



Industria y Comercio
SUPERINTENDENCIA

PCT

SOLICITUD

PATENTE DE INVENCION

03-30682

21. EXPEDIENTE N°

54. TÍTULO UN METODO PARA ANCLAR LENGUETAS DE SUJECION A LAS PORCIONES LATERALES
DE UNA PRENDA DE VESTIR SANITARIA DESECHABLE Y UNA PRENDA DE VESTIR
SANITARIA DESECHABLE QUE COMPRENDE LENGUETAS DE SUJECION ANCLADAS
POR DICHO METODO

51. CLASIFICACIÓN INTERNACIONAL A61F 13/56

71. SOLICITANTE SCA HYGIENE PRODUCTS AB

DOMICILIO Goteborg, Suecia.

74. APODERADO EMILIO FERRERO
Código No. 1092

22. BOGOTÁ, D. C.

202037

42



13 030682 00

PETITORIO

Radicación : 03030682 00000000
Fecha (AMD) : 2003-04-10 17:21:11
Trámite : 011 PCT-PATENT 379 FASE NACI 411 PRESENTAC
Dependencia: 2020 DIVISION DE NUEVAS CREACIONES

FORMULARIO UNICO DE SOLICITUD DE PATENTE
PCT
ENTRADA EN FASE NACIONAL

1 SOLICITUD DE:			
☒ Patente de Invención. ☐ Patente de Modelo de Utilidad.			
☐ Capítulo I. ☒ Capítulo II.			
2 SOLICITANTE (71)	Nombre: SCA HYGIENE PRODUCTS AB sociedad constituida y existente bajo las leyes de Suecia. Dirección: 405 03 Göteborg, Suecia. Domicilio: Goteborg, Suecia.	IDENTIFICACION C.C. ☐ NIT ☐ C.E. ☐ Otro ☐ Cual _____ Número: _____	
3 REPRESENTANTE O APODERADO	Nombre: EMILIO FERRERO Dirección: Carrera 4ª. No. 72-35 Teléfono: 347 38 11 Fax:: 217 92 11 E-mail: clientes@camyp.com . Domicilio: Bogotá, Colombia.	IDENTIFICACION C.C. ☒ NIT ☐ C.E. ☐ Otro ☐ Cual _____ Número: <u>438.019</u> T.P. <u>31.929</u>	
4 INVENTOR (ES) (72)	Tomas GANDEMO Askims Domarringsväg 184, S-436 38 Askim, Suecia.		
5 PCT (86) Solicitud Internacional No. <u>PCT/SE01/01970</u> Fecha: <u>14 de septiembre de 2001</u> Publicación Internacional No. <u>WO 02/30345 A1</u> Fecha : <u>18 de abril de 2002</u>			
6 Título (54) <u>UN METODO PARA ANCLAR LENGUETAS DE SUJECION A LAS PORCIONES LATERALES DE UNA PRENDA DE VESTIR SANITARIA DESECHABLE Y UNA PRENDA DE VESTIR SANITARIA DESECHABLE QUE COMPRENDE LENGUETAS DE SUJECIÓN ANCLADAS POR DICHO METODO</u>			
7 Clasificación Internacional (51) <u>A61F 13/56</u>			
8 Prioridad SI ☒ NO ☐	(33) País de Origen <u>SE.</u>	(32) Fecha <u>13 de octubre de 2000</u>	(31) Número de Solicitud <u>0003703-6</u>

620 08/30345

9

Comprobante de pago No.: 03 - 24.573 Fecha: 7 de abril de 2003

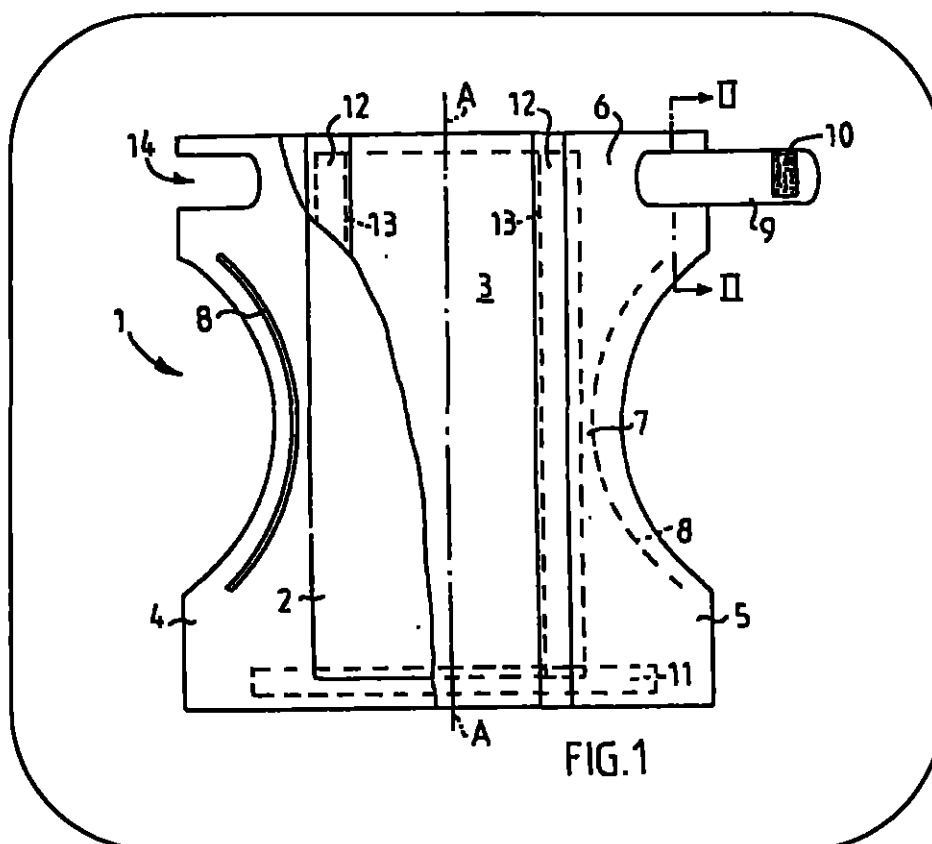
10

Anexos:

- ☒ Comprobante de pago de la tasa de presentación de la solicitud por \$ 400.000.00.
- ☐ Comprobante de pago por reivindicación de prioridad.
- ☒ Documento que acredita la existencia y representación legal cuando el solicitante sea persona jurídica.
- ☒ Poderes, si fuere el caso.
- ☐ Documento de cesión del inventor al solicitante o a su causante.
- ☐ Declaraciones.
- ☒ Copia de la solicitud internacional. (Resumen, descripción, reivindicaciones, dibujos)
- ☒ Traducción de la solicitud internacional al castellano. (Resumen, descripción, reivindicaciones, dibujos)
- ☒ Copia del examen preliminar efectuado por la IPEA.
- ☐ Traducción del examen preliminar efectuado por la IPEA.
- ☐ De ser el caso, copia del contrato de acceso.
- ☐ De ser el caso, documento que acredite la licencia o autorización de uso de conocimientos tradicionales de las comunidades indígenas.
- ☐ De ser el caso, certificado de depósito del material biológico.
- ☒ Arte final 12x12
- ☐ De ser el caso, información sobre otras solicitudes de patente o títulos obtenidos en el extranjero por el mismo titular o su causante, relacionadas parcial o totalmente con la invención de esta solicitud.
- ☐ Otros

11

FIGURA CARACTERISTICA:



12

Solicito la concesión de la patente,

NOMBRE: EMILIO FERRERO

FIRMA:



C.C. 438.019 de Usaquén T.P. 31.929

JBP/mrm-Id-708-

(10) International Publication Number
WO 02/30345 A1

- For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.*

(57) Abstract: The invention relates to a method of anchoring fastening tabs (9) to side portions of a disposable sanitary garment (1), such as a diaper or an incontinence guard. According to the invention the method includes the following steps; cutting out holes (14) in a backing sheet (4) in opposite side portions of the rear or front part thereof joining a top sheet (3) to the cut backing sheet with an absorbent body (2) disposed between these sheets, thereby creating a composite blank, placing fastening tabs (9) in the side portions of the composite blank containing the cut out holes in the backing sheet with the manufacturers ends of said tabs each being disposed in one of said holes, said tabs being made of a material which is compatible to the top sheet material from a welding point of view, and anchoring the manufacturers ends of the fastening tabs to the top sheet by welding. The invention also relates to a sanitary garment having fastening tabs affixed in accordance with said method.

WO 02/30345 A1

A method of anchoring fastening tabs to side portions of a disposable sanitary garment and a disposable sanitary garment comprising fastening tabs anchored by said method.

TECHNICAL FIELD

The present invention relates to a method of anchoring fastening tabs to side portions of a disposable sanitary garment, such as a diaper or an incontinence guard, said garment comprising a top sheet of liquid permeable, weldable material, a backing sheet of liquid impermeable material and an absorbent body enclosed therebetween, the top sheet and the backing sheet being extended outside the absorbent body around the periphery thereof and joined to each other in regions thereof lying outside the absorbent body, said garment having a front part, a rear part and an intermediate crotch part, wherewith laterally extending fastening tabs are fastened to the side portions in the rear or front part of the garment. The invention also relates to a disposable sanitary garment comprising fastening tabs anchored thereon by said method.

BACKGROUND OF THE INVENTION

In order to make the fastening tabs of disposable sanitary garments, such as diapers and incontinence guards, softer to the touch it is desirable to use non-woven material for such tabs. The risk for chafing is reduced if fastening tabs of materials softer than the materials commonly used for such tabs, e.g. polyethylene film, is used. It is also desirable to anchor the manufacturer's end of such tabs by weld joints instead of glue joints. The manufacturer's end of a fastening tab is the end thereof that is permanently fastened to a side portions of the garment by the manufacturer in contrast to the opposite end of the tab which is attached to a side portion of the garment by the user when applying the garment on a wearer. A weld joint can be made stronger than a glue joint and it exists for several reasons a general desire of reducing to a minimum the use of glue joints in manufacturing

lines for absorbent garments. However, since the materials used for the backing sheet and the top sheet usually are incompatible with each other from a welding point of view, i.e. have different melting points, it is a problem to weld fastening tabs of soft non-woven material onto the side portions of the garment due to the incompatibility of the tab material and the backing sheet material.

The object of the invention is to provide a disposable sanitary garment, such as a diaper or an incontinence guard, with fastening tabs of soft material, the manufacturer's ends of the tabs being anchored to the side portions of the garment by a weld joint.

SUMMARY OF THE INVENTION

These object are accomplished by a method of anchoring fastening tabs to side portions of a disposable sanitary garment, such as a diaper or an incontinence guard, said garment comprising a top sheet of liquid permeable, weldable material, a backing sheet of liquid impermeable material and an absorbent body enclosed therebetween, the top sheet and the backing sheet being extended outside the absorbent body around the periphery thereof and joined to each other in regions thereof lying outside the absorbent body, said garment having a front part, a rear part and an intermediate crotch part, wherewith laterally extending fastening tabs are fastened to the side portions in the rear or front part of the garment, characterised by the following steps;

cutting out holes in a backing sheet in opposite side portions of the rear or front part thereof,

between these sheets, thereby creating a composite blank, joining a top sheet to the cut backing sheet with an absorbent body disposed

placing fastening tabs in the side portions of the composite blank containing the cut out holes in the backing sheet with the manufacturer's ends of said tabs each being disposed in one of said holes, said tabs being made of a material which is compatible to the top sheet material from a welding point of view, and

anchoring the manufacturer's ends of the fastening tabs to the top sheet by welding.

In a preferred embodiment the cutting step consist of cutting successive rows of holes in a web of backing material which is continuously running in a machine direction.

In a first alternative the method includes the steps of laying a row of absorbent bodies on to the web of backing material, laying a web of top sheet material on the web of backing material, the web of top sheet material having the same width as the web of backing sheet material, joining the two webs together, thereby creating a continuous web of garment blanks, and thereafter welding fastening tabs to the side portions of the rear or front part of each garment blank.

In a second alternative the method includes the steps of laying a row of absorbent bodies on a continuously running web of top sheet material, the web of top sheet material having the same width as the web of backing sheet material, laying the web of backing material onto the web of top sheet material, joining the two webs together, thereby creating a continuous web of garment blanks, and thereafter welding fastening tabs to the side portions of the rear or front part of each garment blank.

In both alternatives the method preferably includes the steps of reinforcing the top sheet material in areas to which fastening tabs are anchored or are to be anchored, and anchoring the manufacturer's ends of the fastening tabs by ultra-sound welding

The invention is also related to a disposable sanitary garment, such as a diaper or an incontinence guard, comprising a top sheet of liquid permeable, weldable material, a backing sheet of liquid impermeable material and an absorbent body enclosed therebetween, the top sheet and the backing sheet being extended outside the absorbent body around the periphery thereof and joined to each other in regions thereof lying outside the absorbent body, said garment having a front part, a rear

part and an intermediate crotch part, wherewith fastening tabs are fastened to the side portions in the rear or front part of the garment, characterised in that the fastening tabs are made of a material which is compatible to the top sheet material from a welding point of view and that the backing sheet comprises cut-outs in the regions of the garment containing the manufacturer's ends of the fastening tabs such that no backing sheet material is present in those regions, and that the manufacturer's ends of the fastening tabs are fastened to the top sheet by weld joins.

In a preferred embodiment a strip of reinforcing material is attached to the top sheet in each region of the garment containing the manufacturer's end of a fastening tab. The top sheet consists of a non-woven material and the fastening tabs are made of a material containing the same type of fibres as the top sheet. Preferably, the top sheet and the fastening tabs are made of non-woven material containing polypropylene fibres and the manufacturer's end of the fastening tabs and the cut-outs in the backing sheet have a rounded shape, i.e. have no sharp corners. Furthermore, the backing sheet is extended a distance of 10-30 mm from the longitudinal side edge of each side portion in the rear or front part of the garment.

BRIEF DESCRIPTION OF THE DRAWING

The invention will now be described with reference to the enclosed drawing, in which;

Fig. 1 schematically shows a partially sectioned plan view of a diaper according to a preferred embodiment of the invention,

Fig.2 shows a cross-sectional view along line II-II of cross-section in Figure 1,

Fig. 3 shows a similar view as Figure 2 of a diaper according to a second embodiment of the invention,

Fig. 4 illustrates schematically a device for performing a first cutting step in the method according to the invention, and

Fig. 5 illustrates schematically a continuous web of backing sheet blanks.

DESCRIPTION OF EMBODIMENTS

In Figures 1 and 2 a disposable diaper 1 is disclosed. As is conventional in this field of the art, the diaper comprises an absorbent body 2, being enclosed between a liquid-permeable top sheet 3 and a liquid-impermeable backing sheet 4, these sheets being fastened to each other in portions thereof reaching beyond the absorbent body. The diaper has a front part 5, a rear part 6 and an intermediate crotch part 7, the longitudinal direction of the diaper extends from the rear to the front edge thereof. The diaper also comprises leg elastics 8, for example one or several elastic threads or bands disposed between the top sheet and the backing sheet along the sides of the diaper, at least in the crotch part thereof, and attached to the top sheet and/or backing sheet in a stretched state. In Figure 1 all elastic components are shown in a stretched state.

The diaper 1 also comprises fastening tabs 9 projecting out from the lateral sides of the diaper in the rear part thereof. Only one of these fastening tabs is disclosed in Figure 1. These fastening tabs have each a manufacturer's end which is permanently affixed to the respective side portion in the rear part of the diaper by the manufacturer of the diaper, and a user's end which is attached to a respective side portion in the front part of the diaper when the diaper is applied to a wearer by the person applying the diaper. The fastening tabs are provided with fastening elements 10, which in the disclosed embodiment consist of male fastener elements of a hooks and loops-type of fastener. The male elements 10 are engageable with female elements disposed on a band 11 attached to backing sheet on the outside thereof, i.e. the side of the backing sheet that is distal to the wearer during use of the diaper.

Preferably, the male fastening elements are distanced from the respective end of the tabs in order to provide grip portions for the user of the diaper.

Furthermore, barrier flaps 12 are provided on the top sheet and are attached thereto along their distal edges, i.e. the edges distal from the longitudinal symmetry line A-A of the diaper. Along the proximal edges of flaps 12 elastic threads 13 are attached thereto in a stretched state.

