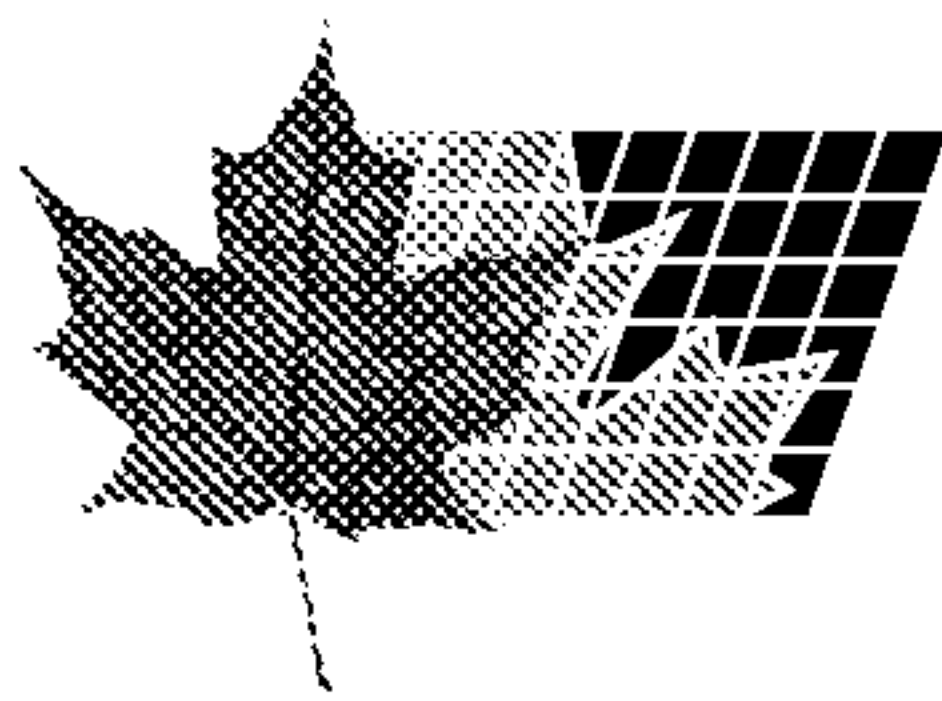
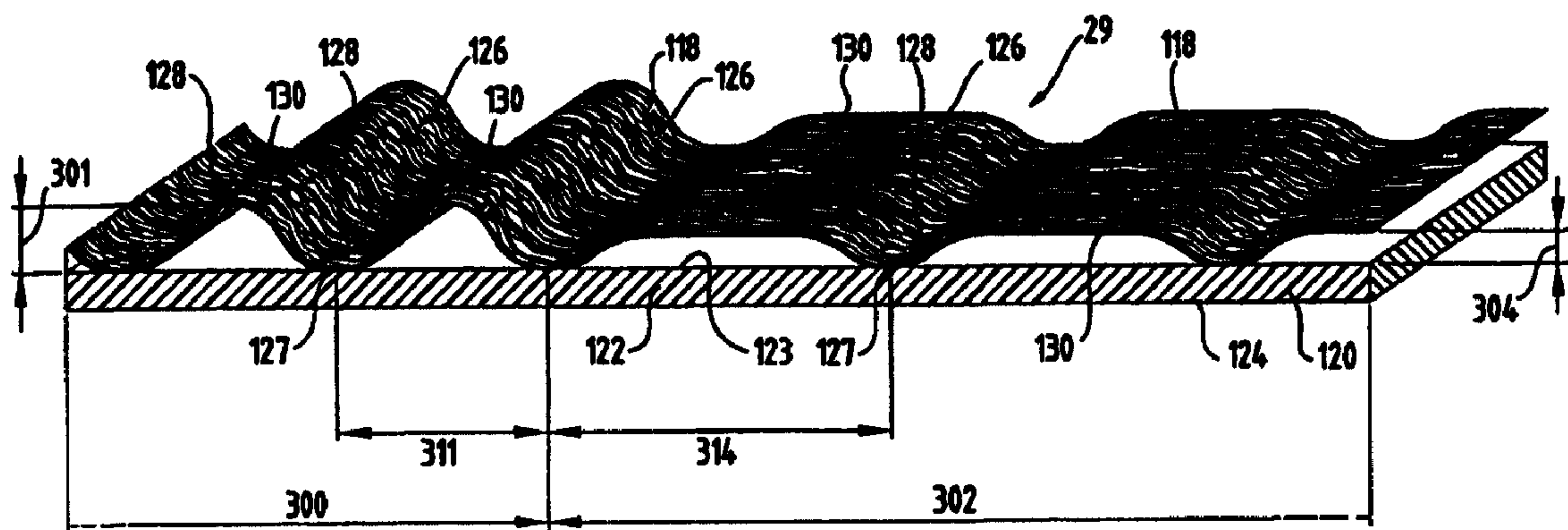




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(51) Int.Cl.⁶ B32B 3/30, A61F 13/15
(54) **ELEMENT A MULTIPLES ZONES**
(54) **MULTIPLE ZONE MEMBER**



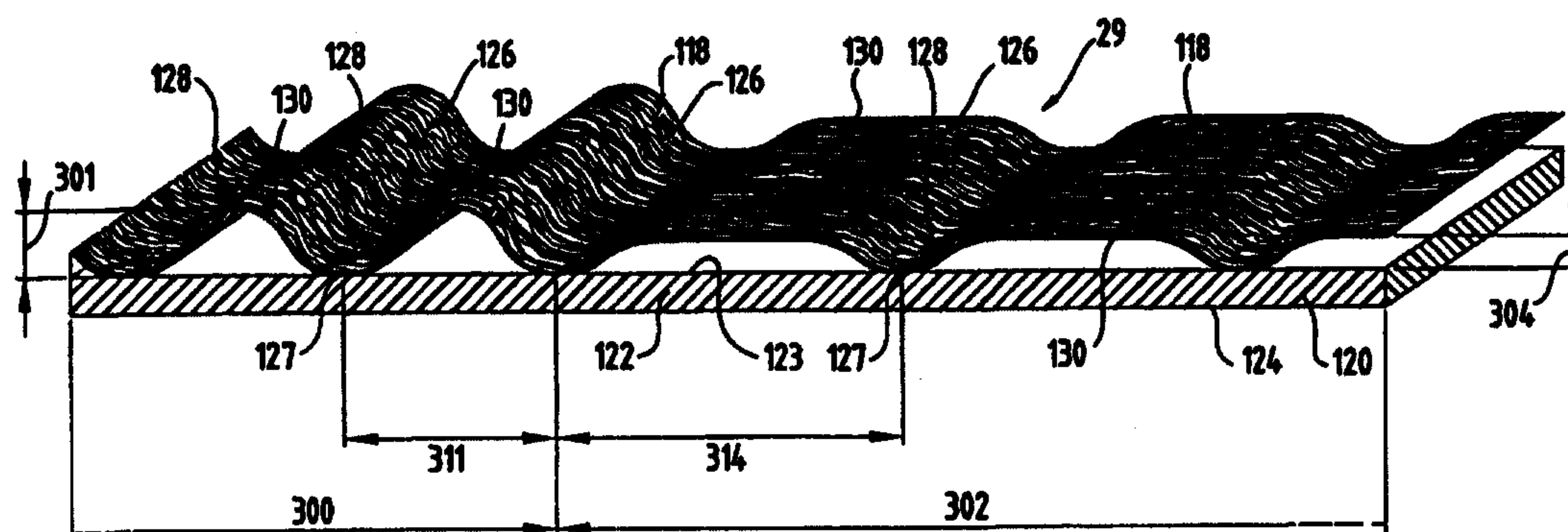
(57) L'invention concerne un élément (29) à multiples zones présentant au moins une première zone (300) et une seconde zone (302). L'élément comprend un support (120, 122) et une feuille de fibres (126). La feuille de fibres dans la première zone présente des parties (127) entrant en contact avec le support à des emplacements de liaison (128) espacés et présente des parties arquées (130) de la feuille faisant saillie à partir du support entre les emplacements de liaison. Les parties arquées de la première zone présentent une hauteur (301) s'étendant à partir du support. La feuille de fibres de la première zone présente des parties entrant en contact avec le support à des emplacements de liaison espacés et présente des parties arquées de la feuille faisant saillie depuis le support entre les emplacements de liaison. Les parties arquées de la seconde zone présentent une hauteur (304) s'étendant depuis le support qui est inférieure à la hauteur des parties arquées s'étendant depuis le support de la première zone.

(57) The present invention is a multiple zone member (29) having at least a first zone (300) and a second zone (302); the member includes a backing (120, 122) and a sheet of fibers (126); the sheet of fibers in the first zone having anchor portions (127) in the backing at spaced bonding locations (128) and having arcuate portions (130) of the sheet projecting from the backing between bonding locations; the arcuate portions in the first zone having a height (301) from the backing; the sheet of fibers in the second zone having anchor portions in the backing at spaced bonding locations and having arcuate portions of the sheet projecting from the backing between bonding locations; the arcuate portions in the second zone having a height (304) from the backing which is less than the height of the arcuate portions from the backing in the first zone.

