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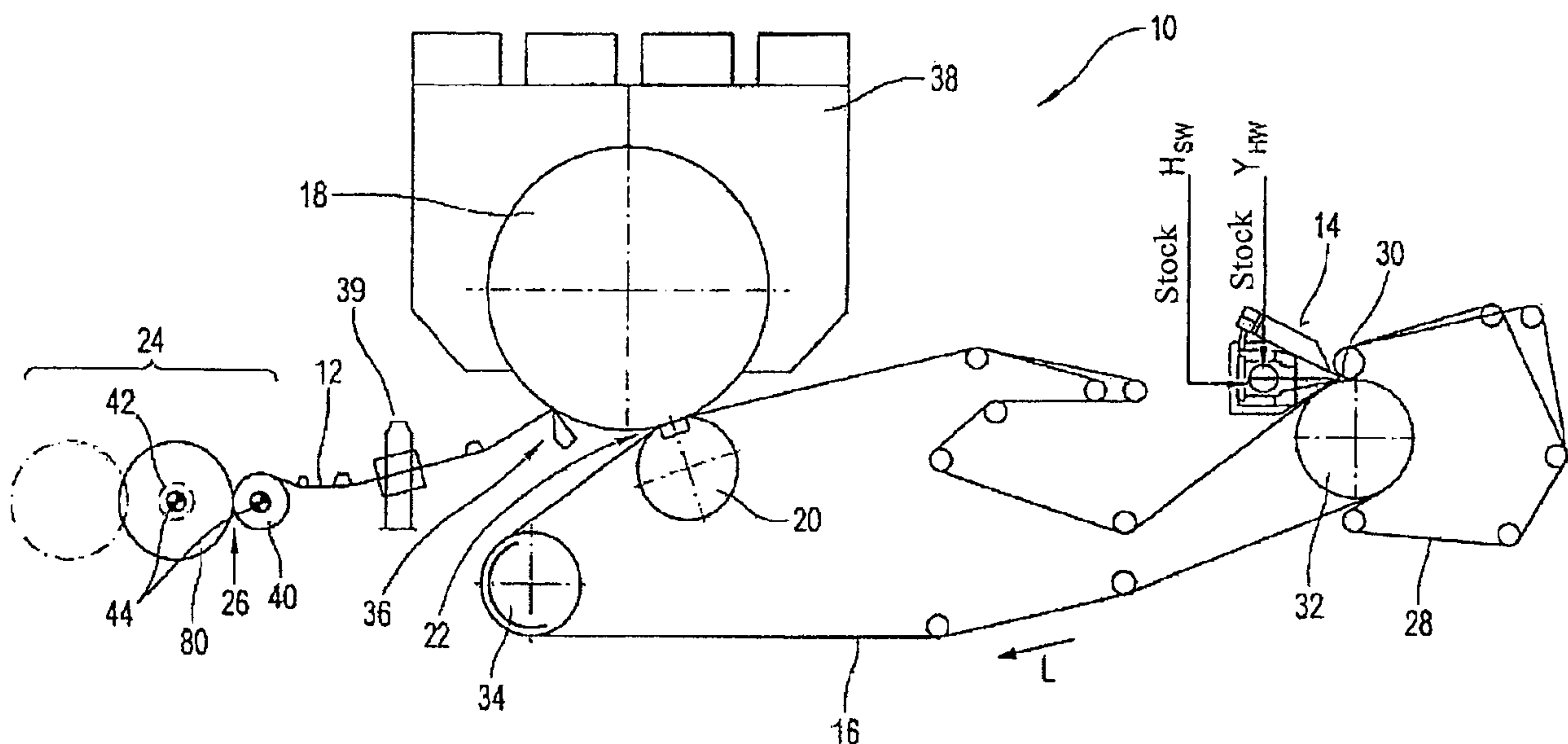
(72) Inventeur/Inventor:
THOROE SCHERB, THOMAS, BR

(73) Propriétaire/Owner:
VOITH PATENT GMBH, DE

(74) Agent: SIM & MCBURNEY

(54) Titre : PROCEDE DE PRODUCTION D'UNE BANDE DE PAPIER

(54) Title: METHOD FOR THE PRODUCTION OF A WEB OF TISSUE MATERIAL



(57) **Abrégé/Abstract:**

The invention relates to a machine for the production of a web of tissue material (12) comprising a material wind-on element or flow box (14) and an endless carrier belt (16) which is used to guide the web of tissue material (12) through a press gap (23) formed between a drying cylinder (18) and a counter unit (20), wherein said material wind-on element is a multilayered element with at least two different types of material being fed thereto. At the connection with the press gap, the web of tissue material is wound on by means of a winding device (24). Preferably, the hardness of the roll (80) thus formed is influenced in a predefined manner, being controlled and/or regulated in particular. The invention also relates to a corresponding tissue machine.

Abstract of the Disclosure

The invention relates to a machine for the production of a web of tissue material (12) comprising a material wind-on element or flow box (14) and an endless carrier belt (16) which is used to guide the web of tissue material (12) through a press gap (23) formed between a drying cylinder (18) and a counter unit (20), wherein said material wind-on element is a multilayered element with at least two different types of material being fed thereto. At the connection with the press gap, the web of tissue material is wound on by means of a winding device (24). Preferably, the hardness of the roll (80) thus formed is influenced in a predefined manner, being controlled and/or regulated in particular. The invention also relates to a corresponding tissue machine.

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Method for the production of a web of tissue material

This application is a division of co-pending Canadian Patent Application No. 2,483,818 filed March 20, 2003.

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The invention relates to a method for the production of a web of tissue material. This can be, in particular, such tissue grades as, for example, "toilet tissue", "facial tissue", serviette paper and/or and the like. Furthermore, the invention relates to a tissue

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machine for carrying out the method.

In particular in the case of the aforementioned tissue grades, what is important, inter alia, is the specific volume ("bulk", measured in cm^3/g), which should be as high as possible, and what is known

15 as the "hand feel", which is a measure of how pleasant the tissue, for example facial tissue, feels when gripped. Since this measure depends on the subjective sense of the user, there is no objective measurement method. Characteristics such as softness, velvetiness, flat surface topography (as opposed to roughly creped and/or

20 embossed surfaces) benefit a high measure of "hand feel". A "hand feel" value is determined as the result of the subjective assessment of a large number of test people.

25

Of course, a certain minimum strength, which suits the requirements of the user, is also important for such a tissue product.

A number of concepts of tissue machines have already been proposed, which generally have the object of improving the tissue characteristics.

30

The present invention is directed towards the provision of an improved tissue machine of the type mentioned at the beginning with which a tissue product or tissue paper, in particular "toilet tissue" and "facial tissue" with a particularly high "hand feel"

35 and high specific volume (bulk) with acceptable strength is ensured. In the case of a "facial tissue" with a mass per unit area

(grammage) of, for example, 15 g/m², the aim is a specific volume (bulk) of 10 cm³/g and higher, and in the case of a mass per unit area (grammage) of 23 g/m², a specific volume (bulk) of 9.0 cm³/g and higher. In addition, the relevant tissue machine should be as simple as possible in construction and economical. At the same time, as may different product grades as possible should be capable of production on this machine.

10 According to an aspect of the invention, there is provided a method for the production of a web of tissue material by means of a tissue machine comprising a flow box and an endless supporting belt, with which the tissue web is led through a press nip formed between a drying cylinder and an opposing unit, the flow box used being a
15 multilayer flow box, at least two stock grades being supplied to this multilayer flow box, and the tissue web being wound up by means of a reel-up after the press nip, the hardness of the reel produced preferably being influenced in a predefinable way, in particular controlled and/or regulated. This aspect of the
20 invention is claimed in the parent CA 2,483,818.

In this case, the drying cylinder used is preferably a Yankee cylinder.

25 The line force produced in the winding nip is expediently selected to be less than or equal to 0.8 kN/m.

According to a preferred practical configuration of the method according to the invention, use is made of a former having two
30 circulating endless belts, which run together, forming a stock inlet gap, and are then guided over a forming element, such as in particular a forming roll, the inner belt that comes into contact with the forming element preferably forming the transport belt. Use is preferably made of a crescent former, whose inner belt is formed
35 by a felt.

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It is also particularly advantageous if the tissue web, together with the supporting belt, is led through at least one shoe press. In this case, the opposing unit
5 assigned to the drying cylinder that is used is expediently a shoe press unit.

A high-temperature hood can be provided above the drying cylinder or Yankee cylinder.
10

A further improvement in the tissue product properties can also be achieved in particular by the tissue web being doctored off the drying cylinder by means of a creping doctor, in particular a thin creping doctor.
15

One or more of the following stock grades is preferably used:

- fibers made of hardwood, in particular short-fiber chemical pulps
- 20 - fibers made of softwood, in particular long-fiber chemical pulps
- CTMP (chemical-thermomechanical pulp).

Preference is given to stock grade mixtures in which
25 the proportion of fibers made of hardwood lies in a range from about 50% to about 80%, the proportion of fibers made of softwood lies in a range from about 20% to about 50% and/or the proportion of CTMP (chemical-thermomechanical pulp) lies in a range from 0% to about
30 20%.

Thus, amongst others, for example the following stock grade mixtures are conceivable:

35	Ex. "a"	Ex. "b"	Ex. "c"
Hardwood (50 to 80%)	50	60	70
Softwood (20 to 50%)	30	40	20
CTMP (0 to 20%)	20	0	10

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In this case, in particular the CTMP in a respective stock grade mixture improves the specific volume (bulk).

- 5 According to a preferred practical configuration of the method according to the invention, the tissue web is led around the drying cylinder after the press nip, the drying in the relevant wrap region preferably being intensified by a drying hood, in particular a high-
10 temperature hood.

It is of particular advantage if the multilayer flow box is supplied with at least two different stock grades and in this case for short fibers obtained from
15 hardwood to be used for the layer of the tissue web that faces the drying cylinder surface and for long fibers obtained from softwood to be used for the layer on the opposite side of the web.

- 20 It is also of advantage in particular if the flow box is loaded with at least two layers with different fibrous stocks, the stock with the short fibers obtained from hardwood being added into the layer of the flow box which forms the side of the tissue web
25 that faces the drying or Yankee cylinder surface. The second layer is expediently loaded with long fibers made from softwood. Alternatively or additionally, this second layer can also be loaded with long fibers and CTMP and/or with long fibers and CMP and short
30 fibers. This layer forms the second layer of the tissue web, which faces the drying hood in the drying process. It therefore never comes into contact with the drying or Yankee cylinder surface. Using these method steps, the "hand feel" and "bulk" values are
35 improved by about 5% and more.

