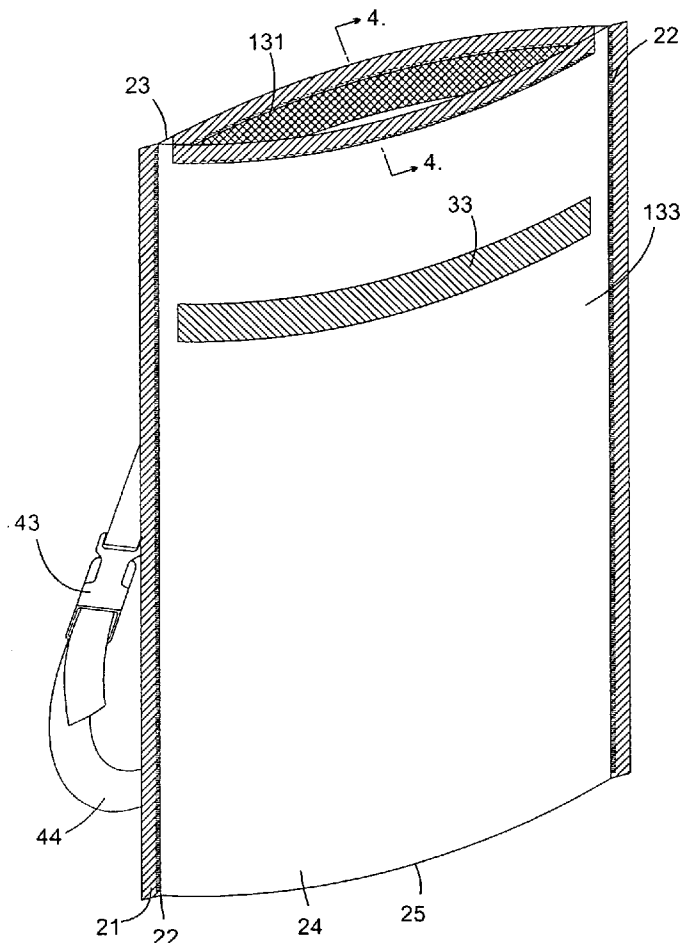




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(19) **United States**(12) **Patent Application Publication**
LYTLE(10) **Pub. No.: US 2013/0243354 A1**(43) **Pub. Date: Sep. 19, 2013**(54) **SELF SEALING WATERPROOF BAG**(71) Applicant: **MATTHEW MARK LYTLE,**
Huntington Beach, CA (US)(72) Inventor: **MATTHEW MARK LYTLE,**
Huntington Beach, CA (US)(21) Appl. No.: **13/886,638**(22) Filed: **May 3, 2013****Related U.S. Application Data**(63) Continuation-in-part of application No. 13/278,828,
filed on Oct. 21, 2011.(60) Provisional application No. 61/458,446, filed on Nov.
23, 2010.**Publication Classification**(51) **Int. Cl.**
B65D 33/24 (2006.01)(52) **U.S. Cl.**CPC **B65D 33/24** (2013.01)USPC **383/59**(57) **ABSTRACT**

A waterproof self sealing container sealed by magnet to magnet contact, making the container airtight and water resistant. The water resistant container has a body made of flexible water resistant material. The body is formed as a sheet. An opening is formed at an end of the body. The body opening has a body opening first side and a body opening second side. A first magnet strip is bonded to the body opening first side. A first bonding layer bonds to the body. The first magnet strip is bonded to the first bonding layer and wherein the first bonding layer is bonded to the body opening first side. A second magnet strip is bonded to the body opening second side. A flap magnet contact area is formed where the first magnet strip and the second magnet strip are free from the sidewalls of the body.



