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(54) **A MACHINE UTILIZED FOR PRODUCING AND MANUFACTURING A RESILIENT FILM SOFT AT TOUCH, SUITABLE TO DRAINING USE.**

MASCHINE ZUR HERSTELLUNG UND FERTIGUNG EINER BERÜHRUNGSWEICHEN UND FÜR ENTWÄSSERUNGSVORGÄNGE VERWENDBAREN ELASTISCHEN FOLIE

MACHINE DESTINÉE À LA PRODUCTION ET LA FABRICATION D'UN FILM ÉLASTIQUE DOUX AU TOUCHER, APPROPRIÉ AU DRAINAGE

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Description

[0001] There exists in the related art, disposable hygienic articles for women, such as absorbent pads, panty liners and internal tampons. It is known that many such articles have a side in contact with the consumer formed by a perforated film with three dimensional apertures. These apertures quickly collect body fluids while remaining dry and clean after the passage of the body fluids.

[0002] The disadvantage of such perforated films is the visual and tactile plastic sensation, which is unpleasant to consumers.

[0003] It is therefore desirable to have available a three dimensional apertured film that is soft to the touch and has a similar appearance to a textile material, whilst maintaining the handling characteristics of the body fluids as per the above mentioned perforated films

[0004] Currently there exists the production of film with micro perforations. There also exists production of films with a type of micro aperture in 3 dimensions which make the material soft to the touch.

[0005] These micro cones can be formed with pressurized water technology or by pneumatic vacuum forming. Both mentioned process are known art.

[0006] An improvement of the process and result has been obtained by applying a series of three dimensional apertured macro cones to the film containing micro perforations, which results in improved draining capabilities of the product.

[0007] The construction of the macro cones must be such so as not to destroy the micro cones produced beforehand.

[0008] Such a result can be obtained in different ways.

[0009] In patent n. US 4.839.216, as in patent US 4.609.518, is taught the construction of non shaped macro holes on a film where micro apertures are already present, using a pressurised water technology.

[0010] Such a method does not thermoform the macro cones, so limiting the draining properties of the film.

[0011] In patent US 6.780.372, is taught a method for creating thermoformed macro holes whereby the film is locally treated in the thermoforming zone without heating the surrounding area of micro holes.

[0012] Whilst the technique of perforating with hot needles is known art, the disadvantage of the macro cones thermoforming process is the tendency to stiffen the film,

[0013] Also the film tends to stick to the needles creating difficulties in detachment.

[0014] In the application of Patent US 2.004.161.586, the problem of fused material rims made around the thermo fused cone is solved by interposing a layer of high melting material so as to avoid direct contact between the film and the hot needles.

[0015] The high melting material being mechanically more resistant compared to the film to be processed, greatly helps the detachment of the film from the hot needles.

[0016] The disadvantages of this last process is that

the insertion of the mentioned high melting material means an increase in the cost of the film and an unwanted increase in thickness.

[0017] DE 101 32 196 upon which the preamble of claims 1 and 4 are based, discloses a perforating apparatus having a perforating roller with projections, coupled with a counter-roller with corresponding apertures. A third roller is also coupled to the perforating roller. A thermoplastic structure is fed between the perforating roller and the counter roller and, once perforated, between the perforating roller and the third roller.

SUMMARY OF INVENTION

[0018] The purpose of this invention is the manufacture of a film apertured three dimensionally, soft to the touch, resilient, and with a matt finish, suitable for the efficient correct handling of body fluids, that eliminates the above mentioned disadvantages of the film and the processes to obtain it.

[0019] Such a film shows, at least on one side, an almost continuous pattern of three dimensional micro cones, arranged according to an axis close to perpendicular to the surface from where the micro apertures have their origin.

[0020] On the opposite side, there is a continuous pattern composed of three dimensional macro cones arranged according to an axis close to perpendicular to the surface from where the macro cones have their origin, where the orientation of the mentioned micro cones and the macro cones are opposite.

[0021] The term "micro cones" refers to cones not discernible by human eye at a distance equal to or greater than 450mm while the term "macro cones" refers to cones clearly visible by human eye at a distance greater than 450mm.

[0022] Because the macro cones are thermoformed on thermoplastic film that already contains the micro cones, the process can cause over-destruction of the micro cones. The technical problem to be solved is to thermoform the macro cones without damaging the micro cones previously made and at the same time maintain the softness of the obtained film.

[0023] Technical solutions available today allow a process to thermoform cones using hot needle technology, forcing the film to pass through a calander where, on one reel there are needles while on the other there are holes, each needles fits in the corresponding slot on the other reel, perforating and forcing the contact between needles and film so that thermoforming can occur.

[0024] Nevertheless, the time of contact between needles and film is very limited in order to avoid that the whole film reaches temperatures near the softening point, a condition which would prevent the detachment of the film from the needle reel.

[0025] Short contact times between needles and film require a higher needle temperature which will melt the thermoplastic film locally also after cooling, the thermo-

plastic film will harden creating an unpleasant effect to the touch.

