Jan. 3, 1967 C. H. TURPIN ET AL 3,295,744

TOP CLOSURE FOR BAG

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FIG. 2

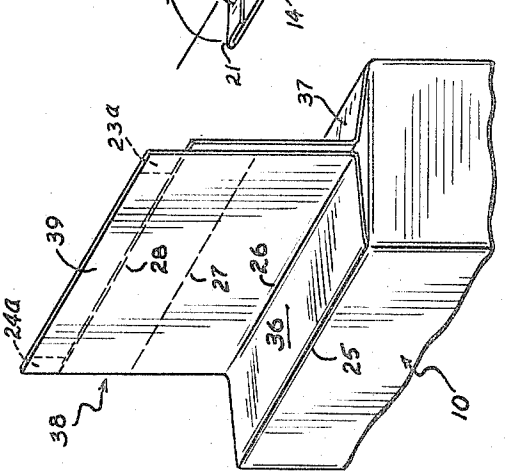


FIG. 3

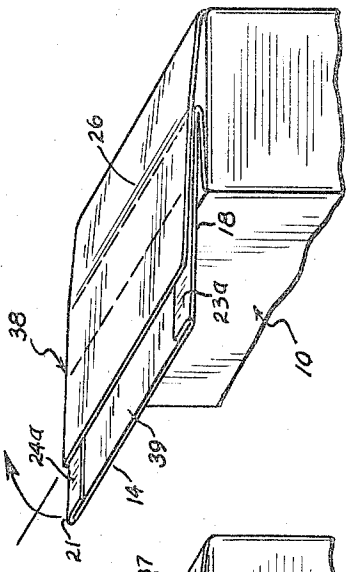


FIG. 4

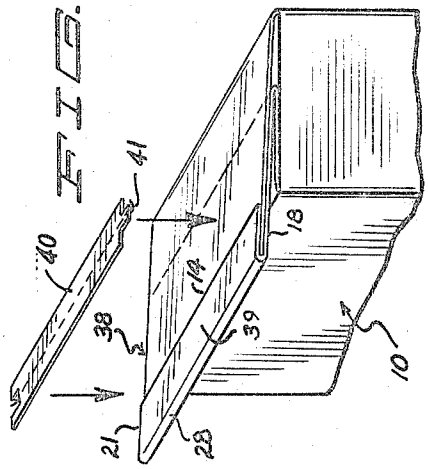


FIG. 5

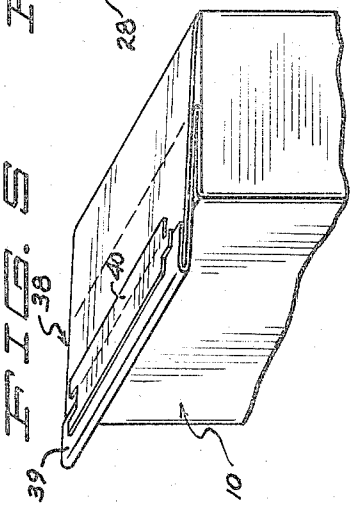


FIG. 6

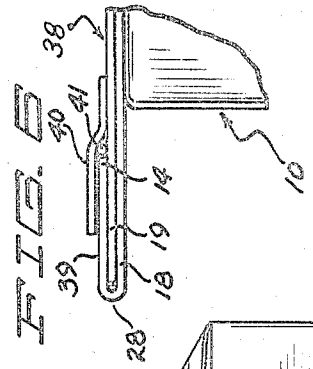
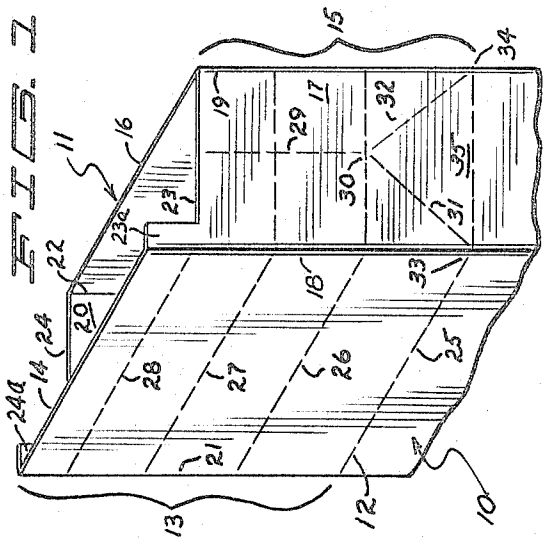