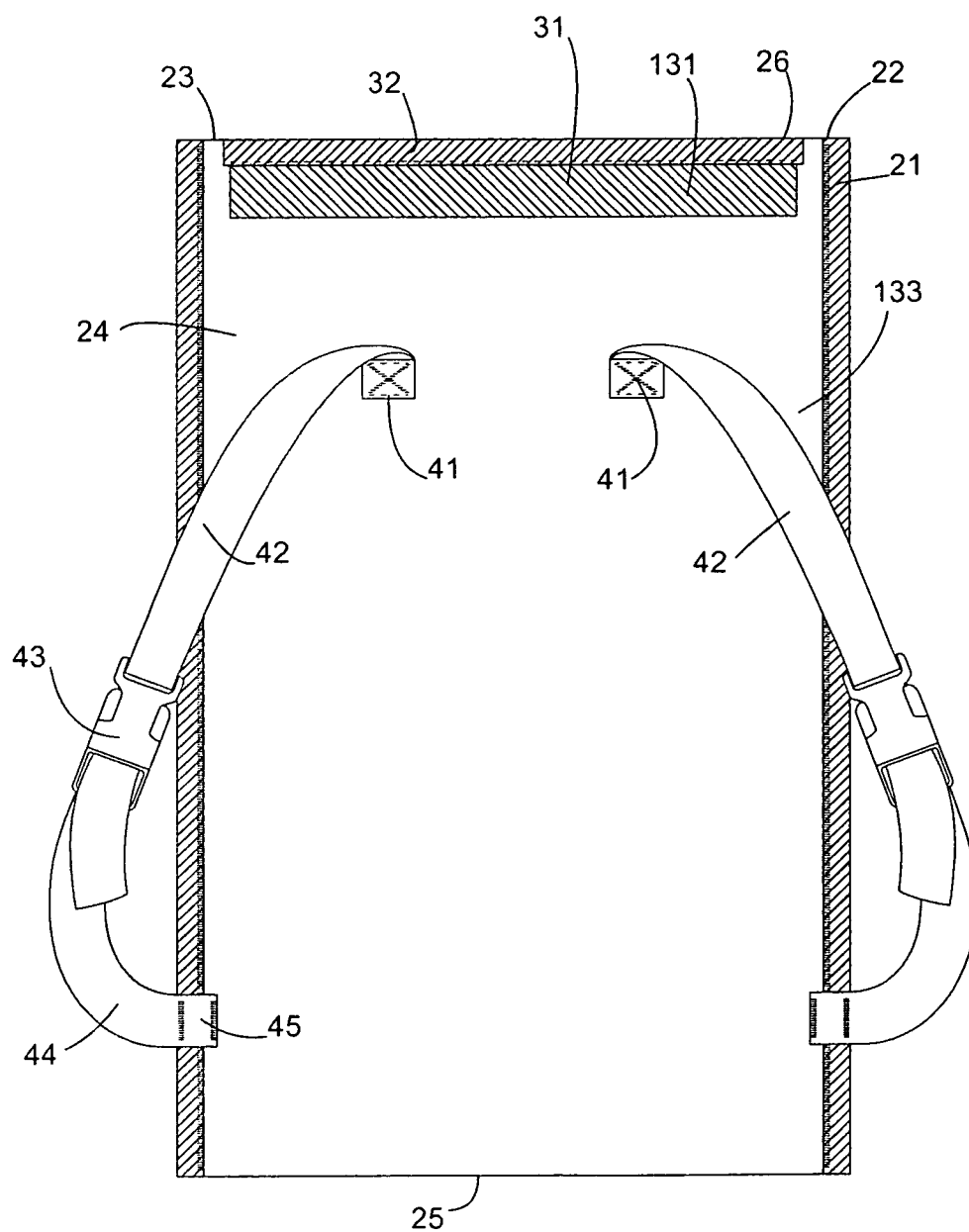


Fig. 1

Fig. 2

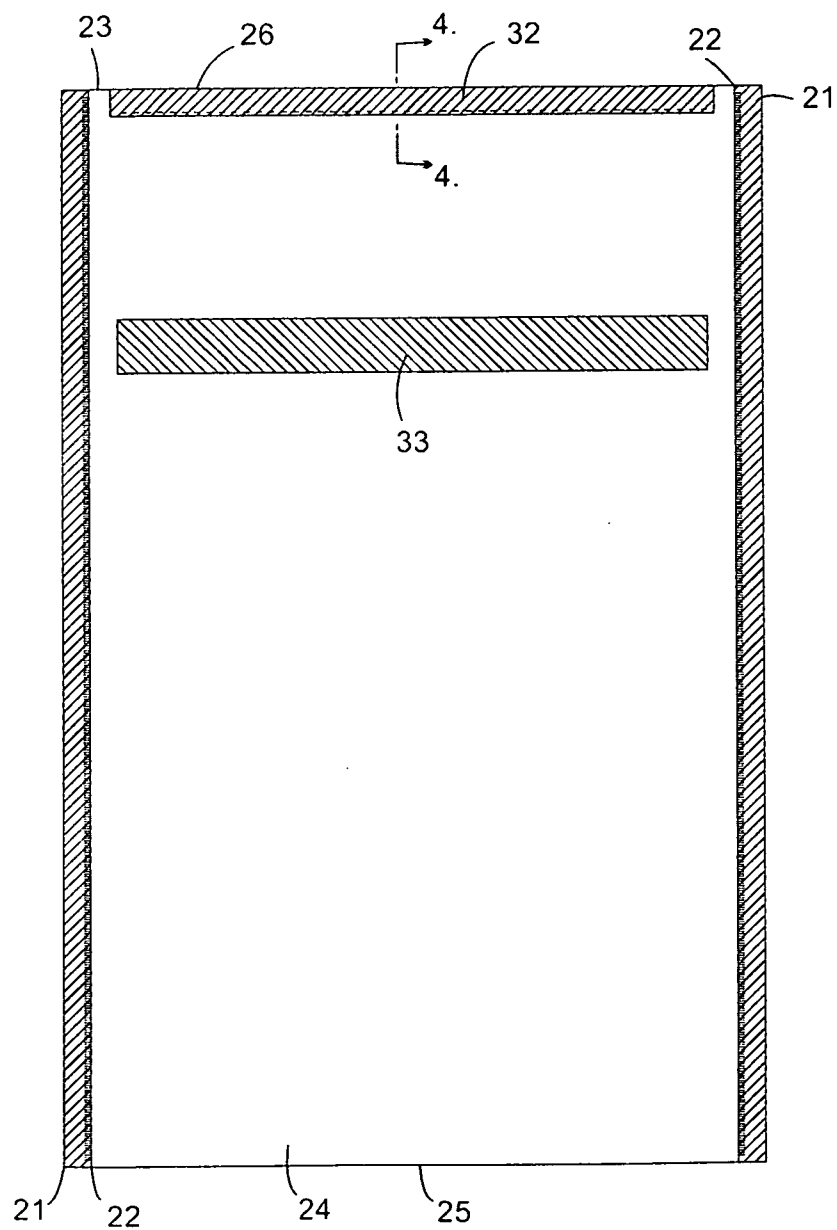


Fig. 3

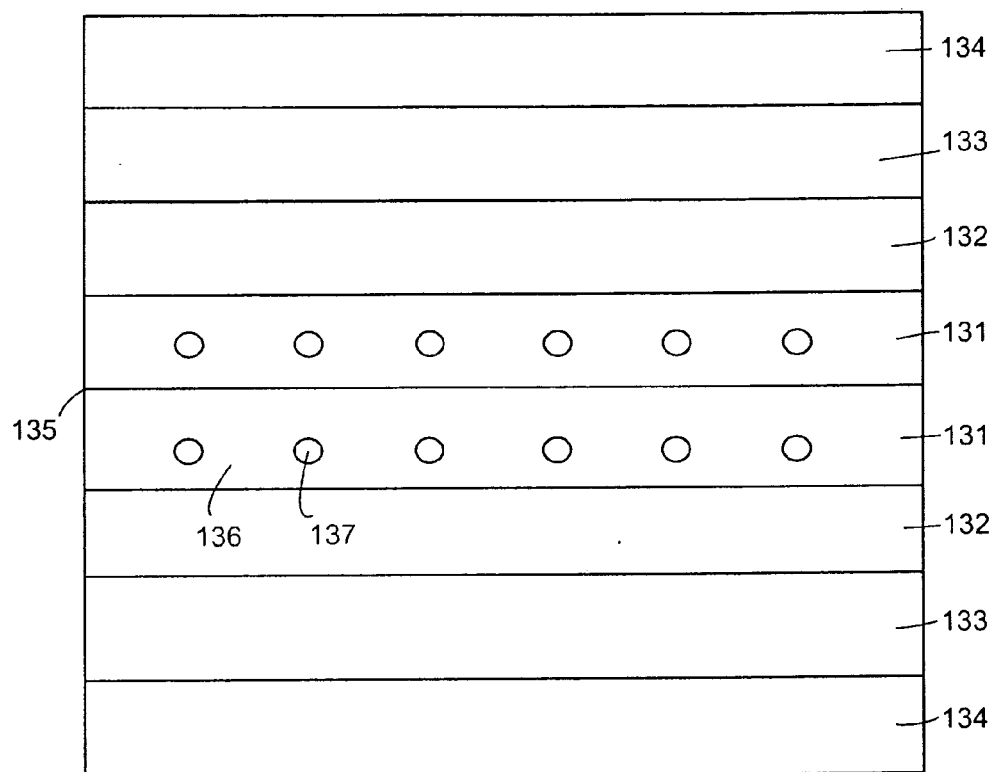


Fig. 4

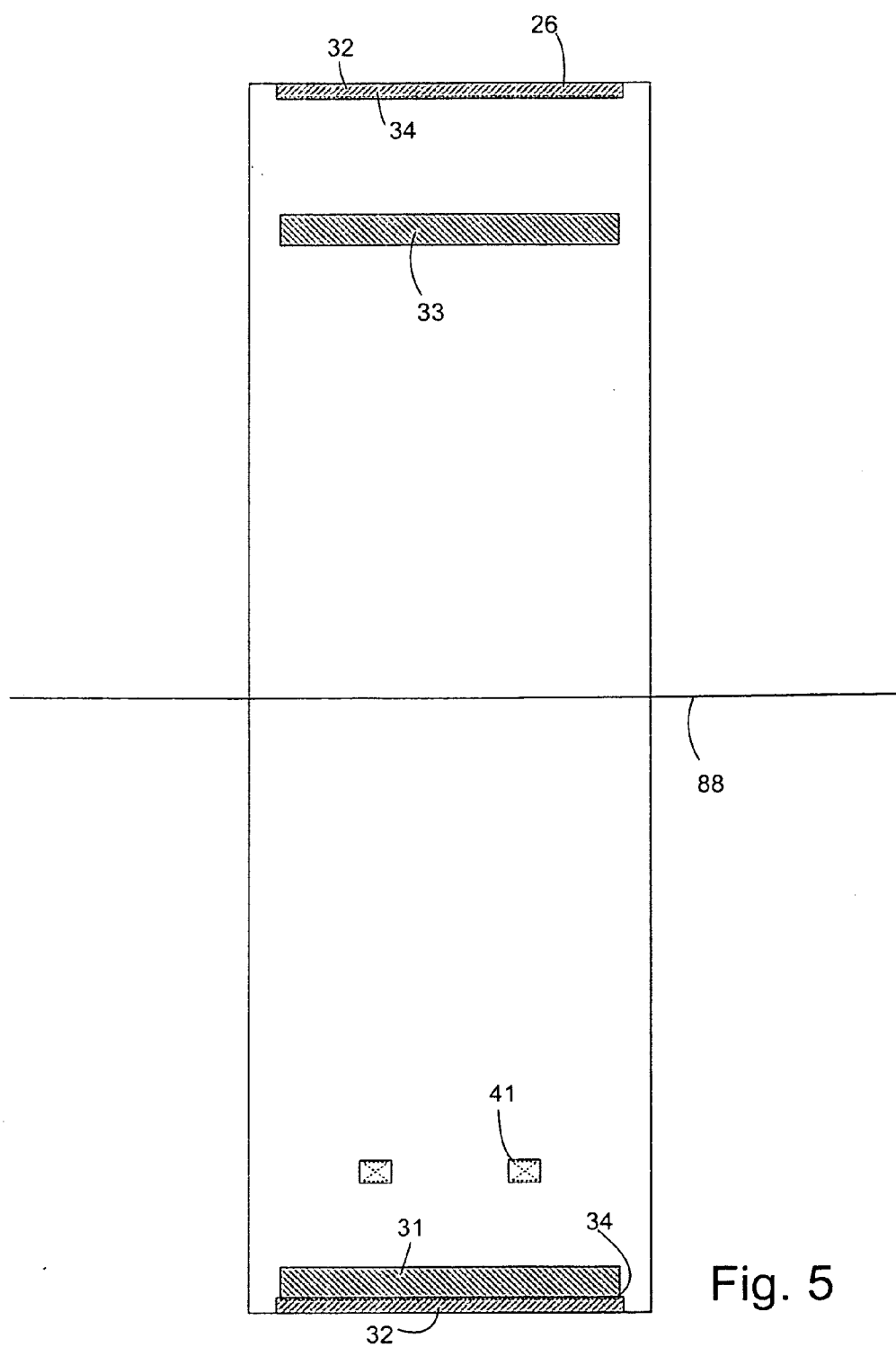


Fig. 5

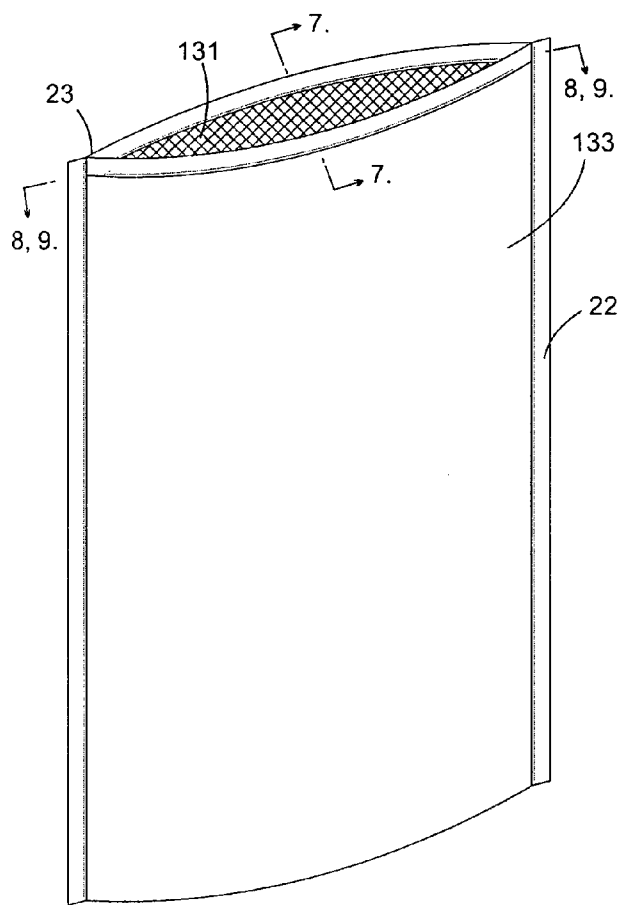


Fig. 6

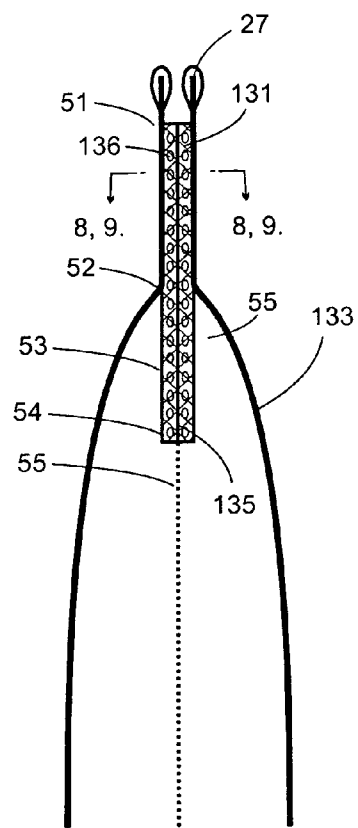


Fig. 7

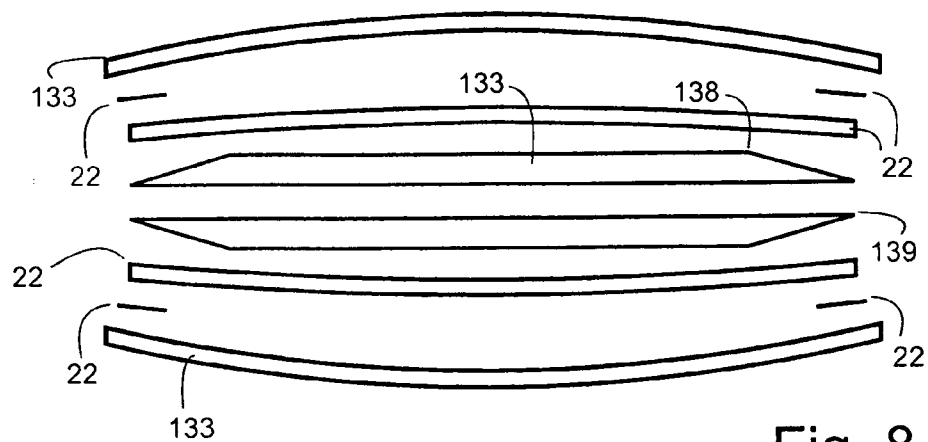


Fig. 8

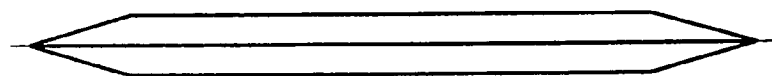


Fig. 9

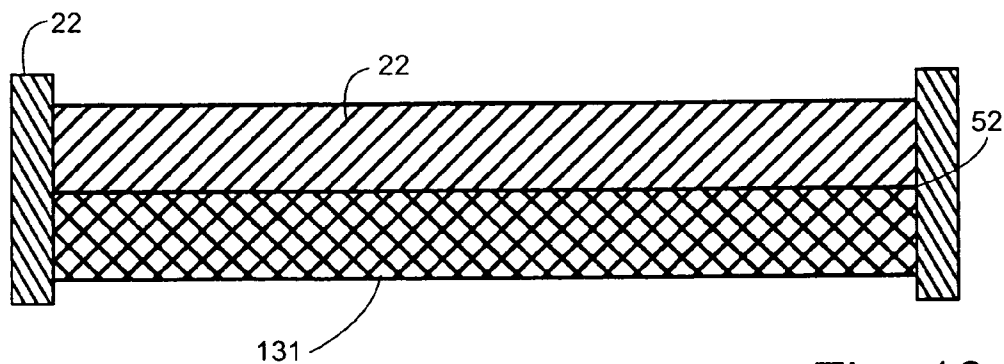


Fig. 10

SELF SEALING WATERPROOF BAG

[0001] The present invention is a continuation in part of U.S. non-provisional utility patent application Ser. No. 13/278,828 filed Oct. 21, 2011 entitled Self Sealing Waterproof Bag, by inventor Matthew Mark Lytle, which in turn claims continuation in part priority from