[0026] Lower film gsm imposed by the market make the actual hot needle technologies not viable for the above mentioned reason.

DESCRIPTION OF DRAWINGS

[0027]

Fig.1 shows schematically the travel of the micro perforated film between the hot needle calander and perforated reel for the thermoforming of the macro cones and between the hot needle calander and the vacuum reel for the detachment from the needles.

Fig.2 shows schematically the travel of the product through a series of grooved reels so as to obtain localised stretching

Fig.3 shows schematically the film with micro holes and macro holes formed in opposite directions

TECHNICAL DESCRIPTION OF INVENTION

[0028] This document explains how to obtain thermoformed macro holes on a thermoplastic matrix where there already exists micro apertures, and to maintain the performance of collection and retention of the discharge of the body fluids and also achieving desirable tactile and visual properties, soft to the touch ,even distribution of holes and of a matt finish.

[0029] In order to avoid the localized over melting of the thermoplastic film it is necessary to work with temperatures lower than the melting point .To achieve correct formation of the holes it is necessary to work with temperatures above the softening point but substantially below the melting point thus it is necessary to have a much longer contact time between the needles and the film.

[0030] The formation of the cone happens by forcing the travel of the film between the needles of the first reel and the corresponding slots in the second reel. Once the cones are created, the film is left in contact with the needles for sufficient time to effect the correct thermo formation. This involves that the whole film reaches a temperature near to the softening point making the detachment of the film from the needles unfeasible with a simple pull because the cohesion force between the needles and the film is such as to ruin the material. This unwanted effect is even more enhanced by use of lower film gsm. To solve this problem a third perforated reel is used. This reel is composed of an external sleeve with holes distributed in such a way that during the rotation each slot engages with a corresponding needle.

[0031] The external sleeve rotates on a hollow fixed shaft. The hollow fixed shaft has opening along its length wide enough to cover the contact area between the needles and the third perforated reel. A vacuum is formed inside the hollow fixed shaft which generates a pulling

force at the base of the thermoformed cone such as to detach the film from the needles without incurring damage to the film.

[0032] Even though the thermoforming process has been slowed minimising the annealing of the films, it is impossible to completely eliminate some hardened or stiffened areas caused by the heating process.

[0033] To further minimise this hardening a further step has been developed whereby the film is passed through one or more grooved reels.

[0034] The film is appropriately stretched locally so as to break and soften the areas hardened in the thermoforming process especially around the macro cones.

[0035] Another method that the invention can employ to detach the thermoplastic film from the needles is by using electrostatic electricity, by which, instead of creating a depressurised area, can charge the film on the third perforated reel with electrostatic charge of opposite polarity, in such a way that an electrostatic force is generated at the base of the thermoformed cones this force detaches the film from the needles, in a way similar to the method described in the previous point.

[0036] The localised stretching system can have grooves in both axial or radial directions, therefore creating localised stretching in machine direction or in cross direction.

[0037] As can be seen in Fig.1, thermoplastic film n.1 (normally ldpe and lldpe base) is extruded with cast technology.

[0038] The film still in a plastic condition is laid on a matrix 7 that has a variety of micro apertures with a density between 140 holes per sq.cm to 1024 holes per sq.cm and is immediately put under vacuum making the film implode and thus creating the three dimensional micro cones.

[0039] The film is left in contact with the matrix for enough time to elapse so that the temperature of the film changes to a temperature that allows the detachment of the film from the matrix.

[0040] Such formed film n.2 is now ready for the macro perforation.

[0041] Subsequently a reel 3 with needles, appropriately thermo regulated at a temperature near to the thermo forming temperature of the thermoplastic film is set to rotate and is synchronised with the pair of perforated reels 4 and 5 with a density of holes equal to the density of needles.

[0042] Both perforated reels can be thermo regulated.

[0043] The perforated reel 4 has the function of creating the three dimensional cone and can be substituted by a brush reel with high density of bristles. Perforated reel 5 has the function of detaching the perforated film from the needles.

[0044] The micro perforated film is passed through the pair of reels 3, 4 creating the three dimensional macro apertures.

[0045] The film is then left in contact with the needles for the necessary time to achieve a correct thermoform-

ing. Such a method allows much lower operating temperatures compared to known methods. In fact such a long contact time between film and needle allows operating temperatures of needles near to thermoforming ones or in any case lower than the fusion temperature of the film, limiting the phenomenon of annealing which makes the film rough and wrinkled.

[0046] Increasing the contact time between the film and the needles limits the annealing effect on the film but unfortunately the whole film reaches a higher temperature making it difficult to detach the film from the needles. The film in contact with the needles should maintain a temperatures preferably between approximately 50 and 60 degrees C;

[0047] It is known that low gsm films (15-30 gsm) at such high temperatures drastically lose their mechanical characteristics, so that the adhesion force between the needles and just formed macro holes can be such that it makes it unfeasible to detach the film using a force acting directly on the film as this would damage the film.