FIG. 7



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FIG. 6

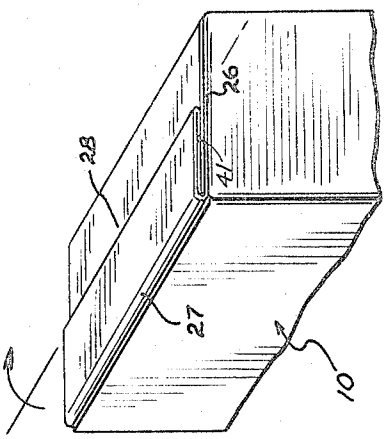


FIG. 8

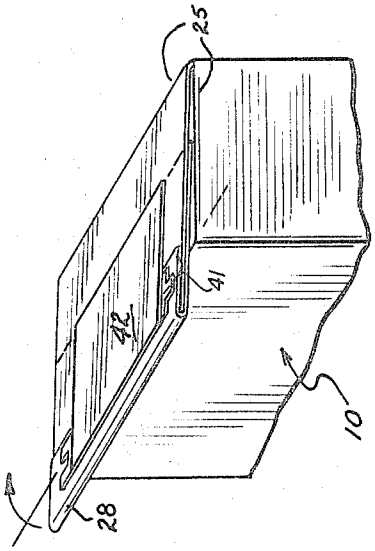


FIG. 9

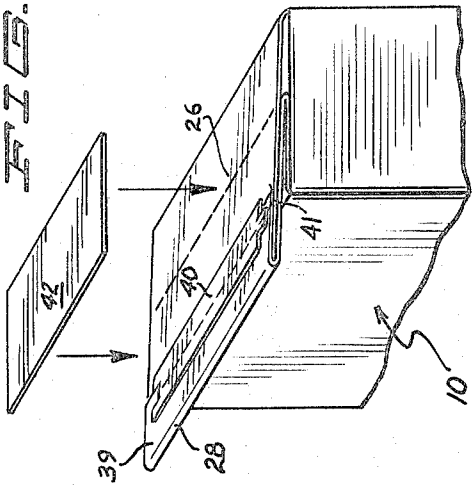


FIG. 12

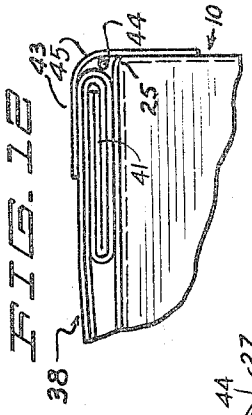


FIG. 11

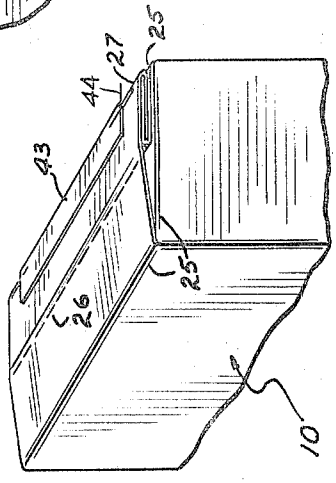
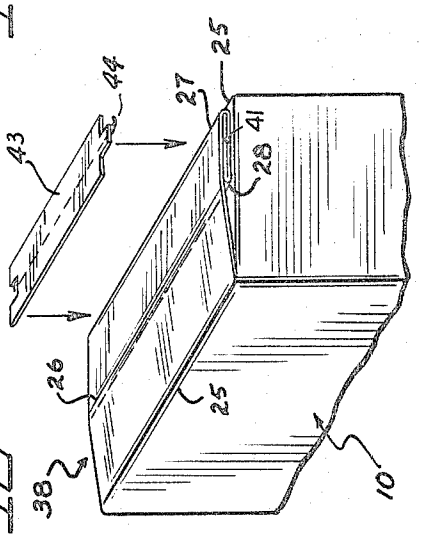


FIG. 10



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FIG. 15

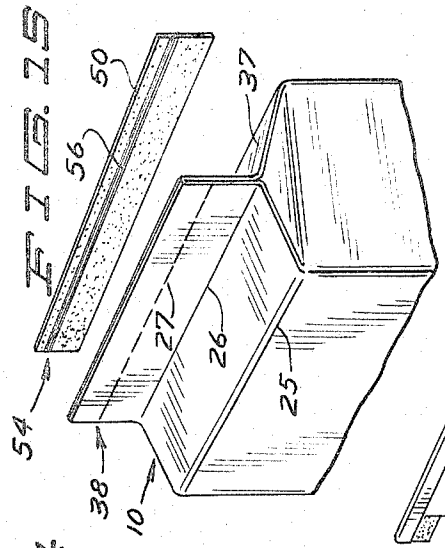


FIG. 16

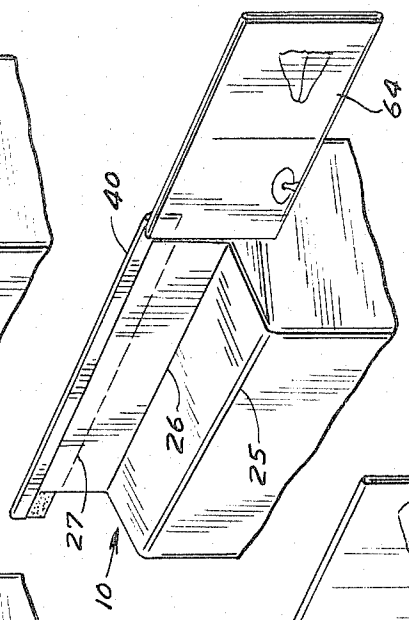


FIG. 14

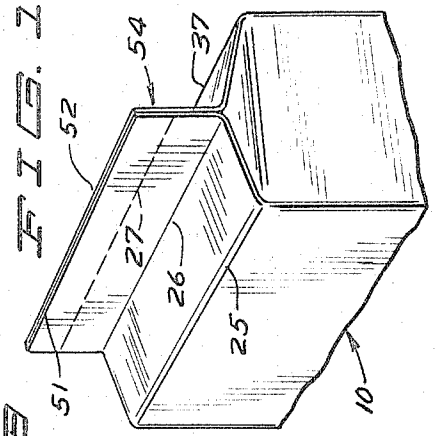


FIG. 17

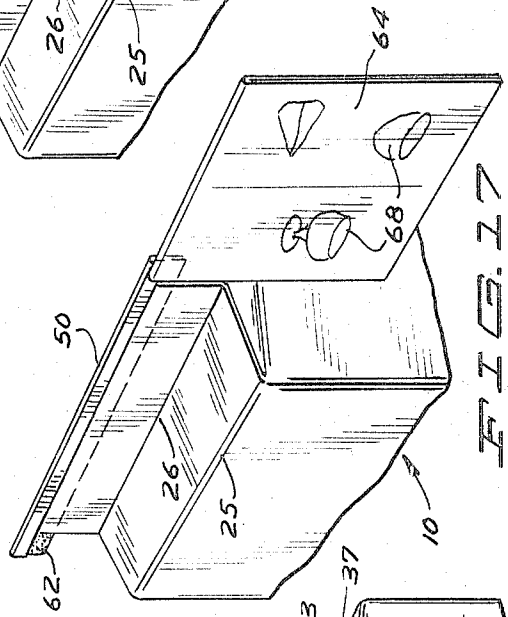


FIG. 18

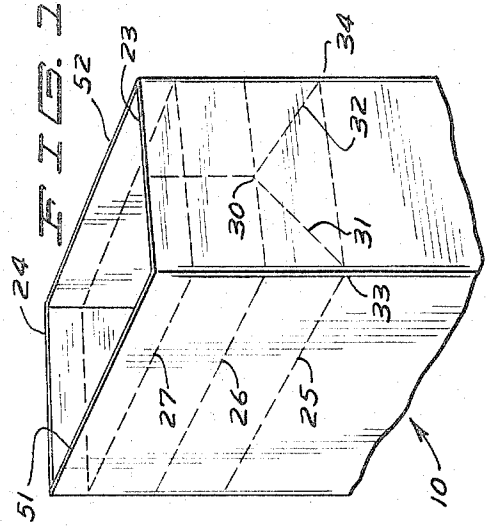
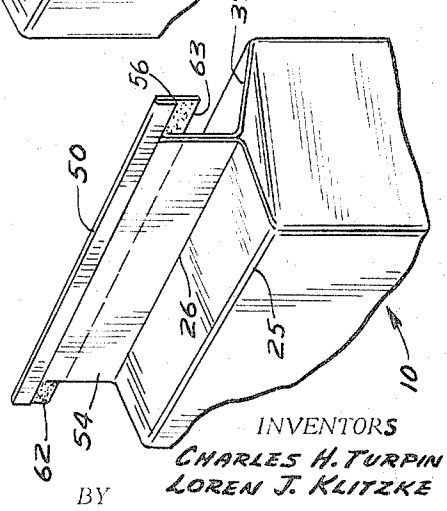