Use is preferably made of a multilayer flow box, whose nozzle is subdivided into at least two channels by means of at least one slat extending over the entire

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machine width. In this case, the nozzle is expediently subdivided at least substantially symmetrically into two channels by a slat.

- 5 Particularly good results are achieved if the slat extends outward beyond the nozzle in the region of the outlet gap. This counteracts any mixing of the plies.

Advantageously, use can be made of a flow box having
10 dilution water regulation and/or control section by section over the machine width, in order to be able to set a respectively desired cross-machine grammage profile.

- 15 In specific cases it is advantageous if in each case dilution water regulation and/or control is provided for at least two layers. For example, when a two-layer flow box is used, in each case dilution water regulation or control can therefore be provided in both
20 layers, if appropriate.

Dilution water regulation and/or control is preferably provided at least in the layer facing the forming or breast roll. In this case, appropriate dilution water
25 regulation and/or control can in particular be provided only for this one layer, that is to say the outer layer with respect to the forming or breast roll. The forming or breast roll can be closed, open or else evacuated.

- 30 The drying of the web by the drying or Yankee cylinder and a drying or hot-air hood is important for the drying process, according to a preferred practical configuration of the method according to the invention,
35 the proportion of the drying contributed by the drying hood to the drying of the tissue web being chosen to be greater than the proportion of the drying contributed by the drying cylinder.

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In this case, the ratio between the proportion of the drying from the drying hood and the proportion of the drying from the drying cylinder is advantageously chosen to be greater than 55:45, in particular greater than or equal to 60:40, in particular greater than or equal to 65:35 and preferably greater than or equal to 70:30.

10 The drying hood is preferably operated at a temperature which is greater than or equal to 400°C, in particular greater than or equal to 500°C, in particular greater than or equal to 600°C and preferably greater than or equal to 700°C.

15 The steam pressure in the drying cylinder can additionally be reduced. For example, for the steam pressure in the drying cylinder, a value is advantageously chosen which is less than or equal to 0.7 MPa, in particular less than or equal to 0.6 MPa
20 and preferably less than or equal to 0.5 MPa.

As a result, the course of the drying can be raised further. By means of the aforementioned measures, an increase in the "bulk" value by up to 5% and an
25 improvement in the "hand feel" value are achieved.

Particular importance is also attached to winding up the tissue web at the end of the tissue machine.

30 According to a preferred practical configuration of the method according to the invention, a reel-up is used in which the tissue web is led over a carrier drum and is then wound up onto a spool, in each case a drive preferably being assigned both to the carrier drum and
35 to the spool. As a result, optimum reeling of the web is achieved, without destroying the specific volume (bulk) of the paper web produced. Thus, with the use of two drives for the carrier drum and the spool or the

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reel, in particular a reduction of the line force produced in the winding nip is possible.

According to an expedient practical configuration of the method according to the invention, the line force produced in the winding nip between the carrier drum and the spool is chosen to be less than or equal to 0.8 kN/m, in particular less than or equal to 0.5 kN/m and preferably less than or equal to 0.2 kN/m. Since no drive power has to be transmitted between the carrier drum and the reel, the pressure in the winding nip or contact nip can be reduced.

Since tissue paper is creped, exhibits high stretch, that is to say a high modulus of elasticity, and has a low tensile strength, no substantial web tension can be applied in order to increase the winding hardness of the reel.

The maximum difference between the circumferential speed of the reel and the circumferential speed of the carrier roll is preferably less than 10% of the circumferential speed of the carrier roll.

According to a preferred practical configuration of the method according to the invention, the web tension between the drying cylinder and the carrier drum is set, in particular controlled and/or regulated, to a predefinable desired value via the drive assigned to the carrier drum, independently of the line force produced in the winding nip.

On account of the creping at the creping doctor, the carrier drum circumferential speed is lower than the circumferential speed of the drying cylinder.

The drive assigned to the spool is advantageously controlled and/or regulated as a function of the speed of the carrier drum.

Of particular importance during the production of a soft reel is the control of the "low" line force in the winding nip or contact nip. According to a preferred practical configuration of the method according to the invention, a reel-up is used for this purpose in which the carrier drum is mounted in a fixed position and the spool can be moved. Accordingly, the growth in the reel diameter can be compensated for by means of appropriate movement of the spool. In addition, the line force in the winding nip can be set in the desired manner via the movable spool. In order to compensate for the growth in diameter of the reel and in order to set the line force in the winding nip, a common control loop can advantageously be used. One expedient configuration of the method according to the invention is distinguished by the fact that the line force in the winding nip is determined via at least one force sensor and this line force is regulated by means of appropriate movement of the spool. In principle, however, for example the spool can also be fixed in position and the carrier drum can be movable. Furthermore, such designs in which both the carrier drum and the spool can respectively be moved are also conceivable.

It is possible that the measurement accuracy of the sensors and the setting accuracy (friction) is no longer sufficient at low line forces and with large, heavy reels. In particular in the case of line forces in the winding nip which are less than or equal to 0.5 kN/m and in particular less than or equal to 0.2 kN/m, the movable spool is therefore preferably moved away under control. In this case, the measured variables used for the movement away under control can in particular be the reel diameter and the position of the spool or the reel formed thereon relative to the carrier drum.

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According to a further advantageous configuration of the method according to the invention, in order to set, control and/or regulate the line force in the winding nip, the region of the winding nip can be monitored appropriately by means of a CCD camera. In this case, by means of the CCD camera, preferably the respective distance between the carrier drum and the spool or the reel formed on the latter is registered. With such observation of the winding nip region, for example by means of a CCD camera, the result is therefore a further possibility of monitoring and setting the winding force. It is therefore possible to measure and display the distance between the carrier drum and the reel. By using an evaluation of the image, it is then again possible to reach a desired value of the hydraulic cylinder pressure that influences the movable reel and, via a control device, to execute the displacement or shift as far as the desired distance or winding force. The gain in bulk can lie, for example, in a range from 4 to 8%. A further advantage is that the "bulk" gain achieved by the shoe press is not destroyed, and therefore the quality of the web is maintained.

It is also of advantage if the drive assigned to the spool and therefore to the reel is not changed during the winding operation, that is to say in particular not when the new spool is moved beyond the primary or winding start position, in which the drive is coupled up and the spool is accelerated, to the secondary position on the rails. Controlled winding from start to end therefore results.

The paper quality can be increased further by the mass per unit area of the tissue web in the uncreped state lying in a range from about 11 g/m² to about 20 g/m² and in the creped state lying in a range from about 14 g/m² to about 24 g/m².

- 10 -

Since, above all in the case of thin papers and in particular in the case of "facial tissue" and "toilet" tissue, the formation, that is to say uniformity of the fiber arrangement, plays an important role, the use of a crescent former is of particular advantage in these cases in particular. In this case, the web is dewatered, transported, pressed and passed on to the drying cylinder or Yankee cylinder on a felt. At the start of dewatering, an outer wire is still provided. In addition to improved formation, the result is also improved strength with possible MD/CMD breaking length ratios of 1:1 to 4:1. This makes it possible to beat the fibers less. This increases the "bulk" value. By means of this former type, "strength" can be converted into "bulk". This former type improves the specific volume (bulk) by + 5% in combination with at least one of the design variants described.

In this case, use can be made in particular of a crescent former, whose inner or supporting belt, formed by a felt, together with the tissue web, is led over at least one evacuated device in the web running direction before the press nip. The evacuated device provided can be, in particular, a suction roll. As already mentioned, the outer belt provided in the region of the forming element of the crescent former can be formed in particular by a mesh belt (wire).

Also of particular advantage, in particular, is the use of a shoe press with a shoe length as measured in the web running direction of greater than or equal to 80 mm and preferably greater than or equal to 120 mm. By means of the shoe press, a line force which lies the range from 60 kN/m to about 90 kN/m is preferably produced. The maximum pressing pressure in the press nip of the shoe press is preferably less than or equal to 2 bar and preferably less than or equal to 1.5 bar. Moreover, the shoe press can comprise a shoe press unit with a blind-drilled press cover. As compared with a

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suction press roll, a bulk gain in a range from about 15% to about 20% can therefore be achieved.

5 According to an expedient practical configuration of the method according to the invention, use is made of a drying cylinder or Yankee cylinder provided with reinforcing ribs in the interior, by which means the line force produced in the press nip can also be increased substantially above 90 kN/m. This makes the
10 tissue machine more flexible, in particular for the case in which, in addition to the "facial" and "toilet" tissue papers, tissue grades are also run in which the "hand feel" and the specific volume (bulk) do not have the first priority but rather the dryness, that is to
15 say the production level.

As already mentioned, a relatively thin creping doctor is preferably used. In this case, the thickness of the creping doctor can in particular be less than or equal
20 to 0.9 mm.

The angle of attack between the tangent to the drying cylinder and the creping doctor is preferably less than or equal to 20°.
25

In the case of this creping doctor, what is known as the "rake angle" can be in particular greater than or equal to 15°.

30 According to an aspect of the invention, there is provided a machine for the production of a web of tissue material comprising a flow box and an endless supporting belt, with which the tissue web is led through a press nip formed
35 between a drying cylinder and an opposing unit, and also comprising a reel-up for subsequently reeling up the tissue web, the flow box provided being a multilayer flow box, to which at least two stock grades can be supplied, and means

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preferably being provided in order to influence in a predefined way the hardness of the reel produced as the tissue web is reeled up, in particular to control and/or regulate it.

