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EP 2 137 346 B1

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(54) **LOOP MATERIAL FOR LOOP AND HOOK TYPE FASTENER USED IN A DISPOSABLE ARTICLE OR GARMENT**

SCHLINGENMATERIAL FÜR KLETTVERSCHLUSS ZUR VERWENDUNG FÜR EINEN
EINWEGARTIKEL ODER EIN EINWEGKLEIDUNGSSTÜCK

MATÉRIAU DE BOUCLE POUR FIXATION DE TYPE BOUCLES ET CROCHETS POUR ARTICLE
OU VÊTEMENT JETABLE

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EP 2 137 346 B1

DescriptionField of the Invention

5 **[0001]** The present invention is directed to a loop material for a loop and hook type fastener used in a disposable article or garment.

Background of the Invention

10 **[0002]** The use of hook and loop fastener devices in consumer and industrial applications is widely known. Examples of such applications include disposable hygiene absorbent articles such as diapers, disposable garments such as surgical gowns, and the like.

15 **[0003]** In general, a hook and loop fastener device comprises a hook component and a loop component. The hook component includes a plurality of hook-shaped members anchored to a base material. The loop component includes a plurality of upstanding loop members projecting outwardly from a backing material. The hook-shaped members are designed to engage the loop members in order to provide a strong mechanical bond there between. The hook members and the loop members can typically be engaged and disengaged repeatedly.

20 **[0004]** However, when the hook and loop fastener device is intended to be used in a disposable hygiene absorbent article or a disposable garment, a low cost loop component, which adequately functions to provide a resealable mechanical closure for a limited number of applications, is desirable. There is no need for the loop component of a disposable article to possess long term capability for repetitious engagements and disengagements with the hook component because such articles only have a short life span. However, the loop component used in conjunction with the hook component should provide a relatively high peel strength, and a relatively high shear strength, i.e. it should secure closure for a limited number of use cycles.

25 **[0005]** US 2003/0077430 relates to a nonwoven laminate material for mechanical closure systems that comprises at least one layer of a polyolefin endless filament nonwoven fabric and a second layer of nonwoven fabric that is bonded to the first layer. The second layer includes a sheet of crimped staple fibers.

30 **[0006]** US 2005/0208259 relates to a loop material for mechanical closure systems, said loop material comprising a layer of fibers lying on a flexible sheet-form substrate. The fibers are disposed in discrete fastening regions of the substrate.

35 **[0007]** US 5 326 612 A1 relates to a female component for a hook and loop fastener. Said female component comprises a nonwoven web secured to a backing, said nonwoven having a basis weight comprised between 6 and 42 g/m² and said nonwoven may comprise a carded web or a spunbond web.

40 **[0008]** US 6 770 065 B1 relates to a female material for a hook and loop fastener, said female material is made of a nonwoven fabric having a basis weight comprised between 20 and 80 g/m², said nonwoven comprising fibers having a fineness of 4 to 15 deniers.

45 **[0009]** JP 2002/315607 relates to a female material for a hook and loop fastener, said female material comprises a base material sheet made of a thermoplastic resin and a nonwoven fabric, both being partly ultrasonic welded.

50 **[0010]** US 2006/0019572 relates to a female material for a hook and loop fastener, said loop material comprising a binder-free nonwoven material having a bottom layer and a top layer, said nonwoven may further be island bonded via hot-roll calendering thereby forming a bonded area and a non-bonded area.

55 **[0011]** There are a variety of loop materials available. Typical loop materials include knit or nonwoven fabrics laminated to a layer of film for support. These loop materials are typically processed on diaper lines by unwinding the material from a roll, applying adhesive to the back, film side of the loop material, feeding the material over a perforated metal cylinder which holds the material in place with vacuum suction, cutting the material in strips as it is held against the cylinder and applying the strips to diaper backsheet material that is fed in parallel through the diaper assembly line.

60 **[0012]** Polypropylene is preferred for production of nonwoven materials for diaper applications due to their relatively low cost, soft feel, availability, and ease of processing. For nonwoven loop materials it would be desirable to eliminate the use of a film support layer in order to further reduce the cost and improve the softness and flexibility of the loop material.

65 **[0013]** However, several problems have been encountered which have limited the use of nonwovens for use as loop fastening materials. These will be discussed in turn.

70 **[0014]** Typical nonwoven materials are too air permeable. Such high permeability materials cannot be held in place effectively during the strip cutting operation on the typical existing diaper line vacuum cylinders. In order to use such highly permeable materials, extensive modification to the vacuum cylinders and associated equipment would be required.

