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Disposable diaper featuring crotch tensioning means
for improved leakage resistance and fit

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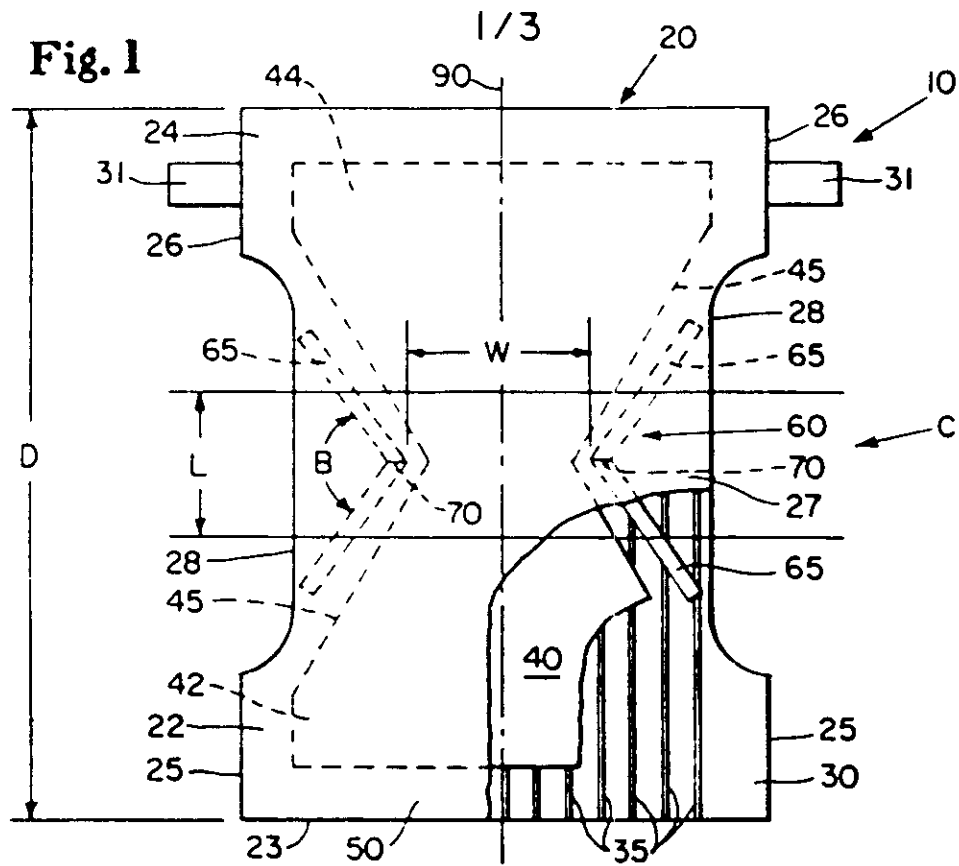
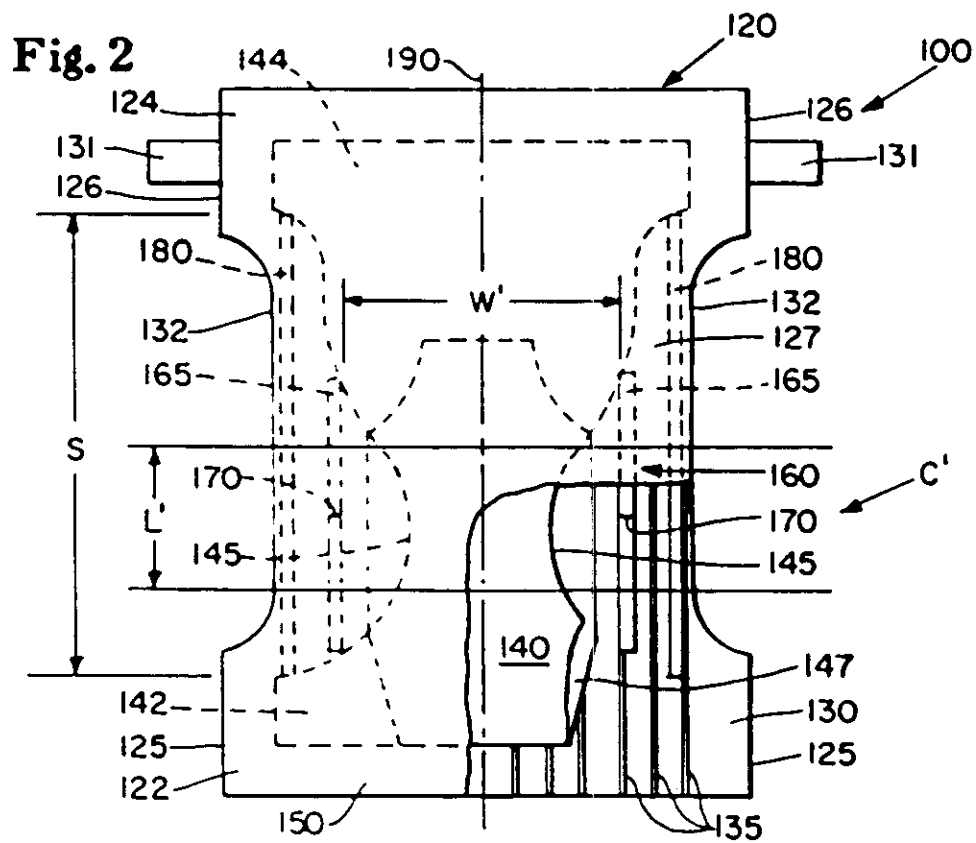
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2/3

