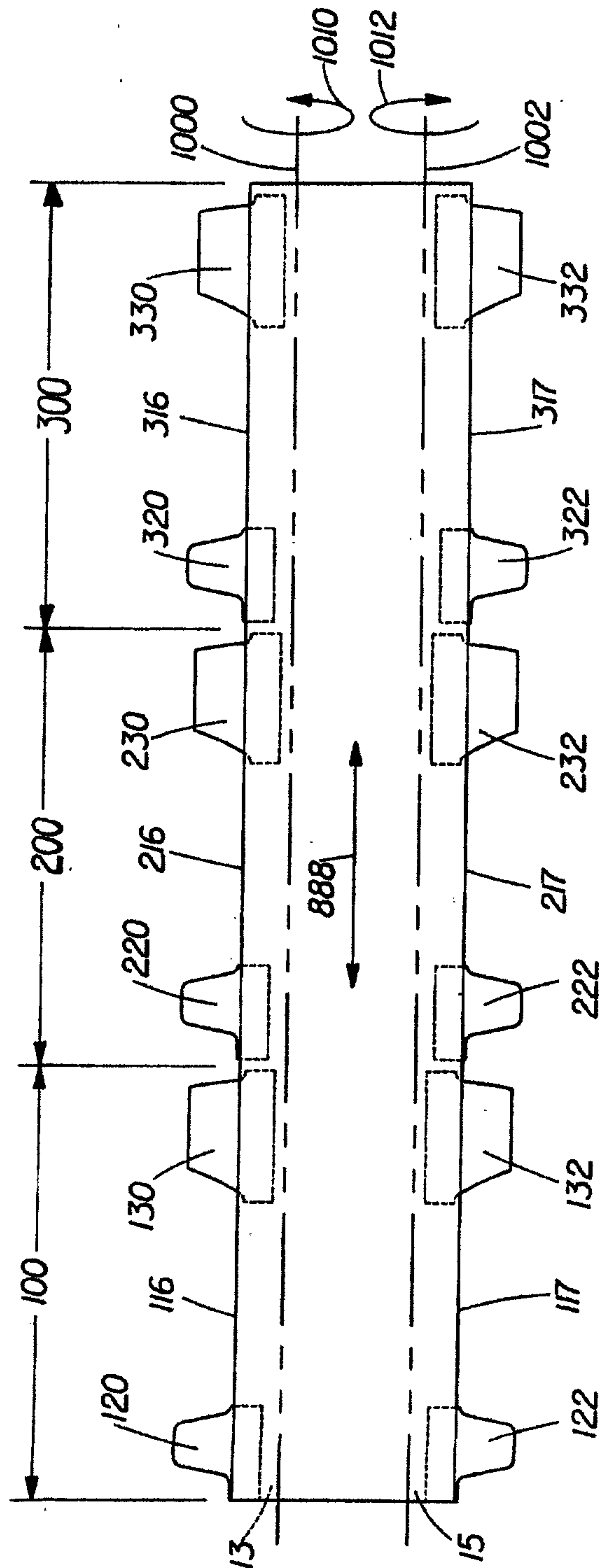


Fig. 2

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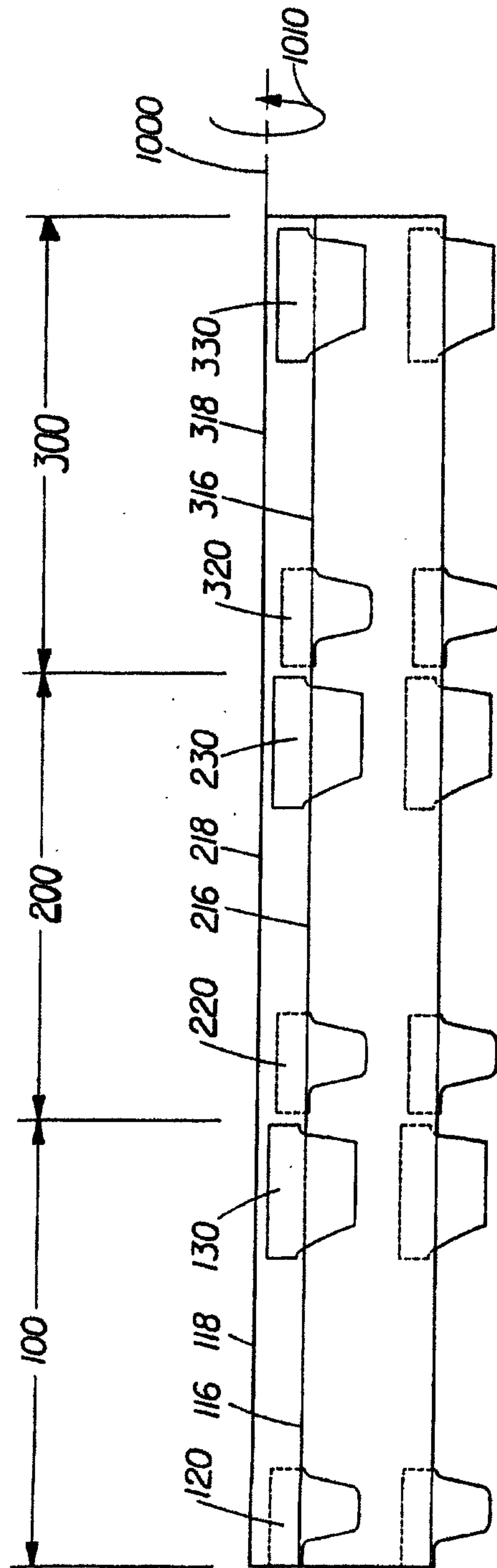