75 **[0015]** Typical polypropylene based nonwovens are susceptible to compression. When nonwoven loop materials are wound into rolls and stored for a period of time, the loop regions can become permanently compressed. When a roll of nonwoven loop material is unwound, processed on the diaper line and pieces are cut and attached to the diaper backsheet, the loop may be so flat as to no longer to be useful as an effective fastening material.

80 **[0016]** The nonwoven fibers and filaments must be bonded together to secure the structure together as well as to

leave regions of unbonded fibers or loops available for fastening with a hook counterpart. If an insufficient percentage of the planar area of the nonwoven is bonded together, nonwoven fibers can be easily pulled free from the structure upon retraction of the hook when opening the fastener. If too high a percentage of the planar area of the nonwoven is bonded together there is insufficient loop fiber available for hook engagement and the fastening performance is too low. In addition, the bonding pattern has a large impact on the ease of hook engagement and therefore the fastening performance.

[0017] There is a need for low cost nonwovens for use as a loop fastening material for use in hygiene applications such as diapers that overcome these problems.

Summary of the Invention

[0018] A loop material for a hook and loop type fastener is a composite nonwoven according to appended claim 1.

Description of the Drawings

[0019] For the purpose of illustrating the invention, there is shown in the drawings a form that is presently preferred; it being understood, however, that this invention is not limited to the precise arrangements and instrumentalities shown.

Figure 1 is a cross sectional view of the nonwoven composite made according to the present invention.

Figure 2 is a top plan view of one of the embodiments of the nonwoven composite made according to the present invention.

Figure 3 is a top plan view of one of the embodiments of the nonwoven composite made according to the present invention.

Figure 4 is a top plan view of "islands".

Figure 5 is a schematic illustration of a method of manufacturing the present invention.

Figure 6 is an illustration associated with the example below.

Description of the Invention

[0020] Referring to the drawing wherein like numerals indicate like elements, there is shown in Figure 1 an embodiment of the nonwoven composite 10. Nonwoven composite 10 includes a loop layer 12, a backing layer 14, and a plurality of bond regions 16. Each of these elements will be discussed in greater detail below.

[0021] Nonwoven composite 10 is intended to be the loop component of a hook and loop type fastener (not shown) for a disposable article/garment. Disposable article/garment includes disposable hygiene absorbent articles (such as diapers), and disposable garments (such as surgical gowns). Disposable, generally, refers to single use.

[0022] In the composite nonwoven 10, loop layer 12 and backing layer 14 are in face-to-face contact and are joined together at bond regions 16. Nonwoven composite 10 may include at least two different nonwoven materials. The loop layer 12 in the non-bonded areas forms a 'mound' whereby the loop layer nonwoven is open and adapted for hook engagement. The loop layer 12 in the bonded areas is flat whereby the loop layer is closed and not adapted for hook engagement. The total air permeability of the composite nonwoven 10 should not exceed 1500 l/m²/s. In one embodiment, the permeability should not exceed 1300 l/m²/s. In another embodiment, the permeability should be at 800 l/m²/s. The upper limits on permeability represent a threshold where the composite nonwoven functions well in a diaper manufacturing process (as discussed above), and the lower limit represents a threshold where the composite nonwoven has sufficient suppleness (i.e., does not feel stiff like a film). Permeability is measured using an Air Permeability Tester III, Model FX 3300 from Textest AG of Zurick, Switzerland.

[0023] Loop layer 12 is adapted to, among other things, engage the hooks (not shown) of the hook and loop type fastener. The loop layer 12 is a carded nonwoven made of thermoplastic crimped staple fibers. The staple fibers have a dTEX in the range of 1.5 to 6.0. The basis weight of the carded nonwoven is in the range of 10 to 35 g/m². Alternatively, the basis weight may be in the range of 18 to 27 g/m². Prior to its inclusion in the composite nonwoven 10, the carded nonwoven is non-bonded. The thermoplastic, as used herein, refers to any thermoplastic material. Thermoplastic materials include, but are not limited to, polyolefins, polyesters, nylons, and combinations thereof. Polyolefins include, but are not limited to: polyethylene, polypropylene, polybutene, polymethylpentene, copolymers thereof and blends thereof. Polyesters include, but are not limited to: PET, PBT, copolymers thereof and blends thereof. In one embodiment, the

thermoplastic material is polypropylene.

