Contents

| Contri | butor contact details | xi |
|--------|---|----|
| 1 | Development of the nonwovens industry A WILSON, <i>Nonwovens Report International, UK</i> | 1 |
| 1.1 | Definition and classification | 1 |
| 1.2 | Dry, wet and polymer-laid nonwovens | 4 |
| 1.3 | Market structure and development | 10 |
| 1.4 | Key companies | 15 |
| 1.5 | References | 15 |
| 2 | Dry-laid web formation | 16 |
| | A G BRYDON, Garnett Group of Associated Companies, UK (Sections 2.1-2.12) and A. POURMOHAMMADI, Consultant. Iran (Sections 2.13-2.20) | |
| 2.1 | Introduction | 16 |
| 2.2 | Selection of raw materials for carding | 16 |
| 2.3 | Opening of fibres | 19 |
| 2.4 | Mixing and blending | 24 |
| 2.5 | Carding: working and stripping principles | 32 |
| 2.6 | Roller operations | 37 |
| 2.7 | Card clothing | 44 |
| 2.8 | Card and Garnett machine configurations | 53 |
| 2.9 | Card feed control, weight measurement and other | |
| | control systems | 58 |
| 2.10 | Cross-lapping | 67 |
| 2.11 | Batt drafting | 71 |
| 2.12 | Vertically lapped (perpendicular-laid) web | |
| | formation | 72 |
| 2.13 | Airlaid web formation: raw materials and fibre | |
| | preparation | 76 |
| 2.14 | Airlaying technology | 80 |

| 2.15 | Developments in airlaying | 98 |
|------|--|-----|
| 2.16 | Airflow and fibre dynamics in airlaying | 101 |
| 2.17 | Bonding and web consolidation | 104 |
| 2.18 | Physical properties and practical applications of | 104 |
| | airlaid fabrics | 106 |
| 2.19 | Direct feed batt formation | 109 |
| 2.20 | References | 109 |
| 3 | Wet-laid web formation | 112 |
| | C WHITE, Consultant, France | |
| 3.1 | Introduction | 112 |
| 3.2 | Background and historical developments | 112 |
| 3.3 | Theoretical basis of wet forming | 114 |
| 3.4 | Raw materials for wet-laid nonwovens | 116 |
| 3.5 | Cellulose fibre preparation | 126 |
| 3.6 | Man-made fibre preparation | 126 |
| 3.7 | Web-forming process technology | 128 |
| 3.8 | Bonding systems for wet-laid nonwovens | 135 |
| 3.9 | Finishing | 138 |
| 3.10 | Product applications | 139 |
| 3.11 | Sources of further information | 141 |
| 3.12 | References | 141 |
| 4 | Polymer-laid web formation | 143 |
| | G S BHAT, University of Tennessee, USA and S R MALKAN, | 110 |
| | Synfil Technologies, USA | |
| 4.1 | Introduction | 143 |
| 4.2 | Resins for spunbonding and meltblowing | 143 |
| 4.3 | Spunbond fabric production | 149 |
| 4.4 | Spunbond production systems | 155 |
| 4.5 | Bonding techniques | 157 |
| 4.6 | Operating variables in the spunbond process | 160 |
| 4.7 | Structure and properties of spunbond fabrics | 168 |
| 4.8 | Spunbond fabric applications | 171 |
| 4.9 | Meltblown fabric production | 172 |
| 4.10 | Meltblown characterization techniques | 180 |
| 4.11 | Characteristics and properties of meltblown fabrics | 184 |
| 4.12 | Meltblown fabric applications | 185 |
| 4.13 | Mechanics of the spunbond and meltblown processes | 186 |
| 4.14 | Composite fabrics and other extrusion processes | 192 |
| 4.15 | Future trends | 195 |
| 4.16 | References | 195 |
| | | |

