



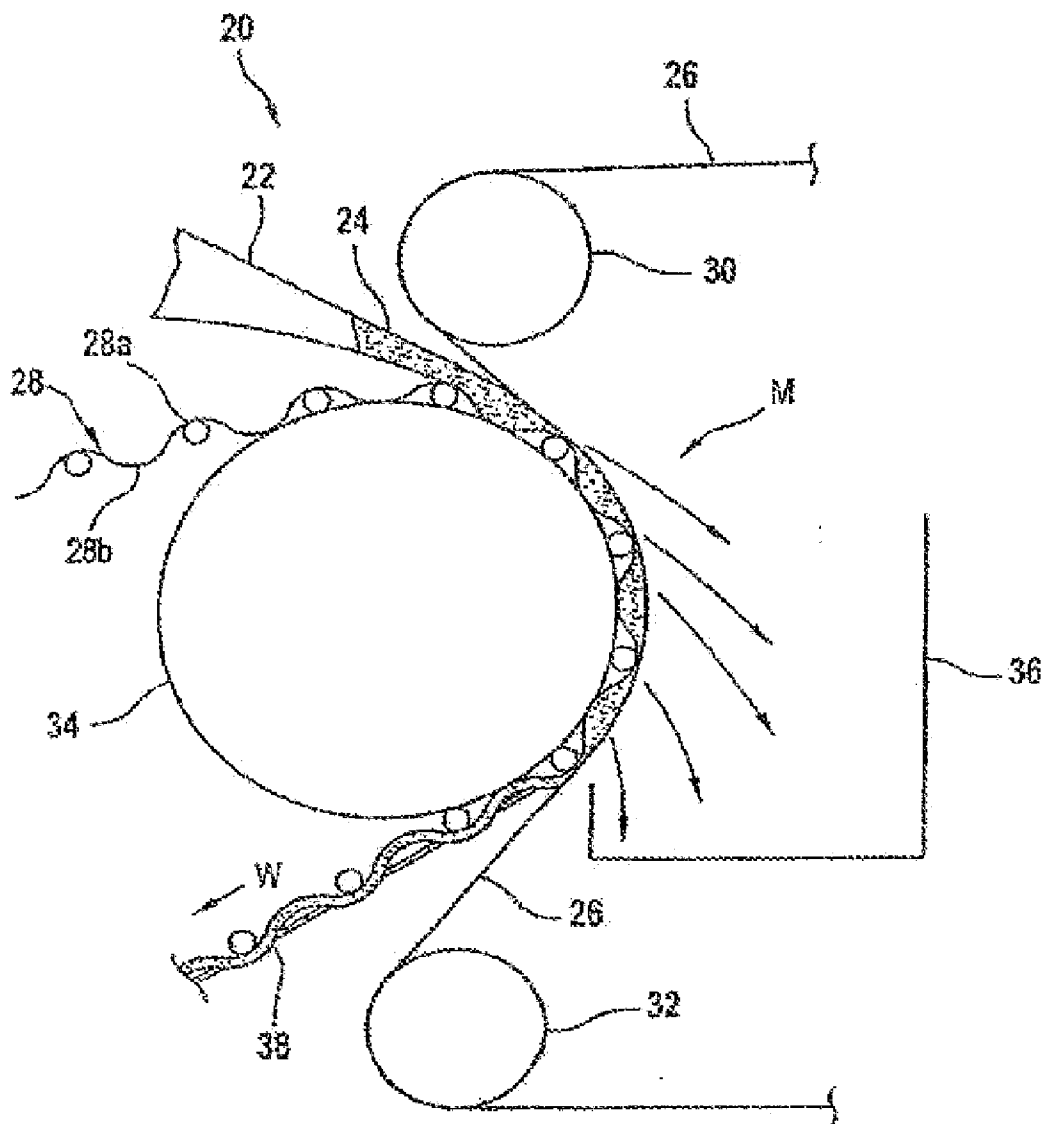
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(19) **United States**(12) **Patent Application Publication**  
**Quigley**(10) **Pub. No.: US 2011/0155340 A1**(43) **Pub. Date: Jun. 30, 2011**(54) **STRUCTURED FORMING FABRIC,  
PAPERMAKING MACHINE AND METHOD****Publication Classification**(51) **Int. Cl.****D21F 11/00** (2006.01)**D21F 3/10** (2006.01)(52) **U.S. Cl.** ..... **162/205; 162/358.2**

(57)

**ABSTRACT**

A fabric for a papermaking machine that includes a machine facing side and a web facing side including pockets formed by warp and weft yarns is provided. Each pocket is defined by four sides on the web facing side, each of the four sides is formed by a knuckle of a single yarn that passes over only two consecutive yarns to define the knuckle.

(76) **Inventor:** **Scott D. Quigley**, Bossier, LA (US)(21) **Appl. No.:** **12/983,598**(22) **Filed:** **Jan. 3, 2011****Related U.S. Application Data**(63) Continuation of application No. PCT/EP2009/  
058389, filed on Jul. 3, 2009.

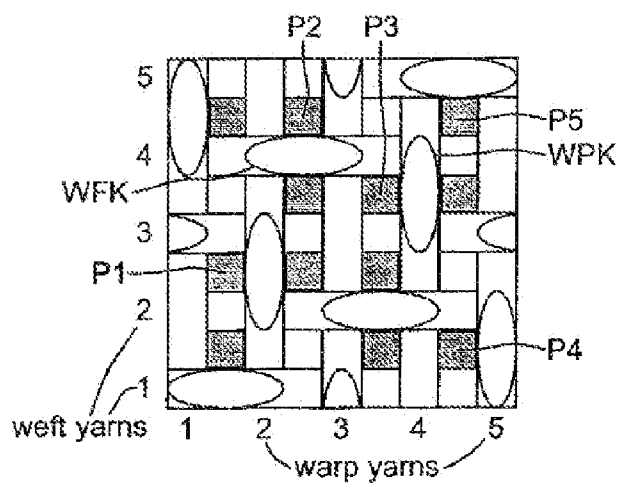


Fig. 1

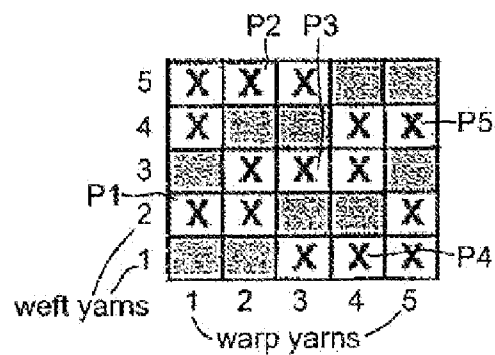


Fig. 2

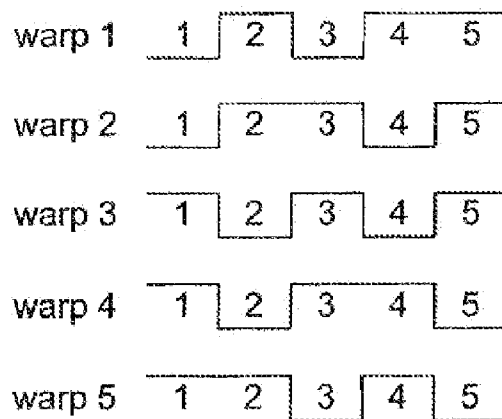
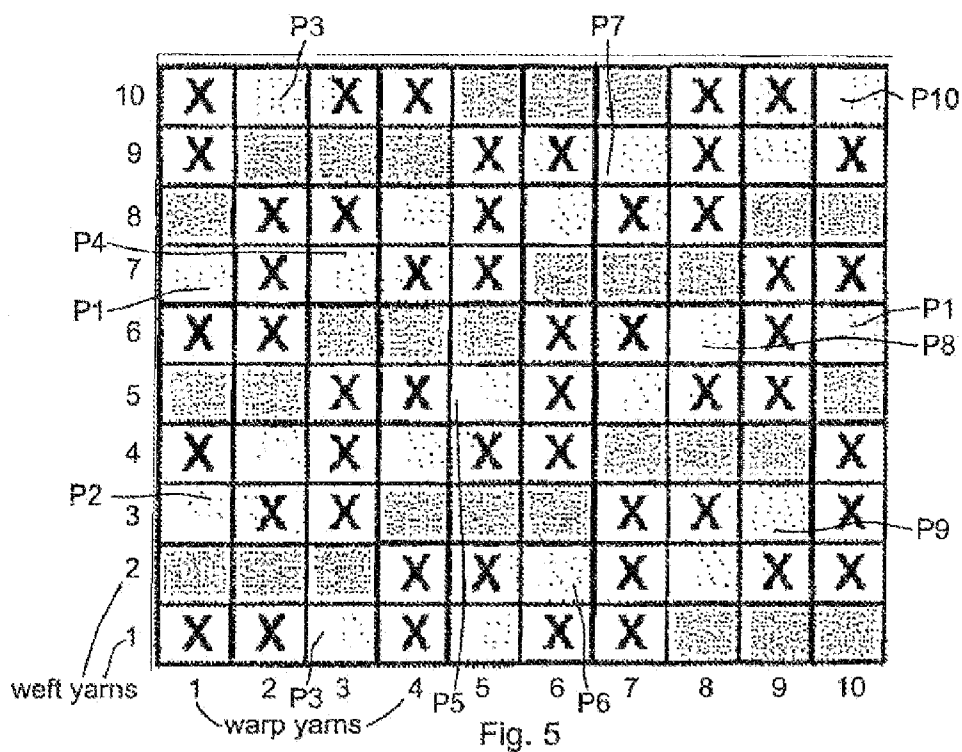
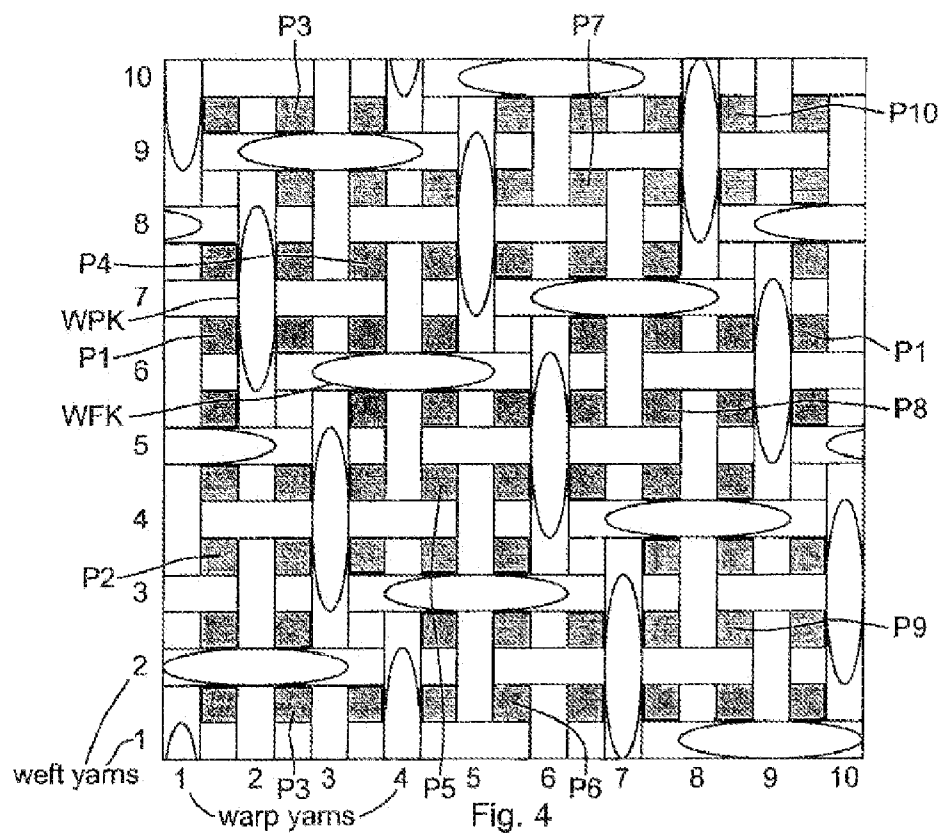