[0024] The backing layer 14 is adapted to, among other things, hold the fibers of the loop layer 12 in place, provide a surface so that the loop layer 12 may be secured to the article/garment (not shown), and facilitate assembly of the article/garment. The backing layer is a spunmelt nonwoven made of thermoplastic filaments. Spunmelt nonwoven, as used herein, refers to a nonwoven made by a spunmelt process. The spunmelt process is a combination of the spunbond (S) and meltblown (M) processes. The spunmelt nonwoven may have a structure of SM or SMS or SMMS or the like. The basis weight of the spunmelt nonwoven may be in the range of 5 to 30 g/m². Alternatively, the basis weight may be in the range of 11 to 17 g/m². The spunmelt nonwoven may be adjusted to reduce air permeability. Reduced air permeability is useful in the article/garment manufacturing process when the composite nonwoven is affixed to the article/garment. The backing layer 14, when produced, may be calendered before assembly of composite nonwoven 10. After this calendering, one side is "smooth," i.e., no dimples from the engraved roller. The smooth side may be an exposed side of the composite nonwoven 10 and may be printed thereon. The thermoplastic, as used herein, refers to any thermoplastic material. Thermoplastic materials include, but are not limited to, polyolefins, polyesters, nylons, and combinations thereof. Polyolefins include, but are not limited to: polyethylene, polypropylene, polybutene, polymethylpentene, copolymers thereof and blends thereof. Polyesters include, but are not limited to: PET, PBT, copolymers thereof and blends thereof. In one embodiment, the thermoplastic material is polypropylene.

[0025] Bond regions 16, as used herein, refers to the areas where the loop layer and the backing layer are joined together and where the nonwoven composite is substantially impermeable. 'Substantially impermeable' refers to the permeability relative to the non-bonded areas, where air may pass through the nonwoven composite. In the bonded areas, no air may pass (or no more than 5% of the air that would pass through the non-bonded area), whereas in the non-bonded areas air may pass through the nonwoven composite. The bond regions 16 may comprise about 35 to 55% of the surface area of the loop material. The bond regions 16 may comprise 40-50% of the surface area of the loop material. The bond regions 16 may be lines or waves (continuous or discontinuous) as illustrated, for example, in Figures 2, and 3; but are not "islands" 19 as illustrated, for example, in Figure 4. In one embodiment, the bond regions are disposed in the cross machine direction. Hooks (not shown) will not engage the nonwoven composite in the bonded areas, but the hooks will engage the nonwoven composite in the non-bonded areas. As noted in Figure 1, the combined height of the loop layer 12 and the backing layer 14 in the bonded areas is less than the height of the backing layer 14 in the non-bonded areas.

[0026] When the bond regions 16 are lines or waves, loop length is the distance between bond regions. Loop lengths in the loop material may be equal or substantially equal. Loop lengths, in the machine direction, may be 1-4 mm or 2-3 mm. The loop height is the distance between the backing layer 14 and the uppermost part of the loop layer 12. The loop height is substantially equal between non-bonded areas.

[0027] The composite nonwoven 10 is manufactured as follows, see Figure 5: A first web 20, spunmelt, is formed by extruding filaments from thermoplastic resin. This web is then consolidated by calendering. A second web 22 is produced by carding crimped staple fibers to produce a web that is not consolidated. The two webs are then superimposed (i.e., face-to-face). The resulting web composed of the two superimposed webs is passed through a hot calender 24 (roll 26 being, for example, an engraved roller, and roll 28 being, for example, a smooth roller) to achieve the following results: consolidation of the carded web by bonding the crimped staple fibers at multiple zones, joining both webs together along multiple bond zones. In the calendering process, the web bonding will be at or near the melting point of the thermoplastic polymer from which the nonwoven is produced. It is important to process at a temperature and pressure sufficient to allow the proper bonding of the webs together. Thereafter, the composite nonwoven is wound-up 30.

Example

Comparison of 180 Degree Peel Test Results

[0028] The 180 Degree Peel results are compared for composite nonwovens that were produced with a relatively low percentage of area bonding and a bonding pattern according to the present invention. Peel testing was conducted using a tensile tester, Model No. MTC Alliance RT/5 from MTS Systems Corporation of Eden Prairie, MN.

[0029] Master rolls of each composite nonwovens were produced using the bonding patterns, noted below, and then slit into rolls and wound at the same level of tension. One slit roll of each bond pattern was then stored for more than two weeks. Samples were then taken from similar sites within each roll and tested for 180 degree peel, see Figure 6.

[0030] The 180° peel strength test involves attaching a hook component to a loop component of a hook and loop fastening system and then peeling the hook component from the loop component at a 180° angle. The maximum load needed to disengage the two components is recorded in newtons.

