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(71) Applicant: **3M INNOVATIVE PROPERTIES COMPANY** [US/US]; 3M Center, Post Office Box 33427, Saint Paul, Minnesota 55133-3427 (US).

(72) Inventors: **ZHANG, Yifan**; 3M Center, Post Office Box 33427, Saint Paul, Minnesota 55133-3427 (US). **QIU, Zai-Ming**; 3M Center, Post Office Box 33427, Saint Paul, Minnesota 55133-3427 (US). **SONG, Liming**; 3M Center, Post Office Box 33427, Saint Paul, Minnesota 55133-3427 (US).

(74) Agents: **GALLAGHER, Ann, K.** et al.; 3M Center, Office of Intellectual Property Counsel, Post Office Box 33427, Saint Paul, MN 55133-3427 (US).

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(54) Title: FIBERS AND WIPES WITH EPOXIDIZED FATTY ESTER DISPOSED THEREON, AND METHODS

(57) Abstract: Fibers, which can be used for making wipes (e.g., antimicrobial wipes), wherein the fibers include a core comprising an aliphatic polyester; and an epoxidized fatty ester having greater than 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester; wherein the epoxidized fatty ester is disposed on the surface of the fiber core.



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## FIBERS AND WIPES WITH EPOXIDIZED FATTY ESTER DISPOSED THEREON, AND METHODS

### 5 BACKGROUND

There is a trend to manufacture products from renewable resources for global environmental protection. Aliphatic polyesters from renewable resources have found increasing application in materials because of their biodegradability and compostability, such as poly(lactic acid); however, such materials may not have suitable shelf-life stability  
10 for certain applications, particularly in environments of high moisture content due to degradation from hydrolysis. For extended hydrolytic stability of these aliphatic polyesters, reactive additives are commonly used to crosslink terminal –OH and/or –CO<sub>2</sub>H groups as one of the approaches. This may significantly change the molecular weight of the original aliphatic polyester, which may affect its processibility and properties. Thus,  
15 there is a need for hydrolytic stabilization of aliphatic polyesters without reaction between the stabilizer and the aliphatic polyesters.

### SUMMARY OF THE DISCLOSURE

The present disclosure provides fibers, which can be used for making wipes such  
20 as wet wipes for cleaning and/or disinfecting (e.g., antimicrobial wipes). The fibers include aliphatic polyesters with one or more additives that improve the hydrolytic stability of the fibers.

The one or more hydrolytic stabilizing agents can be distributed on the surfaces of the fibers made of an aliphatic polyester. Or, fibers made of an aliphatic polyester can be  
25 saturated with an aqueous composition (e.g., a cleaning and/or disinfecting composition) containing one or more hydrolytic stabilizing agents.

Preferably, the hydrolytic stabilizing agents are selected from epoxidized fatty esters. More preferably, the hydrolytic stabilizing agents are selected from epoxidized vegetable oils (e.g., from renewable resources).

30 In one embodiment, the present disclosure provides a fiber that includes: a core including an aliphatic polyester; and an epoxidized fatty ester having greater than 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester; wherein the epoxidized fatty ester is disposed on the surface of the fiber core in an amount of at least

0.5 wt-%, based on the total weight of the fiber (i.e., the dry weight of the core and the epoxidized fatty ester and any optional additives disposed thereon).

In certain embodiments, the aliphatic polyester is selected from the group of poly(lactide), poly(glycolide), poly(lactide-co-glycolide), poly(L-lactide-co-trimethylene carbonate), poly(dioxanone), poly(butylene succinate), poly(butylene adipate),  
5 poly(ethylene adipate), polyhydroxybutyrate, polyhydroxyvalerate, and blends and copolymers thereof. Preferably, the selected aliphatic polyesters are obtained from renewable resources, such as poly(lactic acid).

In another embodiment, the present disclosure provides a wet wipe that includes:  
10 an aliphatic polyester fibrous web (e.g., a nonwoven web) as described herein; and an aqueous composition in contact with the fibrous web. The aqueous composition may also include one or more organic solvents, such as alcohols (e.g., isopropanol), along with the water.

The aqueous composition can include one or more of an epoxidized fatty ester for  
15 coating the aliphatic polyester and improving the hydrolytic stability of the aliphatic polyester fibrous web. Alternatively, or additionally, the aqueous composition can include a surfactant and/or a biocide (dissolved or dispersed in the water).

In yet another embodiment, the present disclosure provides a wet wipe that includes: a fibrous web including fibers that include: a core including an aliphatic  
20 polyester; and an epoxidized fatty acid having greater than 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester; wherein the epoxidized fatty ester is disposed on the surface of the fiber core in an amount of at least 0.5 wt-%, based on the total weight of the fibers (i.e., dry weight of the fibers including the core and the epoxidized fatty ester and any optional additives disposed on the fiber core, after removal  
25 or the water or any solvents used to apply the epoxidized fatty ester); and an aqueous composition contacting the fibrous web, the aqueous composition including: water; and a surfactant and/or a biocide (dissolved or dispersed in the water).

In still another embodiment, the present disclosure provides a wet wipe that includes: a fibrous web that includes fibers, wherein each fiber includes a core including  
30 an aliphatic polyester; and an aqueous composition contacting the fibrous web, wherein the aqueous composition includes: water; a surfactant and/or a biocide (dissolved or dispersed in the water); and an epoxidized fatty ester having greater than 4.7 wt-% oxirane

oxygen, based on the total weight of the epoxidized fatty ester; wherein the epoxidized fatty ester is dispersed in the aqueous composition in an amount of at least 0.5 wt-%, based on the total weight of the aqueous composition.

In certain embodiments, the aqueous composition includes a surfactant, wherein  
5 the wet wipe is a cleaning wipe.

In certain embodiments, the aqueous composition includes a biocide, wherein the wet wipe is a disinfecting wipe.

In certain embodiments, the aqueous composition includes a biocide and a surfactant, wherein the wet wipe is a cleaning/disinfecting wipe.

10 In certain embodiments, the present disclosure provides a process for improving the hydrolytic stability of fibers that include an aliphatic polyester. The method includes: forming fibers (typically, in the form of a fibrous web) including an aliphatic polyester; and depositing an epoxidized fatty ester on the surface of the fibers in an amount of at least 0.5 wt-%, based on the total weight of the fibers; wherein the epoxidized fatty ester  
15 has at least 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester. The epoxidized fatty ester can be deposited out of an aqueous composition. If so, the fibers can then be dried to remove the water and any organic solvents in the aqueous composition.

In certain embodiments, the present disclosure provides another process for  
20 improving the hydrolytic stability of a fibrous web that includes fibers of an aliphatic polyester. The method includes: forming a fibrous web including fibers including an aliphatic polyester; providing an aqueous composition that includes water, an epoxidized fatty ester in an amount of at least 0.5 wt-%, based on the total weight of the aqueous composition, and optionally, a surfactant and/or a biocide; wherein the epoxidized fatty  
25 ester has at least 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester; and contacting the fibrous web with the aqueous composition to deposit the epoxidized fatty ester thereon. The method can optionally include drying the fibrous web.

The terms “comprises” and variations thereof do not have a limiting meaning where these terms appear in the description and claims. Such terms will be understood to  
30 imply the inclusion of a stated step or element or group of steps or elements but not the exclusion of any other step or element or group of steps or elements. By “consisting of” is meant including, and limited to, whatever follows the phrase “consisting of.” Thus, the

phrase “consisting of” indicates that the listed elements are required or mandatory, and that no other elements may be present. By “consisting essentially of” is meant including any elements listed after the phrase, and limited to other elements that do not interfere with or contribute to the activity or action specified in the disclosure for the listed  
5 elements. Thus, the phrase “consisting essentially of” indicates that the listed elements are required or mandatory, but that other elements are optional and may or may not be present depending upon whether or not they materially affect the activity or action of the listed elements.

The words “preferred” and “preferably” refer to claims of the disclosure that may  
10 afford certain benefits, under certain circumstances. However, other claims may also be preferred, under the same or other circumstances. Furthermore, the recitation of one or more preferred claims does not imply that other claims are not useful, and is not intended to exclude other claims from the scope of the disclosure.

In this application, terms such as “a,” “an,” and “the” are not intended to refer to  
15 only a singular entity, but include the general class of which a specific example may be used for illustration. The terms “a,” “an,” and “the” are used interchangeably with the term “at least one.” The phrases “at least one of” and “comprises at least one of” followed by a list refers to any one of the items in the list and any combination of two or more items in the list.

20 As used herein, the term “or” is generally employed in its usual sense including “and/or” unless the content clearly dictates otherwise.

The term “and/or” means one or all of the listed elements or a combination of any two or more of the listed elements.

Also herein, all numbers are assumed to be modified by the term “about” and  
25 preferably by the term “exactly.” As used herein in connection with a measured quantity, the term “about” refers to that variation in the measured quantity as would be expected by the skilled artisan making the measurement and exercising a level of care commensurate with the objective of the measurement and the precision of the measuring equipment used.

Also herein, the recitations of numerical ranges by endpoints include all numbers  
30 subsumed within that range as well as the endpoints (e.g., 1 to 5 includes 1, 1.5, 2, 2.75, 3, 3.80, 4, 5, etc.).

As used herein, the term “room temperature” refers to a temperature of about 20°C

to about 25°C or about 22°C to about 25°C.

The above summary of the present disclosure is not intended to describe each disclosed embodiment or every implementation of the present disclosure. The description that follows more particularly exemplifies illustrative embodiments. In several places  
5 throughout the application, guidance is provided through lists of examples, which examples can be used in various combinations. In each instance, the recited list serves only as a representative group and should not be interpreted as an exclusive list.

#### DETAILED DESCRIPTION OF ILLUSTRATIVE EMBODIMENTS

10 The present disclosure provides fibers (e.g., fibers for use in making wipes such as wet wipes), and methods of making the fibers. The wet wipes can be used as cleaning or disinfecting wipes (e.g., antimicrobial wipes such as antiviral and/or antibacterial and/or antifungal wipes). Significantly, the wet wipes of the disclosure have advantageous “shelf life” stability.

15 Fibers of the present disclosure include an aliphatic polyester, an epoxidized fatty ester, and an optional shrink reduction additive. In one embodiment, the present disclosure provides a fiber that includes: a core including an aliphatic polyester; and an epoxidized fatty ester having greater than 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester; wherein the epoxidized fatty ester is disposed on the  
20 surface of the fiber core in an amount of at least 0.5 wt-%, based on the total weight of the fiber (i.e., dry weight of the fibers including the core and the epoxidized fatty ester and any optional additives disposed on the fiber core, after removal of the water or any solvents used to apply the epoxidized fatty ester).

Herein, “disposed on” means that the epoxidized fatty ester is coated on, deposited  
25 on, or loaded on, the fiber surface. Thus, the epoxidized fatty ester is not reacted with or blended with the aliphatic polyester or otherwise dispersed throughout the thickness of the fiber core.

In certain embodiments the epoxidized fatty ester is pre-coated onto the fibers including an aliphatic polyester prior to contact with an aqueous composition that includes  
30 water and a surfactant and/or a biocide.

In certain embodiments, the epoxidized fatty ester is included in the aqueous composition that includes water and a surfactant and/or a biocide and is disposed onto the

surface of the fibers including an aliphatic polyester when the fibers come into contact with the aqueous composition.

Generally, the epoxidized fatty ester and the aliphatic polyester are not noticeably reacted with each other such that chemical bonds are formed. That is, relative to the aliphatic polyester, the epoxidized fatty ester is “unreacted.”