The fastening elements 10 are in the shown embodiment male fastener elements in fasteners of the hooks and loops type. Other types of mechanical fasteners can of course also be used, such as snap fasteners, buttons and holes and the like. It is also conceivable to use adhesive fasteners.

The liquid-permeable top sheet 3 is made of a soft skin-friendly material. Examples of suitable materials are different types of non-woven. Other material that can be used are perforated plastic films, plastic nets or knitted, crocheted or woven textile materials or combinations and laminates of the above mentioned types of material. The plastic material can be a thermoplastic material, for example polypropylene (PP). The non-woven material can be formed of synthetic fibres, such as PE, polypropylene (PP), polyurethane (PU), a polyester, nylon or regenerated cellulose, or a mix of different fibres. All materials used for top sheets in absorbent sanitary garments and containing weldable fibres can be used for the top sheet 3 and the above mentioned materials are only given as examples. The top sheet can also comprise different materials in central and side parts thereof. The parts of the top sheet 3 lying laterally outside the barrier flaps 12 can be made of a liquid impermeable material whereas the central part between the flaps 12 is made of a liquid permeable material.

The liquid-impermeable backing sheet 4 consists of a flexible material, preferably a thin plastic film of PE, PP or a polyester but could also consist of a laminate of a liquid-permeable material, such as a non-woven, and a liquid-impermeable material.

All materials that are used for liquid-impermeable backing sheets are conceivable. The backing sheet can advantageously be air-permeable.

The absorbent body 2 is preferably formed of cellulose fibres but also other natural materials, such as cotton fibres or peat can be used. Alternatively can absorbent synthetic fibres or a mixture of natural and synthetic fibres be used. The absorbent body can also comprise a super-absorbent, i.e. a polymer having the capacity to absorb liquid to an amount several times larger than its own weight. The absorbent body can also contain form stabilising and/or liquid dispersing components and also bonding agents for holding together short fibres and particles to a continuous unit. Furthermore, the absorbent body can contain more than one layer of absorbent material.

The fastening tabs 9 are made of one or several layers of non-woven material. Thereby a soft fastening tab is obtained which greatly reduces the risk of chafing against the skin of a wearer that exist for tabs made of harder material, such as a plastic film. Moreover, the fastening tabs 9 are attached to the top sheet 3 by weld joins. Such joins are desirable since they can be made stronger than glue joins. The fastening tabs 9 could advantageously be elastic in order to improve the comfort to the wearer in the waist area and to cope with the difference in waist size that appear when a wearer change from a sitting to a lying position. Such tabs are preferably made of two non-woven layers, between which strips of elastic material or several elastic threads have been attached in a stretched state, at least in the areas thereof between the manufacturer's and the user's ends. Examples of elastic bands that can be used are given in EP-A-494 941. Alternatively, the fibres in the non-woven material used for the fastening tabs could be elastic or be a mixture of elastic and non-elastic fibres.

It is often the case that the backing sheet material is not compatible with the top sheet material from a welding point of view, i.e. these materials have different melting points. This incompatibility leads to a problem when a fastening tab should

be fastened to the composite layer of backing sheet material and top sheet material by thermal welding, such as ultra sonic welding. This problem is solved in the present invention by providing cut-outs or holes 14 in the side portions of the backing sheet in the rear or front part of the diaper to which the fastening tabs 9 should be attached. Thereby, the material in the fastening tabs 9 need only be compatible from a welding point of view with the top sheet material and can consequently be chosen without consideration of the material that the backing sheet is made of. As is evident from the cross-sectional view in Figure 2, the weld join 15 is made in an area free of backing sheet material.

The cut-outs or holes 14 are preferably extending 10-30 mm from each longitudinal edge of the side portion of the rear part of the diaper 1 laterally towards each other, but can also as a whole be distanced from the longitudinal edges of the side portion of the rear part of the diaper 1 as long as the holes have a size equal to or larger than the manufacturer's end of the fastening tab. Preferably, the cut-outs and the manufacturer's ends of the tabs 9 have a rounded shape with no sharp corners in order to further reduce the risk for chafing. The total extension of the cut-outs in the lateral direction of the diaper could be up to half the maximum width of the diaper, but lies preferably between 20-40 mm. The extension of the cut-outs in the longitudinal direction of the diaper is smaller than the length of the longitudinal edge of the side portion containing the cut-out.

Figure 3 shows a similar view as Figure 2 of a diaper according to a second embodiment of the invention. This diaper is in most aspects similar to the diaper 1 shown in Figures 1 and 2 and the description of the embodiment according to these Figures is generally valid also for the diaper according to Figure 3. Therefore, components in Figure 3 corresponding to identical components of Figures 1 and 2 are given the same reference numerals with the addition of a prime sign. The only difference between the embodiments is that a reinforcing strip of material 16 is affixed to the top sheet 3' by a weld join 17 in the areas defined by cut-outs 14'. The strip of material 16 is made of a material compatible with the top sheet material

from a welding point of view, preferably from a material comprising the same type of fibres as the top sheet. By the use of reinforcing strips it is possible to reduce the thickness of the top sheet material and thereby reduce the material costs for the diaper.

The step of cutting cut-outs or holes in the backing sheet is easy to incorporate in a conventional line for continuous manufacturing of disposable diapers. In such a line, a first continuous web of backing sheet material or top sheet material is successively running through a device for coating the web with glue, a device for laying a row of absorbent bodies onto the web, a device for laying leg elastics on the web, a device laying a second web of top sheet material or backing sheet material onto the composite web consisting of the first web, the row of absorbent bodies and the leg elastics, a device for affixing fasteners, and a cutting device for making leg cut-outs and for cutting individual diapers out of the composite web. In Figure 4 is schematically shown a cutting device 18 for cutting two rows of holes 19 in the sides of a web 20 continuously running in a machine direction MD. The device 18 comprises a cutting roller 21 provided with knives 22 and an anvil roller 23, the web 20 passing between these rollers. If the first web is a web of backing sheet material, the device 18 is placed in the manufacturing line upstreams of the glue coating device and if the first web is a web of top sheet material, the cutting device 18 is placed outside the transport line for the first web and upstreams of the device for delivery of the second web onto the first web. The cutting of the web of backing sheet material can also be done in a separate line comprising a device for winding the cut web of backing sheet material onto a storage roller which in turn is used in a conventional line for manufacturing of diapers. In a manufacturing line according to the present invention the composite web passes an ultra sonic welding device for welding fastening elements onto the top sheet.

In Figure 5 a plan view of web according to Figure 4 is shown. By interrupted lines is shown how the backing sheet is cut in the final stage of an alternative manufacturing line. As is evident from this Figure, the holes 19 have an extension

also in the front part of the individual diapers cut out by this alternative way of manufacturing.

The embodiment described can of course be modified in several respects without leaving the scope of invention. For example, the holes or cut-outs in the side portions of the rear part of the disposable sanitary garment can have other shapes than disclosed. Other types of barrier flaps could be used and the end parts of such flaps can be used as reinforcing material instead of strip of material 16. Moreover, the side portions of the top sheet can be provided with reinforcement material in the whole area thereof. The fastenings tabs can be provided on the side of the top sheet being distal from the wearer instead of on the side being proximal thereto as in the shown embodiments. The absorbent body can have other shapes than the shown rectangular shape, for example an hour-glass shape. Furthermore, the fastenings tabs and thereby the cut-outs in the backing sheet could be disposed in the side portions of the front part of the garment instead of in the rear part as in the embodiments shown, even if this is not preferred. The diaper can also be provided with waist elastics of conventional type substituting or complementing elastic fastening tabs. The invention can also be used on other types of disposable sanitary garments, such as incontinence guards. The scope of invention shall therefore be determined only by the content of the enclosed patent claims.

CLAIMS

1. A method of anchoring fastening tabs (9) to side portions of a disposable sanitary garment (1), such as a diaper or an incontinence guard, said garment comprising a top sheet (3) of liquid permeable, weldable material, a backing sheet (4) of liquid impermeable material and an absorbent body (2) enclosed therebetween, the top sheet and the backing sheet being extended outside the absorbent body around the periphery thereof and joined to each other in regions thereof lying outside the absorbent body, said garment having a front part (5), a rear part (6) and an intermediate crotch part (7), wherewith laterally extending fastening tabs (9) are fastened to the side portions in the rear or front part of the garment, characterised by the following steps;
cutting out holes (14;19) in a backing sheet (4;20) in opposite side portions of the rear or front part thereof,
joining a top sheet (3) to the cut backing sheet with an absorbent body (2) disposed between these sheets, thereby creating a composite blank,
placing fastening tabs (9) in the side portions of the composite blank containing the cut out holes in the backing sheet with the manufacturer's ends of said tabs each being disposed in one of said holes, said tabs being made of a material which is compatible to the top sheet material from a welding point of view, and anchoring the manufacturer's ends of the fastening tabs to the top sheet by welding.
2. The method according to Claim 1, characterised by cutting successive rows of holes (14;19) in a web (4;20) of backing material which is continuously running in a machine direction (MD).
3. The method according to Claim 2, characterised by laying a row of absorbent bodies (2) on to the web (4;20) of backing material, laying a web (3) of top sheet material on the web of backing material, the web of top sheet material having the same width as the web of backing sheet material, joining the two webs

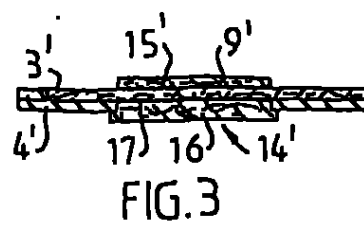
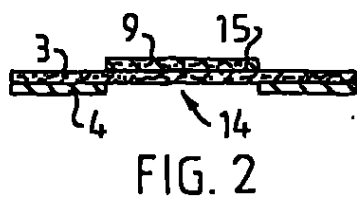
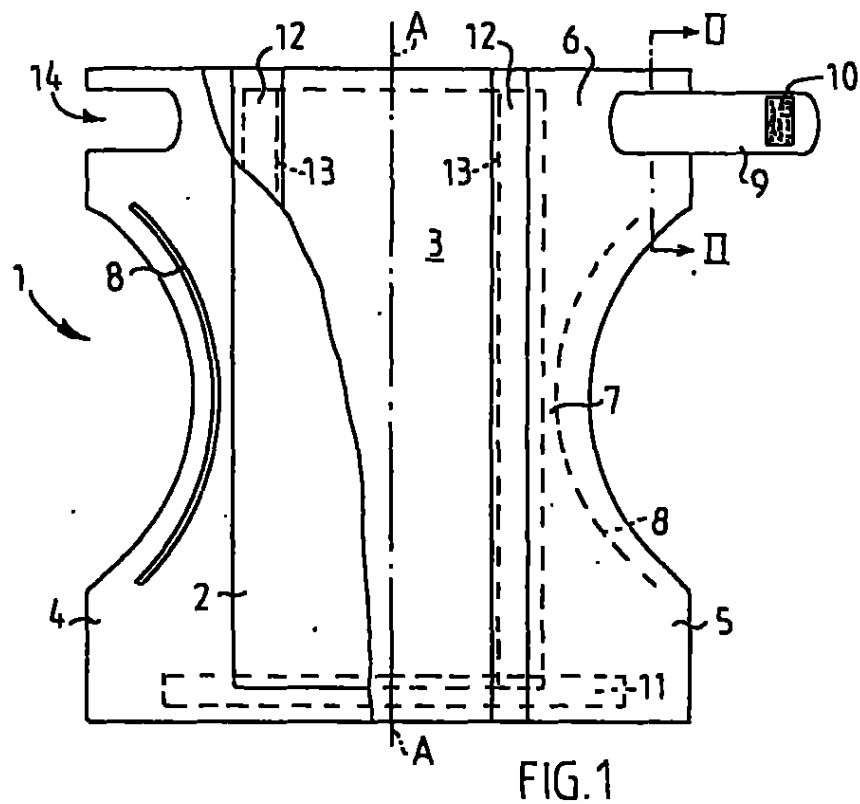
together, thereby creating a continuous web of garment blanks, and thereafter welding fastening tabs (9) to the side portions of the rear (6) or front part of each garment blank.

4. The method according to Claim 2, characterised by laying a row of absorbent bodies (2) on a continuously running web (3) of top sheet material, the web of top sheet material having the same width as the web (4;20) of backing sheet material, laying the web of backing material onto the web of top sheet material, joining the two webs together, thereby creating a continuous web of garment blanks, and thereafter welding fastening tabs (9) to the side portions of the rear (6) or front part of each garment blank.
5. The method according to Claim 1,2,3 or 4, characterised by reinforcing the top sheet material (3) in areas to which fastening tabs (9) are anchored or are to be anchored.
6. The method according to any one of Claims 1-5, characterised by anchoring the manufacturer's ends of the fastening tabs (9) by ultra-sound welding
7. A disposable sanitary garment (1), such as a diaper or an incontinence guard, comprising a top sheet (3) of liquid permeable, weldable material, a backing sheet (4) of liquid impermeable material and an absorbent body (2) enclosed therebetween, the top sheet and the backing sheet being extended outside the absorbent body around the periphery thereof and joined to each other in regions thereof lying outside the absorbent body, said garment having a front part (5), a rear part (6) and an intermediate crotch part (7), wherewith fastening tabs (9) are fastened to the side portions in the rear or front part of the garment, characterised in that the fastening tabs (9) are made of a material which is compatible to the top sheet material from a welding point of view and that the backing sheet (4) comprises cut-outs (14) in the regions of the garment containing the manufacturer's ends of the fastening tabs (9) such that no backing

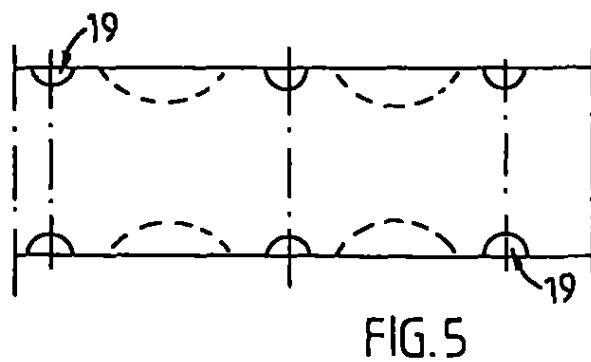
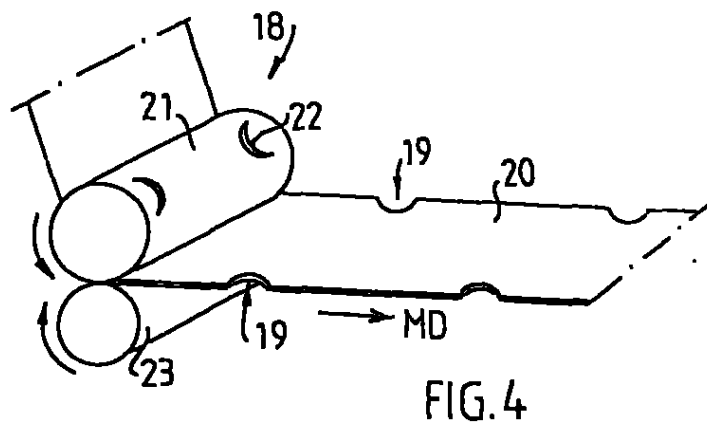
sheet material is present in those regions, and that the manufacturer's ends of the fastening tabs are fastened to the top sheet by weld joins (15).

8. The garment according to Claim 7, characterised in that a strip of reinforcing material (16) is attached to the top sheet (3') in each region of the garment containing the manufacturer's end of a fastening tab (9').
9. The garment according Claim 7 or 8, characterised in that the top sheet (3) consists of a non-woven material and that the fastening tabs (9) are made of a material containing the same type of fibres as the top sheet.
10. The garment according to Claim 9, characterised in that the top sheet (3) and the fastening tabs (9) are made of non-woven material containing polypropylene fibres.
11. The garment according to any one of Claims 7-10, characterised in that the manufacturer's end of the fastening tabs (9) and the cut-outs (14) in the backing sheet have a rounded shape, i.e. have no sharp corners.
12. The garment according to Claim 11, characterised in that the cut-outs (14) in the backing sheet (4) is extended a distance of 10-30 mm from the longitudinal side edge of each side portion in the rear (6) or front part of the garment (1).