[0048] To achieve successful detachment without damaging the product it is desirable to apply the detaching force to the bottom of the macro holes. The perforated reel 5 has a pneumatic vacuum chamber so to exert a light force on the base of the macro cones, during rotation, the force exerted by the pneumatic vacuum detaches the film from the needles without modifying the characteristics of the product.

[0049] Also the volume of air that crosses the depressurised sector cools the macro cones just formed.

[0050] The film has been detached from the needles by vacuum and travels away from the vacuum aperture and thus free of any rollers.

[0051] The film 6, 206 has micro cones 207 produced by micro perforation and macro cones 208 produced by macro perforation.

[0052] The product is now passed through one or more pairs of reels 101, 102 grooved as indicated in Fig.2.

[0053] Film 103 is suitably stretched so to break eventual hardened areas by the thermo forming process especially around the macro cones.

[0054] Film 104 is ready to be cooled and winded.

Claims

1. A procedure for obtaining thermoformed macro holes (208) on a thermoplastic film (1) already having micro holes (207) consisting in:

- making the thermoplastic film (1) pass between a first reel (3) with multiple needles on its surface and a second reel (4) with multiple grooves,
- maintaining the thermoplastic film (1) adhered to the reel carrying the needles and at a temperature close to the softening point and lower than the melting point of the film (1),
- removing the thermoplastic film (1) from con-

tact with the reel carrying the needles via a third reel (5) that is perforated on the surface,

wherein the multiple needles of the first reel (3) are coupled during rotation into the grooves of the second reel (4) and in the perforations of the third reel (5), **characterised in that**

the third reel (5) will exert an adhesion strength on the thermoplastic film (1) that is greater than the adhesion strength of the film (1) to the reel incorporating the needles, which adhesion strength of the third reel (5) on the thermoplastic film (1) is performed using a vacuum or by means of electrostatic electricity charged with opposite polarity to that of the third reel (5) and the thermoplastic film (1).

2. A procedure for obtaining thermoformed macro holes (208) on a thermoplastic film (1) already having micro holes (207) according to claim 1, **characterised in that** the thermoplastic film (1) obtained is additionally passed through one or more grooved reels (101, 102), causing the thermoformed film (1) to stretch and breaking the hardened areas around the conformed macro holes (208).

3. A procedure for obtaining thermoformed macro holes (208) on a thermoplastic film (1) already having micro holes (207) according to claim 2, **characterised in that** the thermoplastic film (1) is made to pass through axial and/or radial reels, achieving axial and/or radial stretching of the film (1).

4. A device for obtaining a thermoplastic film (1) with macro holes (208) that already has micro holes (207) formed by a first reel (3) with multiple needles on its surface and a second reel (4) with multiple grooves that are coupled to one another during the rotation of the reels, wherein in order to remove the thermoplastic film (1) from the reel with multiple needles on its surface, the device comprises a third reel (5) with a perforated surface, wherein these perforations are coupled with the needles of the first reel (3) during its rotation,

characterised in that the third perforated reel uses a vacuum or electrostatic electricity in order to remove the thermoplastic film (1) from the reel with the multiple needles.

5. A device for obtaining a thermoplastic film (1) with macro holes (208) that already has micro holes (207) formed according to claim 4, **characterised in that** the third reel (5) has:

- a fixed and hollow shaft with an opening along its entire length that is sufficiently wide to cover the contact area between the needles and the third perforated reel and inside of which a vacuum is formed;

- an outer jacket that rotates around the fixed and hollow shaft.

6. A device for obtaining a thermoplastic film (1) with macro holes (208) that already has micro holes (207) formed according to claim 4 or 5, additionally **characterised in that** the device comprises one or more grooved reels (101, 102) that cause the thermoformed film (1) to stretch, breaking the hardened areas around the conformed macro holes (208).
7. A device for obtaining a thermoplastic film (1) with macro holes (208) that already has micro holes (207) formed according to claim 6, **characterised in that** the grooved reels (101, 102) are arranged as axial and/or radial reels that cause the film (1) to stretch in an axial and/or radial direction.

Patentansprüche

1. Verfahren zum Erlangen wärmegeformter Makrolöcher (208) auf einem thermoplastischen Film (1), der bereits Mikrolöcher (207) aufweist, umfassend:
 - Veranlassen, dass sich der thermoplastische Film (1) zwischen einer ersten Rolle (3) mit mehreren Nadeln auf ihrer Oberfläche und einer zweiten Rolle (4) mit mehreren Nuten bewegt,
 - Aufrechterhalten eines Anhaftens des thermoplastischen Films (1) an der Rolle, die die Nadeln trägt, bei einer Temperatur, die nahe dem Erweichungspunkt und niedriger als der Schmelzpunkt des Films (1) ist,
 - Entfernen des thermoplastischen Films (1) von einem Kontakt mit der Rolle, die die Nadeln trägt, über eine dritte Rolle (5), die auf der Oberfläche perforiert ist,