Fig. 3

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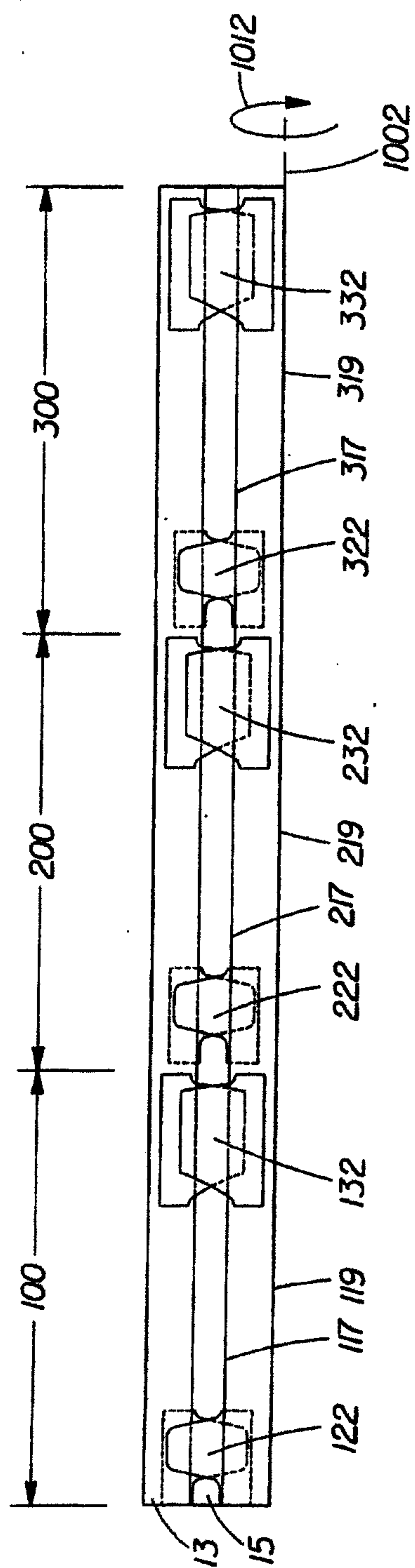