Fig. 3
PRIOR ART

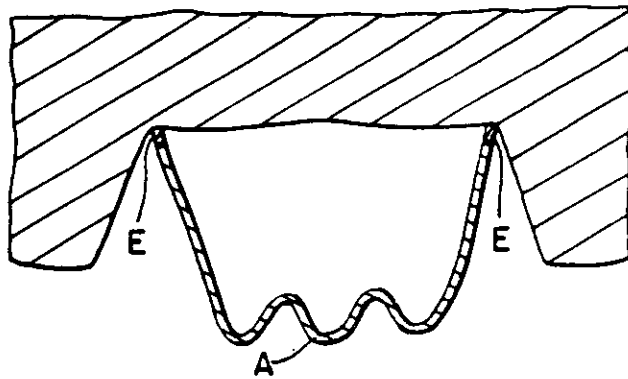


Fig. 4
PRIOR ART

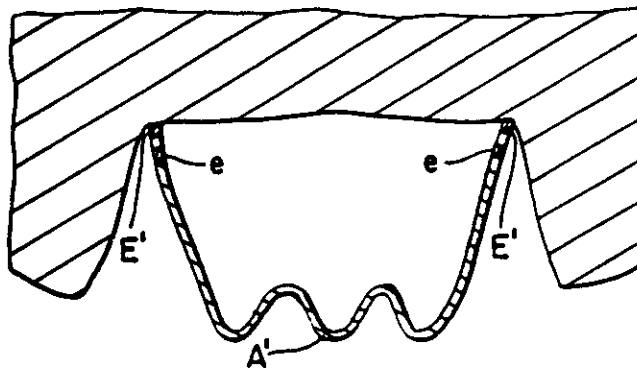
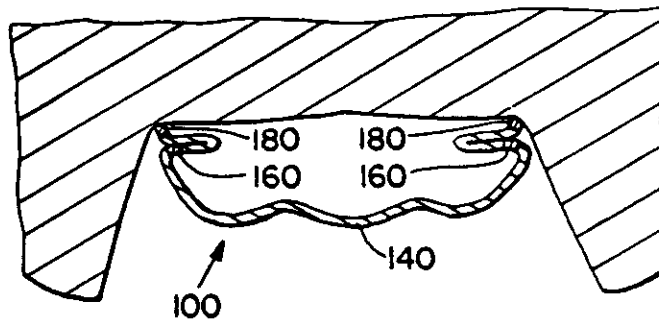


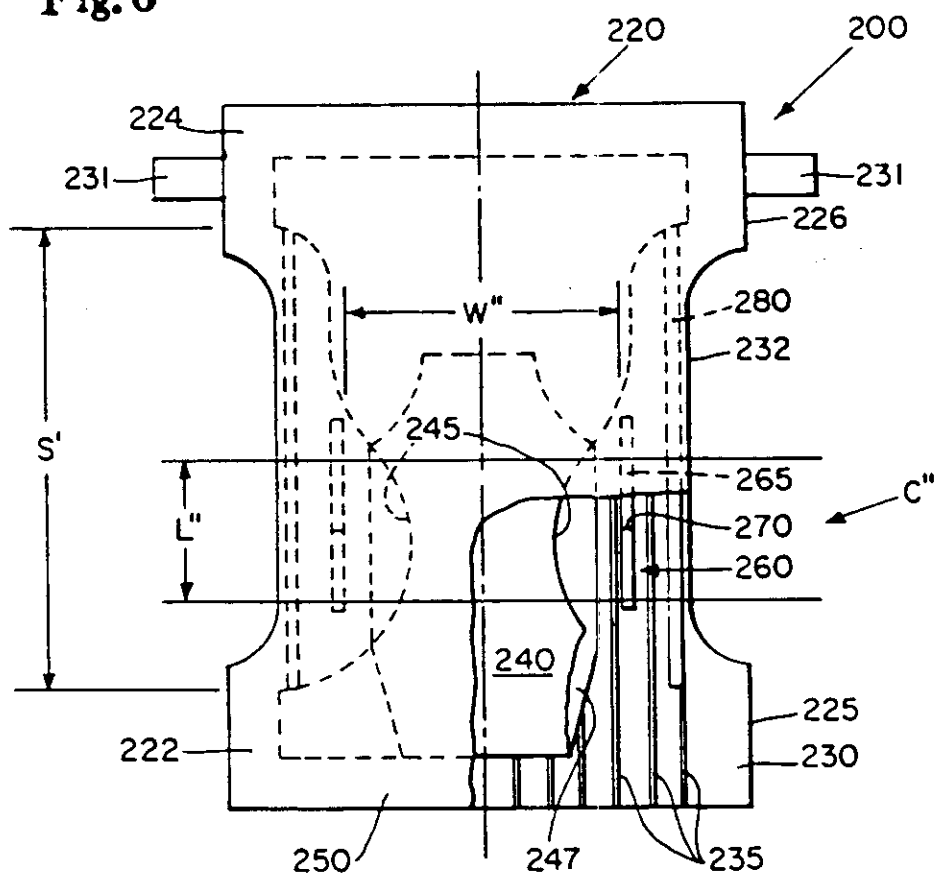
Fig. 5



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3/3

Fig. 6



DISPOSABLE DIAPER FEATURING CROTCH TENSIONING MEANS
FOR IMPROVED LEAKAGE RESISTANCE AND FIT

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TECHNICAL FIELD

This invention relates to a disposable diaper
and, more particularly, to a disposable diaper
having improved leakage resistance and fit as a result of tension-
ing means located within the crotch portion thereof.

BACKGROUND ART

Disposable diapers are well-known articles of manufacture
which are designed to be worn by infants and incontinent per-
sons. Disposable diapers are worn about the lower torso of the
user and are intended to absorb and contain voided urine and
feces thereby preventing the soiling, wetting, or similar contami-
nation of articles (e.g., clothing, bedding, other persons, etc.)
which may come into contact with such diaper in use.

There are numerous executions of disposable diapers avail-
able in the industry which generally comprise an absorbent core
encased between a liquid permeable user-contacting topsheet and
a liquid impermeable backsheet. Additionally, numerous dispos-
able diapers are available in the industry which feature elastic
means formed along that portion of the disposable diaper which
contacts the wearer's thighs to thereby provide elasticized leg
openings for such diaper in use. For example, U.S. Patent
3,860,003, which issued to K. B. Buell on January 14, 1975
discloses an integral disposable diaper which includes opposite,
flexible side flaps in the crotch area of the diaper having an
elastic member secured to each of such side flaps to provide an
elasticized, contractible line through the side flaps, making them
compliant and forming effective seals about the wearer's legs.
The Buell elastic members are operatively associated with the side

flaps so that in a normally unrestrained configuration, the elastic member effectively gathers the side flap material thereabout to provide an elasticized-contractible line through the side flaps adjacent the outer lateral edge thereof. A disposable diaper
5 featuring an elastically constricted crotch section is shown in U.S. Patent 4,050,462, which issued to Woon et al. on September 27, 1977. The Woon et al. diaper comprises a crotch section disposed between two opposite waist sections, with the crotch section being longitudinally constricted by elastic means secured
10 to the backing sheet adjacent each of the side edges of the crotch portion. The elastic means is designed such that when in the non-extended condition, a plurality of gross, transverse rugosities are provided across the width of the crotch section of the diaper. These transverse rugosities thereby reduce the length of
15 the crotch section without reducing the amount of the absorbent material therein, thereby effectively increasing the absorbent capacity per unit area of the diaper in its crotch area.