1 / 2



2 / 2



INTERNATIONAL SEARCH REPORT

International application No.
PCT/SE 01/01970

A. CLASSIFICATION OF SUBJECT MATTER

IPC7: A61F 13/56

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)

IPC7: A61F, B32B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

WPI, EPODOC

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 5482588 A (DAVID J.K. GOULAIT ET AL), 9 January 1996 (09.01.96), column 6, line 1 - line 4; column 6, line 24 - line 34, figure 4, claims 2 and 4 --	1-12
A	WO 0001339 A1 (SCA HYGIENE PRODUCTS AB), 13 January 2000 (13.01.00), abstract -- -----	1-12



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent but published on or after the international filing date

"I" document which may throw doubt on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"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

"X" document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

8 February 2002

Date of mailing of the international search report

12 -02- 2002

Name and mailing address of the ISA:

Swedish Patent Office
Box 5055, S-102 42 STOCKHOLM

Facsimile No. +46 8 666 02 86

Authorized officer

Marie Karlsson/Els

Telephone No. +46 8 782 25 00

INTERNATIONAL SEARCH REPORT
Information on patent family members

27/12/02

International application No.

PCT/SE 01/01970

Patent document cited in search report			Publication date	Patent family member(s)		Publication date
US	5482588	A	09/01/96	AT	177933 T	15/04/99
				AU	2771595 A	15/01/96
				BR	9507991 A	05/08/97
				CA	2192178 A	28/12/95
				CN	1150752 A	28/05/97
				CZ	9603762 A	11/06/97
				DE	69508583 D,T	14/10/99
				EP	0766548 A,B	09/04/97
				SE	0766548 T3	
				ES	2129207 T	01/06/99
				FI	965167 A	20/12/96
				GR	3029797 T	30/06/99
				HK	1012964 A	00/00/00
				HU	9603531 D	00/00/00
				JP	10501716 T	17/02/98
				KR	198374 B	15/06/99
				NO	965484 A	21/02/97
				US	5578152 A	26/11/96
				US	5620432 A	15/04/97
				US	5681306 A	28/10/97
				WO	9535080 A	28/12/95
				ZA	9505100 A	06/06/96
WO	0001339	A1	13/01/00	AU	4948399 A	24/01/00
				EP	1094776 A	02/05/01
				SE	9802429 A	07/01/00
				TW	415839 B	00/00/00

PATENT COOPERATION TREATY

PCT

INTERNATIONAL SEARCH REPORT

(PCT Article 18 and Rules 43 and 44)

Applicant's or agent's file reference 60422-65175	FOR FURTHER ACTION see Notification of Transmittal of International Search Report (Form PCT/ISA/220) as well as, where applicable, item 5 below.
International application No. PCT/SE 01/01970	International filing date (day/month/year) 14 Sept 2001 (Earliest) Priority Date (day/month/year) 13 October 2000
Applicant SCA Hygiene Products AB	

This international search report has been prepared by this International Searching Authority and is transmitted to the applicant according to Article 18. A copy is being transmitted to the International Bureau.

This international search report consists of a total of 2 sheets.

☒ It is also accompanied by a copy of each prior art document cited in this report.

1. Basis of the report

a. With regard to the language, the international search was carried out on the basis of the international application in the language in which it was filed, unless otherwise indicated under this item.

☐ the international search was carried out on the basis of a translation of the international application furnished to this Authority (Rule 23:1(b)).

b. With regard to any nucleotide and/or amino acid sequence disclosed in the international application, the international search was carried out on the basis of the sequence listing:

☐ contained in the international application in written form.

☐ filed together with the international application in computer readable form.

☐ furnished subsequently to this Authority in written form.

☐ furnished subsequently to this Authority in computer readable form.

☐ the statement that the subsequently furnished written sequence listing does not go beyond the disclosure in the international application as filed has been furnished.

☐ the statement that the information recorded in computer readable form is identical to the written sequence listing has been furnished.

2. ☐ Certain claims were found unsearchable (See Box I).

3. ☐ Unity of invention is lacking (See Box II).

4. With regard to the title,

☒ the text is approved as submitted by the applicant.

☐ the text has been established by this Authority to read as follows:

5. With regard to the abstract,

☒ the text is approved as submitted by the applicant.

☐ the text has been established, according to Rule 38.2(b), by this Authority as it appears in Box III. The applicant may, within one month from the date of mailing of this international search report, submit comments to this Authority.

6. The figure of the drawings to be published with the abstract is Figure No. 1

☒ as suggested by the applicant.

☐ because the applicant failed to suggest a figure.

☐ because this figure better characterizes the invention.

☐ None of the figures.

INTERNATIONAL SEARCH REPORT

International application No.

PCT/SE 01/01970

A. CLASSIFICATION OF SUBJECT MATTER

IPC7: A61F 13/56

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)

IPC7: A61F, B32B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

WPI, EPODOC

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 5482588 A (DAVID J.K. GOULAIT ET AL), 9 January 1996 (09.01.96), column 6, line 1 - line 4; column 6, line 24 - line 34, figure 4, claims 2 and 4 --	1-12
A	WO 0001339 A1 (SCA HYGIENE PRODUCTS AB), 13 January 2000 (13.01.00), abstract -- -----	1-12

☐ Further documents are listed in the continuation of Box C.☒ See patent family annex.

* Special categories of cited documents:

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier application or patent but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

"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

"X" document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

8 February 2002

Date of mailing of the international search report

12-02-2002

Name and mailing address of the ISA/
Swedish Patent Office
Box 5055, S-102 42 STOCKHOLM
Facsimile No. +46 8 666 02 86

Authorized officer

Marie Karlsson/Els
Telephone No. +46 8 782 25 00

INTERNATIONAL SEARCH REPORT
Information on patent family members

27/12/02

International application No.

PCT/SE 01/01970

Patent document cited in search report			Publication date	Patent family member(s)		Publication date
US	5482588	A	09/01/96	AT	177933 T	15/04/99
				AU	2771595 A	15/01/96
				BR	9507991 A	05/08/97
				CA	2192178 A	28/12/95
				CN	1150752 A	28/05/97
				CZ	9603762 A	11/06/97
				DE	69508583 D,T	14/10/99
				EP	0766548 A,B	09/04/97
				SE	0766548 T3	
				ES	2129207 T	01/06/99
				FI	965167 A	20/12/96
				GR	3029797 T	30/06/99
				HK	1012964 A	00/00/00
				HU	9603531 D	00/00/00
				JP	10501716 T	17/02/98
				KR	198374 B	15/06/99
				NO	965484 A	21/02/97
				US	5578152 A	26/11/96
				US	5620432 A	15/04/97
				US	5681306 A	28/10/97
				WO	9535080 A	28/12/95
				ZA	9505100 A	06/06/96
WO	0001339	A1	13/01/00	AU	4948399 A	24/01/00
				EP	1094776 A	02/05/01
				SE	9802429 A	07/01/00
				TW	415839 B	00/00/00

PCT REQUEST

60422-65175

Original (for SUBMISSION) - printed on 14.09.2001 08:41:24 AM

0	For receiving Office use only	
0-1	International Application No.	
0-2	International Filing Date	
0-3	Name of receiving Office and "PCT International Application"	
0-4	Form - PCT/RO/101 PCT Request	
0-4-1	Prepared using	PCT-EASY Version 2.92 (updated 01.03.2001)
0-5	Petition The undersigned requests that the present international application be processed according to the Patent Cooperation Treaty	
0-6	Receiving Office (specified by the applicant)	Swedish Patent Office (RO/SE)
0-7	Applicant's or agent's file reference	60422-65175
I	Title of invention	A METHOD OF ANCHORING FASTENING TABS TO SIDE PORTIONS OF A DISPOSABLE SANITARY GARMENT AND A DISPOSABLE SANITARY GARMENT COMPRISING FASTENING TABS ANCHORED BY SAID METHOD
II	Applicant	
II-1	This person is:	applicant only
II-2	Applicant for	all designated States
II-4	Name	SCA HYGIENE PRODUCTS AB
II-5	Address:	S-405 03 Göteborg Sweden
II-6	State of nationality	SE
II-7	State of residence	SE
III-1	Applicant and/or inventor	
III-1-1	This person is:	inventor only
III-1-4	Name (LAST, First)	GANDEMO, Tomas
III-1-5	Address:	Askims Domarringsväg 184 S-436 38 Askim Sweden

19

IV-1	Agent or common representative; or address for correspondence The person identified below is hereby/has been appointed to act on behalf of the applicant(s) before the competent International Authorities as:	agent
IV-1-1	Name	ALBIHNS STOCKHOLM AB
IV-1-2	Address:	P.O.Box 5581 Linnégatan 2 S-114 85 Stockholm Sweden
IV-1-3	Telephone No.	+46 8 59 88 72 00
IV-1-4	Facsimile No.	+46 8 59 88 73 00
IV-1-5	e-mail	info@albihns.se
IV-2	Additional agent(s)	additional agent(s) with same address as first named agent
IV-2-1	Name(s)	HYLTNER, Jan-Olof; STEIN, Jan; HAMMAR, Ernst; BROLIN, Tommy
V	Designation of States	
V-1	Regional Patent (other kinds of protection or treatment, if any, are specified between parentheses after the designation(s) concerned)	AP: GH GM KE LS MW MZ SD SL SZ TZ UG ZW and any other State which is a Contracting State of the Harare Protocol and of the PCT EA: AM AZ BY KG KZ MD RU TJ TM and any other State which is a Contracting State of the Eurasian Patent Convention and of the PCT EP: AT BE CH&LI CY DE DK ES FI FR GB GR IE IT LU MC NL PT SE TR and any other State which is a Contracting State of the European Patent Convention and of the PCT OA: BF BJ CF CG CI CM GA GN GQ GW ML MR NE SN TD TG and any other State which is a member State of OAPI and a Contracting State of the PCT
V-2	National Patent (other kinds of protection or treatment, if any, are specified between parentheses after the designation(s) concerned)	AE AG AL AM AT AU AZ BA BB BG BR BY BZ CA CH&LI CN CO CR CU CZ DE DK DM DZ EC EE ES FI GB GD GE GH GM HR HU ID IL IN IS JP KE KG KP KR KZ LC LK LR LS LT LU LV MA MD MG MK MN MW MX MZ NO NZ PH PL PT RO RU SD SE SG SI SK SL TJ TM TR TT TZ UA UG UZ VN YU ZA ZW

PCT REQUEST

60422-85175

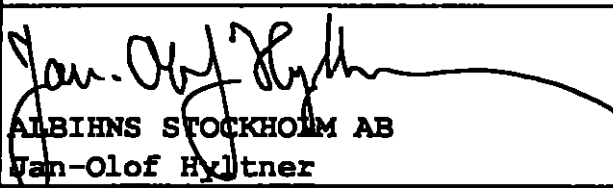
Original (for SUBMISSION) - printed on 14.09.2001 08:41:24 AM

V-6	Precautionary Designation Statement In addition to the designations made under items V-1, V-2 and V-3, the applicant also makes under Rule 4.9(b) all designations which would be permitted under the PCT except any designation(s) of the State(s) indicated under item V-6 below. The applicant declares that those additional designations are subject to confirmation and that any designation which is not confirmed before the expiration of 15 months from the priority date is to be regarded as withdrawn by the applicant at the expiration of that time limit.	
V-6	Exclusion(s) from precautionary designations	NONE
VI-1	Priority claim of earlier national application	
VI-1-1	Filing date	13 October 2000 (13.10.2000)
VI-1-2	Number	0003703-6
VI-1-3	Country	SE
VI-2	Priority document request The receiving Office is requested to prepare and transmit to the International Bureau a certified copy of the earlier application(s) identified above as item(s):	VI-1
VII-1	International Searching Authority Chosen	Swedish Patent Office (ISA/SE)
VII-2	Request to use results of earlier search; reference to that search	
VII-2-1	Date	13 October 2000 (13.10.2000)
VII-2-2	Number	se 00/01205
VII-2-3	Country (or regional Office)	SE
VIII	Declarations	Number of declarations
VIII-1	Declaration as to the identity of the inventor	-
VIII-2	Declaration as to the applicant's entitlement, as at the international filing date, to apply for and be granted a patent	-
VIII-3	Declaration as to the applicant's entitlement, as at the international filing date, to claim the priority of the earlier application	-
VIII-4	Declaration of inventorship (only for the purposes of the designation of the United States of America)	-
VIII-5	Declaration as to non-prejudicial disclosures or exceptions to lack of novelty	-

PCT REQUEST

60422-65175

Original (for SUBMISSION) - printed on 14.09.2001 08:41:24 AM

IX	Check list	number of sheets	electronic file(s) attached
IX-1	Request (including declaration sheets)	4	-
IX-2	Description	10	-
IX-3	Claims	3	-
IX-4	Abstract	1	EZABST00.TXT
IX-5	Drawings	2	-
IX-7	TOTAL	20	
	Accompanying items	paper document(s) attached	electronic file(s) attached
IX-8	Fee calculation sheet	✓	-
IX-17	PCT-EASY diskette	-	Diskette
IX-18	Other (specified):	Copy of ITS-Report and Official Action	-
IX-19	Figure of the drawings which should accompany the abstract	1	
IX-20	Language of filing of the international application	English	
X-1	Signature of applicant, agent or common representative		
X-1-1	Name	ALBIHNS STOCKHOLM AB	
X-1-2	Name of signatory	Jan-Olof Hyltner	

FOR RECEIVING OFFICE USE ONLY

10-1	Date of actual receipt of the purported international application	
10-2	Drawings:	
10-2-1	Received	
10-2-2	Not received	
10-3	Corrected date of actual receipt due to later but timely received papers or drawings completing the purported international application	
10-4	Date of timely receipt of the required corrections under PCT Article 11(2)	
10-5	International Searching Authority	ISA/SE
10-6	Transmittal of search copy delayed until search fee is paid	

FOR INTERNATIONAL BUREAU USE ONLY

11-1	Date of receipt of the record copy by the international Bureau	
------	--	--

PCT (ANNEX - FEE CALCULATION SHEET)

60422-65175

Original (for SUBMISSION) - printed on 14.09.2001 08:41:24 AM

(This sheet is not part of and does not count as a sheet of the International application)

0	For receiving Office use only			
0-1	International Application No.			
0-2	Date stamp of the receiving Office			
0-4	Form - PCT/RO/101 (Annex) PCT Fee Calculation Sheet Prepared using	PCT-EASY Version 2.92 (updated 01.03.2001)		
0-8	Applicant's or agent's file reference	60422-65175		
2	Applicant	SCA HYGIENE PRODUCTS AB		
12	Calculation of prescribed fees	fee amount/multiplier	total amounts (SEK)	
12-1	Transmittal fee T	⇒	1 200	
12-2	Search fee S	⇒	8 690	
12-3	International fee			
	Basic fee (first 30 sheets) b1	3 540		
12-4	Remaining sheets	0		
12-5	Additional amount (X)	80		
12-6	Total additional amount b2	0		
12-7	b1 + b2 = B	3 540		
12-8	Designation fees			
	Number of designations contained in International application	89		
12-9	Number of designation fees payable (maximum 6)	6		
12-10	Amount of designation fee (X)	760		
12-11	Total designation fees D	4 560		
12-12	PCT-EASY fee reduction R	-1 090		
12-13	Total International fee (B+D-R) I	⇒	7 010	
12-14	Fee for priority document			
	Number of priority documents requested	1		
12-15	Fee per document (X)	0		
12-16	Total priority document fee P	⇒	0	
12-17	TOTAL FEES PAYABLE (T+S+I+P)	⇒	16 900	
12-19	Mode of payment	cheque		

VALIDATION LOG AND REMARKS

13-2-1	Validation messages Request	Green? The title of the invention shall be short and precise. Please verify.
--------	--------------------------------	--

PCT (ANNEX - FEE CALCULATION SHEET)

60422-85175

Original (for SUBMISSION) - printed on 14.09.2001 08:41:24 AM

13-2-2	Validation messages States	Green? More designations could be made. The following States have not been designated: US. Please verify.
13-2-3	Validation messages Names	Yellow Applicant 1.:Street address missing
		Green? Applicant 1.:Telephone No. missing
		Green? Applicant 1.:Facsimile No. missing
13-2-7	Validation messages Contents	Yellow! The power of attorney or a copy of the general power of attorney will need to be furnished unless all applicants sign the request form. .
		Green? The abstract shall be as concise as the disclosure permits (preferably 50 to 150 words if it is in English or when translated into English).
13-2-10	Validation messages Annotate	Green? The name of the person signing the request or/and the capacity in which the person signs has/have not been indicated. Please be informed that some receiving Offices require that this information be present along with the signature.

