

(19)		(10) <b>FI 20145063 A7</b>
		(12) <b>JULKISEksi TULLUT PATENTTIHAKEMUS PATENTANSÖKAN SOM BLIVIT OFFENTLIG PATENT APPLICATION MADE AVAILABLE TO THE PUBLIC</b>
		(21) Patentihakemus - Patentansökan - Patent application <span style="float: right;">20145063</span>
		(51) Kansainvälinen patenttiluokitus - Internationell patentklassifikation - International patent classification <i>D21H 17/36</i> (2006.01) <i>D21H 17/37</i> (2006.01) <i>D21H 17/45</i> (2006.01) <i>D21H 17/55</i> (2006.01) <i>D21H 17/56</i> (2006.01) <i>D21H 21/10</i> (2006.01) <i>D21H 21/18</i> (2006.01) <i>D21H 21/20</i> (2006.01) <i>C08L 39/02</i> (2006.01) <i>D21H 11/14</i> (2006.01) <i>D21H 17/34</i> (2006.01)
		(22) Tekemispäivä - Ingivningsdag - Filing date <span style="float: right;">22.01.2014</span>
		(23) Saapumispäivä - Ankomstdag - Reception date <span style="float: right;">22.01.2014</span>
		(41) Tullut julkiseksi - Blivit offentlig - Available to the public <span style="float: right;">23.07.2015</span>
		(43) Julkaisupäivä - Publiceringsdag - Publication date <span style="float: right;">14.06.2019</span>

(71) Hakija - Sökande - Applicant

**1 • Kemira Oyj**, Energiakatu 4, 00180 HELSINKI, SUOMI - FINLAND, (FI)

(72) Keksijä - Uppfinnare - Inventor

**1 • HOKKA, Joonas**, ESPOO, SUOMI - FINLAND, (FI)  
**2 • HIETANIEMI, Matti**, ESPOO, SUOMI - FINLAND, (FI)  
**3 • LEGRAND, Sacha**, OULU, SUOMI - FINLAND, (FI)  
**4 • POLVERARI, Marco**, ST. LEONARD, QUEBEC, KANADA, (CA)

(74) Asiamies - Ombud - Agent

**Berggren Oy**, PL 99, 20521 Turku

(54) Keksiinon nimitys - Uppfinningens benämning - Title of the invention

**Paperinvalmistusaineekoostumus ja menetelmä kuitumassan käsittelyiseksi**

**Substanssammansättning för pappersframställning och förfarande för behandling av fibermassa**

**Papermaking agent composition and method for treating fibre stock**

(57) Tiivistelmä - Sammandrag - Abstract

Keksiinon kohteenon on edullisesti jauhemuotoinen paperinvalmistusaineekoostumus, joka käsittää vesiliukoisena, 21 - 39 mooliprosenttia vinyliamiiniyksiköitä käsittävän polymeerin ja jonka keskimääräinen molekyylipaino on vähintään 1 000 000 Da. Keksiinon kohteenon on myös menetelmä kuitumassan käsittelyiseksi paperin, kartongin tai vastaavan valmistuksessa, jossa saadaan sakea kuitumassa, sitä laimennetaan vettä lisäämällä laihaksi kuitumassaksi, jonka sakeus on < 3 %, ja laiha kuitumassa suotautetaan ja muodostetaan jatkuva kulturaina. Mainittua paperinvalmistusaineekoostumusta lisätään sakeaan kuitumassaan tai laihaan kuituun.

The invention relates to a papermaking agent composition, preferably in powder form, which comprises a water-soluble polymer, which comprises 21 – 39 mol-% of vinylamine units and has an average molecular weight of at least 1 000 000 Da. The invention relates also to a method for treating of fibre stock in manufacture of paper, board or the like, where a thick fibre stock is obtained, it is diluted to a thin fibre stock having a consistency < 3 % by addition of water, and the thin fibre stock is drained and a continuous fibrous web is formed. Said papermaking agent composition is added to the thick fibre stock or to the thin fibre.

## PAPERMAKING AGENT COMPOSITION AND METHOD FOR TREATING FIBRE STOCK

5 The present invention relates to a papermaking agent composition and method for  
treating fibre stock according to the preambles of the enclosed claims.

### TECHNICAL FIELD

10 One object in the manufacture of packaging grade paper and board is the cost efficiency. This object may be achieved by reducing the basis weight of produced paper or board, increasing the filler content, using cheaper recycled raw materials and developing production output. These cost reducing actions increase challenges encountered in wet end retention of paper and board machines, and may cause problems in achieving required strength properties of the final paper  
15 and board. Different chemical additives and agents may be added to the fibre stock for improving the drainage and retention of the formed web as well as the strength properties of the final paper or board.

20 Polyvinylamine polymers comprise primary amine groups attached to the polymer structure or linear polymer backbone. The primary amine groups make the polymers highly reactive, and they are used in numerous applications, also in papermaking, because of their charge density, reactivity and water solubility. However, polyvinylamine polymers having high molecular weight may be too reactive, which may lead to overflocculation and problems in dewatering and  
25 retention in the wet-end of a paper machine or board machine.

30 In paper and boardmaking the use of inexpensive fibre sources, such as old corrugated containerboard (OCC) has been increasing over the past decades. OCC comprises mainly used recycled unbleached or bleached kraft pulp fibres, hardwood semi-chemical pulp fibres and/or grass pulp fibres. OCC pulp may be used especially for manufacture of liner and fluting grades, often together with mixed waste recycled paper grades. Consequently chemical additives, which are suitable for use with pulps comprising recycled fibres, are in constant demand.

EP 1 727 938 discloses a process for production of paper, board and cardboard in presence of polymers which comprise vinylamine units. The used polymers have an average molar mass of at least 1 million and a degree of hydrolysis of from 1 to 5 20 mol-%. The polymers are metered to high consistency stock which is diluted and drained. The stock may contain coated broke and disturbing substances originating from the coating. However, there is a still need for papermaking agent compositions which are especially suitable for improving retention and/or drainage of fibre stock comprising recycled fibres, especially fibres from old corrugated 10 cardboard (OCC). Further, it would be advantageous if the chemicals used for retention and/or drainage would have a positive effect on the properties of the produced paper, e.g. burst strength, short span compression (SCT) and/or tensile strength.

15 The object of the present invention is to minimize or even eliminate the disadvantages existing in the prior art.

One object of the present invention is to provide a papermaking agent, with which the retention and/or drainage in the wet-end of a paper or board machine may be 20 improved, and optionally the strength properties, such as burst strength, short span compression (SCT) and/or tensile strength, of the produced paper may be increased.

A further object is to provide a method for treating fibre stock, especially fibre stock 25 comprising recycled fibres, in order to improve the dewatering and retention in the wet-end of a paper or board machine.

Typical papermaking agent composition according to the present invention, preferably in powder form, comprises a water-soluble polymer, which comprises 30 21 – 39 mol-% of vinylamine units and has an average molecular weight of at least 1 000 000 Da.

Typical method for treating fibre stock according to the present invention in manufacture of paper, board or the like comprises

- obtaining a thick fibre stock,

- diluting the thick fibre stock to a thin fibre stock having a consistency < 3 % by

5 addition of water,

- draining the thin fibre stock and forming a continuous fibrous web,

- adding to the thick fibre stock or to the thin fibre stock a papermaking agent composition which comprises a water-soluble polymer, comprising 21 – 39 mol-% of vinylamine units and having an average molecular weight of at least 1 000 000

10 Da.

Now it has been surprisingly found out that by carefully selecting and optimising the amount vinylamine units and the average molecular weight of the water-soluble polymer it is possible to obtain a papermaking agent composition, which

15 increases the drainage and retention in the wet-end of the paper machine or board machine, especially when the used raw materials comprise recycled fibres. It was surprisingly realised that when a papermaking agent composition comprising the water-soluble polymer having 21 – 39 weight-% of vinylamine units and with an average molecular weight of at least 1 000 000 Da is added to the thick or thin

20 stock, the drainage and retention of the stock is notably increasing. At the same time an increase in the strength properties, e.g. burst strength, short span compression (SCT) and/or tensile strength properties of the produced paper or board may be observed.