wobei die mehreren Nadeln der ersten Rolle (3) während einer Drehung in die Nuten der zweiten Rolle (4) gekoppelt werden, sowie in die Perforationen der dritten Rolle (5), **dadurch gekennzeichnet, dass** die dritte Rolle eine Haftkraft auf den thermoplastischen Film (1) aufbringen wird, die größer ist als die Haftkraft des Films (1) an der Rolle, die die Nadeln enthält, wobei die Haftkraft der dritten Rolle (5) auf den thermoplastischen Film (1) ausgeübt wird, indem ein Vakuum verwendet wird oder durch elektrostatische Elektrizität, welche mit entgegengesetzter Polarität zu der der dritten Rolle (5) und des thermoplastischen Films (1) geladen ist.
2. Verfahren zum Erlangen wärmegeformter Makrolöcher (208) auf einem thermoplastischen Film (1), der bereits Mikrolöcher (207) aufweist, nach Anspruch 1, **dadurch gekennzeichnet, dass** der erlangte thermoplastische Film (1) zusätzlich durch eine oder

mehrere mit Nuten versehene Rollen (101, 102) bewegt wird, wodurch eine Streckung des wärmegeformten Films (1) und ein Brechen der gehärteten Bereiche um die konformen Makrolöcher (208) veranlasst wird.

3. Verfahren zum Erlangen wärmegeformter Makrolöcher (208) auf einem thermoplastischen Film (1), der bereits Mikrolöcher (207) aufweist, nach Anspruch 2, **dadurch gekennzeichnet, dass** der thermoplastische Film (1) veranlasst wird, sich durch axiale und/oder radiale Rollen zu bewegen, wodurch ein axiales und/oder radiales Strecken des Films (1) erreicht wird.
4. Vorrichtung zum Erlangen eines thermoplastischen Films (1) mit Makrolöchern (208), der bereits Mikrolöcher (207) aufweist, gebildet durch eine erste Rolle (3) mit mehreren Nadeln auf ihrer Oberfläche und eine zweite Rolle (4) mit mehreren Nuten, welche miteinander während der Drehung der Rollen gekoppelt sind, wobei zum Entfernen des thermoplastischen Films (1) von der Rolle mit mehreren Nadeln auf ihrer Oberfläche die Vorrichtung eine dritte Rolle (5) mit einer perforierten Oberfläche aufweist, wobei diese Perforationen mit den Nadeln auf der ersten Rolle (3) während ihrer Drehung gekoppelt werden, **dadurch gekennzeichnet, dass** die dritte perforierte Rolle ein Vakuum oder elektrostatische Elektrizität verwendet, um den thermoplastischen Film (1) von der Rolle mit den mehreren Nadeln zu entfernen.
5. Vorrichtung zum Erlangen eines thermoplastischen Films (1) mit Makrolöchern (208), der bereits Mikrolöcher (207) aufweist, gebildet nach Anspruch 4, **dadurch gekennzeichnet, dass** die dritte Rolle (5) aufweist:
 - eine feste und hohle Welle mit einer Öffnung entlang ihrer gesamten Länge, die ausreichend breit ist, um die Kontaktfläche zwischen den Nadeln und der dritten perforierten Rolle abzudecken, und innerhalb von welcher ein Vakuum ausgebildet wird;
 - eine äußere Umhüllung, die sich um die feste und hohle Welle dreht.
6. Vorrichtung zum Erlangen eines thermoplastischen Films (1) mit Makrolöchern (208), der bereits Mikrolöcher (207) aufweist, gebildet nach Anspruch 4 oder 5, zusätzlich **dadurch gekennzeichnet, dass** die Vorrichtung eine oder mehrere mit Nuten versehene Rollen (101, 102) aufweist, die ein Strecken des thermoplastischen Films (1) und ein Brechen der gehärteten Bereiche um die konformen Makrolöcher (208) veranlassen.
7. Vorrichtung zum Erlangen eines thermoplastischen

Films (1) mit Makrolöchern (208), der bereits Mikrolöcher (207) aufweist, gebildet nach Anspruch 6, **dadurch gekennzeichnet, dass** die mit Nuten versehenen Rollen (101, 102) als axiale und/oder radiale Rollen angeordnet sind, die veranlassen, dass der Film (1) in axiale und/oder radiale Richtung gestreckt wird.