| 5 | Mechanical bonding S C ANAND, The University of Bolton, UK (Sections 5.1-5.8); D BRUNNSCHWEILER, Consultant, and G SWARBRICK, Foster Needle Ltd, UK (Sections 5.9-5.13);and S J RUSSELL, University of Leeds, UK (Sections 5.14-5.19) | 201 |
|------|---|-----|
| 5.1 | Stitch bonding: introduction | 201 |
| 5:2 | The Maliwatt and Malivlies stitch-bonding systems | 202 |
| 5.3 | The Malimo stitch-bonding system | 206 |
| 5.4 | Malipol | 214 |
| 5.5 | Voltex | 215 |
| 5.6 | Kunit | 216 |
| 5.7 | Multiknit stitch-bonding systems | 217 |
| 5.8 | Recent developments in stitch bonding | 220 |
| 5.9 | Needlepunching: introduction | 223 |
| 5.10 | Needle design and selection | 226 |
| 5.11 | Penetration depth and other factors affecting needle use | 234 |
| 5.12 | Needlepunching technology | 240 |
| 5.13 | Applications of needlepunched fabrics | 251 |
| 5.14 | Hydroentanglement: introduction | 255 |
| 5.15 | The principles of hydroentanglement | 256 |
| 5.16 | Fibre selection for hydroentanglement | 264 |
| 5.17 | Process layouts | 269 |
| 5.18 | Hydroentanglement process technology | 275 |
| 5.19 | Applications of hydroentangled fabrics | 288 |
| 5.20 | Acknowledgements | 294 |
| 5.21 | References | 294 |
| 6 | Thermal bonding A Pourmohammadi, <i>Consultant, Iran</i> | 298 |
| 6.1 | Introduction | 298 |
| 6.2 | Principle of thermal bonding | 299 |
| 6.3 | Raw materials | 300 |
| 6.4 | Calender (contact) bonding | 305 |
| 6.5 | Through-air and impingement bonding | 318 |
| 6.6 | Thermal radiation/infra-red and ultrasonic bonding | 322 |
| 6.7 | Thermally bonded fabric structure | 325 |
| 6.8 | Applications of thermally bonded fabrics | 327 |
| 6.9 | References | 328 |
| 7 | Chemical bonding R A CHAPMAN, Warwick Innovation Limited, UK | 330 |
| 7.1 | Introduction | 330 |
| 7.2 | Chemical binder polymers | 331 |

vii

| | iii | Contents |
|--|-----|----------|
|--|-----|----------|

| 7.3 7.4 7.5 7.6 7.7 | Mechanism of chemical bonding Methods of binder application Drying Applications of chemically bonded nonwovens References | 344 349 356 361 366 |
|---------------------------------|---|---------------------------------|
| 8 | Nonwoven fabric finishing A AHMED, NIRI, UK | 368 |
| 8.1 | Introduction | 368 |
| 8.2 | Wet finishing | 369 |
| 8.3 | Application of chemical finishes | 376 |
| 8.4 | Lamination | 385 |
| 8.5 | Mechanical finishing | 389 |
| 8.6 | Surface finishing | 394 |
| 8.7 | Developing technologies | 398 |
| 8.8 | Fabric inspection | 399 |
| 8.9 | Acknowledgements | 400 |
| 9 | Characterisation, testing and modelling of nonwoven fabrics N MAO and S J RUSSELL, University of Leeds, UK (Sections 9.1-9.21), B POURDEYHIMI, Nonwovens Cooperative Research Centre, North Carolina State University, USA (Section 9.22) | 401 ; |
| 9.1 | Introduction: characterisation of nonwoven fabrics | 401 |
| 9.2 | Characterisation of fabric bond structure | 403 |
| 9.3 | Fabric weight, thickness, density and other structural | |
| | parameters | 408 |
| 9.4 | General standards for testing nonwovens | 413 |
| 9.5 | Measurement of basic parameters | 426 |
| 9.6 | Measuring fibre orientation distribution | 430 |
| 9.7 | Measuring porosity, pore size and pore size distribution | 431 |
| 9.8 | Measuring tensile properties | 439 |
| 9.9 | Measuring gas and liquid permeability | 440 |
| 9.10 | Measuring water vapour transmission | 441 |
| 9.11 | Measuring wetting and liquid absorption | 442 |
| 9.12 | Measuring thermal conductivity and insulation | 448 |
| 9.13 | Modelling pore size and pore size distribution | 449 |
| 9.14 | Modelling tensile strength | 452 |
| 9.15 | Modelling bending rigidity | 455 |
| 9.16 | Modelling specific permeability | 457 |
| 9.17 | Modelling absorbency and liquid retention | 467 |
| 9.18 | Modelling capillary wicking | 468 |
| 9.19 | Modelling thermal resistance and thermal conductivity | 474 |

| References | 502 | |
|--|---|--|
| of thermal bonded nonwoven fabrics | 492 | |
| The influence of fibre orientation distribution on the | orientation distribution on the properties | |
| Modelling filtration properties | 483 | |
| Modelling acoustic impedance | 478 | |
| | Modelling acoustic impedance Modelling filtration properties The influence of fibre orientation distribution on the of thermal bonded nonwoven fabrics References | |