24

PCT-EASY INFORMATION SHEET

(For applicant use only, DO NOT submit this sheet with the International application)

VALIDATION LOG

Green?	Request The title of the invention shall be short and precise. Please verify.
Green?	States More designations could be made. The following States have not been designated: US. Please verify.
Yellow	Names Applicant 1.:Street address missing
Green?	Applicant 1.:Telephone No. missing
Green?	Applicant 1.:Facsimile No. missing
Yellow!	Contents The power of attorney or a copy of the general power of attorney will need to be furnished unless all applicants sign the request form.
Green?	The abstract shall be as concise as the disclosure permits (preferably 50 to 150 words if it is in English or when translated into English).
Green?	Annotate The name of the person signing the request or/and the capacity in which the person signs has/have not been indicated. Please be informed that some receiving Offices require that this information be present along with the signature.

Before submitting the International Application, please carefully verify that:

- the information contained on printed Request form is correct;
- Box X of the Request form has been signed;
- all elements of the International application as indicated in Boxes VIII and IX of the Request form have been attached; and,
- the diskette containing the PCT-EASY zip file of the International Application has been enclosed and has been clearly labeled "PCT-EASY", with the applicant's or agent's file reference, and the first applicant's name.

ATTENTION

DO NOT modify any indications on the Request form printout. The electronic version of the PCT-EASY application has been locked. If an error or an omission is discovered at this time, you must reopen the stored form for submission, perform necessary amendments and immediately resubmit the form. Finally, a NEW submission diskette must be created manually by resending the corrected stored form to the diskette. The previously created printout and submission diskette must be destroyed in order to prevent the possibility of erroneously sending it to the RO.

PATENT COOPERATION TREATY

① 25

From the-

INTERNATIONAL PRELIMINARY EXAMINING AUTHORITY

To:

Jan-Olof Hyltner
 Alblhns Stockholm AB
 Box 5581
 S-114 85 Stockholm
 SUEDE

ANKOM

02 06 24

Resv.

JOH
BME

PCT

NOTIFICATION OF TRANSMITTAL OF
 THE INTERNATIONAL PRELIMINARY
 EXAMINATION REPORT
 (PCT Rule 71.1)

Date of mailing
 (day/month/year)

19.06.2002

Applicant's or agent's file reference
 60422-65175

IMPORTANT NOTIFICATION

International application No.
 PCT/SE01/01970

International filing date (day/month/year)
 14/09/2001

Priority date (day/month/year)
 13/10/2000

Applicant

SCA HYGIENE PRODUCTS AB

1. The applicant is hereby notified that this International Preliminary Examining Authority transmits herewith the international preliminary examination report and its annexes, if any, established on the international application.
2. A copy of the report and its annexes, if any, is being transmitted to the International Bureau for communication to all the elected Offices.
3. Where required by any of the elected Offices, the International Bureau will prepare an English translation of the report (but not of any annexes) and will transmit such translation to those Offices.

4. REMINDER

The applicant must enter the national phase before each elected Office by performing certain acts (filing translations and paying national fees) within 30 months from the priority date (or later in some Offices) (Article 39(1)) (see also the reminder sent by the International Bureau with Form PCT/IB/301).

Where a translation of the international application must be furnished to an elected Office, that translation must contain a translation of any annexes to the international preliminary examination report. It is the applicant's responsibility to prepare and furnish such translation directly to each elected Office concerned.

For further details on the applicable time limits and requirements of the elected Offices, see Volume II of the PCT Applicant's Guide.

Name and mailing address of the IPEA/



European Patent Office
 D-80289 Munich
 Tel. +49 89 2399-0 Tx: 523658 epmu d
 Fax: +49 89 2399-4485

Authorized officer

Jacobus Prues, S

Tel. +49 89 2399-6113



PCT

INTERNATIONAL PRELIMINARY EXAMINATION REPORT

(PCT Article 36 and Rule 70)

Applicant's or agent's file reference 60422-65175	FOR FURTHER ACTION See Notification of Transmittal of International Preliminary Examination Report (Form PCT/IPEA/416)	
International application No. PCT/SE01/01970	International filing date (day/month/year) 14/09/2001	Priority date (day/month/year) 13/10/2000
International Patent Classification (IPC) or national classification and IPC A61F13/56		
Applicant SCA HYGIENE PRODUCTS AB		
1. This international preliminary examination report has been prepared by this International Preliminary Examining Authority and is transmitted to the applicant according to Article 36. 2. This REPORT consists of a total of 4 sheets, including this cover sheet. ☐ This report is also accompanied by ANNEXES, i.e. sheets of the description, claims and/or drawings which have been amended and are the basis for this report and/or sheets containing rectifications made before this Authority (see Rule 70.16 and Section 607 of the Administrative Instructions under the PCT). These annexes consist of a total of sheets.		
3. This report contains indications relating to the following items: - I ☒ Basis of the report - II ☐ Priority - III ☐ Non-establishment of opinion with regard to novelty, inventive step and industrial applicability - IV ☐ Lack of unity of invention - V ☒ Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement - VI ☐ Certain documents cited - VII ☐ Certain defects in the international application - VIII ☐ Certain observations on the international application		
Date of submission of the demand 06/05/2002	Date of completion of this report 19.06.2002	
Name and mailing address of the international preliminary examining authority:  European Patent Office D-80286 Munich Tel. +49 89 2399 - 0 Tlx 523656 epmu d Fax: +49 89 2399 - 4465	Authorized officer De Crignis, G Telephone No. +49 89 2399 2332 	

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT**

International application No. PCT/SE01/01970

I. Basis of the report

1. With regard to the elements of the international application (*Replacement sheets which have been furnished to the receiving Office in response to an invitation under Article 14 are referred to in this report as "originally filed" and are not annexed to this report since they do not contain amendments (Rules 70.16 and 70.17)*):

Description, pages:

1-10 as published

Claims, No.:

1-12 as published

Drawings, sheets:

1/2-2/2 as published

2. With regard to the language, all the elements marked above were available or furnished to this Authority in the language in which the international application was filed, unless otherwise indicated under this item.

These elements were available or furnished to this Authority in the following language: , which is:

- ☐ the language of a translation furnished for the purposes of the international search (under Rule 23.1(b)).
- ☐ the language of publication of the international application (under Rule 48.3(b)).
- ☐ the language of a translation furnished for the purposes of international preliminary examination (under Rule 55.2 and/or 55.3).

3. With regard to any nucleotide and/or amino acid sequence disclosed in the international application, the international preliminary examination was carried out on the basis of the sequence listing:

- ☐ contained in the international application in written form.
- ☐ filed together with the international application in computer readable form.
- ☐ furnished subsequently to this Authority in written form.
- ☐ furnished subsequently to this Authority in computer readable form.
- ☐ The statement that the subsequently furnished written sequence listing does not go beyond the disclosure in the international application as filed has been furnished.
- ☐ The statement that the information recorded in computer readable form is identical to the written sequence listing has been furnished.

4. The amendments have resulted in the cancellation of:

- ☐ the description, pages:
- ☐ the claims, Nos.:

28

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT**

International application No. PCT/SE01/01970

- ☐ the drawings, sheets:
5. ☐ This report has been established as if (some of) the amendments had not been made, since they have been considered to go beyond the disclosure as filed (Rule 70.2(c)):
(Any replacement sheet containing such amendments must be referred to under item 1 and annexed to this report.)
6. Additional observations, if necessary:

V. Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement

1. Statement

Novelty (N)	Yes:	Claims	1 - 12
	No:	Claims	
Inventive step (IS)	Yes:	Claims	1 - 12
	No:	Claims	
Industrial applicability (IA)	Yes:	Claims	1 - 12
	No:	Claims	

**2. Citations and explanations
see separate sheet**

Re Item V

Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement

The application refers to a method of anchoring fastening tabs to a diaper and such a diaper (claim 1 and 7).

The most pertinent state of the art is represented by US-A-5,482,588 which discloses a one piece tape tab and which should have been acknowledged in the description. This document also can be considered as forming the preamble of the claim.

The problem was to avoid a glue joint in order to have a softer end in the fastening region.

The solution is to use a weld joint and to cut out the backsheet, thus there is less material in the fastening region and the touch is softer.

There is no such solution or hint in the available documents.

The demand must be filed directly with the competent International Preliminary Authority or, if two or more Authorities are competent, with the one chosen by the applicant. The full name or two-letter code of that Authority may be indicated by the applicant on the line below:

IPEA/ EPO

PCT

CHAPTER II

DEMAND

under Article 31 of the Patent Cooperation Treaty:

The undersigned requests that the international application specified below be the subject of international preliminary examination according to the Patent Cooperation Treaty and hereby elects all eligible States (except where otherwise indicated).

For International Preliminary Examination Authority use only

Identification of IPEA		Date of receipt of DEMAND	
Box No. I IDENTIFICATION OF THE INTERNATIONAL APPLICATION		Applicant's or agents file reference 60422-65175	
International application No. PCT/SE01/01970	International filing date (day/month/year) 14 September 2001 (14-09-2001)	(Earliest) Priority date (day/month/year) 13 October 2000 (13-10-2000)	
Title of invention A METHOD OF ANCHORING FASTENING TABS TO SIDE PORTIONS OF A DISPOSABLE SANITARY GARMENT AND A DISPOSABLE SANITARY GARMENT COMPRISING FASTENING TABS ANCHORED BY SAID METHOD			
Box No. II APPLICANT(S)			
Name and address: (Family name followed by given name; for a legal entity, full official designation. The address must include postal code and name of country.) SCA Hygiene Products AB S-405 03 GÖTEBORG Sweden		Telephone No.:	
		Facsimile No.:	
		Teleprinter No.:	
State (i.e. country) of nationality: SE		State (i.e. country) of residence: SE	
Name and address: (Family name followed by given name; for a legal entity, full official designation. The address must include postal code and name of country.)			
State (i.e. country) of nationality:		State (i.e. country) of residence:	
Name and address: (Family name followed by given name; for a legal entity, full official designation. The address must include postal code and name of the country.)			
State (i.e. country) of nationality:		State (i.e. country) of residence:	
☐ Further applicants are indicated on a continuation sheet.			

Box No. III AGENT OR COMMON REPRESENTATIVE; OR ADDRESS FOR CORRESPONDENCE

The following person is ☒ agent ☐ common representative

and ☒ has been appointed earlier and represents the applicant(s) also for international preliminary examination,

☐ is hereby appointed and any earlier appointment of (an) agent(s)/common representative is hereby revoked.

☐ is hereby appointed, specifically for the procedure before the International Preliminary Examination Authority, in addition to the agent(s)/common representative appointed earlier.

Name and address: *(Family name followed by given name; for a legal entity: full official designation. The address must include postal code and name of the country.)*

Jan-Olof Hyltner
Albihns Stockholm AB
Box 5581
S-114 85 Stockholm
Sweden

Telephone No.:

+46 8 59 88 72 00

Facsimile No.:

+46 8 59 88 73 00

Teleprinter No.:

☐ Address for correspondence: Mark this check-box where no agent or common representative is/has been appointed and the space above is used instead to indicate a special address to which correspondence should be sent.

Box No. IV BASIS FOR INTERNATIONAL PRELIMINARY EXAMINATION**Statement concerning amendments:***

1. The applicant wishes the international preliminary examination to start on the basis of:

☒ the international application as originally filed.

the description ☐ as originally filed
☐ as amended under Article 34

the claims ☐ as originally filed
☐ as amended under Article 19 (together with any accompanying statement)
☐ as amended under Article 34

the drawings ☐ as originally filed
☐ as amended under Article 34

2. ☐ The applicant wishes any amendment to the claims under Article 19 to be considered as reversed.

3. ☐ The applicant wishes the start of the international preliminary examination to be postponed until the expiration of 20 months from the priority date unless the International Preliminary Examination Authority receives a copy of any amendments made under Article 19 or a notice from the applicant that he does not wish to make such amendments (Rule 69.1(d)). *(This check-box may be marked only where the time limit under Article 19 has not yet expired).*

* Where no check-box is marked, international preliminary examination will start on basis of the international application as originally filed or, where a copy of amendments to the claims under Article 19 and/or amendments of the international application under Article 34 are received by the International Preliminary Examination Authority before it has begun to draw up a written opinion or the international preliminary examination report, as so amended.

Language for the purposes of international preliminary examination: ...English

☒ which is the language in which the international application was filed.

☐ which is the language of a translation furnished for the purposes of international search.

☐ which is the language of publication of the international application.

☐ which is the language of the translation (to be) furnished for the purposes of international preliminary examination

Box No. V ELECTION OF STATES

The applicant hereby elects all eligible States *(that is, all States which have been designated and which are bound by Chapter II of the PCT)*

excluding the following States which the applicant wishes not to elect:

Box No. VI CHECK LIST

The demand is accompanied by the following elements, in the language referred to in Box No. IV, for the purposes of international preliminary examination:

For International Preliminary Examination Authority use only

- | | | | |
|----|---|---|--------|
| 1. | translation of international application | : | sheets |
| 2. | amendments under Article 34 | : | sheets |
| 3. | copy (or, where required, translation) of amendments under Article 19 | : | sheets |
| 4. | copy (or, where required, translation) of statement under Article 19 | : | sheets |
| 5. | letter | : | sheets |
| 6. | other (specify) | : | sheets |

received	not received
----------	--------------

- | | |
|--------------------------|--------------------------|
| ☐ | ☐ |
| ☐ | ☐ |
| ☐ | ☐ |
| ☐ | ☐ |
| ☐ | ☐ |
| ☐ | ☐ |

The demand is also accompanied by the item(s) marked below:

- | | |
|--|---|
| 1. ☒ fee calculation sheet | 4. ☐ statement explaining lack of signature |
| 2. ☐ separate signed power of attorney | 5. ☐ nucleotide and or amino acid sequence listing in computer readable form |
| 3. ☐ copy of general power of attorney; reference number, if any: | 6. ☐ other (specify): |

Box No. VII SIGNATURE OF APPLICANT, AGENT OR COMMON REPRESENTATIVE

Next to each signature, indicate the name of the person signing and the capacity in which the person signs (if such capacity is not obvious from reading the demand)


Jan-Olof Hylander

For International Preliminary Examining Authority use only

1. Date of actual receipt of DEMAND:

2. Adjusted date of receipt of demand due to CORRECTIONS under rule 60.1(b):

- | | |
|--|---|
| 3. ☐ The date of receipt of the demand is AFTER the expiration of 19 months from the priority date and item 4 or 5, below, does not apply. | ☐ The applicant has been informed accordingly. |
| 4. ☐ The date of receipt of the demand is WITHIN the period of 19 months from the priority date as extended by virtue of rule 80.5. | |
| 5. ☐ Although the date of receipt of the demand is after the expiration of 19 months from the priority date, the delay in arrival is EXCUSED pursuant to Rule 82. | |

For International Bureau use only

Demand received from IPEA on:

PATENT COOPERATION TREATY

33

PCT

ANNO

10. 22

NOTIFICATION OF RECEIPT OF
RECORD COPY

(PCT Rule 24.2(a))

BME

From the INTERNATIONAL BUREAU

To:

ALBIHNS STOCKHOLM AB
P.O. Box 5581
Linnégatan 2
S-114 85 Stockholm
SUÈDE

Date of mailing (day/month/year) 15 October 2001 (15.10.01)	IMPORTANT NOTIFICATION
Applicant's or agent's file reference 60422-65175	International application No. PCT/SE01/01970

The applicant is hereby notified that the International Bureau has received the record copy of the international application as detailed below.

