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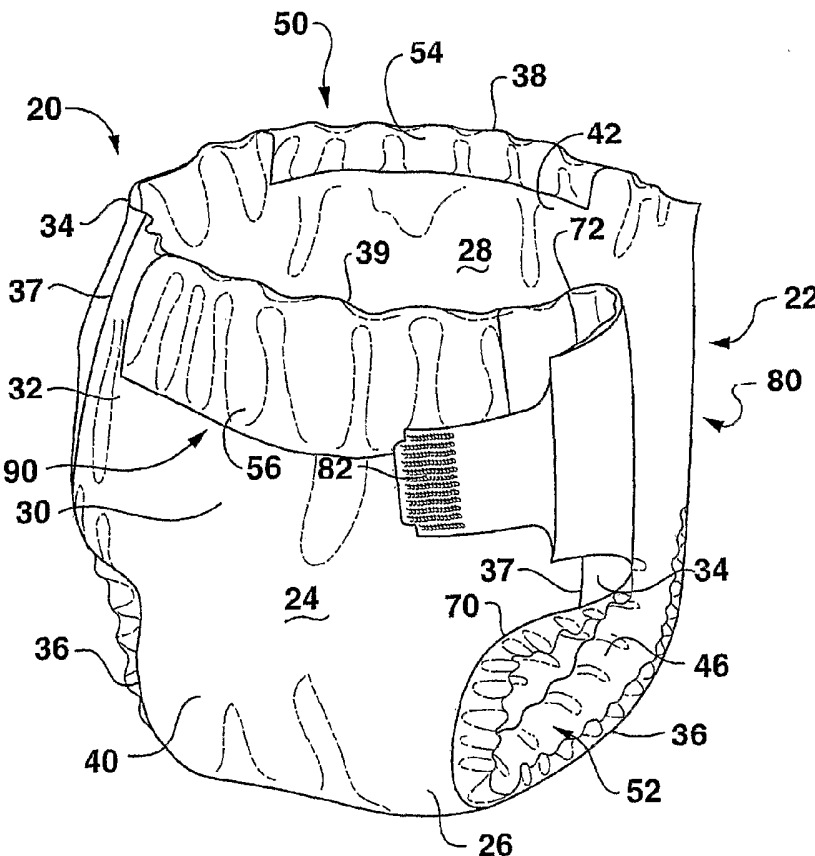
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(54) Title: ABSORBENT ARTICLES HAVING A WAIST REGION AND CORRESPONDING FASTENERS THAT HAVE MATCHING STRETCH PROPERTIES



(57) Abstract: Absorbent articles with carefully controlled stretch properties are disclosed. In particular, the absorbent articles have a waistband that encompasses a pair of opposing side panels and a waist region of the article. The side panels are attached to longitudinal edges of a chassis and are configured to extend around a person's waist. The side panels are attached to fastening devices for fastening the absorbent article to a wearer. In accordance with the present invention, the side panels and the waist region are both elastic. In order to improve fit and comfort, the stretch properties of the side panels are matched with the stretch properties of the waist region. For example, elongation of the side panels can be matched to elongation of the waist region or, alternatively, displacement of the side panels can be matched to the displacement of the waist region for a given range of forces.

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ABSORBENT ARTICLES HAVING A WAIST REGION AND CORRESPONDING FASTENERS THAT HAVE MATCHING STRETCH PROPERTIES

Background of the Invention

Absorbent articles such as diapers, training pants, incontinence garments, swim undergarments, and the like conventionally include a liquid permeable body-facing liner, a liquid impermeable outer cover, and an absorbent core. The absorbent core is typically located in between the outer cover and the liner for taking in and retaining liquids (e.g., urine) exuded by the wearer.

Some of these absorbent articles contain various elastic materials to permit some expansion of the article when necessary to provide a better fit on the wearer. The elastic members are also designed to contract when being worn in order to provide the article with form-fitting properties at least in some areas.

For instance, some disposable diapers made in the past have included elastic fastener tabs that are typically joined to the rear portion of the article and are configured to releasably attach to the front of the article, partially encircling a user's waist when being worn. In other configurations, diapers have also been constructed containing an elastic waistband that also partially encircles the waist of a user.

The amount of stretch and elasticity present in an absorbent article in the transverse direction can have a significant impact upon the perceived comfort and fit of the garment. For example, if the elastic portions of the article only elongate when relatively high forces are exerted on the article, consumers may perceive that the product will not fit correctly and may not provide room for any movement without irritation from the product. If the article, on the other hand, stretches under relatively low amounts of force, consumers may perceive that the product fit will degrade during wear and may result in leakage.

The above problems may become exacerbated in some applications when the stretch properties of the garment are irregular or non-uniform. For instance, products having elastic fasteners and non-elastic waistbands or having elastic waistbands with non-elastic fasteners can, under some circumstances, feel uncomfortable to a consumer. Specifically, these products may feel under some circumstances to have too much stretch or too little stretch.

In view of the above, a need currently exists for an improved absorbent article that is perceived by consumers to have the correct amount of stretch around the entire waist of the user. A need also exists for an absorbent article that has uniform stretch properties in the transverse direction for providing a better and
5 more comfortable fit.

In the past, efforts have been undertaken to produce totally stretchable, form-fitting pant-like absorbent garments. For example, a stretchable absorbent garment is disclosed in PCT International Publication No. WO 02/34185 to Morman, et al., which is incorporated herein by reference. In the above reference,
10 a pant-like absorbent garment is disclosed having a stretchable outer cover and a non-stretchable bodyside liner. In one embodiment, the outer cover is stretchable in the transverse direction. The non-stretchable bodyside liner is attached to a pair of highly stretchable side panels. The total elongation of the side panels in centimeters in a transverse direction is roughly equal to the elongation of the outer
15 cover in centimeters in the transverse direction. Further, the side panels have a percentage transverse stretch equal to at least one-half of a percentage transverse stretch of the outer cover times the width of the outer cover divided by a total width of the side panels. In this manner, the outer cover may stretch freely without inhibiting the non-stretchable bodyside liner.

20 Although the above patent application has provided great advancements in the art, the present invention is directed to further improvements in absorbent articles having controlled transverse stretch properties, especially controlled properties along the waist region of the article.

25 **SUMMARY OF THE INVENTION**

In general, the present invention relates to disposable absorbent articles having carefully controlled stretch properties. For instance, the absorbent articles contain uniform stretch properties in the transverse direction resulting in an improved fit and appearance. In particular, absorbent articles made in accordance
30 with the present invention include a waistband made from multiple pieces of material joined together. Each of the materials, however, are tailored to have matching stretch properties in terms of displacement or elongation. In this manner,

the multi-piece waistband simulates and is perceived as a single and unitary piece of material for maximizing comfort, improving fit and improving appearance.

As used herein, a waistband extends at least partially around the circumference of the absorbent article. For example, in one embodiment, the waistband may extend over a first side panel, a waist region, and a second
5 opposing side panel. In an alternative embodiment, the waistband may form an entire circumference around the article. The different zones in the waistband may be identified by where two different materials are attached together or where a first material is placed on a second material.

10 For instance, in one embodiment, the present invention is directed to an absorbent article comprising an outer cover made from an extendable material. The outer cover may be made, for instance, from a laminate. The laminate may contain a film layer and a nonwoven layer. In one particular embodiment, the outer cover may comprise a neck-bonded laminate. In addition to being extendable, the
15 outer cover may also be elastic.

A bodyside liner is joined to the outer cover in a superimposed relation. Similar to the outer cover, the bodyside liner also comprises an extendable material. The chassis further includes an absorbent structure positioned in between the outer cover and the bodyside liner. The chassis includes a front
20 region and a back region that define a waist opening therebetween opposite two leg openings.

A pair of opposing fastening devices associated with a pair of corresponding elastic side panels are joined to opposing longitudinal edges of the chassis adjacent the waist opening. The fastening devices are configured to secure the
25 article around the waist of a wearer. In many applications, the elastic side panels are attached to the back region of the chassis and are configured to wrap around towards the front of a user. In this regard, the fastening devices are configured to be secured to the front region of the chassis. The fastening device, for instance, may be either a hook material or a loop material of a hook and loop fastener or
30 may comprise an adhesive that secures to an adhesive receptive landing zone located on the front region of the chassis. The fastening device may be located directly on the elastic side panels. Alternatively, the fastening device may

comprise a nonextendable material that is attached to an edge of a corresponding elastic side panel.

The absorbent article further defines an elastic waist region that is laterally aligned with the elastic side panels. In one embodiment, the waist region has an elongation that is within 25% of the elongation of the elastic side panels when the waist region and the side panels are placed under a lateral force ranging from about 300 g to about 1400 g, such as from about 300 g to about 1000 g and, in one embodiment, from about 300 g to about 700 g. The elastic side panels and the waist region each have an elongation of at least 10% when placed under a lateral force of 500 g.

In other embodiments, the waist region has an elongation that is within 15%, particularly within 10%, and in one embodiment, within 5% of the elongation of the elastic side panels when both components are placed under a lateral force as described above.

In the above embodiment, the elastic side panels and the waist region of the absorbent article are designed to have a matching elongation. In an alternative embodiment, however, the waist region and the side panels may have a matching displacement when placed under a given load. For example, the waist region may undergo a displacement that is within 25% of the total displacement of both elastic side panels when the waist region and the elastic side panels are placed under a lateral force ranging from about 300 g to about 1400 g, such as from about 300 g to about 1000 g, and, in one embodiment, from about 300 g to about 700 g. The elastic side panels and the waist region may each have a displacement of at least 10 millimeters when placed under a lateral force of 500 g.

In other embodiments, the waist region may undergo a displacement that is within 15%, particularly within 10%, and in one embodiment, within 5% of the total displacement of the elastic side panels when placed under a lateral force as described above.

In general, the waist region that is laterally aligned with the elastic side panels traverses across the chassis of the absorbent article. The stretch properties of the waist region may be derived completely from the chassis. For instance, the chassis may be made from a stretchable outer cover and/or a stretchable liner in a manner that produces the desired stretch characteristics.

Alternatively, a waist elastic member may be incorporated into or otherwise secured to the chassis to provide the desired stretch properties in conjunction with the elastic side panels.

5 The elastic side panels can be made from any suitable elastic material. For instance, the elastic side panels may be made from a film or from an elastic nonwoven or elastic laminate. In one particular embodiment, for instance, the elastic side panels are made from a neck-bonded laminate.

Other features and aspects of the present invention are discussed in greater detail below.