FIG. 19



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FIG. 27

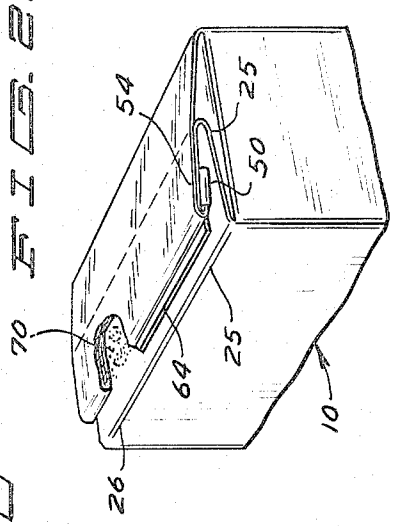


FIG. 24

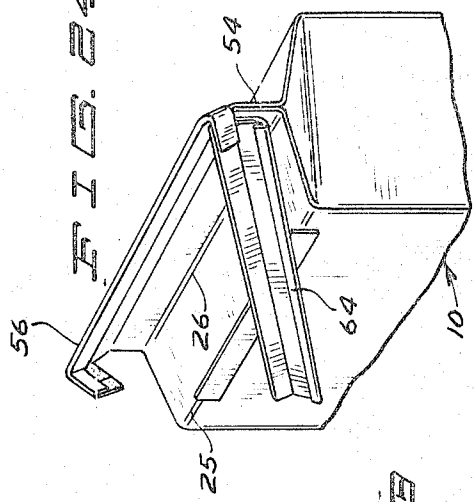


FIG. 20

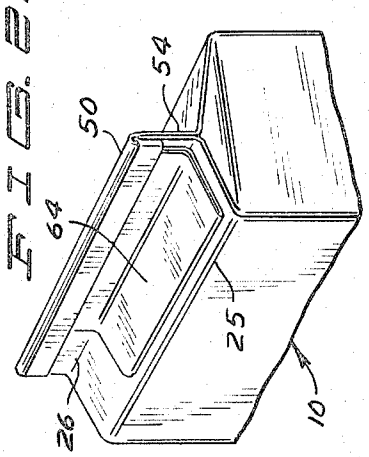


FIG. 23

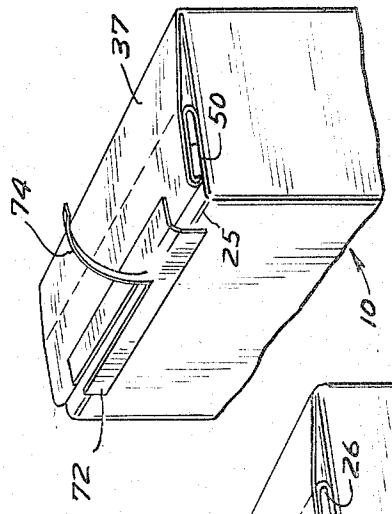


FIG. 19

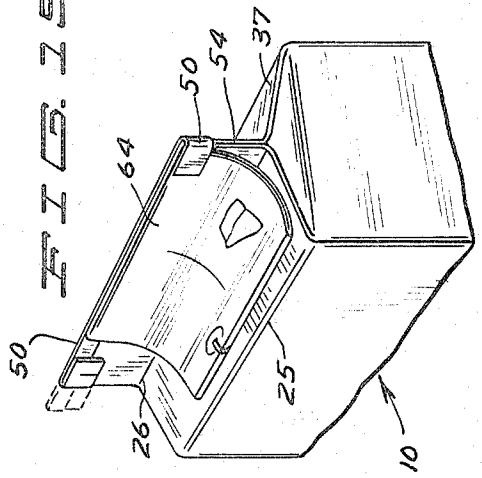
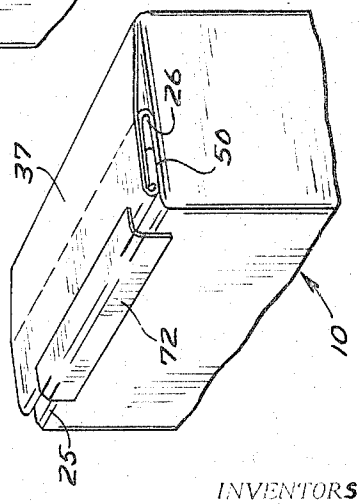


FIG. 22



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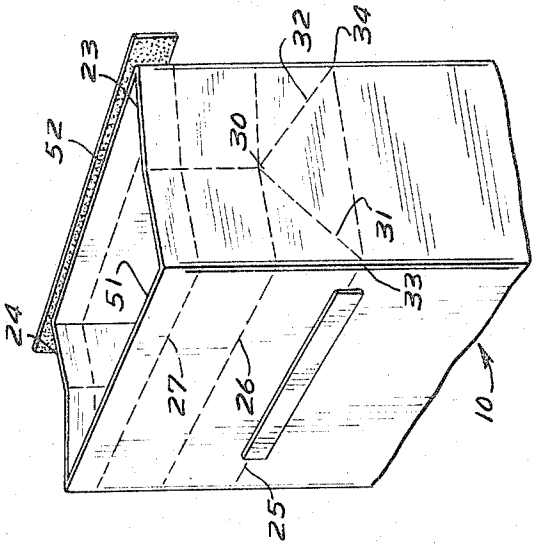