Herein, an unreacted epoxidized fatty ester is one that does not noticeably react with the aliphatic polyester during normal thermal processing and does not noticeably increase the molecular weight of the aliphatic polyester or the corresponding viscosity of the aliphatic polyester. In this context, an “unreacted” epoxidized fatty ester is one that remains in a “free” or unreacted state when disposed on fiber of the aliphatic polyester in an amount of at least 80%, or at least 90%, or at least 95%, of the unreacted epoxidized fatty ester based on the analysis by Gel Permeation Chromatography (GPC) of the fiber.

Thus, the present disclosure provides a process for improving the hydrolytic stability of fibers that include an aliphatic polyester. In certain embodiments, the method includes: forming fibers including an aliphatic polyester; and depositing an epoxidized fatty ester on the surface of the fibers in an amount of at least 0.5 wt-%, based on the total weight of fibers (including the core and the epoxidized fatty ester and optional additives disposed on the core); wherein the epoxidized fatty ester has at least 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester.

Fibers can be made by various techniques, including but not limited to, co-extrusion, solvent-based methods, and melt processing techniques such as melt-blown and spunbond processes.

In certain embodiments, the fibers are continuous fibers that form a web (i.e., a network of entangled fibers forming a sheet like or fabric like structure), particularly a nonwoven web (i.e., an assembly of polymeric fibers (oriented in one direction or in a random manner) held together by mechanical interlocking, fusing of thermoplastic fibers, bonding with a suitable binder such as a natural or synthetic polymeric resin, or a combination thereof).

Webs made from the fibers can be woven, nonwoven, or knitted webs. The fibers can include fibers of indefinite length (e.g., filaments), fibers of discrete length (e.g., staple fibers), and multifilament yarns. Suitable manufacturing processes for making nonwoven webs include, but are not limited to, carding, meltblown, wet laid, air laid, or

spunbond. The nonwoven webs may be post processed into other forms. For example, they may be thermal bonded, hydroentangled, needlepunched, embossed, apertured, perforated, microcreped, laminated, etc. in order to provide additional properties. The webs can be single layer or multi-layer constructions, such as SMS (Spunbond,

5 Meltblown, Spunbond) or SMMS webs.

The general methods of making spunbond nonwoven fabric are well known in the art. An exemplary process of making spunbond nonwoven webs is described in U.S. Pat. No. 7,470,389 (Berrigan et al.). Generally, a stream of filaments is extruded from a spin-pack having multiple orifices arranged in a regular pattern and directed through a  
10 processing chamber. The stream of filaments are subsequently cooled and stretched with high speed air jets and deposited onto a collecting belt in a random manner. The collecting belt is generally porous. A vacuum device can be positioned below the collecting belt to assist the fiber deposition onto the collecting belt. The collected mass (web) can be imparted strength and integrity by thermal bonding (e.g., applying heated rolls or passing  
15 hot air through) to partially melt the polymer and fuse the fibers together. The web can be further bonded to improve strength and other properties by mechanical bonding processes such as hydroentangling as described, for example, in U.S. Pat. No. 4,808,467 (Israel et al.).

In certain embodiments, the fibers made using compositions of the present  
20 disclosure are fine fibers, wherein a population of such fibers has a median fiber diameter of no greater than 50  $\mu\text{m}$ , or no greater than 25  $\mu\text{m}$ , or no greater than 20  $\mu\text{m}$ , or no greater than 10  $\mu\text{m}$ , or no greater than 5  $\mu\text{m}$ . In certain embodiments, the fibers are microfibers, wherein a population of such fibers has a median fiber diameter of at least one  $\mu\text{m}$  but no greater than 100  $\mu\text{m}$ . In certain embodiments, the fibers are ultrafine microfibers, wherein  
25 a population of such fibers has a median fiber diameter of two  $\mu\text{m}$  or less. In certain embodiments, the fibers are sub-micrometer fibers, wherein a population of such fibers has a median fiber diameter of no greater than one  $\mu\text{m}$ .

Once made, the fibers, or more typically a web of the fibers, an epoxidized fatty ester can be disposed thereon either by depositing the epoxidized fatty ester on the surface  
30 of the fibers (or more typically, a web of the fibers) by techniques such as spraying, dipping, and/or soaking, and optionally drying. Typically, an amount of at least 0.5 wt-%, based on the total weight of the fibers, of an epoxidized fatty ester is deposited on the



fibers, wherein the amount is based on the dry weight of the fibers (including the core and the epoxidized fatty ester and any optional additives disposed on the fiber core, after removal or the water or any solvents used to apply the epoxidized fatty ester).

Alternatively, the fibers can be provided in a useable form, e.g., in a fibrous web, and combined with an aqueous composition that includes an epoxidized fatty ester in an amount of at least 0.5 wt-%, based on the total weight of the aqueous composition. The aqueous composition can also include a surfactant and/or a biocide (dissolved or dispersed in the water) as is provided, for example, in commercial cleaning and/or disinfecting compositions. The aqueous composition may also include one or more organic solvents, such as alcohols (e.g., isopropanol), along with the water.

The addition of an epoxidized fatty ester additive to the surface of an aliphatic polyester fiber improves the hydrolytic stability of the aliphatic polyester fibers, and hence, the “shelf life” of the fibers.

An improvement in the hydrolytic stability of fibers that include an aliphatic polyester can be demonstrated by an improvement in the tensile strength of the fibers forming a web, and optionally the dimensional stability (e.g., if a shrink reduction additive is used), of the fibers forming a web, particularly after aging in an aqueous medium.

Typically, improvement in tensile strength means that a web made of fibers of the present disclosure demonstrates greater than 10% increase in tensile strength after aging at a temperature of 135°F for at least 25 days (in an aqueous cleaning and/or disinfecting solution as exemplified in the Examples Section), compared to a web made of fibers of the same aliphatic polyester without such additives.

Typically, improvement in dimensional stability means that a web made of fibers of the present disclosure has at least one dimension which shrinks by no greater than 10% (preferably, no greater than 5%) in the plane of the web when the web is heated to a temperature above a glass transition temperature of the fibers, but below the melting point of the fibers in an unrestrained (i.e., free to move) condition, as compared to a web made of fibers of the same aliphatic polyester without such additives.

In certain situations, compositions of the present disclosure may have shrinkage problems since epoxidized fatty esters, such as epoxidized vegetable oils, are well known as plasticizers that can significantly reduce the crystallinity of an aliphatic polyester. The addition of an optional shrinkage reduction additive in combination with the aliphatic

polyester in the fiber core can thus provide a reduction in shrinkage. Typically, reduction in shrinkage means a demonstration of greater than 5% decrease in shrinkage compared to a web made of fibers of the same aliphatic polyester and epoxidized fatty ester combination without such shrink reduction additive.

5

### Aliphatic Polyesters

Aliphatic polyesters useful in embodiments of the present disclosure include homo- and co-polymers of poly(hydroxyalkanoates), and homo- and co-polymers of those aliphatic polyesters derived from the reaction product of one or more polyols with one or more polycarboxylic acids that is typically formed from the reaction product of one or

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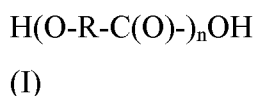
more alkanediols with one or more alkanedicarboxylic acids (or acyl derivatives). Aliphatic polyesters may further be derived from multifunctional polyols, e.g. glycerin, sorbitol, pentaerythritol, and combinations thereof, to form branched, star, and graft homo- and co-polymers.

15

Exemplary aliphatic polyesters are poly(lactic acid), poly(glycolic acid), poly(lactic-co-glycolic acid), polybutylene succinate, polyethylene adipate, polyhydroxybutyrate, polyhydroxyvalerate, blends, and copolymers thereof. One particularly useful class of aliphatic polyesters are poly(hydroxyalkanoates), derived by condensation or ring-opening polymerization of hydroxy acids, or derivatives thereof.

20

Suitable poly(hydroxyalkanoates) may be represented by the Formula (I):



25

wherein: R is an alkylene moiety that may be linear or branched having 1 to 20 carbon atoms, preferably having 1 to 12 carbon atoms, more preferably having 1 to 6 carbon atoms; and n is a number such that the ester is polymeric, and is preferably a number such that the molecular weight of the aliphatic polyester is at least 8,000 daltons (Da).

30

In Formula (I), R may further include one or more catenary (i.e., in chain) ether oxygen atoms. That is, R may optionally be substituted by catenary (bonded to carbon atoms in a carbon chain) oxygen atoms. Generally, the R group of the hydroxy acid is such that the pendant hydroxyl group is a primary or secondary hydroxyl group.

Useful poly(hydroxyalkanoates) include, for example, homo- and copolymers of

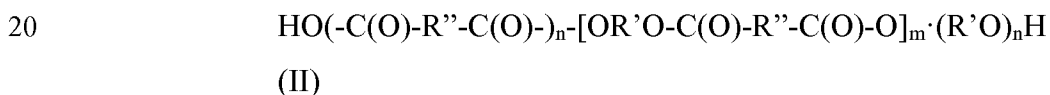
poly(3-hydroxybutyrate), poly( 4-hydroxybutyrate), poly(3-hydroxyvalerate), poly(lactic acid) (as known as polylactide), poly(3-hydroxypropanoate), poly(4-hydroxypentanoate), poly(3-hydroxypentanoate), poly(3-hydroxyhexanoate), poly(3-hydroxyheptanoate), poly(3-hydroxyoctanoate), polydioxanone, polycaprolactone, and polyglycolic acid (i.e.,  
 5 polyglycolide).

Copolymers of two or more of the above hydroxy acids may also be used, for example, poly(3-hydroxybutyrate-co-3-hydroxyvalerate), poly(lactate-co-3-hydroxypropanoate), poly(glycolide-co-dioxanone), and poly(lactic acid-co-glycolic acid).

Blends of two or more of the poly(hydroxyalkanoates) may also be used, as well as  
 10 blends (miscible or immiscible) with one or more other polymers and/or copolymers.

Aliphatic polyesters useful in the disclosure may include homopolymers, random copolymers, block copolymers, star-branched random copolymers, star-branched block copolymers, dendritic copolymers, hyperbranched copolymers, graft copolymers, and combinations thereof.

Another useful class of aliphatic polyesters includes those aliphatic polyesters derived from the reaction product of one or more alkanediols with one or more alkanedicarboxylic acids (or acyl derivatives). Such polyesters have the general Formula  
 15 (II):



wherein: R' and R'' each represent an alkylene moiety that may be linear or branched having from 1 to 20 carbon atoms, preferably 1 to 12 carbon atoms; m is a number such  
 25 that the ester is polymeric, and is preferably a number such that the molecular weight of the aliphatic polyester is at least 8,000 daltons (Da); and each n is independently 0 or 1.

In Formula (II), R' and R'' may further include one or more catemary (i.e., in chain) ether oxygen atoms. Examples of aliphatic polyesters include those homo-and co-polymers derived from (a) one or more of the following diacids (or derivative thereof):  
 30 succinic acid; adipic acid; 1,12 dicarboxydodecane; fumaric acid; glutartic acid; diglycolic acid; and maleic acid; and (b) one of more of the following diols: ethylene glycol; 30 polyethylene glycol; 1,2-propane diol; 1,3--propanediol; 1,2-propanediol; 1,2- butanediol;

1,3-butanediol; 1,4-butanediol; 2,3-butanediol; 1,6-hexanediol; 1,2-alkane diols having 5 to 12 carbon atoms; diethylene glycol; polyethylene glycols having a molecular weight of 300 to 10,000 daltons, preferably 400 to 8,000 daltons; propylene glycols having a molecular weight of 300 to 4000 daltons; block or random copolymers derived from ethylene oxide, propylene oxide, or butylene oxide; dipropylene glycol; and polypropylene glycol, and (c) optionally a small amount (i.e., 0.5-7.0 mole-%) of a polyol with a functionality greater than two such as glycerol, neopentyl glycol, and pentaerythritol. Such polymers may include polybutylene succinate homopolymer, polybutylene adipate homopolymer, polybutylene adipate-succinate copolymer, polyethylene succinate-adipate copolymer, polyethylene glycol succinate homopolymer and polyethylene adipate homopolymer.