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(21) International Application Number: PCT/US98/06560 (22) International Filing Date: 2 April 1998 (02.04.98) (71) Applicant (for all designated States except US): THE PROCTER & GAMBLE COMPANY [US/US]; One Procter & Gamble Plaza, Cincinnati, OH 45202 (US). (72) Inventors; and (75) Inventors/Applicants (for US only): BUSAM, Ludwig [DE/DE]; Talstrasse 17, D-65510 Huenstetten (DE). DIVO, Michael [DE/DE]; Feldbergstrasse 14, D-61381 Friedrichsdorf (DE). MULLER, Jorg [DE/DE]; Alte Haingasse 15, D-61184 Karben (DE). RAHROOH, Ghobad [IR/US]; 8203 Bent Tree Drive, West Chester, OH 45069 (US). (74) Agents: REED, T., David et al.; The Procter & Gamble Company, 5299 Spring Grove Avenue, Cincinnati, OH 45217 (US).		(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, GH, GM, GW, HU, ID, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, US, UZ, VN, YU, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG). Published <i>With international search report.</i>

(54) Title: MULTIPLE ZONE MEMBER**(57) Abstract**

The present invention is a multiple zone member (29) having at least a first zone (300) and a second zone (302); the member includes a backing (120, 122) and a sheet of fibers (126); the sheet of fibers in the first zone having anchor portions (127) in the backing at spaced bonding locations (128) and having arcuate portions (130) of the sheet projecting from the backing between bonding locations; the arcuate portions in the first zone having a height (301) from the backing; the sheet of fibers in the second zone having anchor portions in the backing at spaced bonding locations and having arcuate portions of the sheet projecting from the backing between bonding locations; the arcuate portions in the second zone having a height (304) from the backing which is less than the height of the arcuate portions from the backing in the first zone.

MULTIPLE ZONE MEMBER

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FIELD OF THE INVENTION

The present invention relates to a member having multiple zones, the member is particularly useful in disposable absorbent articles such as diapers, adult incontinence products, sanitary napkins and the like.

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BACKGROUND OF THE INVENTION

Disposable absorbent articles such as diapers and adult incontinence product are well known in the art. Such disposable absorbent articles collect and retain urine and fecal material deposited thereon by the wearer.

20

To date, most attempts in the art to handle the urine and fecal material collected and retained in the disposable absorbent article have been directed to handling urine. Dealing with fecal material collected by the disposable absorbent article is simply more difficult than dealing with urine, due to the complex rheology of fecal material.

25

Exemplary of the urine handling prior art are several attempts to provide disposable absorbent articles having a first topsheet which faces towards and contacts the body of the wearer, and a secondary topsheet under the first topsheet, which either absorbs urine, or transfers the urine to an underlying core for storage until the disposable absorbent article is removed from the wearer.

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Typically, the first topsheet and secondary topsheet have different material properties. The secondary topsheet may have a smaller pore size than the first topsheet, to assist in transfer of the urine through the topsheet. The first topsheet may be hydrophobic

and more resilient when wetted than the secondary topsheet, in order to pass fluids through the first topsheet to the secondary topsheet.

In yet another attempt in the prior art, the disposable absorbent article has a first topsheet, secondary topsheet and core. The secondary topsheet consists essentially of meltblown hydrophilic fibers and has a pore size greater than the pore size of the core. This arrangement allegedly allows the secondary topsheet to rapidly receive multiple liquid insults and distribute the liquid in the X-Y plane prior to absorption by the core. In yet another attempt, improved vertical wicking capability for urine has been allegedly achieved using inflated cellulose fibers which are free of a surface finish or are crosslinked to one another.

In another attempt in the prior art, an absorbent core suitable for acquiring and containing liquids such as urine in a particularly effective and efficient manner comprises multiple layers. The first layer, which is closest to the wearer, comprises hydrophilic fibrous material and has an acquisition zone of a relatively lower average density than other portions of this layer, in order to quickly acquire discharged liquids. Below the first layer is a liquid handling layer comprising a resilient, low density high void volume material that is moisture insensitive in order to rapidly acquire liquid insults into itself through the acquisition zone and distribute these liquids throughout the liquid handling layer to a storage layer. The storage layer comprises a combination of fibrous material and discrete particles of absorbent gelling material, and allows the liquid handling layer to be drained of the liquids it has acquired, so that the liquid handling layer may have sufficient capacity to acquire and distribute subsequent loadings of liquids.

Examples of such attempts in the prior art include U.S. Patents 4,047,531 issued September 13, 1977 to Karami; 4,798,603 issued January 17, 1989 to Meyer et al.; 5,037,409 issued August 6, 1991 to Chen et al.; 5,124,197 issued June 23, 1992 to Bernardin et al.; and 5,134,007 issued July 28, 1992 to Reising et al.

Of course, absorbent gelling materials are also now well known in the prior art for their urine handling capability. Absorbent gelling materials are polymeric materials capable of absorbing large quantities of fluids, such as urine, and retaining such absorbed fluids under moderate pressure. The effectiveness of the absorbent gelling materials is

quite dependent upon the form, position, and weight percentage of the absorbent gelling materials which are incorporated into the core of the disposable absorbent article.

Recent attempts have been made in the art to provide absorbent gelling materials which have the ability to swell against pressure. These teachings allege to provide the advantage that the absorbent gelling materials absorb fluid under actual pressures exerted by the body during use. Yet other teachings in the art provide absorbent gelling materials having a particular free swell rate and absorbency under load. Alleged advantages of such an absorbent gelling materials are lower volume and mass with approximately the same absorbent capacity, the ability to rapidly absorb a discharged liquid under pressures typically encountered during use, and the ability to retain the absorbed liquid under pressures typically encountered during use.

Examples of such attempts in the prior art include U.S. Patents 5,147,343 issued September 15, 1992 to Kellenberger and 5,149,335 issued September 22, 1992 to Kellenberger et al.

However, all of these attempts to handle urine do little, if anything, to improve handling of low-viscosity fecal material which may also be present in the disposable absorbent article. Attempts to deal with fecal material include providing a first topsheet which conforms closely to the wearer and has an aperture. The aperture is hopefully registered with the anal opening, so that fecal material passes therethrough into a void space. The first topsheet may comprise various elastic panels in order to closely conform to the skin of the wearer, and/or may have linear elastic strands. Improvements have been made in this area of the prior art, such as optimizing the material properties of the first topsheet. Such optimization makes the first topsheet more comfortable to the wearer and allows a single disposable absorbent article to fit a larger range of sizes of wearers.

Yet other attempts have been made in this area of the prior art to provide an absorbent core with a hole therein, in order to receive the fecal material. The hole may be oblate shaped, so that it is longer and narrower than the aperture in the first topsheet, or may be diamond shaped. The hole in the core may be positioned below an aperture which has elastic strips around its edge.

Improvements to this genre of the prior art disposable absorbent articles also include the addition of spacers. Spacers may be interposed between the first topsheet and the core, in order to ensure a void space is present to receive the fecal material.

Yet other attempts have been made in this genre of the prior art to provide barriers
5 which limit the movement of fecal material to particular portions of the disposable absorbent article. The barriers limit the contact of the fecal material to a lesser portion of the skin of the wearer, than a comparable disposable absorbent article which has no barriers.

Still other attempts in the prior art provide barrier leg cuffs which are upstanding
10 from the plane of the topsheet. The barrier leg cuffs prevent fecal material from breaching the perimeter of the disposable absorbent article.

Examples of such attempts to handle fecal material include U.S. Patent 4,892,536 issued January 9, 1990 to DesMarais et al.; U.S. Patent 4,909,803 issued March 20, 1990 to Aziz et al.; U.S. Patent 4,968,312 issued November 6, 1990 to Khan; commonly
15 assigned U.S. Patent 4,990,147 issued February 5, 1991 to Freeland; commonly assigned U.S. Patent 5,037,416 issued August 6, 1991 to Allen et al.; U.S. Patent 5,062,840 issued November 5, 1991 to Holt et al.; commonly assigned U.S. Patent 5,171,236 issued December 15, 1992 to Dreier et al.; and European Patent Application 0,355,740 A2 published February 28, 1990 to Enloe.

20 However, none of these attempts to handle fecal material solve the problem of low-viscosity fecal material which is prevalent in younger children, particularly those who are breast fed. Low-viscosity fecal material easily migrates within the disposable absorbent article under the influences of gravity and motion or pressure by the wearer.

The migration of the fecal material often moves it towards the perimeter of the
25 disposable absorbent article, increasing the likelihood of leakage. The migration of the fecal material also smears it against the skin of the wearer, making cleanup more difficult. In order to clean the wearer, the caretaker must wipe the entire area of the skin which has encountered the fecal material and typically has to deal with a relatively large soiled area.