FIG. 27

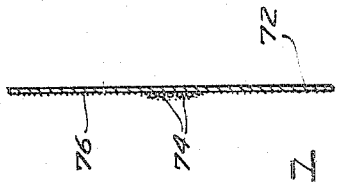


FIG. 27A

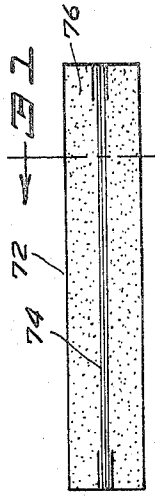


FIG. 27B

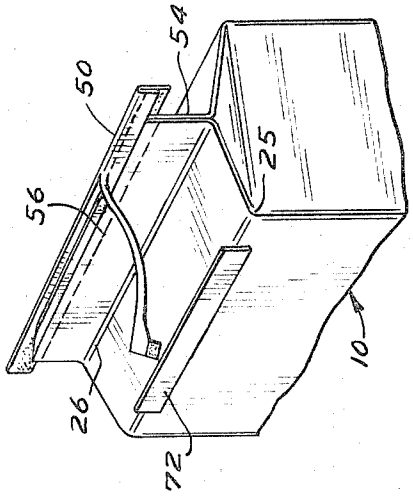


FIG. 26

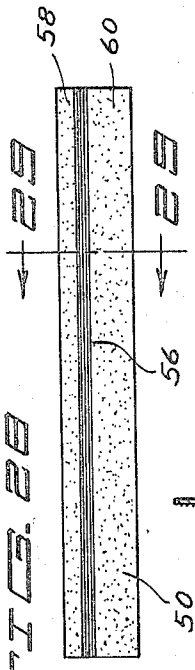


FIG. 28

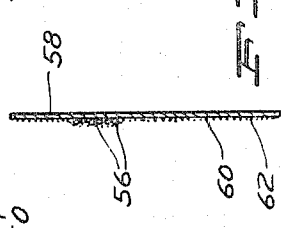


FIG. 28A

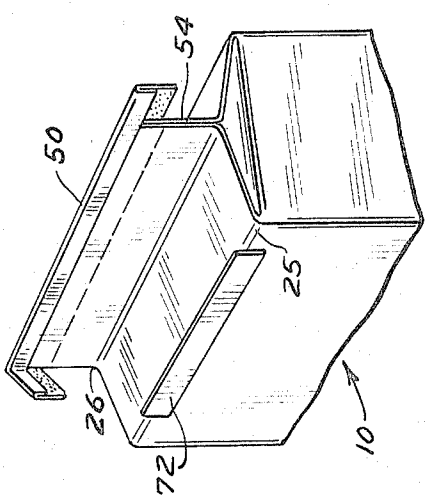


FIG. 25

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United States Patent Office

3,295,744

Patented Jan. 3, 1967

3,295,744

TOP CLOSURE FOR BAG

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Filed Mar. 29, 1965, Ser. No. 445,849
15 Claims. (Cl. 229—62)

This invention relates to flexible sheet bag construction, and more particularly to a top closure therefore.

In the packaging of finely divided substance such as dry powders, flour type food products or other "dusty" substances it becomes important to effect a tight closure to insure against leakage created by puffing or sifting of the material through minute cracks or pin holes. In some instances substantial leakage can occur through a crack created by the edge of a single thickness of paper which may be otherwise sealed perfectly by an overlapping sheet secured marginally of the edge. In the case of flour products, unsightly whitish dust may be deposited upon surfaces adjacent the package and the exterior of the package can become coated with dust from which it becomes transferred to the hands and clothing of one handling the package or bag.

Where the powdery substance is toxic or has intense coloring effect, as in the case of finely ground dye stuffs, a small amount of leakage can have disastrous consequences. It is therefore within the contemplation of this invention and a general object thereof to provide a sack or bag with a novel type closure which inhibits any sifting or leakage of a powdery product contained therein.

It is a further object of the invention to provide a neat appearing bag closure suitable for any finely divided or particulate product, the closure being capable of easy formation and sealing and also capable of being easily opened by a consumer without the use of expensive construction or requirements of special instrumentalities. While tight seals may be produced in metal or glass and plastic containers, having hermetically sealed lids or screw type caps, the instant invention is concerned with closures made from inexpensive sheet materials such as paper from which such hermetic or pressure type closures are not conventionally made.

Another object of the invention is to provide a folded top closure for flour bags and the like, wherein sheet brochures such as recipes, literature and coupons may be simply protected and secured without coming into contact with the contents of the bag. The special top closure which makes it possible for such enclosures to be thus cooperatively included prevents the messy dusting and coating of the sheets with product material and conversely prevents contamination of the product material with bacteria, ink and so forth which may become transferred from the sheet inserts.

A further object of the invention is to provide a top closure of the class described which is consistent with a rectilinear bag construction.

Still another object of the invention is the provision of a top closure of the class described wherein the cut edges at the upper end of the bag are positioned in alignment whereby both edges can be simultaneously formed by means of commercially available cutting equipment and wherein a substantially dust-tight seal can be provided.

Yet another object of the invention is the provision of an improved bag closure of the type described with a means for securely retaining the insert sheet within the folds of the closure but out of contact with the contents of the bag whereby contamination of the sheet

by the material within the bag is prevented and means for assuring that the sheet will be clearly visible when the bag is opened so that it can be easily seen by the person opening the bag.

A still further object of the present invention is the provision of an improved bag closure of the type described wherein a means is provided for securely bonding a sheet of paper or similar article carrying printed matter thereon adjacent to the bag closure at one end thereof without the requirement of any adhesive in addition to that normally used in closing the bag end.

These and other objects and advantages of this invention will more fully appear from the following description, made in connection with the accompanying drawings, wherein like reference characters refer to the same or similar parts throughout the several views and in which:

FIGURE 1 is a perspective view of the upper portion of the rectilinear flexible sheet bag made in accordance with the invention, the top being shown in open condition and the fold lines indicated by dotted configuration;

FIGURE 2 shows the formation of the gusseted and flattened cover flap;

FIGURE 3 is a view similar to that of FIGURE 2 showing the cover flap bent downwardly to expose the inner area of the upper portion thereof, the arrow indicating the direction of the top fold;

FIGURE 4 shows the relative position of the inner tear strip prior to securement;

FIGURE 5 shows the inner tear strip in affixed position;

FIGURE 6 is an enlarged segmental edge view of the folded assemblage of FIGURE 5;

FIGURE 7 shows the relative positions of a sheet insert and the first tear strip;

FIGURE 8 shows the sheet insert in applied position;

FIGURE 9 shows the inner tear strip and sheet insert folded within the top closure;