Commercially available aliphatic polyesters include poly(lactide), poly(glycolide), poly(lactide-co-glycolide), poly(L-lactide-co-trimethylene carbonate), poly(dioxanone), poly(butylene succinate), and poly(butylene adipate).

Preferred aliphatic polyesters include those derived from semicrystalline polylactic acid. Poly(lactic acid) or polylactide has lactic acid as its principle degradation product, which is commonly found in nature, is non-toxic and is widely used in the food, pharmaceutical and medical industries. The polymer may be prepared by ring-opening polymerization of the lactic acid dimer, lactide. Lactic acid is optically active and the dimer appears in four different forms: L,L-lactide, D,D-lactide, D,L-lactide (meso lactide) and a racemic mixture of L,L- and D,D-. By polymerizing these lactides as pure compounds or as blends, poly(lactide) polymers may be obtained having different stereochemistries and different physical properties, including crystallinity. The L,L- or D,D-lactide yields semicrystalline poly(lactide), while the poly(lactide) derived from the D,L-lactide is amorphous. The polylactide preferably has a high enantiomeric ratio to maximize the intrinsic crystallinity of the polymer. The degree of crystallinity of a poly(lactic acid) is based on the regularity of the polymer backbone and the ability to crystallize with other polymer chains. If relatively small amounts of one enantiomer (such as D-) is copolymerized with the opposite enantiomer (such as L-) the polymer chain becomes irregularly shaped, and becomes less crystalline. For these reasons, when crystallinity is favored, it is desirable to have a poly(lactic acid) that is at least 85% of one isomer, more preferably at least 90% of one isomer, or even more preferably at least 95%

of one isomer in order to maximize the crystallinity. An approximately equimolar blend of D-poly(lactide) and L-poly(lactide) is also useful. This blend forms a unique crystal structure having a higher melting point (approximately 210°C) than does either the D-poly(lactide) and L-poly(lactide) alone (approximately 160°C), and has improved thermal stability, see H. Tsuji et al., *Polymer*, 40 (1999) 6699-6708.

Copolymers, including block and random copolymers, of poly(lactic acid) with other aliphatic polyesters may also be used. Useful co-monomers include glycolide, beta-propiolactone, tetramethylglycolide, beta-butyrolactone, gamma-butyrolactone, pivalolactone, 2-hydroxybutyric acid, alpha-hydroxyisobutyric acid, alpha-hydroxyvaleric acid, alpha-hydroxyisovaleric acid, alpha-hydroxycaproic acid, alpha-hydroxyethylbutyric acid, alpha-hydroxyisocaproic acid, alpha-hydroxy-betamethylvaleric acid, alpha-hydroxyoctanoic acid, alpha-hydroxydecanoic acid, alpha-hydroxymyristic acid, and alpha-hydroxystearic acid. Blends of poly(lactic acid) and one or more other aliphatic polyesters, or one or more other polymers may also be used. Examples of useful blends include poly(lactic acid) with a second polymer selected from poly(vinyl alcohol), polyethylene glycol, polysuccinate, polyethylene oxide, polycaprolactone and polyglycolide.

Poly(lactide)s may be prepared as described in U.S. Patent Nos. 6,111,060 (Gruber, et al.), 5,997,568 (Liu), 4,744,365 (Kaplan et al.), 5,475,063 (Kaplan et al.), 6,143,863 (Gruber et al.), 6,093,792 (Gross et al.), 6,075,118 (Wang et al.), 5,952,433 (Wang et al.), 6,117,928 (Hiltunen et al.), 5,883,199 (McCarthy et al.), and International Publication Nos. WO 98/124951 (Tsai et al.), WO 00/112606 (Tsai et al.), WO 84/04311 (Lin), WO 99/50345 (Kolstad et al.), WO 99/06456 (Wang et al.), WO 94/07949 (Gruber et al.), WO 96/122330 (Randall et al.), and WO 98/50611 (Ryan et al.), for example. Reference may also be made to J.W. Leenslag et al., *J. Appl. Polymer Science*, vol. 29 (1984), pp 2829-2842, and H.R. Kricheldorf, *Chemosphere*, vol. 43 (2001) 49-54.

The molecular weight of the polymer should be chosen so that the polymer may be processed as a melt. By "melt-processible," it is meant that the aliphatic polyesters are fluid or can be pumped or extruded at the temperatures used to process the fibers, and do not degrade or gel at those temperatures to the extent that the physical properties are so poor as to be unusable for the intended application. Thus, many of the materials can be made into nonwovens using melt processes such as spun bond, blown microfiber, and the

like. Certain embodiments also may be injection molded.

In certain embodiments, the molecular weight (number average) of suitable aliphatic polyesters is at least 8,000, or at least 10,000, or at least 30,000, or at least 50,000 daltons. Although higher molecular weight polymers generally yield films with better mechanical properties, for both melt processed and solvent cast polymers excessive viscosity is typically undesirable. The molecular weight of the aliphatic polyester is typically no greater than 1,000,000, preferably no greater than 500,000, and most preferably no greater than 300,000 daltons (Da), as measured by gel permeation chromatography (GPC).

For a poly(lactide), for example, the molecular weight may be from 8,000 to 1,000,000 daltons, and is preferably from 30,000 to 300,000 daltons (Da).

The aliphatic polyester may be blended with other polymers but typically is present in fibers of the present disclosure in an amount of at least 50 weight percent, or at least 60 weight percent, or at least 65 weight percent, or at least 80 weight percent (wt-%) of the fibers of the present disclosure.

#### Epoxidized Fatty Esters

Epoxidized fatty esters, such as epoxidized vegetable oils, are commonly known as plasticizers for easy thermal processing of polymers (or processing aides). Suitable epoxidized fatty esters for use on fibers of the present disclosure are used as hydrolysis stabilizing agents. That is, suitable epoxidized fatty esters are those capable of improving the hydrolytic stability of fibers that include an aliphatic polyester upon being disposed on the fibers. Typically, because such deposition (e.g., coating) does not involve thermal processing, the epoxidized fatty ester is unreacted relative to the aliphatic polyester.

Even though there is little or no reaction (e.g., crosslinking) between the aliphatic polyester and the epoxidized fatty ester, the presence of the free (i.e., unreacted) epoxidized fatty esters in the presence of the aliphatic polyester reduces the hydrolysis rate when the aliphatic polyester is aged or dispersed into a water-based medium for a long period of time.

It is believed that as the aliphatic polyester starts to hydrolyze in an aqueous environment, more carboxylic acid groups are formed in the aliphatic polyester that results in an increase in acidity (lower pH). As the hydrolysis continues, the epoxy group of the

epoxidized fatty ester tends to react with the carboxylic acid group of the aliphatic polyester. As such, the epoxidized fatty ester acts as a crosslinker for the hydrolyzable aliphatic polyester, which results in the formation of a higher molecular weight polymer network. At the same time, the reaction that occurs between the epoxy groups of  
5 epoxidized fatty ester and the carboxylic acid groups of the aliphatic polyester that are formed during hydrolysis actually neutralizes the pH of the aliphatic polyester. This results in a slowdown of the hydrolysis of the aliphatic polyester that correspondingly leads to an increased shelf life of the aliphatic polyester in aqueous media. From this  
10 aforementioned theory, it is suggested that a higher oxirane oxygen of the epoxidized fatty ester will tend to greatly increase the hydrolytic stability of an aliphatic polyester such as poly(lactic acid).

Fibers of the present disclosure typically have disposed thereon an epoxidized fatty ester that has greater than 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester. In certain embodiments, the amount of oxirane oxygen is at least  
15 5.5 wt-%, at least 6 wt-%, or at least 9 wt-%, oxirane oxygen, based on the total weight of the epoxidized fatty ester. In certain embodiments, the amount of oxirane oxygen is up to 23 wt-%, or up to 11 wt-%, oxirane oxygen, based on the total weight of the epoxidized fatty ester. In certain embodiments, the amount of oxirane oxygen is 6 wt-% to 11 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester.

20 In certain embodiments, the epoxidized fatty ester is an epoxidized poly(fatty ester) (i.e., a di- or tri-ester or higher functional ester). In certain embodiments, the epoxidized vegetable oil includes a di-ester, tri-ester, or combinations thereof. In certain embodiments, the epoxidized vegetable oil includes a tri-ester or higher functional ester.

In certain embodiments, the epoxidized fatty ester is a triglyceride of an epoxidized  
25 polyunsaturated fatty acid. The epoxidized polyunsaturated fatty acid can be made from the epoxidation of a triglyceride of a polyunsaturated fatty acid, wherein the triglyceride of a polyunsaturated fatty acid can be made from the esterification of glycerol and a polyunsaturated fatty acid. Preferably, the polyunsaturated fatty acid has two or more unsaturated double bonds for higher amounts of oxirane oxygen resulting from an  
30 epoxidization process. In certain embodiments, the polyunsaturated fatty acid is selected from linoleic acid, linoelaidic acid,  $\alpha$ -linolenic acid, arachidonic acid, eicosapentaenoic acid, docosaheptaenoic acid, and combinations thereof. The chemical structures of such

preferred polyunsaturated fatty acids are shown in the following table.

Common name	Chemical structure
Linoleic acid	$\text{CH}_3(\text{CH}_2)_4\text{CH}=\text{CHCH}_2\text{CH}=\text{CH}(\text{CH}_2)_7\text{COOH}$ (9E,9E)
Linoelaidic acid	$\text{CH}_3(\text{CH}_2)_4\text{CH}=\text{CHCH}_2\text{CH}=\text{CH}(\text{CH}_2)_7\text{COOH}$ (9Z,9Z)
$\alpha$ -Linolenic acid	$\text{CH}_3\text{CH}_2\text{CH}=\text{CHCH}_2\text{CH}=\text{CHCH}_2\text{CH}=\text{CH}(\text{CH}_2)_7\text{COOH}$
Arachidonic acid	$\text{CH}_3(\text{CH}_2)_4\text{CH}=\text{CHCH}_2\text{CH}=\text{CHCH}_2\text{CH}=\text{CHCH}_2\text{CH}=\text{CH}(\text{CH}_2)_3\text{COOH}$
Eicosapentaenoic acid	$\text{CH}_3\text{CH}_2\text{CH}=\text{CHCH}_2\text{CH}=\text{CHCH}_2\text{CH}=\text{CHCH}_2\text{CH}=\text{CHCH}_2\text{CH}=\text{CH}(\text{CH}_2)_3\text{COOH}$
Docosahexaenoic acid	$\text{CH}_3\text{CH}_2\text{CH}=\text{CHCH}_2\text{CH}=\text{CHCH}_2\text{CH}=\text{CHCH}_2\text{CH}=\text{CHCH}_2\text{CH}=\text{CHCH}_2\text{CH}=\text{CH}(\text{CH}_2)_2\text{COOH}$

In certain embodiments, the epoxidized fatty ester is an epoxidized vegetable oil.

- 5 In certain embodiments, the epoxidized vegetable oil is selected from the group of epoxidized soybean oil, epoxidized cottonseed oil, epoxidized wheat germ oil, epoxidized soya oil, epoxidized corn oil, epoxidized sunflower oil, epoxidized safflower oil, epoxidized hemp oil, epoxidized linseed oil, and combinations thereof.