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The invention will be explained in more detail in the following text by using exemplary embodiments and with reference to the drawing, in which:

10 Figure 1 shows a schematic illustration of an exemplary embodiment of the tissue machine according to the invention,

15 Figure 2 shows a schematic illustration of an exemplary embodiment of the flow box of the tissue machine according to the invention,

20 Figure 3 shows a schematic partial illustration of a creping doctor assigned to the drying cylinder of the tissue machine according to the invention,

Figure 4 shows a schematic illustration of a conventional reel-up for tissue,

25 Figure 5 shows a schematic illustration of an exemplary embodiment of a reel-up according to the invention, with a spool or reel that can be moved away under control,

30 Figure 6 shows a schematic illustration of a further embodiment of the reel-up according to the invention belonging to the tissue machine according to the invention, with a movable spool or reel with associated pressure and/or force sensors,

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Figure 7 shows a graph which reproduces the influence of the line force in the winding nip on the specific volume (bulk) of the tissue web in the reel,

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Figure 8 shows a graph which, as compared with a suction press roll (SPR), reproduces the influence of a shoe press (TP) provided in accordance with the invention on the specific volume (bulk) as a function of the line force of the press, what is known as a "T-rib" Yankee cylinder, that is to say a Yankee cylinder provided with internal reinforcing ribs, being used above 90 kN/m,

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Figure 9 shows a graph, comparable with the graph of figure 8, but in this case for the "hand feel",

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Figure 10 shows a graph, comparable with the graph of figure 8, but in this case for the dryness after the press,

20 Figure 11 shows a graph which reproduces the influence of drying conditions such as, in particular, the drying ratio between Yankee cylinder/drying hood,

Figure 12 shows a graph which reproduces the influence of the thickness of the creping doctor on the thickness of the tissue paper (bulk), and

25

Figure 13 shows a graph which reproduces the influence of the multilayer production of the tissue paper on the specific volume (bulk) in different presses, it being possible in particular to see the advantage resulting from the use of a shoe press (TF) as compared with a suction press roll (SPR).

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Figure 1 shows, in a schematic illustration, an exemplary embodiment of a machine 10 according to the invention for the production of a tissue web 12.

5

The tissue machine 10 comprises a flow box 14 and an endless supporting belt 16, with which the tissue web 12 is led through a press nip 22 formed between a drying cylinder 18, here a Yankee cylinder 18, and an
10 opposing unit 20.

The tissue machine 10 also comprises a reel-up 24 for subsequently reeling up the tissue web 12.

15 The flow box 14 provided is a multilayer flow box, in the present case a two-layer flow box, to which at least two different stock grades can be supplied.

Furthermore, means described in more detail further
20 below are provided in order to influence the hardness of the reel produced in a predefinable manner when reeling up the tissue web 12, that is to say in particular to control and/or regulate it. In this case, the line force produced in the winding nip 26 is
25 preferably kept below or equal to 0.8 kN/m. A former having two circulating endless belts 16, 28 is provided, one of these two endless circulating belts 16, 28 simultaneously forming the transport belt 16.

30 As can be seen by using figure 1, the two endless belts 16, 28 run together, forming a stock inlet gap 30, in order then to be led over a forming element 32, in particular a forming or breast roll. In this case, the wrap angle with respect to the outer belt 28 is smaller
35 than that with respect to the inner supporting belt 16.

In the present case, a crescent former is provided, whose inner belt (supporting belt) 16 is formed by a felt.

- 15 -

Into the inlet gap 30 formed between the supporting belt 16 and the outer wire 28, by means of the multilayer flow box 14, different stock grades, in the present case a stock grade HW of fibers made from hardwood and a stock grade SW of fibers made from softwood, are introduced. The fibers made of hardwood can be, in particular, short fibered chemical pulps, and the fibers made of softwood can be, in particular, long-fibered chemical pulps.

After the wrap region of the forming roll 32, the tissue web forming in the process, together with the supporting belt 16, is supplied to the press nip 22, which is extended in the web running direction L.

Before reaching the extended press nip 22, the supporting belt 16 carrying the tissue web 12 with it wraps around an evacuated device, designed here as a suction roll 34. The suction roll 34 removes a substantial part of the water from the supporting belt 16 and even somewhat from the outer tissue web 12.

The opposing unit 20 assigned to the drying cylinder 18 is formed in the present case by a shoe press unit, in particular a shoe press roll. The press nip 22 is therefore the extended press nip of a shoe press comprising the drying cylinder 18 and shoe press unit 20.

A creping doctor or bar, in particular a thin creping doctor or bar 36, is assigned to the drying cylinder 18.

Following the press nip 22, the tissue web 12 is led around the drying cylinder 18. In this case, a drying hood 38 is provided in order to intensify the drying in the relevant wrap region.

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As can be seen by using Figure 1, a measuring frame 39 is provided between the drying cylinder 18 and the reel-up 24. In this case, the measured values obtained can, for example, also be used for cross-machine profile regulation of specific web properties.

In the reel-up 24, the tissue web 12 is first led over a carrier drum 40 and then wound on to a spool 42. In this case, preferably both the carrier drum 40 and the spool 42 are each assigned a separate drive 44.

As can be seen by using figure 1, the stock grade HW made of short fibers obtained from hardwood is used for the layer Y facing the surface of the drying cylinder 18, and the stock grade made of long fibers obtained from softwood is used for the layer provided on the opposite web side.

Figure 2 shows, in a schematic illustration, an exemplary embodiment of the flow box 14 of the tissue machine according to the invention. In this case, the nozzle 46 of this flow box 14 is at least substantially divided into two channels 50, 52 by a slat 48 extending over the entire machine width. The slat 48 extends outward beyond the nozzle 46 in the region of the outlet gap 54. The slat length l_2 measured starting from the turbulence generator 56 of the flow box 14, just like the nozzle length l_1 , is therefore greater than the nozzle length l_1 .

Furthermore, the cross-machine distributor pipes 58, 60 for the two stock grades can be seen in figure 2.

In the present case, moreover, dilution water regulation and/or control section by section is provided over the machine width only for the layer facing the forming roll 32 (cf. fig. 1). In figure 2, a cross-machine distribution pipe 61 for dilution water, for example, can be seen.

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In the region of the outlet gap 54 of the nozzle 46, one or more slices 62 can be provided. However, such slices are not imperative.

5

The proportion of the drying contributed by the drying hood 38 to the drying of the tissue web 12 is preferably greater than the proportion of the drying contributed by the drying cylinder 18.

10

Figure 3 shows, in a schematic partial illustration, a creping doctor 36 assigned to the drying cylinder or Yankee cylinder 18 of the tissue machine 10 according to the invention (cf. figure 1).

15

In the present exemplary embodiment, illustrated in figure 3, the thickness b of the creping doctor 36 is less than or equal to 0.9 mm. The angle of attack or clearance angle α between the tangent 76 to the drying cylinder 18 passing through the point of contact 78 and the creping doctor 36 is less than or equal to 20° . The "rake angle" of the creping doctor 36, designated " β " in figure 3, can in particular be greater than or equal to 15° .

25

Figure 4 shows, in a schematic illustration, a conventional reel-up 64 for tissue, in which the carrier drum 68 provided with a drive 66 is pressed against the reel 70 onto which the tissue web produced is wound up, as a result of which the reel 70 is driven. The carrier drum 68 is fixed in position. The reel 70 can be moved on rails 72. The pressing force must be sufficiently high for the necessary drive power to be transmitted. The line force produced in the winding nip 74 is around 0.8 kN/m (width). The line force here is so high that the carrier drum 68 dips into the soft reel 70 and thus destroys or reduces the specific volume (bulk). The growth in the diameter of

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the reel 70 is taken into account by moving the reel 70 away from the carrier drum 68.

5 Figures 5 and 6 show, in a schematic illustration, two exemplary embodiments of the reel-up 24 according to the invention.

10 In the respective reel-up 24, the tissue web 12 is led over a carrier drum 40 and then wound up onto a spool 42. In both the exemplary embodiments, both the carrier drum 40 and the spool 42 are each assigned a drive 44.

15 Between the reel 80 forming on the spool 42 and the carrier drum 40, a winding nip or contact nip 26 is formed, in which a line force is produced which critically influences the resultant winding hardness. At least the spool 42 can be moved in the x direction, that is to say for example horizontally, along rails 82
20 or the like.

The embodiment shown in figure 6 of the reel-up 24 is an example of a possible solution for the regulation of the line force.

25

In the present case, the carrier drum 40 is mounted in a fixed position on the rails 82. By contrast, the spool 42 and, in a corresponding way, the reel 80 formed on the latter can be moved. In this case, the
30 spool 42 can have its position changed, for example by means of translational actuators provided on both sides, such as threaded rods with associated motor, hydraulic cylinders and so on.

35 Preferred criteria for the displacement of the spool 42 and the reel 80 formed on the latter are the growth in the winding diameter D and the line force in the winding nip 26.

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In this embodiment, both criteria can be satisfied by a control loop.

5 Sensors 83 which measure the nip force F in the region of the press nip 26 directly or indirectly can be integrated in the bearings of the spool 42. The aforementioned sensors can be, for example, pressure sensors, force sensors, strain gages and so on.

10 For instance, if the measured force differs from the predefined force, that is to say an appropriate desired value, then the pressure of a relevant hydraulic cylinder, for example, is changed by a controller 84, for example via a hydraulic unit, in such a way that
15 the difference between the desired value and the measured value becomes zero.

Of course, a modification of this embodiment in which only the carrier drum 40 or both the carrier drum 40
20 and the spool 42 can be moved or displaced is also conceivable. In the case of a movable carrier drum 40, the latter has the relevant sensors via which the nip force F is regulated.

25 The reel displacement in this case only compensates for the growth in the reel diameter D .

The distance between the axes of the carrier drum 40 and of the spool 42 or of the reel 80, which is
30 increasingly enlarged during the winding operation, is designated "A" in figure 6.

In the case of lower line forces and large, heavy reels, it is possible for the case to occur in which
35 the measurement accuracy of the sensors and the setting accuracy (friction) are no longer adequate.

In particular in the case of line forces in the winding nip 26 which are less than or equal to 0.5 kN/m and in

- 20 -

particular less than or equal to 0.2 kN/m, for example the movable spool and, in a corresponding way, the reel 80 formed on the latter are preferably designed such that they can be moved away under control. The
5 embodiment shown in figure 5 concerns a corresponding design.

The measured variables provided for this away movement under control are, in particular, the following
10 variables:

- diameter D of the reel 80
- position of the reel 80 or of the spool 42 relative to the carrier drum 40.

15 In this case, the position of the reel 80 can be measured, for example, by means of sensors such as LVDTs (linear variable differential transformers), and the diameter of the reel can be determined by a
20 distance sensor, for example optically or acoustically. The actuators 86 (cf. figure 6), which can be hydraulic cylinders and so on, for example, position the reel 80 accurately such that the latter just touches the carrier drum 40, for example. In this case, the line
25 force F_L produced in the winding nip 26 is therefore equal to zero. If $F_L > 0$ kN/m is to be the case, then the reel 80 can be moved further onto the carrier drum 40 by a predefined distance which, in particular, depends on the softness of the reel 80. Therefore, a
30 slight desired pressure in the press nip or contact nip 26 of, for example, $F_L \leq 0.2$ kN/m is produced. The distance A (cf. also figure 6) is therefore $A < d/2 + D/2$ or $A = d/2 + D/2 - x$, where "x" is the measure of how far the carrier drum 40 dips into the reel 80 formed on
35 the spool 42.