- Other prior art has been aimed at shaping the inner absorbent pad within the disposable diaper to reduce bulk in the
20 crotch area and improve the diaper's fit about the wearer's leg. For example, U.S. Patent 4,336,803, which issued to V. L. Repke on June 29, 1982, concerns a disposable diaper having a shaped absorbent pad which reduces the bulk between the wearer's legs while allegedly maintaining excellent absorptive efficiency of such
25 absorbent pad. Specifically, the Repke shaped absorbent pad is to have a series of indentations formed along its opposite longitudinal edges to provide a short area between one end of the pad and the deepest portion of the indentations, and a long area between the opposite area of the pad wherein a second indentation
30 is formed. The short portion of the absorbent pad is to be positioned in the front of the baby, and the longer portion is to extend between the babies legs and behind the buttocks. Such shape allegedly reduces bulk without negatively affecting absorptive capacity of the absorbent core. The Repke '803 diaper
35 further includes an elastic member along the longitudinal sides of the absorbent core to provide a tight fit about the baby's legs.

Similarly, U.S. Patent 4,430,086, which issued to V. L. Repke on February 7, 1984 discloses a disposable diaper which can include a shaped inner absorbent core; and comprising gathering means having at least two separately extending elastic elements. In particular, the Repke '086 diaper includes a pair of elastic strips extending along the opposite longitudinal sides of the diaper which provide two separate and distinct elastic gathers designed to define two separate lines of gasketing around the wearer's legs. The separation of the distinct elastic elements allegedly provides a greater area over which the elastic forces are distributed thereby minimizing the constrictive effect on the wearer's legs.

Despite all the prior work done in this area, there remain problems in optimizing the fit of disposable diapers while at the same time reducing the amount of urine leakage at the legs. Additionally, prior art diapers tend to sag downwardly and bunch inwardly in the crotch area during use, further negatively affecting the diaper's comfort and fit as well as its containment and absorptive functions. Elasticized leg openings tend to migrate into the wearer's leg creases in the crotch area thereby augmenting the sagging/bunching problem and reducing the ability of such prior art diapers to contain voided substances.

DISCLOSURE OF THE INVENTION

It is an object of this invention to obviate the above-described problems.

It is another object of the present invention to provide a disposable diaper which includes crotch tensioning means which tend to impose outward lateral tension on the crotch portion of the diaper when in use thereby improving aesthetic fit and containment characteristics of such diaper.

It is yet another object of the present invention to provide a disposable diaper whose inherent structure tends to direct voided substances directly into an absorbent core in the diaper thereby avoiding run-off and leakage.

In accordance with one aspect of the present invention, there is provided a disposable diaper having front and rear waist

portions and a crotch portion located intermediate said front and rear waist portions, said diaper comprising:

- a) a liquid permeable topsheet;
- b) a liquid impermeable backsheet, said backsheet being affixed to said topsheet;
- c) an absorbent core interposed between said topsheet and said backsheet, said absorbent core having oppositely disposed end portions and a pair of longitudinal side edges therebetween;
- d) a pair of side flaps, respectively adjacent each of said longitudinal side edges of said absorbent core;
- e) a pair of outboard elastics of predetermined length, one outboard elastic being associated with each side flap in an elastically contractible condition;
wherein the diaper also comprises
- f) crotch tensioning means associated with each of said side flaps and spaced laterally inwardly of the respective outboard elastics, for imposing outward lateral tension (as hereinafter defined) on the crotch portion of said diaper when in use, each said tensioning means having a predetermined length substantially less than that of the corresponding outboard elastic and comprising one or more elasticized members extending from an attachment area in said crotch portion, across the respective side flap to a location longitudinally outside of said crotch portion, said attachment areas in the respective side flaps being oppositely disposed and laterally spaced from one another by not more than approximately 153 mm to thereby establish said outward lateral tension in use on said crotch portion independent of any tension created by the outboard elastics, thereby to reduce sagging and bunching of the absorbent core in the crotch portion.

According to another aspect of the invention, there is provided a disposable diaper having front and rear waist portions and a crotch portion located intermediate said front and rear waist portions, said diaper comprising:

- a) a liquid permeable topsheet;
- b) a liquid impermeable backsheet, said backsheet being affixed to said topsheet;
- c) an absorbent core interposed between said topsheet and said backsheet, said absorbent core having oppositely disposed end portions and a pair of side edges extending generally longitudinally therebetween; said absorbent core having a width which varies intermediate said end portions thereof, said width reaching a minimum within said crotch portion of said diaper;
- d) a pair of side flaps, respectively adjacent each of said longitudinal side edges of said absorbent core; and
- e) a pair of elastics, respectively associated with each side flap in the crotch region in an elastically contractible condition; wherein the elastics comprise crotch tensioning means for imposing outward lateral tension as hereinafter defined on the crotch portion of said diaper when in use, each said tensioning means comprising elasticized members extending from an attachment line located at or adjacent a side edge of said absorbent core in said crotch portion, across the respective side flap to locations longitudinally outside of said crotch portion, to form a substantially v-shaped tensioning structure with its vertex along said attachment line, the attachment lines in the respective side flaps being oppositely disposed and laterally spaced from one another by not more than approximately 153 mm, to thereby establish, in use, said outward lateral tension on said crotch portion, thereby to reduce sagging and bunching of the absorbent core in the crotch portion.

BRIEF DESCRIPTION OF THE DRAWINGS

While the specification concludes with claims particularly pointing out and distinctly claiming the present invention, it is believed that the same will be better understood from the following description taken in conjunction with the accompanying drawings in which:

Figure 1 is a partially cutaway plan view of a disposable diaper of the present invention in an unfolded configuration;

Figure 2 is a partially cutaway plan view of a preferred embodiment of a disposable diaper of the present invention in unfolded condition;

Figure 3 is a partial cross-sectional schematic view of a prior art disposable diaper featuring elastic leg bands and illustrated as it would appear between the legs of a wearer in use;

Figure 4 is a partial cross-section schematic view of a prior art disposable diaper featuring dual elastic leg bands and illustrated as it would appear between the legs of a user in use;

Figure 5 is a partial cross-sectional schematic view illustrating a disposable diaper made in accordance with the present

invention as it would appear between the legs of a user in use; and.