25 The term “water-soluble polymer” is understood in the context of the present application as a polymer, which is fully soluble and miscible with water. When mixed with water, the polymer is fully dissolved and the obtained polymer solution is essentially free from discrete polymer particles and no phase separation can be observed.

30

Molecular weight of the water-soluble polymer comprising vinylamine units is determined by using HPLC size exclusion chromatography, polyethylene oxide (PEO) as reference.

The water-soluble polymer may be a linear copolymer of vinylamine and N-vinylformamide or a linear copolymer of vinylamine and vinylalcohol. Further, the water-soluble polymer may even be a linear homopolymer of vinylamine.

5 According to one preferred embodiment the water-soluble polymer is a copolymer, which consists solely of N-vinylformamide and vinylamine or it is a copolymer, which consists solely of vinylamine and vinylalcohol. Especially when the papermaking agent composition is used as retention and/or drainage aid for fibre stocks comprising recycled fibres from old corrugated cardboard, the copolymers  
10 are preferred.

According to one embodiment of the invention the water-soluble polymer comprises 21 – 30 mol-%, preferably 21.5 – 25 mol-%, more preferably 21.5 – 23.5 mol-%, of vinylamine units. The amount of vinylamine units is selected in

15 order to optimise the retention and dewatering effects, together with the strength properties of the produced paper or board. Especially when OCC pulp is used for making of board or paper, the vinylamine units provide improved short span compression (SCT) and/or burst strength of paper and effective fixation to the fibres.

20 The amount of water-soluble polymer in papermaking agent composition may be at least 30 weight-%, preferably at least 70 weight-%, more preferably at least 85 weight-%, calculated from the total weight of the dry composition. According to one embodiment of the invention the amount of water-soluble polymer in papermaking  
25 agent composition may be 30 – 100 weight-%, preferably 70 – 97 weight-%, more preferably 85 – 95 weight-%, calculated from the total weight of the composition. When the papermaking agent composition is in form of solution the amount of water-soluble polymer in the composition is typically 30 – 60 weight-%, preferably 35 – 55 weight-%, calculated from the total weight of the composition. When the  
30 papermaking agent composition is in form of solid powder or particulate material the amount of water-soluble polymer in the composition is typically > 70 weight-%, preferably 70 – 95 weight-%, calculated from the total weight of the composition.

The papermaking agent composition typically contains salt, i.e. sodium formate, which is formed as a by-product in hydrolysis of N-vinylformamide with sodium hydroxide.

- 5 According to one advantageous embodiment of the invention the papermaking agent composition is in form of dry powder. The dry powder is easy to transport and store. The water-soluble polymer forms the main component of the dry powderous papermaking agent composition. The amount of water-soluble polymer is typically at least 60 weight-%, preferably at least 65 weight-%, more preferably 10 at least 70 weight-%, calculated from the total weight of the composition. The amount of water-soluble polymer in the dry powderous papermaking agent may be 60 – 95 weight-%, preferably 65 – 90 weight -%, more preferably 70 – 90 weight-%, calculated from the total weight of the composition.
- 15 According to another embodiment of the invention the papermaking agent composition is dissolved into water in order to obtain a papermaking agent composition in form of a solution, which has having a viscosity of >1000 mPas, preferably 1500 – 20 000 mPas, more preferably 2000 – 15 000 mPas, measured at 4 weight-% solution and 35 mS/cm conductivity. The conductivity of the 20 papermaking agent composition in solution form can be adjusted e.g. by using NaCl.

The papermaking agent composition may also comprise additives, such salts, acids, and/or anticaking agents. For example, the papermaking agent composition 25 in powder form may comprise one or several suitable salts, such as sodium chloride or urea, for improving the solubility of the composition, and/or anticaking agent(s) for improving the storage stability of the composition. If the composition is in form of a solution, it may comprise acid(s), which is/are used for adjusting the pH of the composition. Suitable acid is, for example, citric acid.

30

Preferably, the papermaking agent composition may comprise < 0.2 weight-%, preferably < 0.1 weight-%, of surfactant, calculated from total weight of the composition. The surfactant may be polyethylene glycol. Alternatively, surfactant

may be a two-block copolymer surfactant or three-block copolymer surfactant, comprising both hydrophilic and hydrophobic ends. According to one embodiment the papermaking agent composition is essentially free from said surfactants or any surfactants. It is advantageous if the amount of surfactant is kept as low as 5 possible, or even non-existent, because it has been observed that the strength properties of the produced paper or board may be then even further increased.

The papermaking agent composition may be added to the thick fibre stock, especially when the strength properties, such as short span compression (SCT), 10 burst strength and/or tensile strength, of the produced paper or board are optimised, i.e. increased. Thick fibre stock is here understood as a fibrous stock or furnish, which has consistency of at least 2 %, preferably at least 2.5 %, more preferably at least 3 %. According to one embodiment of the invention the papermaking agent composition is added to the fibre thick stock and the fibre thick 15 stock is then diluted with short loop white water of the paper or board machine before the web formation. The addition to the fibre thick stock may be advantageous because the papermaking agent comes more easily in contact with the fibres and is adsorbed on them. In this way the strength properties of the paper web can be effectively increased. In this context the term "short loop" is 20 synonymous with the term "short circulation". Short loop denotes the flow loop from the wire pit to the machine headbox and back to the wire pit. The short loop naturally includes all pumps, cleaning systems, etc. located in the flow loop between the wire pit and the headbox.

25 Alternatively, the papermaking agent composition may be added to the thin fibre stock after the last shear stages and before the headbox of the paper machine or board machine. Preferably the papermaking agent composition is added after the machine screen and before the headbox. Thin fibre stock is here understood as a fibrous stock or furnish, which has consistency of < 3 %, preferably less than 2.5 30 %, more preferably less than 2 %. The addition to the thin fibre stock may be advantageous when the dewatering and retention of the filler need to be improved. In the thin fibre stock the papermaking agent comes more easily in contact with

the inorganic filler material in the stock. In this way the retention and drainage of the paper web comprising filler material can be effectively improved.

According to one embodiment the papermaking agent composition may be added

5 in the papermaking or boardmaking process both to the thick stock and to the thin stock.

According to one embodiment of the invention it is possible to add cationic copolymer of acrylamide to the fibre stock, preferably sequentially, alternatively

10 simultaneously, with the papermaking agent composition comprising water-soluble polymer, which comprises vinylamine units. The cationic copolymer of acrylamide enhances retention of stock fines and filler, while the papermaking agent composition takes care of the charge control of the stock. Cationic copolymer of acrylamide may be obtained by polymerizing acrylamide with a cationic monomer

15 or by polymerizing methacrylamide with a cationic monomer. The cationic monomer may be selected from the group consisting methacryloyloxyethyltrimethyl ammonium chloride, acryloyloxyethyltrimethyl ammonium chloride, 3-(methacrylamido) propyltrimethyl ammonium chloride, 3-(acryloylamido) propyltrimethyl ammonium chloride, diallyldimethyl ammonium chloride,

20 dimethylaminoethyl acrylate, dimethylaminoethyl methacrylate, dimethylamino-propylacrylamide, dimethylaminopropylmethacrylamide, and similar monomers.