Slit Sample Roll 1**[0031]**

- 5 SMS base layer: 14 g/m²
 Carded fiber top layer: 23 g/m²
 Bonded Area: 17.4%
 Engraving: Islands (See Figure 4)
- 10 180 Degree peel test conducted with the use of Aplix 94x prototype hook (13 mm wide tape with mushroom shaped hooks with a density of 385 hooks/cm²)
 Samples taken from roll 17 days after slitting master roll

Slit Sample Roll 2**[0032]**

- 15 SMS base layer: 14 g/m²
 Carded fiber top layer: 23 g/m²
 20 Bonded Area: 42%
 Engraving: Horizontal discontinuous waves (See Figure 3)
- 180 Degree peel test conducted with the use of Aplix 94x prototype hook (13 mm wide tape with mushroom shaped hooks with a density of 385 hooks/cm²)
 25 Samples taken from roll 21 days after slitting master roll

Slit Sample Roll 1

Sample Site	Master Roll	A	B	C	D
180 ° Peel, N*	5.6	3.5	3.0	4.4	2.8

Slit Sample Roll 2

Sample Site	Master Roll	A	B	C	D
180 ° Peel, N*	5.3	5.3	5.0	5.3	4.9
* average of ten data points					

Claims

1. A loop material for a hook and loop type fastener **characterized in that** it comprises:

a composite nonwoven consisting of

a loop layer of a non-bonded carded web of thermoplastic crimped staple fibers, said staple fibers being between 1.5 to 6.0 dTEX, and said carded web having a basis weight of between 10 and 35 g/m²;
 a backing layer of a spunmelt nonwoven having a basis weight of 5 to 30 g/m², said spunmelt nonwoven being made by a combination of a spunbond process and a meltblown process, said loop layer being superimposed face-to-face with said backing layer; and
 a plurality of bond regions joining said loop layer to said backing layer and rendering said bond regions substantially air impermeable, and
 said composite nonwoven having an air permeability not exceeding 1500 l/m²/s.

2. The loop material according to claim 1, **characterized in that** said thermoplastic crimped staple fibers are polypropylene crimped staple fibers.

3. The loop material according to claim 1 or claim 2, **characterized in that** said spunmelt nonwoven being a polypropylene spunmelt nonwoven.
- 5 4. The loop material according to any one of claims 1 to -3, **characterized in that** said bond regions comprises between 35 to 55% of a surface area of the loop material.
5. The loop material according to any one of claims 1 to -4, **characterized in that** said composite nonwoven has an air permeability not exceeding 1300 l/m²/s.
- 10 6. The loop material according to claim 5, **characterized in that** said composite nonwoven has an air permeability in the range of 800 to 1300 l/m²/s.
7. The loop material according to any one of claims 1 to -5, **characterized in that** said bond regions being in the form of continuous or discontinuous lines or waves.
- 15 8. The loop material according to claims 7, **characterized in that** said bond regions extend in a cross machine direction.
9. The loop material according to any one of claims 1 to-5, and 7, **characterized in that** a height of said bond region is less than the height of said backing layer.
- 20 10. The loop material according to claim 1, **characterized in that** substantially air impermeable being an air permeability of said bond region being no more than 5% of an air permeability of a non-bond region.
- 25 11. The loop material according to any one of claims 1 to -5, 7, 9, and 10 **characterized in that** a plurality of loops is formed in said loop layer between said bond regions, said loops extending away from said backing layer to a substantially equal height.
- 30 12. The loop material according to any one of claims 1-5, 7, 9, 10, and 11 **characterized in that** a loop length is a distance between bond regions, and said loop length is in the range of 1-4 mm.
- 35 13. The loop material according to any one of claims 1-5, 7, 9, 10, 11, and 12 **characterized in that** said backing layer has a basis weight of between 11 g/m² and 17 g/m².
14. The loop material according to claim 13 **characterized in that** said backing layer having a basis weight of 14 g/m².
- 40 15. A disposable article or garment **characterized in that** it comprises a hook and loop type fastener, said hook and loop type fastener comprising a loop material according to anyone of the claims 1 to 14.
16. A disposable article or garment according to claim 15, **characterized in that** said article or garment includes disposale hygiene articles, such as diapers, and surgical gowns.

Patentansprüche

- 45 1. Schlaufenmaterial für einen Klettverschluss, **dadurch gekennzeichnet, dass** es einen Verbundvliesstoff umfasst, bestehend aus
einer Schlaufenschicht aus einem nicht gebundenen kardierte Gewebe aus gekräuselten Stapelfasern, wobei die Stapelfasern zwischen 1,5 bis 6,0 dTEX aufweisen und das kardierte Gewebe ein Flächengewicht zwischen 10 und 35 g/m² aufweist,
50 einer Trägerschicht aus einem Spinnvliesstoff mit einem Flächengewicht von 5 bis 30 g/m², wobei der Spinnvliesstoff aus einer Kombination eines Spinnvliesverfahrens und eines Schmelzblasverfahrens hergestellt ist, wobei die Schlaufenschicht direkt mit der Trägerschicht überlagert ist, und
mehreren Bindungsregionen, die die Schlaufenschicht mit der Trägerschicht verbinden und die Bindungsregionen im Wesentlichen luftundurchlässig machen, und
55 wobei der Verbundvliesstoff eine Luftdurchlässigkeit aufweist, die 1.500 l/m²/s nicht übersteigt.
2. Schlaufenmaterial nach Anspruch 1, **dadurch gekennzeichnet, dass** die thermoplastischen gekräuselten Stapelfasern gekräuselte Polypropylen-Stapelfasern sind.