Revendications

1. Procédure pour obtenir des macro-trous thermoformés (208) sur un film thermoplastique (1) ayant déjà des micro-trous (207) consistant à :

- faire passer le film thermoplastique (1) entre un premier cylindre (3) avec de multiples aiguilles sur sa surface et un deuxième cylindre (4) avec de multiples cannelures,
- maintenir le film thermoplastique (1) en adhésion sur le cylindre portant les aiguilles et à une température proche du point de ramollissement et inférieure au point de fusion du film (1),
- enlever le film thermoplastique (1) du contact avec le cylindre portant les aiguilles par le biais d'un troisième cylindre (5) qui est perforé sur la surface,

dans laquelle les multiples aiguilles du premier cylindre (3) sont couplées pendant la rotation dans les cannelures du deuxième cylindre (4) et dans les perforations du troisième cylindre (5),

caractérisée en ce que

le troisième cylindre (5) exercera une résistance à l'adhésion sur le film thermoplastique (1) qui est supérieure à la résistance à l'adhésion du film (1) sur le cylindre incorporant les aiguilles, ladite résistance à l'adhésion du troisième cylindre (5) sur le film thermoplastique (1) étant réalisée en utilisant un vide ou au moyen d'électricité électrostatique chargée avec une polarité opposée à celle du troisième cylindre (5) et du film thermoplastique (1).

2. Procédure pour obtenir des macro-trous thermoformés (208) sur un film thermoplastique (1) ayant déjà des micro-trous (207) selon la revendication 1, **caractérisée en ce que** le film thermoplastique (1) obtenu est en outre passé à travers un ou plusieurs cylindres cannelés (101, 102), provoquant l'étirement du film thermoformé (1) et cassant les zones durcies autour des macro-trous conformés (208).
3. Procédure pour obtenir des macro-trous thermoformés (208) sur un film thermoplastique (1) ayant déjà des micro-trous (207) selon la revendication 2, **caractérisée en ce que** l'on fait passer le film thermoplastique (1) à travers des cylindres axiaux et/ou radiaux, atteignant un étirement axial et/ou radial du

film (1).

4. Dispositif pour obtenir un film thermoplastique (1) avec des macro-trous (208) ayant déjà des micro-trous (207) formés par un premier cylindre (3) avec de multiples aiguilles sur sa surface et un second cylindre (4) avec de multiples cannelures qui sont couplées les unes aux autres pendant la rotation des cylindres, dans lequel, afin d'enlever le film thermoplastique (1) du cylindre avec de multiples aiguilles sur sa surface, le dispositif comprend un troisième cylindre (5) avec une surface perforée, dans laquelle ces perforations sont couplées avec les aiguilles du premier cylindre (3) pendant sa rotation,

caractérisé en ce que le troisième cylindre perforé utilise un vide ou de l'électricité électrostatique afin d'enlever le film thermoplastique (1) du cylindre avec les multiples aiguilles.

5. Dispositif pour obtenir un film thermoplastique (1) avec des macro-trous (208) ayant déjà des micro-trous (207) formés selon la revendication 4, **caractérisé en ce que** le troisième cylindre (5) a :

- un arbre fixe et creux avec une ouverture sur toute sa longueur qui est suffisamment large pour couvrir la zone de contact entre les aiguilles et le troisième cylindre perforé et à l'intérieur duquel un vide est formé ;
- un revêtement extérieur qui tourne autour de l'arbre fixe et creux.

6. Dispositif pour obtenir un film thermoplastique (1) avec des macro-trous (208) ayant déjà des micro-trous (207) formés selon la revendication 4 ou 5, **caractérisé en outre en ce que** le dispositif comprend un ou plusieurs cylindres cannelés (101, 102) qui provoquent l'étirement du film thermoformé (1), en cassant les zones durcies autour des macro-trous conformés (208).

7. Dispositif pour obtenir un film thermoplastique (1) avec des macro-trous (208) ayant déjà des micro-trous (207) formés selon la revendication 6, **caractérisé en ce que** les cylindres cannelés (101, 102) sont disposés comme des cylindres axiaux et/ou radiaux qui provoquent l'étirement du film (1) dans une direction axiale et/ou radiale.