According to one preferred embodiment of the invention cationic copolymer of acrylamide is a copolymer of acrylamide or methacrylamide with (meth)acryloyloxyethyltrimethyl ammonium chloride. Cationic copolymer of

25 acrylamide may also contain other monomers, as long as its net charge is cationic and it has an acrylamide/methacrylamide backbone. An acrylamide or methacrylamide based polymer may also be treated after the polymerisation to render it cationic, for example, by using Hofmann or Mannich reactions. Cationic copolymer of acrylamide may have a molecular weight (MW) in the range of 5 000 000 –

30 20 000 000 g/mol. According to one embodiment of the present invention cationic polyacrylamide may have an average molecular weight (MW) in the range of 5 000 000 – 15 000 000 g/mol, preferably 7 000 000 – 13 000 000 g/mol, more preferably 8 000 000 – 10 000 000 g/mol. The retention or flocculation effect may

be optimised by suitable selection of the molecular weight of the cationic copolymer of the acrylamide. The retention or flocculation effect normally increases with the increasing molecular weight.

- 5 According to one embodiment of the invention inorganic anionic microparticles may be added to the fibre stock, preferably after the addition of the papermaking agent composition comprising polymer comprising vinylamine units. Inorganic microparticles may be bentonite particles or colloidal silica particles or any of their mixture. Typically the average particle size of bentonite particles is 50 – 200 nm,
- 10 preferably 75 – 125 nm. Typically the average particle size of colloidal silica particles is 5 – 20 nm, preferably 7.5 – 15 nm. Colloidal silica is here understood as a stable aqueous suspension of amorphous non-porous silica particles. Individual colloidal silica particles are typically spherical or nearly spherical. According to one preferred embodiment of the invention anionic colloidal silica is
- 15 used. Colloidal silica is prepared by starting from an alkali silicate, typically sodium silicate suspension, and allowing the silica to polymerise and form particles. Colloidal silica should not be mixed up with fumed silica, which is pyrogenically produced e.g. by combustion of silicon tetrachloride.
- 20 According to one embodiment it is possible to add inorganic anionic microparticles to the fibre stock before the addition of the papermaking agent composition.

According to another embodiment of the invention anionic copolymer of acrylamide may be added to the fibre stock, preferably after the addition of the papermaking agent composition comprising water-soluble polymer, which comprises vinylamine units. Anionic copolymer of acrylamide may be added in form of a solution or in a form of crosslinked polymer microparticle. Polymer microparticles are obtained by polymerisation of the monomer in a coagulant matrix. Polymer microparticles have typically an average particle size of 0.75 – 1.2

25  $\mu\text{m}$ . Anionic copolymer of acrylamide may be used together with inorganic anionic microparticles described above.

30

Anionic copolymer of acrylamide in form of a solution that is suitable for use together with the papermaking agent composition, may be formed by copolymerising acrylamide together with unsaturated carboxylic acid monomers, such as (meth)acrylic acid, maleic acid, crotonic acid or itaconic acid. Also other

5 anionic monomers, such as vinylsulphonic acid, 2-acrylamide-2-methylpropanesulfonic acid, styrene sulfonic acid, vinyl phosphonic acid or ethylene glycol methacrylate phosphate, may be included. It is also possible that noncharged monomers may be included, as long as the net charge of the formed polymer is anionic and the polymer has an acrylamide/methacrylamide backbone.

10 Anionic copolymer of acrylamide may be linear or crosslinked and have anionic charge 20 – 80 mol-%, sometimes 30 – 80 mol-%. Anionic copolymers of acrylamide may have an intrinsic viscosity value of 1 – 6 dl/g, preferably 2 – 5 dl/g, more preferably 3 – 5 dl/g. Intrinsic viscosity values are measured in a known manner in 1N NaCl at 25 °C by using an Ubbelohde capillary viscometer. The 15 capillary selected is appropriate, and in the measurements of this application an Ubbelohde capillary viscometer with constant K=0.005228 was used.

Anionic copolymer of acrylamide may be added 10 – 400 g/ton produced paper, calculated as active polymer.

20 According to one preferred embodiment of the present invention the papermaking agent composition is used for treating fibre stock, which comprises fibres originating from recycled paper, old corrugated containerboard (OCC), unbleached kraft pulp, neutral sulphite semi chemical (NCCS) pulp and/or mechanical pulp.

25 OCC preferably comprises recycled unbleached kraft pulp fibres, and it is used especially for manufacture of liner and fluting grades, often together with mixed waste recycled paper grades. The fibres in the stock may comprise at least 80 % recycled fibres, preferably at least 90 % recycled fibres, sometimes even 100 % recycled fibres. Recycled fibres originate from old corrugated cardboard and/or 30 mixed paper grades. Preferably a mixture of old corrugated cardboard and mixed paper grades is used for recycled fibres. The papermaking agent composition is especially suitable for fibre thick stock having a zeta-potential value -15 – -1 mV,

preferably -10 – -1 , more preferably -7 – -1 mV, before the addition of the papermaking agent composition to the fibre stock.

5 After the addition of the papermaking composition comprising water-soluble polymer, which comprises vinylamine units, to the fibre stock the zeta-potential of the fibre stock is < 0 mV, preferably -10 – -1 , more preferably -8 – -1 mV.

10 After the addition of the papermaking agent composition and possible other additives the charge density of the fibre stock in the headbox is at the most 300  $\mu\text{eq/l}$ , preferably 200  $\mu\text{eq/l}$ , more preferably 150  $\mu\text{eq/l}$ , higher than the charge density of the fibre thick stock before the addition, when the amount of added water-soluble polymer has been at least 400 g/ton produced paper, given as active agent.

15 15 Papermaking agent composition may be added to the thick fibre stock in such amount of that the amount of the said water-soluble polymer is 50 – 1500 g/ton produced paper, preferably 100 – 900 g/ton produced paper. more preferably at least 400 – 800 g/ton produced paper.

20 20 For example, in one embodiment of the invention the fibre stock, which has been treated with the papermaking agent composition, as described above, is used for making a product, which is paper, board or the like having a base paper ash content of > 10 %, preferably > 15 %, more preferably 15 – 25 %, even more preferably 16 – 25 %. Standard ISO 1762, temperature 525 °C, is used for ash 25 content measurements.

## EXPERIMENTAL

### **Preparation of water-soluble polymer**

30 30 N-vinylformamide, NVF, is used as a precursor for the polymerization of poly(N-vinylformamide), PNVF. In the following Examples the polyvinylamines have been synthetized by using solid N-vinylformamide.

Polyvinylamine, PVAm, is produced by the hydrolysis of PNVF in the presence of basic aqueous NaOH solution. The hydrolysis via basic solution produces a polymer backbone having free amine functional groups and sodium formate salt as a by-product. The base hydrolysis occurs fairly easily because of the attack of 5 strong nucleophile on the amide group in the basic solution.

### **Used test chemicals and methods in the Examples**

Following chemicals are used in the Examples:

C-PAM: cationic copolymer of acrylamide, molecular weight about 6,000,000

10 g/mol, charge 10 mol-%

A-PAM: crosslinked anionic copolymer of acrylamide, molecular weight about 3,000,000 g/mol, charge -60 mol-%

Bentonite: Altonite SF (Kemira Oyj), used as 3 weight-% slurry

Colloidal silica: average particle size 5 nm

15

Papermaking agent compositions comprising water-soluble N-vinylformamide-vinylamine copolymers that are used in the following Examples are defined in annexed Table 1. Viscosity values in Table 1 are measured by using a Brookfield viscometer, the papermaking agent being 4 weight-% solution at 35 mS/cm 20 conductivity (adjusted by NaCl). The level of hydrolysis of the water-soluble copolymer is given mol-%. The percentage of hydrolysis degree gives the amount of monomers having amine functionality in their polymer chain.