FIGURE 10 shows the final fold which places the top closure in a substantially horizontal plane, the second tear strip being aligned for affixation;

FIGURE 11 shows the second tear strip secured over the top closure and against the sidewall material of the bag to complete the closure;

FIGURE 12 is an edge view of an enlarged segment of the folded material as viewed in FIGURE 11;

FIGURE 13 is a perspective view of the modified form of bag end closure in accordance with the present invention with the bag end in an open position and subsequent figures show successive fabrication steps wherein;

FIGURE 14 is a perspective view of the bag end closure of FIGURE 13 following closure of the bag end;

FIGURE 15 is a view similar to FIGURE 14 showing a tear strip immediately before being attached to the end of the bag;

FIGURE 16 is a view similar to FIGURE 15 showing the tear strip after being attached;

FIGURE 17 is a view similar to FIGURE 16 showing the insert sheet immediately after being secured to the bag;

FIGURE 18 is a view similar to FIGURE 16 showing the insert sheet after being folded upwardly upon itself;

FIGURE 19 is a view similar to FIGURE 18 showing the insert sheet folded to a position adjacent the end closure or cover flap of the bag;

FIGURE 20 is a view similar to FIGURE 19 showing the cover flap after being turned downwardly upon the insert sheet;

FIGURE 21 is similar to FIGURE 20 but shows the next stage of fabrication, that of folding the cover flap to a horizontal position adjacent the top surface of the bag with adhesive used to secure the turn-down fold to the bag end;

FIGURE 22 shows the same stage of fabrication illustrated in FIGURE 21 with a modified securing means wherein a retaining tape is applied to secure the turned down flap in position;

FIGURE 23 is a perspective view illustrating the first stage of opening the closure of FIGURE 22;

FIGURE 24 shows the second stage of opening the end closure of FIGURE 22;

FIGURE 25 shows the end closure following the removal of the insert sheet of FIGURE 22;

FIGURE 26 is a view similar to FIGURE 25 showing the first stage of opening of the sealed ends of the bag;

FIGURE 27 is a view similar to FIGURE 26 showing the end of the bag after it has been opened;

FIGURE 28 is a plan view of the tear strip used to seal the end of the bag;

FIGURE 29 is a transverse sectional view taken on line **29—29**;

FIGURE 30 is a plan view of the tape used for sealing the cover flap against the top surface of the bag; and,

FIGURE 31 is a transverse sectional view along line **31—31** of FIGURE 30.

With particular reference to FIGURE 1, it is contemplated that the present invention be employed with a flexible sheet bag **10** which has excess sidewall material extending above plane **12** which defines the top level of a product to be packaged in the bag **10**. As viewed in FIGURE 1, the rectangular side sheet **13** defines a continuation of one side of the flexible sheet bag and extends a predetermined distance from the line **12** up to its top edge **14** as shown. The opposed rectangular side sheet **15** extends from the line **12** upwardly to its top edge **16** for a distance somewhat less than that of the height of the first mentioned rectangular side sheet **13**. To complete the rectilinear open top closure, end sheet **17** forms a side edge juncture **18** with side sheet **13** and another edge juncture **19** with the side sheet **15**. Similarly, the end sheet **20** forms an edge juncture **21** with the sheet **13** and an edge juncture **22** with side sheet **15**.

It will be noted that side sheet **13** extends upwardly for a greater distance than the side sheet **15** and that a cut away portion **23** is defined by the top edge of the end sheet **17**. A similar cut away portion defined by edge **24** appears at the end sheet **20**. Tab areas *23a* and *24a* remain in the respective end sheets **17** and **20** and extend for the full height of the side sheet **13**.

In the preparation of the sheet bag, it is sometimes desirable to score fold lines in advance, particularly where a rectilinear appearance is to be maintained in the filled and completed package. The dotted line configurations of FIGURE 1 may thus represent pre-scored lines or may simply be indicated as lines along which subsequent folding will occur. The fold line **25** is circumscribed about all of the upstanding sheets and coincides with the top level **12** of a product to be contained within the bag or package. A second fold line **26** is also circumscribed about the four sheets so as to be parallel to the line **25** and at a distance above the latter which is substantially equivalent to one-half the distance across the bag top from the side sheet **13** to the side sheet **15**. A third fold line **27** is similarly circumscribed about all four of the sheets at a position intermediate the fold line **26** and the top edge **16** of the side sheet **15**. A fourth fold line **28** lies parallel to the other circumscribed lines and extends across a side sheet **13** and the tab members *23a* and *24a* in a plane coincident with the top edge **16** of sheet **15**.

To complete the description of the fold lines, the end sheet **17** is provided with a medial vertical fold line **29** which extends from the cut away edge **23** down to the circumscribed fold line **26** as shown in FIGURE 1. At the juncture **30** of the vertical fold line **29** and the horizontal line **26**, a pair of branch fold lines **31** and **32** extend downwardly to meet at the juncture **33** and **34** respectively of the juncture edges **18** and **19** with the horizontal circumscribed fold line **25**. The end sheet **20** also contains a vertical and a pair of branch fold lines which are identically positioned with respect to the respective fold lines **29**, **31** and **32** of the end sheet **17**.

Referring now to FIGURE 2, each of the end sheets **17** and **20** is caused to be infolded so that the triangular areas **35** of the respective end walls lie horizontally over the plane defining the top level of the packaged product. The panel portion **36** which lies between the fold lines **25** and **26** in the side sheet **13** is also caused to assume a horizontal position overlying half of the top area. Similarly, the panel **37** which lies between the fold line **25** and the fold line **26** in the side sheet **15** assumes a horizontal position over the other half of the top closure. The portions of all four sheets which lie above the fold line **26** are flattened into an upstanding structure or cover flap **38**.

The endmost panel **39** comprising tabs *23a* and *24a* and that portion of side sheet **13** which lies above the fold line **28** is then folded over in the direction of the arrow in FIGURE 3. For the sake of clarity, the entire cover flap has been shown as bent downwardly to the left about the circumscribed fold line **26**.