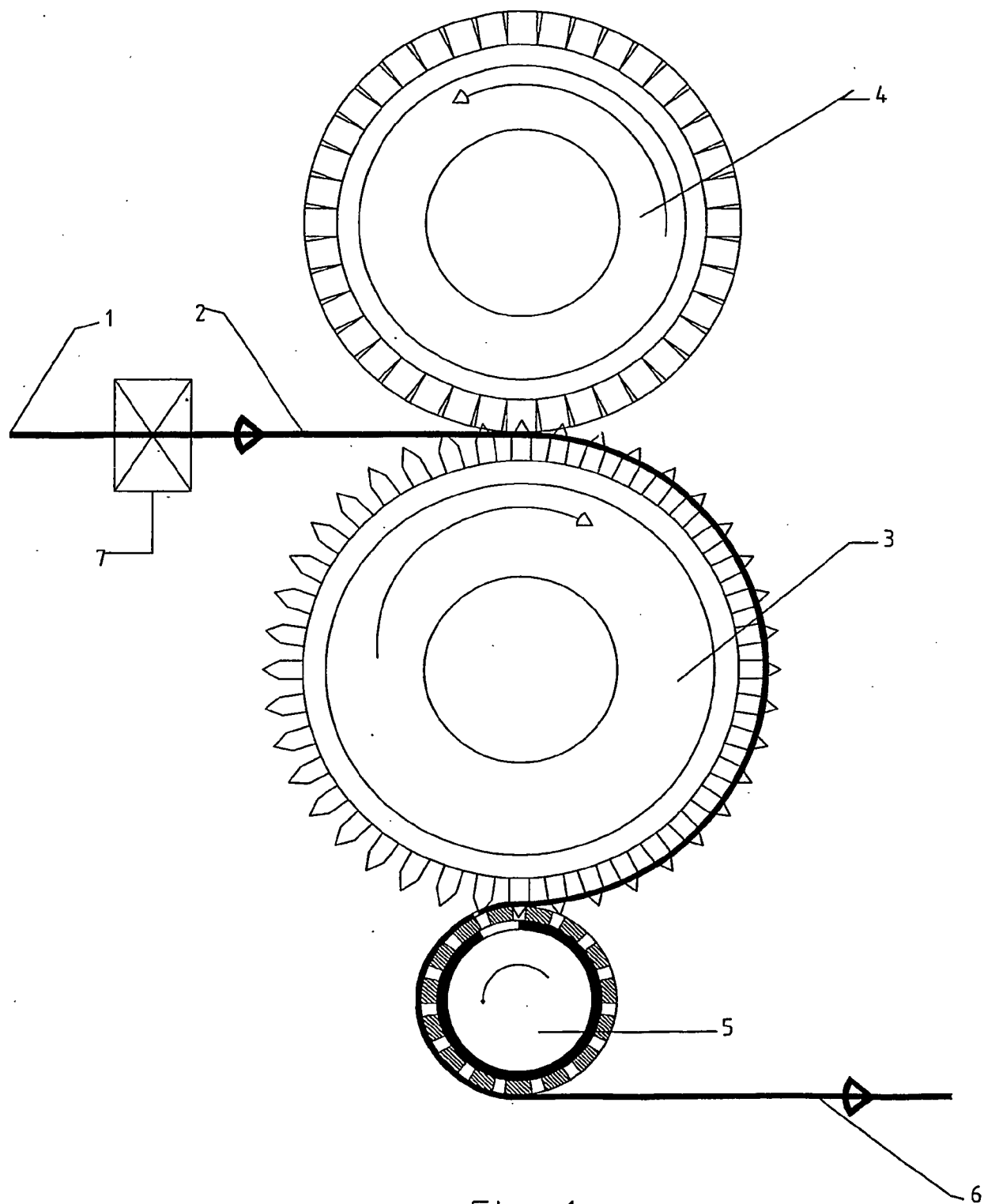


Fig. 1

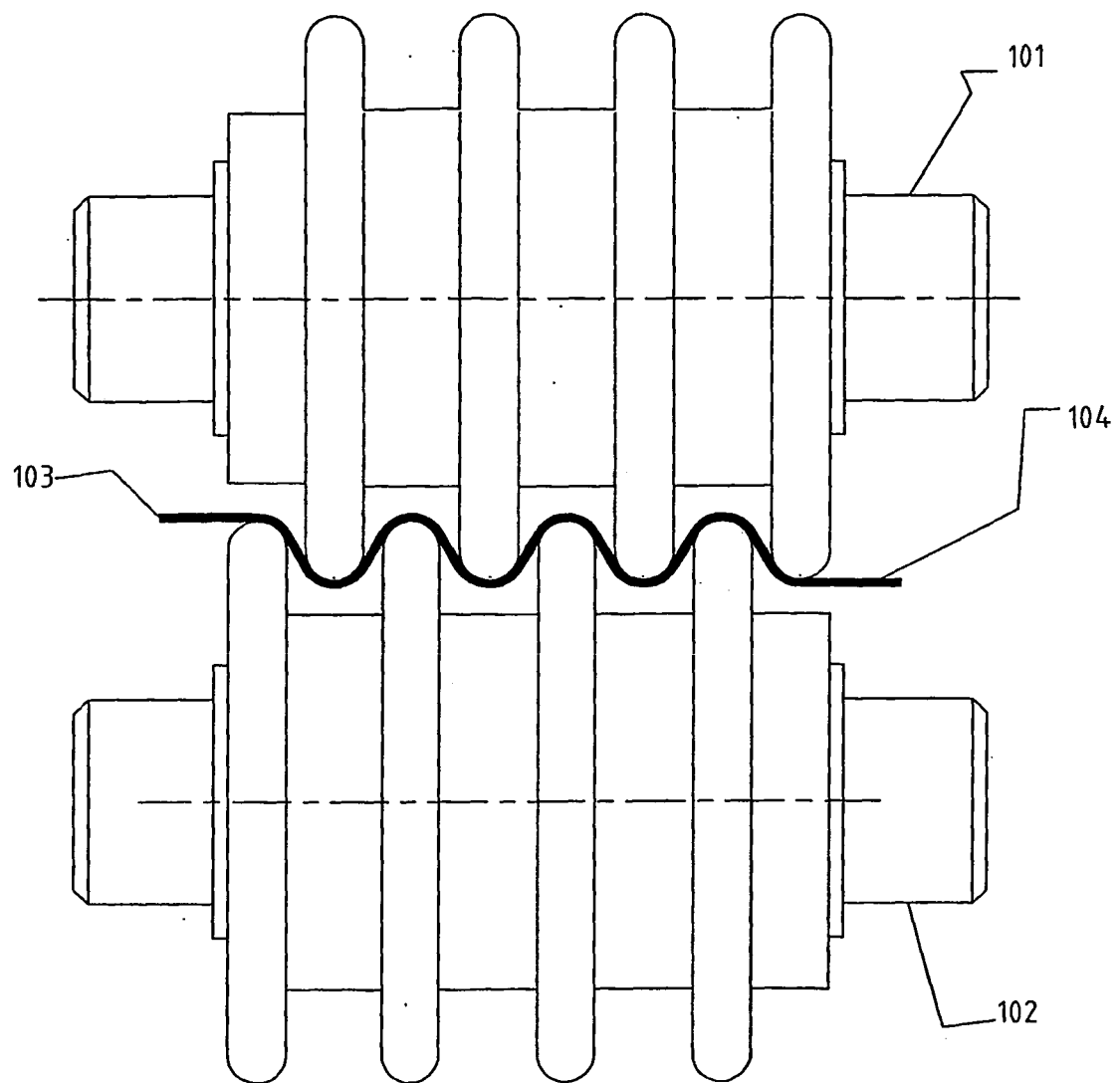


Fig. 2

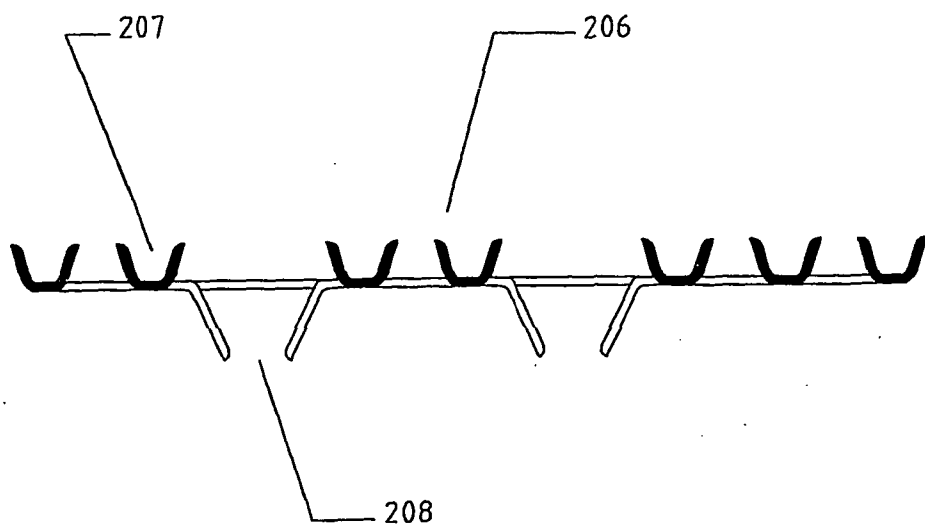


Fig. 3