One attempt in the art to handle low-viscosity fecal material is found in U.S. Patent
30 Application Serial No. 08/076,713 filed June 11, 1993 in the name of Roe. This

application is a disposable absorbent article having a first topsheet with a high trans-topsheet penetration overlaying a secondary topsheet having a lesser trans-topsheet penetration.

Accordingly, it is an object of this invention to provide a disposable absorbent article which reduces leakage of fecal material from the disposable absorbent article and minimizes the amount of low-viscosity fecal material remaining on the skin of the wearer once the disposable absorbent article is removed. It is further an object of this invention to provide a disposable absorbent article which separates the fecal material into components.

SUMMARY OF THE INVENTION

The present invention is directed to a multiple zone member having at least a first zone and a second zone which is particularly well suited for use as a topsheet or a fecal management member in a disposable absorbent article. The multiple zone member comprises a backing and a sheet of fibers, the sheet of fibers in the first zone having anchor portions in the backing at spaced bonding locations and having arcuate portions of the sheet projecting from the backing between bonding locations. The arcuate portions in the first zone having a height from the backing. The sheet of fibers in the second zone having anchor portions in the backing at spaced bonding locations and having arcuate portions of the sheet projecting from the backing between bonding locations. The arcuate portions in the second zone having a height from the backing which is less than the height of the arcuate portions from the backing in the first zone.

BRIEF DESCRIPTION OF THE DRAWINGS

While the specification concludes with claims particularly pointing out and distinctly claiming the subject matter which is regarded as the present invention, it is believed that the description will be better understood from the following descriptions which are taken in conjunction with the accompanying drawings in which like designations are used to designate substantially identical elements.

Figure 1 is a perspective illustration of a multiple zone member of the present invention.

Figure 2 is a perspective illustration of a second embodiment of a multiple zone member of the present invention.

5 Figure 3 is a perspective illustration of a third embodiment of a multiple zone member of the present invention.

Figure 4 is a plan view illustration of another embodiment of a multiple zone member of the present invention.

10 Figure 5 is a plan view illustration of another embodiment of a multiple zone member of the present invention.

Figure 6 is a schematic illustration of a method and equipment for making the multiple zone member of the present invention.

Figure 7 is a schematic illustration of another embodiment of a method and equipment for making the multiple zone member of the present invention.

15 Figure 8 is a plan view of an absorbent article embodiment of the present invention having portions cut away to reveal the underlying structure, the garment-facing surface of the diaper facing the viewer.

DETAILED DESCRIPTION OF THE INVENTION

20 While the present invention will be described in the context of providing a multiple zone member suitable for use as a topsheet or a fecal management member in a disposable absorbent article, the present invention is in no way limited to such application. The description of the multiple zone member and its use as a topsheet or a fecal management member will allow one skilled in the art to readily adapt the invention
25 to other devices and for other uses.

As used herein, the term "absorbent article" refers to devices which absorb and contain body exudates, and more specifically, refers to devices which are placed against or in proximity to the body of the wearer to absorb and contain the various exudates discharged from the body. The term "disposable" is used herein to describe absorbent
30 articles which generally are not intended to be laundered or otherwise restored or reused

as an absorbent article (i.e., they are intended to be discarded after a single use and, preferably, to be recycled, composted or otherwise disposed of in an environmentally compatible manner). (As used herein, the term "disposed" is used to mean that an element(s) of the diaper is formed (joined and positioned) in a particular place or position as a unitary structure with other elements of the diaper or as a separate element joined to another element of the diaper. As used herein, the term "joined" encompasses configurations whereby an element is directly secured to another element by affixing the element directly to the other element, and configurations whereby an element is indirectly secured to another element by affixing the element to intermediate member(s) which in turn are affixed to the other element.) A "unitary" absorbent article refers to absorbent articles which are formed of separate parts united together to form a coordinated entity so that they do not require separate manipulative parts like a separate holder and liner. As used herein, the term "diaper" refers to an absorbent article generally worn by infants and incontinent persons about the lower torso.

FIG. 1 illustrates a first embodiment of a multiple zone member according to the present invention, generally designated by the reference numeral 29. Generally the multiple zone member 29 comprises a sheet of loop material 118 having a backing 120 preferably comprising a thermoplastic backing layer 122 (e.g., of polypropylene) having front and rear major surfaces 123 and 124, and a multiplicity of longitudinally oriented fibers in a specially formed sheet of fibers 126. Multiple zone member 29 comprises at least two distinct zones. In the embodiment shown in Figure 1, the multiple zone member 29 has a first zone 300 and a second zone 302. While Figure 1 shows a multiple zone member 29 having two distinct zones, multiple zone member 29 may have even more zones, e.g., 3, 4, 10, 1000, etc. Sheet of fibers 126 have anchor generally non-deformed anchor portions 127 bonded by being fixed to the backing layer 122 at spaced elongate generally parallel bonding locations 128 that are continuous in one direction along the front surface 123 with arcuate portions 130 of the sheet of fibers 126 projecting from the front surface 123 of the backing layer 122 between the bonding locations 128 in continuous rows also extending transversely across the sheet of loop material 118. While

the individual fibers in the sheet of fibers 126 may be of any size, the individual fibers preferably have denier in the range of 1 to 30.

Sheet of fibers 126 preferably has a hydrophilicity which is less than the hydrophilicity of the backing 120. In a preferred embodiment, the sheet of fibers
5 themselves have a hydrophilicity gradient wherein the arcuate portions 130 have a hydrophilicity which is less than the hydrophilicity of the bonded locations 128. Even in this configuration it is preferred that the bonded locations 128 of the sheet of fibers 126 have a hydrophilicity which is less than the hydrophilicity of the backing 120.

Suitable materials for use as the backing 120 include but are not limited to
10 thermoplastic films, strips of thermoplastic film, porous films, apertured films, apertured formed films, unapertured formed films, nonwoven webs, strips of nonwoven material, hotmelt material, strips of hotmelt material, breathable materials, such as breathable films, including but not limited to microporous films, apertured nonwoven webs and the like. The backing 120 is preferably a relatively thin layer having a thickness in the range of
15 about 0.00125 to 0.025 centimeters.

As can be seen in Figure 1, the arcuate portions 130 in the second zone 302 have a height 304 from the backing 120 which is less than the height 301 of the arcuate portions 130 from the backing 120 in the first zone 300. The arcuate portions 130 in the first zone 300 have a generally uniform height 301 from the backing layer 122 of greater than about
20 0.5 millimeters, preferably greater than about 1.0 millimeter, and more preferably greater than about 2.0 millimeters. Of course, the arcuate portions 130 in the first zone 300 may have even greater heights from the backing layer 122, e.g., heights of greater than 3.0 millimeters or more.

As a result of the differences in the height of the arcuate portions within the first
25 and second zones, the sheet of fibers 126 in the first zone 300 has a basis weight greater than the basis weight of the sheet of fibers 126 in the second zone 302. If the backing 120 is of the same basis weight in the first and second zones, the multiple zone member 29 will then have a greater basis weight in the first zone 300 than in the second zone 302. The sheet of fibers 126 in the first zone 300 preferably has a basis weight in the range of 5

to 300 grams per square meter (and more preferably in the range of 15 to 100 grams per square meter) measured along the first surface 123.

As can be seen in Figure 1 the spacing 311 between bonding locations 128 in first zone 300 is less than the spacing 314 between bonding locations 128 in the second zone 302, i.e., the bonding locations are closer together in the first zone 300 than they are in the second zone 302. However, the spacing 311 between bonding locations 128 in first zone 300 may be the same, or greater than the spacing 314 between bonding locations 128 in the second zone 302 as long as the multiple zone member 29 has the aforementioned height differences between the first zone 300 and the second 302.

The fibers in the sheet of fibers 126 can be disposed in various directions with respect to the parallel bonding locations 128 and may or may not be bonded together at crossover points in the arcuate portions 130; can be disposed in various directions with respect to the parallel bonding locations 128 with the majority of the fibers in the sheet of fibers 126 (i.e., over 80 or 90 percent) extending in directions at about a right angle to the bonding locations 128; or all of the individual fibers in the sheet of fibers 126 can extend in directions generally at right angles to the spaced generally parallel bonding locations 128.

The anchor portions 127 are preferably of such dimension that a planar circle having a diameter of from about 0.2 millimeters to about 20 millimeters may be inscribed thereon, more preferably, the anchor portions 127 are preferably of such dimension that a planar circle having a diameter of from about 0.4 millimeters to about 10 millimeters may be inscribed thereon, and most preferably, the anchor portions 127 are preferably of such dimension that a planar circle having a diameter of from about 0.8 millimeters to about 5 millimeters may be inscribed thereon.