Fig. 3



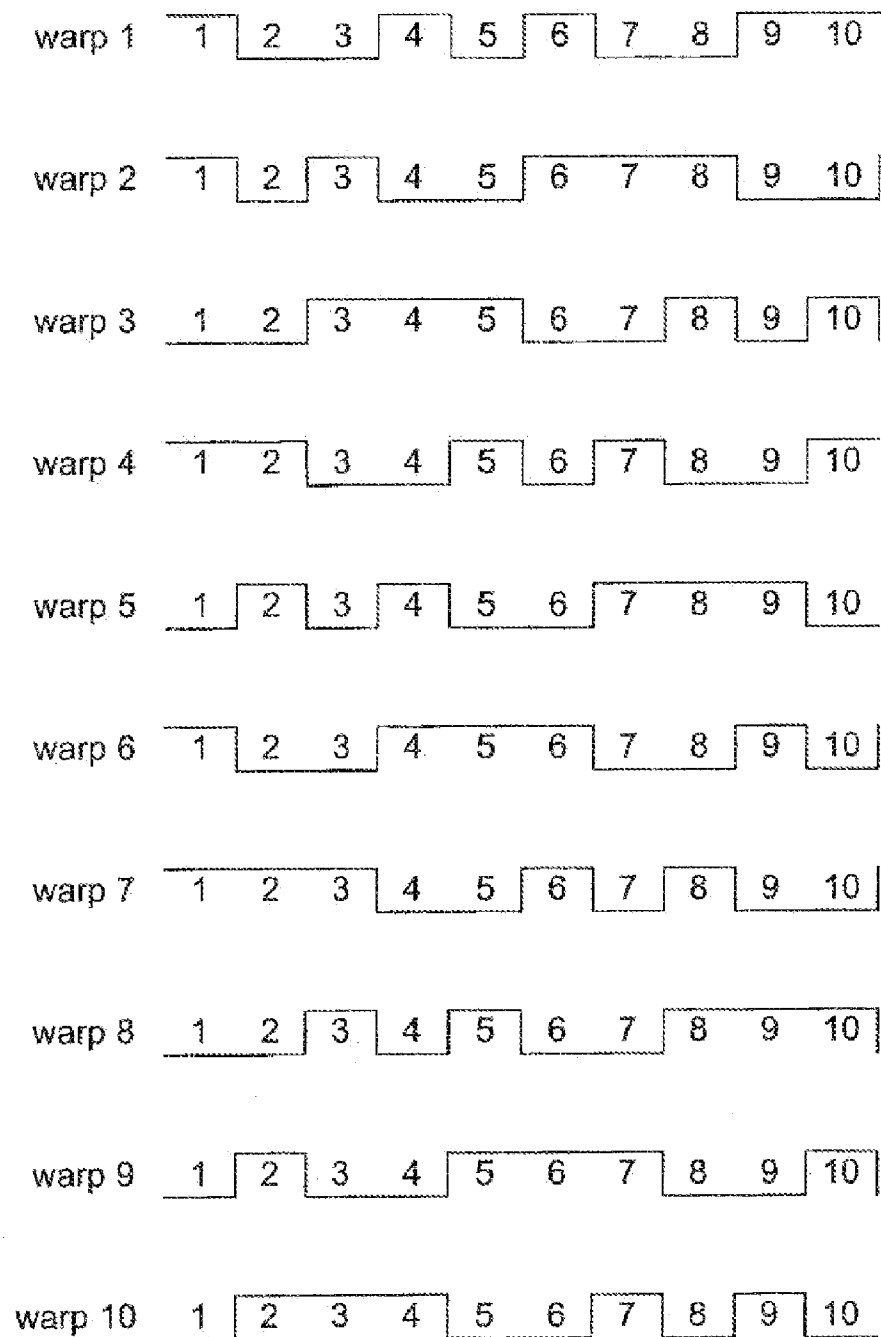


Fig. 6

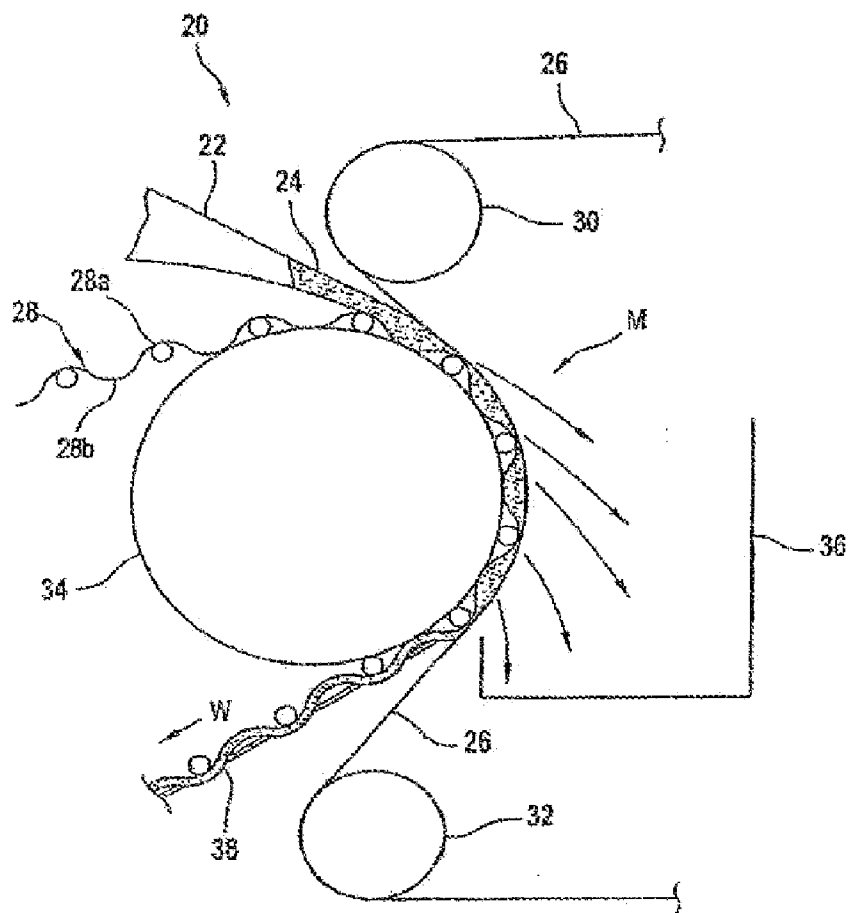


Fig. 7

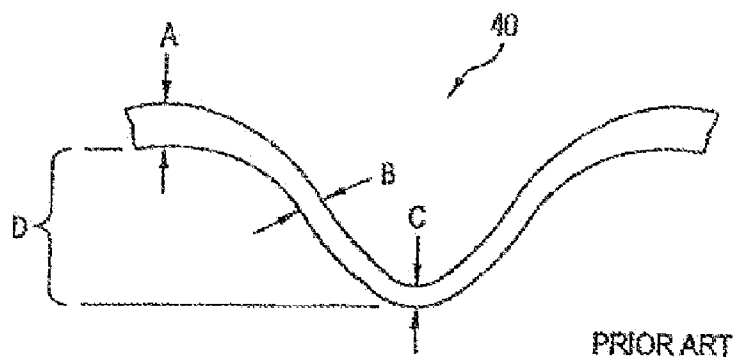


Fig. 8

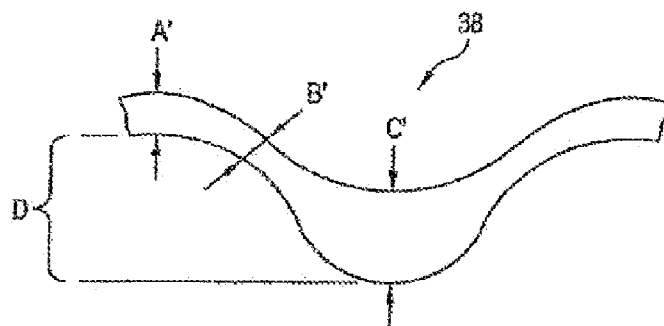


Fig. 9

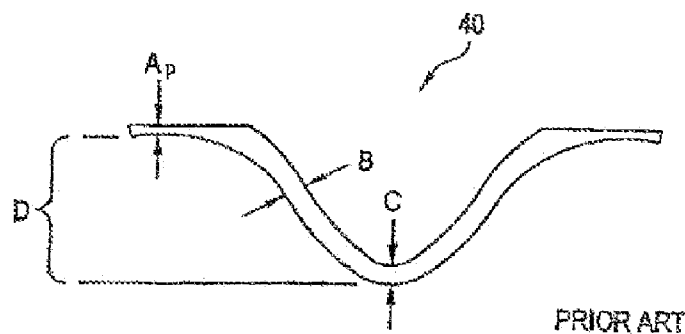


Fig. 10

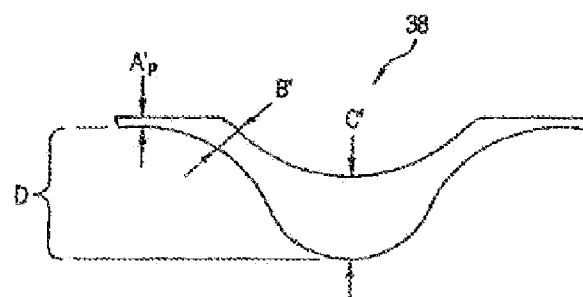


Fig. 11

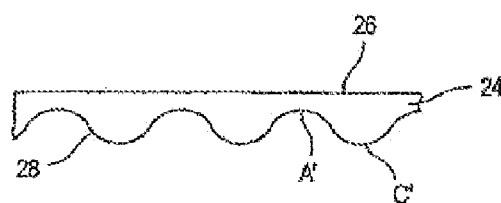


Fig. 12



Fig. 13 PRIOR ART

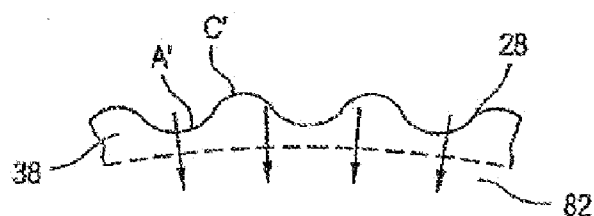


Fig. 14

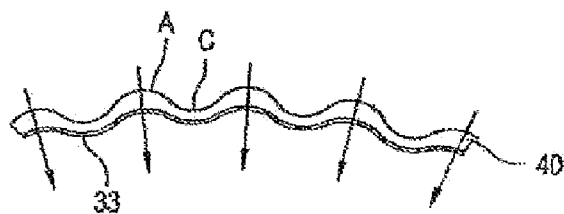


Fig. 15 PRIOR ART

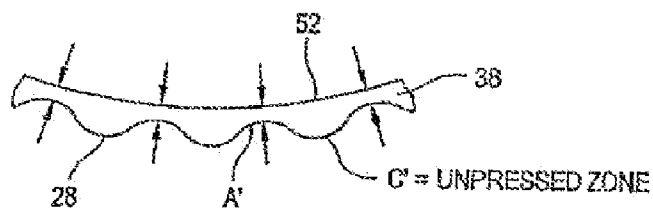


Fig. 16

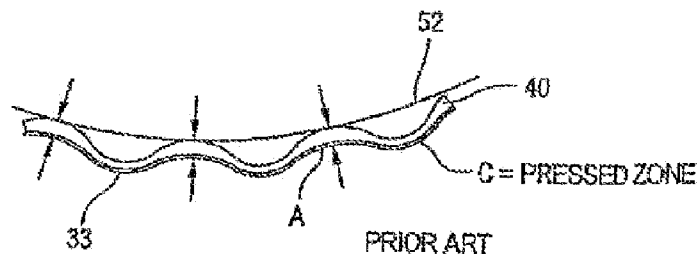


Fig. 17

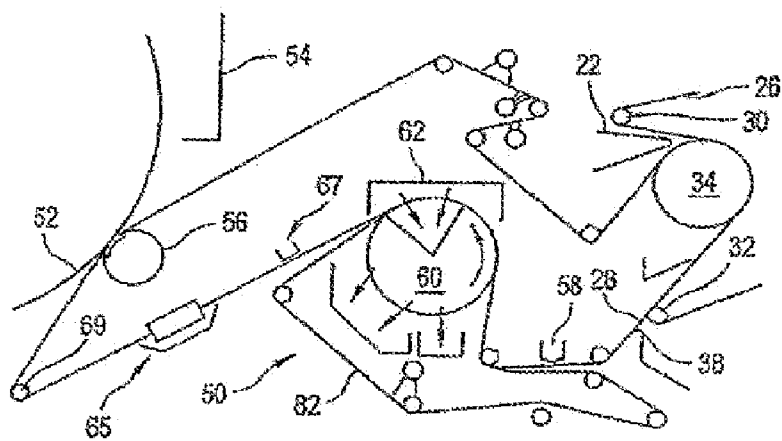


Fig. 18

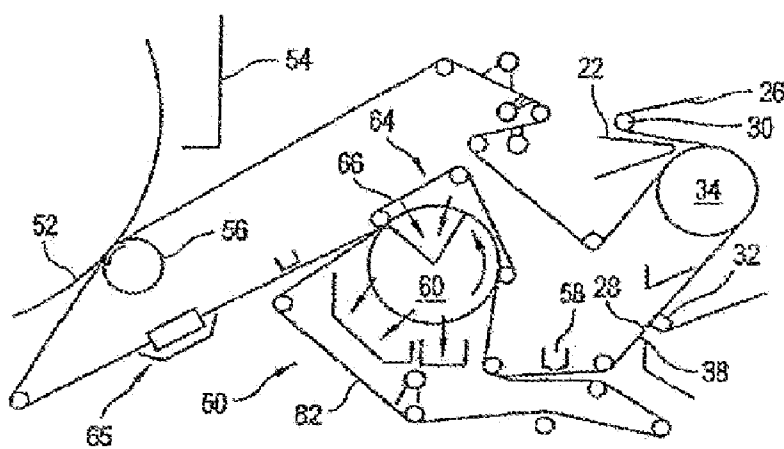


Fig. 19

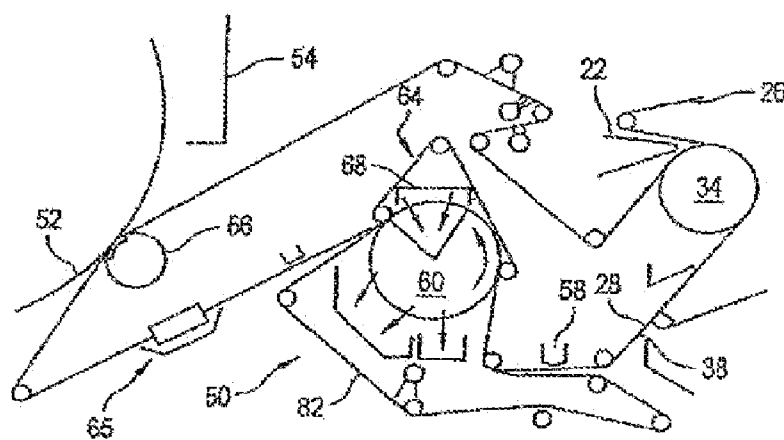


Fig. 20



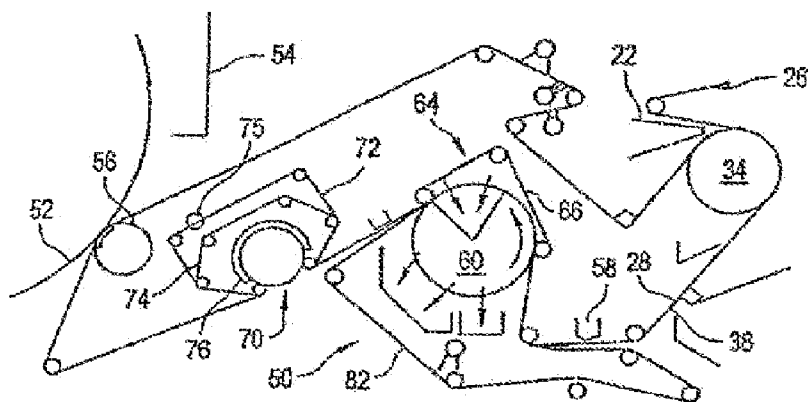


Fig. 21

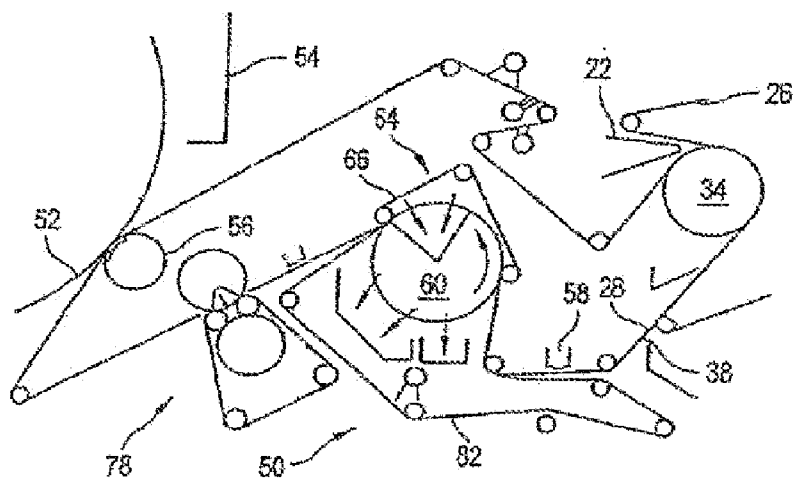


Fig. 22

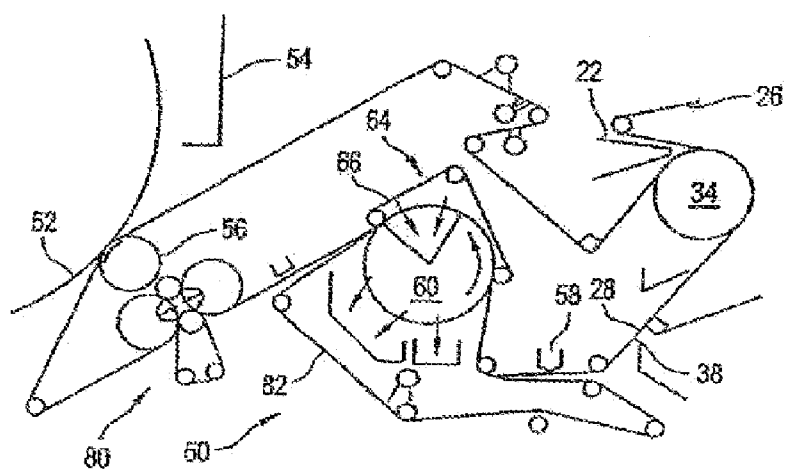


Fig. 23

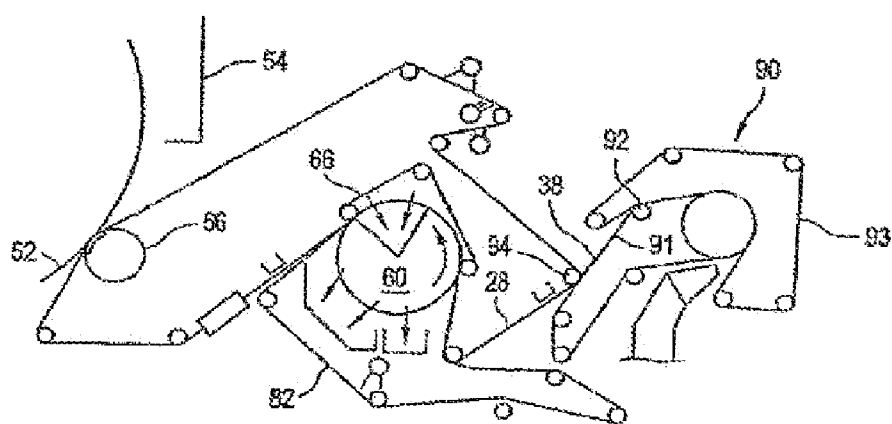


Fig. 24

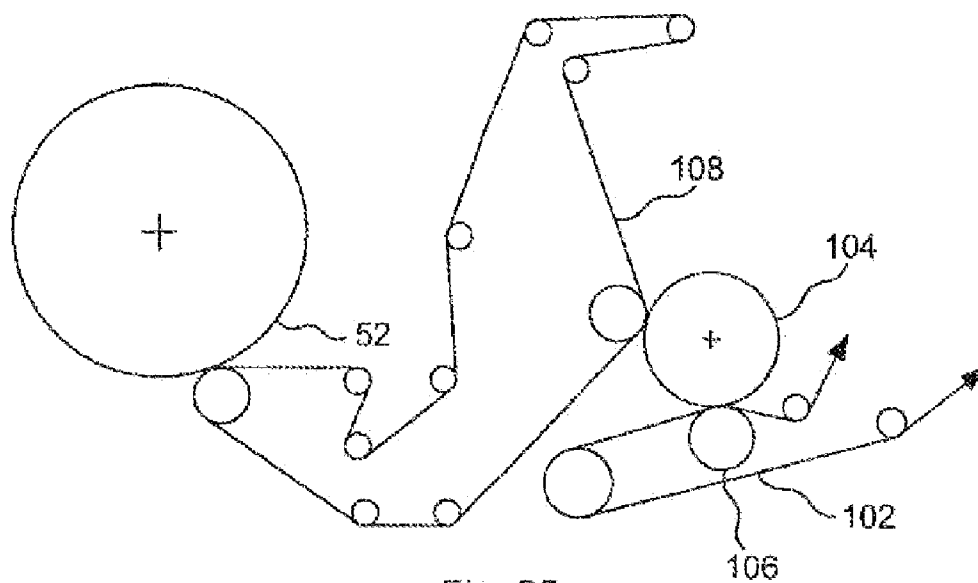


Fig. 25

## STRUCTURED FORMING FABRIC, PAPERMAKING MACHINE AND METHOD

### CROSS REFERENCE TO RELATED APPLICATIONS

**[0001]** This is a continuation of PCT application No. PCT/EP2009/058389, entitled "STRUCTURED FORMING FABRIC, PAPERMAKING MACHINE AND METHOD", filed Jul. 3, 2009, which is incorporated herein by reference.

### BACKGROUND OF THE INVENTION

#### **[0002]** 1. Field of the Invention

**[0003]** The present invention relates generally to papermaking, and relates more specifically to a structured forming fabric employed in papermaking. The present invention also relates to a structured forming fabric having deep pockets.

#### **[0004]** 2. Description of the Related Art

**[0005]** In the conventional Fourdrinier papermaking process, a water slurry, or suspension, of cellulosic fibers (known as the paper "stock") is fed onto the top of the upper run of an endless belt of woven wire and/or synthetic material that travels between two or more rolls. The belt, often referred to as a "forming fabric," provides a papermaking surface on the upper surface of its upper run which operates as a filter to separate the cellulosic fibers of the paper stock from the aqueous medium, thereby forming a wet paper web. The aqueous medium drains through mesh openings of the forming fabric, known as drainage holes, by gravity or vacuum located on the lower surface of the upper run (i.e., the "machine side") of the fabric.

**[0006]** After leaving the forming section, the paper web is transferred to a press section of the paper machine, where it is passed through the nips of one or more pairs of pressure rollers covered with another fabric, typically referred to as a "press felt." Pressure from the rollers removes additional moisture from the web; the moisture removal is often enhanced by the presence of a "batt" layer of the press felt. The paper is then transferred to a dryer section for further moisture removal. After drying, the paper is ready for secondary processing and packaging.

**[0007]** Typically, papermakers' fabrics are manufactured as endless belts by one of two basic weaving techniques. In the first of these techniques, fabrics are flat woven by a flat weaving process, with their ends being joined to form an endless belt by any one of a number of well-known joining methods, such as dismantling and reweaving the ends together (commonly known as splicing), or sewing on a pin-seamable flap or a special foldback on each end, then reweaving these into pin-seamable loops. A number of auto-joining machines are available, which for certain fabrics may be used to automate at least part of the joining process. In a flat woven papermakers' fabric, the warp yarns extend in the machine direction and the filling yarns extend in the cross machine direction.

**[0008]** In the second basic weaving technique, fabrics are woven directly in the form of a continuous belt with an endless weaving process. In the endless weaving process, the warp yarns extend in the cross machine direction and the filling yarns extend in the machine direction. Both weaving methods described hereinabove are well known in the art, and the term "endless belt" as used herein refers to belts made by either method.

**[0009]** Effective sheet and fiber support are important considerations in papermaking, especially for the forming section of the papermaking machine, where the wet web is initially formed. Additionally, the forming fabrics should exhibit good stability when they are run at high speeds on the papermaking machines, and preferably are highly permeable to reduce the amount of water retained in the web when it is transferred to the press section of the paper machine. In both tissue and fine paper applications (i.e., paper for use in quality printing, carbonizing, cigarettes, electrical condensers, and the like) the papermaking surface comprises a very finely woven or fine wire mesh structure.

**[0010]** In a conventional tissue forming machine, the sheet is formed flat. At the press section, 100% of the sheet is pressed and compacted to reach the necessary dryness and the sheet is further dried on a Yankee and hood section. This, however, destroys the sheet quality. The sheet is then creped and wound-up, thereby producing a flat sheet.