10

Brief Description of the Drawings

A full and enabling disclosure of the present invention, including the best mode thereof to one skilled in the art, is set forth more particularly in the remainder of the specification, including reference to the accompanying figures, in which:

15 Figure 1 is a rear perspective view of one embodiment of an absorbent article made in accordance with the present invention;

Figure 2 is a front perspective view of the absorbent article illustrated in Figure 1;

20 Figure 3 is a plan view of the absorbent article shown in Figure 1 with the article in an unfastened, unfolded and laid flat condition showing the surface of the article that faces away from the wearer;

Figure 4 is a plan view similar to Figure 3 showing the surface of the absorbent article that faces the wearer when worn and with portions cut away to show underlying features;

25 Figure 5 is a rear perspective view of another embodiment of an absorbent article made in accordance with the present invention; and

Figures 6 and 7 are plan views of portions of an absorbent article and is provided for illustrating a manner in which the stretch properties of an article may be determined.

30 Repeated use of reference characters in the present specification and drawings is intended to represent the same or analogous features or elements of the present invention.

Detailed Description

It is to be understood by one of ordinary skill in the art that the present discussion is a description of exemplary embodiments only, and is not intended as limiting the broader aspects of the present invention.

5 In general, the present invention is directed to absorbent articles, such as
diapers, that contain a multi-component waistband with carefully controlled stretch
properties. In particular, the products include a chassis having a front region and a
back region that define a waist opening therebetween. The articles further include
a crotch region positioned between the front and back region in the longitudinal
10 direction and between a pair of leg openings in the lateral direction. Adjacent to
the waist opening, the absorbent articles further include a pair of opposing elastic
side panels, which, in some embodiments, may appear as elastic ears. The side
panels may be attached to the chassis along a pair of opposing longitudinal edges.
Alternatively, the side panels may be integrally formed with the chassis. A
15 fastening device is located on or attached to each of the side panels.

 When the articles are donned by a wearer, the side panels are extended
around the waist of a wearer and the fastening devices are secured. For instance,
in one embodiment, the elastic side panels are connected to the back region of the
chassis and are extended over the front region of the chassis to secure the article
20 in place on a wearer. Alternatively, the side panels may be attached to the front
region of the chassis and are stretched around to the back of the chassis and
secured in place.

 The portion of the absorbent article that is laterally aligned with the elastic
side panels comprises a waist region of the article. The waist region may be made
25 up of the chassis itself or may include the chassis connected to one or more
auxiliary elastic components. The side panels and the waist region of the article
form a waistband. In accordance with the present invention, even though the
waistband is made from multiple components, the waistband extends and
contracts as a single piece of material. In particular, according to the present
30 invention, the stretch properties of the elastic side panels are substantially
matched with the stretch properties of the waist region of the article. In this
manner, the entire waistband is perceived as a single piece of material providing
the correct amount of stretch around the waist of the user. Ultimately, absorbent

articles made in accordance with the present invention have an improved fit and allow for a relatively large range of sizes to use the article. Absorbent articles made in accordance with the present invention are also comfortable to wear and easily conform to the dimensions of a person's torso.

5 The manner in which the stretch properties of the elastic side panels are matched with the stretch properties of the waist region of the article may depend on various circumstances and the desired result. For instance, in one embodiment, the elongation of the side panels may be substantially matched with the elongation of the waist region for a given force range. In an alternative
10 embodiment, however, the displacement that the side panels undergo over a given force range may be substantially matched with the amount of displacement that occurs in the waist region for the same range of forces. When the percent elongation of the side panels and the waist region are substantially the same, the two components have a similar elastic modulus individually. In the second case
15 when the displacement of the components are substantially matched, the elastic modulus is varied in the components in order to have substantially the same displacement.

 The range of forces over which the stretch properties of the side panels are matched with the stretch properties of the waist region can vary depending upon
20 the particular absorbent article being produced and its end use. In general, however, the stretch properties of both the side panels and the waist region may be matched over a force range of from about 300 g to about 1400 g, and particularly from about 300 g to about 1000 g. In one embodiment, for instance, the stretch properties may be matched over a range of forces of from about 300 g
25 to about 700 g. In an alternative embodiment, especially for adult products, the stretch properties of the side panels and the waist region may be matched over a force range of from about 800 g to about 4000 g. Waistbands on absorbent articles are typically exposed to forces within the above ranges.

 How closely the stretch properties of the waist region and the stretch
30 properties of the elastic side panels are matched may also vary depending upon the particular application. In general, the percent elongation of the waist region or the displacement of the waist region for a given force may be within about 25%, such as within about 15%, of the percent elongation or the displacement of the

side panels over the same range of forces. For example, in one embodiment, the waist region may have a percent elongation or a displacement that is within about 10% or even within about 5% of the percent elongation or the displacement of the elastic side panels when the waist region and the side panels are placed under the same range of forces.

In general, the absorbent articles are made with extendable and/or elastic materials. As used herein, the term "extendable" refers to a material that may be extensible and/or elastic (or elastomeric). That is, the material may be extended, deformed or the like, without breaking, and may or may not significantly retract after removal of an extending force. The terms "elastic" or "elastomeric" are used interchangeably herein and refer to a property of a material where upon removal of an elongating force, the material is capable of recovering to substantially its unstretched size and shape or the material exhibits a significant retractive force. The term "extensible" refers to a property of a material where upon removal of an elongating force, the material experiences a substantially permanent deformation or the material does not exhibit a significant retractive force. In particular, elastic materials utilized in connection with the present invention may be elongated/extended or stretched in at least one direction without breaking by at least 15%, such as by at least 25% (to at least 125% of its initial unstretched length) in at least one direction, suitably by at least 50% (to at least 150% of its initial unstretched length) and which will recover, upon release of the applied stretching or biasing force, at least 10% of their elongation. It is generally advantageous that the elastomeric material or composite be capable of being elongated by at least 100%, more desirably at least 200%, of its relaxed length and recover at least 30% and more desirably 50% of its elongation upon release of a stretching, biasing force, within about one minute.

Referring to **Figs. 1 and 2**, for exemplary purposes, an absorbent article **20** that may be made in accordance with the present invention is shown. The absorbent article **20** may or may not be disposable, which refers to articles that are intended to be discarded after a limited period of use instead of being laundered or otherwise conditioned for reuse. It is understood that the present invention is suitable for use with various other absorbent articles intended for personal wear, including but not limited to diapers, feminine hygiene products, incontinence

products, medical garments, surgical pads and bandages, other personal care or health care garments, and the like without departing from the scope of the present invention.

By way of illustration only, various materials and methods for constructing
5 absorbent articles such as the diaper **20** of the various aspects of the present invention are disclosed in PCT Patent Application WO 00/37009 published June 29, 2000 by A. Fletcher et al; U.S. Patent 4,940,464 issued July 10, 1990 to Van Gompel et al.; U.S. Patent 5,766,389 issued June 16, 1998 to Brandon et al., and U.S. Patent 6,645,190 issued November 11, 2003 to Olson et al. which are
10 incorporated herein by reference to the extent they are consistent (i.e., not in conflict) herewith.

A diaper **20** is representatively illustrated in **Fig. 1** in a partially fastened condition. The diaper **20** shown in **Figs. 1** and **2** is also represented in **Figs. 3** and **4** in an opened and unfolded state. Specifically, **Fig. 3** is a plan view illustrating
15 the exterior side of the diaper **20**, while **Fig. 4** illustrates the interior side of the diaper **20**. As shown in **Figs. 3** and **4**, the diaper **20** defines a longitudinal direction **48** that extends from the front of the article when worn to the back of the article. Opposite to the longitudinal direction **48** is a lateral direction **49**.

The diaper **20** defines a pair of longitudinal end regions, otherwise referred
20 to herein as a front region **22** and a back region **24**, and a center region, otherwise referred to herein as a crotch region **26**, extending longitudinally between and interconnecting the front and back regions **22**, **24**. The diaper **20** also defines an inner surface **28** adapted in use (e.g., positioned relative to the other components of the article **20**) to be disposed toward the wearer, and an outer surface **30**
25 opposite the inner surface. The front and back regions **22**, **24** are those portions of the diaper **20**, which when worn, wholly or partially cover or encircle the waist or mid-lower torso of the wearer. The crotch region **26** generally is that portion of the diaper **20** which, when worn, is positioned between the legs of the wearer and covers the lower torso and crotch of the wearer. The absorbent article **20** has a
30 pair of laterally opposite side edges **36** and a pair of longitudinally opposite waist edges, respectively designated front waist edge **38** and back waist edge **39**.

The illustrated diaper **20** includes a chassis **32**, that, in this embodiment, encompasses the front region **22**, the back region **24**, and the crotch region **26**.

Referring to **Figs. 1-4**, the chassis **32** includes an outer cover **40** and a bodyside liner **42** (**Figs. 1** and **4**) that may be joined to the outer cover **40** in a superimposed relation therewith by adhesives, ultrasonic bonds, thermal bonds or other conventional techniques. Referring to **Fig. 4**, the liner **42** may suitably be joined to the outer cover **40** along the perimeter of the chassis **32** to form a front waist seam **62** and a back waist seam **64**. As shown in **Fig. 4**, the liner **42** may suitably be joined to the outer cover **40** to form a pair of side seams **61** in the front region **22** and the back region **24**. The liner **42** can be generally adapted, i.e., positioned relative to the other components of the article **20**, to be disposed toward the wearer's skin during wear of the absorbent article. The chassis **32** may further include an absorbent structure **44** particularly shown in **Fig. 4** disposed between the outer cover **40** and the bodyside liner **42** for absorbing liquid body exudates exuded by the wearer, and may further include a pair of containment flaps **46** secured to the bodyside liner **42** for inhibiting the lateral flow of body exudates.

The elasticized containment flaps **46** as shown in **Fig. 4** define a partially unattached edge which assumes an upright configuration in at least the crotch region **26** of the diaper **20** to form a seal against the wearer's body. The containment flaps **46** can extend longitudinally along the entire length of the chassis **32** or may extend only partially along the length of the chassis. Suitable constructions and arrangements for the containment flaps **46** are generally well known to those skilled in the art and are described in U.S. Patent 4,704,116 issued November 3, 1987 to Enloe, which is incorporated herein by reference.

To further enhance containment and/or absorption of body exudates, the diaper **20** may also suitably include leg elastic members **58** (**Fig. 4**), as are known to those skilled in the art. The leg elastic members **58** can be operatively joined to the outer cover **40** and/or the bodyside liner **42** and positioned in the crotch region **26** of the absorbent article **20**.