Fig. 4

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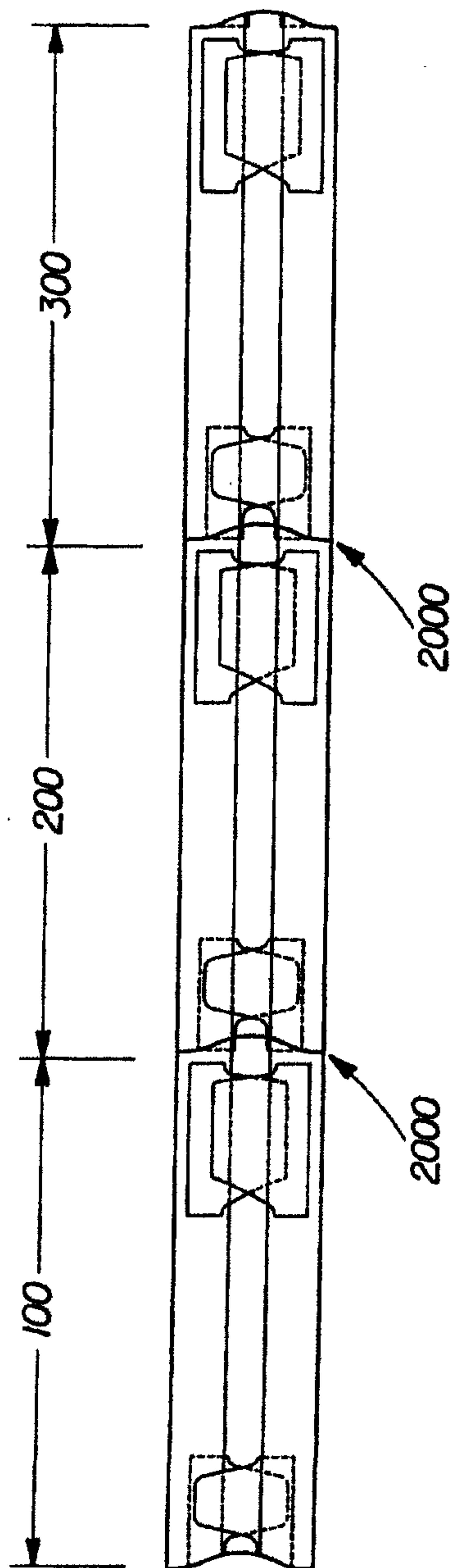


Fig. 5

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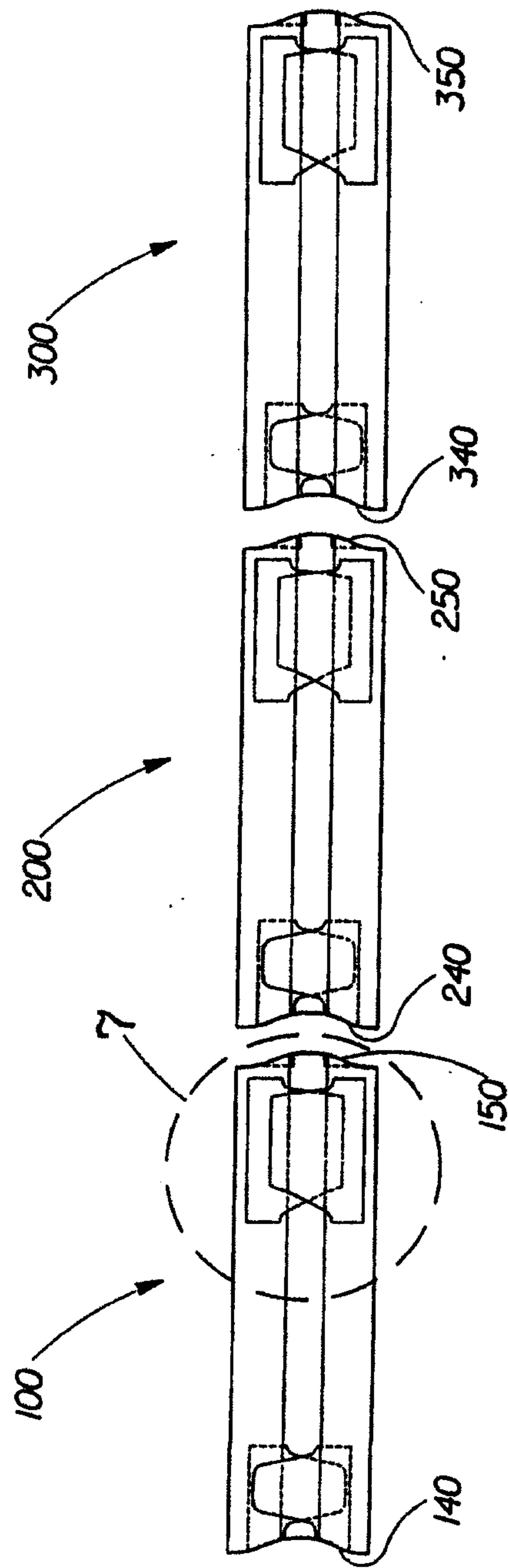