**[0011]** In an ATMOS™ system, a sheet is formed on a structured or molding fabric and the sheet is further sandwiched between the structured or molding fabric and a dewatering fabric. The sheet is dewatered through the dewatering fabric and opposite the molding fabric. The dewatering takes place with air flow and mechanical pressure. The mechanical pressure is created by a permeable belt and the direction of air flow is from the permeable belt to the dewatering fabric. This can occur when the sandwich passes through an extended pressure nip formed by a vacuum roll and the permeable belt. The sheet is then transferred to a Yankee by a press nip. Only about 25% of the sheet is slightly pressed by the Yankee while approximately 75% of the sheet remains unpressed for quality. The sheet is dried by a Yankee/Hood dryer arrangement and then dry creped. In the ATMOS™ system, one and the same structured fabric is used to carry the sheet from the headbox to the Yankee dryer. Using the ATMOS™ system, the sheet reaches between about 35 to 38% dryness after the ATMOS™ roll, which is almost the same dryness as a conventional press section. However, this advantageously occurs with almost 40 times lower nip pressure and without compacting and destroying sheet quality. Furthermore, a big advantage of the ATMOS™ system is that it utilizes a permeable belt which is highly tensioned, e.g., about 60 kN/m. This belt enhances the contact points and intimacy for maximum vacuum dewatering. Additionally, the belt nip is more than 20 times longer than a conventional press and utilizes air flow through the nip, which is not the case on a conventional press system.

**[0012]** Actual results from trials using an ATMOS™ system have shown that the caliper and bulk of the sheet is 30% higher than the conventional through-air drying (TAD) formed towel fabrics. Absorbency capacity is also 30% higher than with conventional TAD formed towel fabrics. The results are the same whether one uses 100% virgin pulp up to 100% recycled pulp. Sheets can be produced with basis weight ratios of between 14 to 40 g/m<sup>2</sup>. The ATMOS™ system also provides excellent sheet transfer to the Yankee working at 33 to 37% dryness. There is essentially no dryness loss with the ATMOS™ system since the fabric has square valleys and not square knuckles (peaks). As such, there is no loss of intimacy between the dewatering fabric, the sheet, the molding fabric, and the belt. A key aspect of the ATMOS™ system is that it forms the sheet on the molding fabric and the same molding fabric carries the sheet from the headbox to the Yankee dryer.

This produces a sheet with a uniform and defined pore size for maximum absorbency capacity.

**[0013]** U.S. patent application Ser. No. 11/753,435 filed on May 24, 2007, the disclosure of which is hereby expressly incorporated by reference in its entirety, discloses a structured forming fabric for an ATMOS™ system. The fabric utilizes an at least three float warp and weft structure which, like the prior art fabrics, is symmetrical in form.

**[0014]** U.S. Pat. No. 5,429,686 to CHIU, et al., the disclosure of which is hereby expressly incorporated by reference in its entirety, discloses structured forming fabrics which utilize a load-bearing layer and a sculptured layer. The fabrics utilize impression knuckles to imprint the sheet and increase its surface contour. This document, however, does not create pillows in the sheet for effective dewatering of TAD applications, nor does it teach using the disclosed fabrics on an ATMOS™ system and/or forming the pillows in the sheet while the sheet is relatively wet and utilizing a hi-tension press nip.

**[0015]** U.S. Pat. No. 6,237,644 to HAY, et al., the disclosure of which is hereby expressly incorporated by reference in its entirety, discloses structured forming fabrics which utilize a lattice weave pattern of at least three yarns oriented in both warp and weft directions. The fabric essentially produces shallow craters in distinct patterns. This document, however, does not create deep pockets which have a three-dimensional pattern, nor does it teach using the disclosed fabrics on an ATMOS™ system and/or forming the pillows in the sheet while the sheet is relatively wet and utilizing a hi-tension press nip.

**[0016]** International Publication No. WO 2005/035867 to LAFOND, et al., the disclosure of which is hereby expressly incorporated by reference in its entirety, discloses structured forming fabrics which utilize at least two different diameter yarns to impart bulk into a tissue sheet. This document, however, does not create deep pockets which have a three-dimensional pattern. Nor does it teach using the disclosed fabrics on an ATMOS™ system and/or forming the pillows in the sheet while the sheet is relatively wet and utilizing a hi-tension press nip.

**[0017]** U.S. Pat. No. 6,592,714 to LAMB, the disclosure of which is hereby expressly incorporated by reference in its entirety, discloses structured forming fabrics which utilize deep pockets and a measurement system. However, it is not apparent that the disclosed measurement system is replicable. Furthermore, LAMB relies on the aspect ratio of the weave design to achieve the deep pockets. This document also does not teach using the disclosed fabrics on an ATMOS™ system and/or forming the pillows in the sheet while the sheet is relatively wet and utilizing a hi-tension press nip.

**[0018]** U.S. Pat. No. 6,649,026 to LAMB, the disclosure of which is hereby expressly incorporated by reference in its entirety, discloses structured forming fabrics which utilize pockets based on five-shaft designs and with a float of three yarns in both warp and weft directions (or variations thereof). The fabric is then sanded. However, LAMB does not teach an asymmetrical weave pattern. This document also does not teach using the disclosed fabrics on an ATMOS™ system and/or forming the pillows in the sheet while the sheet is relatively wet and utilizing a hi-tension press nip.

**[0019]** International Publication No. WO 2006/113818 to KROLL, et al., the disclosure of which is hereby expressly incorporated by reference in its entirety, discloses structured forming fabrics which utilize a series of two alternating deep

pockets for TAD applications. However, KROLL, et al. does not teach to utilize one consistent sized pocket in order to provide effective and consistent dewatering and would not produce a regular sheet finish on the finished product. KROLL, et al. also does not teach an asymmetrical weave pattern. This document also does not teach using the disclosed fabrics on an ATMOS™ system and/or forming the pillows in the sheet while the sheet is relatively wet and utilizing a hi-tension press nip.