A further possible way of monitoring and setting the nip force results, for example, from the observation of the nip region with a CCD camera. Using the latter, in

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particular the distance between the carrier drum 40 and the reel 80 can be measured and displayed. By using an appropriate evaluation of the image obtained, a desired value, for example for a hydraulic cylinder pressure, can again be calculated and, via a control device, can effect the displacement as far as the desired distance or nip force. The bulk gain lies in a range from 4 to 8%.

10 In order to illustrate the outward movement control, in the illustration according to figure 5 the spool 42 is assigned a pointer 88, whose position with respect to a stationary scale 90 ultimately indicates the position of the spool 42 and therefore of the reel 80 formed on the latter.

Furthermore, in figure 5 it is possible to see a sensor 92, which can in particular be a sensor of the aforementioned type, for example only a CCD camera or the like.

Figure 7 shows a graph which reproduces the influence of the line force L_f in the winding nip on the specific volume (bulk) of the tissue web in the reel. "HW" designates a stock grade of fibers made from hardwood and "SW" designates a stock grade of fibers made from softwood.

Figure 8 shows a graph which, in comparison with a suction press roll (SPR), reproduces the influence of a shoe press (TF) provided in accordance with the invention on the specific volume (bulk) as a function of the line force of the press. In this case, beginning at 90 kN/m, what is known as a "T-rib" Yankee cylinder, that is to say a Yankee cylinder provided with internal reinforcing ribs, is used.

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Figure 9 shows a graph that is comparable with the graph of figure 8, but in this case for the "hand feel" already mentioned at the beginning.

- 5 In addition, figure 10 again shows a graph that is comparable with the graph of figure 8, but in this case for the dryness after the press.

10 The graph of figure 11 reproduces the influence of drying conditions, such as in particular the drying ratio Yankee cylinder/drying hood.

15 The graph of figure 12 shows the influence of the thickness of the creping doctor on the thickness of the tissue paper, which here corresponds to the specific volume (bulk). On the other hand, an improved "hand feel" value is also possible at a constant "bulk" value. In the graph, the abbreviation "GMT" stands for the expression "geometric mean tensile strength".

20

Figure 13 shows a graph which reproduces the influence of the multilayer production of the tissue paper on the specific volume (bulk) in the case of different presses, it being possible to see in particular the
25 advantage resulting from the use of a shoe press (TF) as compared with a suction press roll (SPR).

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List of designations

10	Tissue machine
12	Tissue web
14	Flow box
16	Endless circulating belt, supporting belt
18	Drying cylinder, Yankee cylinder
20	Opposing unit, shoe press unit
22	Press nip, contact nip
24	Reel-up
26	Winding nip
28	Endless circulating belt, outer wire
30	Stock inlet gap
32	Forming element, forming roll, breast roll
34	Evacuated device, suction roll
36	Creping doctor, doctor bar
38	Drying hood
39	Measuring frame
40	Carrier drum
42	Spool
44	Drive
46	Nozzle
48	Slat
50	Channel
52	Channel
54	Outlet gap
56	Turbulence generator
58	Cross-machine distribution pipe
60	Cross-machine distribution pipe
61	Cross-machine distribution pipe
62	Slice
64	Reel-up
66	Drive
68	Carrier drum
70	Reel
72	Rails
74	Winding nip
76	Tangent
78	Point of contact

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80 Reel
82 Rails
83 Sensor
84 Controller
86 Actuator
88 Pointer
90 Scale
92 Sensor

A Distance
D Reel diameter
F Nip force, force in the winding nip
b Thickness
 l_1 Nozzle length
 l_2 Slat length
 α Angle of attack, clearance angle
 β "Rake angle"

THE EMBODIMENTS OF THE INVENTION IN WHICH AN EXCLUSIVE PROPERTY OR PRIVILEGE IS CLAIMED ARE DEFINED AS FOLLOWS:

1. A machine for producing a web of tissue material by supplying at least two stock grades to a multilayer flow box, winding up the tissue web on a reel of a reel-up; and maintaining a winding nip having a line pressure of less than or equal to 0.8 kN/m to influence the hardness of the reel produced, the machine comprising:

a multilayer flow box structured and arranged to supply at least two stock grades; an endless supporting belt;

a drying cylinder and an opposing unit arranged to form a press nip, wherein endless supporting belt guides the web through the press nip;

a reel-up for reeling up the tissue web; and a device to influence, in a predefined way, a hardness of a reel produced as the tissue web is reeled, comprising a controller to maintain in the winding nip the line pressure of less than or equal to 0.8 kN/m, wherein said multilayer flow box comprises a nozzle that is subdivided into at least two channels by at least one slat extending over a entire machine width, and wherein said slat extends outwardly beyond said nozzle in a region of an outlet gap.

2. A machine for producing a web of tissue material, comprising:

a multilayer flow box structured and arranged to supply at least two stock grades; an endless supporting belt;

a drying cylinder and an opposing unit arranged to form a press nip, wherein said endless supporting belt guides the web through said press nip;

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a reel-up for reeling up the tissue web; and a device to influence, in a predefined way, a hardness of a reel produced as the tissue web is reeled, comprising a controller to maintain in the winding nip the line pressure of less than or equal to 0.8 kN/m, wherein said multilayer flow box comprises a nozzle that is subdivided into at least two channels by at least one slat extending over a entire machine width, and wherein said slat extends outwardly beyond said nozzle in a region of an outlet gap.

3. The machine in accordance with claim 2, wherein said device to influence is structured and arranged to at least one of control and regulate the hardness of the reel.

4. The machine in accordance with claim 2, wherein said drying cylinder comprises a Yankee cylinder.

5. The machine in accordance with claim 2, wherein said reel-up comprises a winding nip, in which a line force of less than or equal to 0.8 kN/m is produced.

6. The machine in accordance with claim 2, further comprising: a former having two circulating endless belts, which are arranged to run together to form a stock inlet gap; a forming element positioned such that said two circulating endless belts are guided over said forming element.

7. The machine in accordance with claim 6, wherein an inner belt of said two circulating endless belts that comes into contact with said forming element forms a transport belt.

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8. The machine in accordance with claim 6, wherein said forming element comprises a forming roll.

9. The machine in accordance with claim 2, further comprising a crescent former having an inner belt comprising a felt.

10. The machine in accordance with claim 2, further comprising at least one press shoe, wherein the supporting belt is arranged to guide the web through said at least one shoe press.

11. The machine in accordance with claim 2, wherein said opposing unit comprises a shoe press unit.

12. The machine in accordance with claim 2, further comprising a creping doctor, wherein said creping doctor is assigned to said drying cylinder.

13. The machine in accordance with claim 12, wherein said creping doctor is a thin creping doctor.

14. The machine in accordance with claim 12, wherein a thickness of said creping doctor is less than or equal to 0.9 mm.

15. The machine in accordance with claim 12, wherein an angle of attack between a tangent to said drying cylinder and said creping doctor is less than or equal to 20°.

16. The machine in accordance with claim 12, wherein a rake angle of said creping doctor is greater than or equal to 15.degree.

17. The machine in accordance with claim 2, further comprising a drying hood assigned to said drying cylinder, said drying hood being structured and arranged to intensify drying of the tissue web, which is guided over said drying cylinder, in a relevant wrap region of said drying cylinder.

18. The machine in accordance with claim 17, wherein a proportion of the drying of the tissue web contributed by said drying hood is greater than a proportion of the drying of the tissue web contributed by said drying cylinder.

19. The machine in accordance with claim 18, wherein a ratio between the proportion of the drying from said drying hood and the proportion of the drying from said drying cylinder is greater than 55:45.

20. The machine in accordance with claim 19, wherein the ratio is greater than or equal to 60:40.

21. The machine in accordance with claim 19, wherein the ratio is greater than or equal to 65:35.

22. The machine in accordance with claim 19, wherein the ratio is greater than or equal to 70:30.

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23. The machine in accordance with claim 17, wherein said drying hood is operatable at a temperature which is greater than or equal to 400°C.

24. The machine in accordance with claim 23, wherein said drying hood is operable at a temperature greater than or equal to 500°C.

25. The machine in accordance with claim 23, wherein said drying hood is operable at a temperature greater than or equal to 700°C.

26. The machine in accordance with claim 2, wherein said nozzle is subdivided at least substantially symmetrically into two channels by said slat.

27. The machine in accordance with claim 2, wherein said multilayer flow box comprises at least one of dilution water regulation and section by section control over a machine width.

28. The machine in accordance with claim 27, wherein said at least one of dilution water regulation and/or section by section control over the machine width is provided for each of the at least two layers.

29. The machine in accordance with claim 27, wherein said at least one of dilution water regulation and control is provided at least for a layer facing a forming roll.

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30. The machine in accordance with claim 2, wherein a steam pressure in said drying cylinder is less than or equal to 0.7 MPa.

31. The machine in accordance with claim 30, wherein the steam pressure is less than or equal to 0.6 MPa.

32. The machine in accordance with claim 30, wherein the steam pressure is less than or equal to 0.5 MPa.

33. The machine in accordance with claim 2, said reel-up comprises a carrier drum, over which the tissue web is guided, and a spool, on which the tissue web is wound, wherein a drive is assigned to each of said carrier drum and said spool.

34. The machine in accordance with claim 33, wherein said carrier drum and said spool are arranged to form a winding nip, and a line force produced in the winding nip is less than or equal to 0.8 kN/m.

35. The machine in accordance with claim 34, wherein the line force in the winding nip is less than or equal to 0.5 kN/m.

36. The machine in accordance with claim 34, wherein the line force in the winding nip is less than or equal to 0.2 kN/m.

37. The machine in accordance with claim 33, wherein a maximum difference between a circumferential speed of the

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reel formed on said spool and a circumferential speed of said carrier drum is less than 10% of the circumferential speed of the carrier drum.