Fig. 6

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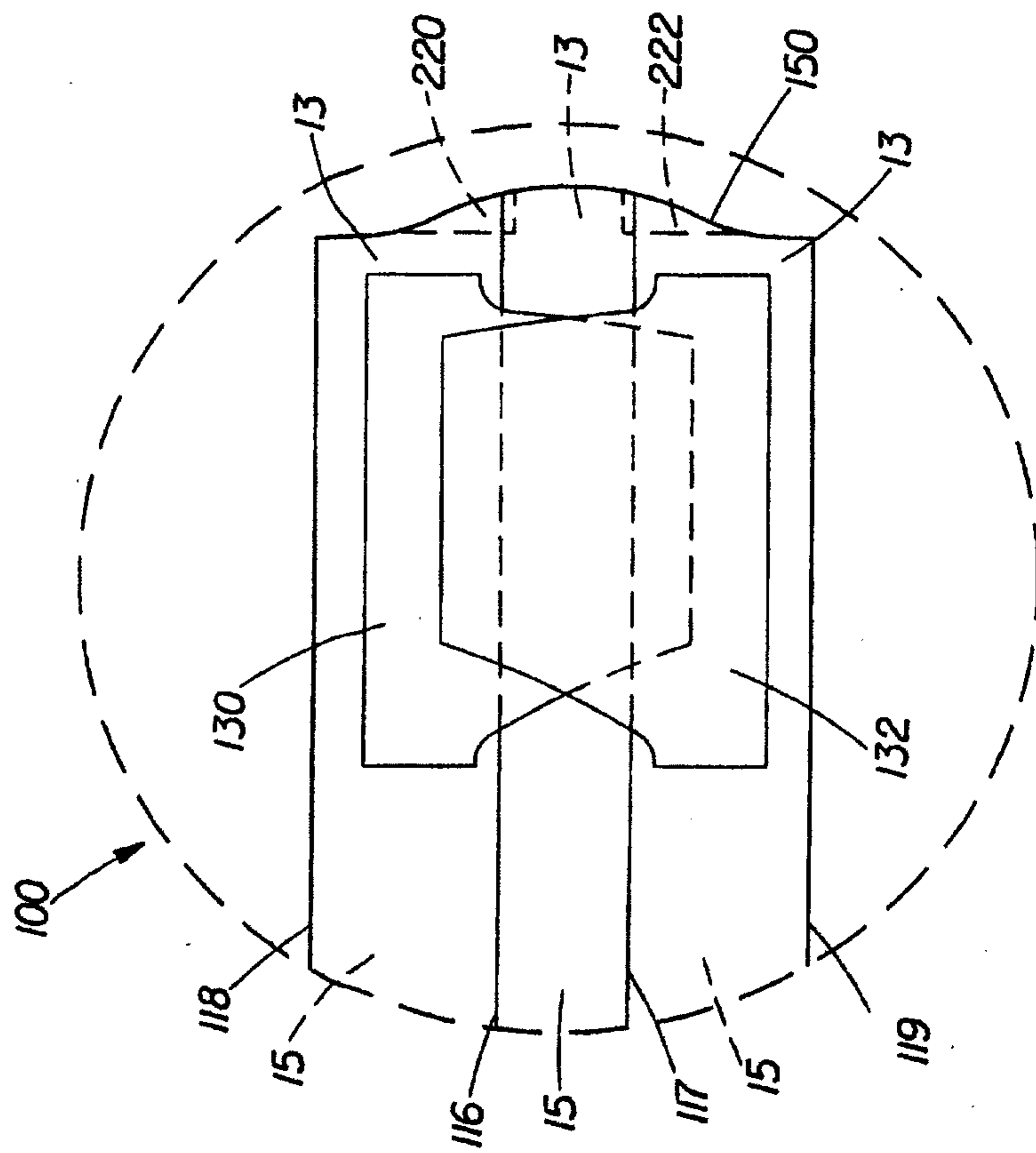