**[0020]** International Publication No. WO 2005/075737 to HERMAN et. al. and U.S. patent application Ser. No. 11/380,826 filed on Apr. 28, 2006, the disclosures of which are hereby expressly incorporated by reference in their entirety, disclose structured molding fabrics for an ATMOS™ system which can create a more three-dimensionally oriented sheet. These documents, however, do not teach, among other things, deep pocket weaves.

**[0021]** International Publication No. WO 2005/075732 to SCHERB, et al., the disclosure of which is hereby expressly incorporated by reference in its entirety, discloses a belt press utilizing a permeable belt in a paper machine which manufactures tissue or toweling. According to this document, the web is dried in a more efficient manner than has been the case in prior art machines such as TAD machines. The formed web is passed through similarly open fabrics and hot air is blown from one side of the sheet through the web to the other side of the sheet. A dewatering fabric is also utilized. Such an arrangement places great demands on the forming fabric because of the pressure applied by the belt press and hot air is blown through the web in the belt press. However, this document does not teach, among other things, deep pocket weaves.

**[0022]** The above-noted conventional fabrics limit the amount of bulk that can be built into the sheet being formed due to the fact that they have shallow depth pockets. Furthermore, the pockets of the conventional fabrics are merely extensions of the contact areas on the warp and weft yarns.

**[0023]** What is needed in the art is a structured forming fabric, papermaking machine and method of manufacturing premium tissue or toweling at low cost.

## SUMMARY OF THE INVENTION

**[0024]** In one aspect, the present invention provides a fabric for a papermaking machine that includes a machine facing side and a web facing side including pockets formed by warp and weft yarns. Each pocket is defined by four sides on the web facing side, each of the four sides is formed by a knuckle of a single yarn that passes over only two consecutive yarns to define the knuckle.

**[0025]** In another aspect, the present invention provides a fabric for a papermaking machine that includes a machine facing side and a web facing side including pockets formed by warp and weft yarns. Each pocket is defined by four sides on the web facing side, two of the four sides are each formed by a warp knuckle of a single warp yarn that passes over three consecutive weft yarns to define the warp knuckle, and the other two of the four sides are each formed by a weft knuckle of a single weft yarn that passes over three consecutive warp yarns to define the weft knuckle. A lower surface of each pocket is formed by first and second lower warps yarns and first and second lower weft yarns. A first warp knuckle is of the first warp yarn passed over by a first weft knuckle and the first lower warp yarn is of the second warp yarn passed over by the first weft knuckle and the second lower warp yarn is of the third warp yarn passed over the first weft knuckle. A

second weft knuckle is of the first weft yarn passed over by the first warp knuckle and the second lower weft yarn is of the second weft yarn passed over by the first warp knuckle and the first lower weft yarn is of the third weft yarn passed over by the first warp knuckle. The first lower warp yarn passes over the first lower weft yarn and under the second lower weft yarn, and the second lower warp yarn passes under the first lower weft yarn and over the second lower weft yarn.

[0026] In another aspect, the present invention provides a papermaking machine that includes a vacuum roll that has an exterior surface and a dewatering fabric that has first and second sides, the dewatering fabric is guided over a portion of the exterior surface of the vacuum roll, and the first side is in at least partial contact with the exterior surface of the vacuum roll. The papermaking machine also includes a structured fabric and the dewatering fabric is positioned between the vacuum roll and the structured fabric. An advantage of the present invention is

[0027] In another aspect, the present invention provides a papermaking machine that includes a Yankee dryer and a structured fabric. The structured fabric conveys a fibrous web to the Yankee dryer.

[0028] In another aspect, the present invention provides methods of using a structured forming fabric according to the present invention in TAD, ATMOS™, and E-TAD papermaking systems.

#### BRIEF DESCRIPTION OF THE DRAWINGS

[0029] The above-mentioned and other features and advantages of this invention, and the manner of attaining them, will become more apparent and the invention will be better understood by reference to the following description of embodiments of the invention taken in conjunction with the accompanying drawings, wherein:

[0030] FIG. 1 shows a weave pattern of a top side or paper facing side of a first embodiment of a structured fabric according to the present invention;

[0031] FIG. 2 shows the repeating pattern square of the structured fabric of FIG. 1. Each 'X' indicates a location where a warp yarn passes over a weft yarn;

[0032] FIG. 3 is a schematic representation of the weave pattern of the structured fabric shown in FIG. 1, and illustrates how each of the five warp yarns weaves with the five weft yarns in one repeat;

[0033] FIG. 4 shows the weave pattern of a top side or paper facing side of a second embodiment of a structured fabric according to the present invention;

[0034] FIG. 5 shows the repeating pattern square of the structured fabric of FIG. 4. Each 'X' indicates a location where a warp yarn passes over a weft yarn. Lightly stippled areas of the pattern square represent pockets;

[0035] FIG. 6 is a schematic representation of the weave pattern of the structured fabric of FIG. 4, and illustrates how each of the ten warp yarns weaves with the ten weft yarns in one repeat;

[0036] FIG. 7 is a cross-sectional diagram illustrating the formation of a structured web using an embodiment of the present invention;

[0037] FIG. 8 is a cross-sectional view of a portion of a structured web of a prior art method;

[0038] FIG. 9 is a cross-sectional view of a portion of the structured web of an embodiment of the present invention as made on the machine of FIG. 7;

[0039] FIG. 10 illustrates the web portion of FIG. 8 having subsequently gone through a press drying operation;

[0040] FIG. 11 illustrates a portion of the fiber web of the present invention of FIG. 9 having subsequently gone through a press drying operation;

[0041] FIG. 12 illustrates a resulting fiber web of the forming section of the present invention;

[0042] FIG. 13 illustrates the resulting fiber web of the forming section of a prior art method;

[0043] FIG. 14 illustrates the moisture removal of the fiber web of the present invention;

[0044] FIG. 15 illustrates the moisture removal of the fiber web of a prior art structured web;

[0045] FIG. 16 illustrates the pressing points on a fiber web of the present invention;

[0046] FIG. 17 illustrates pressing point of prior art structured web;

[0047] FIG. 18 illustrates a schematic cross-sectional view of an embodiment of an ATMOS™ papermaking machine;

[0048] FIG. 19 illustrates a schematic cross-sectional view of another embodiment of an ATMOS™ papermaking machine;

[0049] FIG. 20 illustrates a schematic cross-sectional view of another embodiment of an ATMOS™ papermaking machine;

[0050] FIG. 21 illustrates a schematic cross-sectional view of another embodiment of an ATMOS™ papermaking machine;

[0051] FIG. 22 illustrates a schematic cross-sectional view of another embodiment of an ATMOS™ papermaking machine;

[0052] FIG. 23 illustrates a schematic cross-sectional view of another embodiment of an ATMOS™ papermaking machine;

[0053] FIG. 24 illustrates a schematic cross-sectional view of another embodiment of an ATMOS™ papermaking machine; and

[0054] FIG. 25 is illustrates a schematic cross-sectional view of an E-TAD papermaking machine.

[0055] Corresponding reference characters indicate corresponding parts throughout the several views. The exemplifications set out herein illustrate embodiments of the invention and such exemplifications are not to be construed as limiting the scope of the invention in any manner.

[0056] The particulars shown herein are by way of example and for purposes of illustrative discussion of the embodiments of the present invention only and are presented in the cause of providing what is believed to be the most useful and readily understood description of the principles and conceptual aspects of the present invention. In this regard, no attempt is made to show structural details of the present invention in more detail than is necessary for the fundamental understanding of the present invention, and the description is taken with the drawings making apparent to those skilled in the art how the forms of the present invention may be embodied in practice.

#### DETAILED DESCRIPTION OF THE INVENTION

[0057] The present invention relates to a structured fabric for a papermaking machine, a former for manufacturing premium tissue and toweling, and also to a former which utilizes the structured fabric, and in some embodiments a belt press, in a papermaking machine. The present invention relates to a twin wire former for manufacturing premium tissue and tow-

eling which utilizes the structured fabric and a belt press in a papermaking machine. The system of the present invention is capable of producing premium tissue or toweling with a quality similar to a through-air drying (TAD) but with a significant cost savings.

**[0058]** The present invention also relates to a twin wire former ATMOS™ system which utilizes the structured fabric which has good resistance to pressure and excessive tensile strain forces, and which can withstand wear/hydrolysis effects that are experienced in an ATMOS™ system. The system may also include a permeable belt for use in a high tension extended nip around a rotating roll or a stationary shoe and a dewatering fabric for the manufacture of premium tissue or towel grades. The fabric has key parameters which include permeability, weight, caliper, and certain compressibility.

**[0059]** Referring now to the drawings, and more particularly to FIGS. 1-3, there is shown a first non-limiting embodiment of the structured fabric of the present invention. FIG. 1 depicts a top pattern view of the web facing side of the fabric (i.e., a view of the papermaking surface). The numbers 1-5 shown on the bottom of the pattern identify the warp (machine direction) yarns while the left side numbers 1-5 show the weft (cross-direction) yarns. In FIG. 2, symbol X illustrates a location where a warp yarn passes over a weft yarn and an empty box illustrates a location where a warp yarn passes under a weft yarn. As shown in FIG. 1, the areas formed between warp yarn 2 and warp yarn 3, and between weft yarn 2 and weft yarn 3, as well as other areas, define pocket areas P1-P5 that form a pillow in a web or sheet. The shaded areas indicate the locations of the pockets. The sides of each pocket are defined by two warp knuckles WPK and two weft knuckles WFK.

**[0060]** The embodiment shown in FIGS. 1-3 results in deep pockets formed in the fabric whose bottom surface is formed by one warp yarn (e.g., warp yarn 3 for pocket P3) and one weft yarn (e.g., weft yarn 3 for pocket P3) and the four spaces adjacent to the intersection of warp yarn 3 with weft yarns 3. In the pocket, the warp yarn passes over the weft yarn. As shown in FIG. 1, the repeating pattern square of the fabric includes an upper plane having warp and weft knuckles that define sides for the pockets. Pockets P1-P5 are formed in a lower plane the fabric.

**[0061]** The fabric of FIG. 1 shows a single repeating pattern square of the fabric that encompasses five warp yarns (yarns 1-5 extend vertically in FIG. 1) and five weft yarns (yarns 1-5 extend horizontally in FIG. 1). The fabric can be, for example, a five shed dsp. FIG. 3 depicts the paths of warp yarns 1-5 as they weave with weft yarns 1-5. While FIGS. 1-3 only show a single section of the fabric, those of skill in the art will appreciate that in commercial applications the pattern shown in FIGS. 1-3 would be repeated many times, in both the warp and weft directions, to form a large fabric suitable for use on a papermaking machine.

**[0062]** As seen in FIG. 3, warp yarn 1 weaves with weft yarns 1-5 by passing over weft yarns 2, 4, and 5 and passing under weft yarns 1 and 3. That is, warp yarn 1 passes under weft yarn 1, then over weft yarn 2, then under weft yarn 3, and then over weft yarns 4 and 5. In the area where warp yarn 1 weaves with, e.g., weft yarn 2, pocket P1 is formed. Furthermore, warp knuckle WPK is formed where warp yarn 1 passes over two consecutive weft yarns 4 and 5. Weft knuckles WFK are formed in the areas where weft yarns 1 and 3 pass over warp yarn 1 and an adjacent warp yarn.

**[0063]** Warp yarn 2 weaves with weft yarns 1-5 by passing over weft yarns 2, 3, and 5 and passing under weft yarns 1 and 4. That is, warp yarn 2 passes under weft yarn 1, then over weft yarns 2 and 3, then under weft yarn 4, and then over weft yarn 5. In the area where warp yarn 2 weaves with, e.g., weft yarn 5, pocket P2 is formed. Warp knuckle WPK is formed where warp yarn 2 passes over two consecutive weft yarns 2 and 3. Weft knuckles WFK are formed in the areas where weft yarns 1 and 4 pass over warp yarn 2 and an adjacent warp yarn.

**[0064]** Again with reference to FIG. 3, warp yarn 3 weaves with weft yarns 1-5 by passing over weft yarns 1, 3, and 5 and passing under weft yarns 2 and 4. That is, warp yarn 3 passes over weft yarn 1, then under weft yarn 2, then over weft yarn 3, then under weft yarn 4, and then over weft yarn 5. In the areas where warp yarn 3 weaves with, e.g., weft yarn 3, pocket P3 is formed. Furthermore, portions of warp knuckles WPK are formed near ends of the pattern square, e.g. where warp yarn 3 passes over weft yarns 1 and 5. Weft knuckles WFK are formed in the areas where weft yarns 2 and 4 pass over warp yarn 3 and an adjacent warp yarn.

**[0065]** Warp yarn 4 weaves with weft yarns 1-5 by passing over weft yarns 1, 3, and 4 and passing under weft yarns 2 and 5. That is, warp yarn 4 passes over weft yarn 1, then under weft yarn 2, then over weft yarns 3 and 4, and then under weft yarn 5. In the area where warp yarn 4 weaves with, e.g., weft yarn 1, pocket P4 is formed. Warp knuckle WPK is formed where warp yarn 4 passes over two consecutive weft yarns 3 and 4. Weft knuckles WFK are formed in the areas where weft yarns 2 and 5 pass over warp yarn 4 and an adjacent warp yarn.

**[0066]** Referring now to FIG. 6, warp yarn 5 weaves with weft yarns 1-5 by passing over weft yarns 1, 2, and 4 and by passing under weft yarns 3 and 5. That is, warp yarn 5 first passes over weft yarns 1 and 2, then under weft yarn 3, then over weft yarn 4, and then under weft yarn 5. In the area where warp yarn 5 weaves with, e.g., weft yarn 4, pocket P5 is formed. Warp knuckle WPK is formed where warp yarn 5 passes over two consecutive weft yarns 1 and 2. Weft knuckles WFK are formed in the areas where weft yarns 3 and 5 pass over warp yarn 5 and an adjacent warp yarn.

**[0067]** Each warp yarn weaves with the weft yarns in an identical pattern; that is, each warp yarn passes under one weft yarn, then over one weft yarn, then under one weft yarn, and then over two weft yarns. In addition, this pattern between adjacent warp yarns is offset by three weft yarns. For example, the one weft yarn passed over (besides the two consecutive weft yarns passed over) by warp yarn 1 is weft yarn 2. The one weft yarn passed under by warp yarn 2 is weft yarn 5. Also, each weft yarn weaves with the warp yarns in an identical pattern; that is, each weft yarn passes over two warp yarns and then under three warp yarns. This pattern between adjacent weft yarns is offset by two warp yarns. For example, the first warp yarn passed over by weft yarn 1 is warp yarn 1. The first warp yarn passed over by weft yarn 2 is warp yarn 3.