Figure 6 is a partially cutaway plan view of a third embodiment of a disposable diaper of the present invention.

DETAILED DESCRIPTION OF THE INVENTION

Referring now to the drawings in detail, wherein like numerals indicate the same elements throughout the views, a disposable diaper 10 of the present invention is shown in Figure 1. As used herein, the term "disposable diaper" refers to a garment generally worn by infants or incontinent persons which is drawn up between the legs and fastened about the waist of the wearer, and which is intended to be discarded after a single use (i.e. it is not intended to be laundered or otherwise restored and reused).

Disposable diaper 10 is illustrated in Figure 1 in a partially cut-away perspective view illustrating diaper 10 in an unfolded condition. As can be seen in Figure 1, diaper 10 basically comprises a liquid permeable topsheet 50, an absorbent core 40, a liquid impermeable backsheet 30, and crotch tensioning means 60. While topsheet 50, absorbent core 40, and liquid impermeable backsheet 30 may be assembled in

a plethora of well known configurations, a preferred disposable diaper configuration is described generally in U.S. Patent 3,860,003 entitled "Contractible Side Portions for a Disposable Diaper", which issued to K. B. Buell on January 14, 1975.

Absorbent core 40 is interposed between topsheet 50 and backsheet 30, with backsheet 30 being affixed to topsheet 50. As described and illustrated herein, the topsheet of a disposable diaper of the subject invention is the layer which shall be located adjacent to the wearer in use (i.e., the innermost or user-contacting layer). The manner of locating absorbent core 40 between topsheet 50 and backsheet 30, as well as the manner of affixing backsheet 30 to topsheet 50, are not critical and can be accomplished by a variety of means known in the industry; such as by adhesives, heat sealing, or the like. In a preferred embodiment, a multiplicity of

spaced longitudinal adhesive bands 35 are applied along the full length of backsheet 30 generally parallel to the longitudinal center line 90 of diaper 10. The adhesive used for bands 35 is preferably a hot-melt adhesive, but can be any commonly available adhesive which is compatible with the various elements of disposable diaper 10. Longitudinal adhesive bands 35 serve to affix topsheet 50 to backsheet 30 at those locations where such topsheet, backsheet and adhesive bands interface with one another. The extent and location of the areas where topsheet 50, backsheet 30, and longitudinal adhesive bands 35 interface will depend on the spacing between such longitudinal adhesive bands 35, and on the location, shape and size of absorbent core 40 vis-a-vis topsheet 50 and backsheet 30. The number of longitudinal adhesive bands 35, and the spacing therebetween should be designed to sufficiently secure topsheet 50 to backsheet 30 in the area between the diaper periphery 20 and the periphery and longitudinal side edges 45 of absorbent core 40.

A hot-melt adhesive suitable for use as longitudinal adhesive bands 35 is available from the Eastman Chemical Products Company, Kingsport, Tennessee, and is marketed under the trade name of Eastobond A-3. Diaper periphery 20 is preferably formed by the boundaries of topsheet 50 and backsheet 30. In this regard, it is preferred that topsheet 50 and backsheet 30 feature substantially identical peripheral shapes and sizes so that their boundaries are in substantial registry with one another thereby forming diaper periphery 20. It will be noted that the described manner of affixing topsheet 50 to backsheet 30 results in topsheet 50 being intermittently attached to backsheet 30 and thereby encasing absorbent core 40 therebetween. It is contemplated that alternative methods of affixing topsheet 50 to backsheet 30 may be equally substituted for the above described procedure; for example, an intermediate member (not shown) may be used to affix topsheet 50 to backsheet 30, similarly encasing absorbent core 40 therewithin.

Disposable diaper 10 is shown as including a first or front waist portion 22 and a second or rear waist portion 24. Front

waist portion 22 extends from the front edge 23 of diaper 10 inwardly a predetermined distance toward the center of diaper 10. The rearwardly extending edges 25 of front waist portion 22 intersect with the front edges of the contoured edges 28 of diaper periphery 20. Similarly, the frontwardly extending opposite edges 26 of rear waist portion 24 intersect with the rear edges of contoured edges 28. While the longitudinal length of edges 25 and 26 may vary between particular embodiments of diaper 10, generally such waist portions extend toward the center of the diaper a distance from $1/4$ to $1/3$ the overall length of the diaper. Waist portions 22 and 24 comprise those portions of diaper 10 which, in use, encircle the waist of the wearer. On the other hand, crotch portion C is that portion of diaper 10 between front waist portion 22 and rear waist portion 24 which, in use, is positioned between the legs of the wearer. Crotch portion C is illustrated in Figure 1 as having a longitudinal length L. The remaining portions of diaper 10 situated between waist portions 22 and 24, respectively, and the crotch portion C, cover the front and rear lower torso of the wearer in use.

Absorbent core 40 may be any means which is generally compressible, conformable, non-irritating to the wearer's skin, and which is capable of absorbing and retaining liquids. Whilst the absorbent core 40 shown in Figure 1 is illustrated as comprising a single absorbent layer, it is contemplated that a plurality of absorbent layers could be combined and/or laminated to form absorbent core 40. Absorbent core 40 is intended to absorb and contain voided liquid and may be manufactured in a wide variety of sizes and shapes (e.g., rectangular, hourglass, etc.), and from a wide variety of liquid absorbent materials commonly used in disposable diapers (e.g., comminuted wood pulp which is generally referred to as "airfelt", creped cellulose wadding, absorbent foams or sponges, or the like). The total absorbent capacity of absorbent core 40 should be predetermined to be compatible with the designed liquid loading requirements and the intended use of the disposable diaper 10. Accordingly, the size and absorbent capacity of absorbent core 40 may be varied to

wearing applications ranging from infants through adults.