The leg elastic members **58** can be formed of any suitable elastic material. As is well known to those skilled in the art, suitable elastic materials include sheets, strands or ribbons of natural rubber, synthetic rubber, or thermoplastic elastomeric polymers. The elastic materials can be stretched and adhered to a substrate, adhered to a gathered substrate, or adhered to a substrate and then elasticized or shrunk, for example with the application of heat, such that elastic

retractive forces are imparted to the substrate. In one particular aspect, for example, the leg elastic members **58** may include a plurality of dry-spun coalesced multifilament spandex elastomeric threads sold under the trade name LYCRA and available from Invista, Wilmington, Delaware, U.S.A.

5 In some embodiments, the absorbent article **20** may further include a surge management layer (not shown) which may be optionally located adjacent the absorbent structure **44** and attached to various components in the article **20** such as the absorbent structure **44** or the bodyside liner **42** by methods known in the art, such as by using an adhesive. A surge management layer helps to decelerate and diffuse surges or gushes of liquid that may be rapidly introduced into the
10 absorbent structure of the article. Desirably, the surge management layer can rapidly accept and temporarily hold the liquid prior to releasing the liquid into the storage or retention portions of the absorbent structure. Examples of suitable surge management layers are described in U.S. Pat. No. 5,486,166; and U.S. Pat.
15 No. 5,490,846. Other suitable surge management materials are described in U.S. Pat. No. 5,820,973. The entire disclosures of these patents are hereby incorporated by reference herein to the extent they are consistent (i.e., not in conflict) herewith.

As shown in **Figs. 1-4**, the absorbent article **20** further includes a pair of
20 opposing elastic side panels **34** that are attached to the back region of the chassis **32**. As shown particularly in **Figs. 1** and **2**, the side panels **32** may be stretched around the waist and/or hips of a wearer in order to secure the garment in place. As shown in **Figs. 3** and **4**, the elastic side panels are attached to the chassis along a pair of opposing longitudinal edges **37**. The side panels **34** may be
25 attached or bonded to the chassis **32** using any suitable bonding technique. For instance, the side panels **34** may be joined to the chassis by adhesives, ultrasonic bonds, thermal bonds, or other conventional techniques.

In an alternative embodiment, the elastic side panels may also be integrally formed with the chassis **32**. For instance, the side panels **34** may comprise an
30 extension of the bodyside liner **42**, of the outer cover **40**, or of both the bodyside liner **42** and the outer cover **40**.

In the embodiments shown in the figures, the side panels **34** are connected to the back region of the absorbent article **20** and extend over the front region of

the article when securing the article in place on a user. It should be understood, however, that the side panels **34** may alternatively be connected to the front region of the article **20** and extend over the back region when the article is donned.

5 With the absorbent article **20** in the fastened position as partially illustrated in **Figs. 1** and **2**, the elastic side panels **34** may be connected by a fastening system **80** to define a 3-dimensional diaper configuration having a waist opening **50** and a pair of leg openings **52**. The waist opening **50** of the article **20** is defined by the waist edges **38** and **39** which encircle the waist of the wearer.

10 In the embodiments shown in the figures, the side panels are releasably attachable to the front region **22** of the article **20** by the fastening system. It should be understood, however, that in other embodiments the side panels may be permanently joined to the chassis **32** at each end.

The elastic side panels **34** each have a longitudinal outer edge **68**, a leg end edge **70** disposed toward the longitudinal center of the diaper **20**, and waist end edges **72** disposed toward a longitudinal end of the absorbent article. The leg end edges **70** of the absorbent article **20** may be suitably curved and/or angled relative to the lateral direction **49** to provide a better fit around the wearer's legs. However, it is understood that only one of the leg end edges **70** may be curved or angled, such as the leg end edge of the back region **24**, or alternatively, neither of the leg end edges may be curved or angled, without departing from the scope of the present invention. As shown in **Fig. 4**, the outer edges **68** are generally parallel to the longitudinal direction **48** while the waist end edges **72** are generally parallel to the transverse axis **49**. It should be understood, however, that in other embodiments the outer edges **68** and/or the waist edges **72** may be slanted or curved as desired. Ultimately, the side panels **34** are generally aligned with a waist region of the chassis.

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The fastening system **80** may include laterally opposite first fastening components **82** adapted for refastenable engagement to corresponding second fastening components **84**. In the embodiment shown in the figures, the first fastening component **82** is located on the elastic side panels **34**, while the second fastening component **84** is located on the front region **22** of the chassis **32**. In one aspect, a front or outer surface of each of the fastening components **82**, **84** includes a plurality of engaging elements. The engaging elements of the first

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fastening components **82** are adapted to repeatedly engage and disengage corresponding engaging elements of the second fastening components **84** to releasably secure the article **20** in its three-dimensional configuration.

The fastening components **82**, **84** may be any refastenable fasteners
5 suitable for absorbent articles, such as adhesive fasteners, cohesive fasteners, mechanical fasteners, or the like. In particular aspects the fastening components include mechanical fastening elements for improved performance. Suitable mechanical fastening elements can be provided by interlocking geometric shaped materials, such as hooks, loops, bulbs, mushrooms, arrowheads, balls on stems,
10 male and female mating components, buckles, snaps, or the like.

In the illustrated aspect, the first fastening components **82** include hook fasteners and the second fastening components **84** include complementary loop fasteners. Alternatively, the first fastening components **82** may include loop fasteners and the second fastening components **84** may be complementary hook
15 fasteners. In another aspect, the fastening components **82**, **84** can be interlocking similar surface fasteners, or adhesive and cohesive fastening elements such as an adhesive fastener and an adhesive-receptive landing zone or material; or the like. One skilled in the art will recognize that the shape, density and polymer composition of the hooks and loops may be selected to obtain the desired level of
20 engagement between the fastening components **82**, **84**. Suitable fastening systems are also disclosed in the previously incorporated PCT Patent Application WO 00/37009 published June 29, 2000 by A. Fletcher et al. and the previously incorporated U.S. Patent 6,645,190 issued November 11, 2003 to Olson et al.

In the embodiment shown in the figures, the fastening components **82** are
25 attached to the side panels **34** along the edges **68**. In this embodiment, the fastening components **82** are not elastic or extendable. In other embodiments, however, the fastening components may be integral with the side panels **34**. For example, the fastening components may be directly attached to the side panels **34** on a surface thereof.

30 As described above, the present invention is particularly directed to absorbent articles having controlled and uniform stretch properties along the entire length of a waistband that extends from the outer edge of the first elastic side panel **34** to the outer edge of the second elastic side panel **34**. The side panels **34**

are elastic and extend in the lateral direction when the article is worn about a wearer. In addition to the side panels **34**, the absorbent article **20** includes an elastic waist region generally **90** as particularly shown in **Figs. 1, 3 and 4** that is generally laterally aligned with the side panels **34** that traverses across the chassis

5 **32**. In the past, absorbent articles have been made with elastic side panels that have elastic properties much different than the waist region of the article. In order to improve fit and comfort, however, the present invention is directed to substantially matching the stretch properties of the elastic side panels **32** with the stretch properties of the waist region **90**.

10 In one embodiment, for instance, the percent elongation of the side panels **34** over a particular range of forces is similar to or substantially equal to the percent elongation of the waist region **90** over the same range. For example, the absorbent article **20** may be constructed such that the waist region has an elongation that is within 25% of the elongation of the elastic side panels when the

15 waist region and the side panels are placed under a lateral force ranging from about 300 g to about 700 g, such as from about 300 g to about 1000 g, and, in one embodiment, from about 300 g to about 1400 g. In other embodiments, the elongation of the waist region within the above range of forces may be within about 15%, such as within about 10%, and even within about 5% of the elongation of the

20 elastic side panels. As used herein, the above comparisons are made between the waist region **90** and both side panels together **34**.

By matching the stretch characteristics of the side panels in the waist region, strain is distributed uniformly over the entire waistband for improving the fit of the article.

25 In an alternative embodiment of the present invention, instead of matching percent elongation, the displacement of the waist region **90** substantially matches the total displacement of both side panels **34** over a given range of forces. In particular, the present inventors have discovered that in some embodiments it may be more desirable to match percent elongation, while in other embodiments, it may

30 be more desirable to match total displacement. When matching displacement, for instance, the waist region undergoes a displacement that is within 25% of the total displacement of both elastic side panels when the waist region and the elastic side panels are placed under a lateral force ranging, for instance, from about 300 g to

about 700 g, particularly from about 300 g to about 1000 g, and, in one embodiment, from about 300 g to about 1400 g. In an alternative embodiment, the range of forces may be from about 800 g to about 4000 g, such as when producing articles to be worn by adults. In various embodiments, the waist region may
5 undergo a displacement that is within 15%, such as within 10%, and even within 5% of the total displacement of both elastic side panels under a given force range.

The materials used to construct the elastic side panels and the elastic waist region of the article may vary dramatically depending upon the particular application. In general, any suitable elastic material may be used in the absorbent
10 article as long as the stretch characteristics of the side panels can be matched with the stretch characteristics of the waist region as described above. In general, the waist region and both side panels will have an elongation of at least 10% when placed under a lateral force of 500 g, such as at least 15%, and, in one embodiment, may have an elongation of at least 20% when placed under a force
15 of 500 g. When placed under a force of about 500 g, both side panels and the waist region should also undergo a displacement of at least 10 millimeters, such as at least 15 millimeters for many applications.

Suitable elastic materials that may be used to construct the opposing side panels **34** are described in the following U.S. Patents: 4,940,464 issued July 10,
20 1990 to Van Gompel et al.; 5,224,405 issued July 6, 1993 to Pohjola; 5,104,116 issued April 14, 1992 to Pohjola; and 5,046,272 issued September 10, 1991 to Vogt et al.; all of which are incorporated herein by reference. In particular aspects, the elastic material may include a stretch-thermal laminate (STL), a neck-bonded laminate (NBL), a reversibly-necked laminate, or a stretch-bonded laminate (SBL)
25 material. Methods of making such materials are well known to those skilled in the art and described in U.S. Patent 4,663,220 issued May 5, 1987 to Wisneski et al.; U.S. Patent 5,226,992 issued July 13, 1993 to Morman; European Patent Application No. EP 0 217 032 published on April 8, 1987 in the name of Taylor et al.; and PCT application WO 01/88245 in the name of Welch et al.; all of which are
30 incorporated herein by reference to the extent that they are consistent (i.e., not in conflict) herewith. Alternatively, the side panel material may include other woven or non-woven materials, such as those described later herein as being suitable for

construction of the outer cover **40** and/or the bodyside liner **42**; mechanically pre-stretched composites; or stretchable but inelastic materials.