38. The machine in accordance with claim 33, wherein web tension between said drying cylinder and said carrier drum is at least one of controllable and regulatable to a predefinable desired value via said drive assigned to said carrier drum.

39. The machine in accordance with claim 38, wherein the web tension is at least one of controlled and regulated independently of the line force produced in the winding nip.

40. The machine in accordance with claim 33, wherein said drive assigned to said spool is at least one of controllable and regulatable as a function of a speed of said carrier drum.

41. The machine in accordance with claim 33, wherein said carrier drum is mounted in a fixed position and said spool is movably mounted.

42. The machine in accordance with claim 33, further comprising a device to automatically compensate for the growth in a winding diameter by appropriately moving said spool.

43. The machine in accordance with claim 33, further comprising a device to automatically set a line force in said winding nip via said movable spool.

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44. The machine in accordance with claim 33, further comprising a common control loop structured and arranged to compensate for growth in a winding diameter and to set a line force in said winding nip.

45. The machine in accordance with claim 33, wherein variables for moving said spool under control are winding diameter and position of said spool or the reel formed on said spool relative to said carrier drum.

46. The machine in accordance with claim 45, further comprising sensors to measure the position of said reel.

47. The machine in accordance with claim 46, wherein said sensors comprise linear variable differential transformers.

48. The machine in accordance with claim 33, further comprising a CCD camera structured and arranged to monitor a region of said winding nip in order to at least one of set, control and regulate the line force in said winding nip.

49. The machine in accordance with claim 48, wherein said CCD camera is arranged to register respective distances between said carrier drum and said spool or said reel formed on said spool.

50. The machine in accordance with claim 2, further comprising at least one force sensor structured and arranged to determine a line force in said winding nip, wherein a line force is regulatable by appropriately moving said spool.

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51. The machine in accordance with claim 50, wherein, when the line forces in said winding nip are less than or equal to 0.5 kN/m, said spool is moved away from said carrier roll under control.

52. The machine in accordance with claim 50, wherein, when the line forces are less than or equal to 0.2 kN/m, said spool is moved away from said carrier roll under control.

53. The machine in accordance with claim 2, further comprising: a crescent former; and at least one evacuated device, wherein said supporting belt is an inner belt of said crescent formed by a felt, and said inner belt guides the tissue web over said at least one evacuated device in a web running direction before said press nip.

54. The machine in accordance with claim 53, wherein said at least one evacuated device comprises a suction roll.

55. The machine in accordance with claim 53, wherein said crescent former comprises a forming element, and an outer belt, provided in a region of said forming element, is formed by a mesh belt.

56. The machine in accordance with claim 2, wherein said press nip comprises a shoe press having a shoe length measured in a web running direction which is greater than or equal to 80 mm.

57. The machine in accordance with claim 56, wherein the shoe length is greater than or equal to 120 mm.

58. The machine in accordance with claim 57, wherein a line force produced by said shoe press lies in a range from about 60 kN/m to about 90 kN/m.

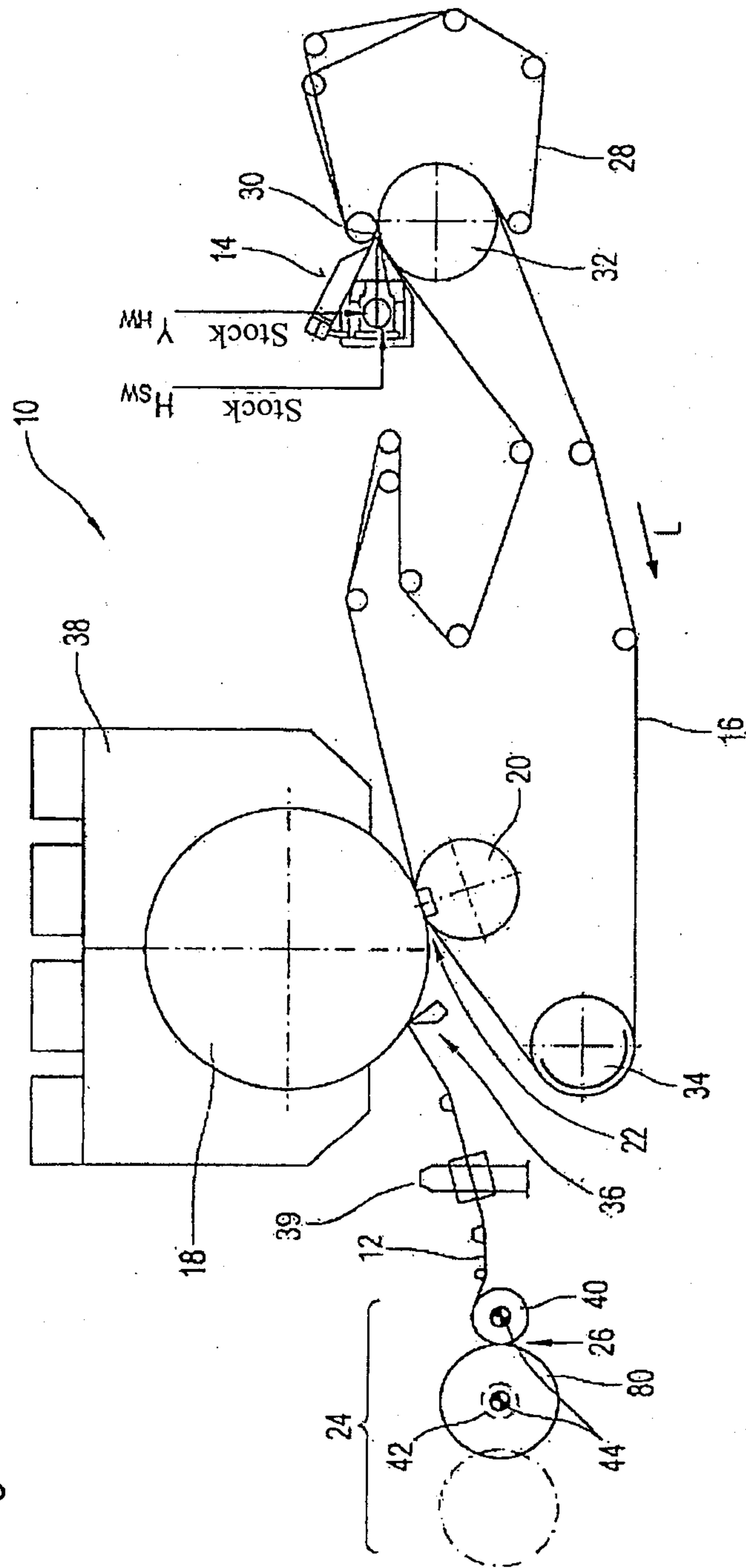
59. The machine in accordance with claim 57, wherein a maximum pressing pressure in said press nip of said shoe press is less than or equal to 2 bar.

60. The machine in accordance with claim 59, wherein the maximum pressing pressure is less than or equal to 1.5 bar.

61. The machine in accordance with claim 57, wherein said shoe press comprises a shoe press unit with a blind-drilled press cover.

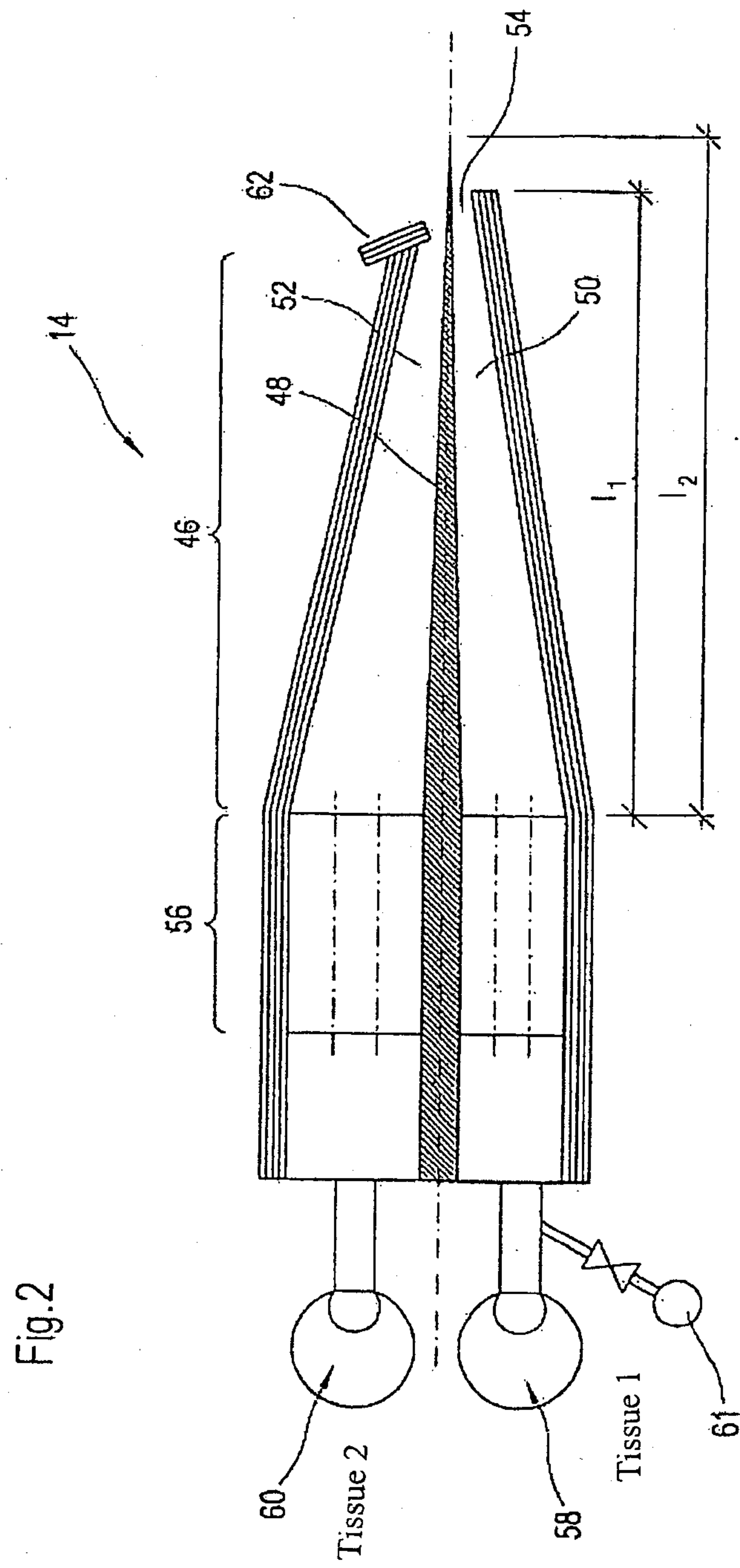
62. The machine in accordance with claim 2, wherein said drying cylinder includes reinforcing ribs in an interior.