25 The papermaking agent compositions 1 – 3 according to the invention are in form of dry powderous products. Employed powderous compositions are diluted to suitable concentration before the addition to the test pulp slurry. The dilutions are conducted to facilitate the dosage volumes of the test chemicals.

30 All chemical dosages in the Examples are calculated as dry product.

### **Dynamic Drainage Analyzer, DDA**

A Dynamic Drainage Analyzer, DDA, (AB Akribi Kemikonsulter, Sweden) was used to measure drainage and retention.

DDA's vacuum and stirrer were calibrated and necessary adjustments to the settings were made. DDA was connected to a computer for measuring the time between an application of vacuum and the vacuum break point. A change of the 5 vacuum expresses the forming time of a wet fibre web until air breaks through the thickening web indicating the drainage time. A drainage time limit was set to 30 seconds for the measurements.

10 In drainage measurements, 500 ml of the stock sample was measured into the reaction jar. The drainage test was performed by mixing the sample stock with the stirrer at 1200 rpm for 30 seconds while the chemicals to be tested were added in predetermined order. Test chemical addition times are indicated in result tables as negative time before the start of the drainage.

15 In retention measurements, 500 ml of the stock sample was measured into the reaction jar, and a wire with 0.25 mm openings and a 300 mbar vacuum were used.

20 Abbreviations used in the Examples: LF=long fibre; SF=short fibre; CF=clear filtrate

**Example 1: Papermaking agent composition with anionic copolymer of acrylamide (A-PAM)**

Commercial Central European Old Corrugated Container (OCC) stock from 25 Germany was used as raw material in Example 1. Stock had been separated into long fibre (LF) fraction and short fibre (SF) fraction by the screen fractionation process already at the papermill. Both stock fractions were characterised, results are shown in annexed Table 2. Clear filtrate and thin stock were also obtained from a papermill, and they were characterised, results are shown in Table 2.

30 Both LF- and SF-fractions were tested and analysed separately, and all the results in Example 1 are given as an arithmetic average of individual results obtained with LF-fraction and SF-fraction.

The dilution ratio for the DDA measurements was as follows: two parts of OCC fibre stock, either LF- or SF-fraction, and one part of thin stock. Sample was diluted to consistency of 2.6 g/l with the clear filtrate and adjusted to room 5 temperature of +23 °C. The ash content of 16.9 % was achieved due to the high filler content of the added thin stock.

Papermaking agent compositions and anionic copolymer of acrylamide are as defined above. Drainage and retention of each stock sample was measured as 10 described earlier by using the DDA, and the used chemicals were added sequentially into the stock sample during mixing. The results of Example 1 are shown in annexed Table 3.

It can be seen from Table 3 that Composition 1 comprising water-soluble 15 polyvinylamine having hydrolysis degree of 21 % gives faster drainage and higher first-pass retention (FPR) results than reference compositions comprising polyvinylamines with higher hydrolysis degree.

**Example 2: Papermaking agent compositions with cationic copolymer of 20 acrylamide (C-PAM) and bentonite**

Papermaking agent compositions, cationic copolymer of acrylamide (C-PAM), as well as bentonite are as defined above. Same stock raw material is used as in Example 1. The results are given as an arithmetic average of individual results obtained with LF-fraction and SF-fraction.

25 Drainage and retention of each stock sample was measured as described above by using the DDA, and the tested compositions and chemicals were added sequentially into the stock sample during mixing. The drainage and retention results of Example 2, which uses a multicomponent system comprising 30 papermaking agent composition, C-PAM and bentonite are shown in annexed Table 4.

It can be seen from Table 4 that when used together with C-PAM and bentonite, Composition 1 comprising water-soluble polyvinylamine having hydrolysis degree of 21 % gives faster drainage and higher first-pass retention (FPR) results than reference compositions comprising polyvinylamines with higher hydrolysis degree.

5

### **Example 3: Drainage test with recirculated filtrate**

The stock sample was prepared by using the same long fibre (LF) fraction and thin stock as in Example 1, as well as tap water. Conductivity of tap water was adjusted to the same level as in the thin stock by adding NaCl. The same dilution

10 ratio of the test pulp was selected according to the drainage of the Test #1 of Example 1.

Drainage tests were performed as described above by using the Dynamic Drainage Analyzer, and DDA filtrate was used as dilution water for the sample

15 stock. Sample stock consistency was 6.6 g/l and the ash content was 15 %. The configuration and settings of the DDA equipment corresponded with the Example 1. DDA filtrate was recirculated as dilution water in order to simulate the short circulation of a paper machine. The filtrate was recirculated seven times. The filtrate charge was analyzed from every other DDA filtrate by using Mütek PCD 03.

20 The results of Example 3 are presented in annexed Table 5.

After seven circulations the system achieved relatively stable charge conditions.

From Table 5 it can be seen that Compositions 1 and 3, comprising water-soluble polyvinylamine having hydrolysis degree of 21 % and 35 %, respectively, were

25 much more effective in drainage than the reference compositions, comprising polyvinylamine having hydrolysis degree of 55 % and 90 %, respectively.

### **Example 4: Papermaking agent composition with anionic copolymer of acrylamide (A-PAM)**

30 Commercial Central European Old Corrugated Container (OCC) stock was used as raw material in Example 4. For preparation of samples the following dilution ratio was chosen: one part of OCC stock and two parts of white water. White water

was obtained from a papermill. Each sample was diluted to consistency of 5.4 g/l by using conductivity adjusted tap water.

Properties of OCC stock and white water are given in annexed Table 6.

5

Drainage was measured by using the DDA, as described above. The drainage results are shown in annexed Table 7. It can be seen from Table 7 that Compositions comprising polyvinylamine having hydrolysis degree of 21 %, 23 % and 35 % give faster, i.e. better, drainage than the reference compositions 10 comprising polyvinylamines with higher hydrolysis degree of 40 %, 55 % and 90 %. The same effect is seen when the compositions are used together with anionic copolymer of acrylamide.

#### **Example 5: Effect on Zeta potential**

15 Test fibre slurry was prepared by wet disintegrating dry testliner and fluting sheets based on recycled fibres by using a Lorentzen & Wettre Pulp Disintegrator, according to standard ISO 5263:1995. The dry testliner and fluting sheets were cut to pieces having size of 2.5 × 2.5 cm and weighted to oven-dry mass of 60 g. The cut and weighed testliner and fluting sheets, in weight ratio 1:1, were dissolved in 20 the white water, temperature 50 °C, dissolution time 10 minutes. The volume of the obtained disintegrated slurry was 2700 ml and the rotation of the propeller was adjusted to 50 000 rotations. The test slurry was cooled to room temperature in an ice cube bath prior to the zeta potential measurements.

25 The disintegrated slurry volume in zeta potential determination was 500 ml. The compositions were added under mixing, mixing speed 250 rpm, mixing time 10 seconds. After addition and mixing of the compositions zeta potential was determined by using Mütek SZP-06 device. The results of the zeta potential measurement are illustrated in Figure 1.

30 It can be seen from Figure 1 that it is possible to use a large dose of Composition 1 comprising polyvinylamine having hydrolysis degree of 21 % before the zero level of zeta potential is reached. When using Reference Compositions 1 and 2,

comprising polyvinylamine having hydrolysis degree of 55 % and 95 %, respectively, the zero level of zeta potential is reached with significantly smaller dosages. The runnability and/or retention of paper machine is known to suffer when the zeta potential of the stock is around zero or positive. Composition 1  
5 according to the invention provides for use of high chemical dosages, which may improve the drainage and strength of the web, without runnability and/or retention problems.

#### **Example 6: Effect on Dry Strength of Produced Paper**

10 Commercial Central European Old Corrugated Container (OCC) stock from Central Europe was used as raw material in Example 6.