**[0068]** As discussed above, the yarns define areas in which pockets are formed. Due to the offset of the weave pattern between warp yarns as discussed in the previous paragraph, the pockets defined by adjacent warp yarns are also offset from each other by three weft yarns. For example, pocket P1 is defined in the area where warp yarn 1 intersects with weft yarn 2. Pocket P2 is defined in the area where warp yarn 2 intersects with weft yarn 5.

**[0069]** Each pocket is defined by four sides. Two sides are defined by warp knuckles WPK, each of which crosses two weft yarns, and two sides are defined by weft knuckles WFK, each of which crosses two warp yarns. In addition, each warp knuckle WPK and weft knuckle WFK defines a side for more than one pocket. For example, warp knuckle WPK of warp yarn 2 defines sides of pockets P1 and P3. Similarly, weft knuckle WFK of weft yarn 4 defines a lower side of pocket P2 and an upper side of pocket P3.

**[0070]** Each of the warp knuckles WPK and weft knuckles WFK that defines a single pocket passes over an end of one of the other knuckles and has an end that passes under one of the other knuckles. For example, pocket P3 is defined by warp knuckles WPK of warp yarns 2 and 4 and weft knuckles WFK of weft yarns 2 and 4. Warp knuckle WPK of warp yarn 2 passes over an end of weft knuckle WFK of weft yarn 2 and has an end that passes under weft knuckle WFK of weft yarn 4. Warp knuckle WPK of warp yarn 4 passes over an end of weft knuckle WFK of weft yarn 4 and has an end that passes under weft knuckle WFK of weft yarn 2.

**[0071]** Referring now to FIGS. 1-4, there is shown a second non-limiting embodiment of the structured fabric of the present invention. As shown in FIG. 4, the areas formed between warp yarn 2 and warp yarn 5, and between weft yarn 6 and weft yarn 9, as well as other areas, define pocket areas P1-P10 that form a pillow in a web or sheet. The shaded areas indicate the locations of the pockets. The sides of each pocket are defined by two warp knuckles WPK and two weft knuckles WFK.

**[0072]** The embodiment shown in FIGS. 4-6 results in deep pockets formed in the fabric whose bottom surface is formed by two warp yarns (e.g., warp yarns 3 and 4 for pocket P4) and two weft yarns (e.g., weft yarns 7 and 8 for pocket P4) and the nine spaces adjacent to the intersections of warp yarns 3 and 4 with weft yarns 7 and 8. In the pocket, one of the warp yarns passes over a first of the weft yarns and under a second of the weft yarns (e.g., warp yarn 3 passes over weft yarn 8 and under weft yarn 7). The other warp yarn passes under the first of the weft yarns and over the second of the weft yarns (e.g., warp yarn 4 passes under weft yarn 8 and over weft yarn 7). As shown in FIG. 4, the repeating pattern square of the fabric includes an upper plane having warp and weft knuckles that define sides for the pockets. Pockets P1-P10 are formed in a lower plane the fabric.

**[0073]** The fabric of FIG. 4 shows a single repeating pattern square of the fabric that encompasses ten warp yarns (yarns 1-10 extend vertically in FIG. 4) and ten weft yarns (yarns 1-10 extend horizontally in FIG. 4). The fabric can, for example, be a ten shed dsp. FIG. 6 depicts the paths of warp yarns 1-10 as they weave with weft yarns 1-10. While FIGS. 4-6 only show a single section of the fabric, those of skill in the art will appreciate that in commercial applications the pattern shown in FIGS. 4-6 would be repeated many times, in both the warp and weft directions, to form a large fabric suitable for use on a papermaking machine.

**[0074]** As seen in FIG. 6, warp yarn 1 weaves with weft yarns 1-10 by passing over weft yarns 1, 4, 6, 9, and 10 and passing under weft yarns 2, 3, 5, 7, and 8. That is, warp yarn 1 passes over weft yarn 1, then under weft yarns 2 and 3, then over weft yarn 4, then under weft yarn 5, then over weft yarn 6, then under weft yarns 7 and 8, and then over weft yarns 9 and 10. In the area where warp yarn 1 weaves with, e.g., weft yarns 6 and 7, half of pocket P1 is formed. In the area where warp yarn 1 weaves with, e.g., weft yarns 3 and 4, half of

pocket P2 is formed. Furthermore, portions of warp knuckles WPK are formed near ends of the pattern square, e.g. where warp yarn 1 passes over weft yarns 1, 9, and 10. Weft knuckles WFK are formed in the areas where weft yarns 2, 5, and 8 pass over warp yarn 1 and pass over three consecutive warp yarns.

**[0075]** Warp yarn 2 weaves with weft yarns 1-10 by passing over weft yarns 1, 3, and 6-8 and passing under weft yarns 2, 4, 5, 9, and 10. That is, warp yarn 2 passes over weft yarn 1, then under weft yarn 2, then over weft yarn 3, then under weft yarns 4 and 5, then over weft yarns 6-8, and then under weft yarns 9 and 10. In the area where warp yarn 2 weaves with, e.g., weft yarns 3 and 4, half of pocket P2 is formed. In the areas where warp yarn 2 weaves with, e.g., weft yarns 1 and 10, two quarters of pocket P3 are formed. Warp knuckle WPK is formed where warp yarn 2 passes over three consecutive weft yarns 6-8. Weft knuckles WFK are formed in the areas where weft yarns 2, 5, and 9 pass over warp yarn 2 and pass over three consecutive warp yarns.

**[0076]** Again with reference to FIG. 6, warp yarn 3 weaves with weft yarns 1-10 by passing over weft yarns 3-5, 8, and 10 and passing under weft yarns 1, 2, 6, 7, and 9. That is, warp yarn 3 passes under weft yarns 1 and 2, then over weft yarns 3-5, then under weft yarns 6 and 7, then over weft yarn 8, then under weft yarn 9, and then over weft yarn 10. In the areas where warp yarn 3 weaves with, e.g., weft yarns 1 and 10, two quarters of pocket P3 are formed. In the area where warp yarn 3 weaves with, e.g., weft yarns 7 and 8, half of pocket P4 is formed. Furthermore, warp knuckle WPK is formed where warp yarn 3 passes over weft yarns 3-5. Weft knuckles WFK are formed in the areas where weft yarns 2, 6, and 9 pass over warp yarn 3 and pass over three consecutive warp yarns.

**[0077]** Warp yarn 4 weaves with weft yarns 1-10 by passing over weft yarns 1, 2, 5, 7, and 10 and passing under weft yarns 3, 4, 6, 8, and 9. That is, warp yarn 4 passes over weft yarns 1 and 2, then under weft yarns 3 and 4, then over weft yarn 5, then under weft yarn 6, then over weft yarn 7, then under weft yarns 8 and 9, and then over weft yarn 10. In the area where warp yarn 4 weaves with, e.g., weft yarns 7 and 8, half of pocket P4 is formed. In the area where warp yarn 4 weaves with, e.g., weft yarns 4 and 5, half of pocket P5 is formed. Furthermore, portions of warp knuckles WPK are formed near ends of the pattern square, e.g. where warp yarn 4 passes over weft yarns 1, 2, and 10. Weft knuckles WFK are formed in the areas where weft yarns 3, 6, and 9 pass over warp yarn 4 and pass over three consecutive warp yarns.

**[0078]** Again with reference to FIG. 6, warp yarn 5 weaves with weft yarns 1-10 by passing over weft yarns 2, 4, and 7-9 and by passing under weft yarns 1, 3, 5, 6, and 10. That is, warp yarn 5 first passes under weft yarn 1, then over weft yarn 2, then under weft yarn 3, then over weft yarn 4, then under weft yarns 5 and 6, then over weft yarns 7-9, and then under weft yarn 10. In the area where warp yarn 5 weaves with, e.g., weft yarns 4 and 5, half of pocket P5 is formed. In the area where warp yarn 5 weaves with, e.g., weft yarns 1 and 2, half of pocket P6 is formed. Warp knuckle WPK is formed where warp yarn 5 passes over weft yarns 7-9. Weft knuckles WFK are formed in the areas where weft yarns 3, 6, and 10 pass over warp yarn 5 and pass over three consecutive warp yarns.

**[0079]** Warp yarn 6 weaves with weft yarns 1-10 by passing over weft yarns 1, 4-6, and 9 and passing under weft yarns 2, 3, 7, 8, and 10. That is, warp yarn 6 passes over weft yarn 1, then under weft yarns 2 and 3, then over weft yarns 4-6, then under weft yarns 7-8, then over weft yarn 9, and then under weft yarn 10. In the area where the warp yarn 6 weaves with,

e.g., weft yarns 1 and 2, half of pocket P6 is formed. In the area where warp yarn 6 weaves with, e.g., weft yarns 8 and 9, half of pocket P7 is formed. Warp knuckle WPK is formed where warp yarn 6 passes over weft yarns 4-6. Weft knuckles WFK are formed in the areas where weft yarns 3, 7, and 10 pass over warp yarn 6 and pass over three consecutive warp yarns.

**[0080]** Again with reference to FIG. 6, warp yarn 7 weaves with weft yarns 1-10 by passing over weft yarns 1-3, 6, and 8 and by passing under weft yarns 4, 5, 7, 9, and 10. That is, warp yarn 7 first passes over weft yarns 1-3, then under weft yarns 4 and 5, then over weft yarn 6, then under weft yarn 7, then over weft yarn 8, and then under weft yarns 9-10. In the area where warp yarn 7 weaves with, e.g., weft yarns 8 and 9, half of pocket P7 is formed. In the area where warp yarn 7 weaves with, e.g., weft yarns 5 and 6, half of pocket P8 is formed. Warp knuckle WPK is formed in the area where warp yarn 7 passes over weft yarns 1-3. Weft knuckles WFK are formed in the areas where weft yarns 4, 7, and 10 pass over warp yarn 7 and pass over three consecutive warp yarns.

**[0081]** Warp yarn 8 weaves with weft yarns 1-10 by passing over weft yarns 3, 5, and 8-10 and passing under weft yarns 1, 2, 4, 6, and 7. That is, warp yarn 8 passes under weft yarns 1 and 2, then over weft yarn 3, then under weft yarn 4, then over weft yarn 5, then under weft yarns 6 and 7, and then over weft yarns 8-10. In the area where warp yarn 8 weaves with, e.g., weft yarns 5 and 6, half of pocket P8 is formed. In the area where warp yarn 8 weaves with, e.g., weft yarns 2 and 3, half of pocket P9 is formed. Warp knuckle WPK is formed in the area where warp yarn 8 passes over weft yarns 8-10. Weft knuckles WFK are formed in the areas where the weft yarns 1, 4, and 7 pass over warp yarn 8 and pass over three consecutive warp yarns.

**[0082]** Again with reference to FIG. 6, warp yarn 9 weaves with weft yarns 1-10 by passing over weft yarns 2, 5-7, and 10 and passing under weft yarns 1, 3, 4, 8, and 9. That is, warp yarn 9 passes under weft yarn 1, then over weft yarn 2, then under weft yarns 3 and 4, then over weft yarns 5-7, then under weft yarns 8 and 9, and then over weft yarn 10. In the area where the warp yarn 9 weaves with, e.g., weft yarns 2 and 3, half of pocket P9 is formed. In the area where warp yarn 9 weaves with, e.g., weft yarns 9 and 10, half of pocket P10 is formed. Furthermore, warp knuckle WPK is formed in the area where the warp yarn 9 passes over weft yarns 5-7. Weft knuckles WFK are formed in the areas where weft yarns 1, 4, and 8 pass over warp yarn 9 and pass over three consecutive warp yarns.

**[0083]** Finally, warp yarn 10 weaves with weft yarns 1-10 by passing over weft yarns 2-4, 7, and 9 and passing under weft yarns 1, 5, 6, 8, and 10. That is, warp yarn 10 passes under weft yarn 1, then over weft yarns 2-4, then under weft yarns 5 and 6, then over weft yarn 7, then under weft yarn 8, then over weft yarn 9, and then under weft yarn 10. In the area where warp yarn 10 weaves with weft yarns 9 and 10, half of pocket P10 is formed. In the area where warp yarn 10 weaves with, e.g., weft yarns 6 and 7, half of pocket P11 is formed. Warp knuckle WPK is formed in the area where warp yarn 10 passes over weft yarns 2-4. Weft knuckles WFK are formed in the areas where weft yarns 1, 5, and 8 pass over warp yarn 10 and pass over three consecutive warp yarns.

**[0084]** Each warp yarn weaves with the weft yarns in an identical pattern; that is, each warp yarn passes over one weft yarn, then under one weft yarn, then over one weft yarn, then under two weft yarns, then over three weft yarns, and then

under two weft yarns. In addition, this pattern between adjacent warp yarns is offset by seven weft yarns. For example, the one weft yarn passed under (besides the sets of two consecutive weft yarns passed under) by warp yarn 2 is weft yarn 2. The one weft yarn passed under by warp yarn 3 is weft yarn 9. Also, each weft yarn weaves with the warp yarns in a pattern identical to the one described above; that is, each weft yarn passes over one warp yarn, then under one warp yarn, then over one warp yarn, then under two warp yarns, then over three warp yarns, and then under two warp yarns. This pattern between adjacent weft yarns is offset by seven warp yarns. For example, the one warp yarn passed under (besides the sets of two consecutive warp yarns passed under) by weft yarn 7 is warp yarn 2. The one warp yarn passed over by weft yarn 6 is warp yarn 9.

**[0085]** As discussed above, the yarns define areas in which pockets are formed. Due to the offset of the weave pattern between warp yarns as discussed in the previous paragraph, similar portions of each pocket defined by adjacent warp yarns are also offset from each other by seven weft yarns. For example, a left half of pocket P6 is defined in the area where warp yarn 5 intersects with weft yarns 1 and 2. A left half of pocket P7 is defined in the area where warp yarn 6 intersects with weft yarns 8 and 9.

**[0086]** Each pocket is defined by four sides. Two sides are defined by warp knuckles WPK, each of which crosses three weft yarns, and two sides are defined by weft knuckles WFK, each of which crosses three warp yarns. In addition, each warp knuckle WPK and weft knuckle WFK defines a side for more than one pocket. For example, warp knuckle WPK of warp yarn 2 defines sides of pockets P1 and P4. Similarly, weft knuckle WFK of weft yarn 6 defines a lower side of pocket P4 and an upper side of pocket P5.