“Neck-bonded” laminate refers to a composite material having an elastic member that is bonded to a non-extensible member while the non-elastomeric
5 member is extended in the machine direction creating a necked material that is elastic in the cross-direction. Examples of neck-bonded laminates are disclosed in U.S. Pat. Nos. 4,965,122; 4,981,747; 5,226,992; and 5,336,545, which are incorporated herein by reference in their entirety for all purposes.

“Reversibly-necked material” refers to a necked material that has been
10 treated while necked to impart memory to the material so that when force is applied to extend the material to its pre-necked dimensions, the necked and treated portions will generally recover to their necked dimensions upon termination of the force. A reversibly-necked material may include more than one layer. For example, multiple layers of spunbonded web, multiple layers of meltblown web,
15 multiple layers of bonded carded web or any other suitable combination of mixtures thereof. The production of reversibly-necked materials is described in U.S. Pat. Nos. 4,965,122 and 4,981,747, incorporated herein by reference for all purposes.

“Stretch-bonded” laminate refers to a composite material having at least two
20 layers in which one layer is a gatherable layer and the other layer is an elastic layer. The layers are joined together when the elastic layer is in an extended condition so that upon relaxing the layers, the gatherable layer is gathered. For example, one elastic member can be bonded to another member while the elastic member is extended at least about 25% of its relaxed length. Such a multilayer
25 composite elastic material may be stretched until the non-extensible layer is fully extended. Examples of stretch-bonded laminates are disclosed, for example, in U.S. Patent Nos. 4,720,415, 4,789,699, 4,781,966, 4,657,802, and 4,655,760, which are incorporated herein by reference in their entirety for all purposes.

“Neck stretch-bonded” laminate” refers to a laminate made from the
30 combination of a neck-bonded laminate and a stretch-bonded laminate. Examples of necked stretch bonded laminates are disclosed in U.S. Patent Nos. 5,114,781 and 5,116,662, which are incorporated herein in their entirety by reference thereto

for all purposes. Of particular advantage, a necked stretch bonded laminate can be stretchable in both the machine and cross-machine directions.

In one particular embodiment, the elastic side panels or the chassis materials may comprise an elastic laminate, such as a neck-bonded laminate that may after formation be fed through a series of grooved rolls that have grooves in the cross machine direction. The grooved rolls, for instance, may increase the softness of the product.

The groove roll arrangement may be single rolls immediately adjacent one another such that the peaks of one roll lie in the valleys of an adjacent roll, or alternatively, they may be a single or main anvil roll that is encircled by smaller satellite rolls.

Similar to the elastic side panels **34**, the waist region **90** of the absorbent article **20** can also be made from various different materials. The waist region **90**, in many embodiments, at least contains portions of the outer cover **40**, the inner liner **42**, and possibly a portion of the absorbent structure **44**. In addition, the waist region **90** can contain various elastic auxiliary components in order to control the stretch properties of the waist region. For instance, in the embodiment shown in **Figs. 1-4**, the waist region **90** includes a waist elastic member **56** that is attached to the chassis **32**. The waist elastic member **56**, for instance, can be made from any of the materials described above. As shown in **Fig. 1**, the absorbent article **20** can include not only a back waist elastic member **56**, but also a front waist elastic member **54**. When present, the front waist elastic member **54** may constitute another extendable and elastic transverse section of the article.

In an alternative embodiment as shown in **Fig. 4**, the waist region **90** is comprised essentially of the chassis **32** and does not contain any auxiliary elastic components. In this embodiment, the stretch properties of the waist region **90** reside primarily in the outer cover **40** and the inner liner **42**.

In many applications, the chassis **32** within the waist region **90** is at least extendable. Various auxiliary elastic components may then be incorporated into the chassis, such as waist elastic member **56**, in order to make the waist region **90** elastic. In addition to being extendable, the chassis **32** may also be elastic such as in the embodiment shown in **Fig. 5**. For the chassis **32** to be elastic, the outer cover **40** may be elastic while the inner liner **42** may be extendable, the outer

cover **40** may be extendable and the inner liner **42** may be elastic, or both the outer cover **40** and the inner liner **42** may be made from elastic materials. In still other embodiments, the absorbent structure **44** may be elastic and extend into the waist region **90**.

5 Thus, the outer cover **40**, the inner liner **42** and the absorbent structure **44** may be made from many different materials depending upon the particular application and the desired result. All three layers, for instance, may be extendable and/or elastic. Further, the stretch properties of each layer may vary in order to control the overall stretch properties of the product.

10 The outer cover **40**, for instance, may be breathable and/or may be liquid impermeable. The outer cover **40** may be constructed of a single layer, multiple layers, laminates, spunbond fabrics, films, meltblown fabrics, elastic netting, microporous webs, bonded card webs or foams provided by elastomeric or polymeric materials. The outer cover **40**, for instance, can be a single layer of a
15 liquid impermeable material, or alternatively can be a multi-layered laminate structure in which at least one of the layers is liquid impermeable. In other embodiments, however, it should be understood that the outer cover may be liquid permeable. In this embodiment, for instance, the absorbent article may contain an interior liquid barrier layer.

20 For instance, the outer cover **40** can include a liquid permeable outer layer and a liquid impermeable inner layer that are suitably joined together by a laminate adhesive, ultrasonic bonds, thermal bonds, or the like. Suitable laminate adhesives, which can be applied continuously or intermittently as beads, a spray, parallel swirls, or the like, can be obtained from Bostik Findley Adhesives, Inc., of
25 Wauwatosa, Wisconsin, U.S.A., or from National Starch and Chemical Company, Bridgewater, New Jersey U.S.A. The liquid permeable outer layer can be any suitable material and is desirably one that provides a generally cloth-like texture. One example of such a material is a 20 gsm (grams per square meter) spunbond polypropylene nonwoven web. The outer layer may also be made of those
30 materials of which the liquid permeable bodyside liner **42** is made.

 The inner layer of the outer cover **40** can be both liquid and vapor impermeable, or it may be liquid impermeable and vapor permeable. The inner layer can be manufactured from a thin plastic film, although other flexible liquid

impermeable materials may also be used. The inner layer, or the liquid impermeable outer cover **40** when a single layer, prevents waste material from wetting articles, such as bed sheets and clothing, as well as the wearer and caregiver. A suitable liquid impermeable film for use as a liquid impermeable inner layer, or a single layer liquid impermeable outer cover **40**, is a 0.02 millimeter polyethylene film commercially available from Pliant Corporation of Schaumburg, Illinois, U.S.A.

The outer cover **40** may be extendable and optionally elastic. Elastic non-woven laminate webs that can be used as the outer cover **40** include a non-woven material joined to one or more gatherable non-woven webs, films, or foams. Stretch Bonded Laminates (SBL) and Neck Bonded Laminates (NBL) are examples of elastomeric composites. Non-woven fabrics are any web of material which has been formed without the use of textile weaving processes which produce a structure of individual fibers that are interconnected in an integrating manner.

Examples of suitable materials are spunbond-meltblown fabrics, spunbond-meltblown-spunbond fabrics, spunbond fabrics, or laminates of such fabrics with films, foams, or other nonwoven webs. Elastomeric materials may include cast or blown films, foams, meltblown fabrics or spunbond fabrics composed of polyethylene, polypropylene, or polyolefin elastomers, as well as combinations thereof. The elastomeric materials may include PEBAX elastomer (available from AtoChem located in Philadelphia, Pa.), HYTREL elastomeric polyester (available from Invista of Wilmington, Del.), KRATON elastomer (available from Kraton Polymers of Houston, Tex.), or strands of LYCRA elastomer (available from Invista of Wilmington, Del.), or the like, as well as combinations thereof. The outer cover **40** may include materials that have elastomeric properties through a mechanical process, printing process, heating process, or chemical treatment. For examples such materials may be apertured, creped, neck-stretched, heat activated, embossed, and micro-strained; and may be in the form of films, webs, and laminates.

In particular aspects of the invention, the outer cover **40** may include a 0.4 ounces per square yard (osy) (13.6 grams per square meter (gsm)) basis weight layer of G2760 KRATON elastomer strands adhesively laminated with a 0.3 gsm

layer of adhesive between two facings. Each facing can be composed of a thermal point bonded bicomponent spunbond non-woven fibrous web having a 0.7 osy (23.7 gsm) basis weight. The adhesive is similar to an adhesive which is supplied by Bostik Findley Adhesive and designated as H2525 A, and the elastomer strands are placed and distributed to provide approximately 12 strands of KRATON elastomer per inch (2.54 cm) of lateral width of the outer cover **40**.

Alternatively, the outer cover **40** may include a woven or non-woven fibrous web layer which has been totally or partially constructed or treated to impart the desired levels of liquid impermeability to selected regions that are adjacent or proximate the absorbent structure. For example, the outer cover **40** may include a gas-permeable, non-woven fabric layer laminated to a polymer film layer which may or may not be gas-permeable. Other examples of fibrous, cloth-like outer cover **40** materials can include a stretch thinned or stretch thermal laminate material composed of a 0.6 mil (0.015 mm) thick polypropylene blown film and a 0.7 osy (23.8 gsm) polypropylene spunbond material (2 denier fibers).

Suitable materials for a biaxially stretchable outer cover **40** include biaxially stretchable material and biaxially elastic stretchable material. One example of a suitable outer cover material can include a 0.3 osy (10.2 gsm) polypropylene spunbond that is necked 60% in the lateral direction **49** and creped 60% in the longitudinal direction **48**, laminated with 3 grams per square meter (gsm) Findley 2525A styrene-isoprene-styrene based adhesive to 8 gsm PEBAX 2533 film with 20% TiO₂ concentrate. The outer cover **40** can suitably be stretched, laterally and/or longitudinally, by at least 30% (to at least 130% of an initial (unstretched) width and/or length of the outer cover **40**). More suitably, the outer cover **40** can be stretched laterally and/or longitudinally, by at least 50% (to at least 150% of the unstretched width or length of the outer cover **40**). Even more suitably, the outer cover **40** can be stretched, laterally and/or longitudinally, by at least 100% (to at least 200% of the unstretched width or length of the outer cover **40**). Tension force in the outer cover **40** at 50% extension is suitably between 50 and 1000 grams, more suitably between 100 and 600 grams, as measured on a 3 inch (7.62 cm) wide piece of the outer cover material.