- 10 In certain embodiments, the vegetable oil used for preparation of the epoxidized vegetable oil has a polyunsaturated value of at least 50 grams per 100 grams total oil, preferably at least 60 grams per 100 grams total oil. The polyunsaturated value is the weight of the polyunsaturated oil in 100 grams of total oil (100 g of saturated oil + monounsaturated oil + polyunsaturated oil). The polyunsaturated values of various oils, useful for making epoxidized vegetable oils, are shown in the following table, which
- 15 shows that examples of epoxidized vegetable oil having a polyunsaturated value of at least approximately 50 grams per 100 grams total oil include wheat germ sunflower oil, safflower oil, and hemp oil.

Oil	Saturated	Monounsaturated	Polyunsaturated
	g/100g	g/100g	g/100g



Cottonseed oil	25.5	21.3	48.1
Wheat germ oil	18.8	15.9	60.7
<u>Soya oil</u>	14.5	23.2	56.5
Corn oil	12.7	24.7	57.8
Sunflower oil	11.9	20.2	63.0
<u>Safflower oil</u>	10.2	12.6	72.1
Hemp oil	10	15	75

In certain embodiments, fibers of the present disclosure typically include at least 1 wt-%, or at least 2 wt-%, or at least 3 wt-%, or at least 5 wt-%, of an epoxidized fatty ester, based on the total weight of the fibers (i.e., dry weight of the fibers including the core and the epoxidized fatty ester and any optional additives disposed on the fiber core, after removal of the water or any solvents used to apply the epoxidized fatty ester). In certain embodiments, fibers of the present disclosure typically include up to 20 wt-%, or up to 10 wt-%, of an epoxidized fatty ester, based on the total weight of the fibers (i.e., dry weight of the fibers including the core and the epoxidized fatty ester and any optional additives disposed on the fiber core, after removal of the water or any solvents used to apply the epoxidized fatty ester). In certain embodiments, fibers of the present disclosure typically include up to 7 wt-% (and in some embodiments, less than 7 wt-%), or up to 6 wt-%, of an epoxidized fatty ester, based on the total weight of the fibers (i.e., dry weight of the fibers including the core and the epoxidized fatty ester and any optional additives disposed on the fiber core, after removal of the water or any solvents used to apply the epoxidized fatty ester).

#### Optional Shrink Reduction Additives

The “shrink reduction” or “antishrink” or “antishrinkage” additive (i.e., agent) refers to a thermoplastic polymeric additive which, when added to the aliphatic polyester in a suitable amount during thermal process formation of a uniform fibrous web, results in a web having at least one dimension which shrinks by no greater than 10% in the plane of the web when the web is heated to a temperature above a glass transition temperature of the fibers, but below the melting point of the fibers in an unrestrained (free to move) state,

when compared to a web made in the same way with the same components without the shrink reduction additive. Although, typically, because the epoxidized fatty acid is disposed on the surface of the aliphatic polyester fibers, as opposed to mixed within the aliphatic polyester, there is often no need for the shrink reduction additive.

5 Preferred shrink reduction additives (i.e., shrink reduction agents) form a dispersed phase in the aliphatic polyester when a mixture is cooled to 23-25°C. Preferred shrink reduction additives are also semicrystalline thermoplastic polymers as determined by differential scanning calorimetry.

Potentially useful semicrystalline polymers include polyethylene, linear low  
10 density polyethylene, polypropylene, polyoxymethylene, poly(vinylidene fluoride), poly(methyl pentene), poly(ethylene-chlorotrifluoroethylene), poly(vinyl fluoride), poly(ethylene oxide) (PEO), poly(ethylene terephthalate), poly(butylene terephthalate), semicrystalline aliphatic polyesters including polycaprolactone (PCL), aliphatic polyamides such as nylon 6 and nylon 66, thermotropic liquid crystal polymers, and  
15 combinations thereof. Particularly preferred semicrystalline polymers include polypropylene, nylon 6, nylon 66, polycaprolactone, and poly(ethylene oxide).

The shrink reduction additives have been shown to dramatically reduce the shrinkage of PLA nonwovens. The molecular weight (MW) of these additives may affect the ability to promote shrinkage reduction. Preferably the MW is greater than about  
20 10,000 daltons, preferably greater than 20,000 daltons, more preferably greater than 40,000 daltons and most preferably greater than 50,000 daltons.

Derivatives of the thermoplastic shrink reduction polymers also may be suitable. Preferred derivatives will likely retain some degree of crystallinity. For example, polymers with reactive end groups such as PCL and PEO can be reacted to form, for  
25 example, polyesters or polyurethanes, thus increasing the average molecular weight.

A highly preferred shrink reduction additive is a polyolefin, in particular a polypropylene. Polypropylene homo- and co-polymers useful in practicing embodiments of the present disclosure may be selected from polypropylene homopolymers, polypropylene copolymers, and blends thereof (collectively polypropylene polymers). The  
30 homopolymers may be atactic polypropylene, isotactic polypropylene, syndiotactic polypropylene and blends thereof. The copolymer can be a random copolymer, a statistical copolymer, a block copolymer, and blends thereof. In particular, the polymer

blends described herein include impact copolymers, elastomers and plastomers, any of which may be physical blends or in situ blends with the polypropylene.

The polypropylene polymers can be made by any method known in the art such as by slurry, solution, gas phase or other suitable processes, and by using catalyst systems appropriate for the polymerization of polyolefins, such as Ziegler-Natta-type catalysts, metallocene-type catalysts, other appropriate catalyst systems or combinations thereof. In a preferred embodiment, the propylene polymers are made by the catalysts, activators and processes described in U.S. Patent Nos. 6,342,566 (Burkhardt et al.); 6,384,142 (Burkhardt et al.); WO 03/040201 (Stevens et al.); WO 97/19991 (McAlpin et al.) and U.S. Patent No. 5,741,563 (Mehta et al.). Likewise, the polypropylene polymers may be prepared by the process described in U.S. Patent Nos. 6,342,566 and 6,384,142. Such catalysts are well known in the art, and are described in, for example, ZIEGLER CATALYSTS (Gerhard Fink, Rolf Mulhaupt and Hans H. Brintzinger, eds., Springer-Verlag 1995); Resconi et al., Selectivity in Propene Polymerization with Metallocene Catalysts, 100 CHEM. REV. 20 1253-1345 (2000); and I, II METALLOCENE-BASED POLYOLEFINS (Wiley & Sons 2000).

Propylene polymers that are useful in practicing some embodiments of the present disclosure include those sold under the tradenames ACHIEVE and ESCORENE by Exxon-Mobil Chemical Company (Houston, TX), and various propylene (co)polymers sold by Total Petrochemicals (Houston, TX).

Presently preferred propylene homopolymers and copolymers useful in the present disclosure typically have: 1) a weight average molecular weight ( $M_w$ ) of at least 30,000 Da, preferably at least 50,000 Da, more preferably at least 90,000 Da, as measured by gel permeation chromatography (GPC), and/or no more than 2,000,000 Da, preferably no more than 1,000,000 Da, more preferably no more than 500,000 Da, as measured by gel permeation chromatography (GPC); and/or 2) a polydispersity (defined as  $M_w/M_n$ , wherein  $M_n$  is the number average molecular weight determined by GPC) of 1, preferably 1.6, and more preferably 1.8, and/or no more than 40, preferably no more than 20, more preferably no more than 10, and even more preferably no more than 3; and/or 3) a melting temperature  $T_m$  (second melt) of at least 30°C, preferably at least 50°C, and more preferably at least 60°C as measured by using differential scanning calorimetry (DSC), and/or no more than 200°C, preferably no more than 185°C, more preferably no more than

175°C, and even more preferably no more than 170°C as measured by using differential scanning calorimetry (DSC); and/or a crystallinity of at least 5%, preferably at least 10%, more preferably at least 20% as measured using DSC, and/or no more than 80%, preferably no more than 70%, more preferably no more than 60% as measured using DSC; and/or 5) a glass transition temperature (T<sub>g</sub>) of at least -40°C, preferably at least -10°C, more preferably at least -10°C, as measured by dynamic mechanical thermal analysis (DMTA), and/or no more than 20°C, preferably no more than 10°C, more preferably no more than 5°C, as measured by dynamic mechanical thermal analysis (DMTA); and/or 6) a heat of fusion (R<sub>f</sub>) of 180 J/g or less, preferably 150 J/g or less, more preferably 120 J/g or less as measured by DSC and/or at least 20 J/g, more preferably at least 40 J/g as measured by DSC; and/or 7) a crystallization temperature (T<sub>c</sub>) of at least 15°C, preferably at least 20°C, more preferably at least 25°C, even more preferably at least 60°C and/or, no more than 120°C, preferably no more than 115°C, more preferably no more than 110°C, even more preferably no more than 145°C.

Although typically not necessary, fibers of the present disclosure can optionally include a shrink reduction additive (preferably a propylene polymer (including both poly(propylene) homopolymers and copolymers)) in an amount of up to 10 wt-%. In certain embodiments, fibers of the present disclosure include a shrink reduction additive in an amount of at least 0.5 wt-%, or at least 1 wt-%, or at least 2 wt-% by weight, based on the total weight of the fibers. In certain embodiments, fibers of the present disclosure include a shrink reduction additive (preferably a propylene polymer (including both poly(propylene) homopolymers and copolymers)) in an amount of up to 5 wt-%, based on the total weight of the fibers.

#### Optional Additives

Various optional additives may be added to the fibers of the present disclosure, either in the core or disposed on the surface of the fibers. Suitable additives include, but are not limited to, particulates, fillers, stabilizers, plasticizers, tackifiers, flow control agents, cure rate retarders, adhesion promoters (for example, silanes and titanates), adjuvants, impact modifiers, expandable microspheres, thermally conductive particles, electrically conductive particles, silica, glass, clay, talc, pigments, colorants, glass beads or bubbles, antioxidants, optical brighteners, antimicrobial agents, surfactants, wetting

agents, fire retardants, and repellents such as hydrocarbon waxes, silicones, and fluorochemicals. However, some fillers (i.e., insoluble organic or inorganic materials generally added to augment weight, size or to fill space in the resin for example to decrease cost or impart other properties such as density, color, impart texture, effect degradation rate and the like) may detrimentally effect fiber properties.

Fillers, if used, can be particulate non-thermoplastic or thermoplastic materials. Fillers also may be non-aliphatic polyesters polymers which often are chosen due to low cost such as starch, lignin, and cellulose based polymers, natural rubber, and the like. These filler polymers tend to have little or no crystallinity.

Fillers, plasticizers, and other additives, when used at levels above 3% by weight, and more certainly above 5% by weight of the aliphatic polyester, can have a significant negative effect on physical properties such as tensile strength of a web of the fibers (e.g., a nonwoven web). Above 10% by weight of the aliphatic polyester resin, these optional additives can have a dramatic negative effect on physical properties. Therefore, total optional additives are typically present at no more than 10% by weight, preferably no more than 5% by weight and most preferably no more than 3% by weight based on the weight of the aliphatic polyester.

### Wet Wipes

Fibers of the present disclosure can be used in wipes, particularly wet wipes.

“Wet” wipe is a wipe wherein a substrate, typically a fibrous web (e.g., nonwoven web), has been pre-moistened with the aqueous composition. That is, the aqueous composition is in contact with the fibrous web. In most cases the wipe has been saturated with the aqueous composition (i.e., full absorbent capacity of the substrate used). But this may not necessarily have to be the case. It would depend on the absorbent capacity of the wipe and aqueous formulation. As long as the wipe can be loaded with enough active material, it would not have to be completely saturated. In some cases the wipes may be super saturated, i.e., have more liquid than its absorbent capacity. This is achieved, for example, by delivering the wipes from a container with excess liquid composition.