**[0087]** Each of the warp knuckles WPK and weft knuckles WFK that defines a single pocket passes over an end of one of the other knuckles and has an end that passes under one of the other knuckles. For example, pocket P5 is defined by warp knuckles WPK of warp yarns 3 and 6 and weft knuckles WFK of weft yarns 3 and 6. Warp knuckle WPK of warp yarn 3 passes over an end of weft knuckle WFK of weft yarn 3 and has an end that passes under weft knuckle WFK of weft yarn 6. Warp knuckle WPK of warp yarn 6 passes over an end of weft knuckle WFK of weft yarn 6 and has an end that passes under weft knuckle WFK of weft yarn 3.

**[0088]** By way of non-limiting example, the parameters of the structured fabric shown in FIGS. 1-6 can have a mesh (number of warp yarns per inch) of 42 and a count (number of weft yarns per inch) of 36. The fabric can have a caliper of about 0.045 inches. The number of pockets per square inch is, for example, in the range of 150-200. The depth of pockets, which is the distance between the upper plane and the lower plane of the fabric, is for example between 0.07 mm and 0.60 mm. The fabric has an upper plane contact area of approximately 10% or higher, for example 15% or higher, or 20% depending upon the particular product being made. The top surface may also be hot calendered to increase the flatness of the fabric and the upper plane contact area. In addition, the single or multi-layered fabric should have a permeability value of between approximately 400 cfm and approximately 600 cfm, for example between approximately 450 cfm and approximately 550 cfm.

**[0089]** Regarding yarn dimensions, the particular size of the yarns is typically governed by the mesh of the papermaking surface. In a typical embodiment of the fabric disclosed



herein, the diameter of the warp and weft yarns can be between about 0.30 mm and 0.50 mm. The diameter of the warp yarns can be about 0.45 mm, for example about 0.40 mm, or about 0.35 mm. The diameter of the weft yarns can be about 0.50 mm, for example about 0.45 mm, or about 0.41 mm. Those of skill in the art will appreciate that yarns having diameters outside the above ranges may be used in certain applications. In one embodiment of the present invention, the warp and weft yarns can have diameters of between about 0.30 mm and 0.50 mm. Fabrics employing these yarn sizes may be implemented with polyester yarns or with a combination of polyester and nylon yarns.

**[0090]** The woven single or multi-layered fabric may utilize hydrolysis and/or heat resistant materials. Hydrolysis resistant materials may include a PET monofilament having an intrinsic viscosity value normally associated with dryer and TAD fabrics in the range of between approximately 0.72 IV (Intrinsic Velocity, i.e., a dimensionless number used to correlate the molecular weight of a polymer; the higher the number the higher the molecular weight) and approximately 1.0 IV. Hydrolysis resistant materials may also have a suitable "stabilization package" which includes carboxyl end group equivalents, as the acid groups catalyze hydrolysis and residual DEG or di-ethylene glycol as this too can increase the rate of hydrolysis. These two factors separate the resin which can be used from the typical PET bottle resin. For hydrolysis, it has been found that the carboxyl equivalent should be as low as possible to begin with, and should be less than approximately 12. Even at this low level of carboxyl end groups an end capping agent may be added, and may utilize a carbodiimide during extrusion to ensure that at the end of the process there are no free carboxyl groups. There are several chemical classes that can be used to cap the end groups such as epoxies, ortho-esters, and isocyanates, but in practice monomeric and combinations of monomeric and polymeric carbodiimides are preferred.

**[0091]** Heat resistant materials such as PPS can be utilized in the structured fabric. Other materials such as PEN, PST, PEEK and PA can also be used to improve properties of the fabric such as stability, cleanliness and life. Both single polymer yarns and copolymer yarns can be used. The yarns for the fabric need not necessarily be monofilament yarns and can be a multi-filament yarns, twisted multi-filament yarns, twisted monofilament yarns, spun yarns, core and sheath yarns, or any combination thereof, and could also be a non-plastic material, i.e., a metallic material. Similarly, the fabric may not necessarily be made of a single material and can be made of two, three or more different materials. Shaped yarns, i.e., non-circular yarns such as round, oval or flat yarns, can also be utilized to enhance or control the topography or properties of the paper sheet. Shaped yarns can also be utilized to improve or control fabric characteristics or properties such as stability, caliper, surface contact area, surface planarity, permeability and wearability. In addition, the yarns may be of any color.

**[0092]** The structured fabric can also be treated and/or coated with an additional polymeric material that is applied by, e.g., deposition. The material can be added cross-linked during processing in order to enhance fabric stability, contamination resistance, drainage, wearability, improve heat and/or hydrolysis resistance and in order to reduce fabric surface tension. This aids in sheet release and/or reduced drive loads. The treatment/coating can be applied to impart/improve one or several of these properties of the fabric. As

indicated previously, the topographical pattern in the paper web can be changed and manipulated by use of different single and multi-layer weaves. Further enhancement of the pattern can be attained by adjustments to the specific fabric weave by changes to the yarn diameter, yarn counts, yarn types, yarn shapes, permeability, caliper and the addition of a treatment or coating, etc. In addition, a printed design, such as a screen printed design, of polymeric material can be applied to the fabric to enhance its ability to impart an aesthetic pattern into the web or to enhance the quality of the web. Finally, one or more surfaces of the fabric or molding belt can be subjected to sanding and/or abrading in order to enhance surface characteristics. Referring to FIGS. 1 and 4, the upper plane of the fabric may be sanded, ground, or abraded in such a manner, resulting in flat oval shaped areas on warp knuckles WPK and weft knuckles WFK.

**[0093]** The characteristics of the individual yarns utilized in the fabric of the present invention can vary depending upon the desired properties of the final papermakers' fabric. For example, the materials comprising yarns employed in the fabric of the present invention may be those commonly used in papermakers' fabric. As such, the yarns may be formed of polypropylene, polyester, nylon, or the like. The skilled artisan should select a yarn material according to the particular application of the final fabric.

**[0094]** By way of non-limiting example, the structured fabric can be a single or multi-layered woven fabric which can withstand high pressures, heat, moisture concentrations, and which can achieve a high level of water removal and also mold or emboss the paper web. These characteristics provide a structured fabric appropriate for the Voith ATMOST<sup>TM</sup> papermaking process. The fabric preferably has a width stability and a suitable high permeability and may, for example utilize hydrolysis and/or temperature resistant materials, as discussed above. The fabric is, for example, a woven fabric that can be installed on an ATMOST<sup>TM</sup> machine as a pre-joined and/or seamed continuous and/or endless belt. Alternatively, the forming fabric can be joined in the ATMOST<sup>TM</sup> machine using, e.g., a pin-seam arrangement or can otherwise be seamed on the machine.

**[0095]** The present invention also provides for utilizing the structured fabric disclosed herein on a machine for making a fibrous web, e.g., tissue or hygiene paper web, etc., which can be, e.g., a twin wire ATMOST<sup>TM</sup> system. Referring again to the drawings, and more particularly to FIG. 7, there is fibrous web machine 20 including headbox 22 that discharges fibrous slurry 24 between forming fabric 26 and structured fabric 28. It should be understood that structured fabric 28 is an embodiment of the structured fabric discussed above in connection with FIGS. 1-6. Rollers 30 and 32 direct fabric 26 in such a manner that tension is applied thereto, against slurry 24 and structured fabric 28. Structured fabric 28 is supported by forming roll 34 which rotates with a surface speed that matches the speed of structured fabric 28 and forming fabric 26. Structured fabric 28 has peaks 28a and valleys 28b, which give a corresponding structure to web 38 formed thereon. Peaks 28a and valleys 28b generally represent the shape of the fabric due to the upper plane, the lower plane, and the pockets of the structured fabric as discussed above. Structured fabric 28 travels in direction W, and as moisture M is driven from fibrous slurry 24, structured fibrous web 38 takes form. Moisture M that leaves slurry 24 travels through form-

ing fabric **26** and is collected in save-all **36**. Fibers in fibrous slurry **24** collect predominately in valleys **28b** as web **38** takes form.

[0096] Forming roll **34** is, for example, solid. Moisture travels through forming fabric **26** but not through structured fabric **28**. This advantageously forms structured fibrous web **38** into a more bulky or absorbent web than the prior art.

[0097] In prior art methods of moisture removal, moisture is removed through a structured fabric by way of negative pressure. This results in a cross-sectional view of fibrous web **40** as seen in FIG. **8**. Prior art fibrous web **40** has pocket depth D which corresponds to the dimensional difference between a valley and a peak. The valley is located at the point where measurement C is located and the peak is located at the point where measurement A is located. Top surface thickness A is formed in the prior art method. Sidewall dimension B and pillow thickness C of the prior art result from moisture drawn through a structured fabric. Dimension B is less than dimension A and dimension C is less than dimension B in the prior art web.

[0098] In contrast, structured fibrous web **38**, as illustrated in FIGS. **9** and **11**, have for discussion purposes, pocket depth D that is similar to the prior art. However, sidewall thickness B' and pillow thickness C' exceed the comparable dimensions of web **40**. This advantageously results from the forming of structured fibrous web **38** on structured fabric **28** at low consistency and the removal of moisture is an opposite direction from the prior art. This results in a thicker pillow dimension C'. Even after structured fibrous web **38** goes through a drying press operation, as illustrated in FIG. **11**, dimension C' is substantially greater than AP'. As illustrated in FIG. **10**, this is in contrast to dimension C of the prior art. Advantageously, the fiber web resulting from the present invention has a higher basis weight in the pillow areas as compared to the prior art. Also, the fiber-to-fiber bonds are not broken as they can be in impression operations, which expand the web into the valleys.

[0099] According to the prior art, an already formed web is vacuum transferred into a structured fabric. The sheet must then expand to fill the contour of the structured fabric. In doing so, fibers must move apart. Thus the basis weight is lower in these pillow areas and therefore the thickness is less than the sheet at point A.

[0100] Now, referring to FIGS. **12** to **17**, the process will be explained by simplified schematic drawings. As shown in FIG. **12**, fibrous slurry **24** is formed into web **38** with a structure that matches the shape of structured fabric **28**. Forming fabric **26** is porous and allows moisture to escape during forming. Further, water is removed as shown in FIG. **14**, through dewatering fabric **82**. The removal of moisture through fabric **82** does not cause compression of pillow areas C' in the web, since pillow areas C' reside in valleys **28b** of structured fabric **28**.

[0101] The prior art web shown in FIG. **13** is formed between two conventional forming fabrics in a twin wire former and is characterized by a flat uniform surface. It is this fiber web that is given a three-dimensional structure by a wet shaping stage, which results in the fiber web that is shown in FIG. **8**. A conventional tissue machine that employs a conventional press fabric will have a contact area approaching 100%. Normal contact area of the structured fibrous web, as in this present invention, or as on a TAD machine, is typically

much lower than that of a conventional machine; it is in the range of 15 to 35% depending on the particular pattern of the product being made.

[0102] Referring now to FIGS. **15** and **17**, there is shown a prior art web structure where moisture is drawn through structured fabric **33** causing the web, as shown in FIG. **8**, to be shaped and causing pillow area C to have a low basis weight as the fibers in the web are drawn into the structure. The shaping can be done by performing pressure or underpressure to web **40** forcing the web to follow the structure of structured fabric **33**. This additionally causes fiber tearing as they are moved into pillow area C. Subsequent pressing at Yankee dryer **52**, as shown in FIG. **17**, further reduces the basis weight in area C. In contrast, water is drawn through dewatering fabric **82** in the present invention, as shown in FIG. **14**, preserving pillow areas C'. Pillow areas C' of FIG. **16** are unpressed zones which are supported on structured fabric **28** while pressed against Yankee dryer **52**. Pressed zone A' is the area through which most of the pressure is applied. Pillow area C' has a higher basis weight than that of the illustrated prior art structures.

[0103] The increased mass ratio of the present invention, particularly the higher basis weight in the pillow areas, carries more water than the compressed areas, resulting in at least two positive aspects of the present invention over the prior art, as illustrated in FIGS. **14** and **16**. First, it allows for a good transfer of web **38** to Yankee surface **52**, since web **38** has a relatively lower basis weight in the portion that comes in contact with Yankee surface **52**, at a lower overall sheet solid content than had been previously attainable, because of the lower mass of fibers that comes in contact with Yankee dryer **52**. The lower basis weight means that less water is carried to the contact points with Yankee dryer **52**. The compressed areas are dryer than the pillow areas, thereby allowing an overall transfer of the web to another surface, such as Yankee dryer **52**, with a lower overall web solids content. Secondly, the construct allows for the use of higher temperatures in Yankee hood **54** without scorching or burning of the pillow areas, which occurs in the prior art pillow areas. Yankee hood **54** temperatures are often greater than approximately 350° C., for example greater than 450° C., or even greater than 550° C. As a result the present invention can operate at lower average pre-Yankee press solids than the prior art, making more full use of the capacity of Yankee hood drying system. The present invention allows the solids content of web **38** prior to the Yankee dryer **52** to run at less than approximately 40%, less than 35% and even as low as 25%.

[0104] Due to the formation of web **38** with structured fabric **28** the pockets of fabric **28** are fully filled with fibers. Therefore, at Yankee surface **52** web **38** has a much higher contact area, up to approximately 100%, as compared to the prior art because web **38** on the side contacting Yankee surface **52** is almost flat. At the same time pillow areas C' of web **38** are maintained unpressed, because they are protected by the valleys of structured fabric **28** (FIG. **16**). Good results in drying efficiency were obtained only pressing 25% of the web.

[0105] As can be seen in FIG. **17** the contact area of the prior art web **40** to Yankee surface **52** is much lower as compared to the one of web **38** manufactured according to the present invention. The lower contact area of the prior art web **40** results from shaping web **40** by drawing water out of web **40** through structured fabric **33**. Drying efficiency of the prior

art web **40** is less than that of web **38** of the present invention because the area of the prior art web **40** is in less contact with Yankee surface **52**.

[0106] Referring now to FIG. **18**, there is shown an embodiment of the process according to the present invention where structured fibrous web **38** is formed. Structured fabric **28** carries three dimensional structured fibrous web **38** to advanced dewatering system **50**, past vacuum box **67** and then to a position where the web is transferred to Yankee dryer **52** and hood section **54** for additional drying and creping before winding up on a reel (not shown).