Absorbent core 40 is shown in Figure 1 as featuring a generally hourglass shape, and is intended to be worn by infants ranging in weight from 12 to 26 pounds (5 kgs. to 12 kgs.). Absorbent core 40 is preferably a bat of airfelt approximately 15.25 inches (387.4 mm) long when measured along longitudinal center line 90, approximately 10 inches (254 mm) across the front and rear ends 42 and 44, respectively, and approximately 3.25 inches (82.5 mm) across at its narrowest portion in crotch portion C. The absorptive capacity of the airfelt used for absorbent core 40 is preferably designed to be sufficient to absorb and retain from 8 to 16 grams of liquid per gram of absorbent material. Accordingly, in a typical diaper 10 designed for use on infants, the airfelt preferably weighs from 20 to 56 grams. It should be understood, however, that the dimensions, shape and configuration of absorbent core 40 may be varied to accommodate wearers ranging from infants through adults (e.g. the absorbent core may have a varying caliper, or a hydrophilic gradient, or may contain polymeric gelling agents). Additional layers of tissue (not shown) might also be included to improve the tensile strength of absorbent core 40 thereby reducing its tendency to split, lump or ball when wetted; and also to help improve lateral wicking of liquids to provide a more even distribution of liquid voided into the absorbent core 40. Such additional layers are preferably coterminous with absorbent core 40, however, they may have different dimensions and configuration if desired.

Absorbent core 40 is superimposed on backsheet 30 and is preferably affixed thereto by any means well known in the diaper art. For example, absorbent core 40 may be secured to backsheet 30 by a uniform continuous layer of adhesive, by a patterned layer of adhesive, or by a combination of lines and/or spots of adhesive. It is preferred that the longitudinal adhesive bands 35 discussed earlier be used to simultaneously affix absorbent core 40 to backsheet 30, as well as affixing topsheet 50 to backsheet 30.

Backsheet 30 is impermeable to liquids to thereby prevent liquids absorbed by absorbent core 40 from wetting the undergarments, clothing, bedding, and other objects with which a disposable diaper 10 may come into contact. A preferred material for backsheet 30 is a polyethylene film (e.g. polyethylene film number 8020 available from the Monsanto Chemical Company) of between .0005 and .002 inches (between 0.012 and 0.051 mm) in thickness, although other flexible, liquid impermeable materials may equally be utilized. As used herein, the term "flexible" connotes materials which are compliant and which readily conform to the varying shape and contours of the human body. It is preferred that backsheet 30 feature an embossed and/or mat finish to provide a more clothlike appearance and tactile impression. Further, backsheet 30 may be formed with passages which permit the escape of vapors from absorbent core 40 while preventing the passage of liquid therethrough.

As described above, backsheet 30 includes front and rear waist portions 22 and 24, respectively, and oppositely disposed contoured edges 28 thereby forming a modified hourglass shape which extends peripherally outwardly on all sides of absorbent core 40 forming a marginal portion 27 thereabout. Marginal portion 27 thereby preferably extends completely around the periphery of absorbent core 40, forming front and rear endflaps across the distal ends of waist portions 22 and 24, respectively, and oppositely disposed side flaps extending longitudinally on opposite sides of absorbent core 40 between waist portions 22 and 24. The exact width of marginal portion 27 is not critical and may vary in a specific diaper, as illustrated in Figure 1. As an example, however, the front and rear end flaps formed across the distal ends of waist portions 22 and 24 are typically 1.5 inches (38 mm) or less in length (measured longitudinally on diaper 10).

Topsheet 50 is to be formed of a compliant, relatively soft material which is non-irritating to the wearer's skin and prevents direct contact between absorbent core 40 and the wearer of diaper

10. Additionally, topsheet 50 is to be liquid-permeable to permit
voided liquid to readily penetrate therethrough as it is directed
to absorbent core 40. Various materials can be used to form
topsheet 50, such as natural fibers (e.g., wood or cotton fibers),
5 synthetic fibers (e.g., polyester or polypropylene), a combination
of natural and synthetic fibers, or any of the reticulated foams or
formed films which are well known in the art. A particularly
preferred material for topsheet 50 is a non-woven fabric compris-
ing staple length polypropylene fibers having a denier of about
10 1.5 (such as Hercules-type 151 polypropylene, available from
Hercules, Inc., Wilmington, Delaware). As used herein, the term
"staple length fibers" refers to those fibers having a length of
0.625 inches (15.9 mm). It is contemplated that
topsheet 50 could be produced by any of a number of manufactur-
15 ing processes commonly available in the industry. For example,
topsheet 50 may be woven, non-woven, spun-bonded, carded, or
the like. Preferably, topsheet 50 is carded and thermally bonded
by means well known to those skilled in the non-woven fabrics
art. A preferred topsheet 50 additionally has a weight of from
20 18 to 25 grams per square yard, a minimum dry
tensile strength of at least 400 grams per centimeter in the
machine direction, and a wet tensile strength of at least 55
grams per centimeter in the cross-machine direction.

Crotch tensioning means 60 are shown as being operatively
25 associated with the longitudinal side flaps of diaper 10, for im-
posing outward lateral tension on the crotch portion C of diaper
10 when in use. As used herein, the term "associated with"
refers to the structural relationship of crotch tensioning means 60
with a particular side flap. In particular, it has been found that
30 crotch tensioning means 60 must comprise one or more elasticized
member 65 extending from an attachment area 70
located at or adjacent the longitudinal edge 45 of
absorbent core 40 within crotch portion C of diaper 10.
At least two relatively oppositely disposed elasticized
members 65 are utilized to provide evenly distributed
outward lateral tension to crotch portion C. From

attachment area 70, crotch tensioning means 60 extends across the respective side flap to a location which is longitudinally outside of crotch area C. The exact location of attachment area 70 is not critical, however, it has been found that in order to most efficiently impose the desired outward lateral tension on crotch portion C of diaper 10, attachment area 70 should be located at or adjacent the longitudinal side edge of periphery 45 of absorbent core 40 within crotch portion C. It is, therefore, contemplated that attachment area 70 could be located

on the longitudinal side edge of periphery 45 of absorbent core 40, or on the longitudinal side flap adjacent the longitudinal edge of periphery 45 of absorbent core 40 within crotch area C. It has also been found that it is critical that the elasticized members 65 extend from attachment area 70 within crotch portion C to a location longitudinally outside of crotch portion C. Such structural requirement ensures that the desired outward lateral tension will be established by anchoring the source of that tension outside the crotch portion C.

As illustrated in Figure 1, crotch portion C will have an approximately predetermined length L for a particular embodiment of diaper 10. While the exact length L can vary between various embodiments of diaper 10, it is preferred that crotch portion C be located approximately in the central portion of diaper 10 having its front edge located approximately 35 percent of the overall longitudinal length D of diaper 10 rearwardly from front edge thereof, and having its rear edge located approximately 50 percent of the longitudinal length D of diaper 10 rearwardly of front edge 23. In this regard, it is preferred that crotch portion C be located somewhat forwardly of the physical center of diaper 10 to more closely correspond to the anatomy of the human body. It is also preferred that the narrowest portion of absorbent core 40 be located substantially in the center of crotch portion C.