provisional application 61/458,446 filed Nov. 23, 2010 by inventor Matthew Mark Lytle, the disclosure of which is incorporated herein by reference.

FIELD OF THE INVENTION

[0002] This invention relates in general to a self-sealing container.

DISCUSSION OF RELATED ART

[0003] An early waterproof bag was invented in 1912 by William J. Graham. In U.S. Pat. No. 1,038,351, issued on Sep. 1, 1912, Graham's waterproof bag comprises of hinged yokes and hinged frames that form a water tight joint.

[0004] Hibbard in U.S. Pat. No. 4,213,549 published Jul. 22, 1980 describes a waterproof storage bag and backpack that includes a harness and harness mounting grommets. The grommets permit the harness to cradle the bag and load items therein to enhance the top closure seal and to permit the bag to be opened without removal of the harness.

[0005] Masters in U.S. Pat. No. 4,421,150 published Dec. 20, 1983 describes a bag having a waterproof enclosure contained with an outer case having a cover flap, which fastens over a closure by a yieldable fastener to seal an article within the enclosure in a generally airtight waterproof environment. A safety fastener maintains the closure.

[0006] Gunzi, et al. in U.S. Pat. No. 5,797,683 published Aug. 25, 1998 describes a bag with an access opening made up of a pair of edges and a closure for closing the access opening. "The closure comprises a first bar secured to one edge and a second bar releasably connectable to the first with the edges clamped together to close the opening."