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Fig.3

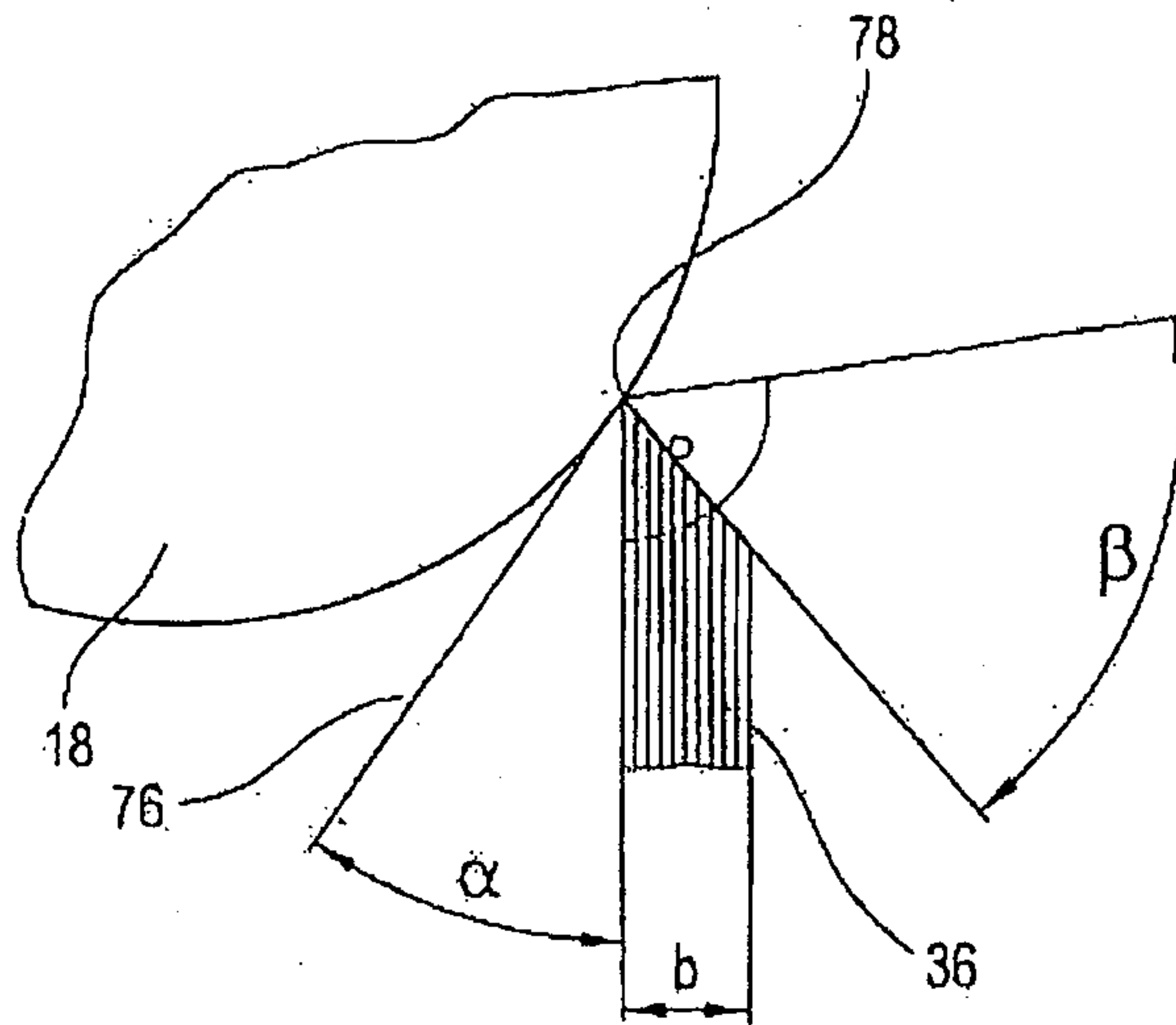
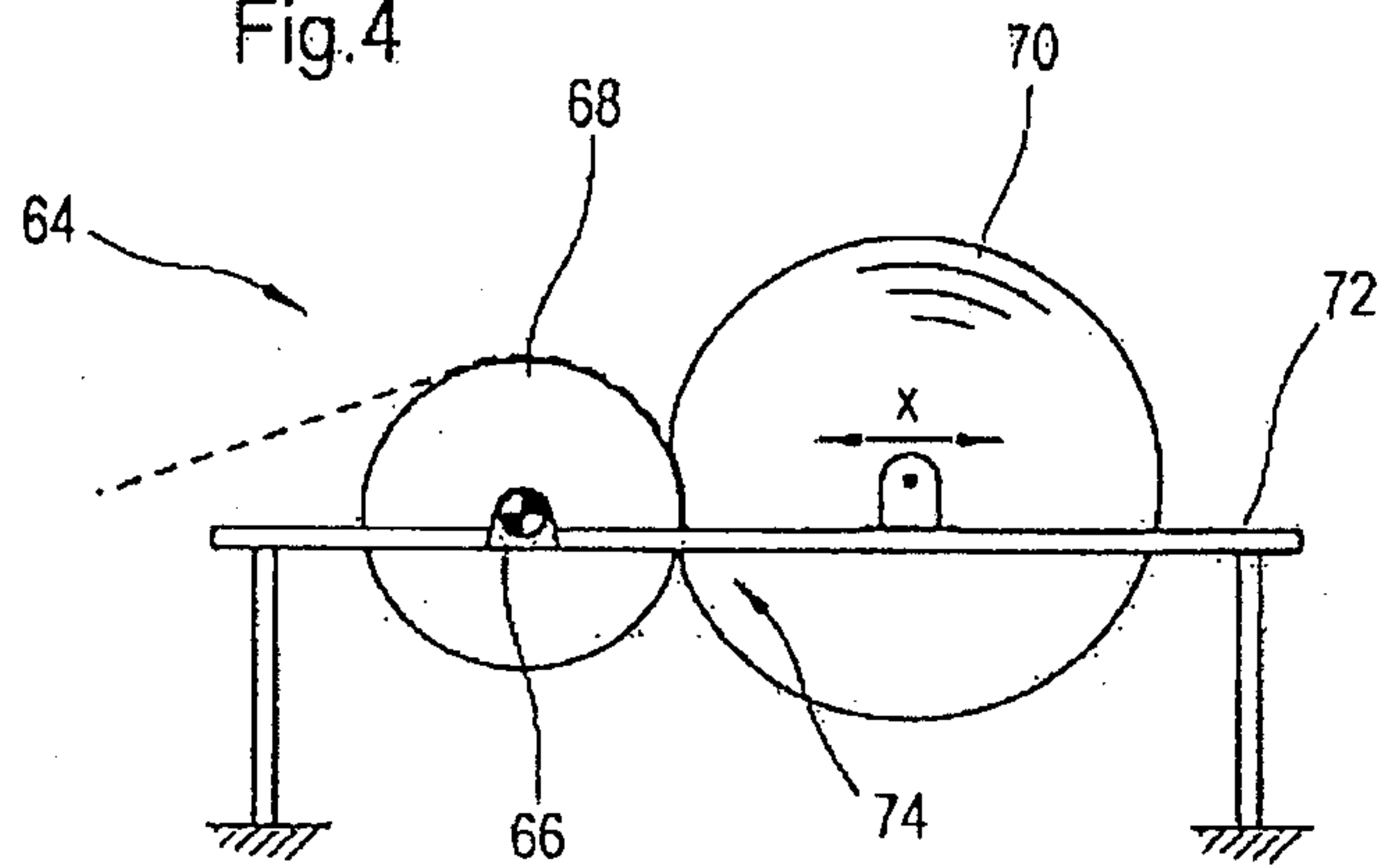
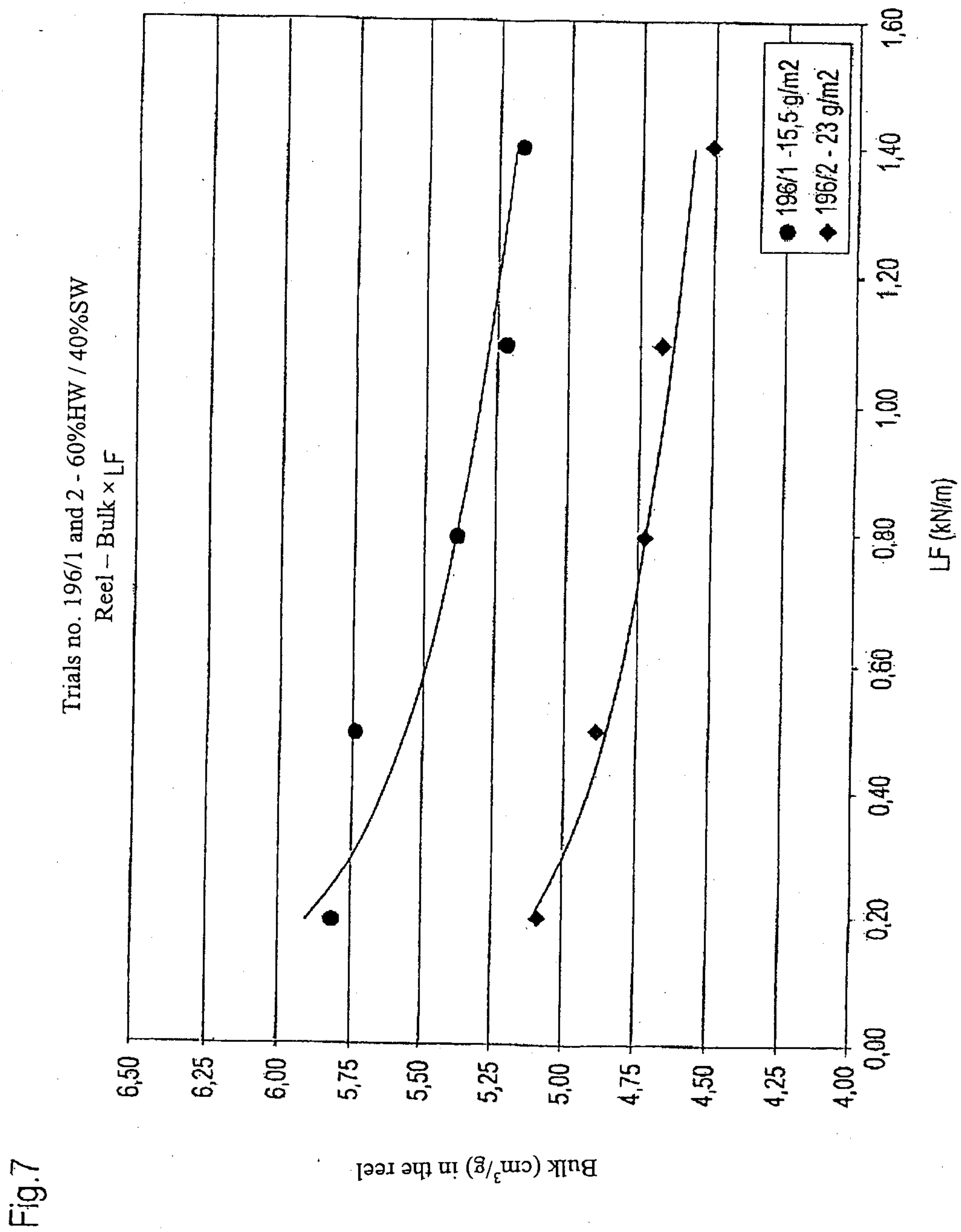