Name(s) of the applicant(s) and State(s) for which they are applicants:

SCA HYGIENE PRODUCTS AB (all designated States)

International filing date: 14 September 2001 (14.09.01)

Priority date(s) claimed: 13 October 2000 (13.10.00)

Date of receipt of the record copy
by the International Bureau: 28 September 2001 (28.09.01)

List of designated Offices:

AP : GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW
EA : AM, AZ, BY, KG, KZ, MD, RU, TJ, TM
EP : AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR
OA : BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG
National : AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ,
EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU,
LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PH, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ,
UA, UG, UZ, VN, YU, ZA, ZW

ATTENTION

The applicant should carefully check the data appearing in this notification. In case of any discrepancy between these data and the indications in the international application, the applicant should immediately inform the International Bureau.

In addition, the applicant's attention is drawn to the information contained in the Annex, relating to:

- time limits for entry into the national phase
- confirmation of precautionary designations (if applicable)
- requirements regarding priority documents (if applicable)

A copy of this notification is being sent to the receiving Office and to the International Searching Authority.

The International Bureau of WIPO 34, chemin des Colombettes 1211 Geneva 20, Switzerland	Authorized officer: Beate GIFFO-SCHMITT
Facsimile No. (41-22) 740.14.35	Telephone No. (41-22) 338.91.11

31

INFORMATION ON TIME LIMITS FOR ENTERING THE NATIONAL PHASE

The applicant is reminded that the "national phase" must be entered before each of the designated Offices indicated in the Notification of Receipt of Record Copy (Form PCT/IB/301) by paying national fees and furnishing translations, as prescribed by the applicable national laws.

The time limit for performing these procedural acts is 20 MONTHS from the priority date or, for those designated States which the applicant elects in a demand for international preliminary examination or in a later election, 30 MONTHS from the priority date, provided that the election is made before the expiration of 19 months from the priority date. Some designated (or elected) Offices have fixed time limits which expire even later than 20 or 30 months from the priority date. In other Offices an extension of time or grace period, in some cases upon payment of an additional fee, is available.

In addition to these procedural acts, the applicant may also have to comply with other special requirements applicable in certain Offices. It is the applicant's responsibility to ensure that the necessary steps to enter the national phase are taken in a timely fashion. Most designated Offices do not issue reminders to applicants in connection with the entry into the national phase.

For detailed information about the procedural acts to be performed to enter the national phase before each designated Office, the applicable time limits and possible extensions of time or grace periods, and any other requirements, see the relevant Chapters of Volume II of the PCT Applicant's Guide. Information about the requirements for filing a demand for international preliminary examination is set out in the PCT Applicant's Guide, Volume I, Chapter IX.

Note that only an applicant who is a national or resident of a PCT Contracting State which is bound by Chapter II has the right to file a demand for International preliminary examination (at present, all PCT Contracting States are bound by Chapter II).

CONFIRMATION OF PRECAUTIONARY DESIGNATIONS

This notification lists only specific designations made under Rule 4.9(a) in the request. It is important to check that these designations are correct. Errors in designations can be corrected where precautionary designations have been made under Rule 4.9(b). The applicant is hereby reminded that any precautionary designation may be confirmed according to Rule 4.9(c) before the expiration of 15 months from the priority date. If it is not confirmed, it will automatically be regarded as withdrawn by the applicant. There will be no reminder and no invitation. Confirmation of a designation consists of the filing of a notice specifying the designated State concerned (with an indication of the kind of protection or treatment desired) and the payment of the designation and confirmation fees. The Notice of confirmation and payment must reach the receiving Office within the 15-month time limit.

REQUIREMENTS REGARDING PRIORITY DOCUMENTS

For applicants who have not yet complied with the requirements regarding priority documents, the following is recalled.

Where the priority of an earlier national, regional or international application is claimed, the applicant must submit a copy of the said earlier application, certified by the authority with which it was filed ("the priority document") to the receiving Office (which will transmit it to the International Bureau) or directly to the International Bureau, before the expiration of 18 months from the priority date, provided that any such priority document may still be submitted to the International Bureau before that date of international publication of the international application, in which case that document will be considered to have been received by the International Bureau on the last day of the 18-month time limit (Rule 17.1(a)).

Where the priority document is issued by the receiving Office, the applicant may, instead of submitting the priority document, request the receiving Office to prepare and transmit the priority document to the International Bureau. Such request must be made before the expiration of the 18-month time limit and may be subjected by the receiving Office to the payment of a fee (Rule 17.1(b)).

If the priority document concerned is not submitted to the International Bureau or if the request to the receiving Office to prepare and transmit the priority document has not been made (and the corresponding fee, if any, paid) within the applicable time limit indicated under the preceding paragraphs, any designated State may disregard the priority claim, provided that no designated Office may disregard the priority claim concerned before giving the applicant an opportunity, upon entry into the national phase, to furnish the priority document within a time limit which is reasonable under the circumstances.

Where several priorities are claimed, the priority date to be considered for the purposes of computing the 18-month time limit is the filing date of the earliest application whose priority is claimed.

PATENT COOPERATION TREATY

35

PCT

From the INTERNATIONAL BUREAU

NOTIFICATION CONCERNING
SUBMISSION OR TRANSMITTAL
OF PRIORITY DOCUMENT

(PCT Administrative Instructions, Section 411)

To:

ALBIHNS STOCKHOLM AB
P.O. Box 5581
Linnégatan 2
S-114 85 Stockholm
SUÈDE

Date of mailing (day/month/year) 15 October 2001 (15.10.01)	
Applicant's or agent's file reference 60422-65175	IMPORTANT NOTIFICATION
International application No. PCT/SE01/01970	International filing date (day/month/year) 14 September 2001 (14.09.01)
International publication date (day/month/year) Not yet published	Priority date (day/month/year) 13 October 2000 (13.10.00)
Applicant SCA HYGIENE PRODUCTS AB	

1. The applicant is hereby notified of the date of receipt (except where the letters "NR" appear in the right-hand column) by the International Bureau of the priority document(s) relating to the earlier application(s) indicated below. Unless otherwise indicated by an asterisk appearing next to a date of receipt, or by the letters "NR", in the right-hand column, the priority document concerned was submitted or transmitted to the International Bureau in compliance with Rule 17.1(a) or (b).
2. This updates and replaces any previously issued notification concerning submission or transmittal of priority documents.
3. An asterisk(*) appearing next to a date of receipt, in the right-hand column, denotes a priority document submitted or transmitted to the International Bureau but not in compliance with Rule 17.1(a) or (b). In such a case, the attention of the applicant is directed to Rule 17.1(c) which provides that no designated Office may disregard the priority claim concerned before giving the applicant an opportunity, upon entry into the national phase, to furnish the priority document within a time limit which is reasonable under the circumstances.
4. The letters "NR" appearing in the right-hand column denote a priority document which was not received by the International Bureau or which the applicant did not request the receiving Office to prepare and transmit to the International Bureau, as provided by Rule 17.1(a) or (b), respectively. In such a case, the attention of the applicant is directed to Rule 17.1(c) which provides that no designated Office may disregard the priority claim concerned before giving the applicant an opportunity, upon entry into the national phase, to furnish the priority document within a time limit which is reasonable under the circumstances.

<u>Priority date</u>	<u>Priority application No.</u>	<u>Country or regional Office or PCT receiving Office</u>	<u>Date of receipt of priority document</u>
13 Octo 2000 (13.10.00)	0003703-6	SE	28 Sept 2001 (28.09.01)

The International Bureau of WIPO 34, chemin des Colombettes 1211 Geneva 20, Switzerland Facsimile No. (41-22) 740.14.35	Authorized officer Beate GIFFO-SCHMITT Telephone No. (41-22) 338.83.38
--	--

UN MÉTODO PARA ANCLAR LENGÜETAS DE SUJECCIÓN A LAS
PORCIONES LATERALES DE UNA PRENDA DE VESTIR SANITARIA
DESECHABLE Y UNA PRENDA DE VESTIR SANITARIA DESECHABLE
QUE COMPRENDE LENGÜETAS DE SUJECCIÓN ANCLADAS POR DICHO
MÉTODO

CAMPO TÉCNICO

La presente invención se relaciona con un método para anclar lengüetas de sujeción a las porciones laterales de una prenda de vestir sanitaria desechable tal como un pañal o una guarda de incontinencia, dicha prenda comprende una lámina superior de material soldable permeable a los líquidos, una lámina de respaldo de material impermeable a los líquidos y un cuerpo absorbente encerrado entre ellas, la lámina superior y la lámina de respaldo se extienden hacia el exterior del cuerpo absorbente alrededor de la periferia del mismo y se unen una a la otra en regiones de las mismas que alcanzan en la parte exterior del cuerpo absorbente, dicha prenda de vestir tiene una parte frontal, una parte trasera y una parte de entrepierna intermedia, con lo cual las lengüetas de sujeción que se extienden lateralmente son sujetadas a las porciones laterales de

las partes trasera y frontal de la prenda de vestir. La invención también se relaciona con una prenda sanitaria desechable que comprende lengüetas de sujeción ancladas a ella por dicho método.

ANTECEDENTES DE LA INVENCION

Con el objeto de hacer lengüetas de sujeción de prendas sanitarias desechables, tales como pañales o guardas de incontinencia, más suaves al toque es desváhale usar material no tejido para tales lengüetas. El riesgo de raspaduras se reduce si las lengüetas de sujeción de materiales más suaves que los materiales comúnmente utilizados para tales lengüetas, por ejemplo películas de polietileno se usan. También es deseable anclar el extremo del fabricante de tales lengüetas por medio de uniones de soldadura en vez de uniones de pegante. El fin del fabricante de una lengüeta de sujeción es el fin del mismo que sea sujeta permanentemente a las porciones laterales de la prenda por el fabricante en contraste con el extremo opuesto de la lengüeta que es sujeta a la porción lateral de la prenda por el usuario cuando se coloca la prenda sobre el usuario. Una unión de soldadura puede ser hecha más

fuerte que una unión de pegado con goma y existe por varias razones un deseo general de reducir a un mínimo el uso de uniones pegadas en la fabricación de líneas para prendas absorbentes de vestir. Sin embargo, ya que estos materiales usados para la lámina de respaldo y la lámina superior usualmente son incompatibles uno con el otro desde un punto de vista de soldadura, por ejemplo tienen diferentes puntos de fusión es un problema soldar las lengüetas de sujeción de la materiales no tejidos suaves sobre las porciones laterales de la prenda debido a la incompatibilidad del material de la lengüeta y del material de la lámina de respaldo.

El objetivo de la invención es suministrar una prenda sanitaria desechable, tal como un pañal o una guarda de incontinencia, con lengüetas de sujeción de materia suave, con los extremo de fabricación de las lengüetas anclados sobre las porciones laterales de la prenda por unión de soldadura.

RESUMEN DE LA INVENCION

Estos objetos se llevan a cabo por un método para anclar las lengüetas de sujeción a las porciones laterales de una prenda sanitaria desechable, tal como un pañal o una guarda de incontinencia, dicha prenda comprende una lámina superior de material soldable permeable a los líquidos, una lámina de respaldo de material impermeable a los líquidos y un cuerpo absorbente encerrado entre ellos, la lámina superior y la lámina de respaldo se extienden hacia el exterior del cuerpo absorbente alrededor de su periferia y se unen una a la otra en regiones que descansan por fuera del cuerpo absorbente, dicha prenda tiene una parte frontal, una parte trasera y una parte de entrepierna intermedia, en donde las lengüetas de sujeción que se extienden lateralmente sin sujetadas a las porciones laterales de la parte trasera o frontal de la prenda, caracterizado por las siguientes etapas;

Cortar unos agujeros en la lámina de respaldo en las porciones laterales opuestas de la parte trasera o frontal del mismo,

Entre estas láminas, creando así un blanco compuesto, uniendo una lámina superior al corte de la lámina de respaldo con un cuerpo absorbente dispuesto colocando,

Colocando lengüetas de sujeción en las porciones laterales del blanco compuesto que contiene el corte de los huecos o agujeros en la lámina de respaldo con los extremos del fabricado de dichas lengüetas dispuestos en uno de dichos agujeros, dichas lengüetas son hechas de un material que es compatible con el material de lámina superior desde un punto de vista de soldadura, y

Anclar los extremos del fabricado de las láminas de sujeción a la lámina superior por soldadura.

En una modalidad preferida la etapa de corte consiste de un corte de filas sucesivas de agujeros en la lámina de material de respaldo que corre continuamente en una dirección de máquina.

En una primera alternativa el método incluye las etapas de hacer descansar una fila de cuerpos absorbentes sobre la lámina de material de respaldo, descansar una

lámina de material de lámina superior sobre la lámina de material de respaldo, la lámina de material de lámina superior tiene el mismo ancho que la lámina de material de hoja de respaldo, uniendo las dos láminas juntas, creando así una lámina continua de blancos de prenda de vestir, y por lo tanto las lengüetas de sujeción se sueldan sobre las porciones laterales de la parte delantera y frontal de cada blanco de prenda de vestir.

En una segunda alternativa, el método incluye las etapas de hacer descansar una fila de cuerpos absorbentes sobre una lámina que corre continuamente de material de lámina superior, la lámina de material de lámina superior tiene el mismo ancho que la lámina de material de lámina de respaldo, hacer descansar la lámina de material de respaldo sobre la lámina de material de hoja superior, unir las dos láminas juntas, creando así una lámina continua de blancos de prenda de vestir, y de ahí en adelante soldar las lengüetas de sujeción a las porciones laterales de la parte trasera o frontal de cada blanco de prenda de vestir.

En ambas alternativas el método preferiblemente las etapas de reforzar el material de lámina superior en las

áreas en las cuales se sujetan las lengüetas o van a ser sujetadas y sujetar los extremos del fabricado de las láminas de sujeción por soldadura por ultrasonido.

La invención también se relaciona con una prenda sanitaria desechable, tal como un pañal o una guarda de incontinencia, que comprende un material soldable permeable a los líquidos de lámina superior, una lámina de respaldo de material impermeable y un cuerpo absorbente encerrado entre ellas, la lámina superior y la lámina de respaldo se extienden hacia el exterior del cuerpo absorbente alrededor de su periferia y son unidos una a la otra en regiones que descansan por la parte exterior o fuera del cuerpo absorbente, dicha prenda tiene una parte frontal y una parte trasera y una parte de entrepierna intermedia, con lo cual las lengüetas de sujeción se sujetan a las porciones laterales de la parte trasera o frontal de la prenda, caracterizado en que las lengüetas de sujeción están hechas de un material que es compatible con el material de la lámina superior desde un punto de vista de soldadura y que la lámina de respaldo comprende unos cortes en las regiones de la prenda que contienen los extremos de fabricación de las lengüetas de sujeción tal que no hay material de lámina de respaldo

presente en aquellas regiones, y que los extremos de fabricación de las lengüetas de sujeción están sujetadas sobre la lámina superior por uniones de soldadura.

En una modalidad preferida una tira de material de refuerzo es sujeta a la lámina superior en cada región de la prenda que contiene los extremos del fabricante de una lengüeta de sujeción. La lámina superior consiste de un material no tejido y las lengüetas de sujeción están hechas de un material que contiene el mismo tipo de fibras de la lámina superior. Preferiblemente, la lámina superior y las lengüetas de sujeción están hechas de material no tejido que contienen fibras de polipropileno y los extremos de fabricación de las lengüetas de sujeción y los cortes en la lámina de respaldo tienen una forma redondeada, por ejemplo no tienen esquinas agudas. Más aún, la lámina de respaldo se extiende una distancia entre 10 a 30 mm desde el borde lateral longitudinal de cada porción lateral de la parte trasera o frontal de la prenda.

BREVE DESCRIPCIÓN DE LOS DIBUJOS

La invención será ahora descrita con referencia a los dibujos adjuntos, en los cuales;

La figura 1 muestra de manera esquemática una vista de planta parcialmente seccionada de un pañal de acuerdo con una modalidad preferida de la invención,

La figura 2 muestra una vista en corte de sección transversal a lo largo de las líneas 2-2 de la sección transversal en la figura 1,

La figura 3 muestra una vista similar a la de la figura 2 de un pañal de acuerdo con una segunda modalidad de la invención,

La figura 4 ilustra esquemáticamente un dispositivo para llevar a cabo una primera etapa de corte en el método de acuerdo con la invención, y

La figura 5 ilustra esquemáticamente una lámina continua de blancos de lámina de respaldo.