Another example of a suitable material for a biaxially stretchable outer cover **40** is a breathable elastic film/nonwoven laminate, described in U.S. Patent No.

5,883,028, issued to Morman et al., incorporated herein by reference to the extent that it is consistent (i.e. not in conflict) herewith. Examples of materials having two-way stretchability and retractability are disclosed in U.S. Patent No. 5,116,662 issued to Morman and U.S. Patent No. 5,114,781 issued to Morman, both of which
5 are hereby incorporated herein by reference to the extent that it is consistent (i.e., not in conflict) herewith. These two patents describe composite elastic materials capable of stretching in at least two directions. The materials have at least one elastic sheet and at least one necked material, or reversibly necked material, joined to the elastic sheet at least at three locations arranged in a nonlinear
10 configuration, so that the necked, or reversibly necked, web is gathered between at least two of those locations.

In another embodiment, the outer cover **40** is made by adhesively laminating a facing material, such as a nonwoven web, to an extendable film followed by slit necking the material.

15 The bodyside liner **42** is suitably compliant, soft-feeling, and non-irritating to the wearer's skin. The bodyside liner **42** is also sufficiently liquid permeable to permit liquid body exudates to readily penetrate through its thickness to the absorbent structure **44**. A suitable bodyside liner **42** may be manufactured from a wide selection of web materials, such as porous foams, reticulated foams,
20 apertured plastic films, woven and non-woven webs, or a combination of any such materials. For example, the bodyside liner **42** may include a meltblown web, a spunbonded web, or a bonded-carded-web composed of natural fibers, synthetic fibers or combinations thereof. The bodyside liner **42** may be composed of a substantially hydrophobic material, and the hydrophobic material may optionally be
25 treated with a surfactant or otherwise processed to impart a desired level of wettability and hydrophilicity.

The bodyside liner **42** may also be stretchable, and more suitably it may be elastomeric. Suitable elastomeric materials for construction of the bodyside liner **42** can include elastic strands, LYCRA elastics, cast or blown elastic films,
30 nonwoven elastic webs, meltblown or spunbond elastomeric fibrous webs, as well as combinations thereof. Examples of suitable elastomeric materials include KRATON elastomers, HYTREL elastomers, ESTANE elastomeric polyurethanes (available from Noveon of Cleveland, Ohio), or PEBAX elastomers.

As an additional example, in one aspect the bodyside liner **42** suitably includes a non-woven, spunbond polypropylene fabric composed of about 2 to 3 denier fibers formed into a web having a basis weight of about 12 gsm which is necked approximately 60 percent. Strands of about 9 gsm KRATON G2760 elastomer material placed eight strands per inch (2.54 cm) are adhered to the necked spunbond material. The fabric is surface treated with an operative amount of surfactant, such as about 0.6 percent AHCOVEL Base N62 surfactant, available from ICI Americas, a business having offices in Wilmington, Del., U.S.A. The surfactant can be applied by any conventional means, such as spraying, printing, brush coating or the like. Other suitable materials may be extensible biaxially stretchable materials, such as a neck stretched/creped spunbond. The bodyside liner **42** can also be made from extensible materials as are described in U.S. Patent Application Serial No. 09/563,417 filed on May 3, 2000 by Roessler et al. The bodyside liner **42** can also be made from biaxially stretchable materials as are described in U.S. Patent Application Serial No. 09/698,512 filed on October 27, 2000 by Vukos et al.

The liner **42** can suitably be stretched, laterally and/or longitudinally, by at least 30% (to at least 130% of an initial (unstretched) width and/or length of the liner **42**). More suitably, the liner **42** can be stretched laterally and/or longitudinally, by at least 50% (to at least 150% of the unstretched width or length of the liner **42**). In some embodiments, the liner **42** can even be stretched, laterally and/or longitudinally, by at least 100% (to at least 200% of the unstretched width or length of the liner **42**). Tension force in the liner **42** at 50% extension is suitably between 50 and 4000 grams, more suitably between 100 and 2000 grams, as measured on a 3 inch (7.62 cm) wide piece of the liner material.

The absorbent structure **44** may be disposed between the outer cover **40** and the bodyside liner **42**. The absorbent structure **44** can be any structure or combination of components which are generally compressible, conformable, non-irritating to a wearer's skin, and capable of absorbing and retaining liquids and certain body wastes. For example, the absorbent structure **44** may include an absorbent web material of cellulosic fibers (e.g., wood pulp fibers), other natural fibers, synthetic fibers, woven or nonwoven sheets, scrim netting or other stabilizing structures, superabsorbent material, binder materials, surfactants,

selected hydrophobic materials, pigments, lotions, odor control agents or the like, as well as combinations thereof. In a particular aspect, the absorbent web material is a matrix of cellulosic fluff and superabsorbent hydrogel-forming particles. The cellulosic fluff may include a blend of wood pulp fluff. One preferred type of fluff is
5 identified with the trade designation CR 1654, available from Bowater of Greenville, South Carolina, USA, and is a bleached, highly absorbent sulfate wood pulp containing primarily southern soft wood fibers. The absorbent materials may be formed into a web structure by employing various conventional methods and techniques. For example, the absorbent web may be formed with a dry-forming
10 technique, an air forming technique, a wet-forming technique, a foam-forming technique, or the like, as well as combinations thereof. Methods and apparatus for carrying out such techniques are well known in the art. Furthermore, the absorbent structure may itself encompass multiple layers in the Z direction. Such multiple layers may take advantage of differences in absorbency capacity, such as
15 by placing a lower capacity absorbent material layer closer to the liner **42** and a higher capacity absorbent material closer to the outer cover layer **40**. Likewise, discrete portions of an absorbent single-layered structure may encompass higher capacity absorbents, and other discrete portions of the structure may encompass lower capacity absorbents.

20 As a general rule, the superabsorbent material is present in the absorbent web in an amount of from about 0 to about 90 weight percent based on total weight of the web. The web may have a density within the range of about 0.10 to about 0.60 grams per cubic centimeter.

Superabsorbent materials are well known in the art and can be selected
25 from natural, synthetic, and modified natural polymers and materials. The superabsorbent materials can be inorganic materials, such as silica gels, or organic compounds, such as crosslinked polymers. Typically, a superabsorbent material is capable of absorbing at least about 10 times its weight in liquid, and desirably is capable of absorbing more than about 25 times its weight in liquid.
30 Suitable superabsorbent materials are readily available from various suppliers. For example, SXM 9394, and Favor 9543 superabsorbents are available from DeGussa Superabsorbers.

After being formed or cut into a desired shape, the absorbent web material may be wrapped or encompassed by a suitable tissue or meltblown web or the like wrap sheet that aids in maintaining the integrity and shape of the absorbent structure **44**.

5 The absorbent web material may also be a coform material. The term "coform material" generally refers to composite materials comprising a mixture or stabilized matrix of thermoplastic fibers and a second non-thermoplastic material. As an example, coform materials may be made by a process in which at least one meltblown die head is arranged near a chute through which other materials are
10 added to the web while it is forming. Such other materials may include, but are not limited to, fibrous organic materials such as woody or non-woody pulp such as cotton, rayon, recycled paper, pulp fluff and also superabsorbent particles, inorganic absorbent materials, treated polymeric staple fibers and the like. Any of a variety of synthetic polymers may be utilized as the melt-spun component of the
15 coform material. For instance, in certain aspects, thermoplastic polymers can be utilized. Some examples of suitable thermoplastics that can be utilized include polyolefins, such as polyethylene, polypropylene, polybutylene and the like; polyamides; and polyesters. In one aspect, the thermoplastic polymer is polypropylene. Some examples of such coform materials are disclosed in U.S.
20 Patent Nos. 4,100,324 to Anderson, et al.; 5,284,703 to Everhart, et al.; and 5,350,624 to Georger, et al.; which are incorporated herein by reference to the extent they are consistent (i.e., not in conflict) herewith.

In a particular aspect of the absorbent article of the present invention, the absorbent structure **44** may also be elastomeric. For this purpose, the absorbent
25 web material can include elastomeric fibers in an amount which is at least a minimum of about 2 wt %. The amount of elastomeric fibers can alternatively be at least about 3 wt %, and can optionally be at least about 5 wt % to provide improved performance. In addition, the amount of elastomeric fibers can be not more than about 60 wt %. Alternatively, the amount of elastomeric fibers can be
30 not more than about 45 wt %, and optionally, can be not more than about 30 wt % to provide improved benefits. These values may impact the absorbent structure **44** by affecting the desired levels of stretchability and structural stability without excessively degrading the physical properties or the liquid-management properties

of the absorbent structure. An absorbent web material with an excessively low proportion of elastomeric fibers may be insufficiently stretchable, and a web material with an excessively high proportion of elastomeric fibers may exhibit an excessive degradation of its absorbency functionalities, such as poor intake, poor distribution, poor retention of liquid.

The absorbent structure **44** may include an elastomeric coform absorbent web material. Such materials are described for instance in US 6,231,557 B1 and 6,362,389 B1, which are each incorporated by reference herein to the extent they are consistent (i.e., not in conflict) herewith. In particular aspects, the elastomeric coform material can have an overall coform basis weight of at least about 50 gsm, such as up to about 1200 gsm. The coform basis weight, for example, may be at least about 100 gsm, such as at least about 200 gsm. These values can provide the absorbent structure with the desired stretchability and structural stability without excessively degrading the physical properties or the liquid-management functionalities of the absorbent structure. For example, retention portions having excessively low proportions of elastomeric coform material may not be sufficiently stretchable. Conversely, an absorbent web material having excessively large amounts of elastomeric coform materials can exhibit an excessive degradation of their absorbency functionalities, such as an excessive degradation of intake, distribution and/or retention properties.

Other examples of usable elastomeric absorbent bodies are described in international patent application WO 03/051254 and U.S. Patent Nos. 5,964,743, 5,645,542, 6,231,557, and 6,362,389 B1, each of which are incorporated by reference herein to the extent they are consistent (i.e., not in conflict) herewith.

25

Testing Procedures

For the purposes of the present invention, the properties, such as elongation, of a material or component can be determined by ASTM Procedure D 2433 "Standard Test Methods for Rubber Thread". Sections 20-22 of the ASTM Standard may be referred to for tensile strength testing.