Fig.4



PRIOR ART

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Fig.8

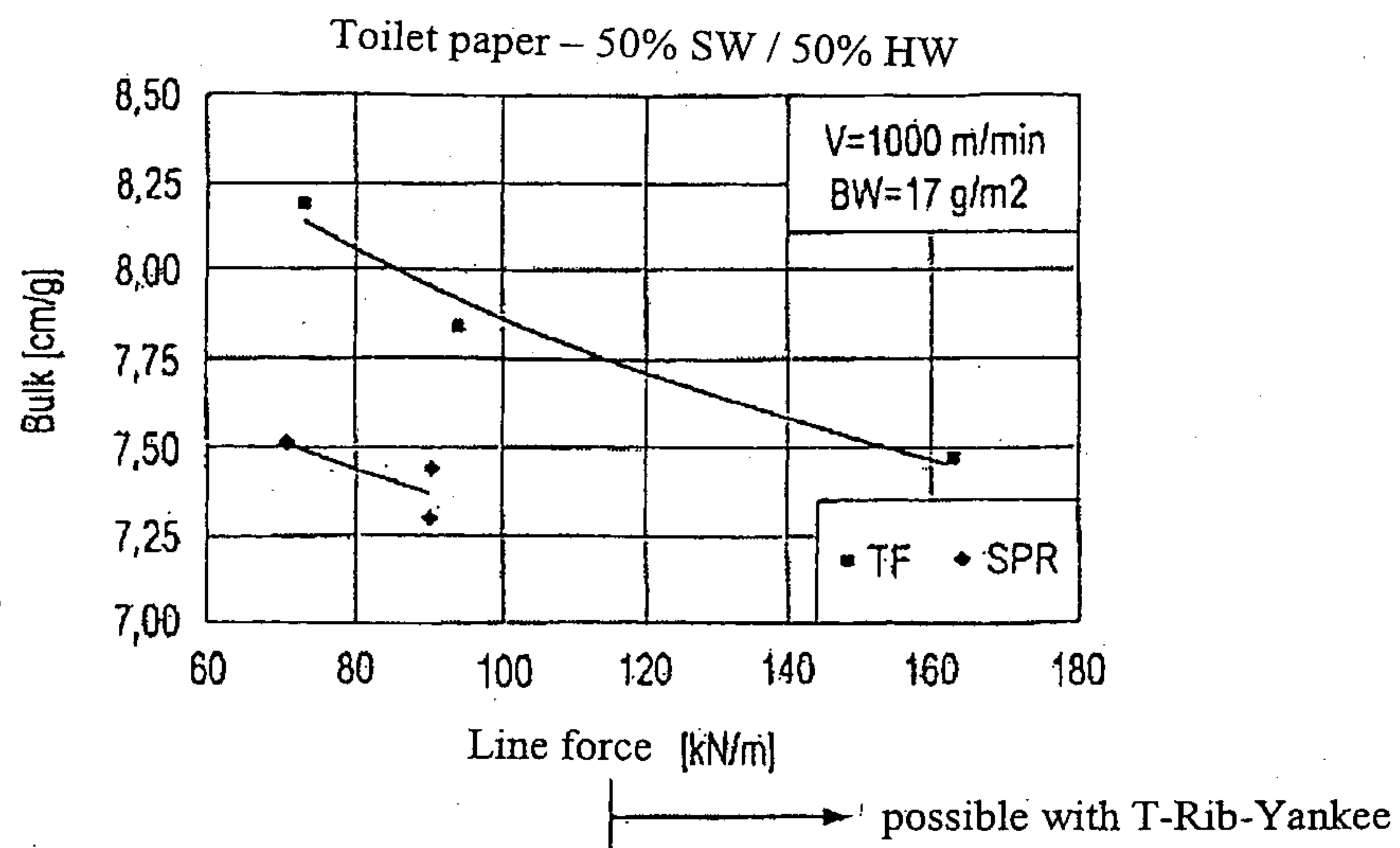


Fig.9

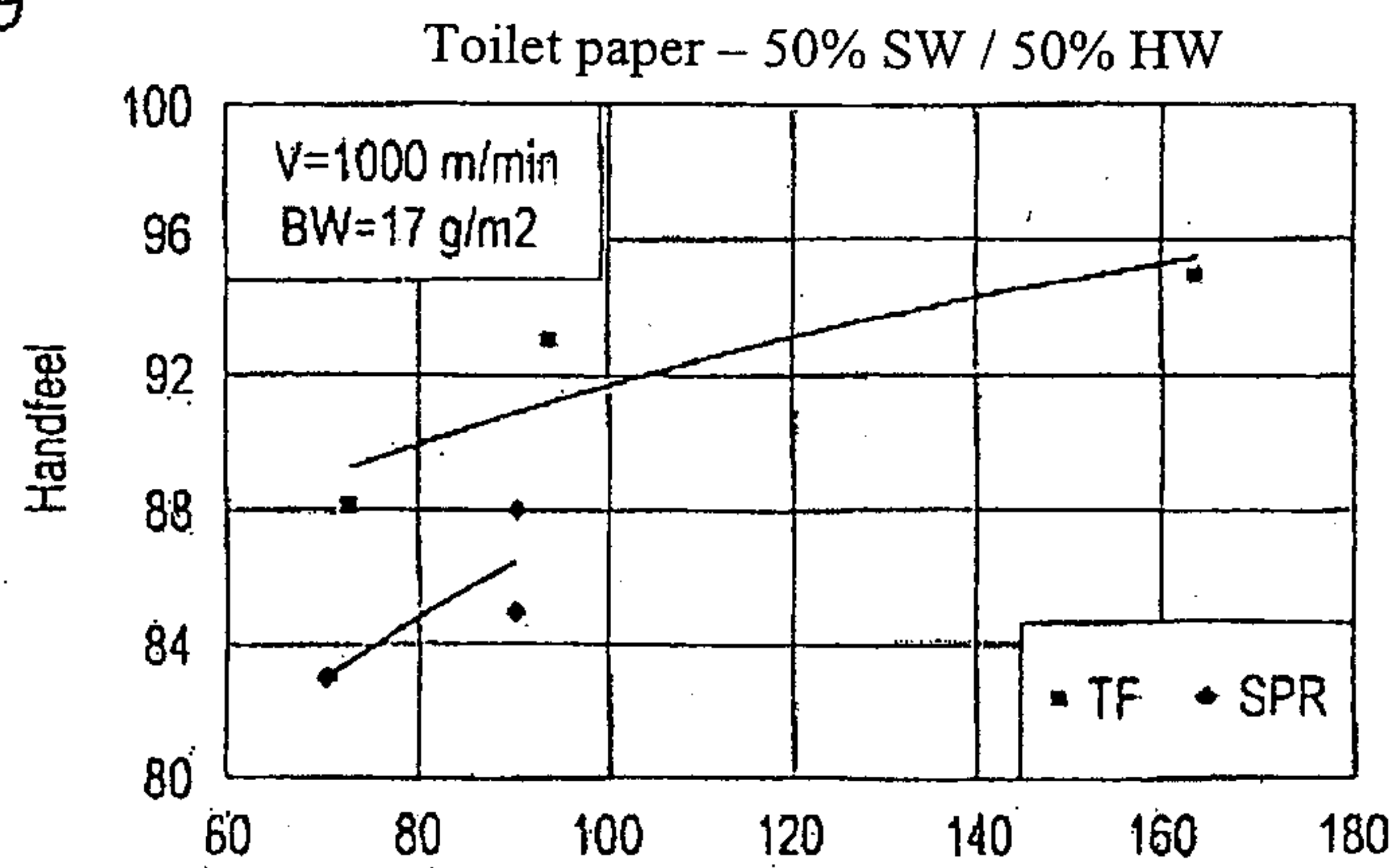
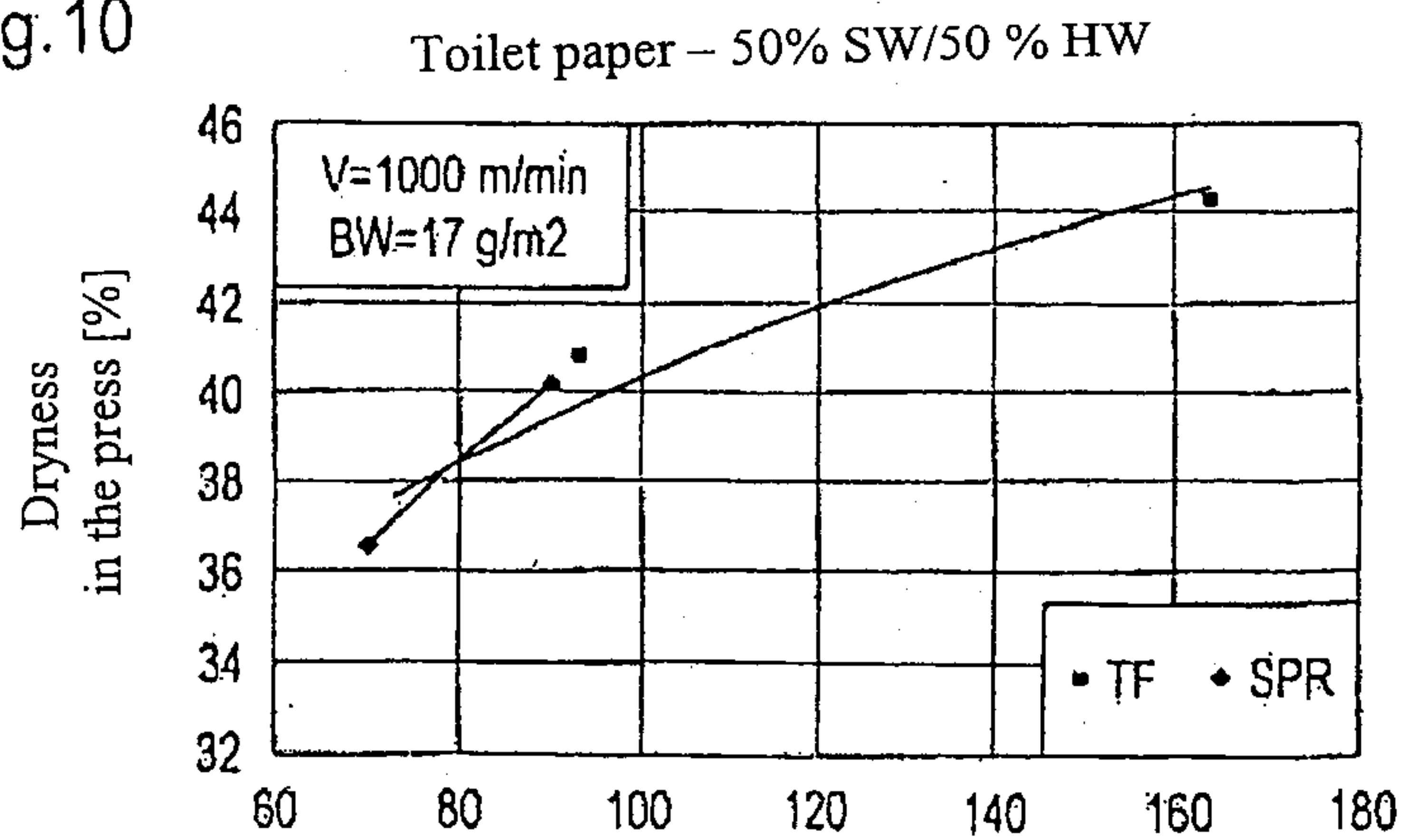