FIG. 2 illustrates a second embodiment of a multiple zone member according to the present invention, generally designated by the reference numeral 140, which multiple zone member 140 has the same structure as the multiple zone member 29 (the same reference numerals being used with respect to the corresponding portions thereof) except that backing 145 of the sheet of loop material 118 includes a second sheet of backing material 147, which second sheet of backing material 147 is adhered on the side 124 of

the backing layer 122 opposite the sheet of fibers 126. The second sheet of backing material 147 in the backing 145 of the sheet of loop material 118 may be a polymeric film. Other suitable materials for use as the second sheet of backing material 147 include but are not limited to porous films, apertured films, apertured formed films, unapertured
5 formed films, nonwoven webs, breathable materials, such as breathable films, including but not limited to microporous films, apertured nonwoven webs and the like. The second sheet of backing material 147 is preferably a relatively thin layer having a thickness in the range of about 0.00125 to 0.025 centimeters.

FIG. 3 illustrates a third embodiment of a multiple zone member according to the
10 present invention, generally designated by the reference numeral 150, which multiple zone member 150 has the same structure as the multiple zone member 29 (the same reference numerals being used with respect to the corresponding portions thereof) except that backing 155 of the sheet of loop material 118 includes a plurality of fibers 157. Fibers 157 of backing 155 can be disposed in various directions with respect to the
15 parallel bonding locations 128 and may or may not be bonded together; can be disposed in various directions with respect to the parallel bonding locations 128 with the majority of the fibers in the backing 155 (i.e., over 80 or 90 percent) extending in directions at about a right angle to the bonding locations 128; or all of the individual fibers 157 in the backing 155 can extend in directions generally at right angles to the spaced generally
20 parallel bonding locations 128. Preferably, the individual fibers 157 are not bonded together and are spaced from one another by a distance of from about 0.01 mm to about 10.0 mm. The fibers 157 have a denier within the range of about 0 - 50.

FIG. 4 is a top plan view of another embodiment of a fecal management member 202 of the present invention. Fecal management member 202 depicts one of many
25 possible configuration for the arrangement of the rows of arcuate portions 203.

FIG. 5 is a top plan view of another embodiment of a fecal management member 204 of the present invention. Fecal management member 204 depicts one of many possible configuration for the arrangement of the rows of arcuate portions 205.

In addition to the configurations shown in FIGS. 4 and 5, other possible
30 configurations for the arrangement of the rows of arcuate portions may also be used.

In another embodiment, the respective zones may have different configurations for the arcuate portions. For example, the first zone may comprise arcuate portions as shown in Figure 1, while the second zone comprises arcuate portions as shown in Figure 4. Of course, other combinations may also be used.

5 While the present invention has been described as a single material having two distinct zones, it is also contemplated that one may achieve the same results by bonding together two materials each having the characteristics of the first and second zones respectively.

FIG. 6 schematically illustrates a method and equipment for forming the multiple
10 zone member 29. The method illustrated in FIG. 6 generally comprises forming longitudinally oriented polymeric fibers into a sheet of fibers 126, forming the sheet of fibers 126 so that it has arcuate portions 130 projecting in the same direction from the spaced generally parallel anchor portions 127 of the sheet of fibers 126, and bonding the spaced generally parallel anchor portions 127 of the sheet of fibers 126 projecting from
15 the front surface 123 of the backing 120. This method is performed by providing first and second corrugating members or rollers 226 and 227 each having an axis and including a plurality of circumferentially spaced generally axially extending ridges 228 around and defining its periphery, with the ridges 228 having outer surfaces and defining spaces between the ridges 228 adapted to receive portions of the ridges 228 of the other
20 corrugating member 226 or 227 in meshing relationship with the sheet of fibers 126 between the meshed ridges 228 and to afford rolling engagement between the ridges 228 and spaces of the corrugating members in the manner of gear teeth. First and second corrugating members or rollers 226 and 227 may optionally be heated. The corrugating members 226 and 227 are mounted in axially parallel relationship with portions of the
25 ridges 228 of the corrugating members 226 and 27 meshing generally in the manner of gear teeth; at least one of the corrugating members 226 or 227 is rotated; and the sheet of fibers 126 is fed between the meshed portions of the ridges 228 of the corrugating members 226 and 227 to generally conform the sheet of fibers 126 to the periphery of the first corrugating member 226 and form the arcuate portions 130 of the sheet of fibers 126
30 in the spaces between the ridges 228 of the first corrugating member 226 and the

generally parallel anchor portions 127 of the sheet of fibers 126 along the outer surfaces of the ridges 228 on the first corrugating member 226. The formed sheet of fibers 126 is retained along the periphery of the first corrugating member 226 after it has moved past the meshed portions of the ridges 228. The thermoplastic backing layer 120 is formed and
5 bonded to the anchor portions 127 of the sheet of fibers 126 on the end surfaces of the ridges 228 on the first corrugating member 226 by extruding the thermoplastic backing layer 120 (e.g., polypropylene) in a molten state from a die 240 into a nip between the anchor portions 127 of the sheet of fibers 126 on the periphery of the first corrugating member 226 and a cooling roll 250 after which the multiple zone member 29 is separated
10 from the first corrugating member 226 and carried partially around the cooling roll 250 and through a nip between the cooling roller and a pinch roller 260 to complete cooling and solidification of the thermoplastic backing layer 120.

The sheet of fibers 126 fed between the meshed portions of the ridges 228 of the corrugating members 226 and 227 can be in the form of yarns distributed so that the fibers
15 in the sheet of fibers 126 fed between the meshed ridges 228 of the corrugating members 226 and 227 are uniformly distributed across the width of the sheet of fibers 126 and all extend generally perpendicular to the axes of the corrugating members 226 and 227, or the fibers in the sheet of fibers 126 can be disposed in random orientation as in a non woven web or sheet. Such a nonwoven sheet of randomly oriented fibers 126 with no
20 internal bonding except for the friction between the fibers can be formed from loose fibers using a carding machine 270 as illustrated, which nonwoven sheet of randomly oriented fibers 126 has enough integrity to be fed from the carding machine 270 into the nip between the corrugating members 226 and 227 (if needed, a conveyer (not shown) could be provided to help support and guide the non woven sheet of randomly oriented fibers
25 126 is used, preferably the first corrugating member 226 has a rough finish (e.g., formed by sand blasting), the second corrugating member 227 has a smooth polished finish, and the first corrugating member 226 is heated to a temperature slightly above the temperature of the second corrugating member 226 so that the nonwoven sheet of fibers 126 will preferentially stay along the surface of the first corrugating member 226 and be carried to
30 the nip between the first corrugating member and the cooling roller 250 after passing

through the nip between the corrugating members 226 and 227. Alternatively, instead of feeding fibers from a carding machine 270, a sheet of bonded fibers, such as a spunbond web or other suitable web, may be fed from a roll to the corrugating members 226 and 227.

5 Corrugating members 226 and 227 adapted to have such a sheet of fibers 126 fed into them can have their ridges 228 oriented generally in the range of 0 to 90 degrees with respect to their axes, but preferably have their ridges 228 oriented at 0 degrees with respect to (or parallel to) their axes which simplifies making of the corrugating members 226 and 227.

10 Instead of extruding a solid thermoplastic sheet 120 from die 240, a plurality of fibers may be extruded from a die to form a backing layer, such as backing layer 155 illustrated in FIG. 3.

15 Instead of extruding a thermoplastic material from a die such as die 240, a non-molten backing maybe used. The roller 250 is then heated to thermo-bond the backing to the sheet of fibers.

20 As can be seen in Figure 6, rollers 226 and 227 each have a region corresponding to the first zone and second zones of the multiple zone material. Rollers 226 and 227 each have a first region 500 corresponding to first zone 300 and a second region 502 corresponding to second zone 302. The dimension of the extending ridges 228 is greater in the first region 500 than in the second region 502. The spacing between the ridges is greater in the second region 502 than in the first region 500. Such a configuration produces the multiple zone member as shown in Figure 1.

25 FIG. 7 schematically illustrates another embodiment of a method and equipment according to the present invention for forming the fecal management member 140, which method is generally the same and uses much of the same equipment as is illustrated in FIG. 6 (with similar portions of that equipment having the same reference numerals), except for the addition of means including a pinch roller 340 for feeding the sheet of backing material 147 into the nip between the first corrugating roller 226 and the cooling roller 250 along the surface of the cooling roller 250 which results in the extruded molten thermoplastic backing layer 120 from the die 240 being deposited between the formed

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sheet of fibers 126 along the periphery of the first corrugating member 226 and the sheet of backing material 120 along the surface of the cooling roll 250 so that the molten thermoplastic backing layer 120 envelopes and adheres the anchor portions 127 of the sheet of fibers 126 to the sheet of backing material 147 after which the fecal management member 140 is separated from the first corrugating member 226 and carried partially around the cooling roll 250 with its backing 145 against the cooling roll 250 to complete cooling and solidification of its thermoplastic backing layer 120. The molten thermoplastic backing layer 120 can be extruded into the nip, onto the anchor portions 127 of the sheet of fibers on the first corrugating member 226 prior to the nip, or onto the sheet of backing material 147 along the periphery of the cooling roller just prior to the nip as may work best for any given application. The cooling roll 250 can be water cooled and have a chrome plated periphery which is particularly useful for forming the fecal management member 140 because of the high rate of heat transfer such a cooling roll 250 affords from the molten thermoplastic backing layer 120, through the sheet of polymeric backing material 147 and into the cooling roll 250. Alternatively, the cooling roll 250 may have an outer rubber layer defining its surface which may be preferred for forming the fecal management member 140 if the sheet of backing material is of a material (e.g., paper) that tends to restrict such heat transfer into the cooling roll 250, whereupon the rubber layer provides an alternative advantage of deforming adjacent its nip with the first corrugating roller 226 to provide intimate contact of the molten thermoplastic backing layer 120 with the anchor portions 127 of the sheet of fibers 126 and the sheet of backing material 147.