30

A suitable testing device is a SINTECH constant rate of extension tensile tester (available from MTS Systems Corporation, a business having offices located in Edens Prairie, Minnesota), or an equivalent device. The tensile tester is

operatively programmed with suitable software, such as TESTWORKS software (available from MTS Systems Corporation), or an equivalent software.

In order to test absorbent articles to determine if the articles have stretch properties within the scope of the present invention, the following procedure is offered with reference to **Figs. 6** and **7**. In general, the following test procedure determines the stretch profile of a waistband of an absorbent article by measuring individual zones. For example, referring to **Fig. 6**, a portion of an absorbent article generally **20** is illustrated. In particular, shown in **Fig. 6** is a rear waistband that extends from a first side panel **34** through a middle region **90** of the article and to a second side panel **34**. As shown, the absorbent article **20** can include a waist elastic member **56** and containment flaps **46**. The article **20** further includes fastening components **82** that are not included in the test, since, in this embodiment, they are non-elastic.

In order to measure the stretch properties of the article, as shown in **Fig. 6**, the waistband is first divided into two separate zones identified as zones 1 and 2. The zones are measured and recorded in millimeters at the product's resting state. The zone 2 measurement provides the gauge length for a constant rate of extension tensile machine. The resting state measurements are taken when the waistband is laid out flat but with no tension applied.

The waistband is then placed under incremental amounts of tension. For example, in accordance with the present invention, the waistband is first placed under a lateral force of 300 g. The lateral force is then increased by, for instance, 100 g until a desired end point is reached, such as about 700 g. After each increment, each zone is measured and the data is recorded in millimeters. If done manually, it may take up to about 45 seconds to take the measurements. In other embodiments, however, the measurements may be done almost instantaneously with the use of camera.

In some embodiments, testing may continue until a force of 1400 g or greater on the article.

Based upon the above procedure, the following data may be obtained:

Amount of Force	Length of Zone 1	Length of Zone 2	Zone 2 Minus Zone 1
0 g			
300 g			
400 g			
500 g			
600 g			
700 g, etc.			

Displacement of the side panels **34** are represented by subtracting zone 2 from zone 1.

5 From the above data, percent elongation of the waist region **90** and the side panels **34** may be calculated. Percent elongation is calculated by subtracting the final length minus the initial length, dividing by the initial length, and multiplying by 100. This information can then be used to determine whether or not the elongation of the middle region **90** indicated as zone 1 is similar to the elongation of the side
10 panels **34**, which may be represented by zone 2 minus zone 1.

The above data can also be used to calculate displacement. Displacement is simply the final length minus the initial length. From this information, one can determine if the displacement of the side panels **34** substantially matches the displacement of the middle region **90** as discussed and defined herein.

15 In addition to determining the stretch characteristics of the side panels **34** in relation to the middle region **90**, the above test may also be used to determine the similarities of stretch properties between different regions of the article. For instance, referring to **Fig. 7**, the absorbent article is shown divided into more zones, namely five zones designated A, B, C, D and E. Zone A represents a zone
20 between the containment flaps, while zone B represents a zone bordered by the outer containment flap edges. Zone C, as discussed above, represents the middle region **90**. Zone D, on the other hand, is where bonding of the side panels **34** ends. Zone E represents the entire width of the waistband. By dividing the article into more zones, the elastic properties of various regions may be compared and
25 contrasted in designing products. For instance, percent elongation may be

matched between the individual regions or, alternatively, displacement may be substantially matched between the individual regions.

In calculating percent elongation or displacement for any of the zones included in **Fig. 7**, data is first collected for each zone as the amount of tension placed on the article is increased, similar to the table presented above. In order to determine percent elongation or displacement for a particular section or region of the absorbent article **20**, the data obtained from the individual zones may need to be manipulated. For instance, as described above with respect to **Fig. 6**, measurements taken with respect to zone 1 were subtracted from the measurements taken from zone 2 in order to particularly calculate percent elongation and displacement for the side panels.

These and other modifications and variations to the present invention may be practiced by those of ordinary skill in the art, without departing from the spirit and scope of the present invention, which is more particularly set forth in the appended claims. In addition, it should be understood that aspects of the various embodiments may be interchanged both in whole or in part. Furthermore, those of ordinary skill in the art will appreciate that the foregoing description is by way of example only, and is not intended to limit the invention so further described in such appended claims.

What is Claimed:

1. An absorbent article comprising:
a chassis including an outer cover comprising an extendable material, a bodyside liner joined to the outer cover in a superimposed relation, the
5 bodyside liner also comprising an extendable material, and an absorbent structure positioned in between the outer cover and the bodyside liner, the chassis including a front region and a back region that define a waist opening therebetween opposite two leg openings;
a pair of opposing fastening devices associated with a pair of
10 corresponding elastic side panels, the elastic side panels being joined to opposing longitudinal edges of the chassis adjacent to the waist opening, the fastening devices for securing the article around the waist of a wearer; and
wherein the absorbent article defines an elastic waist region that is generally aligned with the elastic side panels, and wherein either the waist region
15 has an elongation that is within 25% of the elongation of the elastic side panels when the waist region and the side panels are placed under a lateral force ranging from about 300 g to about 700 g and wherein the elastic side panels and the waist region each have an elongation of at least 10% when placed under a lateral force of 500 g, or the waist region undergoes a displacement that is within 25% of the
20 total displacement of both elastic side panels when the waist region and the elastic side panels are placed under a lateral force ranging from about 300 g to about 700 g and wherein the elastic side panels and the waist region each have a displacement of at least 10 mm when placed under a lateral force of 500 g.
2. An absorbent article as defined in claim 1, wherein the waist region has an elongation that is within 25% of the elongation of the elastic side panels when the waist region and the side panels are placed under a lateral force ranging from about 300 g to about 700 g and wherein the elastic side panels and the waist
5 region have an elongation of at least 10% when placed under a lateral force of 500g.
3. An absorbent article as defined in claims 1 or 2, wherein the waist region undergoes a displacement that is within 25% of the total displacement of both elastic side panels when the waist region and the elastic side panels are placed under a later force ranging from about 300 g to about 700 g and wherein

- 5 the elastic side panels and the waist region each have a displacement of at least 10 mm when placed under a lateral force of 500 g.
4. An absorbent article as defined in any of the preceding claims, further comprising at least one waist elastic member positioned within the waist region of the article.
5. An absorbent article as defined in any of the preceding claims, wherein the elastic side panels are joined to opposing edges of the back region of the chassis, the waist region of the absorbent article being located along the back region of the chassis.
6. An absorbent article as defined in claim 5, wherein the pair of elastic side panels are configured to extend over the front region of the chassis, the fastening devices located on the side panels being configured to attach to the front region.
7. An absorbent article as defined in any of the preceding claims, wherein the elastic side panels comprise a neck-bonded laminate.
8. An absorbent article as defined in any of the preceding claims, wherein the outer cover, bodyside liner, or both the outer cover and the bodyside liner are substantially responsible for the elongation properties of the waist region of the article.
9. An absorbent article as defined in any of the preceding claims, wherein the waist region of the absorbent article does not contain any auxiliary elastic components attached to the chassis.
10. An absorbent article as defined in any of the preceding claims, wherein the elongation of the waist region is within 15% of the elongation of the elastic side panels, such as within 10% of the elongation of the elastic side panels, when the waist region and the elastic side panels are placed under a lateral force
- 5 ranging from about 300 g to about 700 g.
11. An absorbent article as defined in any of the preceding claims, wherein the elongation of the waist region is within 5% of the elongation of the elastic side panels when the waist region and the elastic side panels are placed under a lateral force ranging from about 300 g to about 700 g.
12. An absorbent article as defined in any of the preceding claims, wherein the elongation of the waist region is within 25% of the elongation of the

elastic side panels when the waist region and the side panels are placed under a lateral force ranging from about 300 g to about 1000 g.

13. An absorbent article as defined in any of the preceding claims, wherein the elongation of the waist region is within 25% of the elongation of the elastic side panels when the waist region and the side panels are placed under a lateral force ranging from about 300 g to about 1400 g.

14. An absorbent article as defined in any of the preceding claims, wherein both the waist region and the elastic side panels have an elongation of at least 20%, such as at least 30%, when placed under a lateral force of 500 g.

15. An absorbent article as defined in any of the preceding claims, wherein the outer cover comprises an extendable laminate, the laminate containing a film and a nonwoven material or comprises a neck-bonded laminate.

16. An absorbent article as defined in any of the preceding claims, wherein the absorbent structure floats in between the outer cover and the bodyside liner.

17. An absorbent article as defined in any of the preceding claims, wherein at least a portion of the absorbent structure floats in between the outer cover and the bodyside liner.

18. An absorbent article as defined in any of the preceding claims, wherein the displacement of the waist region is within 15%, such as within 10%, or such as within 5% of the total displacement of the elastic side panels when the waist region and the elastic side panels are placed under a lateral force ranging
5 from about 300 g to about 700 g.

19. An absorbent article as defined in any of the preceding claims, wherein both the displacement of the waist region and the total displacement of the elastic side panels is at least about 15 mm when placed under a lateral force of 500 g.

20. An absorbent article as defined in any of the preceding claims, wherein the waist region undergoes a displacement that is within 25% of the total displacement of both elastic side panels when the waist region and the elastic side panels are placed under a lateral force ranging from about 300 g to about 1000 g.

21. An absorbent article as defined in any of the preceding claims, wherein the waist region undergoes a displacement that is within 25% of the total

displacement of both elastic side panels when the waist region and the elastic side panels are placed under a lateral force ranging from about 300 g to about 1400 g.