DESCRIPCIÓN DE LAS MODALIDADES

En las figuras 1 y 2 un pañal desechable 1 se describe. Como es convencional en este campo de la técnica, el pañal comprende un cuerpo absorbente 2, que está encerrado entre una lámina superior permeable a los líquidos 3 y una lámina de respaldo impermeable a los líquidos 4, estas láminas son sujetadas una a la otra en porciones de las mismas que alcanzan más allá del cuerpo absorbente. El pañal tiene una parte frontal 5, una parte trasera 6 y una parte de entrepierna intermedia 7, la dirección longitudinal del pañal se extiende desde el borde trasero al borde delantero del mismo. El pañal también comprende elásticos de las piernas 8, por ejemplo uno o varios hilos o bandas elásticas dispuestos entre la lámina superior y la lámina de respaldo a los lados del pañal, por lo menos en la parte de entrepierna del mismo, y sujetados a la lámina superior y/o la lámina de respaldo en un estado estirado. En la figura 1, todos los componentes elásticos se muestran en un estado estirado.

El pañal 1 también comprende lengüetas de sujeción 9 que se proyectan hacia fuera desde los lados laterales del pañal en la parte trasera del mismo. Solamente una de

estas lengüetas de sujeción se describe en la figura 1. Estas lengüetas de sujeción tienen cada una un extremo de fabricación que es fijado permanentemente a la porción lateral repetida sobre la parte trasera del pañal por el fabricante del pañal, y un extremo de usuario que es sujetado a la porción lateral respectiva en la parte frontal del pañal cuando el pañal es aplicado a un usuario por la persona que aplica el pañal. Las lengüetas de sujeción están provistas con elementos de sujeción 10, que en la modalidad descrita consisten de elementos de sujeción machos de un sujetador de tipo gancho y aro. Los elementos hembra 10 son enganchables con elementos hembra dispuestos sobre una banda 11 sujeta a la lámina de respaldo sobre el lado exterior de la misma, por ejemplo el lado de la lámina de respaldo que está más lejos al usuario durante el uso del pañal.

Preferiblemente, los elementos de sujeción macho están distanciados desde el extremo respectivo de las lengüetas para poder suministrar porciones de agarre para el usuario del pañal.

Más aún, las aletas de barrera 12 están provistas sobre la lámina superior y están sujetadas a ella a lo

largo de sus extremos distales, por ejemplo, los extremos distales desde la línea de simetría longitudinal A-A del pañal. A lo largo de los extremos más próximos de las aletas 12 de los hilos elásticos 13 son sujetados allí en un estado estirado.

Los elementos de sujeción 10 están en la modalidad mostrada en los elementos de sujetadores macho en los sujetadores del tipo gancho y anillo. Otros tipos de sujetadores mecánicos por supuesto pueden ser usados, tal como botones, ganchos de sujeción o agujeros y similares. También es concebible el uso de sujetadores adhesivos.

La lámina superior permeable a los líquidos 3 está hecha de un material suave amigable a la piel. Ejemplos de tales materiales son diferentes tipos de no tejidos. Otro material que puede ser usado son las películas plásticas perforadas, las mallas plásticas o tejidas, en crochet, o materiales textiles tejido o combinaciones o laminados de los tipos anteriores de materiales mencionados. El material plástico puede ser un material termoplástico, por ejemplo polipropileno (PP). El material no tejido puede estar formado de fibras sintéticas, tales como PE, polipropileno (PP) poliuretano

(PU), o poliéster, nylon o celulosa regenerada, o una mezcla de diferentes fibras. Todos los materiales usados para las láminas superiores en prendas sanitarias absorbentes y que contienen fibras soldables pueden ser usados para la lámina superior 3 y los materiales anteriormente mencionados se dan solamente como ejemplos. La lámina superior puede comprender también materiales diferentes en las partes centrales y laterales de la misma. Las partes de la lámina superior 3 que descansan lateralmente hacia el exterior de las aletas de barrera 12 pueden estar hechas de un material impermeable a los líquidos mientras que la parte central entre las aletas 12 está hecha de un material permeable a los líquidos.

La lámina de respaldo a los líquidos 4 consiste de un material flexible, preferiblemente una película plástica delgada de PE, PP o un poliéster pero podría también consistir de un laminado de un material permeable a los líquidos, tal como un no tejido, y un material impermeable a los líquidos. Todos los materiales que son usados para las láminas de respaldo impermeables a los líquidos son concebibles. Las láminas de respaldo pueden ventajosamente ser permeables al aire.

El cuerpo absorbente 2 está preferiblemente formado de fibras de celulosa pero también de otros materiales naturales tales como fibras de algodón o de penca que pueden ser usados. Alternativamente pueden usarse fibras sintéticas absorbentes o una mezcla de fibras sintéticas y naturales. El cuerpo absorbente también puede comprender un superabsorbente, por ejemplo un polímero que tenga la capacidad de absorber líquido hasta una cantidad varias veces mayor que su propio peso. El cuerpo absorbente también puede contener formas de componentes estabilizadores y/o dispersantes de líquido y también agentes de pegado para sostener juntos las fibras cortas y partículas en una unidad continua. Más aún, el cuerpo absorbente puede contener más de una capa de material absorbente.

Las lengüetas de sujeción 9 están hechas de una o varias capas de material no tejido. Por lo tanto una lengüeta de sujeción suave es obtenida la cual reduce grandemente el riesgo de irritación contra la piel de un usuario del que existe para lengüetas de un material más duro, tal como las de películas plásticas. Más aún, las lengüetas de sujeción 9 están sujetadas en la lámina superior 3 por uniones de soldadura. Tales uniones son

deseables ya que pueden ser hechas más fuertes que las uniones de pegado con pegante. Las lengüetas de sujeción 9 pueden ventajosamente ser elásticas para poder mejorar el confort del usuario en el área de cintura y para cubrir con la diferencia en tamaños de cintura que aparecen cuando un usuario cambia de una posición de sentado a una posición de acostado. Tales lengüetas son preferiblemente hechas de dos capas no tejidas, entre las cuales se ponen tiras de material elástico o diversos hilos elásticos que pueden ser sujetados en un estado estirado, por lo menos en las áreas de ellas entre el extremo del fabricante y el extremo del usuario. Ejemplos de estas bandas elásticas que pueden ser usadas se dan en la EP-A-494 941. Alternativamente, las fibras en el material no tejido usadas para las lengüetas de sujeción pueden ser elásticas o pueden ser una mezcla de fibras elásticas y no elásticas.

Es frecuente el caso de que el material de lámina de respaldo no sea compatible con material de lámina superior desde un punto de vista de pegado por soldadura, por ejemplo, estos materiales tienen diferentes puntos de fusión. Esta incompatibilidad lleva a un problema cuando una lengüeta de sujeción debería ser sujeta a la capa

compuesta de material de lámina de respaldo y material de lámina superior por una soldadura térmica, tal como una soldadura por ultrasonido. Este problema se resuelve en la presente invención suministrando unos cortes o agujeros 14 en las porciones laterales de la lámina de respaldo en la parte frontal y trasera del pañal en la cual las lengüetas de sujeción 9 van a ser sujetadas. Así, el material de las lengüetas de sujeción 9 requiere solamente ser compatibles desde un punto de vista de soldadura con el material de lámina superior y puede consecuentemente ser escogida sin considerar el material de la lámina de respaldo. Como es evidente desde el punto de vista de corte seccional en la figura 2, la unión por soldadura 15 es hecha en el área libre de material de lámina de respaldo.

Los cortes o agujeros 14 se extienden preferiblemente de entre 10 a 30 mm desde cada borde longitudinal de la porción lateral de la parte trasera del pañal 1, lateralmente 1 hacia el otro, pero también puede de una manera completa estar distanciado desde el borde longitudinal de la porción lateral de la parte trasera del pañal 1 siempre que los agujeros tengan un tamaño igual a o mayor que el extremo de fabricante de la

lengüeta de sujeción. Preferiblemente, los cortes y los extremos de fabricante de las lengüetas 9 tienen una forma redondeada con ninguna esquina aguda para poder reducir el riesgo adicionalmente de irritación. La extensión total de los cortes en la dirección lateral del pañal puede ser hasta la mitad del ancho máximo del pañal, pero descansa preferiblemente entre 20 a 40 mm. La extensión de los cortes en la dirección longitudinal del pañal es más pequeña que la longitud del borde longitudinal de la porción lateral que contiene el corte.

La figura 3 muestra una vista similar a la figura 2 de un pañal de acuerdo con una segunda modalidad de la invención. Este pañal en varios aspectos en la mayoría de los aspectos similar al pañal 1 mostrado en las figuras 1 y 2 y la descripción de la modalidad de acuerdo con estas figuras es generalmente válida también para el pañal de acuerdo con la figura 3. Por lo tanto, los componentes de la figura 3 que corresponden a componentes idénticos en las figuras 1 y 2 se les dan el mismo numeral de referencia con la adición de un signo prima. La única diferencia entre las modalidades es que las tiras de refuerzo de material 16 están fijas sobre la lámina superior 3' por una unión de soldadura 17 en las áreas

definidas por lo cortes 14'. La tira de material 16 está hecha de un material compatible con el material de lámina superior desde un punto de vista de soldadura, preferiblemente a partir de un material que comprende el mismo tipo de fibras que la lámina superior. Por el uso de las fibras de refuerzo es posible reducir el espesor del material de lámina superior y por lo tanto reducir los costos de material para el pañal.

La etapa de cortar los cortes o agujeros en la lámina de respaldo es fácil de incorporar en una línea convencional para fabricación continua de los pañales desechables. En tal línea, una primera tela continua de material de lámina de respaldo o de material de lámina superior corre sucesivamente por un dispositivo para recubrir la lámina con goma, un dispositivo para hacer descansar una fila de cuerpos absorbentes sobre la lámina, un dispositivo para hacer descansar los elásticos de pierna sobre la lámina, un dispositivo para descansar una segunda lámina de material de lámina superior de material de lámina de respaldo sobre la lámina compuesta que consiste de la primera lámina, la fila de cuerpos absorbentes y los elásticos de pierna, un dispositivo para fijar los sujetadores y un dispositivo de corte para

hacer los cortes de las piernas y para cortar los pañales individuales de la lámina compuesta. En la figura 4 se muestra de manera esquemática un dispositivo de corte 18 para cortar dos fibras de agujeros 19 en los laterales de una tela 20 que corre continuamente en una dirección MD de la máquina. El dispositivo 18 comprende un rodillo de corte 21 que está provisto con cuchillas 22 y un rodillo de yunque 23, la lámina 20 pasa entre estos rodillos. Si la primera lámina es una lámina de material de lámina de respaldo, el dispositivo 18 está colocado en la línea de fabricación aguas arriba del dispositivo de recubrimiento de goma y si la primera lamina es una lámina de material de lámina superior, el dispositivo de corte 18 está colocado en el exterior de la línea de transporte para la primera lámina y aguas arriba del dispositivo de suministro de la segunda lámina sobre la primera lámina. El corte de la lámina de material de lámina de respaldo también puede hacerse en una línea separada que comprende un dispositivo para enrollar la lámina cortada de material de lámina de respaldo sobre un rodillo de almacenamiento que a su vez es usado en una línea convencional para la fabricación de pañales. En una línea de fabricación de acuerdo con la presente invención la lámina compuesta pasa por un dispositivo de soldadura de

ultrasónica para soldar los elementos de sujeción sobre la lámina superior.

En la figura 5 se muestra una vista en planta de una lámina de acuerdo con la figura 4. Por medio de las líneas interrumpidas se muestra como la lámina de respaldo es cortada en la etapa final de una línea de fabricación alternativa. Como es evidente de esta figura, los agujeros 19 tienen una extensión también en la parte frontal de los pañales individuales cortados por esta manera alternativa de fabricación.

La modalidad descrita puede por supuesto ser modificada en diversos aspectos sin salirse del alcance de la invención. Por ejemplo, los agujeros o cortes en las porciones laterales de la parte trasera de la prenda sanitaria desechable pueden tener otras formas según se describió. Otros tipos de aletas de barrera pueden ser usados y las partes extremo de tales aletas pueden ser usadas como material de refuerzo en lugar de la tira de material 16. Más aún, las porciones laterales de la lámina superior pueden estar provistas con material de refuerzo con el área total de la misma. Las lengüetas de sujeción pueden estar provistas sobre la parte lateral de

la lámina superior que está lejos o distal del usuario en lugar de sobre el lado que está próximo al mismo como en las modalidades mostradas. El cuerpo absorbente también puede tener otras formas que la forma rectangular mostrada, por ejemplo una forma de reloj de arena. Más aún, las lengüetas de sujeción y por lo tanto los cortes en la lámina de respaldo pueden estar dispuestos en las porciones laterales de la parte frontal de la prenda en lugar de la parte trasera como en las modalidades mostradas, aunque esto no es lo preferido. El pañal también puede estar provisto con elásticos de cintura del tipo convencional que sustituyen o complementen las lengüetas de sujeción elásticas. La invención también puede ser usada sobre otros tipos de prendas sanitarias desechables, tales como guardas de incontinencia. El alcance de la invención por lo tanto deberá determinarse solamente por el contenido de las reivindicaciones de patente adjuntas.

REIVINDICACIONES

1. Un método para anclar lengüetas de sujeción (9) a las porciones laterales de una prenda sanitaria desechable (1), tal como un pañal o una guarda de incontinencia, dicha prenda comprende una lámina superior (3) de material soldable permeable a los líquidos, una lámina de respaldo (4) de material impermeable a los líquidos y un cuerpo absorbente (2) encerrado entre ellas, la lámina superior y la lámina de respaldo se extienden hacia el exterior del cuerpo absorbente alrededor de la periferia del mismo y se unen una a otra en las regiones que descansan en la parte exterior del cuerpo absorbente, dichas prendas pueden tener una parte frontal (5), una parte trasera (6) y una parte de entrepierna intermedia (7), con lo cual las lengüetas de sujeción se extienden lateralmente (9) y quedan sujetadas a las porciones laterales de la parte trasera o frontal de la prenda, caracterizado por las siguientes etapas:

Cortar agujeros (14; 19) en una lámina de respaldo (4; 20) en las porciones laterales opuestas de la parte trasera o frontal del mismo,

Unir una lámina superior (3) a la lámina de respaldo cortada con un cuerpo absorbente (2) dispuesto entre estas láminas, creando así un blanco compuesto,

Colocar las lengüetas de sujeción (9) en las porciones laterales del blanco compuesto que contiene los agujeros cortados en la lámina de respaldo con el extremo del fabricante de dichas lengüetas cada una dispuesta en uno de dichos agujeros, dichas lengüetas están hechas de un material que es compatible con el material de la lámina superior desde un punto de vista de soldadura, y el anclaje de los extremos del fabricante de las lengüetas de sujeción a la lámina superior por soldadura.

2. El método de acuerdo con la reivindicación 1, caracterizado por cortar filas sucesivas de agujeros (14, 19) en una lámina (4, 20) de

material de respaldo que corre continuamente en una dirección de máquina (MD).

3. El método de acuerdo con la reivindicación 2, caracterizado por hacer descansar una fila de cuerpos absorbentes (2) sobre una lámina (4, 20) de material de respaldo, hacer descansar una lámina (3) de material de lámina superior sobre la lámina de material de respaldo, la lámina de material superior tiene el mismo ancho que la lámina de material de respaldo, uniendo las dos láminas juntas, creando así una lámina continua de blancos de prenda de vestir, y de ahí en adelante soldar las lengüetas de sujeción (9) a las porciones laterales de la parte trasera (6) o frontal de cada blanco de prenda de vestir.

4. El método de acuerdo con la reivindicación 2, caracterizado por hacer descansar una fila de cuerpos absorbentes (2) sobre una lámina que corre continuamente (3) de un material de lámina superior, la lámina de material de lámina superior tiene el mismo ancho que la lámina (4,20) de material de lámina de respaldo, hacer

descansar la lámina de material de respaldo sobre la lámina de material de lámina superior, unir las dos láminas juntas, creando así una lámina continua de blancos de prenda de vestir, y después soldar las lengüetas de sujeción (9) a las porciones laterales de la parte trasera (6) o delantera de cada blanco de prenda de vestir.