The sheet of backing material 147 incorporated in the backing 145 could be a woven, knitted, random woven, needle punched, nonwoven or other solid or porous layer of intertwined fibers, or could be a continuous polymeric film. Such film used for the sheet of backing material 21 may be a single layer of a polymeric material such as polypropylene, polyester, or polyamide; or may have a plurality of layers such as a central layer of a relatively high strength material such as polyester, a layer defining the first surface of a material more easily bonded to the layer of thermoplastic material 120 such as ethylene vinyl acetate or polyethylene, and a layer defining the outer surface of the

backing 147 adapted to adhere the backing to a substrate such as polyethylene or a bonding layer of room-temperature non-tacky thermoplastic material. The sheet of backing material could also be a layer of pressure sensitive adhesive along a release liner disposed so that the release liner contacts the cooling roller 250, resulting in the layer of pressure sensitive adhesive being disposed along the rear surface of the layer of thermoplastic material 120 with the release liner over the layer of pressure sensitive adhesive and removable so that the pressure sensitive adhesive could be used to adhere the fecal management member to a substrate.

Preferably, the drives for the corrugating member 226 and 227 and for the cooling roller 250 are separately controllable so that the cooling roller 250 can be rotated at a surface speed that is the same as or different than the surface speed of the first corrugating member 226. When the cooling roller 250 and the first corrugating member 226 are rotated so that the cooling roller has a surface speed that is slower than the surface speed of the first corrugating member 226 the anchor portions 127 of the sheet of fibers 126 will be moved closer together in the backing layer 120 at the nip between the cooling roller 250 and the first corrugating member 226, resulting in greater density of the loop portions 130 along the backing 120 than when the cooling roller 250 and the first corrugating member 226 are rotated so that they have the same surface speed.

In another alternative embodiment for making the multiple zone member to those shown in Figures 6 and 7, the method and equipment may be the same as shown in Figures 6 and 7 except that the rollers 226 and 227 have just one region where the spacing and dimension of ridges 228 is uniform throughout the periphery of rollers 226 and 227. The member produced with such a method will have arcuate portions which have the same dimension. The member may then be subjected to selective stretching such that a portion thereof is elongated. The arcuate portions within the elongated portion will have a height dimension which is less than the height dimension of the arcuate portions within the non-elongated portion. Similarly, the spacing between the bonding locations will be greater in the elongated portion than in the non-elongated. The member may be selectively stretched using known stretching techniques such as incremental stretching

with corrugated stretching rollers, or other methods. Heat may also be used during the stretching operation.

Figure 8 is a plan view of the diaper 20 of the present invention in a flat-out, state with portions of the structure being cut-away to more clearly show the construction of the diaper 20. The portion of the diaper 20 which faces the wearer is oriented towards the viewer. As shown in Figure 8, the diaper 20 preferably comprises a liquid pervious topsheet 24; a liquid impervious backsheet 26; an absorbent core 28, which is preferably positioned between at least a portion of the topsheet 24 and the backsheet 26; a fecal management member 27 positioned between the topsheet 24 and the absorbent core 28; side panels 30; elasticized leg cuffs 32; an elastic waist feature 34; and a fastening system generally designated 40. Diaper 20 is shown in Figure 8 to have a front waist region 36, a rear waist region 38 opposed to the front waist region 36 and a crotch region 37 located between the front waist region and the rear waist region. The periphery of the diaper 20 is defined by the outer edges of the diaper 20 in which the longitudinal edges 50 run generally parallel to the longitudinal centerline 100 of the diaper 20 and the end edges 52 run between the longitudinal edges 50 generally parallel to the lateral centerline 110 of the diaper 20.

The chassis 22 of the diaper 20 comprises the main body of the diaper 20. The chassis 22 comprises at least a portion of the absorbent core 28 and preferably an outer covering layer including the topsheet 24 and the backsheet 26. If the absorbent article comprises a separate holder and a liner, the chassis 22 generally comprises the holder and the liner. (For example, the holder may comprise one or more layers of material to form the outer cover of the article and the liner may comprise an absorbent assembly including a topsheet, a backsheet, and an absorbent core. In such cases, the holder and/or the liner may include a fastening element which is used to hold the liner in place throughout the time of use.) For unitary absorbent articles, the chassis 22 comprises the main structure of the diaper with other features added to form the composite diaper structure. While the topsheet 24, the backsheet 26, and the chassis 22 may be assembled in a variety of well known configurations, preferred diaper configurations are described generally in U.S. Patent 3,860,003; U.S. Pat. No. 5,151,092; and U.S. Pat. No. 5,221,274 issued to Buell on

June 22, 1993. Other suitable diaper chassis design are disclosed in U.S. Pat. No. 5,569,232; U.S. Pat. No. 5,554,144; U.S. Pat. No. 5,554; U.S. Pat. No. 5,554,145; U.S. Pat. No. 5,556,394. Each of these references is hereby incorporated by reference herein.

The backsheet 26 is generally that portion of the diaper 20 positioned adjacent the garment facing surface 45 of the absorbent core 28 which prevents the exudates absorbed and contained therein from soiling articles which may contact the diaper 20, such as bedsheets and undergarments. In preferred embodiments, the backsheet 26 is impervious to liquids (e.g., urine) and comprises a thin plastic film such as a thermoplastic film having a thickness of about 0.012 mm (0.5 mil) to about 0.051 mm (2.0 mils). Suitable backsheet films include those manufactured by Tredegar Industries Inc. of Terre Haute, IN and sold under the trade names X15306, X10962 and X10964. Other suitable backsheet materials may include breathable materials which permit vapors to escape from the diaper 20 while still preventing exudates from passing through the backsheet 26. Exemplary breathable materials may include materials such as woven webs, nonwoven webs, composite materials such as film-coated nonwoven webs, and microporous films such as manufactured by Mitsui Toatsu Co., of Japan under the designation ESPOIR NO and by EXXON Chemical Co., of Bay City, TX, under the designation EXXAIRE. Suitable breathable composite materials comprising polymer blends are available from Clopay Corporation, Cincinnati, OH under the name HYTREL blend P18-3097. Such breathable composite materials are described in greater detail in PCT Application No. WO 95/16746, published on June 22, 1995 in the name of E. I. DuPont and copending U.S. Patent Application Serial No. 08/744,487, filed on November 6, 1996 in the name of Curro. Other breathable backsheets including nonwoven webs and apertured formed films are described in U.S. Pat. No. 5,571,096 issued to Dobrin et al. on November 5, 1996. Each of these references is hereby incorporated by reference herein.

The backsheet 26 may be joined to the topsheet 24, the absorbent core 28 or any other element of the diaper 20 by any attachment means known in the art. For example, the attachment means may include a uniform continuous layer of adhesive, a patterned layer of adhesive, or an array of separate lines, spirals, or spots of adhesive. One preferred attachment means comprises an open pattern network of filaments of adhesive

as disclosed in U.S. Patent 4,573,986 entitled "Disposable Waste-Containment Garment", which issued to Minetola et al. on March 4, 1986. Other suitable attachment means include several lines of adhesive filaments which are swirled into a spiral pattern, as is illustrated by the apparatus and methods shown in U.S. Patent 3,911,173 issued to Sprague, Jr. on October 7, 1975; U.S. Patent 4,785,996 issued to Ziecker, et al. on November 22, 1978; and U.S. Patent 4,842,666 issued to Werenicz on June 27, 1989. Each of these patents are incorporated herein by reference. Adhesives which have been found to be satisfactory are manufactured by H. B. Fuller Company of St. Paul, Minnesota and marketed as HL-1258. Alternatively, the attachment means may comprise heat bonds, pressure bonds, ultrasonic bonds, dynamic mechanical bonds, or any other suitable attachment means or combinations of these attachment means as are known in the art.

The topsheet 24 is preferably positioned adjacent the body surface 47 of the absorbent core 28 and may be joined thereto and/or to the backsheet 26 by any attachment means known in the art. Suitable attachment means are described above with respect to means for joining the backsheet 26 to other elements of the diaper 20. In one preferred embodiment of the present invention, the topsheet 24 and the backsheet 26 are joined directly to each other in some locations and are indirectly joined together in other locations by directly joining them to other elements of the diaper 20.