Wet wipes are typically sold in sealed single-use or resealable multi-use packages or canisters often with an excess of the aqueous composition. “Wet” wipe also includes a wipe that is coated with a concentrate up to 100% solids that is subsequently wet with

water by the user. For example, a roll of perforated wipes can be provided in a container to which the user adds a predetermined amount of water that wicks into the roll of wipes. In certain embodiments, the aqueous composition is present in an amount of at least 2 times, or at least 4 times, the weight of the fibrous web. In certain embodiments, the aqueous composition is present in an amount of up to 6 times, the weight of the fibrous web.

Herein, a wet wipe includes: a fibrous web as described herein and an aqueous composition that includes water and a surfactant and/or a biocide (dissolved or dispersed in the water). The aqueous composition may also include one or more organic solvents, such as alcohols (e.g., isopropanol), along with the water. The aqueous composition is in contact with the fibrous web.

For example, in certain embodiments, a wet wipe of the present disclosure includes a fibrous web that includes fibers, wherein each fiber includes: a core comprising an aliphatic polyester; and an epoxidized fatty acid having greater than 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester; wherein the epoxidized fatty ester is disposed on the surface of the fiber core in an amount of at least 0.5 wt-%, based on the total weight of the fiber (i.e., dry weight of the fibers including the core and the epoxidized fatty ester and any optional additives disposed on the fiber core, after removal of the water or any solvents used to apply the epoxidized fatty ester).

The wet wipe also includes an aqueous composition that includes water and a surfactant and/or a biocide. The aqueous composition can have a pH of 1 to 14. In certain embodiments, the aqueous composition includes at least 0.01 wt-%, or at least 0.05 wt-%, surfactant and/or biocide, based on the total weight of the aqueous composition. In certain embodiments, the aqueous composition includes up to 0.5 wt-%, surfactant and/or biocide, based on the total weight of the aqueous composition.

In certain embodiments, the aqueous composition includes a surfactant and the wet wipe is a cleaning wipe.

In certain embodiments, the aqueous composition includes a biocide and the wet wipe is a disinfecting wipe.

In certain embodiments, the aqueous composition includes a biocide and a surfactant, wherein the wet wipe is a cleaning/disinfecting wipe.

The surfactant can be nonionic, anionic, cationic, amphoteric (i.e., zwitterionic), or

combinations thereof. In certain embodiments, the surfactant is a nonionic surfactant.

Exemplary anionic surfactants include: alcohol sulfates and sulfonates, alcohol phosphates and phosphonates, alkyl sulfates, alkyl ether sulfate, sulfate esters of an alkylphenoxy polyoxyethylene ethanol, alkyl monoglyceride sulfate, alkyl sulfonate, alkyl benzene sulfonate, alkyl ether sulfonate, ethoxylated alkyl sulfonate, alkyl carboxylate, alkyl ether carboxylate, alkyl alkoxy carboxylate, alkane sulfonate, alkylbenzene sulfonate, alkyl ester sulfonate, alkyl sulfate, alkyl alkoxyated sulfate (e.g., sodium lauryl sulfate), alkyl carboxylate (e.g., sorbitan stearate), and sulfonated alkyl glucosides (e.g., sodium decylglucosides, hydroxypropyl sulfonate, sodium decylglucosides hydroxypropyl sulfonate and sodium laurylglucosides hydroxypropyl sulfonate).

Exemplary zwitterionic surfactants include Betaine and sultaine (e.g., C12-18 alkyl dimethyl betaines such as coconutbetaine), C10-C16 alkyl dimethyl betaine (laurylbetaine), fatty acylamidopropylene(hydroxylpropylene)sulfobetaine, lauryldimethylcarboxymethylbetaine, cocoamido propyl monosodium phosphitane, cocoamido disodium 3-hydroxypropyl phosphobetaine, and amphoteric amine oxide (e.g., alkyl dimethyl amine oxides and alkylamidopropyl amine oxides).

Exemplary nonionic surfactants include ethoxylated alkylphenol, ethoxylated and propoxylated fatty alcohols, polyethylene glycol ethers of methyl glucose, ethoxylated esters of fatty acids, alkyl polyglucoside (e.g., capryl glucoside such as Glucopon 215UP, decyl glucoside such as Glucopon 225DK, coco-glucoside such as Glucopon 425N, lauryl glucoside such as Glucopon 625UP, an aqueous solution of alkyl glucosides based fatty acid alcohol C9-C11 such as APG 325N, and sodium laureth sulfate & lauryl glucoside & cocoamidopropyl betaine such as Plantapon 611L, fatty alcohol polyglycoether (e.g., Dephypon LS54, Dehypon LT104), fatty alcohol ethoxylates (propoxylates), and ethoxylated alkylphenol.

Exemplary cationic surfactants include aminoamide, quaternary ammonium salt, aminoamides (e.g., stearamidopropyl ethyldimonium ethosulfate, stearamidopropyl PG-dimonium chloride phosphate), and quaternary ammonium salts (e.g., cetyl ammonium chloride, lauryl ammonium chloride, and ditalow dimethyl ammonium chloride).

Various combinations of surfactants can be used if desired.

In certain embodiments, the biocide is a cationic biocides such as a quaternary ammonium salts (e.g., dodecyldimethyl benzyl ammonium chloride, tridecyldimethyl

benzyl ammonium chloride, tetradecyldimethyl benzyl ammonium chloride, pentadecyldimethyl benzyl ammonium chloride, hexadecyldimethyl benzyl ammonium chloride, (butyl)(dodecyl)dimethyl ammonium chloride, (hexyl)(decyl)dimethyl ammonium chloride, dioctyldimethyl ammonium chloride), polyhexamethyl biguanide (PHMB), and chlorhexidine gluconate), aldehydes (e.g., formaldehyde, glutaraldehyde, parabens), phenolic biocides (e.g., those described in U.S. Pat. No. 6,113,933 (Beerse et al.), including thymol, tricosan, 0-penyl-phenol, p-chlorophenol, benzyl alcohol), essential oils (e.g., oils derived from herbs, flowers, trees, and other plants such as thyme, lemongrass, citrus, lemons, orange, anise, clove, lavender, cedar), metal salts (e.g., aluminum, silver, zinc, copper, and those described in U.S. Pat. No. 6,113,933), and antimicrobial lipids such as a (C8-C12)saturated fatty acid ester of a polyhydric alcohol, a (C12-C22)unsaturated fatty acid ester of a polyhydric alcohol, a (C8-C12)saturated fatty ether of a polyhydric alcohol, a (C12-C22)unsaturated fatty ether of a polyhydric alcohol, an alkoxyated derivative thereof, (C5-C12)1,2-saturated alkanediol, and (C12-C18)1,2-unsaturated alkanediol or combinations thereof (e.g., those described in U.S. Pub. No. 2005/0058673 (Scholz et al.)), peroxy acids (e.g., hydrogen peroxide, peracetic acid), and alcohols (e.g., ethyl alcohol, propyl alcohol).

In certain embodiments, the biocide is a compound capable of destroying or reducing the concentration of bacteria including *Staphylococcus spp.*, *Streptococcus spp.*, *Escherichia spp.*, *Enterococcus spp.*, *Pseudomonas spp.*, or combinations thereof. In certain embodiments, the biocide is an antibacterial that destroys or reduces the concentration of *Staphylococcus aureus*, *Staphylococcus epidermidis*, *Escherichia coli*, *Pseudomonas aeruginosa*, *Streptococcus pyogenes*, or combinations thereof.

Various combinations of biocides can be used if desired.

## EXEMPLARY EMBODIMENTS

### 1. A fiber comprising:

a core comprising an aliphatic polyester; and

an epoxidized fatty ester having greater than 4.7 wt-% oxirane oxygen,

based on the total weight of the epoxidized fatty ester;

wherein the epoxidized fatty ester is disposed on the surface of the fiber core in an amount of at least 0.5 wt-%, based on the total weight of the fiber.



2. The fiber of embodiment 1 wherein the epoxidized fatty ester has at least 5.5 wt-% oxirane oxygen.
- 5 3. The fiber of embodiment 2 wherein the epoxidized fatty ester has at least 6 wt-% oxirane oxygen.
4. The fiber of embodiment 3 wherein the epoxidized fatty ester has at least 9 wt-% oxirane oxygen.
- 10 5. The fiber of any of embodiments 1 through 4 wherein the epoxidized fatty ester has up to 23 wt-% oxirane oxygen.
- 15 6. The fiber of any of embodiments 1 through 5 wherein the epoxidized fatty ester is an epoxidized poly(fatty ester).
7. The fiber of claim 6 wherein the epoxidized poly(fatty ester) is a triglyceride of an epoxidized polyunsaturated fatty acid derived from an unsaturated fatty acid selected from linoleic acid, linoelaidic acid,  $\alpha$ -linolenic acid, arachidonic acid, eicosapentaenoic acid, docosahexaenoic acid, and combinations thereof.
- 20 8. The fiber of embodiment 6 wherein the epoxidized poly(fatty ester) is an epoxidized vegetable oil.
- 25 9. The fiber of embodiment 8 wherein the epoxidized vegetable oil is selected from the group of epoxidized soybean oil, epoxidized cottonseed oil, epoxidized wheat germ oil, epoxidized soya oil, epoxidized corn oil, epoxidized sunflower oil, epoxidized safflower oil, epoxidized hemp oil, epoxidized linseed oil, and combinations thereof.

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10. The fiber of embodiment 9 wherein the epoxidized vegetable oil is derived from an unsaturated vegetable oil having a polyunsaturated value of at least 60 grams per 100 grams total oil.
- 5 11. The fiber of any of embodiments 8 through 10 wherein the epoxidized vegetable oil comprises a di-ester, tri-ester, or combinations thereof.
12. The fiber of any of embodiments 1 through 11 wherein the epoxidized fatty ester is present on the fiber in an amount of up to 20 wt-%, based on the total weight of the  
10 fiber.
13. The fiber of embodiment 12 wherein the epoxidized fatty ester is present on the fiber in an amount of up to 10 wt-%, based on the total weight of the fiber.
- 15 14. The fiber of embodiment 13 wherein the epoxidized fatty ester is present on the fiber in an amount of up to 7 wt-%, based on the total weight of the fiber.
15. The fiber of any of embodiments 1 through 14 wherein the epoxidized fatty ester is present on the fiber in an amount of at least 1 wt-%, based on the total weight of  
20 the fiber.
16. The fiber of any of embodiments 1 through 15 wherein the aliphatic polyester is selected from the group of poly(lactide), poly(glycolide), poly(lactide-co-glycolide), poly(L-lactide-co-trimethylene carbonate), poly(dioxanone),  
25 poly(butylene succinate), poly(butylene adipate), poly(ethylene adipate), polyhydroxybutyrate, polyhydroxyvalerate, and blends and copolymers thereof.
17. The fiber of embodiment 16 wherein the aliphatic polyester is a poly(lactide).
- 30 18. The fiber of any of embodiments 1 through 17 wherein the aliphatic polyester has a number average molecular weight of at least 8,000 Daltons.