EP 2 137 346 B1

3. Schlaufenmaterial nach Anspruch 1 oder 2, **dadurch gekennzeichnet, dass** der Spinnvliesstoff ein Polypropylen-spinnvliesstoff ist.
- 5 4. Schlaufenmaterial nach einem der Ansprüche 1 bis 3, **dadurch gekennzeichnet, dass** die Bindungsregionen zwischen 35 bis 55 % eines Oberflächenbereiches des Schlaufenmaterials ausmachen.
5. Schlaufenmaterial nach einem der Ansprüche 1 bis 4, **dadurch gekennzeichnet, dass** der Verbundvliesstoff eine Luftdurchlässigkeit aufweist, die 1.300 l/m²/s nicht übersteigt.
- 10 6. Schlaufenmaterial nach Anspruch 5, **dadurch gekennzeichnet, dass** der Verbundvliesstoff eine Luftdurchlässigkeit im Bereich von 800 bis 1.300 l/m²/s aufweist.
7. Schlaufenmaterial nach einem der Ansprüche 1 bis 5, **dadurch gekennzeichnet, dass** die Bindungsregionen in Form von fortlaufenden oder unterbrochenen Linien oder Wellen vorliegen.
- 15 8. Schlaufenmaterial nach Anspruch 7, **dadurch gekennzeichnet, dass** sich die Bindungsregionen in einer Maschinenquerrichtung erstrecken.
9. Schlaufenmaterial nach einem der Ansprüche 1 bis 5 und 7, **dadurch gekennzeichnet, dass** eine Höhe der Bindungsregion kleiner ist als die Höhe der Trägerschicht.
- 20 10. Schlaufenmaterial nach Anspruch 1, **dadurch gekennzeichnet, dass** im Wesentlichen luftundurchlässig eine Luftundurchlässigkeit der Bindungsregion ist, die nicht mehr als 5 % einer Luftdurchlässigkeit einer Nichtbindungsregion beträgt.
- 25 11. Schlaufenmaterial nach einem der Ansprüche 1 bis 5, 7, 9 und 10, **dadurch gekennzeichnet, dass** mehrere Schlaufen in der Schlaufenschicht zwischen den Bindungsregionen ausgebildet sind, wobei die Schlaufen sich von der Trägerschicht auf eine im Wesentlichen gleiche Höhe weg erstrecken.
- 30 12. Schlaufenmaterial nach einem der Ansprüche 1 bis 5, 7, 9, 10 und 11, **dadurch gekennzeichnet, dass** eine Schlaufenlänge ein Abstand zwischen Bindungsregionen ist und die Schlaufenlänge in der Größenordnung von 1 bis 4 mm liegt.
- 35 13. Schlaufenmaterial nach einem der Ansprüche 1 bis 5, 7, 9, 10, 11 und 12, **dadurch gekennzeichnet, dass** die Trägerschicht ein Flächengewicht zwischen 11 g/m² und 17 g/m² aufweist.
14. Schlaufenmaterial nach Anspruch 13, **dadurch gekennzeichnet, dass** die Trägerschicht ein Flächengewicht von 14 g/m² aufweist.
- 40 15. Einwegartikel oder -bekleidungsstück, **dadurch gekennzeichnet, dass** es einen Klettverschluss umfasst, wobei der Klettverschluss ein Schlaufenmaterial nach einem der Ansprüche 1 bis 14 umfasst.
- 45 16. Einwegartikel oder -bekleidungsstück nach Anspruch 15, **dadurch gekennzeichnet, dass** der Artikel oder das Bekleidungsstück Einweghygieneartikel, wie z.B. Windeln, und OP-Kittel umfasst.

Revendications

- 50 1. Matériau à boucles pour une fixation de type à crochets et à boucles, **caractérisé en ce qu'il comprend :**
- un non-tissé composite se composant de
- une couche de boucles faite d'un voile cardé non lié de fibres coupées frisées thermoplastiques, lesdites fibres coupées étant entre 1,5 et 6,0 dTEX, et ledit voile cardé ayant un poids de base compris entre 10 et 35 g/m² ;
- 55 une couche de renfort faite d'un non-tissé filé fondu ayant un poids de base de 5 à 30 g/m², ledit non-tissé filé fondu ayant été fabriqué par une combinaison d'un procédé filé-lié et d'un procédé soufflé-fondu, ladite couche de boucles étant superposée face contre face avec ladite couche de renfort ; et
- une pluralité de régions de liaison joignant ladite couche de boucles à ladite couche de renfort et rendant lesdites régions de liaison sensiblement imperméables à l'air, et

ledit non-tissé composite ayant une perméabilité à l'air n'excédant pas 1500 l/m²/s.