The topsheet 24 is preferably compliant, soft feeling, and non-irritating to the wearer's skin. Further, at least a portion of the topsheet 24 is liquid pervious, permitting liquids to readily penetrate through its thickness. A suitable topsheet 24 may be manufactured from a wide range of materials, such as porous foams; reticulated foams; apertured plastic films; woven or nonwoven webs of natural fibers (e.g., wood or cotton fibers), synthetic fibers (e.g., polyester or polypropylene fibers), or a combination of natural and synthetic fibers; or apertured nonwoven webs. If the absorbent assemblies include fibers, the fibers may be spunbond, carded, wet-laid, meltblown, hydroentangled, or otherwise processed as is known in the art. One suitable topsheet 24 comprising a web of staple length polypropylene fibers is manufactured by Veratec, Inc., a Division of International Paper Company, of Walpole, Massachusetts under the designation P-8.

Another suitable topsheet 24 is the multiple zone member 29 of the present invention. Preferably, the first zone 300 of the multiple zone member 29 is positioned in the rear waist region 38 of the diaper 20 such that the first zone 300 is aligned with the wearer's anus where it can be most effective in the management of fecal material deposited onto the diaper 20. The second zone 302 is preferably positioned within the crotch region 37 and extend into the front waist region 36. In some embodiments it may also be desirable to have the first zone 300 extend from the rear waist region 38 into the crotch region 37 either up to or just beyond the transverse centerline 110. Of course, the multiple zone member topsheet may be designed to any desired configuration, such as, for male and female anatomies.

Suitable formed film topsheets are described in U.S. Pat. No. 3,929,135; U.S. Pat. No. 4,324,246; U.S. Patent 4,342,314; U.S. Pat. No. 4,463,045; and U.S. Pat. No. 5,006,394. Other suitable topsheets 30 are made in accordance with U.S. Pat. Nos. 4,609,518 and 4,629,643. Such formed films are available from The Procter & Gamble Company of Cincinnati, Ohio as "DRI-WEAVE" and from Tredegar Corporation of Terre Haute, Indiana as "CLIFF-T."

The absorbent core 28 may comprise any absorbent material which is generally compressible, conformable, non-irritating to the wearer's skin, and capable of absorbing and retaining liquids such as urine and other certain body exudates. The absorbent core 28 may be manufactured in a wide variety of sizes and shapes (e.g., rectangular, hourglass, "T"-shaped, asymmetric, etc.) and may comprise a wide variety of liquid-absorbent materials commonly used in disposable diapers and other absorbent articles such as comminuted wood pulp, which is generally referred to as airfelt. Examples of other suitable absorbent materials include creped cellulose wadding; meltblown polymers, including coform; chemically stiffened, modified or cross-linked cellulosic fibers; tissue, including tissue wraps and tissue laminates; absorbent foams; absorbent sponges; superabsorbent polymers; absorbent gelling materials; or any other known absorbent material or combinations of materials.

The configuration and construction of the absorbent core 28 may also be varied (e.g., the absorbent core(s) or other absorbent structure(s) may have varying caliper zones,

a hydrophilic gradient, a superabsorbent gradient, or lower average density and lower average basis weight acquisition zones; or may comprise one or more layers or structures). However, the total absorbent capacity of the absorbent core 28 should be compatible with the design loading and the intended use of the diaper 20.

5 Exemplary absorbent structures for use as the absorbent assemblies are described in U.S. Patent 4,610,678; U.S. Patent 4,834,735; U.S. Patent 4,888,231; U.S. Pat. No. 5,137,537; U.S. Patent 5,147,345; and U.S. Pat. No. 5,342,338. Each of these patents is incorporated herein by reference.

10 The fecal management member 27 is shown in Figure 8 to be positioned just beneath the topsheet 24. Preferably, the fecal management member is positioned between the topsheet 24 and the absorbent core 28. The fecal management member 27 may be secured to the topsheet 24 and/or the absorbent core 28. The fecal management member 27 preferably comprises the multiple zone member 29. Preferably, the first zone 300 of the multiple zone member 29 is positioned in the rear waist region 38 of the diaper 15 20 such that the first zone 300 is aligned with the wearer's anus where it can be most effective in the management of fecal material deposited onto the diaper 20. The second zone 302 is preferably positioned within the crotch region 37 and extend into the front waist region 36. In some embodiments it may also be desirable to have the first zone 300 extend from the rear waist region 38 into the crotch region 37 either up to or just beyond 20 the transverse centerline 110. Of course, the fecal management member may be designed to any desired configuration, such as, for male and female anatomies.

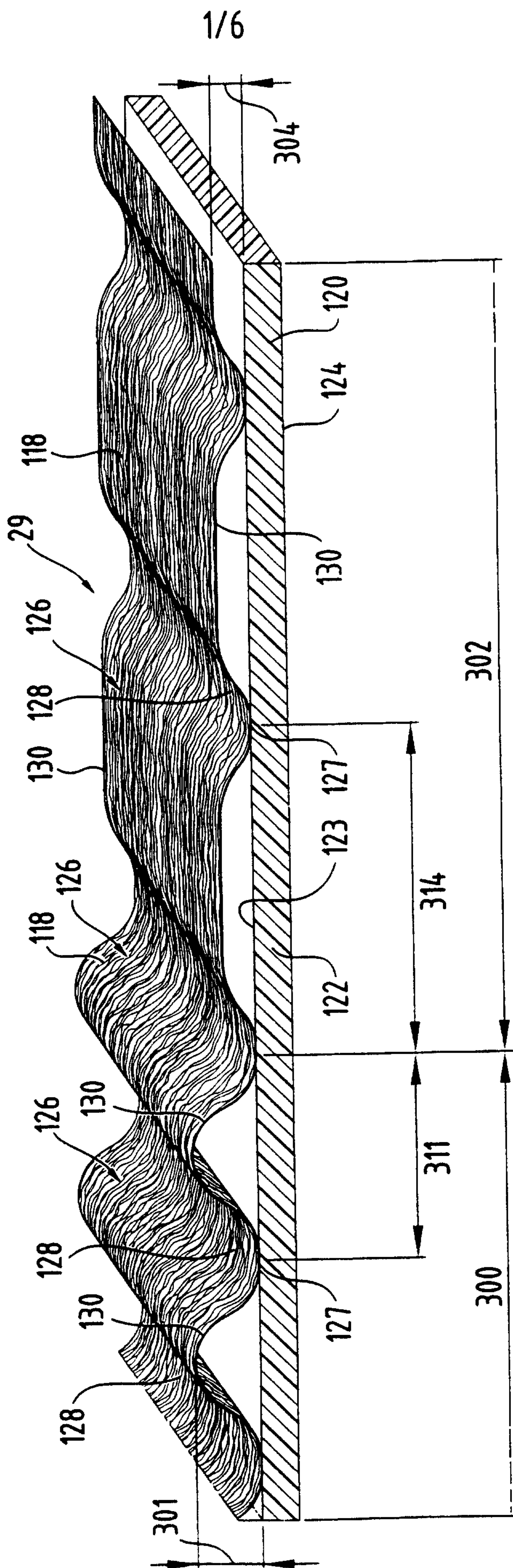
While particular embodiments of the present invention have been illustrated and described, it would be obvious to those skilled in the art that various other changes and modifications can be made without departing from the spirit and scope of the invention. 25 It is therefore intended to cover in the appended claims all such changes and modifications that are within the scope of this invention.

WHAT IS CLAIMED IS:

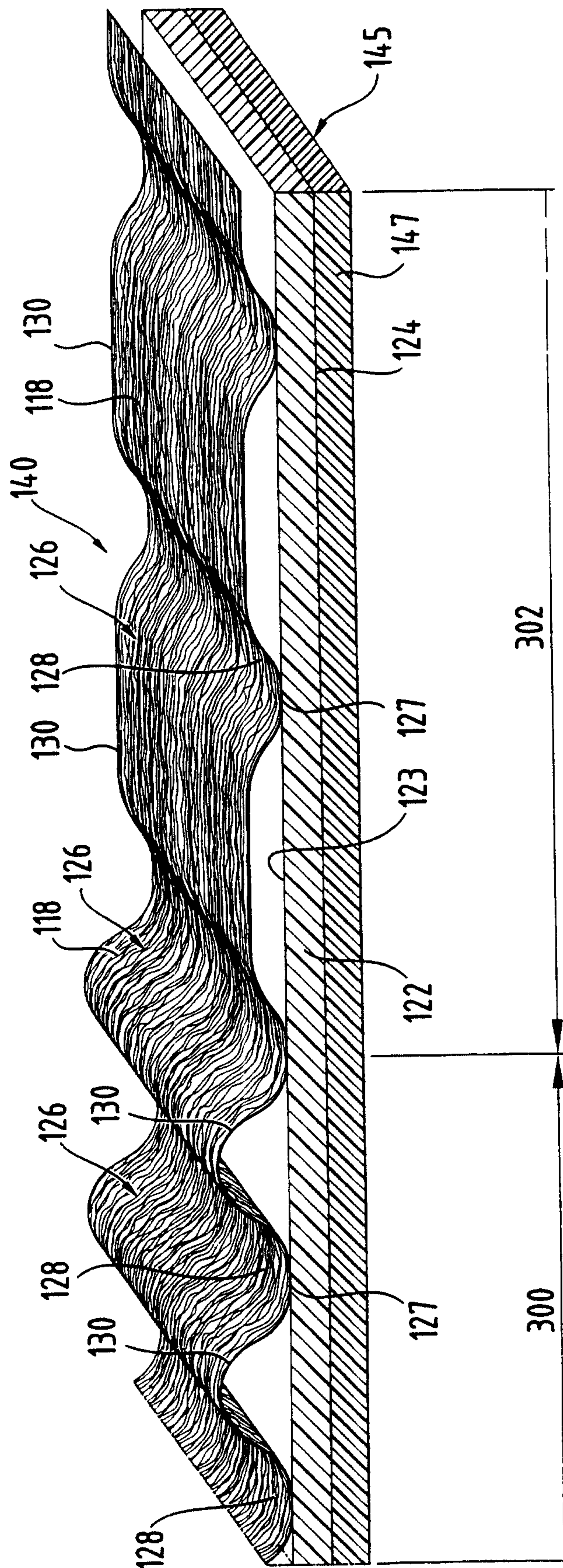
- 5 1. A multiple zone member having at least a first zone and a second zone, said member comprising a backing and a sheet of fibers, said sheet of fibers in said first zone having anchor portions in said backing at spaced bonding locations and having arcuate portions of said sheet projecting from said backing between bonding locations, said arcuate portions in said first zone having a height from said backing,
- 10 said sheet of fibers in said second zone having anchor portions in said backing at spaced bonding locations and having arcuate portions of said sheet projecting from said backing between bonding locations, said arcuate portions in said second zone having a height from said backing which is less than the height of said arcuate portions from said backing in said first zone.
- 15 2. The multiple zone member of claim 1 wherein the bonding locations within said second zone are spaced different than the bonding locations within said first zone.
- 20 3. The multiple zone member of claim 1 wherein said first zone has a basis weight greater than that of said second zone.
- 25 4. The multiple zone member of any one of claims 1 to 3 wherein said backing is selected from the group consisting of a plurality of fibers, a porous film, a breathable material, a breathable film, a nonwoven web, an apertured nonwoven web, strips of nonwoven material, a sheet of loop material, apertured films, apertured formed films, strips of thermoplastic film, a hotmelt material, or strips of hotmelt material.
- 30 5. The multiple zone member of any one of claims 1 to 4 wherein the arcuate portions in said first zone have a height from said backing of at least 0.5 mm.

6. The multiple zone member of claim 5 wherein the arcuate portions in said first zone have a height from said backing of at least 1.0 mm.
7. The multiple zone member of any one of claims 1 to 6 wherein said sheet of fibers
5 has a hydrophilicity which is less than the hydrophilicity of said backing.
8. The multiple zone member of any one of claims 1 to 7 wherein the fibers are oriented in the longitudinal direction.
- 10 9. The multiple zone member of any one of claims 1 to 8 further comprising a second backing joined to said backing opposite said sheet of fibers.
10. A disposable absorbent article comprising a liquid pervious topsheet, a backsheet joined to said topsheet, and a fecal management member positioned between said
15 topsheet and said backsheet, at least one of said fecal management member and said topsheet comprising the multiple zone member of any one of claims 1 to 9.
11. The disposable absorbent article of claim 10 further comprising an absorbent core positioned between said fecal management member and said backsheet.