OCC was disintegrated from bales by using Andritz laboratory refiner for 35 minutes with open fillings. The bales were disintegrated with mill water to achieve  
15 consistency of 2.3 % for the test stock suspension. The properties of the disintegrated OCC stock and mill water are shown in annexed Table 8.

The papermaking agent compositions were dosed into the disintegrated OCC stock. Fresh mill water was used as process water which was fed into a mixing  
20 tank with the stock under agitation, the stock was diluted to headbox consistency of 1 %, and the thin stock suspension was fed to a headbox of a pilot paper machine. The used retention aids were C-PAM, dosage of 100 g/ton of dry product, and colloidal silica, dosage of 200 g/ton of dry product. C-PAM and colloidal silica have been defined above. C-PAM was added before the headbox  
25 pump of the pilot paper machine, whereas silica was dosed before the headbox of the pilot paper machine.

OCC liner and fluting sheets having basis weight of 100 g/m<sup>2</sup> were produced on a pilot paper machine. Operational parameters of the pilot paper machine were as  
30 follows:

Running speed: 2 m/min; Web width: 0.32 m; Rotation speed of holey roll: 120 rpm; Press section: 2 nips; Drying section: 8 pre-drying cylinders, baby cylinder, 5 drying cylinders

Before testing of strength properties of the produced liner and fluting sheets, the sheets were pre-conditioned for 24 h at 23 °C in 50 % relative humidity according to standard ISO 187. Devices and standards, which were used to measure the 5 properties of the sheets, are given in annexed Table 9.

The results for strength property tests are given in annexed Table 10. The results in Table 10 were indexed and compensated to the same ash content in order to make a representative comparison between the tested compositions. Tensile and 10 SCT measurements were indexed by dividing each obtained measurement value by basis weight of the measured sheet and then calculated as geometrical mean of machine direction strength and cross direction strength. The results were leveled to 16 % ash content. The results were interpolated to 16 % ash content based on the known data points. A difference of +1 % unit in ash content 15 corresponds to the difference of -0.25 Nm/g in the geometrical SCT index and to the difference of -0.75 Nm/g in the geometrical tensile index.

It can be seen from results in Table 10 that Composition 1 comprising 20 polyvinylamine having hydrolysis degree of 21 % has a positive effect on SCT strength and tensile strength values in comparison to reference compositions.

#### **Example 7: Effect on Beta Formation**

Commercial Central European Old Corrugated Container (OCC) stock from Germany was used as raw material in Example 7. Stock had been separated into 25 long fibre (LF-) fraction and short fibre (SF-) fraction by the screen fractionation process already at the mill. Both stock fractions were characterized, results are shown in annexed Table 11.

Used C-PAM and A-PAM have been defined above. The chemicals were added to 30 the stock in a mixing jar under mixing with 700 rpm in the following sequence: 1) cationic polymer/composition, allowed reaction time 2 min, and 2) anionic polymer, allowed reaction time 1 min. After last chemical addition the mixing was continued for 1 min, a determined volume of thin stock was poured into the jar in order to

keep the basis weight of the sheets constant ( $120 \text{ g/m}^2$ ) and mixed at 1500 rpm for 30 s until the stock suspension was ready for the sheet formation.

For the preparation of laboratory sheets the stock was diluted to 1 % consistency

5 with clear filtrate (CF). Handsheets having basis weight of  $120 \text{ g/m}^2$  were formed by using Rapid Köthen sheet former with circulation water in accordance with ISO 5269-2:2012. The basis weight of the sheets was adjusted by the volume of the thin stock and the amount of stock portion (240 ml) was kept constant. The sheets were dried in vacuum dryers for 6 minutes at  $92^\circ\text{C}$  and at 1000 mbar.

10

The used circulation water was prepared in a separate container, where the conductivity and hardness of tap water were adjusted with  $\text{CaCl}_2$  and  $\text{NaCl}$  to correspond white water of a paper mill.

15 Before testing the laboratory sheets were pre-conditioned for 24 h at  $23^\circ\text{C}$  in 50 % relative humidity, according to ISO 187. Basis weight was determined by using Mettler Toledo weighing apparatus, according to with ISO 536. Formation of the laboratory sheets was studied by using AMBERTEC Beta Formation tester according to standard SCAN-P 92:09. The formation result of each sheet was

20 divided by the square root of the basis weight of the sheet in order to obtain normalized beta formation value for the sheets. Figure 2 shows the normalized beta formation results of Example 7 for the short fiber pulp handsheets.

Low value beta formation values are preferred. From Figure 2 it can be seen that

25 Composition 1 comprising polyvinylamine having hydrolysis degree of 21 % performs better than Reference 2 comprising polyvinylamine having hydrolysis degree of 55 %.

### **Example 8: Drainage Test**

30 Same stock as in Example 7 was used in Example 8. The following dilution ratio was used: two parts of the long fibre fraction and one proportion of thin stock. The stock was diluted to 4.2 g/l consistency with the conductivity adjusted tap water.

Drainage results were obtained by using the DDA, as described earlier, except that the sample stock was mixed with the stirrer at 1200 rpm, instead of 1500 rpm, for 30 seconds.

5 The drainage results are shown in annexed Table 12. From Table 12 it is seen that Composition 1 comprising polyvinylamine having hydrolysis degree of 21 % provides clear improvement in drainage compared Reference 1, 2 and 3. Also Composition 2 performs well at dose level of 1.2 kg/ton and together with A-PAM.

10 **Example 9: Effect on Burst Index**

Commercial European OCC stock was used for preparation of laboratory sheets. The stock was diluted to a consistency of 8.8 g/l with clear filtrate (CF). Properties of OCC stock, clear filtrate and white water are given in annexed Table 13.

15 Tested compositions were added to the stock in a mixing jar under mixing with 1500 rpm in the following sequence: 1) test composition, added after 10 s from the start of the mixing, 2) a predetermined volume of the white water after 15 s from the start of the mixing, 3) colloidal silica particles after 20 s from the start of the mixing. After 30 s from the start of the mixing, handsheets having basis weight of 20 120 g/m<sup>2</sup> were formed by using Rapid Köthen sheet former with circulation water in accordance with ISO 5269-2:2012. The basis weight of the sheets was adjusted by the volume of the white water and the amount stock portion (440 ml) was kept constant.

25 The used circulation water was prepared in a separate container, where the conductivity and hardness of tap water were adjusted with CaCl<sub>2</sub> and NaCl to correspond white water of a paper mill.

30 The formed sheets were dried in a vacuum dryer for 6 minutes at temperature of 92 °C and at pressure of 1000 mbar.

Before testing the laboratory sheets were pre-conditioned for 24 h at 23 °C in 50 % relative humidity, according to ISO 187. Basis weight was determined by using

Mettler Toledo weighing apparatus, according to ISO 536. Burst strength was measured by using L&W Bursting Strength tester, according to ISO 2758. The obtained were indexed and compensated to the same ash content in order to make a representative comparison between tested compositions. The results were

5 leveled to 17 % ash content. A difference of +1 % unit in ash content corresponds to the difference of -0.05 kPa\*m<sup>2</sup>/g in the burst index. The results of Example 9 are shown in annexed Table 14. It is seen from Table 14 that Composition 1 has the best improvement effect on the burst index of the laboratory sheet compared with Reference 0 and Reference 1.

10

Even if the invention was described with reference to what at present seems to be the most practical and preferred embodiments, it is appreciated that the invention shall not be limited to the embodiments described above, but the invention is intended to cover also different modifications and equivalent technical solutions

15 within the scope of the enclosed claims.

Table 1 Definitions of papermaking agent compositions comprising water-soluble polymers that are used in the Examples.