Referring now to FIGURE 4, the panel **39** is there shown as having been folded reversely with the tabs *23a* and *24a* folded inwardly to form an unbroken structure at the juncture lines **18** and **21**. A sealing means, which may conveniently comprise a flexible tape, may be provided with a tear string **41** placed longitudinally at the bottom thereof. The tear strip **40** is adhered to the folded over panel **39** and its outer edge **14**, as shown more clearly in FIGURE 5. Portions of the tear strip **40** are affixed to the panel **39** while the remaining portions are secured to the external surface of the cover flap **38**. FIGURE 6 shows in detail the edge view of the tear tape or strip **40** and the position of the string **41**, with respect to the panel **39** and edge **14** and the cover flap structure **38**. It will be noted that the sealing means or tear strip **40** constitutes a continuous dust seal for the entire width of the folded package with the cracks and small passageways effectively closed against the escape of dust when further folded and immobilized, as will be set forth subsequently.

Referring now to FIGURE 7, the folded panel **39** and the tear strip **40** lie outwardly and a sheet insert **42** is placed with one edge **43** adjacent to the tear strip **40** as shown in FIGURE 8. The insert sheet **42** may comprise advertising literature, recipes, premium coupons or the like and may be tacked or secured at a local spot to the top closure if desired. It has been found that the insert may effectively be frictionally held within the top closure without any securement whatsoever other than the entrapment of the folds of the closure. With the sheet insert in position as shown in FIGURE 8, the panel **39** and inner tear strip **40** are then folded about the fold line **27** as shown in FIGURE 9. Final folding in the direction of the arrow will bring the folded top closure to the position of FIGURE 10. If the fold line **27** is spaced from fold line **28** for a distance equivalent to half of the width of the bag **10**, the further folding of the cover flap about fold line **26** will bring the fold line **27** into a position which is coincident with the fold line **25** in the side sheet **16**.

An outer tear tape **43** may be similarly provided with a tear string **44** at the longitudinal underside thereof. The tear tape **43** is then adhered to the cover flap over the folded edge **27** so that a portion of the tape covers a margin of the cover flap and also extends over against an exterior surface of the side wall bag material. Where the folded edges **27** coincide with or register over the fold line **25** in the side sheet **15**, the outer tear tape **43** may be creased or bent longitudinally at right angles as shown in the enlarged side view of FIGURE 12. The tear string **44** will thus lie at the creased corner **45** of the tear tape **43**.

It will be noted that pin holes and sheet edge passage-

ways are blocked in the structure of the invention. The double tear tape securement, coupled with the folded structure, produces a pleasing rectilinear package in addition to effecting a dust tight enclosure. An important function of the inner sealing means in its folded condition is to provide the above mentioned blocking function. The outer tape performs the important function of locking the entire enclosure in its folded position and immobilizes the inner sealing means. The sheet insert is protected and securely held in the closure but at no time comes in contact with the product within the bag or package. The sheet insert is easily exposed and removed after the outer tear tape **43** is released and then the bag may be entirely opened by releasing the inner tear tape **40**.

Refer now to FIGURE 13 which shows the first stage of forming the closure in accordance with the modified form of the invention. On the major sidewalls of the bag are provided three vertically spaced horizontal fold lines **25**, **26** and **27** parallel with the cut edges at the end of the bag as described herein below. A fold line is also provided in each of the shorter end walls extending vertically from the point **30**. Inclined fold lines **31** and **32** extend downwardly from point **30** to the folded corners of the bag and intersect the fold lines **25** on each of the major sidewalls of the bag.

It should be noted that in the embodiment of the invention illustrated in FIGURES 13 through 27, the upward edges **51** and **52** of the bag are cut in alignment with each other. Since the edges **51** and **52** are aligned in this manner, the cutting operation can be performed at high speed with readily available cutting equipment.

In the next step of forming the bag, the major sidewalls of the bag are folded towards one another and the area of the bag distally of the fold lines **31** and **32** and above the points **30** are pressed inwardly until the sidewalls have been brought together at the end of the bag as shown in FIGURE 14 to form a cover flap **54**. As shown in FIGURES 15, 28 and 29 a tear strip **50** is provided that includes a strong tearing element such as strings **56** extending longitudinally thereof and positioned closer to one side edge than the other to divide the tape into a smaller and larger areas **58** and **60** respectively. The tear strip **50** can be secured to the flap **54** either by pressure or by heat depending upon the nature of adhesive material **62** that is applied to the same surface of the tape to which the string **56** is applied.

As shown in FIGURE 16, sealing strip **50** is placed against the flap **54** with the strings **56** adjacent the cut-ends **51** and **52** so that the large area **60** projects downwardly on one side and the small area projects downwardly a lesser distance on the other side of the flap **54**. It should also be noted that the ends of the tape project slightly beyond the side edges of the flap **54** and include areas of exposed adhesive designated **61** and **63** as shown in FIGURE 16.

Refer now to FIGURE 17 showing the first step of attaching an insert sheet **64** that consists of a flat sheet of paper to which pictures **68** or other indicia are printed describing the contents of the bag **10** or the applications to which the contents can be placed. The sheet **64** is sealed to the adhesive area **63** by either pressure or heat as the case may be. If the insert sheet is fairly large in size it can be folded upwardly against itself before the closure is completely sealed as shown in FIGURE 18.

FIGURE 19 shows how the insert sheet **64** is folded into abutting relationship with the flap **54** and the portion of the side wall bag between the fold lines **25** and **26**. In an alternative procedure for attaching insert sheet **64**, the side surface of the insert sheet **64** is initially placed adjacent to and in contact with the side of the flap **54**. The free end of tape **50**, for example, at the right in FIGURE 16 is folded centrally so that the adhesive **63** becomes bonded to the upper right hand underlying surface of the insert sheet **64** which then assumes the position shown in FIGURE 19.

Next, the uppermost portion of the flap **54**, the part containing the sealing strip **50**, is folded downwardly as shown in FIGURE 20 into abutting relationship with a portion of the insert sheet **64**. The flap **54** is then folded laterally to a horizontal position so that it lies against the insert sheet **64** and the top portion of the bag between the fold lines **26** and **25**. The flap **54** is secured to the portions of the top of the bag adjacent to the lower end of flap **54** and laterally thereof as shown in FIGURE 21 by means of a sealing strip such as tape **72** including a tearing means such as a string **74** in the center thereof running longitudinally and covered with an adhesive **76** which can be either of the pressure sensitive, thermally sensitive type or other kind. The sealing strip **72** can be secured in position as shown in FIGURE 22 either by the application of pressure or heat as required.

Refer now to FIGURE 22 which shows the first step of opening the package in accordance with the invention. As seen in FIGURE 23 the string **74** is pulled upwardly thereby severing the strips **72** and allowing the flap **54** to fold upwardly and the insert sheet **64** to swing outwardly where it can be easily seen by the person opening the bag.