5. El método de acuerdo con las reivindicaciones 1, 2, 3 o 4, caracterizado por reforzar el material de lámina superior (3) en las áreas en las cuales las lengüetas de sujeción (9) son ancladas o van a ser ancladas.

6. El método de acuerdo con una cualquiera de las reivindicación 1 a 5, caracterizado por anclar los extremos del fabricante de las lengüetas de sujeción (9) por ultrasonido.

7. Una prenda sanitaria desechable (1) tal como un pañal o una guarda de incontinencia, que comprende una lámina superior (3) de material soldable permeable a los líquidos, una lámina de respaldo (4) de material impermeable a los

líquidos y un cuerpo absorbente (2) encerrado entre ellas, la lámina superior y la lámina de respaldo se extienden hacia el exterior del cuerpo absorbente alrededor de la periferia del mismo y son unidas una a otra en las regiones que descansan por fuera del cuerpo absorbente, dicha prenda tiene una parte frontal (5), una parte trasera (6) y una parte de entrepierna intermedia (7), con el cual las lengüetas de sujeción (9) son sujetadas a las porciones laterales de la parte trasera o frontal de la prenda, caracterizado en que las lengüetas de sujeción (9) están hechas de un material que es compatible con el material de lámina superior desde un punto de vista de soldadura y que la lámina de respaldo (4) comprende cortes (14) en las regiones de la prenda que contienen los extremos de fabricante de las lengüetas de sujeción (9) de modo que no exista material de lámina de respaldo presente en aquellas regiones, y que los extremos de fabricante de las lengüetas de sujeción estén sujetos a la lámina superior por uniones de soldadura (15).

8. La prenda de acuerdo con la reivindicación 7, caracterizada en que una tira de material de refuerzo (16) está sujeta a la lámina superior (3') en cada región de la prenda que contiene el extremo de fabricante de una lengüeta de sujeción (9').
9. La prenda de acuerdo con las reivindicaciones 7 u 8, caracterizada en que la lámina superior (3) consiste de un material no tejido y que las lengüetas de sujeción (9) están hechas de un material que contiene el mismo tipo de fibras de la lámina superior.
10. La prenda de acuerdo con la reivindicación 9, caracterizada en que la lámina superior (3) y las lengüetas de sujeción (9) están hechas de un material no tejido que contiene fibras de polipropileno.
11. La prenda de acuerdo con una cualquiera de las reivindicaciones 7 a 10, caracterizada en que el extremo de fabricante de las lengüetas de sujeción (9) y los cortes (14) en la lámina de

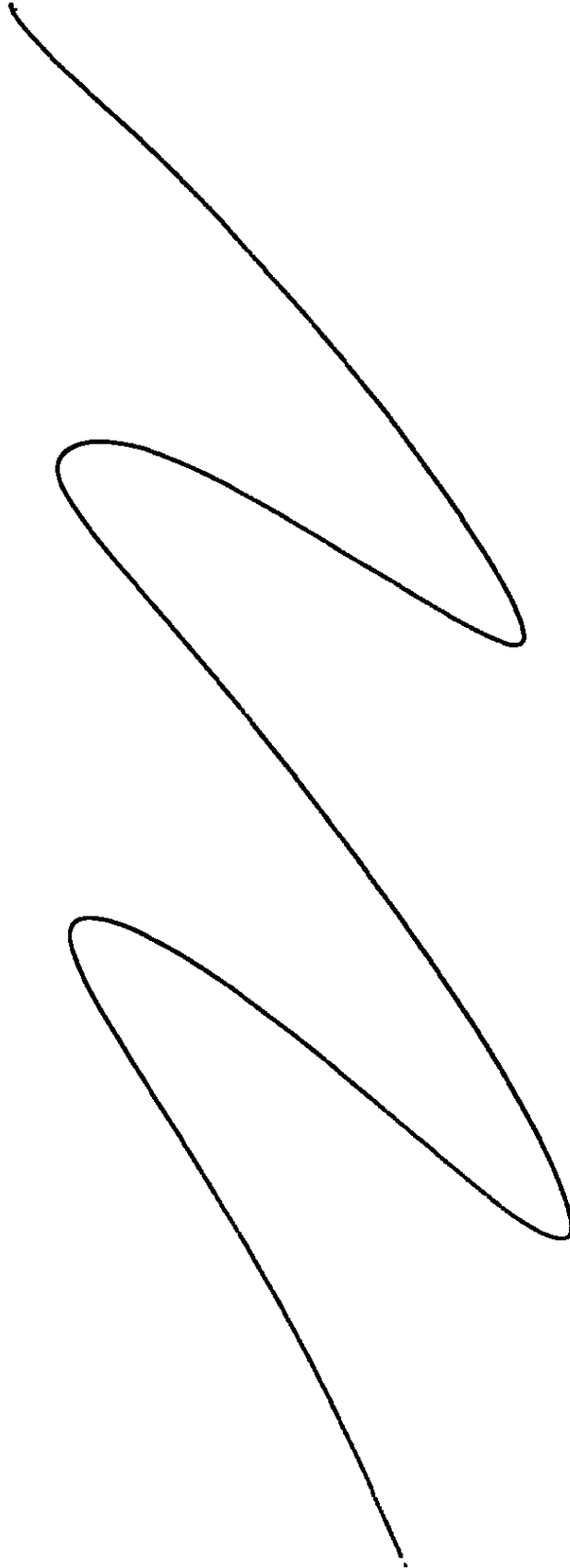
respaldo tienen una forma redondeada, por ejemplo no tienen esquinas agudas.

12. La prenda de acuerdo con la reivindicación 11, caracterizada en que los cortes (14) en la lámina de respaldo (4) se extiende una distancia entre 10 a 30 mm desde el borde lateral longitudinal de cada porción lateral de la parte trasera (6) o frontal de la prenda (1).

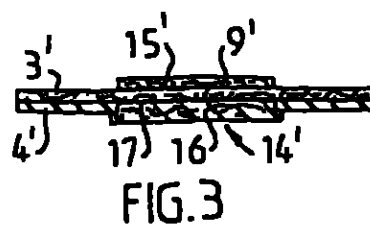
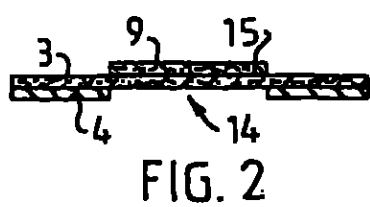
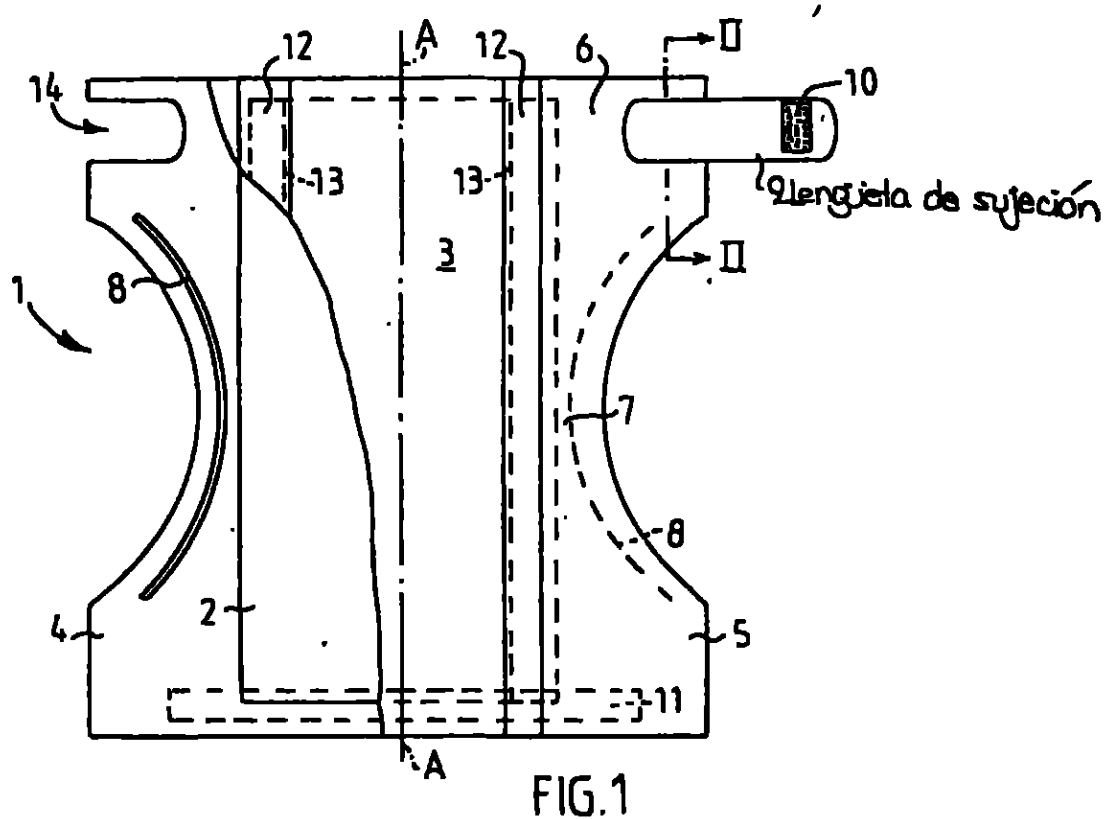
RESUMEN

La invención se relaciona con un método para anclar lengüetas de sujeción (9) a las porciones laterales de una prenda de vestir sanitaria desechable (1), tal como un pañal o una guarda de incontinencia, de acuerdo con la invención el método incluye las siguientes etapas: hacer cortes de agujeros (14,) en una lámina de respaldo (4) en las porciones laterales opuestas de la parte trasera o frontal del mismo, unir una lámina superior (3) a la lámina de respaldo cortada con un cuerpo absorbente (2) dispuesto entre estas láminas, creando así un blanco compuesto, colocar las lengüetas de sujeción (9) en las porciones laterales del blanco compuesto que contiene los agujeros cortados en la lámina de respaldo con el extremo del fabricante de dichas lengüetas cada una dispuesta en uno de dichos agujeros, dichas lengüetas están hechas de un material que es compatible con el material de la lámina superior desde un punto de vista de soldadura, y el anclaje de los extremos del fabricante de las lengüetas de sujeción a la lámina superior por soldadura. La invención también se relaciona con una prenda

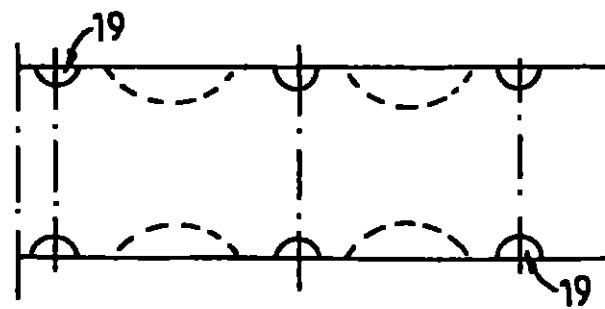
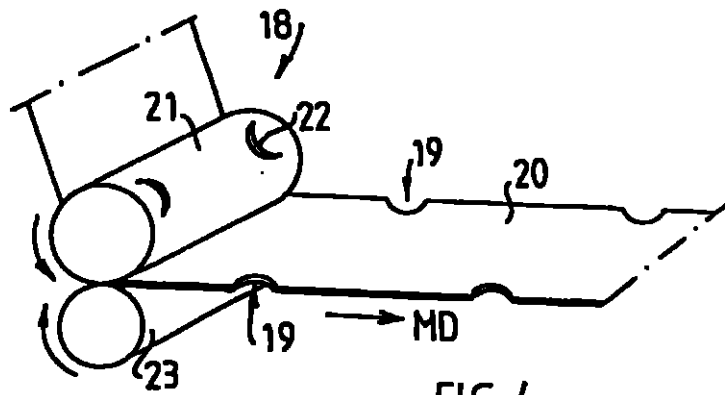
sanitaria que tienen lengüetas de sujeción fijadas de acuerdo con dicho método.



1/2



2/2



CAVELIER

ABOGADOS

ESPANOL 3151

CARRERA 4ª 72-35

BOGOTÁ, C. COLOMBIA

REPRESENTACION Y PODER

For patents, utility models, industrial designs, trademarks, commercial names, trade emblems, slogans. 68

Para patentes, modelos de utilidad, diseños industriales, marcas de fábrica, nombres comerciales, enseñas, lemas comerciales.

REPRESENTATION AND
POWER OF ATTORNEY

11156
0131

I (we), the undersigned / Yo (nosotros), abajo firmado (s)
SCA HYGIENE PRODUCTS AB

of / domiciliado (s) en 405 03 Goteborg,
SWEDEN

por el presente nombramos a EMILIO FERRERO, tpa. 31929; GONZALO PERDOMO, tpa. 831; LUZ CLEMENCIA DE PAEZ, tpa. 23555 y GERMAN CAVELIER, tpa. 832, domiciliados en la Carrera 4ª N° 72-35, Bogotá, Colombia, en obediencia a lo dispuesto en el parágrafo 1º del Artículo 543 del Código de Comercio, el primero como principal y los demás como suplentes, en su orden, como mis (nuestros) representantes en todos los asuntos de propiedad industrial con facultad para recibir notificaciones y nombrar apoderados judiciales o extrajudiciales. El primer representante suplente reemplazará al principal en caso de ausencia o impedimento temporal o definitivo de aquél. La misma regla se aplicará cuando el segundo representante suplente haya de reemplazar al primero, o el tercero al segundo. En tales casos, el representante principal, o el primero, o segundo suplente, en su caso, o ambos, declararán su intención de no ejercer la representación mediante declaración autenticada por Notario Público en Colombia, o por Notario u otro Funcionario Público, o Cónsul de Colombia, en el extranjero; y si se tratare de impedimento, con el certificado respectivo. Si alguno de los nombrados faltare definitivamente, el siguiente tomará su lugar. Cuando cesare la ausencia o impedimento del representante principal, o de su primero o segundo suplentes, en su caso, podrán ejercer la representación, en su orden, uno u otros según el caso, asumiéndola por el solo hecho de ejercerla, cesando en ese momento el ejercicio de la representación por el primero, segundo o tercer suplente en su caso.

Además, confiero (conferimos) poder a los abogados arriba nombrados, para obtener la protección de mí (nuestra) propiedad industrial y contra la competencia desleal, a cuyo efecto autorizo (amos) a los dichos apoderados para que me (nos) representen ante cualesquiera entidades o personas, ejerzan o no jurisdicción, especialmente ante las del orden administrativo, contencioso-administrativo y judicial, así como los tribunales de arbitramento, en todo lo concerniente a los siguientes asuntos: a) Obtención de patentes de invención, modelos de utilidad, y diseños industriales; el registro de marcas de fábrica, colectivas, defensivas, de servicio, lemas comerciales, nombres comerciales, enseñas, variedades vegetales y denominaciones de origen; su renovación, traspaso, cambio de nombre o domicilio, cancelación voluntaria; y el registro de licencias de uso de esos derechos; b) Las acciones de competencia desleal, protección del consumidor, oposiciones u observaciones, cancelación administrativa y judicial, nulidad, medidas cautelares, concesión de licencias, la tutela, la protección de secretos industriales, y en general los juicios civiles, penales, administrativos o contencioso-administrativos relacionados con estos derechos; acciones y procesos que promovamos o se nos promuevan. Y para que en todos los asuntos arriba determinados, puedan sustituir este mandato, transigir, conciliar, admitir los hechos del proceso, desistir, cancelar, recibir, renunciar, y ratificar los actos de agentes oficiales.

In due compliance with the terms of paragraph 1st. of article 543 of the Commercial Code, do hereby appoint EMILIO FERRERO, tpa. 31929; GONZALO PERDOMO, tpa. 831; LUZ CLEMENCIA DE PAEZ, tpa. 23555 and GERMAN CAVELIER, tpa. 832, domiciled at Carrera 4ª N° 72-35, Bogotá, Colombia, the first as principal and the others as alternates, in the order of their appointment, as our representatives for all industrial property matters with faculty to receive notifications and to appoint attorneys in and out of Court. The first alternate shall replace the principal in case of his absence or of temporal or definitive impediment. The same rule will apply when the second alternate representative is to replace the first one, or when the third is to replace the first or second alternates in their turn, or both of them, second. In such cases, the principal representative, or the first or second alternates in their turn, or both of them, shall state their intention not to act as representatives through a declaration given before a Notary Public in Colombia, or before a Notary or another Public Official or a Colombian Consul abroad; and in case of impediment, the appropriate certificate shall suffice. If any of the appointees were to be definitely absent, the following alternate shall take his place. When the absence or impediment of the principal representative, or of the first or second alternate in their turn ceases, the representation can be taken again in their sequence, by the principal, the first or second alternate depending on case, and the mere fact of its exercise will suffice. The exercise of the representation by the first, second or third alternates in their turn shall end at such time.