Fig.10



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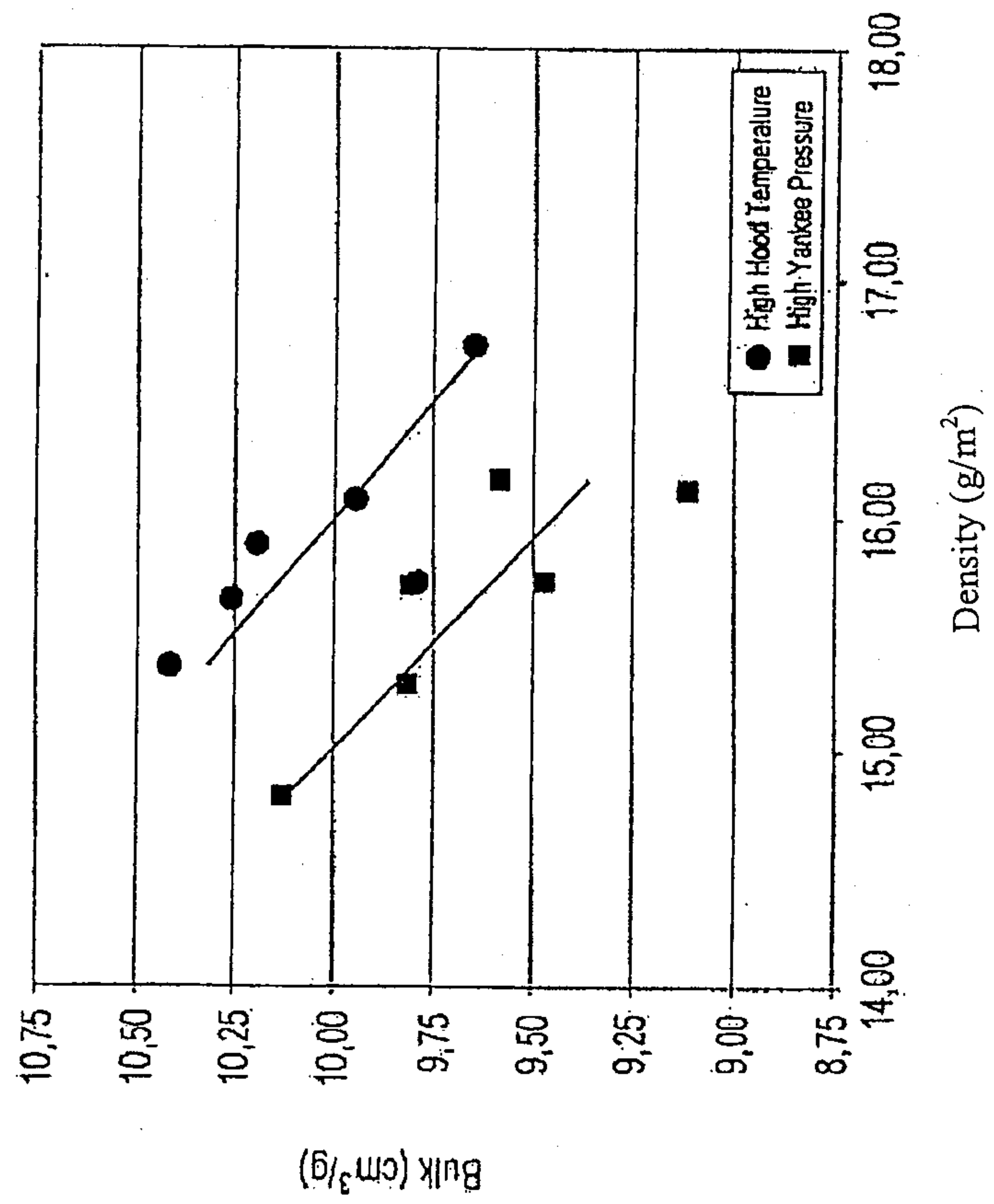


Fig.11

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Fig.12

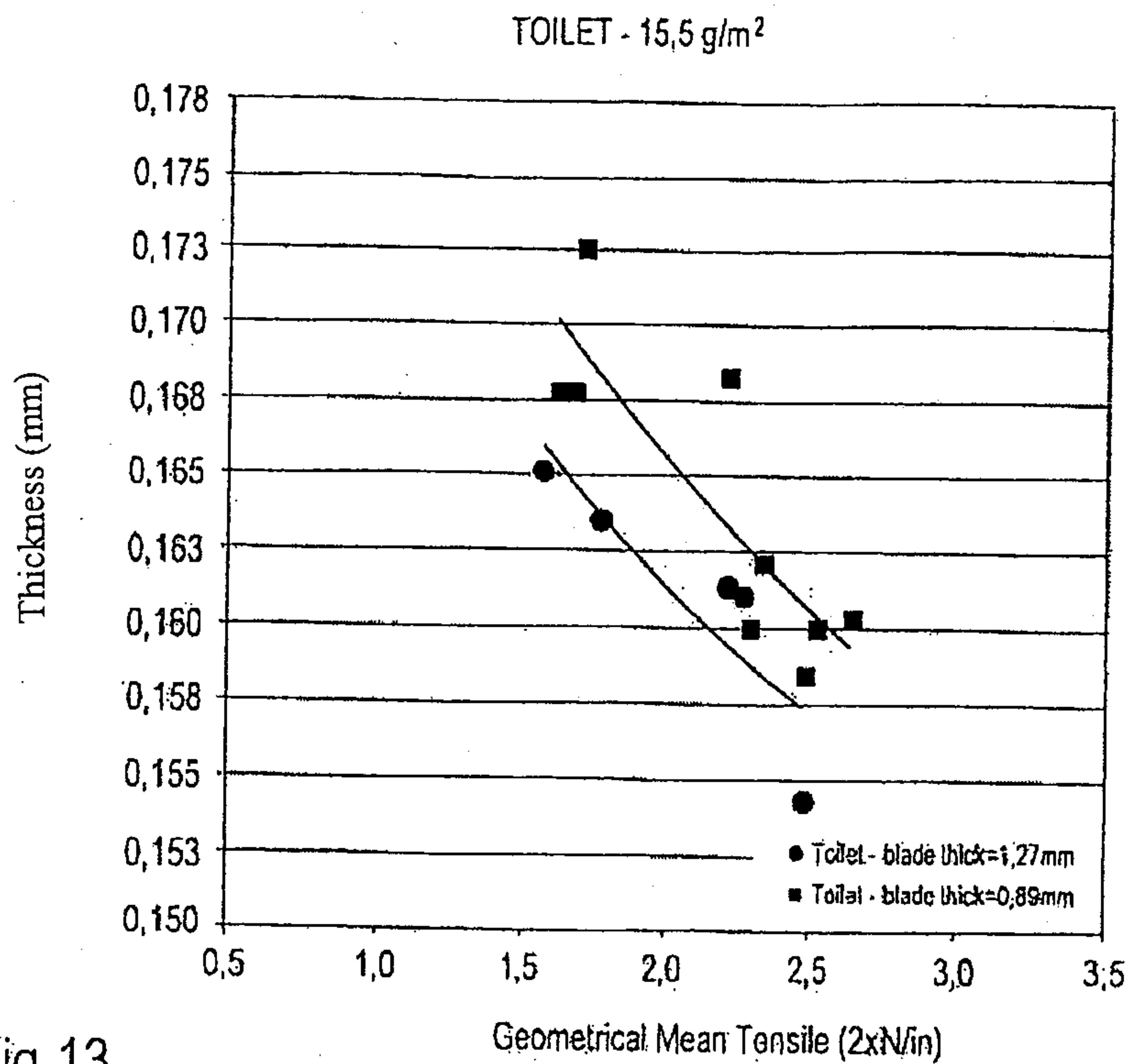


Fig.13