19. The fiber of embodiment 18 wherein the aliphatic polyester has a number average molecular weight of at least 10,000 Daltons.
20. The fiber of any of embodiments 18 or 19 wherein the aliphatic polyester has a  
5 number average molecular weight of up to 1,000,000 Daltons.
21. The fiber of any of embodiments 1 through 20 wherein the aliphatic polyester is present in an amount of at least 80 wt-%, based on the total weight of the fiber.
- 10 22. The fiber of any of embodiments 1 through 21 wherein the core further comprises a shrink reduction additive.
23. The fiber of embodiment 22 wherein the shrink reduction additive is a polyolefin.
- 15 24. A web comprising a plurality of the fibers of any of embodiments 1 through 23.
25. The web of embodiment 24 which is a nonwoven web.
26. A wet wipe comprising:  
20 a nonwoven web of embodiment 25; and  
an aqueous composition comprising water and a surfactant and/or a biocide (dissolved or dispersed therein), wherein the aqueous composition contacts the nonwoven web.
- 25 27. A wet wipe comprising:  
a fibrous web comprising fibers, wherein each fiber comprises:  
a core comprising an aliphatic polyester; and  
an epoxidized fatty ester having greater than 4.7 wt-% oxirane  
oxygen, based on the total weight of the epoxidized fatty ester;  
30 wherein the epoxidized fatty ester is disposed on the surface of the fiber core in an amount of at least 0.5 wt-%, based on the total weight of the fiber; and

an aqueous composition contacting the fibrous web, the aqueous composition comprising:  
water; and  
a surfactant and/or a biocide (dissolved or dispersed in the water).

5

28. The wet wipe of embodiment 27 wherein the epoxidized fatty ester is disposed on the surface of the fibers prior to contacting the fibrous web with the aqueous composition.

10

29. The wet wipe of embodiment 27 wherein the aqueous composition comprises water, a surfactant and/or a biocide, and the epoxidized fatty ester, and upon contacting the fibrous web with the aqueous composition, the epoxidized fatty ester is deposited on the surface of the fibers.

15

30. A wet wipe comprising:  
a fibrous web comprising fibers, wherein each fiber comprises a core comprising an aliphatic polyester; and  
an aqueous composition contacting the fibrous web, wherein the aqueous composition comprises:

20

water;  
a surfactant and/or a biocide (dissolved or dispersed in the water);  
and

an epoxidized fatty ester having greater than 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester;

25

wherein the epoxidized fatty ester is dispersed in the aqueous composition in an amount of at least 0.5 wt-%, based on the total weight of the aqueous composition.

30

31. The wet wipe of any of embodiments 26 through 30 wherein the aqueous composition has a pH of 1 to 14.

32. The wet wipe of any of embodiments 26 through 31 wherein the aqueous composition comprises at least 0.01 wt-% surfactant and/or biocide, based on the total weight of the aqueous composition.

5 33. The wet wipe of any of embodiments 26 through 32 wherein the aqueous composition comprises a surfactant, wherein the wet wipe is a cleaning wipe.

34. The wet wipe of embodiment 33 wherein the surfactant comprises a nonionic surfactant.

10

35. The wet wipe of any of embodiments 26 through 32 wherein the aqueous composition comprises a biocide, wherein the wet wipe is a disinfecting wipe.

15

36. The wet wipe of any of embodiments 26 through 32 wherein the aqueous composition comprises a biocide and a surfactant, wherein the wet wipe is a cleaning/disinfecting wipe.

20

37. The wet wipe of any of embodiments 26 through 36 wherein the aqueous composition is present in an amount of at least 2 times the weight of the fibrous web.

38. A process for improving the hydrolytic stability of fibers comprising an aliphatic polyester, the method comprising:

25

forming fibers comprising an aliphatic polyester; and  
depositing an epoxidized fatty ester on the surface of the fibers in an amount of at least 0.5 wt-%, based on the total weight of the fibers;  
wherein the epoxidized fatty ester has at least 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester.

30

39. The process of embodiment 38 wherein forming fibers comprises forming spunbond fibers.

40. The process of embodiment 38 or 39 wherein depositing the epoxidized fatty ester on the surface of the fibers comprises coating the epoxidized fatty ester onto the fibers.

5        41. The process of embodiment 38 through 40 wherein depositing the epoxidized fatty ester on the surface of the fibers comprises contacting the fibers with an aqueous composition, wherein the aqueous composition comprises water, a surfactant and/or a biocide, and the epoxidized fatty ester (and optionally drying the fibers).

10       42. The process of any of embodiments 38 through 41 wherein the fibers are formed into a fibrous web before depositing an epoxidized fatty ester.

43. The process of embodiment 42 wherein the fibrous web is a nonwoven web.

15       44. A process for improving the hydrolytic stability of a fibrous web comprising fibers comprising an aliphatic polyester, the method comprising:

          forming a fibrous web comprising fibers comprising an aliphatic polyester;  
          providing an aqueous composition comprising:

                  water;

20               an epoxidized fatty ester in an amount of at least 0.5 wt-%, based on the total weight of the aqueous composition; and

                  optionally, a surfactant and/or a biocide;

                  wherein the epoxidized fatty ester has at least 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester; and

25               contacting the fibrous web with the aqueous composition to deposit the epoxidized fatty ester thereon (and optionally drying the fibrous web).

## EXAMPLES

30        Objects and advantages of this invention are further illustrated by the following examples, but the particular materials and amounts thereof recited in these examples, as well as other conditions and details, should not be construed to unduly limit this invention. These examples are merely for illustrative purposes only and are not meant to be limiting on the scope of the appended claims.

**Materials**

NATUREWORKS PLA Polymer 6202D, (PLA), poly(lactic acid), available from NatureWorks LLC, Minnetonka, MN

5 PARAPLEX G-60, (G-60), epoxidized soybean oil with 5.5 wt% of oxirane oxygen, available from The HallStar Company, Chicago, IL

VIKOFLEX 4050, (VK-4050), is epoxidized octyl oleate monoester with a minimum oxirane oxygen content of 5.3 wt%, available from Arkema Inc., King of Prussia, PA

10 VIKOFLEX 5075, (VK-5075), is a monomeric epoxidized propylene glycol dioleate with a minimum oxirane oxygen content of 4.4%, available from Arkema Inc., King of Prussia, PA

VIKOFLEX 7170, (VK-7170), epoxidized soybean oil with a minimum oxirane oxygen content of 7.0 wt% , available from Arkema Inc., King of Prussia, PA

VIKOFLEX 7190, (VK-7190), epoxidized linseed oil with a minimum oxirane oxygen content of 9.0 wt%, available from Arkema Inc., King of Prussia, PA

15 **PLA Spunbond Nonwoven Web Preparation**

The PLA spunbond nonwoven webs described in the Examples were generally prepared on an experimental spunbond line using the equipment and processing techniques for spunbond nonwoven webs described in U.S. Patent Publication 2008/0038976. In a typical procedure, the PLA pellets were fed from a hopper into a 2 inch (5.1 cm) single  
20 screw extruder (Davis-Standard BLUE RIBBON (DS-20<sup>®</sup>) available from Davis Standard Corporation, Pawcatuck, CT) at controlled rate. The extruder temperature was 230°C. The molten resin was pumped via a gear pump into a spin pack having rows of small orifices. The orifices, arranged in a rectangular form, had a diameter of 0.014 inch (0.36 mm) and a length to diameter ratio (L/D) of 4. Fibers were formed through the spin pack and  
25 subsequently cooled down by passing them through a quenching air chamber. The rate and extent of fiber attenuation was controlled by the attenuating pressure (AP) of the attenuator air – the higher the attenuating pressure, the faster and greater the extent of attenuation. The attenuated PLA fibers were collected as an unbonded fiber mat on a conventional screen support using vacuum assistance, and the fiber mat was then passed  
30 through a through-air bonder at a temperature of 147°C in order to cause light autogeneous bonding between at least some of the fibers. The web was subsequently treated by a

typical hydroentangling/spunlacing process and then dried. This further bonded the fibers in the web and provided web softness.

**Method for preparing wet wipes using the PLA spunbond nonwoven webs for aging studies**

5           The aging stability of PLA spunbond nonwoven webs was studied in three different water based cleaning/disinfecting solutions:

**Solution 1 (S1):** an aqueous cleaning solution comprising 1 wt% GLUCOPON 425N alkyl polyglycoside surfactant (available from BASF Chemical Company, Florham Park, NJ), 0.02 wt% EASY WET 20 wetting agent based on N-Octyl-2-Pyrrolidone  
10       (available from Ashland Inc., Covington, KY), 0.01 wt% DOW CORNING 7305 silicone based antifoam emulsion (available from Dow Corning Corporation, Midland, MI) 0.2 wt% MACKSTAT DM 55% active solution of Dimethylol-5,5-dimethylhydantoin (available from Rhodia, Cranbury, NJ), 0.03 wt% OMACIDE IPBC 30 DPG fungicide based on 3-Iodopropynylbutylcarbamate (available from Arch Chemicals, Atlanta, GA),  
15       0.15 wt% fragrance (No. 70331 citrus fragrance, available from Belle-Aire Fragrances, Mundelein, IL), and 98.59 wt% water. The pH of this solution was 7.0.

**Solution 2 (S2):** an aqueous solution of Lonza LC-75, a quaternary ammonium compound based aqueous disinfectant solution (EPA Registration Number: 6836-334), available from Lonza Inc., Allendale, NJ. The Lonza LC-75 was diluted 1:75 with water  
20       to prepare Solution 2. The pH of this solution was 10.5.

**Solution 3 (S3):** an aqueous disinfectant solution comprising 0.24 wt % CAPMUL 908P Propylene glycol monocaprylate (available from Abitec Corporation, Columbus, OH), 0.3 wt% Citric acid (available from Sigma Aldrich, St. Louis, MO), 0.3 wt% Sorbic acid (available from Sigma Aldrich, St. Louis, MO), 0.81 wt% Propylene glycol (available  
25       from Dow Chemical Company, Midland, MI), 0.49 wt% NAXOLATE® AS-LG-85 Sodium Lauryl Sulfate (available from Nease Corporation, Blue Ash, OH), 0.13 wt % Sodium hydroxide (20% solution, available from Sigma Aldrich, St. Louis, MO), and 97.73 wt% water. The pH of this solution was 4.5. The PLA spunbond nonwoven webs were cut into 6 inch x 5 inch (15.2 cm X 12.7 cm) samples, and an excess of the  
30       cleaning/disinfecting solution used for testing was loaded onto the webs (generally about 5-6 times the web weight). The wipes were then sealed in an aluminum bag and aged in an oven maintained at a temperature of either 135°F or 158°F (57°C or 70°C) over a period



of time as indicated in the Examples. After removing the webs from the oven, excess cleaning solution was squeezed from the webs by passing the webs between nip rollers. The hydrolytic stability of the PLA spunbond nonwoven web with epoxidized vegetable oils additive in comparison to the untreated PLA spunbond nonwoven webs was then  
5 assessed by measuring the tensile strength and the % tensile strength retention of the webs.

#### **Test Method for Tensile Strength and % Retention**

Tensile strength measurements were carried out using a Lloyd LF Plus tensile tester (available from Lloyd Instruments, Segensworth Fareham England). The size of the nonwoven web samples that were tested was 1 inch (2.54 cm) x 3 inch (7.6 cm) (width x  
10 length), and the gap for the tensile measurement was 1/8 inch (0.32 cm). Measurements were in the machine direction (length direction of the test sample) unless indicated otherwise, at a rate of 14 inches per minute. The tensile strength in this experiment is defined as the maximum load when the nonwoven web is broken with 1 kg load, and is the average measurement of 8 replicate nonwoven web samples. The % tensile strength  
15 retention (i.e., % retention) was calculated by dividing the tensile strength after aging by the initial tensile strength and multiplying by 100.