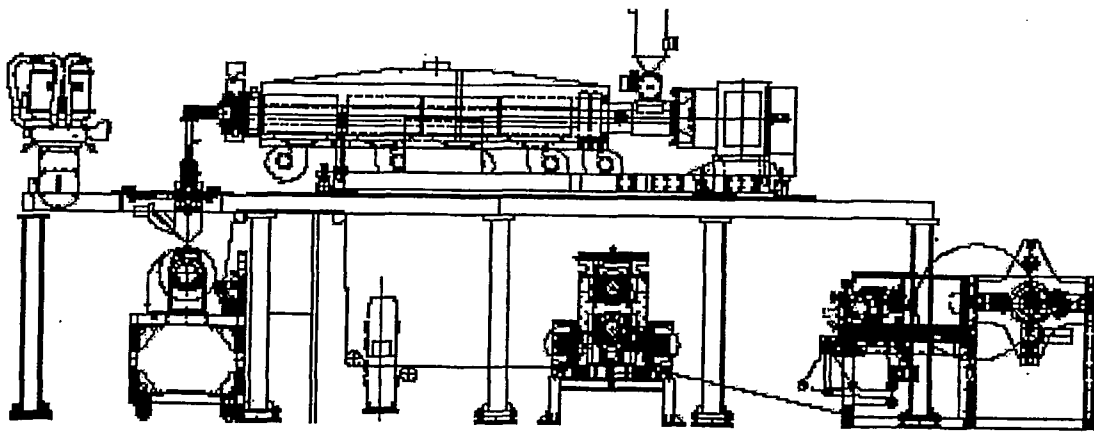


Fig. 4

REFERENCES CITED IN THE DESCRIPTION

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Patent documents cited in the description