[0107] Shoe press **56** is placed adjacent to structured fabric **28**, holding fabric **28** in a position proximate Yankee dryer **52**. Structured fibrous web **38** comes into contact with Yankee dryer **52** and transfers to a surface thereof, for further drying and subsequent creping.

[0108] Vacuum box **58** is placed adjacent to structured fabric **28** to achieve a solids level of approximately 15-25% on a nominal 20 gsm web running at -0.2 to -0.8 bar vacuum with, for example, an operating level of approximately -0.4 to -0.6 bar. Web **38**, which is carried by structured fabric **28**, contacts dewatering fabric **82** and proceeds toward vacuum roll **60**. Vacuum roll **60** operates at a vacuum level of approximately -0.2 to -0.8 bar with an operating level, for example, of at least -0.4 bar. Hot air hood **62** is optionally fit over vacuum roll **60** to improve dewatering. If, for example, a commercial Yankee drying cylinder with 44 mm steel thickness and a conventional hood with an air blowing speed of 145 m/s is used, production speeds of 1400 m/min or more for towel paper and 1700 m/min or more for toilet paper are used.

[0109] Optionally a steam box can be installed instead of hood **62** supplying steam to web **38**. The steam box may have a sectionalized design to influence the moisture re-dryness cross profile of web **38**. The length of the vacuum zone inside vacuum roll **60** can be from approximately 200 mm to 2,500 mm, for example 300 mm to 1,200 mm or between 400 mm to 800 mm. The solids level of web **38** leaving suction roll **60** is 25% to 55%, depending on installed options. Vacuum box **67** and hot air supply **65** can be used to increase web **38** solids after vacuum roll **60** and prior to Yankee dryer **52**. Wire turning roll **69** can also be a suction roll with a hot air supply hood. As discussed above, roll **56** includes a shoe press with a shoe width of 80 mm or higher, for example 120 mm or higher, with a maximum peak pressure of less than 2.5 MPa. To create an even longer nip to facilitate the transfer of web **38** to Yankee dryer **52**, web **38** carried on structured fabric **28** can be brought into contact with the surface of Yankee dryer **52** prior to the press nip associated with shoe press **56**. Further, the contact can be maintained after structured fabric **28** travels beyond press **56**.

[0110] Dewatering fabric **82** may have a permeable woven base fabric connected to a batt layer. The base fabric includes machine direction yarns and cross-direction yarns. The machine direction yarn is a three-ply multi-filament twisted yarn. The cross-direction yarn is a monofilament yarn. The machine direction yarn can also be a monofilament yarn and the construction can be of a typical multilayer design. In either case, the base fabric is needled with a fine batt fiber having a weight of less than or equal to 700 gsm, for example less than or equal to 150 gsm, or less than or equal to 135 gsm. The batt fiber encapsulates the base structure giving it sufficient stability. The sheet contacting surface is heated to improve its surface smoothness. The cross-sectional area of the machine direction yarns is larger than the cross-sectional

area of the cross-direction yarns. The machine direction yarn is a multi-filament yarn that may include thousands of fibers. The base fabric is connected to a batt layer by a needling process that results in straight through drainage channels.

[0111] In another embodiment of dewatering fabric **82** according to the present invention, there is included a fabric layer, at least two batt layers, an anti-rewetting layer, and an adhesive. The base fabric is substantially similar to the previous description. At least one of the batt layers includes a low melt bi-compound fiber to supplement fiber-to-fiber bonding upon heating. On one side of the base fabric, there is attached an anti-rewetting layer, which may be attached to the base fabric by an adhesive, a melting process, or needling wherein the material contained in the anti-rewetting layer is connected to the base fabric layer and a batt layer. The anti-rewetting layer is made of an elastomeric material thereby forming an elastomeric membrane, which has openings there through.

[0112] The batt layers are needled to thereby hold dewatering fabric **82** together. This advantageously leaves the batt layers with many needled holes therethrough. The anti-rewetting layer is porous, having water channels or straight through pores there through.

[0113] In yet another embodiment of dewatering fabric **82** according to the present invention, there is a construct substantially similar to that previously discussed with an addition of a hydrophobic layer to at least one side of dewatering fabric **82**. The hydrophobic layer does not absorb water, but it does direct water through pores therein.

[0114] In yet another embodiment of dewatering fabric **82** according to the present invention, the base fabric has attached thereto a lattice grid made of a polymer, such as polyurethane, that is put on top of the base fabric. The grid may be put on to the base fabric by utilizing various known procedures, such as, for example, an extrusion technique or a screen-printing technique. The lattice grid may be put on the base fabric with an angular orientation relative to the machine direction yarns and the cross-direction yarns. Although this orientation is such that no part of the lattice is aligned with the machine direction yarns, other orientations can also be utilized. The lattice can have a uniform grid pattern, which can be discontinuous in part. Further, the material between the interconnections of the lattice structure may take a circuitous path rather than being substantially straight. The lattice grid is made of a synthetic, such as a polymer or specifically a polyurethane, which attaches itself to the base fabric by its natural adhesion properties.

[0115] In yet another embodiment of dewatering fabric **82** according to the present invention, there is included a permeable base fabric having machine direction yarns and cross-direction yarns that are adhered to a grid. The grid is made of a composite material that may be the same as that discussed relative to a previous embodiment of dewatering fabric **82**. The grid includes machine direction yarns with a composite material formed therearound. The grid is a composite structure formed of composite material and machine direction yarns. The machine direction yarns may be pre-coated with a composite before being placed in rows that are substantially parallel in a mold that is used to reheat the composite material causing it to re-flow into a pattern. Additional composite material may be put into the mold as well. The grid structure, also known as a composite layer, is then connected to the base fabric by one of many techniques including laminating the grid to the permeable fabric, melting the composite coated yarn as it is held in position against the permeable fabric or by

re-melting the grid onto the base fabric. Additionally, an adhesive may be utilized to attach the grid to the permeable fabric.

[0116] The batt layer may include two layers, an upper and a lower layer. The batt layer is needled into the base fabric and the composite layer, thereby forming dewatering fabric **82** having at least one outer batt layer surface. Batt material is porous by its nature, and additionally the needling process not only connects the layers together, but it also creates numerous small porous cavities extending into or completely through the structure of dewatering fabric **82**.

[0117] Dewatering fabric **82** has an air permeability of from approximately 5 to 100 cfm, for example 19 cfm or higher, or 35 cfm or higher. Mean pore diameters in dewatering fabric **82** are from approximately 5 to 75 microns, for example 25 microns or higher, or 35 microns or higher. The hydrophobic layers can be made from a synthetic polymeric material, a wool or a polyamide, for example, nylon 6. The anti-rewetting layer and the composite layer may be made of a thin elastomeric permeable membrane made from a synthetic polymeric material or a polyamide that is laminated to the base fabric.

[0118] The batt fiber layers are made from fibers ranging from approximately 0.5 d-tex to 22 d-tex and may contain a low melt bi-compound fiber to supplement fiber-to-fiber bonding in each of the layers upon heating. The bonding may result from the use of a low temperature meltable fiber, particles and/or resin. The dewatering fabric can be less than approximately 2.0 mm thick.

[0119] Preferred embodiments of the dewatering fabric **82** are also described in the PCT/EP2004/053688 and PCT/EP2005/050198 which are herewith incorporated by reference.

[0120] Now, additionally referring to FIG. 19, there is shown yet another embodiment of the present invention, which is substantially similar to the invention illustrated in FIG. 18, except that instead of hot air hood **62**, there is belt press **64**. Belt press **64** includes permeable belt **66** capable of applying pressure to the machine side of structured fabric **28** that carries web **38** around vacuum roll **60**. Fabric **66** of belt press **64** is also known as an extended nip press belt or a link fabric, which can run at approximately 60 KN/m fabric tension with a pressing length that is longer than the suction zone of roll **60**.

[0121] Preferred embodiments of fabric **66** and the required operation conditions are also described in PCT/EP2004/053688 and PCT/EP2005/050198 which are herewith incorporated by reference.

[0122] The above mentioned references are also fully applicable for dewatering fabrics **82** and press fabrics **66** described in the further embodiments.

[0123] While pressure is applied to structured fabric **28** by belt press **64**, the high fiber density pillow areas in web **38** are protected from that pressure as they are contained within the body of structured fabric **28**, as they are in the Yankee nip.

[0124] Belt **66** is a specially designed extended nip press belt **66**, made of, for example reinforced polyurethane and/or a spiral link fabric. Belt **66** also can have a woven construction. Such a woven construction is disclosed, e.g., in EP 1837439. Belt **66** is permeable thereby allowing air to flow there through to enhance the moisture removing capability of belt press **64**. Moisture is drawn from web **38** through dewatering fabric **82** and into vacuum roll **60**.

[0125] Belt **66** provides a low level of pressing in the range of approximately 50-300 KPa, for example greater than 100 KPa. This allows a suction roll with a 1.2 m diameter to have a fabric tension of greater than 30 KN/m, for example greater than 60 KN/m. The pressing length of permeable belt **66** against fabric **28**, which is indirectly supported by vacuum roll **60**, is at least as long as a suction zone in roll **60**. However, the contact portion of belt **66** can be shorter than the suction zone.

[0126] Permeable belt **66** has a pattern of holes there-through, which may, for example, be drilled, laser cut, etched formed or woven therein. Permeable belt **66** may be mono-planar without grooves. In one embodiment of the present invention, the surface of belt **66** has grooves and is placed in contact with fabric **28** along a portion of the travel of permeable belt **66** in belt press **64**. Each groove connects with a set of the holes to allow the passage and distribution of air in belt **66**. Air is distributed along the grooves, which constitutes an open area adjacent to contact areas, where the surface of belt **66** applies pressure against web **38**. Air enters permeable belt **66** through the holes and then migrates along the grooves, passing through fabric **28**, web **38** and fabric **82**. The diameter of the holes may be larger than the width of the grooves. The grooves may have a cross-section contour that is generally rectangular, triangular, trapezoidal, semi-circular or semi-elliptical. The combination of permeable belt **66**, associated with vacuum roll **60**, is a combination that has been shown to increase sheet solids by at least 15%.

[0127] An example of another structure of belt **66** is that of a thin spiral link fabric, which can be a reinforcing structure within belt **66** or the spiral link fabric will itself serve as belt **66**. Within fabric **28** there is a three dimensional structure that is reflected in web **38**. Web **38** has thicker pillow areas, which are protected during pressing as they are within the body of structured fabric **28**. As such, the pressing imparted by belt press **64** upon web **38** does not negatively impact web quality, while it increases the dewatering rate of vacuum roll **60**.

[0128] Referring now to FIG. 20, there is shown another embodiment of the present invention which is substantially similar to the embodiment shown in FIG. 19 with the addition of hot air hood **68** placed inside of belt press **64** to enhance the dewatering capability of belt press **64** in conjunction with vacuum roll **60**.

[0129] Referring now to FIG. 21, there is shown yet another embodiment of the present invention, which is substantially similar to the embodiment shown in FIG. 19, but including a boost dryer **70** which encounters structured fabric **28**. Web **38** is subjected to a hot surface of boost dryer **70**, and structured web **38** rides around boost dryer **70** with another woven fabric **72** riding on top of structured fabric **28**. On top of woven fabric **72** is a thermally conductive fabric **74**, which is in contact with both woven fabric **72** and cooling jacket **76** that applies cooling and pressure to all fabrics and web **38**. Here again, the higher fiber density pillow areas in web **38** are protected from the pressure as they are contained within the body of structured fabric **28**. As such, the pressing process does not negatively impact web quality. The drying rate of boost dryer **70** is above approximately 400 kg/hr-m<sup>2</sup>, for example above 500 kg/hr-m<sup>2</sup>. The concept of boost dryer **70** is to provide sufficient pressure to hold web **38** against the hot surface of the dryer, thus preventing blistering. Steam that is formed at the knuckle points of fabric **28** passes through fabric **28** and is condensed on fabric **72**. Fabric **72** is cooled by fabric **74** that is in contact with cooling jacket **76**, which

reduces its temperature to well below that of the steam. Thus the steam is condensed to avoid a pressure build-up to thereby avoid blistering of web 38. The condensed water is captured in woven fabric 72, which is dewatered by dewatering device 75. It has been shown that, depending on the size of boost dryer 70, the need for vacuum roll 60 can be eliminated. Further, depending on the size of boost dryer 70, web 38 may be creped on the surface of boost dryer 70, thereby eliminating the need for Yankee dryer 52.

[0130] Referring now to FIG. 22, there is shown yet another embodiment of the present invention substantially similar to the invention disclosed in FIG. 19, but with an addition of air press 78, which is a four roll cluster press that is used with high temperature air and is referred to as an HPTAD for additional web drying prior to the transfer of web 38 to Yankee dryer 52. Four roll cluster press 78 includes a main roll, a vented roll, and two cap rolls. The purpose of this cluster press is to provide a sealed chamber that is capable of being pressurized. The pressure chamber contains high temperature air, for example, approximately 150° C. or higher and is at a significantly higher pressure than conventional TAD technology, for example, greater than approximately 1.5 psi resulting in a much higher drying rate than a conventional TAD. The high pressure hot air passes through an optional air dispersion fabric, through web 38 and fabric structured 28 into a vent roll. The air dispersion fabric may prevent web 38 from following one of the cap rolls. The air dispersion fabric is very open, having a permeability that equals or exceeds that of fabric structured 28. The drying rate of the HPTAD depends on the solids content of web 38 as it enters the HPTAD. The drying rate is, for example, at least 500 kg/hr·m<sup>2</sup>, which is a rate of at least twice that of conventional TAD machines.

[0131] Advantages of the HPTAD process are in the areas of improved sheet dewatering without a significant loss in sheet quality and compactness in size and energy efficiency. Additionally, it enables higher pre-Yankee solids, which increase the speed potential of the invention. Further, the compact size of the HPTAD allows for easy retrofitting to an existing machine. The compact size of the HPTAD and the fact that it is a closed system means that it can be easily insulated and optimized as a unit to increase energy efficiency.

[0132] Referring now to FIG. 23, there is shown another embodiment of the present invention. This is significantly similar to the embodiments shown in FIGS. 19 and 22 except for the addition of two-pass HPTAD 80. In this case, two vented rolls are used to double the dwell time of structured web 38 relative to the design shown in FIG. 22. An optional coarse mesh fabric may be used as in the previous embodiment. Hot pressurized air passes through web 38 carried on structured fabric 28 and onto the two vent rolls. It has been shown that depending on the configuration and size of the HPTAD, more than one HPTAD can be placed in series, which can eliminate the need for roll 60.