In addition, we grant a Power of Attorney in favor of the above-named attorneys-at-law so that they may obtain the protection of my (our) industrial property and against the unfair competition, of which purpose (we) authorize the said attorneys to represent me (us) before any authority or persons, with or without jurisdiction, especially before administrative, administrative contentious and judicial, as well as before Arbitration Court, in all matters concerning the following: a) Obtainment of patents, utility models and industrial designs; the registration of trademarks, collective, defensive and service marks, slogans, commercial names, trade emblems, vegetal varieties and denominations of origin; its renewal, assignment, change of name or domicile, voluntary cancellation; and the registration of licenses of use of the above rights; b) Actions of unfair competition, protection to the consumer, oppositions or observations, administrative or Court cancellation, nullity, infringement, granting of licenses, the action for writ mandamus, the protection of trade secrets, and in general the civil, penal, and administrative suits relating to those rights; actions and suits instituted by me (us) or against me (us). And that in all the above matters they may substitute this Power of Attorney, compromise, conciliate, admit the facts of the case, desist, cancel, receive, resign, and ratify acts done by representatives without a power of attorney.

Given and signed this / Dado y firmado hoy
Gothenburg 19 February 1999

in/en

Signature

Firma

Bengt Forshult
Head of Patent Department

SCA Hygiene Products AB

CAVELIER ABOGADOS
WTFODERE-174 (MINUTA 12.1.1.2.5)

TRADUCCION No: 1707199
MARIA ELVIRA MARTELO
Traductora e Interprete Oficial
Inglés - Español - Inglés
Res. No. 2879 Min. Justicia

LEGALIZACION

El Señor Cónsul de Colombia debe expedir un certificado consular sobre (1) la existencia legal de la compañía que otorga el poder, (2) que ésta ejerce su objeto social, y (3) que las personas que otorgan el poder están autorizadas para darlo. A este efecto les solicitamos que muestren al Señor Cónsul las pruebas que acreditan esos hechos (1), (2) y (3).

LEGALIZATION

The Colombia Consul must issue a consular certificate, on (1) the legal existence of the company which grants the Power-of-Attorney, (2) that it is in actual exercise of its company purposes, and (3) that the persons who execute the Power of Attorney is authorized to do so. To this effect, please show the Consul the evidence to prove the above facts (1), (2) and (3).

TRADUCCION No: 1707/99
MARIA ELVIRA MARTELO
Traductora e Interprete Oficial
Inglés - Español - Inglés
Res. No. 2879 Min. Justicia

NO SE ASUME
RESPONSABILIDAD DEL TEXTO
2009 FEB 14 A 11:50
DE LEGALIZACIONES
DE GOBIERNO

I, the undersigned, RICKARD STRÖM, Notary Public of Gothenburg, Sweden, do hereby certify,

that Bengt Forshult

has personally signed this document overleaf, and

according to a Power of Attorney, dated 1998-08-11, signed by GUNNAR ANDERSSON and SVEN-ERIK WINLÖF, who are duly authorized

to sign jointly for and on behalf of

HYGIENE PRODUCTS AKTIEBOLAG - Org.No. 556007-2356

according to a Swedish Certificate of Registration, dated

1998-07-20, Bengt Forshult is duly authorized

to sign such a document on behalf of the company.

Gothenburg, this 25th day of February 1999

MINISTERIO DE RELACIONES
EXTERIORES

Exp.No.: 79234
Fee: SEK 350:-



PAGADO
Impuesto de Timbre
Derechos Consulares
dólares US\$ 7
Miles 133

NO. 3066

The Ministry for Foreign
Affairs in Stockholm

certifies that

Mr. Richard

has issued and signed the

foregoing attestation

in his official capacity

NOTARIO

18 ABR 2003

Fee Stockholm this 2nd day of March

Kr 120/- PAID 1977

Inger Högberg

MARIA SMITH RUEDA
Encargada de las Funciones Consulares

MA Smith

Fecha

1999-03-05

No. DCC

que el señor Bengt Forshult
quien firma el documento que antecede
ejercía para la sociedad de la Sociedad SH Hygiene Products
que existe en Colombia c. las leyes de
según se me presentó en los documentos que
tuve a la vista.

CERTIFICADO
que el señor Bengt Forshult

NOTA PARA EL SEÑOR CONSUL DE COLOMBIA: Según los artículos 65 del C. de P.C. y 480 del C. de Co., si el poderdante es una sociedad, el Señor Cónsul debe certificar que tuvo a la vista las pruebas de su existencia que ejerce su objeto social y que quien confiere el poder es su representante:



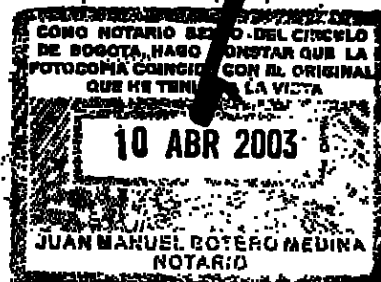
MINISTERIO DE RELACIONES
EXTERIORES

282837
Marta Smith Rueda
Cuya firma aparece en el
DOCUMENTO DESEMPEÑA
LAS FUNCIONES INDICADAS

JEFE
SEA

MINISTERIO DE RELACIONES
EXTERIORES
NO SE ASUME
RESPONSABILIDAD DEL TEXTO
079530
99 JUL 28 1999
ANULADO
JEFE DE LEGALIZACIONES
SANTAFE DE BOGOTA D.C.
Cuya firma aparece en el
DOCUMENTO DESEMPEÑA
LAS FUNCIONES INDICADAS

TRADUCCION No. 707199
MARIA ELVIRA MARTELO
Traductora e Interprete Oficial
Inglés - Español - Inglés
Res. No. 2879 Min. Justicia



EL CONSULADO DE COLOMBIA EN
ESTOCOLMO, SUECIA

Fecha.....1999-07-01..... No:.....331329

Previa la confrontación correspondiente DA
FE de que la firma que aparece en este docu-
mento es similar a la REGISTRADA aquí por.

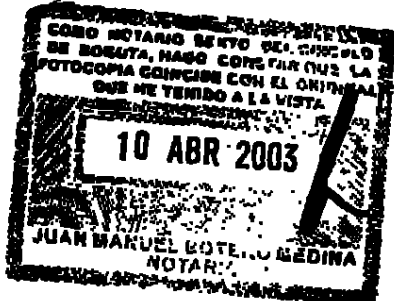
Inger Höglberg, Ann Zeladovskis
Sueños, Suecia

M. Smith
MARIA SMITH RUEDA
Encargada de las Funciones Consulares

PAGADO	
Impuesto de Timbre	
<u>Seiete</u>	dólares US\$ <u>7</u>
Derechos Consulares	
<u>Quince</u>	dólares US\$ <u>15</u>



TRADUCCION No: 1709199
MARIA ELVIRA MORTOLO
Traductora e Interprete Oficial
Inglés - Español - Inglés
Res. No. 2879 Min. Justicia



70

TRADUCCIÓN OFICIAL No. 17.07/99 preparada por María Elvira Martelo, Traductora Oficial aprobada por el Ministerio de Justicia por Resolución 2879 de 1995 y reconocida por el Ministerio de Relaciones Exteriores.

(A continuación se traducen los sellos y legalizaciones de un documento escrito en inglés y español, por el cual SCA HYGIENE PRODUCTS AB otorga poder a EMILIO FERRERO, GONZALO PERDOMO, LUZ CLEMENCIA DE PAEZ Y GERMAN CAVELIER). Dado y firmado el 19 de febrero de 1999 en Gothenburg. (Firma ilegible) Bengt Forshult, Jefe del Departamento de Patentes.

Yo, el abajo firmante RICKARD STRÖM, Notario Público de Gothenburg, Suecia, por el presente certifico,

que Bengt Forshult

ha firmado personalmente el documento antes de mí, el Notario Público de Gothenburg, Suecia, el 19 de febrero de 1999, en Gothenburg, Suecia, por el cual SCA HYGIENE PRODUCTS AB otorga poder a EMILIO FERRERO, GONZALO PERDOMO, LUZ CLEMENCIA DE PAEZ Y GERMAN CAVELIER, quienes están debidamente autorizados para firmar conjuntamente por y a nombre de SCA

HYGIENE PRODUCTS AKTIEBOLAG - Org. No. 556007-2356, según

Certificado de Registro Sueco de fecha 1998-07-20, Bengt Forshult está debidamente autorizado para firmar dicho documento a nombre de la compañía.

Gothenburg, 25 de febrero de 1999.

Ex oficio: (Firma ilegible), RICKARD STRÖM (Sello notarial).

Exp. No.: 79234

Derechos: SEK 350:-.

No. 3066

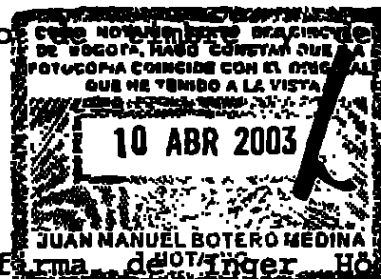
El Ministerio de Relaciones Exteriores en Estocolmo por el presente certifica que el Sr. Rickard Ström, Notario Público de Goteborg, ha expedido y firmado la declaración anterior en su capacidad oficial.

Derechos Estocolmo, 25 de marzo

Kr. 120 PAGADOS de 1999

(Firma ilegible) Inger Högberg. (Sello en tinta) Ministerio de Relaciones Exteriores.

(En español) Certificación de la capacidad legal de Bengt Forshult y de la existencia legal de SCA HYGIENE PRODUCTS AKTIEBOLAG expedida el 5 de marzo 1999 por el Consulado de Colombia en Estocolmo bajo el No. 022. (Firma) M. Smith. MARÍA SMITH RUEDA, Encargada de las Funciones Consulares. Sello consular en tinta. Pagados impuesto de timbre y derechos consulares.



(En español) Certificación de la firma de Inger Högberg, Ministerio de Relaciones Exteriores, Suecia, expedida el 01 de julio de 1999 por el Consulado de Colombia en Estocolmo bajo el No. 001329. (Firma) M. Smith. MARÍA SMITH RUEDA, Encargada de las Funciones Consulares. Sello consular en tinta. Pagados impuesto de timbre y derechos consulares.

(Al anverso) Legalización de la firma que antecede expedida por

el MINISTERIO DE RELACIONES EXTERIORES bajo el No. 119916 del 14 de febrero del 2000, firmado por el Jefe de Legalizaciones.

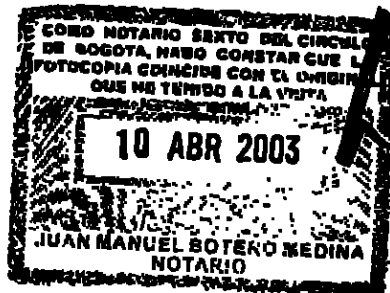
Es traducción fiel y completa de la cual se deja copia en esta oficina para su confrontación.

COLO 11256-801-014-7

Id. 108

Feb. 15/00

Maria Elvira Martelo
 TRADUCCION No. 170799
 MARIA ELVIRA MARTELO
 Traductora e Interprete Oficial
 Inglés - Español - Inglés
 Res. No. 2879 Min. Justicia



MINISTERIO DE RELACIONES EXTERIORES
 220552
 CUYA FIRMA ATANDE EN EL DOCUMENTO DESEMPENA LAS FUNCIONES INDICADAS
 2000 FEB 15/00 12:02
 Jefe de Legalizaciones
 SANTA FE DE BOGOTÁ, D.C.
 SE ASUME RESPONSABILIDAD DEL TEXTO

COMO NOTARIO SEXTO DEL CIRCULO DE SANTAFE DE BOGOTA, HAGO CONSTAR QUE LAS FIRMAS DE

[Firma]

CONCIDE(N) CON LA FIRMA REGISTRADA POR EL (ELLOS) EN ESTA NOTARIA

SANTAFE DE BOGOTA, 16 FEB 2000



SECRETARIA DE RELACIONES

30225

2000 FEB 16 15:05

COMO NOTARIO SEXTO DEL CIRCULO DE BOGOTA, HAGO CONSTAR QUE LA FOTOCOPIA CONCIDE CON EL ORIGINAL QUE HE TENIDO A LA VISTA

10 ABR 2003

JUAN MANUEL BOTERO MEDINA
NOTARIO

Expediente No		03- 30682	No de Folio
Item		No de unidades	✓
1	CD		
2	DVD		
3	REVISTA		
4	LIBRO		
5	PERIODICO		
6	DISQUETES		
7	SOBRE DE MANILA	1	✓
8	SOBRE BLANCO TAMAÑO CARTA		
9	SOBRE BLANCO TAMAÑO OFICIO		
10	OTROS:		

Observaciones:
 sobre vacio

74
SUPERINDUSTRIA Y COMERCIO
Radicacion : 03030682 00000000
Fecha (AMR): 2003-04-10 17:21:11
Tramite : 011 PCT-PATENT 379 FASE NNCI 411 PRESENTAL
Dependencia: 2820 DIVISION DE NUEVAS CREACIONES

NIT : 000174089-2

RECIBO OFICIAL DE CAJA : 03 - 24,573
FECHA : ABRIL 7 DE 2003

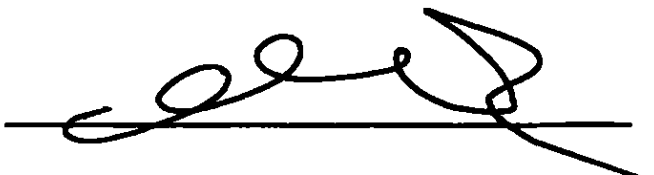
***** CONSIGNACION *****

DEPOSITANTE	TIPO PAGO	BANCO	CUENTA	No. PAGO	FECHA PGO	Vr. PAGO
CAVELIER ABOGADOS	CONSIGNACION	BANCO POPULAR	050-00110-6	12169296	07/04/2003	23,763,000.00

***** CONCEPTO *****

CANT. CONTABILISTICO	CONCEPTO	TOTAL CONCEPTO
1 50003-01-01 SOLICITUDES	1 TRAMITES DE SOL. DE PATENTE DE IN	400,000.00
	TOTAL :	\$ 400,000.

SON: CUATROCIENTOS MIL PESOS

RESPONSABLE : 

RECIBO DE CAJA APLICADO AL EXPEDIENTE No. _____

Boleto 11256-841-009-9

REQUISITOS NECESARIOS PARA PRESENTACION Y AGILIZACION DEL TRAMITE

	USUARIO	RADICADOR
PATENTE DE INVENCION	()	()
Indicacion de que se solicita la concesion de una patente	()	(x)
Datos de identificacion del solicitante o de la persona que se presenta la solicitud	()	(x)
Descripcion de la invencion	()	(x)
Dibujos de ser estos pertinentes	()	(x)
Comprobante de Pago de las tasas establecidas	()	(x)
COMPLETA (x)	INCOMPLETA ()	()
DISEÑO INDUSTRIAL ()		
Indicacion de que se solicita el registro de Diseño Industrial	()	()
Datos de identificación del solicitante o de la persona que presenta la solicitud	()	()
Representación gráfica y fotográfica del Diseño Industrial o muestra del Material que incorpora el diseño	()	()
Comprobante de pago de las tasas establecidas	()	()
COMPLETA ()	INCOMPLETA ()	()
ESQUEMA DE TRAZADO ()		
Indicacion de que solicita el registro de un Esquema de trazado	()	()
Datos de identificación del solicitante o de la persona que presenta la solicitud	()	()
Representación gráfica del esquema de trazado	()	()
Comprobante de pago de las tasas establecidas	()	()
COMPLETA ()	INCOMPLETA ()	()

Firma Responsable

Eduar Novillo

10-04-2003

Fecha