#### **Method for determining epoxy equivalent weight (EEW) and % oxirane oxygen content**

The epoxy equivalent weight of the samples was measured and calculated using  
20 titrimetry according to the following procedure. Each sample (about 0.5-0.9 milliequivalents epoxy) was weighed to the nearest 0.0001 gram and was then dissolved in 50 mL chloroform in a 100 mL beaker and stirred magnetically until dissolved. A solution of 10 weight percent tetrabutylammonium iodide in acetic acid (10 mL) and acetic acid (20 mL) was added to the sample solution and stirred for approximately 15 minutes. A  
25 drop of 0.1 weight percent methyl violet indicator solution in acetic acid was then added. The mixture was titrated with a 0.1 N solution of perchloric acid in acetic acid to the potentiometric endpoint. The potentiometer was a Metrohm 751 Titrino with a Metrohm 6.0229.010 Solvotrode electrode that was obtained from Metrom AG, Switzerland. A blank was titrated using the sample procedure without the sample aliquot. The volume for  
30 the blank titration was subtracted from the total titration volume from the above procedure. Samples were run in triplicate.

Calculations were performed as shown below:

$$\% \text{ Epoxy containing compound} = [100 (V)(N)(\text{Eq. Wt.})] \div [1000 (SW)]$$

$$\text{Epoxy Equivalent Weight (EEW)} = [1000 (SW)] \div [(V)(N)]$$

$$\% \text{ oxirane content} = [100 \times (V) \times (N) \times 16] \div [1000 (SW)]$$

5 where V is the Volume of titrant used in milliliters, N is the Normality of the titrant, SW is the Sample Weight in grams, and Eq. Wt. is the Equivalent Weight. The Equivalent Weight is the Molecular Weight of the epoxy containing compound in grams divided by the number of equivalents per gram.

### Example 1

10 A PLA spunbond nonwoven web was prepared using the method described above (AP was 12 psi). The dry basis weight of the web was about 60 grams/meter<sup>2</sup>. Wet wipes were prepared using Solution 1 (S1) having PARAPLEX G-60, (G-60) epoxidized soybean oil added to the solution (S1:G-60 = 95:5). Wet wipes were also prepared using Solution 1 (S1) without any epoxidized vegetable oil additive for comparison. The wet  
15 wipes were aged at 135°F (57°C) and tensile strength data was obtained as described above. The PLA wipe compositions, tensile strength, and % retention data are provided in Table 1.

**Table 1**

Tensile Strength (kgf) - 135°F (57°C) aging

<b>Example</b>	<b>Control 1</b>	<b>1</b>
<b>Aging (days)</b>	<b>PLA web in S1</b>	<b>PLA web in S1 with G-60 (95:5)</b>
7		8.8808
15		9.1228
21		7.5429
23	7.7441	7.7973
30	4.9153	6.0653
32	4.7994	5.0809
35	2.6593	4.0574
36	2.4921	3.9551
37		3.5620
38	1.2082	2.2830
39	0.7103	1.7296
42		0.4127

**Example 2**

A PLA spunbond nonwoven web was prepared using the method described above (AP was 12 psi). The dry basis weight of the web was about 45 grams/meter<sup>2</sup>. Wet wipes were prepared using Solution 3 (S3) having PARAPLEX G-60, (G-60) epoxidized soybean oil added to the solution (S3:G-60 = 95:5). Wet wipes were also prepared using Solution 3 (S3) without any epoxidized vegetable oil additive for comparison. The wet wipes were aged at 158°F (70°C) and tensile strength data was obtained as described above. The PLA wipe compositions, tensile strength, and % retention data are provided in Table 2.

**Table 2**

Tensile Strength (kgf) - 158°F (70°C) aging

<b>Example</b>	<b>Control 2</b>	<b>2</b>
<b>Aging (days)</b>	<b>PLA web in S3</b>	<b>PLA web in S3 with G-60 (95:5)</b>
1	6.7997	6.5470
2	5.2716	5.4570
3	3.3413	4.1389
4	1.9852	2.9345
5	0.4683	1.3041
6		0.3643

**Example 3**

A PLA spunbond nonwoven web was prepared using the method described above (AP was 12 psi). The dry basis weight of the web was about 45 grams/meter<sup>2</sup>. Instead of hydroentangling the web, the web was calendared (approximately 10% bond area). Wet wipes were prepared using Solution 3 (S3) having PARAPLEX G-60, (G-60) epoxidized soybean oil added to the solution (S3:G-60 = 95:5). Wet wipes were also prepared using Solution 3 (S3) without any epoxidized vegetable oil additive for comparison. The wet wipes were aged at 135°F (57°C) and tensile strength and % retention data were obtained as described above. The PLA wipe compositions, tensile strength, and % retention data are provided in Table 3.

**Table 3**

Tensile Strength (kgf) and % Retention - 135°F (57°C) aging

<b>Example</b>	<b>Control 3</b>		<b>3</b>	
<b>Aging (days)</b>	<b>Calendared PLA web in S3</b>		<b>Calendared PLA web in S3 with G-60 (95:5)</b>	
	<b>Tensile Strength</b>	<b>% Retention</b>	<b>Tensile Strength</b>	<b>% Retention</b>
0	4.75	100	4.75	100
3	4.28	90	5.32	112
6	3.81	80	4.82	101
9	2.16	46	4.30	91
12	0.00	0	4.09	86
14			3.51	74
16			2.11	44
20			0.14	3

**5 Examples 4-9**

PLA spunbond nonwoven webs were prepared using the method described above (AP was 12 psi). The dry basis weight of the webs was about 60 grams/meter<sup>2</sup>. Wet wipes were prepared using Solution 1 (S1) that included epoxidized vegetable oils added in to the solution. Varying types and amounts of epoxidized vegetable oils were used to prepare the wet wipes and the epoxidized oils used also had different wt% oxirane oxygen content. Wet wipes were also prepared using Solution 1 (S1) without any epoxidized vegetable oil additive for comparison. The wet wipes were aged at 158°F (70°C) and tensile strength and % retention data were obtained as described above. The PLA wipe compositions, tensile strength, and % retention data are provided in Tables 4 and 5.

**Table 4**

Tensile Strength (kgf) - 158°F (70°C) aging

<b>Example</b>	<b>Control 4</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>
<b>Aging (days)</b>	<b>PLA web in S1</b>	<b>PLA web in S1 with VK-4050 (95:5)</b>	<b>PLA web in S1 with VK-5075 (95:5)</b>	<b>PLA web in S1 with VK-7170 (95:5)</b>	<b>PLA web in S1 with VK-7190 (99:1)</b>	<b>PLA web in S1 with VK-7190 (95:5)</b>	<b>PLA web in S1 with VK-7190 (90:10)</b>
0	8.2331	8.2331	8.2331	8.2331	8.2331	8.2331	8.2331
1	5.9194	6.9075	5.7313	6.6936	5.6329	5.6095	6.9027

2	6.3704	6.7115	6.8698	5.0394	6.5921	6.2562	5.3728
3	5.9150	5.8941	5.3893	6.2994	5.7845	5.9591	6.6367
4	5.6753	4.8882	4.5232	5.9794	5.9440	6.0347	5.1508
5	2.6698	3.9305	4.3467	4.1305	3.1839	4.5760	5.6941
6	0.8326	3.8304	1.7982	1.9080	1.8483	4.8500	4.2102
7	0	2.0229	0.9414	0.6505	0.9830	3.8334	3.6596
8		1.6485	0.2845	0	0	2.5059	1.8017

**Table 5**

% Retention - 158°F (70°C) aging

<b>Example</b>	<b>Contro l 4</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>
<b>Aging (days)</b>	<b>PLA web in S1</b>	<b>PLA web in S1 with VK-4050 (95:5)</b>	<b>PLA web in S1 with VK- 5075 (95:5)</b>	<b>PLA web in S1 with VK- 7170 (95:5)</b>	<b>PLA web in S1 with VK-7190 (99:1)</b>	<b>PLA web in S1 with VK- 7190 (95:5)</b>	<b>PLA web in S1 with VK- 7190 (90:10)</b>
0	100	100	100	100	100	100	100
1	72	84	70	81	68	68	84
2	77	82	83	61	80	76	65
3	72	72	65	77	70	72	81
4	69	59	55	73	72	73	63
5	32	48	53	50	39	56	69
6	10	47	22	23	22	59	51
7	0	25	11	8	12	47	44
8		20	3	0	0	30	22

**5 Examples 10 - 15**

PLA spunbond nonwoven webs were prepared using the method described above (AP was 12 psi). The dry basis weight of the webs was about 60 grams/meter<sup>2</sup>. Epoxidized vegetable oils were dissolved in ethyl acetate to 0.5 wt%, 1 wt% and 2 wt% solutions, which were disposed on the webs by soaking. The webs were then dried in an air oven at 60°C for 5 minutes. This resulted in webs having epoxidized vegetable oil contents of 2.5 wt%, 5 wt% and 10 wt% correspondingly based on the total weight of web plus the loaded epoxidized vegetable oil. Varying types and amounts of epoxidized vegetable oils were used and the epoxidized vegetable oils also had different wt% oxirane oxygen content. Wet wipes were then prepared from the coated PLA webs using Solution 1 (S1). Wet wipes were also prepared using Solution 1 (S1) without any epoxidized vegetable oil additive for comparison. The wet wipes were aged at 158°F (70°C) and tensile strength

and % retention data were obtained as described above. The PLA wipe compositions, tensile strength, and % retention data are provided in Tables 6 and 7.

**Table 6**

5 Tensile Strength (kgf) - 158°F (70°C) aging in Solution 1 (S1)

<b>Example</b>	<b>Control 5</b>	<b>10</b>	<b>11</b>	<b>12</b>	<b>13</b>	<b>14</b>	<b>15</b>
<b>Aging (days)</b>	<b>Uncoated PLA web</b>	<b>Coated PLA web PLA/VK-4050 (95:5)</b>	<b>Coated PLA web PLA/VK-5075 (95:5)</b>	<b>Coated PLA web PLA/VK-7170 (95:5)</b>	<b>Coated PLA web PLA/VK-7190 (97.5:2.5)</b>	<b>Coated PLA web PLA/VK-7190 (95:5)</b>	<b>Coated PLA web PLA/VK-7190 (90:10)</b>
0	8.2331	7.72053	6.06812	7.1274	6.7385	6.9502	7.1748
1	5.9194	6.50661	6.77606	6.3915	6.0356	7.9675	6.7671
2	6.3704	5.8719	5.61197	5.3091	5.8969	5.9760	5.5164
3	5.9150	6.51599	5.00827	5.8497	5.8368	6.2178	4.8855
4	5.6753	5.23444	5.77974	5.5459	5.0411	4.7404	6.3103
5	2.6698	5.11056	4.08648	3.6858	4.8927	4.3560	4.8191
6	0.8326	3.23923	3.38899	3.5453	4.6055	4.1273	4.1092
7	0			2.3650	3.4023	3.5058	4.4002
8				1.1583	2.5812	3.1096	3.2838

**Table 7**

% Retention - 158°F (70°C) aging in Solution 1 (S1)

<b>Example</b>	<b>Control 5</b>	<b>10</b>	<b>11</b>	<b>12</b>	<b>13</b>	<b>14</b>	<b>15</b>
<b>Aging (days)</b>	<b>Uncoated PLA web</b>	<b>Coated PLA web PLA/VK-4050 (95:5)</b>	<b>Coated PLA web PLA/VK-5075 (95:5)</b>	<b>Coated PLA web PLA/VK-7170 (95:5)</b>	<b>Coated PLA web PLA/VK-7190 (97.5:2.5)</b>	<b>Coated PLA web PLA/VK-7190 (95:5)</b>	<b>Coated PLA web PLA/VK-7190 (90:10)</b>
0	100	100	100	100	100	100	100
1	72	84	112	90	90	115	94
2	77	76	92	74	88	86	77
3	72	84	83	82	87	89	68
4	69	68	95	78	75	68	88
5	32	66	67	52	73	63	67
6	10	42	56	50	68	59	57
7	0			33	50	50	61
8				16	38	45	46

**Examples 16 - 21**

PLA spunbond nonwoven webs were prepared using the method described above (AP was 12 psi). The dry basis weight of the webs was about 60 grams/meter<sup>2</sup>. Epoxidized vegetable oils were dissolved in ethyl acetate to 0.5 wt%, 1 wt% and 2 wt% solutions, which were disposed on the webs by soaking. The webs were then dried in an air oven at 60°C for 5 minutes. This resulted in webs having epoxidized vegetable oil contents of 2.5 wt%, 5 wt% and 10 wt% correspondingly based on the total weight of web plus the loaded epoxidized vegetable oil. Varying types and amounts of epoxidized vegetable oils were used and the epoxidized oils also had different wt% oxirane oxygen content. Wet wipes were then prepared from the coated PLA webs using Solution 2 (S2). Wet wipes were also prepared using Solution 2 (S2) without any epoxidized vegetable oil additive for comparison. The wet wipes were aged at 158°F (70°C) and tensile strength and % retention data were obtained as described above. The PLA wipe compositions, tensile strength, and % retention data are provided in Tables 8 and 9.