	Hydrolysis degree of water-soluble polymer [mol-%]	Molecular weight [g/mol]	Active polymer content of dry composition [%]	Viscosity [mPas]
Composition 1	21	~4,000,000	71	4400
Composition 2	23	~4,000,000	67	733
Composition 3	35	~4,000,000	59	633
Reference 0	10	~4,000,000	83	-
Reference 1	40	~4,000,000	74	3300
Reference 2	55	~4,000,000	48	1670
Reference 3	90	~4,000,000	36	507
Reference 4	44	~300,000	53	23

Table 2 Properties of LF- and SF-fractions, thin stock and clear filtrate used in Example 1.

Property	LF-fraction	SF-fraction	Thin stock	CF	Device/standard
pH	6.2	6.3	6.8	6.7	Knick Portamess 911
Turbidity (NTU)	2760	2478	866	490	WTW Turb 555IR
Conductivity (mS/cm)	4.0	4.0	2.9	2.7	Knick Portamess 911
Charge (μekv/l)	-105.5	-89.8	-71.1	-90.9	Mütek PCD 03
Zeta potential (mV)	-1.5	-1.4	-	-	Mütek SZP-06
Consistency (g/l)	38.6	38.5	14.0	-	ISO 4119
Ash content (%)	14.5	16.3	25.1	-	ISO 1762
Fines content (%)	20	24	-	-	SCAN-CM 66:05

Table 3 Drainage and retention results of Example 1.

Dosing time [s]	-10		-5	Drainage and Retention Results	
Test No	Composition name	Dose [kg/ton]	A-PAM Dosage [kg/ton]	Drainage Time [s]	First-pass Rate [%]
1	-	-	-	6.8	91.95
2	-	-	0.2	6.98	93.02
3	Composition 1	0.4	0.2	4.06	97.27
4	Composition 1	0.8	0.2	3.53	99.30
5	Composition 1	1.2	0.2	3.17	99.63
6	Reference 2	0.4	0.2	5.63	95.07
7	Reference 2	0.8	0.2	5.39	94.47
8	Reference 2	1.2	0.2	5.44	94.80
9	Reference 3	0.4	0.2	5.83	93.75
10	Reference 3	0.8	0.2	5.22	93.71
11	Reference 3	1.2	0.2	5.53	93.65

Table 4 Drainage and retention results of Example 2.

Dosing Time [s]	-15		-15	-10	Drainage and Retention Results	
Test No	Composition name	Dose [kg/ton]	C-PAM Dosage [kg/ton]	Bentonite Dosage [kg/ton]	Drainage Time [s]	First-pass Rate [%]
12	-	-	0.2	1.5	7.08	91.07
13	Composition 1	0.4	0.2	1.5	4.93	92.37
14	Composition 1	0.8	0.2	1.5	3.48	93.10
15	Composition 1	1.2	0.2	1.5	2.76	96.30
16	Reference 2	0.4	0.2	1.5	6.79	90.03
17	Reference 2	0.8	0.2	1.5	6.81	90.80
18	Reference 3	0.4	0.2	1.5	6.99	90.77
19	Reference 3	0.8	0.2	1.5	6.96	90.50

Table 5 Drainage test results of Example 3 with recirculated DDA filtrate.

Dosing time [s]	-15		Results for Drainage and Filtrate Charge		
	Number of circulations	Composition name	kg/ton [active]	Drainage [s]	Charge [ $\mu$ ekv/l]
0	-		0	12	-195
1	Composition 1		0.8	10.4	-75
1	Composition 3		0.8	11.3	-74
1	Reference 2		0.8	12.4	-91
1	Reference 3		0.8	12	-87
3	Composition 1		0.8	6.3	-51
3	Composition 3		0.8	7.21	-49
3	Reference 2		0.8	10	-75
3	Reference 3		0.8	11.3	-91
5	Composition 1		0.8	5.7	-51
5	Composition 3		0.8	6.3	-45
5	Reference 2		0.8	8.8	-36
5	Reference 3		0.8	10.8	-55
7	Composition 1		0.8	5.9	-52
7	Composition 3		0.8	6.2	-38
7	Reference 2		0.8	8.3	-38
7	Reference 3		0.8	10.1	-42

Table 6 Properties of OCC stock and white water used in Example 4.

Property	OCC stock	White Water	Device/Standard
pH	6.7	6.9	Knick Portamess 911
Turbidity (NTU)	431	23	WTW Turb 555IR
Conductivity (mS/cm)	3.3	1.6	Knick Portamess 911
Charge ( $\mu$ ekv/l)	-213	-62	Mütek PCD 03
Zeta potential (mV)	-9	-	Mütek SZP-06
Consistency (g/l)	46	1	ISO 4119
Ash content (%)	14	31	ISO 1762

Table 7 Drainage test results of Example 4.

Dosing time [s]	-15		-10	Drainage Results
	Test No	Composition Name	Dose [kg/ton]	
1			-	- 11.45
2	Composition 1	0.4		- 8.56
3	Composition 2	0.4		- 8.43
4	Composition 3	0.4		- 9.10
5	Reference 1	0.4		- 9.25
6	Composition 1	0.8		- 7.51
7	Composition 2	0.8		- 7.14
8	Composition 3	0.8		- 8.13
9	Reference 1	0.8		- 8.49
10	Reference 2	0.8		- 8.98
11	Reference 3	0.8		- 9.52
12	Composition 1	0.8	0.07	7.23
13	Composition 2	0.8	0.07	7.12
14	Composition 3	0.8	0.07	7.85
15	Reference 1	0.8	0.07	7.98
16	Reference 2	0.8	0.07	8.29
17	Reference 3	0.8	0.07	9.13

Table 8 Properties of disintegrated OCC stock and mill water in Example 6.

Property	Disintegrated OCC stock	Mill water	Device/standard
pH	-	7.5	Knick Portamess 911
Conductivity	1.9	2.5	Knick Portamess 911
Charge	-262	-283	Mütek PCD 03
Zeta potential	-8.7	-	Mütek SZP-06
Consistency	23	-	ISO 4119
Ca-content (mg/l)	-	643	ISO 777
Alkanity (mmol/l)	-	2.2	ISO 9963
COD (mg/l)	1013	630	ISO 6060

Table 9 Sheet testing devices and standards in Example 6.

Measurement	Device	Standard
Basis weight	Mettler Toledo	ISO 536
SCT (Short Span Compression test)	Lorentzen & Wettre Compression Strength tester	ISO 9895
Tensile strength	Lorentzen & Wettre Tensile tester	ISO 1924-3

Table 10 Results of Example 6.

Composition Name	Composition Dose [kg/ton]	SCT Geom. ind. [kNm/kg]	Tensile Geom. ind. [Nm/g]
-	-	21.0	35.3
Composition 1	0.5	24.4	42.1
Reference 1	0.5	21.7	37.4
Reference 4	0.5	22.7	37.2

5 Table 11 Properties of LF- and SF-fractions, thin stock and clear filtrate (CF) used in Example 7.

Property	LF-fraction	SF-fraction	Thin stock	CF	Device/standard
pH	6.3	6.2	6.9	6.3	Knick Portamess 911
Turbidity (NTU)	2477	2280	1236	517	WTW Turb 555IR
Conductivity (mS/cm)	3.8	3.7	2.3	2.3	Knick Portamess 911
Charge (μekv/l)	-195.3	-122.7	-94.7	-103.1	Mütek PCD 03
Zeta potential (mV)	-6.8	-6.2	-	-	Mütek SZP-06
Consistency (g/l)	46.6	41.2	17.1	-	ISO 4119
Ash content (%)	14.9	16.4	23.3	-	ISO 1762
Ca content (mg/l)	1144	1090	519	521	ISO 777

Table 12 Drainage results for Example 8.