Fig. 7

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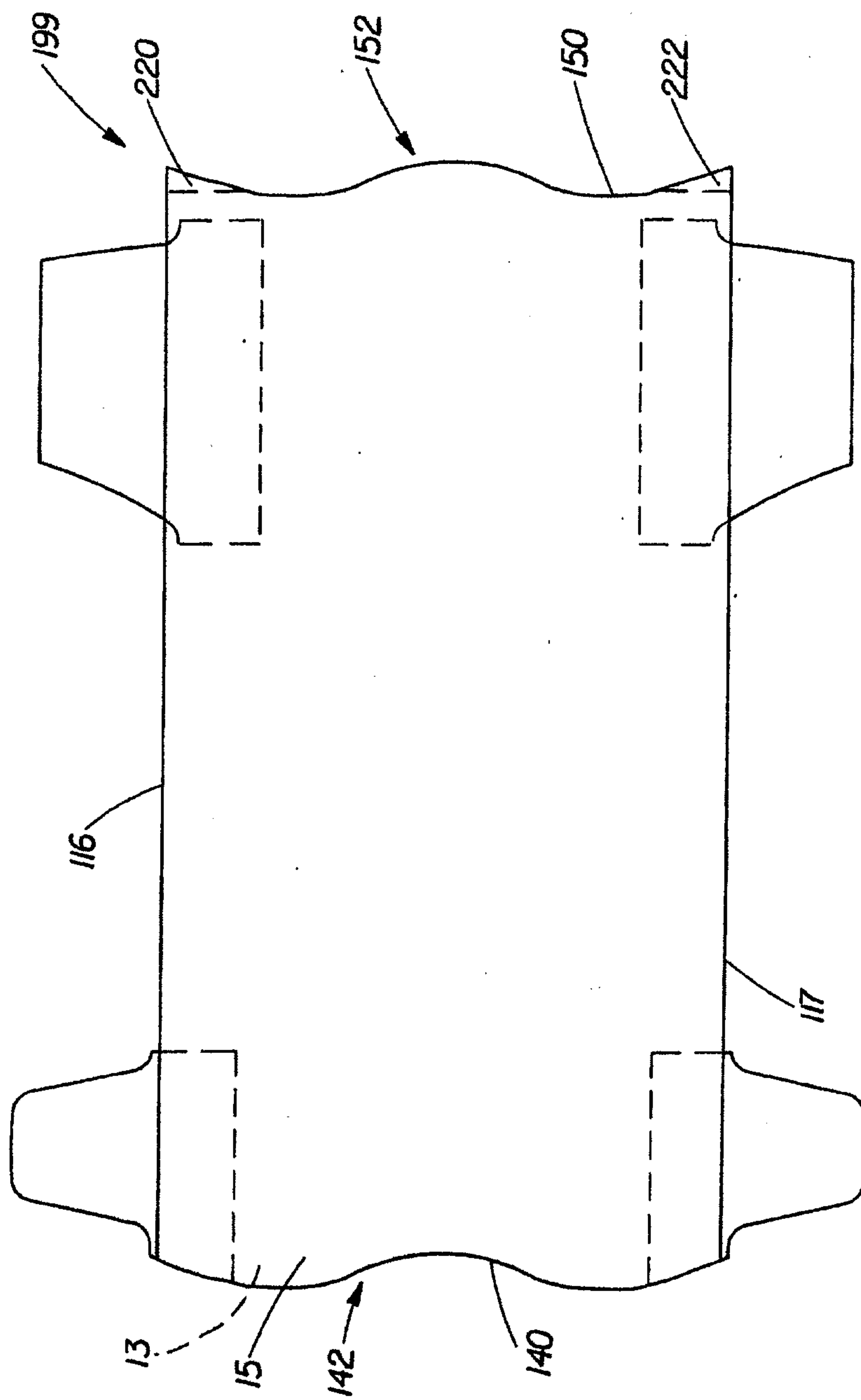