It should also be noted that the insert sheet **64** will not be exposed to the contents of the bag. The insert sheet is then removed as shown in FIGURE 25.

In FIGURE 26 there is shown the first stage of opening the end of the bag. To accomplish this, the string **56** of the tear strip **50** is removed thereby enabling the cut ends **51** and **52** to be separated and the bag to be completely opened.

A great many changes will be apparent to skilled workers. For example, a surface adhesive such as paste **70** can be applied between flap **54** and the bag end in place of the tape **72**.

It will, of course, be understood that various other changes may be made in the form, details, arrangements, and proportions of the parts without departing from the scope of this invention as set forth in the appended claims.

What is claimed is:

1. A flexible sheet bag containing a finely divided substance having excess sidewall material extending above the plane defined by the top level of said substance, said bag comprising:

(a) a gussetted and flattened cover flap formed from excess upper sidewall material,

(b) said cover flap having an endmost panel folded against itself on an upper fold line parallel to the plane of the bag top,

(c) dust tight sealing means disposed at the marginal edge of said endmost panel and over the adjacent surface of the cover flap,

(d) said coverflap further having an innermost panel toward which said folded endmost panel is again folded on an outer fold line parallel to the plane of the bag top,

(e) and an outer tape adhesively affixed over said outer fold line and against the exterior surface of the bag sidewall material, whereby said dust tight sealing means and said upper fold line will be immobilized in its folded condition.

2. A flexible sheet bag containing a finely divided substance having excess sidewall material extending above the plane defined by the top level of said substance, said bag comprising:

(a) a gussetted and flattened cover flap formed from excess upper sidewall material,

(b) said cover flap having an endmost panel folded against itself on an upper fold line parallel to the plane of the bag top,

(c) an inner tear tape sealed marginally over the edge

of said endmost panel and over the adjacent surface of the cover flap,

(d) said cover flap further having an innermost panel toward which said folded endmost panel is again folded on an outer fold line parallel to the plane of the bag top,

(e) and an outer tear tape sealed marginally over said outer fold line and against the exterior surface of the bag sidewall material.

3. A flexible sheet bag containing a finely divided substance having excess sidewall material extending above the plane defined by the top level of said substance, said bag comprising:

(a) a gussetted and flattened cover flap formed from excess upper sidewall material,

(b) said cover flap having an endmost panel folded against itself on an upper fold line parallel to the plane of the bag top,

(c) an inner tear tape sealed marginally over the edge of said endmost panel and over the adjacent surface of the cover flap,

(d) said cover flap further having an innermost panel toward which said folded endmost panel is again folded on an outer fold line parallel to the plane of the bag top, said outer fold line falling substantially in registry with a top edge of said bag,

(e) and an outer tear tape sealed marginally over said outer fold line and downwardly against the exterior surface of the bag sidewall material.

4. A flexible sheet bag containing a finely divided substance having excess sidewall material extending above the plane defined by the top level of said substance, said bag comprising:

(a) a gussetted and flattened cover flap formed from excess upper sidewall material,

(b) said cover flap having an endmost panel folded against itself on an upper fold line parallel to the plane of the bag top, said endmost panel being formed of an upward marginal extention of sidewall material at one side and around partially into adjacent areas of the gussetted portions,

(c) an inner seal means continuously formed between the endmost panel and the adjacent surface of the cover flap,

(d) said cover flap further having an innermost panel toward which said folded endmost panel is again folded on an outer fold line parallel to the plane of the bag top,

(e) and an outer tape sealed marginally over said outer fold line and against the exterior surface of the bag sidewall material.

5. A flexible sheet bag containing a finely divided substance having excess sidewall material extending above the plane defined by the top level of said substance, said bag comprising:

(a) a gussetted and flattened cover flap formed from excess upper sidewall material,

(b) said cover flap having an endmost panel folded against itself on an upper fold line parallel to the plane of the bag top,

(c) an inner tear tape sealed marginally over the edge of said endmost panel and over the adjacent surface of the cover flap,

(d) said cover flap further having an innermost panel toward which said folded endmost panel is again folded on an outer fold line parallel to the plane of the bag top,

(e) an outer tear tape sealed marginally over said outer fold line and against the exterior surface of the bag sidewall material,

(f) and a sheet insert having one edge lying adjacent one of said tear tapes and in external contact against the cover flap but folded therewithin so as to be protected until the flap is released and unfolded.

6. A flexible sheet bag containing a finely divided substance having excess sidewall material extending above the plane defined by the top level of said substance, said bag comprising:

(a) a gussetted and flattened cover flap formed from excess upper sidewall material,

(b) said cover flap having an endmost panel folded against itself on an upper fold line parallel to the plane of the bag top,

(c) an inner tear tape sealed marginally over the edge of said endmost panel and over the adjacent surface of the cover flap,

(d) said cover flap further having an innermost panel toward which said folded endmost panel is again folded on an outer fold line parallel to the plane of the bag top,

(e) an outer tear tape sealed marginally over said outer fold line and against the exterior surface of the bag sidewall material,

(f) and a rectangular sheet insert having one marginal edge adhesively secured adjacent said inner tear tape and lying externally against the cover flap but folded therewithin so as to be protected until the cover flap is released and unfolded.

7. A rectilinear flexible sheet bag containing a finely divided substance having excess sidewall material extending above the plane defined by the top level of said substance, said bag comprising:

(a) a first rectangular side sheet extending a predetermined distance from the top of the bag sidewall structure,

(b) a second rectangular side sheet extending a distance less than said predetermined distance from the top of the bag sidewall structure,

(c) a first end sheet joined at each side edge to one pair of respectively opposed side edges of said rectangular side sheets,

(d) a second end sheet joined at each side edge to the other pair of respectively opposed side edges of said rectangular side sheets,

(e) each of said end sheets having a tab portion and a cut away portion at its upper marginal edge corresponding to the difference in the extension distances between said first and said second rectangular side sheets,

(f) a first horizontal fold line circumscribed around all of said sheets in the plane of the top of the product to be packaged,

(g) a second horizontal fold line circumscribed around all of said sheets at a distance from said first fold line which is equivalent to substantially one-half the distance from one rectangular side sheet to the other,

(h) a third horizontal fold line circumscribed around all of said sheets in spaced parallel relation to said second fold line,