Dosing time [s]	-10		-5		Drainage Results
	Test No	Composition Name	Dose [kg/ton]	A-PAM Dosage [kg/ton]	
1	-		-	-	6.57
2	Reference 0		0.8	-	4.38
3	Composition 1		0.8	-	3.97
4	Composition 2		0.8	-	4.06
5	Composition 3		0.8	-	4.51
6	Reference 1		0.8	-	4.26
7	Reference 2		0.8	-	4.98
8	Reference 3		0.8	-	5.8
9	Reference 0		1.2	-	4.68
10	Composition 1		1.2	-	3.42
11	Composition 2		1.2	-	3.4
12	Composition 3		1.2	-	3.65
13	Reference 1		1.2	-	4.4
14	Reference 0		0.8	A-PAM 0.07	4.4
15	Composition 1		0.8	A-PAM 0.07	4.02
16	Composition 2		0.8	A-PAM 0.07	4.0
17	Composition 3		0.8	A-PAM 0.07	4.52
18	Reference 1		0.8	A-PAM 0.07	4.23
19	Reference 2		0.8	A-PAM 0.07	4.74
20	Reference 3		0.8	A-PAM 0.07	5.2

Table 13 Properties of the OCC stock, white water and clear filtrate used in Example 9.

Property	OCC	White Water	CF	Device/Standard
pH	6.4	6.5	5.4	Knick Portamess 911
Turbidity (NTU)	97	83	21	WTW Turb 555IR
Conductivity (mS/cm)	3.6	3	2	Knick Portamess 911
Charge ( $\mu$ ekv/l)	-120	-66	-48	Mütek PCD 03
Zeta potential (mV)	-7.8	-	-	Mütek SZP-06
Consistency (g/l)	33.8	3.3	-	ISO 4119
Ash content (%)	19.2	48.8	-	ISO 1762

Table 14 Results of Example 9.

Composition Name	Dose [kg/ton]	Burst index [kPa*m <sup>2</sup> /g]
-	0	1.39
Reference 0	0.5	1.45
Composition 1	0.5	1.49
Reference 1	0.5	1.39

## CLAIMS

1. Papermaking agent composition, preferably in powder form, which comprises a water-soluble polymer, which comprises 21 – 39 mol-% of vinylamine units and  
5 has an average molecular weight of at least 1 000 000 Da.
2. Composition according to claim 1 or 2, **characterised** in that the water-soluble polymer comprises 21 – 30 mol-%, preferably 21.5 – 25 mol-%, more preferably 21.5 – 23.5 mol-%, of vinylamine units.  
10
3. Composition according to claim 1, **characterised** in that the papermaking agent is in form of a solution, which has a viscosity of at least 1000 mPas, preferably 1500 – 20 000 mPas, more preferably 2000 – 15 000 mPas, measured at 4 weight-% solution and conductivity of 35 mS/cm.  
15
4. Composition according to any of preceding claims 1 – 3, **characterised** in that the water-soluble polymer a copolymer, which consists of N-vinylformamide and vinylamine.  
20
5. Composition according to claim 1, **characterised** in that the composition comprises < 0.2 weight-% of surfactant, calculated from total weight of the composition.  
25
6. Composition according to claim 1, **characterised** in that the amount of water-soluble polymer in the composition is at least 30 weight-%, preferably at least 70 weight-%, more preferably at least 85 weight-%, calculated from the total weight of the dry composition.  
30
7. Method for treating of fibre stock in manufacture of paper, board or the like, where
  - obtaining a thick fibre stock ,
  - diluting the thick fibre stock to a thin fibre stock having a consistency < 3 % by addition of water,

- draining the thin fibre stock and forming a continuous fibrous web,  
**characterised in**

adding to the thick fibre stock or to the thin fibre stock a papermaking agent composition which comprises a water-soluble polymer, comprising 21 – 39 mol-%

5 of vinylamine units and having an average molecular weight of at least 1 000 000 Da.

8. Method according to claim 7, **characterised** in adding the papermaking agent composition comprising water-soluble polymer comprising vinylamine units to the

10 thick fibre stock.

9. Method according to claim 7, **characterised** in adding the papermaking agent composition comprising water-soluble polymer comprising vinylamine units to the thin fibre stock after the last shear stages and before the headbox.

15

10. Method according to claim 7, **characterised** in adding to the fibre stock cationic copolymer of acrylamide, preferably sequentially, with the papermaking agent composition comprising water-soluble polymer comprising vinylamine units.

20 11. Method according to any of preceding claim 7 – 10, **characterised** in adding anionic copolymer of acrylamide and/or microparticles to the fibre stock, preferably after the addition of the papermaking agent composition comprising water-soluble polymer comprising vinylamine units.

25 12. Method according to any of preceding claim 7 – 11, **characterised** in that the fibre stock comprises fibres originating from recycled paper, old corrugated containerboard (OCC), unbleached kraft pulp, neutral sulphite semi chemical (NCCS) pulp and/or mechanical pulp.

30 13. Method according to claim 7, **characterised** in adding the papermaking agent composition comprising polymer comprising vinylamine units to the thick fibre stock in such amount of that the amount of the said polymer is 50 – 1500 g/ton

produced paper, preferably 100 – 900 g/ton produced paper, more preferably at least 400 – 800 g/ton produced paper.

14. Method according to claim 7, **characterised** in that before the addition of the  
5 papermaking agent composition to the fibre stock the zeta-potential of the fibre  
stock is -15 – -1 mV, preferably -10 – -1, more preferably -7 – -1 mV.

15. Method according to claim 7, **characterised** in that after the addition of the  
10 papermaking composition comprising polymer comprising vinylamine units to the  
fibre stock the zeta-potential of the fibre stock is < 0 mV, preferably -10 – -1 , more  
preferably -8 – -1 mV.