[0133] Referring now to FIG. 24, conventional twin wire former 90 may be used to replace the crescent former shown in previous examples. The forming roll can be either a solid or open roll. If an open roll is used, care must be taken to prevent significant dewatering through the structured fabric to avoid losing basis weight in the pillow areas. Outer forming fabric 93 can be either a standard forming fabric or one such as that disclosed in U.S. Pat. No. 6,237,644. Inner fabric 91 should be a structured fabric that is much coarser than outer forming

fabric 90. For example, inner fabric 91 may be similar to structured fabric 28. Vacuum roll 92 may be needed to ensure that the web stays with structured fabric 91 and does not go with outer wire 90. Web 38 is transferred to structured fabric 28 using a vacuum device. The transfer can be a stationary vacuum shoe or vacuum assisted rotating pick-up roll 94. Second structured fabric 28 is at least the same coarseness and may be coarser than first structured fabric 91. The process from this point is the same as the process previously discussed in conjunction with FIG. 19. The registration of the web from the first structured fabric to the second structured fabric is not perfect, and as such some pillows will lose some basis weight during the expansion process, thereby losing some of the benefit of the present invention. However, this process option allows for running a differential speed transfer, which has been shown to improve some sheet properties. Any of the arrangements for removing water discussed above as may be used with the twin wire former arrangement and a conventional TAD.

[0134] Referring now to FIG. 25, the components shown in previous examples may be replaced by a machine in which the web is not directly transferred between fabrics. This system is referred to as an E-TAD and includes press felt 102 that originally carries a structured fibrous web. The web is transferred to backing roll 104 at shoe press 106. Backing roll 104 is, for example, a dryer that carries the web without the assistance of a fabric over part of its surface. Backing roll 104 transfers the web to transfer fabric 108 that is an embodiment of the structured fabric discussed above in connection with FIGS. 1-6. This process allows for running a differential speed transfer between backing roll 104 and transfer fabric 108. Transfer fabric 108 subsequently transfers the web to Yankee dryer 52. Additional components may be added to the E-TAD system, such as other drying components as discussed with previous embodiments of the present invention.

[0135] Although the structured fabric of the present invention may be used with a papermaking machine according to the previous discussion, the structured fabric may also be used with a conventional TAD machine. TAD machines, as well as their operating characteristics and associated components, are well known in the art as for example from U.S. Pat. No. 4,191,609, hereby incorporated by reference in its entirety.

[0136] The fiber distribution of web 38 in the present invention is opposite that of the prior art, which is a result of removing moisture through the forming fabric and not through the structured fabric. The low density pillow areas are of relatively high basis weight compared to the surrounding compressed zones, which is opposite of conventional TAD paper. This allows a high percentage of the fibers to remain uncompressed during the process. The sheet absorbency capacity as measured by the basket method, for a nominal 20 gsm web is equal to or greater than 12 grams water per gram of fiber and often exceeds 15 grams of water per gram fiber. The sheet bulk is equal to or greater than 10 cm<sup>3</sup>/gm, for example greater than 13 cm<sup>3</sup>/gm. The sheet bulk of toilet tissue is expected to be equal to or greater than approximately 13 cm<sup>3</sup>/gm before calendering.

[0137] With the basket method of measuring absorbency, 5 grams of paper are placed into a basket. The basket containing the paper is then weighed and introduced into a small vessel of water at 20° C. for 60 seconds. After 60 seconds of soak time, the basket is removed from the water and allowed to drain for 60 seconds and then weighed again. The weight

difference is then divided by the paper weight to yield the grams of water held per gram of fibers being absorbed and held in the paper.

[0138] As discussed above, web 38 is formed from fibrous slurry 24 that headbox 22 discharges between forming fabric 26 and structured fabric 28. Roll 34 rotates and supports fabrics 26 and 28 as web 38 forms. Moisture M flows through fabric 26 and is captured in save-all 36. It is the removal of moisture in this manner that serves to allow pillow areas of web 38 to retain a greater basis weight and, therefore, thickness than if the moisture was removed through structured fabric 28. Sufficient moisture is removed from web 38 to allow fabric 26 to be removed from web 38 to allow web 38 to proceed to a drying stage. As discussed above, web 38 retains the pattern of structured fabric 28 and, in addition, any zonal permeability effects from fabric 26 that may be present.

[0139] As slurry 24 comes from headbox 22 it has a very low consistency of approximately 0.1 to 0.5%. The consistency of web 38 increases to approximately 7% at the end of the forming section outlet. In some of the embodiments described above, structured fabric 28 carries web 38 from where it is first placed there by headbox 22 all the way to a Yankee dryer to thereby provide a well defined paper structure for maximum bulk and absorbency. Web 38 has exceptional caliper, bulk and absorbency, those parameters being about 30% higher than with a conventional TAD fabric used for producing paper towels. Excellent transfer of web 38 to the Yankee dryer takes place with the ATMOS™ system working at 33% to 37% dryness, which is a higher moisture content than the TAD of 60% to 75%. There is no dryness loss running in the ATMOS™ configuration since structured fabric 28 has pockets (valleys 28b), and there is no loss of intimacy between a dewatering fabric, web 38, structured fabric 28 and the belt.

[0140] As explained above, the structured fabric imparts a topographical pattern into the paper sheet or web. To accomplish this, high pressures can be imparted to the fabric via the high tension belt. The topography of the sheet pattern can be manipulated by varying the specifications of the fabric, i.e., by regulating parameters such as, yarn diameter, yarn shape, yarn density, and yarn type. Different topographical patterns can be imparted in the sheet by different surface weaves. Similarly, the intensity of the sheet pattern can be varied by altering the pressure imparted by the high tension belt and by varying the specification of the fabric. Other factors which can influence the nature and intensity of the topographical pattern of the sheet include air temperature, air speed, air pressure, belt dwell time in the extended nip, and nip length.

[0141] It is noted that the foregoing examples have been provided merely for the purpose of explanation and are in no way to be construed as limiting of the present invention. While the present invention has been described with reference to exemplary embodiments, it should be understood that the words that have been used are words of description and illustration, rather than words of limitation. Changes may be made, within the purview of the appended claims, as presently stated and as amended, without departing from the scope and spirit of the present invention in its aspects. Although the invention has been described herein with reference to particular arrangements, materials and embodiments, the invention is not intended to be limited to the particulars disclosed herein. Instead, the invention extends to all functionally equivalent structures, methods and uses, such as are within the scope of the appended claims.

[0142] While this invention has been described with respect to at least one embodiment, the present invention can be further modified within the spirit and scope of this disclosure. This application is therefore intended to cover any variations, uses, or adaptations of the invention using its general principles. Further, this application is intended to cover such departures from the present disclosure as come within known or customary practice in the art to which this invention pertains and which fall within the limits of the appended claims.

What is claimed is:

1. A papermaking machine comprising:
  - a vacuum roll having an exterior surface;
  - a dewatering fabric having a first side and a second side, the dewatering fabric being guided over a portion of the exterior surface of the vacuum roll, the first side being in at least partial contact with the exterior surface of the vacuum roll; and
  - a structured fabric having a machine facing side and a web facing side including a plurality of pockets, each of said pockets is defined by four sides on the web facing side, each of the four sides formed by a knuckle of a single yarn that passes over only two other consecutive yarns to define the knuckle, wherein the dewatering fabric is positioned between the vacuum roll and the structured fabric.
2. The papermaking machine according to claim 1, further comprising a belt press including a permeable belt having a first side, the permeable belt being guided over a portion of the vacuum roll and the first side of the permeable belt being in at least partial contact with the machine facing side of the structured fabric.
3. The papermaking machine according to claim 2, further comprising:
  - a forming roll having an exterior surface, the structured fabric being guided over a portion of the exterior surface of the forming roll and the machine facing side of the structured fabric being in at least partial contact with the exterior surface of the forming roll; and
  - a forming fabric having a first side and a second side, the structured fabric being positioned between the forming roll and the forming fabric.
4. The papermaking machine according to claim 3, wherein a fibrous web is formed between the web facing side of the structured fabric and the first side of the forming fabric.
5. The papermaking machine according to claim 4, wherein the structured fabric transfers the fibrous web to a Yankee dryer.
6. A papermaking machine comprising:
  - a vacuum roll having an exterior surface;
  - a dewatering fabric having a first side and a second side, the dewatering fabric being guided over a portion of the exterior surface of the vacuum roll, the first side being in at least partial contact with the exterior surface of the vacuum roll; and
  - a structured fabric having a machine facing side and a web facing side including pockets formed by warp and weft yarns, wherein each pocket is defined by four sides on the web facing side, two of the four sides each formed by a warp knuckle of a single warp yarn that passes over three consecutive weft yarns to define the warp knuckle, the other two of the four sides each formed by a weft knuckle of a single weft yarn that passes over three consecutive warp yarns to define the weft knuckle, a lower surface of each pocket being formed by first and

second lower warps yarns and first and second lower weft yarns, a first warp knuckle being of the first warp yarn passed over by a first weft knuckle and the first lower warp yarn being of the second warp yarn passed over by the first weft knuckle and the second lower warp yarn being of the third warp yarn passed over the first weft knuckle, a second weft knuckle being of the first weft yarn passed over by the first warp knuckle and the second lower weft yarn being of the second weft yarn passed over by the first warp knuckle and the first lower weft yarn being of the third weft yarn passed over by the first warp knuckle, the first lower warp yarn passing over the first lower weft yarn and under the second lower weft yarn, and the second lower warp yarn passing under the first lower weft yarn and over the second lower weft yarn, and wherein the dewatering fabric is positioned between the vacuum roll and the structured fabric.

7. The papermaking machine according to claim 6, further comprising a belt press including a permeable belt having a first side, the permeable belt being guided over a portion of the vacuum roll, wherein the first side of the permeable belt is in at least partial contact with the machine facing side of the structured fabric.

8. A papermaking machine comprising:

a Yankee dryer;

at least one structured fabric having a machine facing side and a web facing side including pockets formed by warp and weft yarns, each of the pockets defined by four sides on the web facing side, each of the four sides formed by a knuckle of a single yarn that passes over only two consecutive yarns to define the knuckle and the at least one structured fabric configured to convey a fibrous web to the Yankee dryer.

9. The papermaking machine according to claim 8, further comprising a forming roll having an exterior surface and a forming fabric having a first side and a second side, the at least one structured fabric being guided over a portion of the exterior surface of the forming roll, the machine facing side of the structured fabric being in at least partial contact with the exterior surface of the forming roll and the at least one structured fabric being positioned between the forming roll and the forming fabric.

10. The papermaking machine according to claim 9, further comprising a backing roll, the at least one structured fabric being a transfer fabric between the fabric roll and the Yankee dryer.

11. A papermaking machine comprising:

a Yankee dryer;

at least one structured fabric having a machine facing side and a web facing side including pockets formed by warp and weft yarns, wherein each pocket is defined by four sides on the web facing side, two of the four sides each formed by a warp knuckle of a single warp yarn that passes over three consecutive weft yarns to define the warp knuckle, the other two of the four sides each formed by a weft knuckle of a single weft yarn that passes over three consecutive warp yarns to define the weft knuckle, a lower surface of each pocket being formed by first and second lower warps yarns and first and second lower weft yarns, a first warp knuckle being

of the first warp yarn passed over by a first weft knuckle and the first lower warp yarn being of the second warp yarn passed over by the first weft knuckle and the second lower warp yarn being of the third warp yarn passed over the first weft knuckle, a second weft knuckle being of the first weft yarn passed over by the first warp knuckle and the second lower weft yarn being of the second weft yarn passed over by the first warp knuckle and the first lower weft yarn being of the third weft yarn passed over by the first warp knuckle, the first lower warp yarn passing over the first lower weft yarn and under the second lower weft yarn, and the second lower warp yarn passing under the first lower weft yarn and over the second lower weft yarn, and wherein the at least one structured fabric conveys a fibrous web to the Yankee dryer.

12. The papermaking machine according to claim 11, further comprising a forming roll having an exterior surface and a forming fabric having first and second sides, wherein the at least one structured fabric is guided over a portion of the exterior surface of the forming roll and the machine facing side of the structured fabric is in at least partial contact with the exterior surface of the forming roll, wherein the at least one structured fabric is positioned between the forming roll and the forming fabric.

13. A method of pressing a fibrous material web in a papermaking machine, the method comprising the steps of:

forming a fabric for the papermaking machine, the fabric having a machine facing side and a web facing side including pockets formed by a plurality of warp yarns and weft yarns, each of the pockets being defined by four sides on the web facing side, each of the four sides formed by a knuckle of one yarn of the plurality of warp yarns and weft yarns that passes over only two consecutive other yarns of the plurality of warp yarns and weft yarns to define the knuckle;

forming the fibrous material web; and

applying pressure to the fabric and the fibrous material web.

14. The method according to claim 13, wherein the papermaking machine is one of a TAD system, an ATMOS™ system and an E-TAD system.

15. A method of pressing a fibrous material web in a papermaking machine, the method comprising the steps of:

forming a fabric for the papermaking machine, the fabric having a machine facing side and a web facing side including pockets formed by a plurality of warp yarns and weft yarns, wherein each pocket is defined by four sides on the web facing side, two of the four sides each formed by a warp knuckle of a single warp yarn that passes over three consecutive weft yarns to define the warp knuckle, the other two of the four sides each formed by a weft knuckle of a single weft yarn that passes over three consecutive warp yarns to define the weft knuckle, a lower surface of each pocket being formed by first and second lower warps yarns and first and second lower weft yarns, a first warp knuckle being of the first warp yarn passed over by a first weft knuckle and the first lower warp yarn being of the second warp yarn passed over by the first weft knuckle and the second

lower warp yarn being of the third warp yarn passed over the first weft knuckle, a second weft knuckle being of the first weft yarn passed over by the first warp knuckle and the second lower weft yarn being of the second weft yarn passed over by the first warp knuckle and the first lower weft yarn being of the third weft yarn passed over by the first warp knuckle, the first lower warp yarn passing over the first lower weft yarn and under the second lower weft yarn, and the second lower warp yarn passing under the

first lower weft yarn and over the second lower weft yarn;  
forming the fibrous web; and  
applying pressure to the fibrous material web and the fabric.

**16.** The method according to claim **15**, wherein the paper-making machine is one of a TAD system, an ATMOST™ system and an E-TAD system.

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