(i) a fourth horizontal fold line parallel to each of the said circumscribed fold lines across said first rectangular side sheet and said tab portions and lying substantially at the same distance from the top of the bag sidewall structure as the extended distance of said second rectangular sheet,

(j) each of said end sheets having a medial vertical fold line from its top edge to the second fold line and a pair of fold lines branching from the juncture of the vertical fold line, said end sheets being infolded on said vertical, said branch, and said first horizontal fold lines and said side sheets being simultaneously convergently folded on said first and second horizontal fold lines to form a flattened structure of the excess sidewall material lying above the second horizontal fold line,

(k) said first sheet and said tab portions being reversely folded over the top of said closure on the said fourth horizontal fold line,

(l) an inner sealing means secured over the top edge

of the first sheet and tab portions and against the second rectangular side sheet,

(m) said side and end sheets all being further folded reversely on said third horizontal fold line into substantially a horizontal plane,

(n) and an outer tape adhesively secured over the area marginal to the reverse fold on said third horizontal fold line and over an adjacent area of the bag sidewall, whereby said sealing means and the associated sheet and tab portions will be immobilized in their infolded position.

8. A rectilinear flexible sheet bag containing a finely divided substance having excess sidewall material extending above the plane defined by the top level of said substance, said bag comprising:

(a) a first rectangular side sheet extending a predetermined distance from the top of the bag sidewall structure,

(b) a second rectangular side sheet extending a distance less than said predetermined distance from the top of the bag sidewall structure,

(c) a first end sheet joined at each side edge to one pair of respectively opposed side edges of said rectangular side sheets,

(d) a second end sheet joined at each side edge to the other pair of respectively opposed side edges of said rectangular side sheets,

(e) each of said end sheets having a tab portion and a cut away portion at its upper marginal edge corresponding to the difference in the extension distances between said first and said second rectangular side sheets,

(f) a first horizontal fold line circumscribed around all of said sheets in the plane of the top of the product to be packaged,

(g) a second horizontal fold line circumscribed around all of said sheets at a distance from said first fold line which is equivalent to substantially one-half the distance from one rectangular side sheet to the other,

(h) a third horizontal fold line circumscribed around all of said sheets in spaced parallel relation to said second fold line,

(i) a fourth horizontal fold line parallel to each of the said circumscribed fold lines across said first rectangular side sheet and said tab portions and lying substantially at the same distance from the top of the bag sidewall structure as the extended distance of said second rectangular sheet,

(j) each of said end sheets having a medial vertical fold line from its top edge to the second fold line and a pair of fold lines branching from the juncture of the vertical fold line to the respective junctures of the side edges of the end sheets with the first horizontal fold line, said end sheets being infolded on said vertical, said branch, and said first horizontal fold lines and said side sheets being simultaneously convergently folded on said first and said second horizontal fold lines to form a flattened structure of the excess sidewall material lying above the second horizontal fold line,

(k) said first sheet and said tab portions being reversely folded over the top of said closure on the said fourth horizontal fold line,

(l) an inner tear strip adhesively secured over the top edge of the first sheet and tab portions and against the second rectangular side sheet,

(m) said side and end sheets all being further folded reversely on said third horizontal fold line into substantially a horizontal plane,

(n) and an outer tear strip adhesively secured over the area marginal to the reverse fold on said third horizontal fold line and over an adjacent area of the bag sidewall.

9. The top closure of claim 7 wherein said third horizontal fold line registers with a side edge of the rectilinear bag and the outer tape is longitudinally creased at substantially a right angle whereby to secure the folded top closure with respect to the side wall of the bag.

10. The top closure of claim 7 wherein an insert sheet lies in contact with the exterior of the excess sidewall material, but is internally folded within the top closure and releasable therefrom upon removal of said tape.

11. A sheet bag containing a finely divided substance having excess sidewall material extending above the plane defined by the top level of said substance, said bag comprising a flattened cover flap formed from excess sidewall material, the top edges of the end of the bag being cut in alignment with each other, a dust-tight sealing means disposed at the marginal edge of the cover flap and sealed to the marginal edges thereof adjacent the cut end thereof, said dust-tight sealing means being bonded to itself beyond at least one side edge of the cover flap, an adhesive material covering the entire lower surfaces of said dust-tight sealing means exposed adjacent to said cover flap, said sealing means being folded over the cover flap along a longitudinally extending fold line disposed closer to one edge of said sealing means than the other edge thereof whereby a portion of the adhesive covered surface of the sealing means is exposed at at least one end thereof and an insert sheet bonded to the sealing means by the adhesive thus exposed, said cover flap being folded downwardly over the insert sheet.

12. The bag closure according to claim 11 wherein said sealing means is provided with a longitudinally extending tearing means positioned to extend longitudinally of the cut end of the bag along said fold line.

13. The combination in accordance with claim 11 wherein an adhesive is applied between the cover flap and the bag top for bonding the cover flap to the portion of the top of the bag adjacent to and laterally of the lower edge of the cover flap.

14. A flexible sheet bag containing a finely divided substance having excess sidewall material extending upwardly above the plane defined by the top level of said substance, said bag comprising in combination:

(a) a gussetted and flattened cover flap formed from excess upper sidewall material,

(b) an inner tear tape sealed marginally over the cut edge of the cover flap and sealed to the surfaces of the flap,

(c) an insert sheet bonded to the cover flap, and positioned adjacent the outside surface thereof,

(d) said cover flap being folded downwardly over the insert sheet, and

(e) a retaining means securing the cover flap to the side wall of the package adjacent the top level of the product laterally of the lower end of the cover flap.

15. A flexible sheet bag containing a finely divided substance having an excess sidewall material extending above the plane defined by the top level of said substance, said bag comprising a gussetted and flattened cover flap having upper and lower ends formed from excess upper sidewall material, a means for sealing the free edge of the cover flap, an insert sheet abutting the side wall of the cover flap and positioned adjacent to the portion of the bag extending from the lower end of the cover flap laterally toward the top end of the side wall of the bag and a second sealing means for securing the upper end of the cover flap in a downwardly folded position in abutting relationship with the upper end of the side wall of the bag, said second sealing means comprising a sealing strip having a tearing means thereon for severing said sealing strip, the second sealing means thereby securely retaining the insert sheet between the downwardly folded cover flap and the end of the side wall passing through said plane.

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