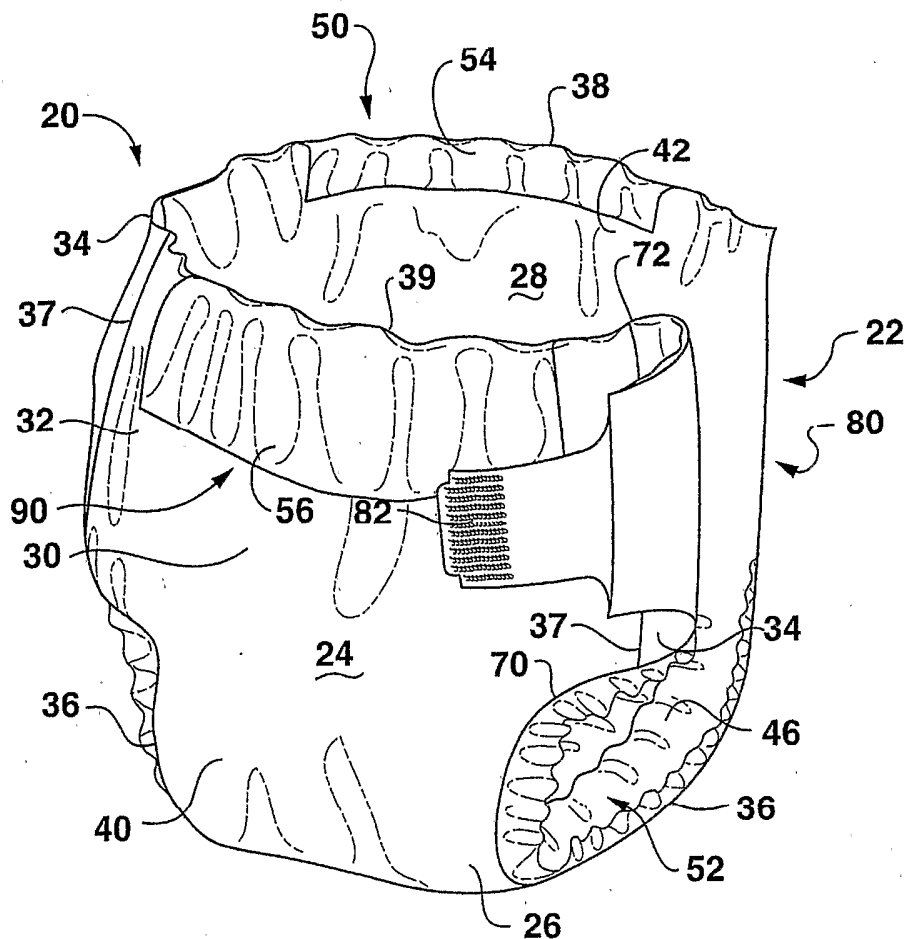


FIG. 1

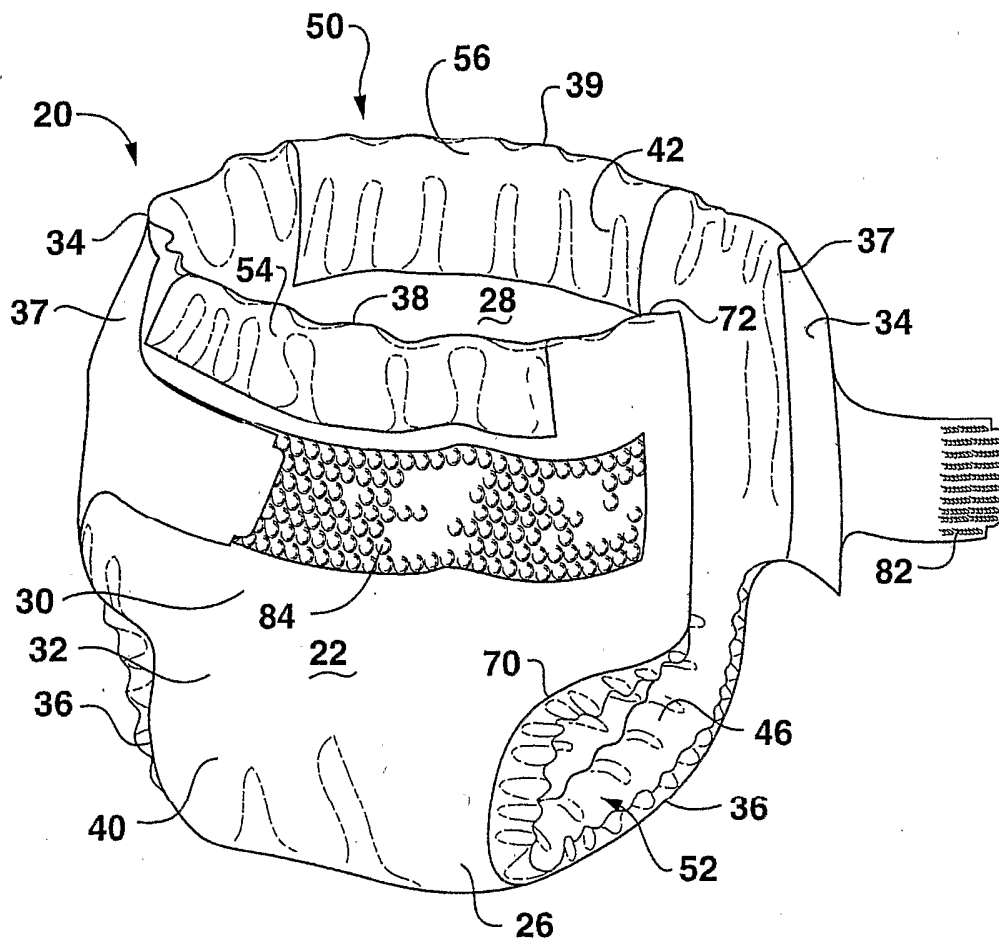


FIG. 2

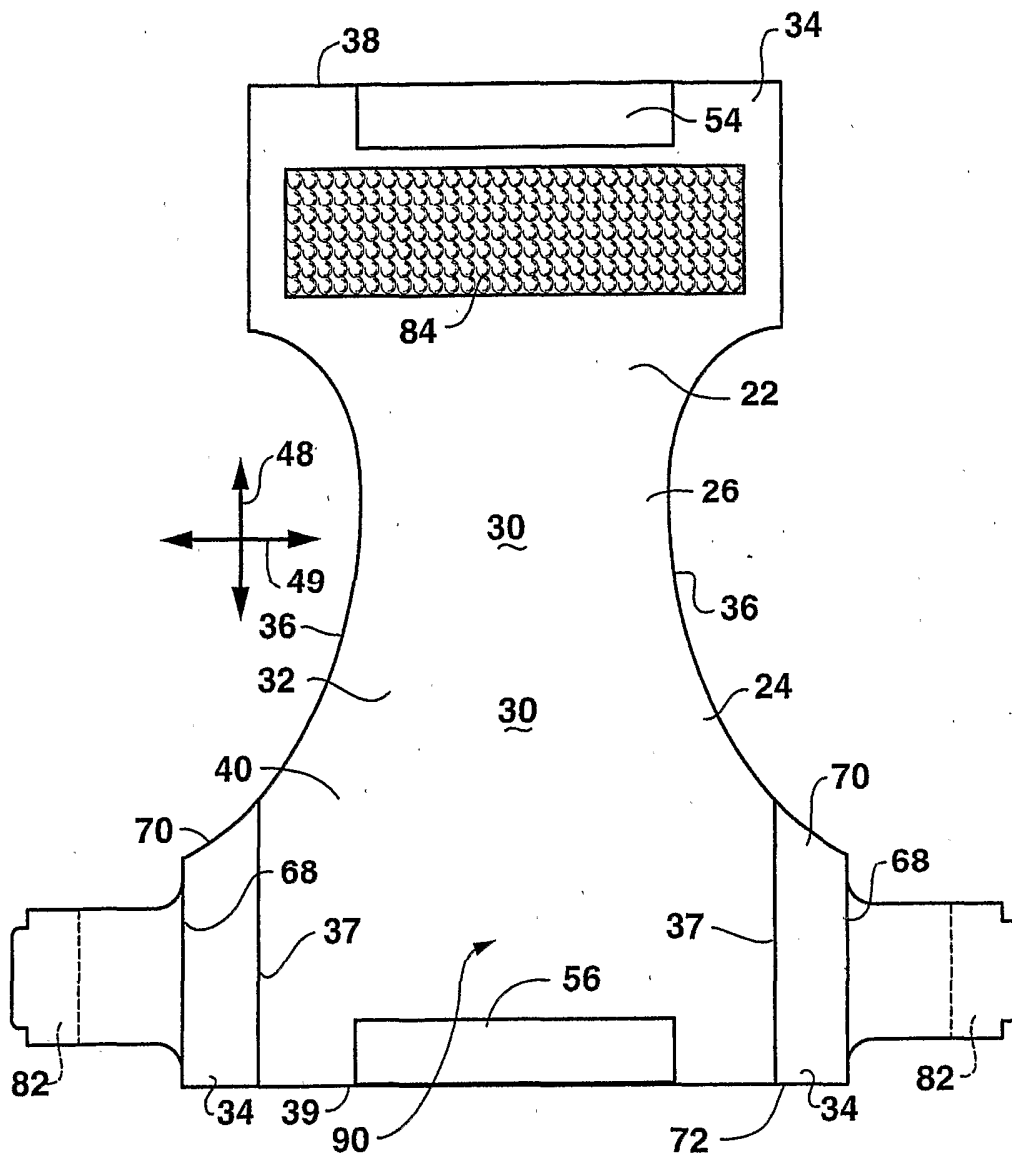


FIG. 3

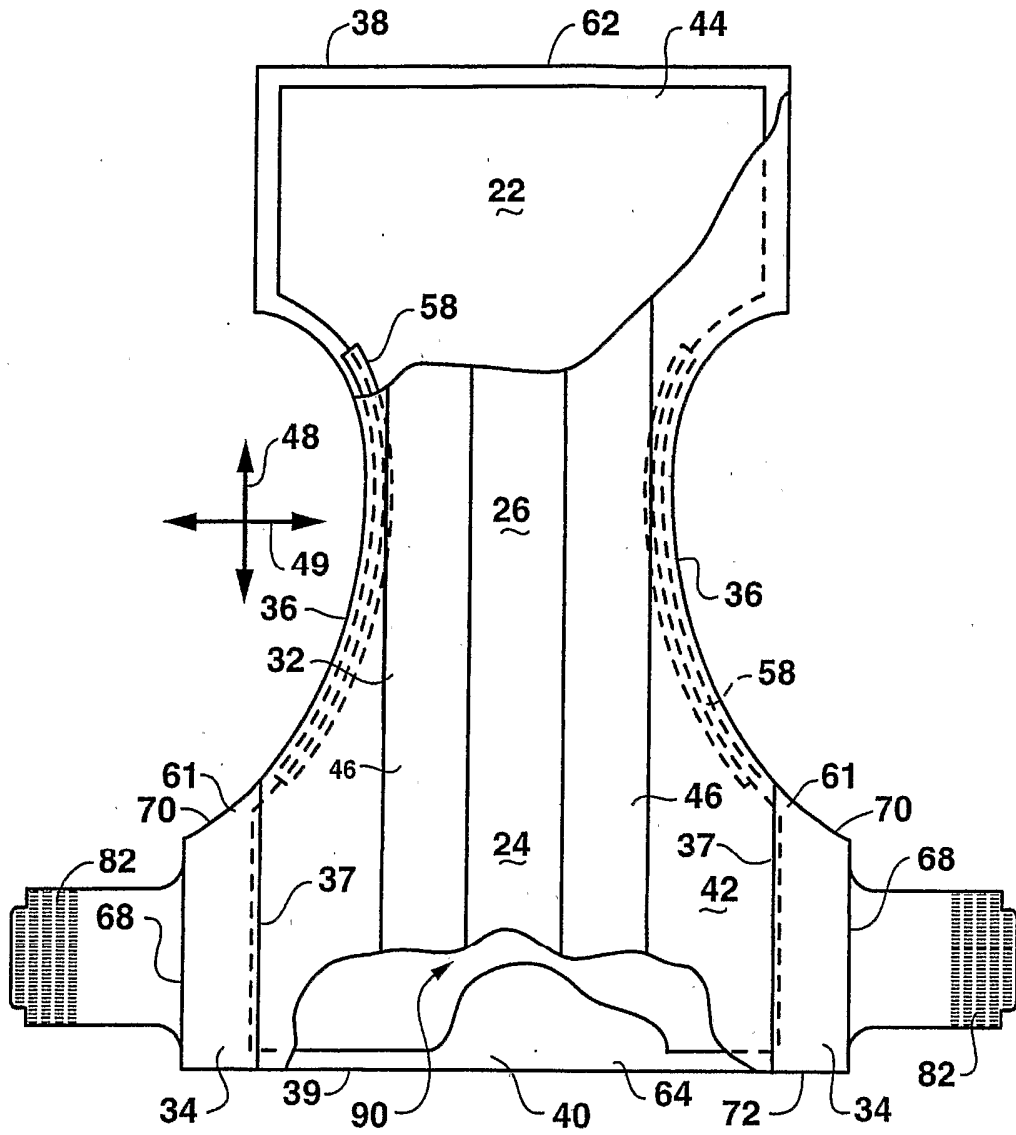


FIG. 4

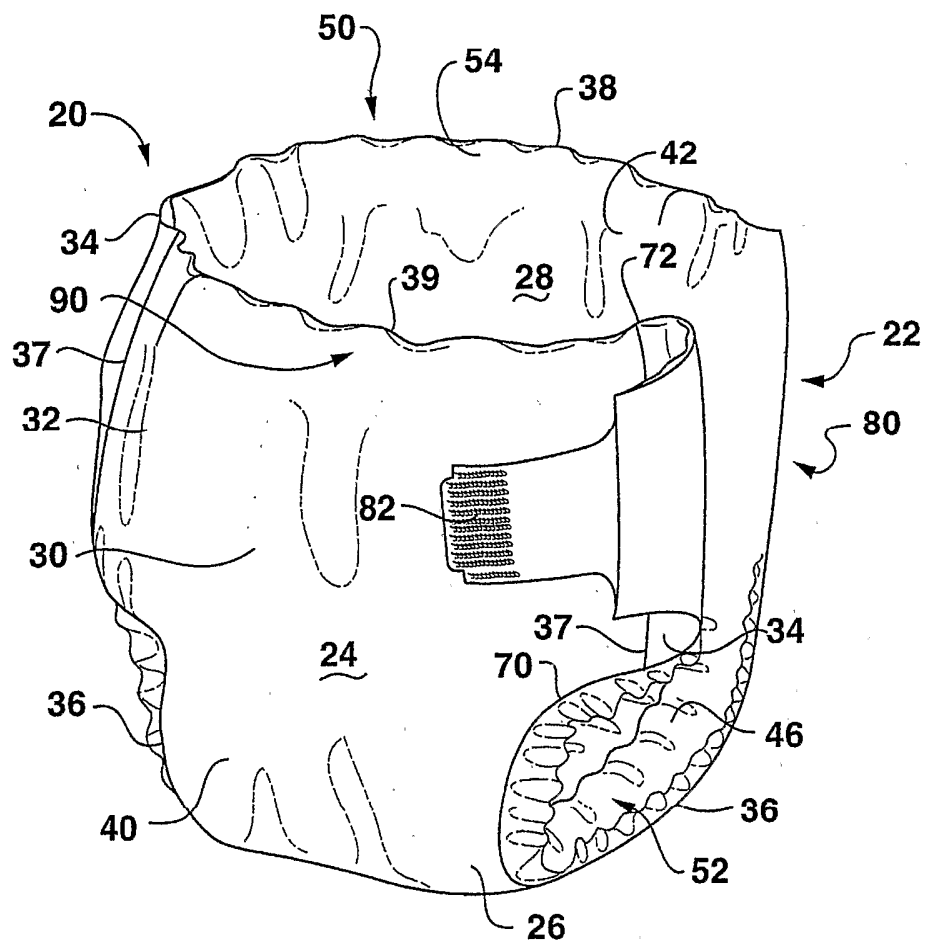


FIG. 5

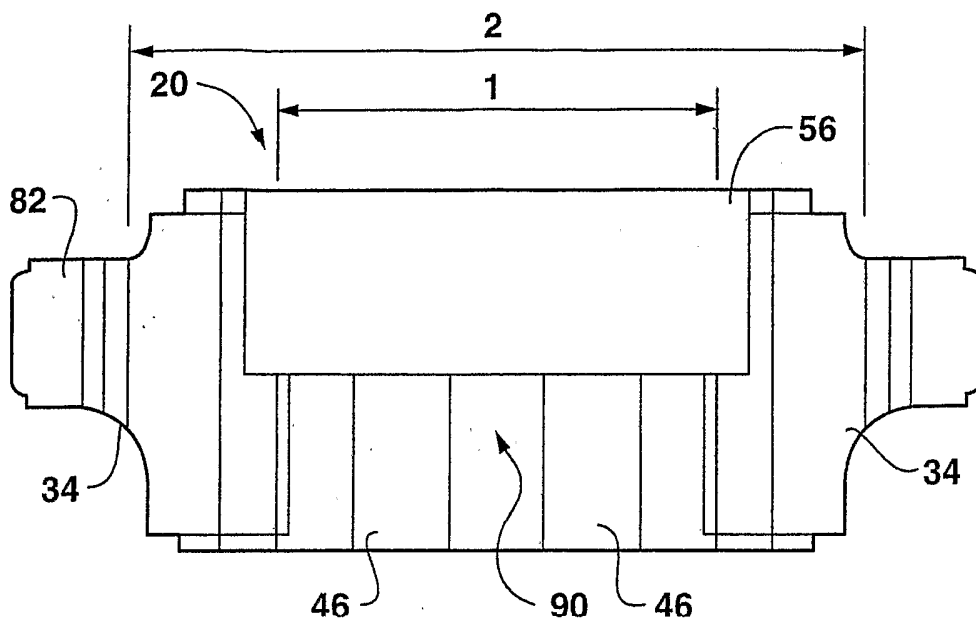


FIG. 6

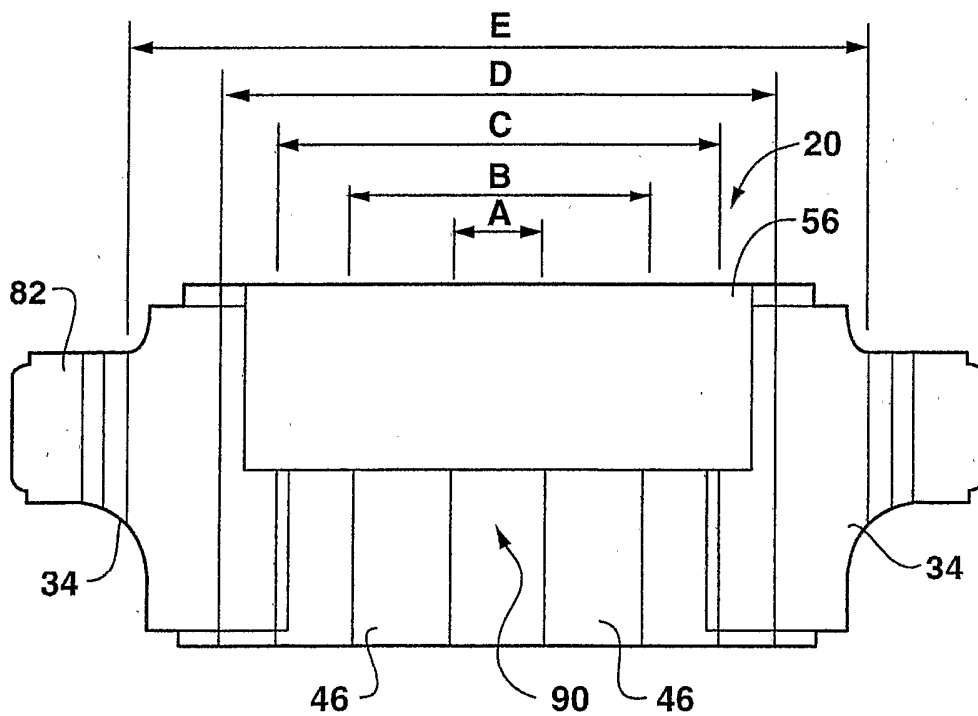


FIG. 7

INTERNATIONAL SEARCH REPORT

International Application No
PCT/US2005/017779

A. CLASSIFICATION OF SUBJECT MATTER IPC 7 A61F13/15		
According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED		
Minimum documentation searched (classification system followed by classification symbols) IPC 7 A61F		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
Electronic data base consulted during the international search (name of data base and, where practical, search terms used) EPO-Internal, WPI Data		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category °	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2004/122404 A1 (MEYER STEPHEN C ET AL) 24 June 2004 (2004-06-24) paragraphs '0049!, '0051! - '0053!, '5458!, '0064!; figure 1	1-21
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<input checked="" type="checkbox"/> Further documents are listed in the continuation of box C.		
<input checked="" type="checkbox"/> Patent family members are listed in annex.		
° Special categories of cited documents :		
"A" document defining the general state of the art which is not considered to be of particular relevance	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention	
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Date of the actual completion of the international search <p style="text-align: center;">25 August 2005</p>	Date of mailing of the international search report <p style="text-align: center;">01/09/2005</p>	
Name and mailing address of the ISA European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Tx. 31 651 epo nl, Fax: (+31-70) 340-3016	Authorized officer <p style="text-align: center;">Martinez, C</p>	

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PCT/US2005/017779

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
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