In order to impose outward lateral tension on crotch portion C, attachment areas 70 are illustrated as located on the respective side flaps of diaper 10 adjacent core periphery 45 of absorbent core 40 within crotch portion C. While attachment areas 70 need

not be located adjacent the narrowest portion of absorbent core 40, it is preferred to locate such attachment areas approximate the center of crotch area C in order to more evenly distribute the outward tension thereacross. Similarly, while crotch tensioning means 60 are shown as comprising a pair of oppositely disposed elasticized members 65 extending outwardly from attachment points 70, it is contemplated that any number of elasticized members 65 could extend from the respective attachment areas 70 associated with each of the side flaps of diaper 10 to a location longitudinally outside of crotch portion C to establish the desired outward lateral tension thereon. Accordingly, a plurality of elasticized members 65 could extend from attachment area 70 to locations outside of crotch portion C. However, it must be remembered that such elasticized members 65 are to impose outward lateral tension on crotch portion C and so must be disposed in directions from attachment areas 70 to accomplish that function. As used herein, the term "outward lateral" tension defines the requirement that the resultant tension vector established by the crotch tensioning means in a diaper of the subject invention while in use will have a substantial outward component oriented approximately outwardly normal to the longitudinal center line (e.g., 90) or central axis of such diaper. Therefore, in diaper 10 as shown and described, the tension vectors established by the individual elasticized members 65 would include a component directed outwardly toward the contoured edges 28 thereof substantially perpendicular to center line 90. While orientation of the elasticized members 65 can be altered by varying the included angle B therebetween, it is critical that the resultant tension vectors of such elasticized members include a substantial outward component in order to establish the outward tension on diaper 10.

Elasticized members 65 are illustrated in Figure 1 as extending outwardly from attachment areas 70 thereby forming substantially V-shaped elasticized tensioning means 60. In particular, elasticized members 65 form the vertex of V-shaped tensioning means 60 along single attachment lines 70. This

particular V-shape structure has been illustrated only as an example, as it has been found that such elasticized members need not always extend outwardly relative to the longitudinal center line 90 of diaper 10 in order to impose such outward lateral tension. For example, as described in greater detail below with respect to Figure 2, elasticized members 65 can be substantially co-linear relative to one another along a line substantially parallel to center line 90 and still create the desired outward lateral tension on crotch portion C. The actual length of the individual elasticized members 65 is not critical except that such members must be sufficiently long to extend from attachment area 70 to a location longitudinally outside of crotch portion C.

In order to impose such outward lateral tension on crotch portion C, crotch tensioning means 60 are affixed to diaper 10 such that they tend to draw such crotch portion C outwardly in use. Thus, when worn, the diaper 10 will have an elasticized longitudinal portion in its crotch portion C. While crotch tensioning means 60 may be affixed to diaper 10 by any of several means well known in the diaper art, a particularly preferred diaper construction incorporating elastic strips is described in detail in the hereinbefore referenced U.S. Patent 3,860,003. In addition, a method and apparatus suitable for manufacturing a disposable diaper having elasticized portions are described in U.S. Patent 4,081,301 entitled "Method and Apparatus for Continuously Attaching Discrete, Stretched Elastic Strands to Predetermined Isolated Portions of Disposable, Absorbent Products" which issued to K. B. Buell on March 28, 1978.

In this manner, crotch tensioning means 60 are associated with each of the side flaps in an elastically contractible condition so that in a normally unrestrained configuration, elasticized members 65 effectively contract or gather the longitudinal side flaps of diaper 10. In a preferred embodiment, elasticized members 65 are affixed to a portion of backsheet 30 within the respective side flaps of marginal portion 27 as shown and described. A suitable adhesive for this purpose must be flexible and of sufficient adhesiveness to hold elasticized

members 65 to backsheet 30 while the elasticized members are stretched. An adhesive which has been used with satisfactory results for this purpose is manufactured by Century Adhesives Corporation of Columbus, Ohio, and is marketed under the trade name "Century 5227". Crotch tensioning means 60 may be incorporated into diaper 10 in such an elastically contractible condition in any manner known or conceivable by one skilled in the art. For example, elasticized members 65 may be stretched prior to affixation to backsheet 30, or, alternatively, portions of disposable diaper 10 may be contracted (e.g., by pleating) prior to affixation of the unstretched elasticized member thereto.

The material or materials from which elasticized members 65 are formed is not critical and may be any of a number of suitable elastic materials such as natural rubber, or elastomeric films such as ethylene, propylene dimonomer, or polyurethane. Similarly, the width of elasticized members 65 is not critical, and typically may be varied as desired from 0.038mm to 25.4mm

or more. In addition to adhesives, elasticized members 65 may be affixed to diaper 10 in other manners well known in the art, such as by ultrasonic bonding or heat-sealing. A preferred elasticized member is manufactured of natural rubber (L-1900 Rubber Compound marketed by East Hampton Rubber Thread Co.) having a width of approximately 0.25 inches (6.35 mm), a thickness of approximately 0.007 inches (0.2 mm), and producing a tensile force of 100 grams when stretched 100 percent from its relaxed condition.

Diaper 10 is further illustrated as featuring outer fastening means or tape tabs 31 affixed to rear waist portion 24 near the rear edge of diaper 10 for maintaining front waist portion 22 and rear waist portion 24 in an overlapping configuration when diaper 10 is in use. Thus, diaper 10 is fitted to the wearer, and a waist closure is formed thereabout. Outer fastening means 31 must, therefore, be affixed to both the rear and front waist portions in a manner and with sufficient strength to resist forces acting to cause such waist portions to separate during wearing. It is contemplated that any of a variety of alternate fastening

means (e.g., velcro strips, patches, buttons, snaps, or the like) could equally be utilized as fastening means 31. In a preferred embodiment, fastening means 31 comprise tape tabs such as the Y-shaped tape as described in US Patent 3,848,594 entitled "Tape Fastening System for Disposable Diaper" which issued to K.B. Buell on November 19, 1974.