[0007] Townsend in U.S. Pat. No. 6,112,959 published in Sep. 5, 2000 describes a waterproof carrying bag and backpack for carrying items, the disclosure of which is incorporated herein by reference. The Townsend waterproof bag is described to include an outer case having top and bottom panels, a pair of side panels, a back panel and an open front. The outer case has top and bottom flaps that substantially cover the open front of the outer case. A waterproof inner pouch is provided in the outercase and is also detachably attached to the back panel of the outer case.

[0008] Kennedy in U.S. Pat. No. 6,435,392 B1 published Aug. 20, 2002 describes a lightweight waterproof pouch comprising an outer enclosure formed of flexible material, a removable and resealable waterproof and watertight inner pouch liner for insertion into the outer enclosure, and a strap attached to the outer enclosure.

[0009] Revels in US 2006/0072857 A1 published Apr. 6, 2006 describes a waterproof carrying case using a dielectric welding. The main body of the bag comprises an interlocking closure member fused in the open top and sealed against the main body by a pair of end sleeves positioned over a corner of the main body and the closure member. There is a pair of opening loop handles secured to the main body adjacent the closure member. Revels discussed shortcomings of prior art where moisture can seep through the line of closure through zippers.

[0010] Sakai in U.S. 2007/0261977 A1 published Nov. 15, 2007 describes a waterproof container that includes "an outer shell having a lid and a bottom portion connected by a zipper, an inner liner secured to and positioned within the outer shell, and a gap defined between the outer shell and the inner liner." The container has a drainage hole in the bottom portion that communicates the gap with the exterior of the container, allowing water entering through the zipper to fall through the gap and exit through the drainage hole.

[0011] Kirby in US 2009/0208146 A1 published Aug. 20, 2009 describes an impermeable bag with a sealing mechanism that prevents water from entering the bag and has a sealing mechanism for convenient opening and closing of the bag. The bag includes a first sidewall, a second sidewall, a flexible interlocking member and a flexible interposing member. The first sidewall comprises a first inner surface and a first outer surface. The second sidewall comprises a second inner surface and a second outer surface. Pressure applied to the first outer surface and the second outer surface inserts the flexible interposing member in to the flexible interlocking member for sealing the opening.

[0012] Fujimura, in Japanese patent publication number JP5056809 published Mar. 9, 1993 in the Japanese patent office entitled Opening And Closing Device Using Magnet In Waterproof Bag, provides for magnets folded inside folds of a waterproof bag to facilitate in closing the bag, the disclosure which is incorporated herein by reference.

[0013] There is a need for a container product that is self-sealing, simple and convenient to use. The prior art may have water resistant qualities, but are not self-sealing, and require human intervention to form the enclosures on the bags. Many of the prior art use seals such as "zip-lock" type seal, multiple roll and clip seal, clamp seal, and waterproof zipper.

SUMMARY OF THE INVENTION

[0014] It is an object of the invention to self seal the opening of containers with flexible magnetic strips. A preferred embodiment of the present invention is a container that is water resistant and airtight. The use of magnet-to-magnet contact to self seal containers simplifies the process of sealing the opening of the container because the convergence of the magnets may provide an air and/or water tight seal. This present invention uses a magnet convergence that automatically, quickly and efficiently seals a container when an individual is around water to provide a water-resistant and airtight bag that protects valuables free from water damage. The magnet-to-magnet seal can be applied in any size and variety of different shaped containers.

[0015] A waterproof self sealing container sealed by magnet to magnet contact, making the container airtight and water resistant. The water resistant container has a body made of flexible water resistant material. The body is formed as a sheet. An opening is formed at an end of the body. The body opening has a body opening first side and a body opening second side. A first magnet strip is bonded to the body opening first side. A first bonding layer bonds to the body. The first magnet strip is bonded to the first bonding layer and wherein the first bonding layer is bonded to the body opening first side. A second magnet strip is bonded to the body opening second side. A second bonding layer is bonded to the body. The second magnet strip is bonded to the second bonding layer and the second bonding layer is bonded to the body opening second side. A water resistant seal is formed between the first magnet strip and the second magnet strip when the first mag-

net strip is closed to the second magnet strip to close the opening formed at the end of the body.

[0016] A double fold is formed in body material such that the first magnet strip and second magnet strip defines a folding region that is folded twice over the water resistant seal. The double fold is secured to the body by a locking means. An upper carry strap is connected to the body at an upper strap connection and a lower carry strap is connected to the body at a lower strap connection. The upper connection is higher than the lower connection. A left edge seal and the right edge seal are formed on the body. The left edge seal seals stitching holes on the left edge and the right edge seal seals stitching holes on the right edge, so that the left edge seal is heat laminated to the left edge, and so that the right edge seal is heat laminated to the right edge. A fold edge is formed by a fold of the water resistant material to form the fold edge of the body.

[0017] The first magnet strip and the second magnet strip have linearly oriented magnetized channels disposed within plastic resin. The plastic resin has lower magnetic properties than the linearly oriented magnetic channels.

[0018] A flap magnet contact area is located where the first magnet strip and the second magnet strip contact each other, but the flap outside surface is free from the sidewalls of the body and are not glued, laminated or bonded to the sidewalls of the body. The flap magnet contact area is adjacent to the water resistant seal area.

[0019] The water resistant container optionally has: a first left magnet bevel formed at a left side of the first magnet strip; a first right magnet bevel formed at a right side of the first magnet strip; a second left magnet bevel formed at a left side of the second magnet strip; and a second right magnet bevel formed at a right side of the second magnet strip. The water resistant container also has a first left magnet bevel tip formed at a left side of the first magnet strip; a first right magnet bevel tip formed at a right side of the first magnet strip; a second left magnet bevel tip formed at a left side of the second magnet strip; and a second right magnet bevel tip formed at a right side of the second magnet strip.

BRIEF DESCRIPTION OF THE DRAWINGS

[0020] FIG. 1 is the frontal view of the self-sealing bag.

[0021] FIG. 2 is the back view of the self-sealing bag with the magnet strip at the opening and two straps used for carrying the bag.

[0022] FIG. 3 is a front view of the self-sealing bag with a hook and loop strip.

[0023] FIG. 4 is a cross-section diagram of the layers of the self sealing bag, not drawn to scale.

[0024] FIG. 5 is a diagram of the template of the sheet used for making the self sealing bag.

[0025] FIG. 6 is a front perspective view of the self sealing bag without supplemental hook and loop tape closures.