**Table 8**

Tensile Strength (kgf) - 158°F (70°C) aging in Solution 2 (S2)

<b>Example</b>	<b>Control 6</b>	<b>16</b>	<b>17</b>	<b>18</b>	<b>19</b>	<b>20</b>	<b>21</b>
<b>Aging (days)</b>	<b>Uncoated PLA web</b>	<b>Coated PLA web PLA/VK-4050 (95:5)</b>	<b>Coated PLA web PLA/VK-5075 (95:5)</b>	<b>Coated PLA web PLA/VK-7170 (95:5)</b>	<b>Coated PLA web PLA/VK-7190 (97.5:2.5)</b>	<b>Coated PLA web PLA/VK-7190 (95:5)</b>	<b>Coated PLA web PLA/VK-7190 (90:10)</b>
0	8.1650	6.65362	6.23088	7.5680	8.2019	8.5145	8.8851
1	7.2035	4.5093	6.40667	7.3903	6.4483	6.4277	7.7954
2	6.2132	3.24408	3.61341	6.0700	6.1770	5.0689	5.2061
3	3.5920	2.03559	1.06699	3.5659	4.8018	5.3336	4.5335
4	1.7399	0.58129	0.47218	1.2129	3.2257	3.8005	5.2281
5	0.7926	0	0	0.3736	1.2296	3.5428	3.2105
6	0.2434			0.1895	0.5695	2.4567	3.6578
7				0.0000	0	1.5439	2.6655
8						0.8790	1.9650

**Table 9**

% Retention - 158°F (70°C) aging in Solution 2 (S2)

<b>Exempl e</b>	<b>Control 5</b>	<b>16</b>	<b>17</b>	<b>18</b>	<b>19</b>	<b>20</b>	<b>21</b>
<b>Aging (days)</b>	<b>Uncoate d PLA web</b>	<b>Coated PLA web PLA/VK-4050 (95:5)</b>	<b>Coated PLA web PLA/VK -5075 (95:5)</b>	<b>Coated PLA web PLA/VK -7170 (95:5)</b>	<b>Coated PLA web PLA/VK -7190 (97.5:2.5 )</b>	<b>Coated PLA web PLA/VK -7190 (95:5)</b>	<b>Coated PLA web PLA/VK -7190 (90:10)</b>
0	100	100	100	100	100	100	100
1	88	68	103	98	79	75	88
2	76	49	58	80	75	60	59
3	44	31	17	47	59	63	51
4	21	9	8	16	39	45	59
5	10	0	0	5	15	42	36
6	3			3	7	29	41
7				0	0	18	30
8						10	22

- 5           The complete disclosures of the patents, patent documents, and publications cited herein are incorporated by reference in their entirety as if each were individually incorporated. Various modifications and alterations to this disclosure will become apparent to those skilled in the art without departing from the scope and spirit of this disclosure. It should be understood that this disclosure is not intended to be unduly
- 10   limited by the illustrative embodiments and examples set forth herein and that such examples and embodiments are presented by way of example only with the scope of the disclosure intended to be limited only by the claims set forth herein as follows.



## What Is Claimed Is:

1. A fiber comprising:
  - a core comprising an aliphatic polyester; and
  - an epoxidized fatty ester having greater than 4.7 wt-% oxirane oxygen,
- 5 based on the total weight of the epoxidized fatty ester;
  - wherein the epoxidized fatty ester is disposed on the surface of the fiber
  - core in an amount of at least 0.5 wt-%, based on the total weight of the fiber.
- 10 2. The fiber of claim 1 wherein the epoxidized fatty ester has at least 5.5 wt-% oxirane oxygen.
3. The fiber of claim 1 wherein the epoxidized fatty ester has up to 23 wt-% oxirane oxygen.
- 15 4. The fiber of claim 1 wherein the epoxidized fatty ester is an epoxidized poly(fatty ester).
5. The fiber of claim 1 wherein the epoxidized fatty ester is present on the fiber in an amount of up to 20 wt-%, based on the total weight of the fiber.
- 20 6. The fiber of claim 1 wherein the epoxidized fatty ester is present on the fiber in an amount of at least 1 wt-%, based on the total weight of the fiber.
7. The fiber of claim 1 wherein the aliphatic polyester is selected from the group of
- 25 poly(lactide), poly(glycolide), poly(lactide-co-glycolide), poly(L-lactide-co-trimethylene carbonate), poly(dioxanone), poly(butylene succinate), poly(butylene adipate), poly(ethylene adipate), polyhydroxybutyrate, polyhydroxyvalerate, and blends and copolymers thereof.
- 30 8. The fiber of claim 7 wherein the aliphatic polyester is a poly(lactide).

9. The fiber of claim 1 wherein the aliphatic polyester has a number average molecular weight of at least 8,000 Daltons.
10. The fiber of claim 1 wherein the aliphatic polyester is present in an amount of at least 80 wt-%, based on the total weight of the aliphatic polyester, epoxidized fatty ester, and shrink reduction additive (if present).
11. The fiber of claim 1 wherein the fiber core further comprises a shrink reduction additive.
12. A web comprising a plurality of the fibers of claim 1.
13. The web of claim 12 which is a nonwoven web.
14. A wet wipe comprising:  
a nonwoven web of claim 13; and  
an aqueous composition comprising water and a surfactant and/or a biocide; wherein the aqueous composition contacts the nonwoven web.
15. A wet wipe comprising:  
a fibrous web comprising fibers, wherein each fiber comprises:  
a core comprising an aliphatic polyester; and  
an epoxidized fatty acid having greater than 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester;  
wherein the epoxidized fatty ester is disposed on the surface of the fiber core in an amount of at least 0.5 wt-%, based on the total weight of the fiber; and  
an aqueous composition contacting the fibrous web, the aqueous composition comprising:  
water; and  
a surfactant and/or a biocide.

16. The wet wipe of claim 15 wherein the aqueous composition comprises a surfactant,  
wherein the wet wipe is a cleaning wipe.
17. The wet wipe of claim 15 wherein the aqueous composition comprises a biocide,  
5 wherein the wet wipe is a disinfecting wipe.
18. A wet wipe comprising:  
a fibrous web comprising fibers, wherein each fiber comprises a core  
comprising an aliphatic polyester; and  
10 an aqueous composition contacting the fibrous web, wherein the aqueous  
composition comprises:  
water;  
a surfactant and/or a biocide; and  
an epoxidized fatty ester having greater than 4.7 wt-% oxirane  
15 oxygen, based on the total weight of the epoxidized fatty ester;  
wherein the epoxidized fatty ester is dispersed in the aqueous  
composition in an amount of at least 0.5 wt-%, based on the total weight of  
the aqueous composition.
- 20 19. A process for improving the hydrolytic stability of fibers comprising an aliphatic  
polyester, the method comprising:  
forming fibers comprising an aliphatic polyester; and  
depositing an epoxidized fatty ester on the surface of the fibers in an  
amount of at least 0.5 wt-%, based on the total weight of the fibers;  
25 wherein the epoxidized fatty ester has at least 4.7 wt-% oxirane oxygen,  
based on the total weight of the epoxidized fatty ester.
20. A process for improving the hydrolytic stability of a fibrous web comprising fibers  
comprising an aliphatic polyester, the method comprising:  
30 forming a fibrous web comprising fibers comprising an aliphatic polyester;  
providing an aqueous composition comprising:  
water;

an epoxidized fatty ester in an amount of at least 0.5 wt-%, based on the total weight of the aqueous composition; and

optionally, a surfactant and/or a biocide;

wherein the epoxidized fatty ester has at least 4.7 wt-% oxirane oxygen, based on the total weight of the epoxidized fatty ester; and

5

contacting the fibrous web with the aqueous composition to deposit the epoxidized fatty ester thereon.

# INTERNATIONAL SEARCH REPORT

International application No  
PCT/US2014/056463

<b>A. CLASSIFICATION OF SUBJECT MATTER</b> INV. D06M13/11 D06M13/224 D04H1/435 D06M101/32 ADD.		
According to International Patent Classification (IPC) or to both national classification and IPC		
<b>B. FIELDS SEARCHED</b> Minimum documentation searched (classification system followed by classification symbols) D06M D04H C08L C08K		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) EPO-Internal, WPI Data		
<b>C. DOCUMENTS CONSIDERED TO BE RELEVANT</b>		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	JP 2009 249450 A (TEIJIN LTD) 29 October 2009 (2009-10-29)	1-13, 19, 20
Y	paragraph [0007] - paragraph [0008] paragraph [0017] paragraph [0041] paragraph [0047] paragraph [0055] paragraph [0169]	14-18
X	JP 2011 256221 A (KUREHA CORP) 22 December 2011 (2011-12-22)	1-7, 9-12, 19, 20
Y	abstract paragraph [0025] paragraph [0046] paragraph [0056] - paragraph [0057] paragraph [0060]	14-18
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<div style="display: flex; justify-content: space-between;"> <span><input checked="" type="checkbox"/> Further documents are listed in the continuation of Box C.</span> <span><input checked="" type="checkbox"/> See patent family annex.</span> </div>		
<div style="display: flex;"> <div style="flex: 1;"> <p>* Special categories of cited documents :</p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier application or patent but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> </div> <div style="flex: 1;"> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art</p> <p>"&amp;" document member of the same patent family</p> </div> </div>		
Date of the actual completion of the international search  <div style="text-align: center; font-size: 1.2em;">7 January 2015</div>		Date of mailing of the international search report  <div style="text-align: center; font-size: 1.2em;">22/01/2015</div>
Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016		Authorized officer  <div style="text-align: center; font-size: 1.2em;">Fiocco, Marco</div>

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International application No

PCT/US2014/056463

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

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Y	paragraph [0025] - paragraph [0029] paragraph [0038] -----	14-18
Y	WO 2009/152349 A1 (3M INNOVATIVE PROPERTIES CO [US]; MOORE ERIC M [US]; SCHOLZ MATTHEW T) 17 December 2009 (2009-12-17) page 4, line 24 - page 5, line 17 page 12, line 27 - line 28 -----	14-18
A	EP 2 199 456 A1 (TORAY INDUSTRIES [JP]) 23 June 2010 (2010-06-23) paragraph [0009] - paragraph [0015] -----	1-20

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