As illustrated in Figure 1, it has further been found that in order to impose sufficient outward lateral tension on the crotch portion C of diaper 10, attachment areas 70 should be oppositely disposed within crotch portion C and laterally spaced from one another by a distance W. It has been determined that W must be not greater than approximately 153mm on a diaper in order that appreciable amounts of outward lateral tension can be established. In other words, if the innermost points of the oppositely disposed attachment areas 70 of a diaper 10 are laterally spaced from one another by more than approximately 153 mm, insufficient outward lateral tension is created in the crotch portion C of a diaper 10, and the advantages herein described cannot be achieved. If attachment areas 70 were each to be located near the centre of crotch portion C along centerline 90, (i.e. W effectively equal to zero), such a placement would not be desirable as crotch tensioning means 60 might then tend to precipitate bunching of absorbent core 40 in the crotch area. To avoid such bunching, attachment areas 70 should be located at or adjacent opposite longitudinal side edges of periphery 45 of absorbent core 40, as shown in Figure 1.

An alternate and preferred embodiment of diaper 10 is shown in Figure 2, where disposable diaper 100 is illustrated as including a pair of outboard elastics 180, with one outboard elastic being associated with each side flap in an elastically contractible condition and being spaced laterally outward from elasticized members 165 of crotch tensioning means 160. In diaper 100, attachment areas 170 comprise substantially laterally extending attachment lines and elasticized members 165 extend from such attachment lines in exactly opposite longitudinal directions such that elasticized

members 165 are co linear and extend longitudinally and substantially parallel to the central longitudinal axis 190 of diaper 100. Absorbent core 140 is illustrated as including a second layer of absorbent material 147 which does not conform identically to the shape of absorbent core 140. Such multilayer absorbent core 140 is shown as an example of such a core having a plurality of layers which are not coterminous about their periphery, as mentioned above.

Diaper 100 is illustrated as a more preferred embodiment of the diaper of the subject invention, with the outboard elastics 180 affixed to diaper 100 along both longitudinal side flaps in marginal portion 127, and being designed to draw and hold diaper 100 against the legs of the wearer. Thus, when worn, diaper 100 will have elasticized leg openings in addition to crotch tensioning means. Diaper 100 further illustrates another example of the substantially unlimited shapes and configurations of the absorbent core of the diaper of the subject invention. As described above with regard to diaper 10, crotch tensioning means 160 are designed to impose outward lateral tension on crotch portion C' in use. Unlike crotch tensioning means 60 however, crotch tensioning means 160 are oriented substantially parallel to central axis 190 of diaper 100, having substantially no apparent outward component of the tensioning vectors established by elasticized members 165. However, in use, the wearer's legs will tend to bunch diaper 100 inwardly, putting inward tension on crotch tensioning means 160. Such inward tension is resisted by crotch tensioning means 160, thereby establishing a tension vector having a substantial outward component which tends to impose outward lateral tension on the crotch portion C' of diaper 100. It has been found that to permit the bunching normally created by the wearer's legs to establish such outward lateral tension in diapers having crotch tensioning means 160 oriented substantially parallel to central axis 190, distance W' between attachment lines 170 must be at least 60 mm. If distance W' is less than approximately 60 mm, insufficient outward lateral tension is provided in crotch portion C' to reduce sagging and bunching therein, as will be described below. W' is more preferably from 101mm to 115 mm.

Outboard elastics 180 are preferably spaced a sufficient lateral distance from such crotch tensioning means 160 to enable substantially independent action of such outboard elastics from such crotch tensioning means. As used herein, the term "independent action" refers to the ability of crotch tensioning means 160 to impose the desired outward lateral tension without relying on or being impaired significantly by tension about the wearer's legs created by outboard elastics 180. Outboard elastics 180 create a snug fit of diaper 100 about the legs of the wearer, while crotch tensioning means 160 provide outward lateral tension on crotch portion C' of diaper 100. As shown in Figure 2, outboard elastics 180 will preferably have an effective length S which is substantially longer than the required length corresponding crotch tensioning means 160. This is generally true because outboard elastics 180 are designed to provide leg openings which extend around substantially the circumference of the wearer's leg, while, as described above, crotch tensioning means 160 need only extend to locations longitudinally outside of crotch portion C'.

In use, both diapers 10 and 100 perform generally in identical fashions. For example, disposable diaper 100 is generally fitted to the wearer so that diaper 100 conforms to the wearer's waist and legs thereby providing protection against leakage. As generally described above, after diaper 100 is fitted about the waist of the wearer, tape tabs 131 are utilized to affix rear waist portion 124 in an overlapping relationship to front waist portion 122. The extent to which the rear waist portion 124 is overlain on front waist portion 122 will depend on the overall dimensions and shape of diaper 100, and the size of the wearer.

Figure 5 illustrates a partial cross-sectional schematic view of the crotch portion C' of diaper 100 as it would generally appear between the legs of a wearer. As described above, elasticized leg openings of diapers tend to migrate into the creases between the wearer's leg in use, as shown by the location of outboard elastics 180 adjacent such leg creases in Figure 5. However, crotch tensioning means 160 would tend to be located generally below outboard elastics 180 and, as described above,

tending to impose outward lateral tension on crotch portion C' of diaper 100, thereby acting to reduce sagging/bunching of diaper 100 between the legs of the wearer and improving aesthetic fit and containment characteristics of the diaper. By imposing
5 outward tension on the crotch portion of diaper 100, crotch tensioning means 160 function to help maintain crotch portion C' nearer to the wearer's body and minimize bunching of diaper 100, thereby facilitating the direction of voided substances directly into absorbent core 140 and greatly reducing liquid run-off and
10 leakage often permitted by otherwise sagging/bunching diapers.

In this regard, Figures 3 and 4 illustrate partial cross-sectional schematic views of prior art diaper structures which do not include the unique crotch tensioning means of the present invention. In particular, Figure 3 illustrates a disposable diaper
15 which includes a single pair of elasticized leg openings E and an absorbent core A. As described, in use the elasticized leg openings E tend to migrate into the wearer's leg creases, and without the crotch tensioning means of the present invention, the absorbent core A and the balance of the diaper located between
20 elasticized leg openings E tends to sag downwardly and bunches inwardly in the crotch area. Such sagging/bunching vitiates the aesthetic fit of such diapers and impairs its ability to contain voided fluids therein. Similarly, Figure 4 illustrates a prior art diaper having dual elasticized leg openings, illustrated by the
25 inboard elastics e and outboard elastics E'. As can be seen in Figure 4, the dual elastics similarly tend to migrate into the wearer's leg creases in the crotch area, again permitting substantial sagging/bunching in the diaper crotch area. Figures 3 and 4, therefore, illustrate the fact that dual elastics alone do not
30 achieve the outward lateral tension of the subject diapers because they lack the crotch tensioning means of the subject invention. As mentioned, aesthetic fit and containment characteristics of such diapers are greatly compromised as a result of this general tendency to sag or bunch in the crotch area.