[0026] FIG. 7 is a side cross-section showing the flap magnet contact area and fluid pocket.

[0027] FIG. 8 is a top cross-section exploded view diagram showing assembly of the bag opening.

[0028] FIG. 9 is a top cross-section diagram of the assembled bag opening.

[0029] FIG. 10 is a front view diagram showing the assembly template of bag opening.

[0030] The following call out list of elements can be used for referencing the call out numbers of the drawings.

[0031]	21 Side Fringe
[0032]	22 Seal Strip
[0033]	23 Gap
[0034]	24 Body
[0035]	25 Fold Edge
[0036]	26 Opening Edge
[0037]	27 Bias Member
[0038]	31 First Hook Or Loop Strip
[0039]	32 Opening Fringe
[0040]	33 Second Hook Or Loop Strip
[0041]	41 Upper Strap Connection
[0042]	42 Upper Strap
[0043]	43 Strap Linkage
[0044]	44 Lower Strap
[0045]	45 Lower Strap Connection
[0046]	51 Outside Magnet Contact Edge
[0047]	52 Middle Magnet Connection
[0048]	53 Flap Magnet Contact Area
[0049]	54 Inside Magnet Contact Edge
[0050]	55 Fluid Pocket
[0051]	88 Fold Line
[0052]	131 Magnet Strip
[0053]	132 Bonding Layer Of Glue Or Melt Plastic
[0054]	133 Side Walls Of The Body
[0055]	134 Graphic Printing Layer
[0056]	135 Magnet Contact Area
[0057]	136 Plastic Resin
[0058]	137 Magnetized Channel
[0059]	138 Magnet Bevel
[0060]	139 Magnet Tip

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

[0061] The self sealing container has one or more openings using magnet to magnet contact, preferably making the container water-resistant and airtight. The specialized magnet to magnet seal may be used in, for example, but not limited to, bags, backpacks, pockets, duffle bags, soft coolers and handbags. More specifically, this invention relates to sealing containers without human intervention and using only flexible magnet-to-magnet contact. When left hands-free, the magnet to magnet contact and bias rods pops the opening closed.

[0062] The present invention is constructed on a sheet of waterproof fabric using a length of fabric and folded so as to have a fold line **88** to form a fold edge **25** at a bottom of the bag. The sides of the bag are stitched with thread and a strip of seal **22** material is laminated over the stitching holes on the inside of the bag. The seal strip **22** is heat laminated and pressed against the stitching holes on the inside of the bag. The seal strip **22** is reinforced by a side fringe **21** which runs along the length of the left and right side of the bag.

[0063] The hook and loop panels are sewn to the bag and all the stitching has a vinyl tape heat pressed against the stitching holes on the inside of the bag. The hook and loop panels are disposed to engage with each other. A gap **23** can be formed between the opening fringe **32** and the side seal strip **22** when the bag is open, but the gap closes to be watertight when the bag is closed. The **23** is preferably minimized.

[0064] The body **24** of the bag can be a polyester or nylon fabric material that has been treated with a waterproof coating or is inherently waterproof. The body **24** of the bag is preferably rectangular, but can be made in other shapes such as round or triangular. The body of the bag receives a pair of seal strips **22**, namely a left seal strip in the right seal strip. The seal

strips seal the left and right bag edges. The opening edge 26 receives a pair of opening fringes 32 to reinforce the opening edge.

[0065] A first hook or loop strip 31 connects to a second hook or loop strip 33 when the bag opening edge 26 is folded in a roll configuration so that the first hook or loop strip 31 engages with the second hook or loop strip 33. The first hook or loop strip 31 in conjunction with the second hook or loop strip 33 forms a hook and loop tape connection that is removable by a user. Instead of a hook and loop tape connection, clasps and magnets can also be used for maintaining a folded roll configuration of the opening edge 26 and of the pair of opening fringes 32.

[0066] The preferred embodiment includes a double fold formed in the body materials such that the pair of magnet strips defines a folding region of the magnet to magnet contact that is folded over the body and locked by a locking means. The locking means can be a locking mechanism such as hook and loop material, snaps, clasp, or zipper thereby providing strength to the magnet to magnet water resistant seal. When the fold region is folded, the first fold is located underneath the magnet strips and the second fold is located above the second hook or loop tape area. The second hook or loop tape area connects with the first hook or loop tape area. The first hook or loop tape area can be generally along the outside of the body overlying the first magnet strip. Therefore, the first closing seal is the magnet to magnet connection. The second closing seal is the first fold and second fold with the secondary connection locking means. The first fold and second fold form a double fold that can look like a rolled edge. The distance between the first magnet and the second hook or loop tape area would be approximately the width of the first magnet and the second magnet. The width of the first magnet and the second magnet should be generally equivalent. The secondary connection locking means is configured to increase orientation retention to provide increased torsion and twist resistance.

[0067] Connected to the body of the bag are straps. An upper strap connection 41 having a watertight seal of stitching holes holds an upper strap 42. The upper strap 42 connects to an end of a strap linkage 43. The other end of the strap linkage 43 can be a second strap 44 acting as a lower strap 44. The lower strap 44 is secured to an edge of the body 24 at a side fringe 21 where a lower strap connection 45 connects the lower strap 44 to the body. The stitching holes of the second strap connection or the lower strap connection 45 provides for waterproof connection.

[0068] On the inside of the body of the bag are a pair of magnets formed as magnet strips 131, FIG. 4. The magnet strips 131 provide direct connection to each other at a magnet contact area 135. The magnet contact area 135 is waterproof but may have small air gaps trapped between magnetized channels 137. The magnet strips 131 preferably have magnetized channels 137 extending along the length of the magnetic strips 131. The magnetized channels are aligned between the upper magnet strip and the lower magnet strip. The magnetized channels 137 are held in the magnetic strip by plastic resin 136 or are more magnetized areas of the magnetic strip. The plastic resin of the upper magnetic strip is pressed against the plastic resin of the lower magnetic strip. The plastic resin 136 has a lower concentration of magnetic material and the magnetized channels 137 have a higher concentration of magnetic material and therefore have higher magnetic properties. The magnetic channels attract to each other and maintain

parallel orientation between the first magnet strip and the second magnet strip. The cooperative alignment of the magnetic channels is configured to increase orientation retention to provide increased torsion and twist resistance. The magnetic channels 137 align to each other and provide multiple seal contracts in linear orientation long the length of the magnet strip 131. The magnetic channels 137 do not necessarily have a round cross-section, but could also have a rectangular or other shaped cross section. The magnetic channels are strip magnets held to or encapsulated in the plastic resin 136 such that they are maintained parallel to each other.