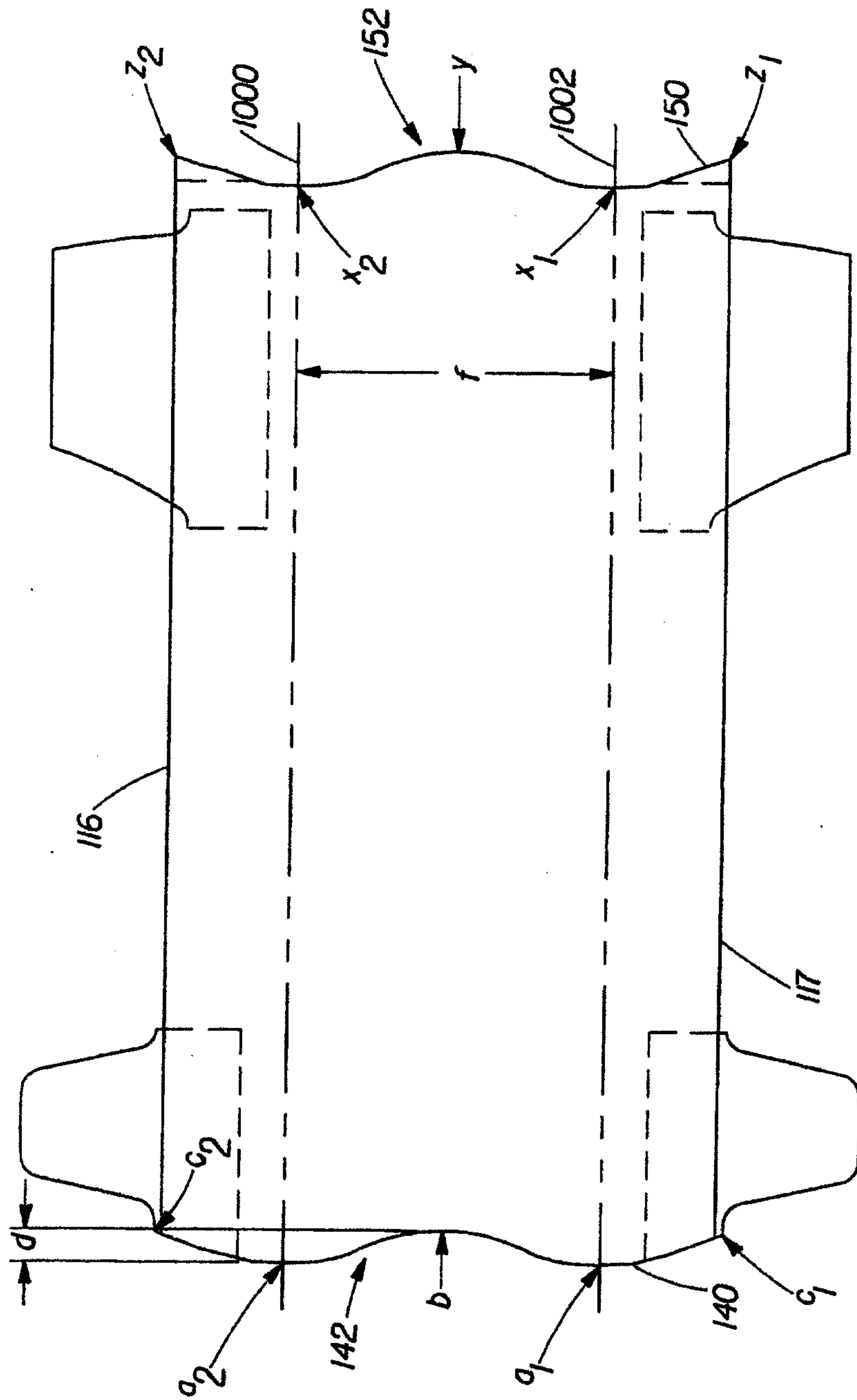


Fig. 8



9
a.
i.
E.