2. Matériau à boucles selon la revendication 1, **caractérisé en ce que** lesdites fibres coupées frisées thermoplastiques sont des fibres coupées frisées en polypropylène.
3. Matériau à boucles selon la revendication 1 ou la revendication 2, **caractérisé en ce que** ledit non-tissé filé fondu est un non-tissé filé fondu en polypropylène.
4. Matériau à boucles selon l'une quelconque des revendications 1 à 3, **caractérisé en ce que** lesdites régions de liaison comprennent entre 35 et 55 % d'une aire surfacique du matériau à boucles.
5. Matériau à boucles selon l'une quelconque des revendications 1 à 4, **caractérisé en ce que** ledit non-tissé composite a une perméabilité à l'air n'excédant pas 1300 l/m²/s.
6. Matériau à boucles selon la revendication 5, **caractérisé en ce que** ledit non-tissé composite a une perméabilité à l'air située dans la plage de 800 à 1300 l/m²/s.
7. Matériau à boucles selon l'une quelconque des revendications 1 à 5, **caractérisé en ce que** lesdites régions de liaison se présentent sous la forme de lignes ou de vagues continues ou discontinues.
8. Matériau à boucles selon la revendication 7, **caractérisé en ce que** lesdites régions de liaison s'étendent dans un sens transversal au sens machine.
9. Matériau à boucles selon l'une quelconque des revendications 1 à 5 et 7, **caractérisé en ce qu'une** hauteur de ladite région de liaison est inférieure à la hauteur de ladite couche de renfort.
10. Matériau à boucles selon la revendication 1, **caractérisé en ce que** sensiblement imperméable à l'air est une perméabilité à l'air de ladite région de liaison qui n'est pas supérieure à 5 % d'une perméabilité à l'air d'une région de non-liaison.
11. Matériau à boucles selon l'une quelconque des revendications 1 à 5, 7, 9 et 10, **caractérisé en ce qu'une** pluralité de boucles est formée dans ladite couche de boucles entre lesdites régions de liaison, lesdites boucles s'étendant depuis ladite couche de renfort à une hauteur sensiblement égale.
12. Matériau à boucles selon l'une quelconque des revendications 1 à 5, 7 et 9 à 11, **caractérisé en ce qu'une** longueur de boucle est une distance entre les régions de liaison, et ladite longueur de boucle est située dans la plage de 1 à 4 mm.
13. Matériau à boucles selon l'une quelconque des revendications 1 à 5, 7 et 9 à 12, **caractérisé en ce que** ladite couche de renfort a un poids de base compris entre 11 g/m² et 17 g/m².
14. Matériau à boucles selon la revendication 13, **caractérisé en ce que** ladite couche de renfort a un poids de base de 14 g/m².
15. Article ou vêtement jetable, **caractérisé en ce qu'il** comprend une fixation de type à crochets et à boucles, ladite fixation de type à crochets et à boucles comprenant un matériau à boucles selon l'une quelconque des revendications 1 à 14.
16. Article ou vêtement jetable selon la revendication 15, **caractérisé en ce que** ledit article ou vêtement comprend des articles d'hygiène jetables, tels que des couches, et des blouses chirurgicales.