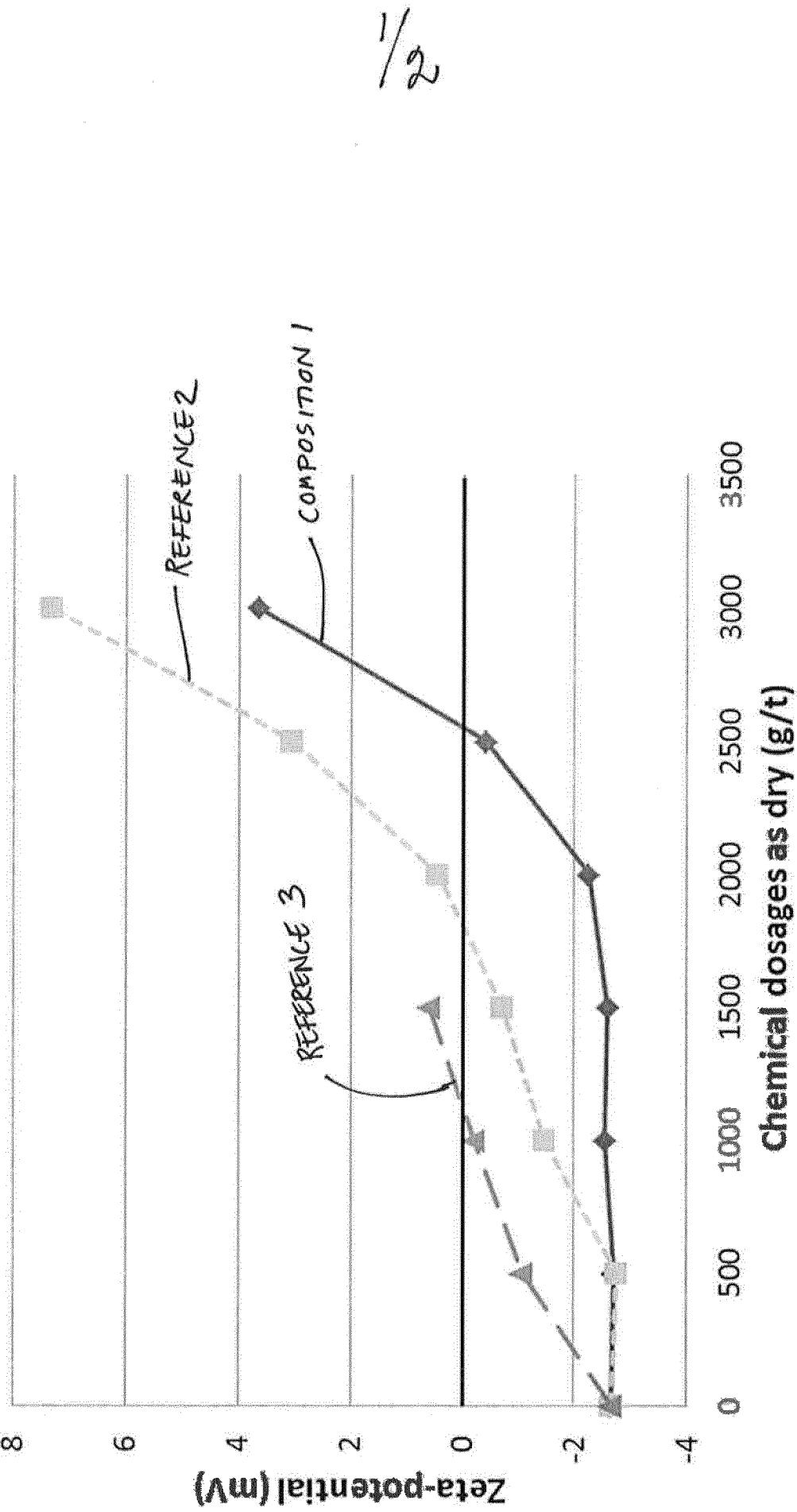


FIG. 1

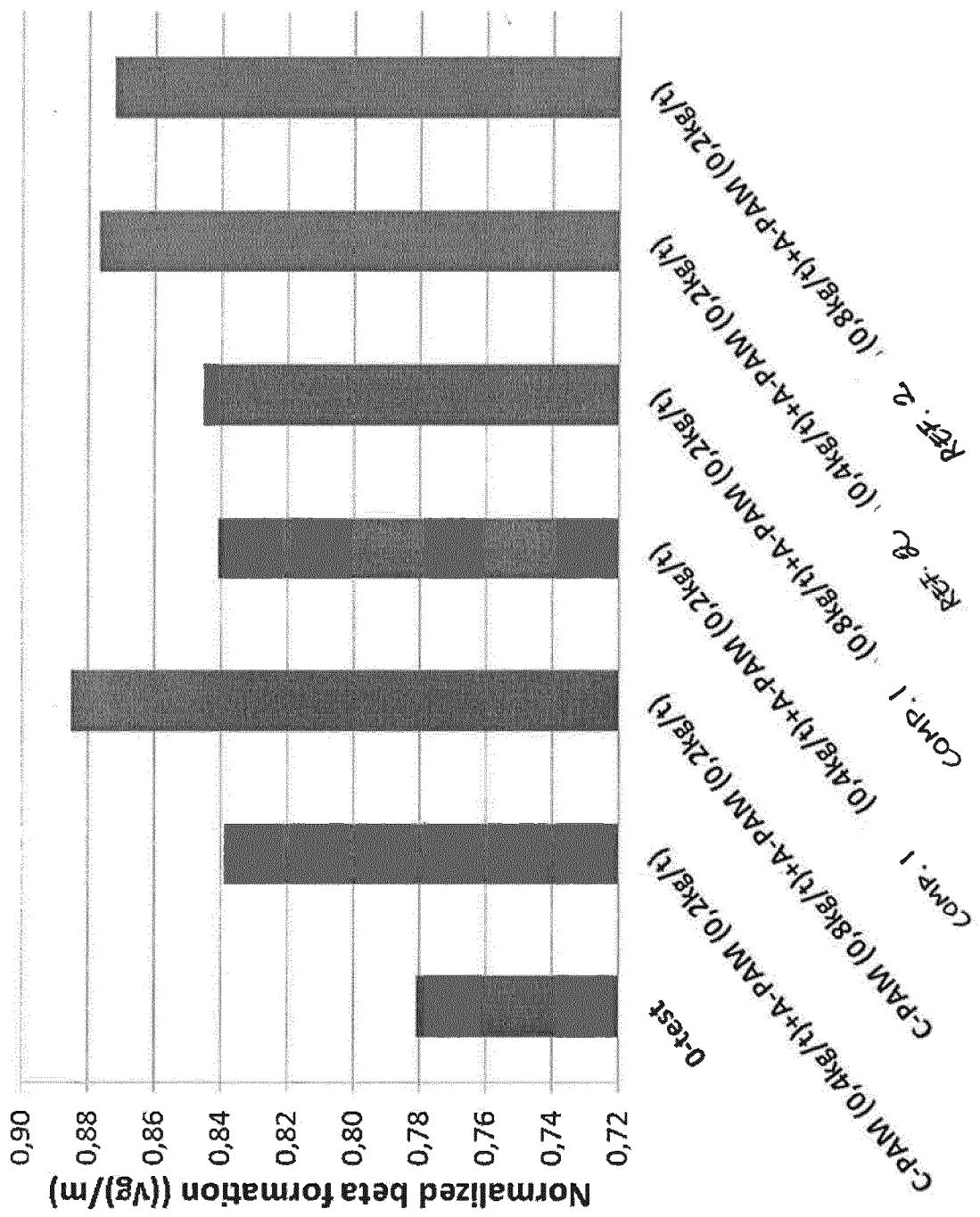


FIG. 2

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**SEARCH REPORT**

<b>PATENT APPLICATION No.</b>		<b>CLASSIFICATION</b>	
20145063		Int.Cl. <b>D21H 17/34</b> (2006.01) <b>D21H 21/10</b> (2006.01) <b>D21H 21/18</b> (2006.01) <b>D21H 11/14</b> (2006.01)	CPC <b>D21H 17/34</b> <b>D21H 21/10</b> <b>D21H 21/18</b> <b>D21H 11/14</b>
<b>PATENT CLASSES SEARCHED</b> (classification systems and classes)			
IPC: D21H, C08F, C08L			
<b>DATABASES CONSULTED DURING THE SEARCH</b>			
EPO-Internal, WPI, XPESP, XPRD			

**DOCUMENTS CONSIDERED TO BE RELEVANT**

<b>Category*)</b>	<b>Bibliographic data on the document and relevant passages</b>	<b>Relevant to claims</b>
X	US 2008000601 A1 (LEDUC MARC [DE] et al.) 03 January 2008 (03.01.2008) claims 1-6; paragraphs [0016]-[0043], [0049], examples	1, 2, 4-15
X	US 2008196852 A1 (LEDUC MARC [DE] et al.) 21 August 2008 (21.08.2008) claims 1-9; paragraphs [0018]-[0050], examples	1, 2, 4-15
X	EP 0331047 A1 (AIR PROD & CHEM [US]) 06 September 1989 (06.09.1989) claims 1, 9, 15; examples 11, 12	1-7, 13-15
A	US 2007181274 A1 (ESSER ANTON [DE] et al.) 09 August 2007 (09.08.2007) claims 1, 9; paragraph [0016], examples	

 1 **Continued on the next sheet** 

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 Further information given in the annex 

<b>Date</b> 21.08.2014	<b>Senior Patent Examiner</b> Heimo Koskinen
	<b>Telephone</b> (09) 6939 5355