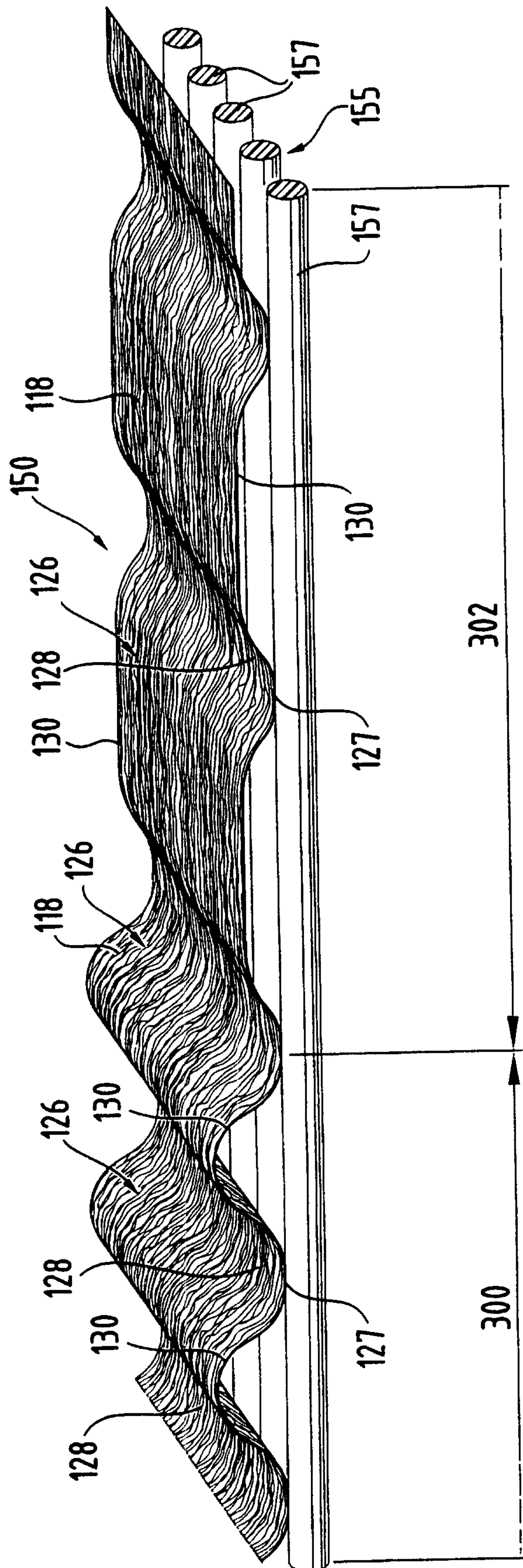
Fig. 1



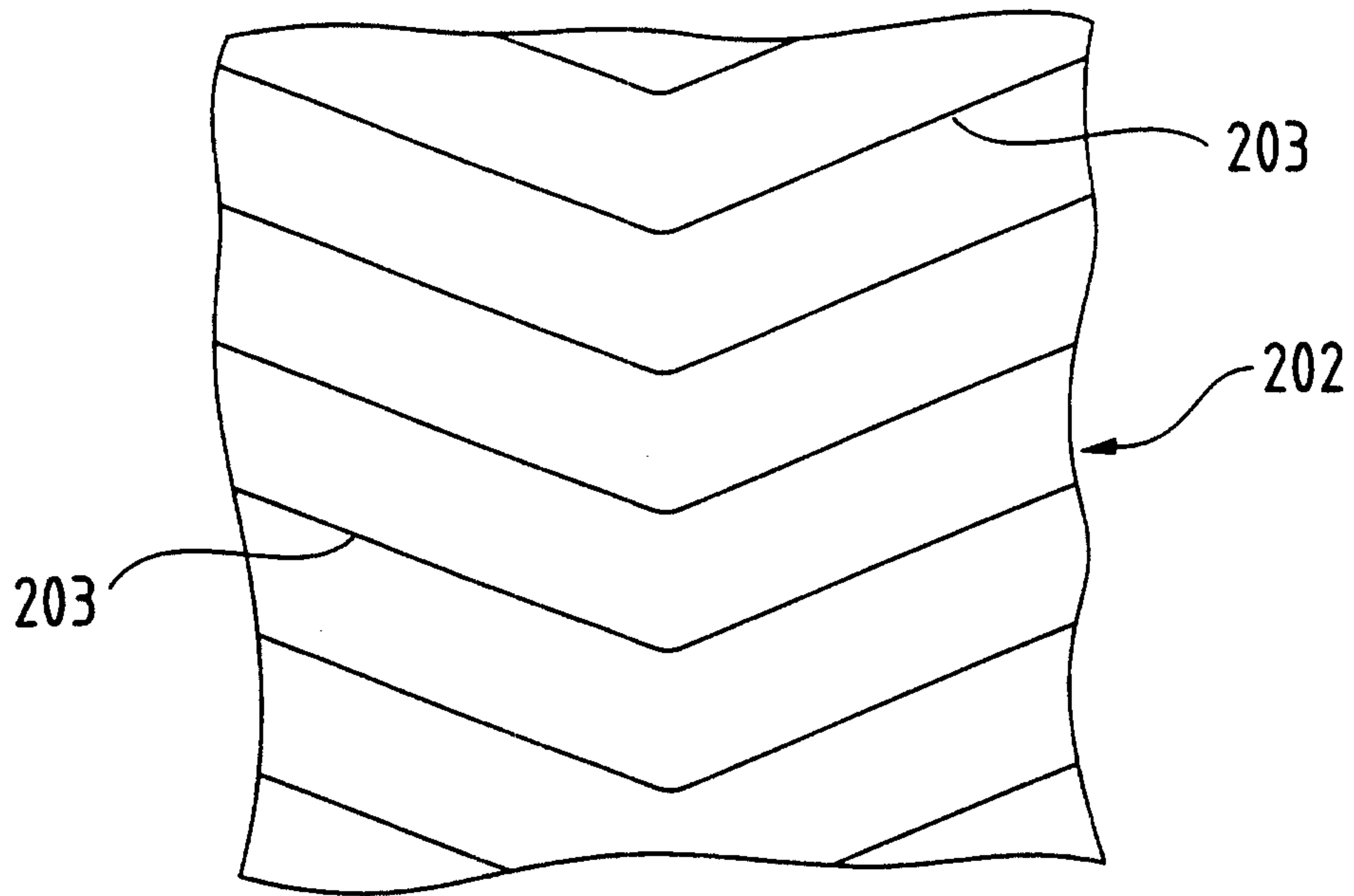
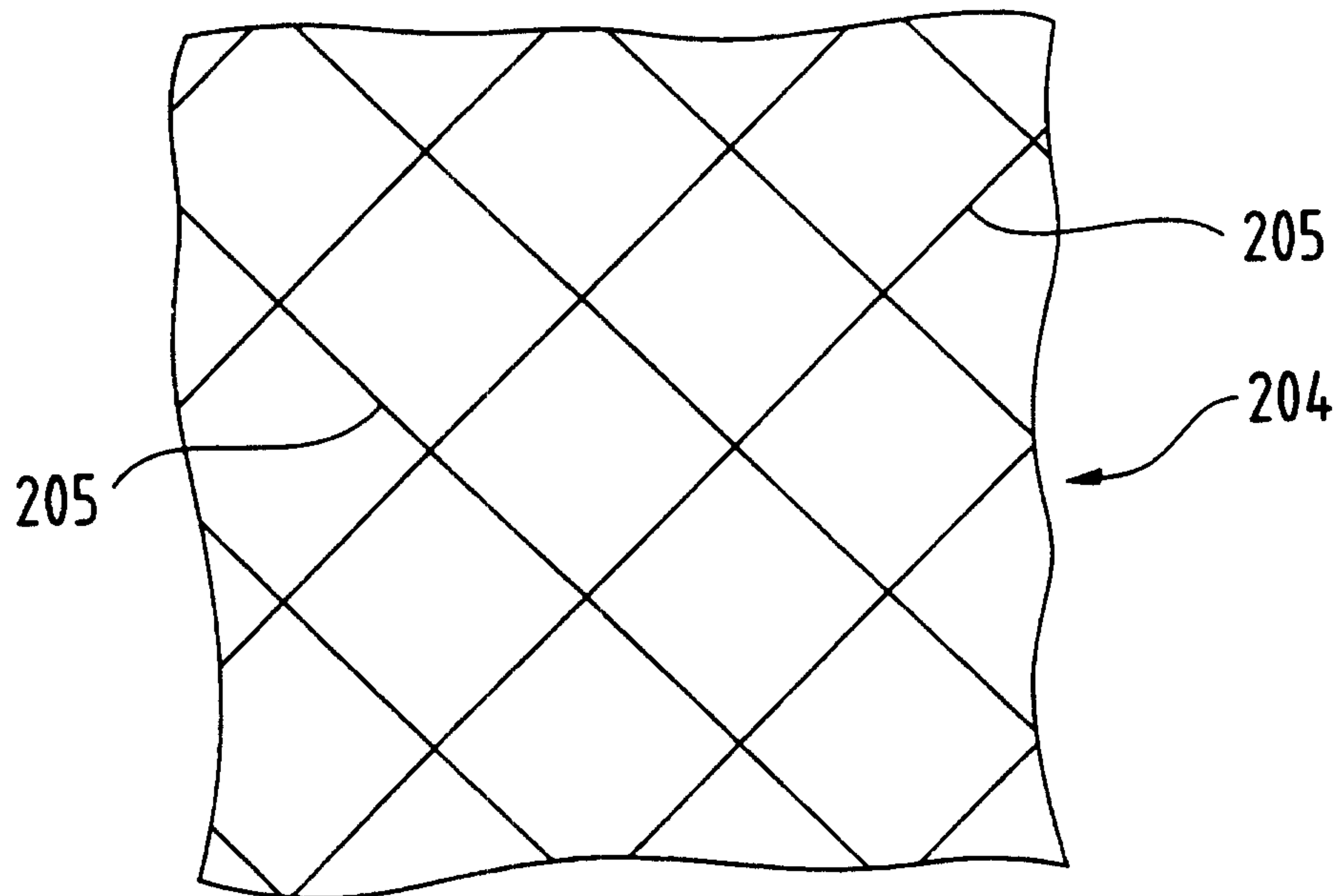
2/6

Fig. 2

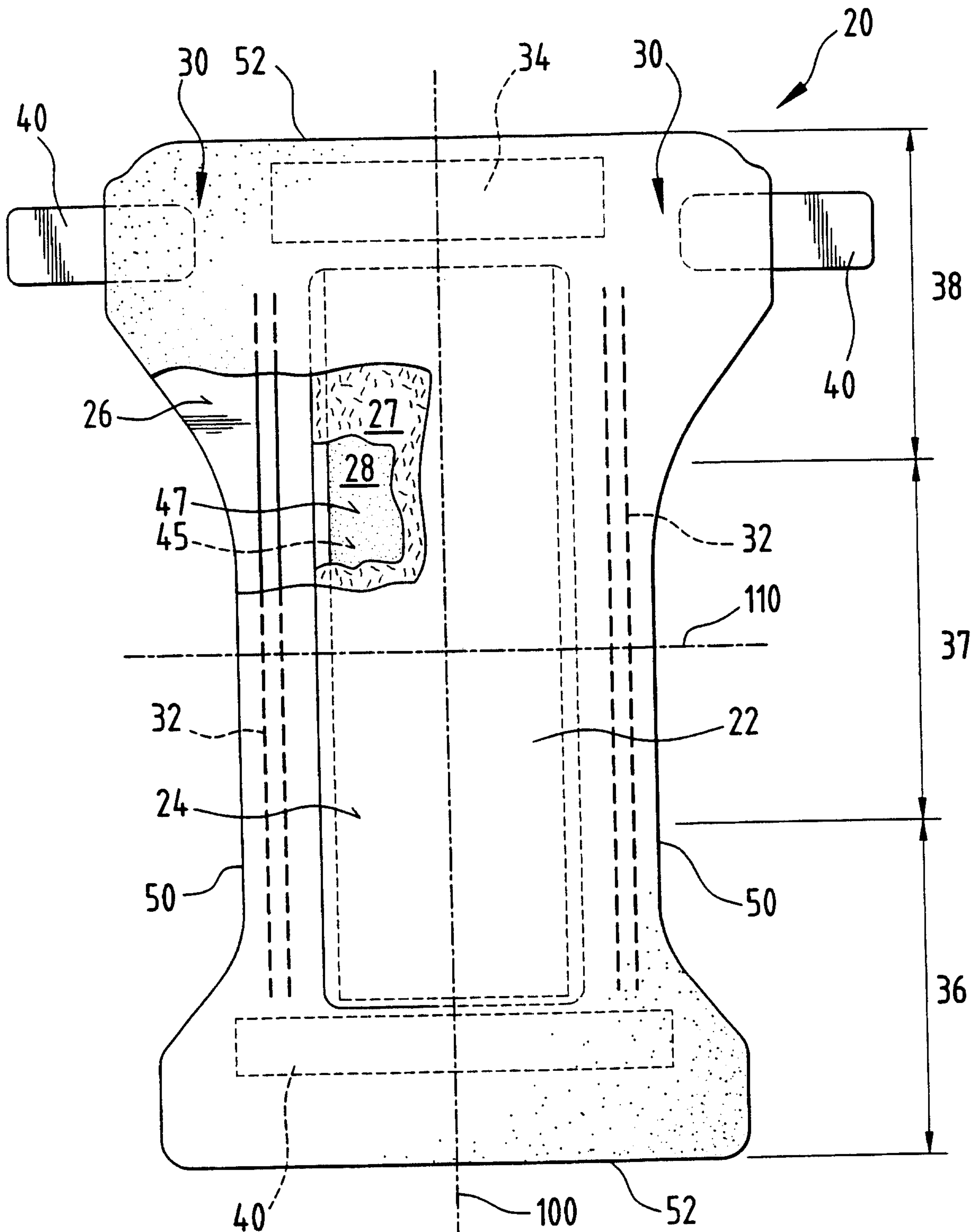
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Fig. 3

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Fig. 4**Fig. 5**

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**Fig. 8**