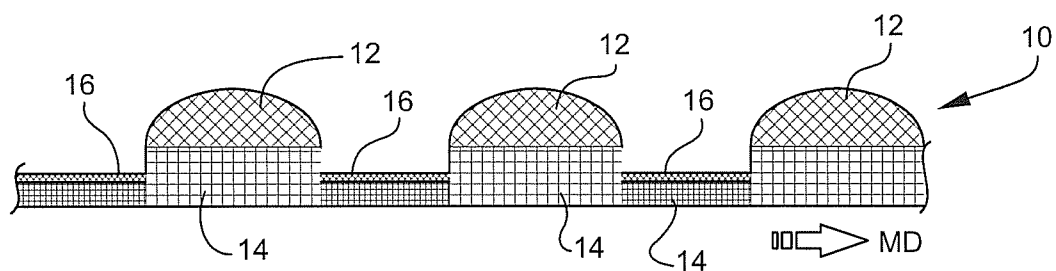


Fig. 1

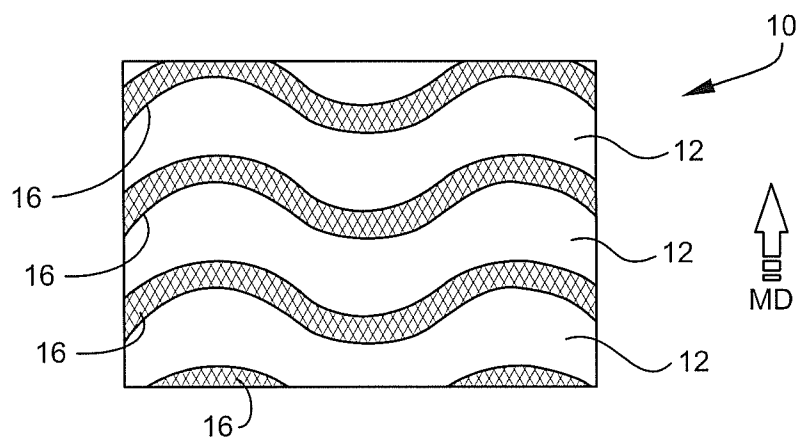


Fig. 2

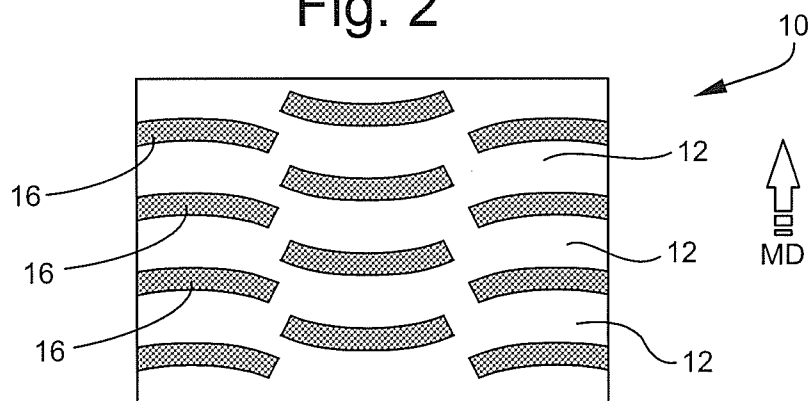


Fig. 3

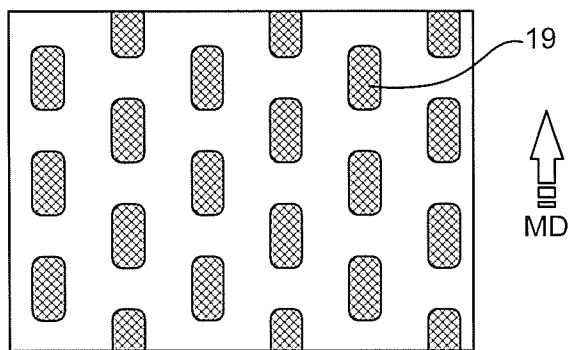


Fig. 4

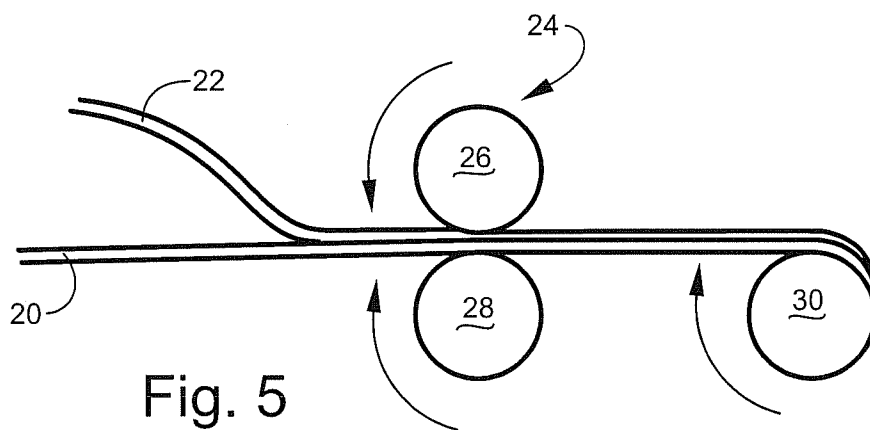


Fig. 5

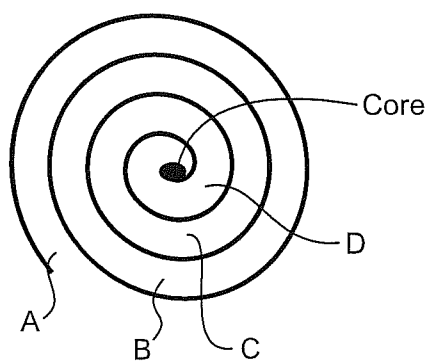


Fig. 6

REFERENCES CITED IN THE DESCRIPTION

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Hurkos anyag eldobható terméken vagy ruházaton használatos tépőzárhoz