- US 4839216 A [0009]
- US 4609518 A [0009]
- US 6780372 B [0011]
- US 2004161586 A [0014]
- DE 10132196 [0017]



1. Eljárás hőformázott makrolyukaknak (208) egy, már mikrolyukakkal (207) rendelkező hőre lágyuló fólián (1) való előállítására, amely során:

- átvezetjük a hőre lágyuló fóliát (1) egy, a felületén több tűvel rendelkező első görgő (3) és egy, több horonnyal rendelkező második görgő (4) között,
- fenntartjuk a hőre lágyuló fólia (1) tűket hordozó görgőhöz való tapadását, és olyan hőmérsékleten tartjuk, amely a lágyulásponthoz közeli és a fólia (1) olvadáspontjánál alacsonyabb,
- eltávolítjuk a hőre lágyuló fóliát (1) a tűket hordozó görgővel való érintkezésből egy harmadik görgőn (5) keresztül, amely a felületen át van lyukasztva,

ahol az első görgő (3) tűit forgás közben a második görgő (4) hornyaiba és a harmadik görgő (5) lyuksorozataiba csatlakoztatjuk,

azzal jellemezve, hogy

a harmadik görgő (5) olyan tapadási erőt fejt ki a hőre lágyuló fólián (1), amely nagyobb, mint a fóliának (1) a tűkkel ellátott görgőhöz való tapadási ereje, ahol a harmadik görgő (5) tapadási erejét a hőre lágyuló fóliához (1) vákuum használatával vagy a harmadik görgőhöz (5) és a hőre lágyuló fóliához (1) képest ellentétes polaritású elektrosztatikus hatás révén fejtjük ki.

2. Az 1. igénypont szerinti eljárás hőformázott makrolyukaknak (208) egy, már mikrolyukakkal (207) rendelkező hőre lágyuló fólián (1) való előállítására, **azzal jellemezve**, hogy az előállított hőre lágyuló fóliát (1) továbbá egy vagy több hornyolt görgőn (101, 102) vezetjük át, amely a hőre lágyuló fólia (1) megnyúlását és az egyidejűleg kiképzett makrolyukak (208) körüli megkeményedett területek megtörését okozza.

3. A 2. igénypont szerinti eljárás hőformázott makrolyukaknak (208) egy, már mikrolyukakkal (207) rendelkező hőre lágyuló fólián (1) való előállítására, **azzal jellemezve**, hogy a hőre lágyuló fóliát (1) tengelyirányú és/vagy sugárirányú görgőkön úgy vezetjük át, hogy a fólia (1) tengelyirányú és/vagy sugárirányú megnyúlását elérjük.

4. Eszköz egy, már mikrolyukakkal (207) rendelkező hőre lágyuló fóliának (1) makrolyukkal (208) való előállítására, amely egy, a felületén több tűvel rendelkező első görgő (3) és egy, több horonnyal rendelkező második görgő (4) által van kialakítva, amelyek a görgők forgása során egymáshoz csatlakoznak, ahol a hőre lágyuló fóliának (1) a felületén több tűvel rendelkező görgőről való eltávolítása végett az eszköz egy, perforált felülettel rendelkező harmadik görgőt (5) tartalmaz, ahol ezek a lyuksorozatok az első görgő (3) tűivel összekapcsolódnak ennek a forgása során,

azzal jellemezve, hogy a harmadik perforált görgő a hőre lágyuló fóliának (1) a több tűvel rendelkező görgőről történő eltávolítása érdekében vákuumot vagy elektrosztatikus töltést alkalmaz.

5. A 4. igénypont szerinti eszköz egy, már mikrolyukakkal (207) kialakított hőre lágyuló fóliának (1) makrolyukkal (208) való előállítására, **azzal jellemezve**, hogy a harmadik görgő (5) rendelkezik:

- egy, a teljes hossza mentén egy nyílással rendelkező rögzített és üreges tengellyel, amely elég széles, hogy a tűk és a harmadik perforált görgő közötti érintkezési tartományt befedje, és amely tengely belsejében vákuum van;
- egy, a rögzített és üreges tengely körül forgatott külső borítással.

6. A 4. vagy az 5. igénypont szerinti eszköz egy, már mikrolyukakkal (207) kialakított hőre lágyuló fóliának (1) makrolyukkal (208) való előállítására, **továbbá azzal jellemezve**, hogy az eszköz egy vagy több, a hőre lágyuló fólia (1) megnyúlását, és az egyidejűleg kiképzett makrolyukak (208) körüli megkeményedett területek megtörését okozó hornyolt görgőt (101, 102) tartalmaz.

7. A 6. igénypont szerinti eszköz egy, már mikrolyukakkal (207) kialakított hőre lágyuló fóliának (1) makrolyukkal (208) való előállítására, **azzal jellemezve**, hogy a hornyolt görgők (101, 102) a fólia (1) tengelyirányú és/vagy sugárirányú megnyúlását okozó tengelyirányú és/vagy sugárirányú görgökként vannak elrendezve.