[0069] The pair of magnetic strips 131 are bonded respectively to the pair of upper and lower inside surfaces of the side walls of the body 133. The magnetic strips can be bonded by a bonding layer 132 of glue or thermal activated melt plastic. The magnetic strips are preferably bonded by a bonding layer of contact adhesive, or by glue or thermally activated melt plastic. The pair of bonding layers bonds the magnet strips to the body in a watertight fashion. The bonding layer 132 can be provided by a seal strip 22 which can be thermally adhesive or room temperature adhesively bonded.

[0070] Additionally, a graphic printing layer 134 can be imprinted over an outside surface of the side walls of the body 133. The graphic print layer may have instructions, text, graphics or designs.

[0071] During construction, waterproof material of the body is cut to a desired size. Then, straps, bias, and hook and loop material are sewn to the body. After sewing, vinyl tape is heat pressed over stitching to seal the holes. One of the magnetic strips can be adhered over the top hook and loop stitch holes to seal the stitch holes formed by the hook or loop tape strip. The adhering of the magnetic strip over the hook and loop tape stitch holes also holds the magnetic strip to the body and at the same time seals the hook and loop tape stitch holes.

[0072] Adhesive can be applied to the magnet strip and the waterproof material is folded in half. The sides of the waterproof material can be heat pressed to seal the sides and corners of the bag. The waterproof material may come with a layer of seal strip on the inside surface of the waterproof material. After the bag is folded in half and joined, the bag is trimmed and bias is sewn to the sides to give a finished look. During use, the magnet strips close the opening of the bag giving an airtight or watertight seal. The top of the bag includes the opening edge 26 and can be folded twice until the first hook or loop strip 31 connects to the second hook or loop strip 33 four increasing the strength of the seal. Once the completed bag is closed, it can hold air or water inside. The bag can also hold dry articles inside for keeping the article dry.

[0073] It is possible for the seal strip and the plastic bonding layer to be made of a solid heat activated adhesive resin which could be a layer of polypropylene film that is thinner than the magnetic strip and thinner than the side walls of the body 133. The seal strip and the plastic bonding layer can be made of an intermediate polymer film layer of ethylene based octene plastomer. This polyolefin film may comprise a polyethylene, a polypropylene polymer or a blend of polyethylene with about 1 to 10% ethylene vinyl acetate. The bonding layer can be made as a plastomer film layer. Stitching holes of the upper strap connection can be sealed with a heat laminated sealing layer, and stitching holes of the lower strap connection can also be sealed with a heat laminated sealing layer.

[0074] As seen in FIG. 6, the present invention can optionally be made without a hook and loop strip connection. As

seen in FIG. 7, the magnet strips 131 have a magnet contact area 135 that can extend downward as a loose flap that is not laminated to side walls of the body 133. Optionally, the flap can be connected to one side wall but not the other. At least either the first magnet strip or the second magnet strip is free from the sidewalls of the body not being bonded to the sidewalls of the body at the flap area. This means that one of the first magnet strip or the second magnet strip can be attached entirely to the sidewalls of the body being bonded to the sidewalls of the body at the flap area.

[0075] The flap magnet connection configuration has an outside magnet contact edge 51 that closes the outside edge. The flap magnet connection configuration also has a middle magnet connection 52 which is where the side walls of the body 133 connect to a middle portion of the magnet strips 131. The middle magnet connection 52 is between the inside magnet contact edge 54 and outside magnet contact edge 51. The inside magnet contact edge 54 is a terminal edge of a flap magnet contact area 53. The flap magnet contact area 53 is bounded between the middle magnet connection 52 and the inside magnet contact edge 54. The flap magnet contact area 53 and the side walls of the body 133 can hold a fluid pocket 55 between the flap magnet contact area 53 and the side walls of the body 133. The fluid pocket 55 can be filled with a liquid or gas such as air or water. The fluid pocket can also be empty.

[0076] When the bag is submerged, fluid pushing against the fluid pocket 55 also pushes against the flap magnet contact area 53 to keep the flap magnet contact area 53 closed. Without the flap magnet contact area 53, the bag would burst open at the connection between the side walls of the body 133 and the magnet strips 131. However, the flap magnet contact area 53 more evenly distributes pressure to maintain the bag in a closed position. During testing, the bag bursts at the side seal strip 22 before bursting at the flap magnet contact area 53. The fluid pocket being described is the area between the side walls of the body 133 and the magnet strips 131. The magnet strips 131 would have magnet channels 136 which are parallel to the outside magnet contact edge 51, which are parallel to the magnet strips 131 and which are parallel to the inside magnet contact edge 54. The magnet strips 131 maintain magnet strip alignment during fluid pocket pressurization such as when traveling underwater.

[0077] A bias member 27 can be a leaf spring that can snap the bag shut when the bag is open. The bias member 27 can be formed as a rod or stick and passed through a sleeve formed in the opening fringe 32. The opening fringe 32 can be a strip of fabric that is folded along the length of the body and the bias member 27 can be placed in the fold that forms a sleeve. The bias member can be sewed shut and enclosed within the sleeve fold. The bias member can be formed of carbon fiber to resist saltwater corrosion, or can be made of spring steel or fiberglass. The bias member can also be made of plastic in a more potentially inexpensive embodiment. The opening fringe 32 can be a heavy fabric that is plastic based and has slight resistance to bending to form the fabric fold also called the sleeve fold. The sleeve fold retains the bias member. The bias member can have a round cross section and be formed as a slender flexible rod. The bias member can be removable if the sleeve fold is open at a left or right edge. The bias member does not necessarily touch the magnet, but could be formed to bias on the outside of the magnet.