35 In contrast, it can be clearly seen in Figure 5 that the crotch tensioning means 160 of diaper 100 being oppositely

disposed adjacent core 140 and laterally spaced from one another at a predetermined width of between approximately 60 mm and 153 mm, tend to impose outward lateral tension on the crotch portion of diaper 100, thereby greatly reducing sagging and bunching in the crotch portion of such diaper, and thereby improving the aesthetic fit and the ability of the diaper structure to direct voided substances directly into absorbent core 140. It is this tendency to recover from the sagging/bunching forces normally encountered in the crotch area of a diaper during use which distinguishes diapers of the subject invention from others. The result is a disposable diaper having greatly improved leakage resistance and aesthetic fit. It should be noted that while obviously no deformable diaper structure can completely resist inward compression of the crotch area of the diaper between the wearer's legs when the legs are held in close proximity to one another, it is the unique characteristic of the diapers of the subject invention to tend to recover in an outward direction thereby reducing diaper bunching or compression during movement of the wearer's legs and thereby reducing the diaper's tendency to sag.

Figure 6 illustrates yet another embodiment of a diaper made in accordance with the subject invention. In particular, disposable diaper 200 is illustrated as being substantially identical to diaper 100, described above, except that crotch tensioning means 260 extend from attachment 270 to a location only a short distance longitudinally outside of crotch portion C". Diaper 200 is illustrated merely to emphasize that crotch tensioning means of the subject invention need only extend from their attachment area within the crotch portion of a diaper, to a location longitudinally outside of such crotch portion. In this regard, elements designated in Figure 6 by numerals having their last two digits the same as the last two digits of numerals shown in Figures 1 and 2, respectively, indicate corresponding elements.

Crotch tensioning means 160 of diaper 100 are illustrated in Figure 2 as having their distal ends adjacent the longitudinal edges of periphery 145 of absorbent core 140. While this

arrangement is preferred as providing slightly more outward tension in crotch portion C', it has been found that the shorter crotch tensioning means 260 of diaper 200 can also be utilized to achieve the benefits of the subject invention while minimizing the
5 elastic material necessary to form crotch tensioning means 260.

CLAIMS

1. A disposable diaper having front and rear waist portions and a crotch portion located intermediate said front and rear waist portions, said diaper comprising:
 - a) a liquid permeable topsheet;
 - b) a liquid impermeable backsheet, said backsheet being affixed to said topsheet;
 - c) an absorbent core interposed between said topsheet and said backsheet, said absorbent core having oppositely disposed end portions and a pair of longitudinal side edges therebetween;
 - d) a pair of side flaps, respectively adjacent each of said longitudinal side edges of said absorbent core;
 - e) a pair of outboard elastics of predetermined length, one outboard elastic being associated with each side flap in an elastically contractible condition;
wherein the diaper also comprises
 - f) crotch tensioning means associated with each of said side flaps and spaced laterally inwardly of the respective outboard elastics, for imposing outward lateral tension (as hereinbefore defined) on the crotch portion of said diaper when in use, each said tensioning means having a predetermined length substantially less than that of the corresponding outboard elastic and comprising one or more elasticized members extending from an attachment area in said crotch portion, across the respective side flap to a location longitudinally outside of said crotch portion, said attachment areas in the respective side flaps being oppositely disposed and laterally spaced from one another by not more than approximately 153 mm to thereby establish said outward lateral tension in use on said crotch portion independent of any tension created by the outboard elastics, thereby to reduce sagging and bunching of the absorbent core in the crotch portion.

2. A disposable diaper according to claim 1, wherein said crotch tensioning means each comprise two or more substantially straight elasticized members extending from said attachment areas in relatively opposite longitudinal directions such that their distal ends are located outside said crotch portion.
3. A disposable diaper according to claim 2, wherein the attachment area is a single attachment line, each attachment area being located adjacent the longitudinal edge of said absorbent core, and wherein said elasticized members extend from such attachment line in exactly opposite longitudinal directions such that such elasticized members are co-linear and extend longitudinally and substantially parallel to the central longitudinal axis of said diaper, said oppositely disposed attachment areas being laterally spaced from one another by at least 60 mm.
4. A disposable diaper according to claim 3, wherein said oppositely disposed attachment areas are laterally spaced from one another by from 101 to 115 mm.
5. A disposable diaper according to any one of claims 1-4, wherein said absorbent core has a width which varies intermediate said end portions thereof, said width reaching a minimum within said crotch portion of said diaper.
6. A disposable diaper according to claim 1 substantially as described with reference to Figures 2, 5 and 6 of the Drawings.

7. A disposable diaper having front and rear waist portions and a crotch portion located intermediate said front and rear waist portions said diaper comprising:
- a) a liquid permeable topsheet;
 - b) a liquid impermeable backsheet, said backsheet being affixed to said topsheet;
 - c) an absorbent core interposed between said topsheet and said backsheet, said absorbent core having oppositely disposed end portions and a pair of side edges extending generally longitudinally therebetween; said absorbent core having a width which varies intermediate said end portions thereof, said width reaching a minimum within said crotch portion of said diaper;
 - d) a pair of side flaps, respectively adjacent each of said longitudinal side edges of said absorbent core; and
 - e) a pair of elastics, respectively associated with each side flap in the crotch region in an elastically contractible condition; wherein the elastics comprise crotch tensioning means for imposing outward lateral tension as hereinbefore defined on the crotch portion of said diaper when in use, each said tensioning means comprising elasticized members extending from an attachment line located at or adjacent a side edge of said absorbent core in said crotch portion, across the respective side flap to locations longitudinally outside of said crotch portion, to form a substantially v-shaped tensioning structure with its vertex along said attachment line, the attachment lines in the respective side flaps being oppositely disposed and laterally spaced from one another by not more than approximately 153 mm, to thereby establish, in use, said outward lateral tension on said crotch portion, thereby to reduce sagging and bunching of the absorbent core in the crotch portion.

8. A disposable diaper according to claim 1 substantially as described with reference to Figure 1 of the Drawings.
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