Szabadalmi igénypontok

1. Hurkos anyag tépőzárhoz, azzal jellemezve, hogy tartalmaz

kompozit nemszótt kelmét, amely áll

hullámosított hőre lágyuló műanyag vágott szálak alkotta nemragasztott kártolt fátyol képezte hurkos rétegből, a vágott szálak 1,5 és 6,0 dTEX között vannak, továbbá a kártolt fátyol négyzetmétertömege 10-35 g/m²;

5-30 g/m² négyzetmétertömegű ömledéksodrott („spunmelt”) nemszótt kelme képezte alaprétegből, az ömledéksodrott nemszótt kelme sodorva-hurkolásos eljárás és ömledékfűvások eljárás kombinációjával van előállítva, a hurkos réteg és az alapréteg egymással szembenézően egymásra vannak fektetve; valamint

összekötő tartományokból, melyek a hurkos réteget az alapréteggel egyesítik és az összekötő tartományokat lényegében légátnemeresztővé teszik, továbbá

a kompozit nemszótt kelme légáteresztése legfeljebb 1500 l/m²/s.

2. Az 1. igénypont szerinti hurkos anyag, azzal jellemezve, hogy a hullámosított hőre lágyuló műanyag vágott szálakat hullámosított polipropilén vágott szálak képezik.

3. Az 1. vagy a 2. igénypont szerinti hurkos anyag, azzal jellemezve, hogy az ömledéksodrott nemszótt kelmét ömledéksodrott polipropilén nemszótt kelme képezi.

4. Az 1-3. igénypontok bármelyike szerinti hurkos anyag, azzal jellemezve, hogy az összekötő tartományok a hurkos anyag felületének 35-55%-át képezik.

5. Az 1-4. igénypontok bármelyike szerinti hurkos anyag, azzal jellemezve, hogy a kompozit nemszótt kelme légáteresztése legfeljebb 1300 l/m²/s.

6. Az 5. igénypont szerinti hurkos anyag, azzal jellemezve, hogy a kompozit nemszótt kelme légáteresztése a 800-1300 l/m²/s tartományban van.

7. Az 1-5. igénypontok bármelyike szerinti hurkos anyag, azzal jellemezve, hogy az összekötő tartományok összefüggő vagy nemösszefüggő vonalak vagy hullámok formájában vannak jelen.

8. A 7. igénypont szerinti hurkos anyag, azzal jellemezve, hogy az összekötő tartományok gépirányra keresztben terjednek.



SZTNH-100071932

9. Az 1-5. és a 7. igénypontok bármelyike szerinti hurkos anyag, **azzal jellemezve**, hogy az összekötő tartomány magassága az alapréteg magasságánál kisebb.

10. Az 1. igénypont szerinti hurkos anyag, **azzal jellemezve**, hogy a lényegében légátnemeresztő az összekötő tartományok egy nemösszekötő tartomány légáteresztése legfeljebb 5%-ának megfelelő légáteresztését jelenti.

11. Az 1-5., a 7., a 9. és a 10. igénypontok bármelyike szerinti hurkos anyag, **azzal jellemezve**, hogy a hurkos rétegben az összekötő tartományok között hurkok sokasága van kiképezve, a hurkok az alaprétegtől lényegében azonos magasságig terjednek.

12. Az 1-5., a 7., a 9., a 10. és a 11. igénypontok bármelyike szerinti hurkos anyag, **azzal jellemezve**, hogy egy hurokhossz egy az összekötő tartományok közötti távolságnak felel meg, továbbá a hurokhossz az 1-4 mm tartományban van.

13. Az 1-5., a 7., a 9., a 10., a 11. és a 12. igénypontok bármelyike szerinti hurkos anyag, **azzal jellemezve**, hogy az alapréteg négyzetmétertömege 11 g/m^2 és 17 g/m^2 között van.

14. A 13. igénypont szerinti hurkos anyag, **azzal jellemezve**, hogy az alapréteg négyzetmétertömege 14 g/m^2 .

15. Eldobható termék vagy ruházat, **azzal jellemezve**, hogy tépőzárt tartalmaz, amely tépőzár egy az 1-14. igénypontok bármelyike szerinti hurkos anyagot tartalmaz.

16. A 15. igénypont szerinti eldobható termék vagy ruházat, **azzal jellemezve**, hogy a tekintett termék vagy ruházat eldobható higiénia cikket, úgymint pelenkát és műtőköpenyeket foglal magában.