[0078] As seen in FIG. 8, the present invention can be constructed by using seal strips 22 for connecting the side walls of the body 133. The seal strips can be heat tape or

adhesive strips, such as double-sided adhesive strips. The seal strips are preferably airtight and watertight. The seal strips can be purchased on a roll of plastic strip or made by thermal heat lamination of plastic members such as the side walls of the body directly onto the magnet. The seal strips can be formed when abutting plastic members are heated, such as by sonic welding and a melted interface can form the seal strips if the magnet matrix material is compatible with the side walls of the body. When adhesive tape materials are not independently purchased, and the melted interface is the seal strip, the bond may be weaker. It may be preferable to have thermal heat lamination of plastic members together as well as using seal strips. The best closure construction is dependent upon the materials involved.

[0079] FIG. 8 shows that the magnets are beveled such as by cutting and grinding the magnet edge. The magnet bevel 138 terminates at a magnet tip 139. The thickness of the members are not to scale and are exaggerated for clarity. A suggested order of construction would be to first bevel the left edge and the right edge of the magnet to have a tip at a left side and at a right side. Seal strips 22 can be placed on the magnet outside surface parallel to the length of the magnet while maintaining a magnet to magnet contact on a magnet inside surface. The side adhesive strips can be seal strips 22 and seal the left and right side against the side walls of the body. Once completely laid out, a thermal press can be used for finalizing the seal. The resulting structure is waterproof and can also be made airtight. The assembled cross-section view is shown in FIG. 9 as having a beveled profile. The assembled structure may have fringes on the left and right side that can be trimmed and finished with a serger or have edge trim covering. FIG. 10 shows the preferred front view of the assembly with the horizontal adhesive strip as seal strip 22 covering the top half of the magnet 131 and having side vertical adhesive strips as seal strip 22 covering the left and right edges of the horizontal adhesive strip and the magnet strip. It is preferred that approximately half of the magnet is covered, although different ratios can also be workable such as one third or one fourth coverage of the magnet.

[0080] Although it is preferred that the first magnet strip and the second magnet strip are made of the same material and same construction, it is possible to make the second magnet strip of a different material. The second magnet strip can be a ferromagnetic material such as iron that has attraction to the first magnet strip which is a permanent magnet. The second magnet strip has magnetic properties attracting to the first magnet strip upon touching the first magnet strip. The second magnet strip can be a metal such as a steel leaf spring.

[0081] The flap magnet contact area is free and can be connected to the bag sidewalls at a left and right side edge, or the flap magnet contact area can be unconnected to the bag sidewalls at a left and right side edge. The flap magnet contact area is free at an inside edge and is free along the outside surface of the first magnet strip and along the outside surface of the second magnet strip.

1. A water resistant container comprising:
 - a. a body made of flexible water resistant material, wherein the body is formed of a sheet material that comprises sidewalls of the body;
 - b. an opening formed at an end of the body, wherein the body opening has a body opening first side and a body opening second side;
 - c. a first magnet strip bonded to the body opening first side;

- d. a second magnet strip bonded to the body opening second side;
- e. a water resistant seal formed between the first magnet strip and the second magnet strip when the first magnet strip is closed to the second magnet strip to close the opening formed at the end of the body, wherein at a magnet side opposing the water resistant seal, the first magnet strip is bonded to the body opening first side and the second magnet strip is bonded to the body opening second side; and
- f. a flap magnet contact area where the first magnet strip and the second magnet strip contact each other, but at least either the first magnet strip or the second magnet strip is free from the sidewalls of the body at the flap magnet contact area not being bonded to the sidewalls of the body, wherein the flap magnet contact area is adjacent to the water resistant seal area.

2. The water resistant container of claim 1, further comprising: a left edge seal and the right edge seal, wherein the left edge seal seals stitching holes on the left edge and wherein the right edge seal seals stitching holes on the right edge, wherein the left edge seal is heat laminated to the left edge, wherein the right edge seal is heat laminated to the right edge.

3. The water resistant container of claim 1, further comprising: a fold edge formed by a fold of the water resistant material to form the fold edge of the body.

4. The water resistant container of claim 3, further comprising: a double fold formed in body material such that the first magnet strip and second magnet strip defines a folding region that is folded twice over the water resistant seal, wherein the double fold is secured to the body by a locking means.

5. The water resistant container of claim 1, wherein the first magnet strip and the second magnet strip have linearly oriented magnetized channels disposed within plastic resin, wherein the plastic resin has lower magnetic properties than the linearly oriented magnetic channels.

6. The water resistant container of claim 1, further comprising: a first left magnet bevel formed at a left side of the first magnet strip; a first right magnet bevel formed at a right side of the first magnet strip; a second left magnet bevel formed at a left side of the second magnet strip; a second right magnet bevel formed at a right side of the second magnet strip.

7. The water resistant container of claim 6, further comprising: a first left magnet bevel tip formed at a left side of the first magnet strip; a first right magnet bevel tip formed at a right side of the first magnet strip; a second left magnet bevel tip formed at a left side of the second magnet strip; a second right magnet bevel tip formed at a right side of the second magnet strip.

8. The water resistant container of claim 7, further comprising: a left edge seal and the right edge seal, wherein the left edge seal seals stitching holes on the left edge and wherein the right edge seal seals stitching holes on the right edge, wherein the left edge seal is heat laminated to the left edge, wherein the right edge seal is heat laminated to the right edge.

9. The water resistant container of claim 7, further comprising: a fold edge formed by a fold of the water resistant material to form the fold edge of the body.

10. The water resistant container of claim 9, further comprising: a double fold formed in body material such that the first magnet strip and second magnet strip defines a folding region that is folded twice over the water resistant seal, wherein the double fold is secured to the body by a locking means.

11. The water resistant container of claim 7, wherein the first magnet strip and the second magnet strip have linearly oriented magnetized channels disposed within plastic resin, wherein the plastic resin has lower magnetic properties than the linearly oriented magnetic channels.

12. The water resistant container of claim 1, further comprising: a middle magnet connection which is where the sidewalls of the body connect to a middle portion of the magnet strips.

13. The water resistant container of claim 12, wherein the first magnet strip and the second magnet strip are made of the same material.

14. The water resistant container of claim 12, wherein the first magnet strip and the second magnet strip are made of different material, wherein the second magnet strip is a ferromagnetic material that has attraction to the first magnet strip.

15. The water resistant container of claim 14, wherein the second magnet strip is a metal leaf spring.

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