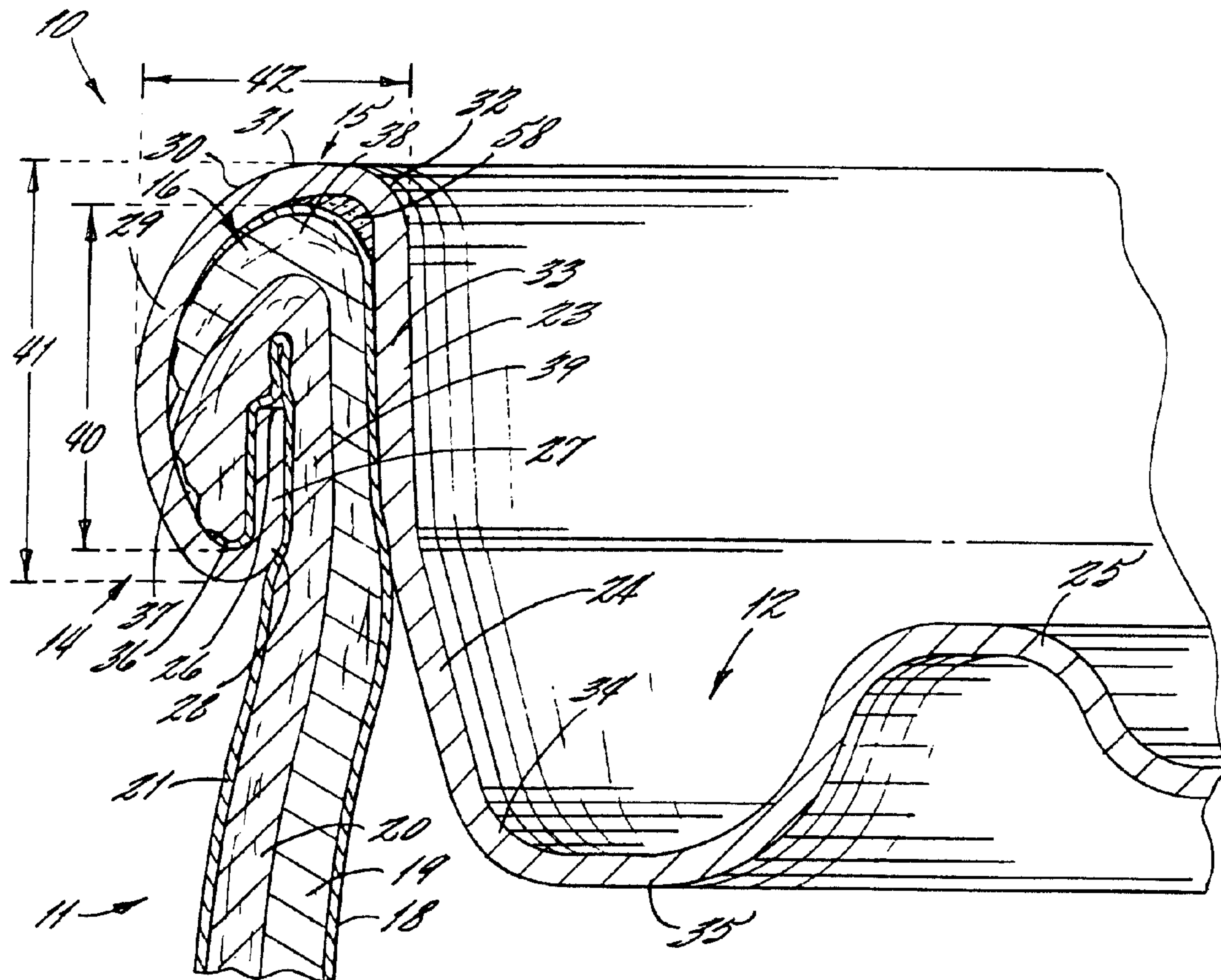




(22) Date de dépôt/Filing Date: 1999/02/05
 (41) Mise à la disp. pub./Open to Public Insp.: 1999/12/26
 (45) Date de délivrance/Issue Date: 2002/12/24
 (30) Priorité/Priority: 1998/06/26 (09,106,199) US

(51) Cl.Int.⁶/Int.Cl.⁶ B65D 8/18, B65D 6/28
 (72) Inventeur/Inventor:
 BACON, JOHN ELLIS, US
 (73) Propriétaire/Owner:
 SONOCO PRODUCTS COMPANY, US
 (74) Agent: SIM & MCBURNEY

(54) Titre : JOINT DOUBLE A DIAMETRE REDUIT POUR CONTENANT DE MATERIAU COMPOSITE
 (54) Title: REDUCED DIAMETER DOUBLE SEAM FOR A COMPOSITE CONTAINER



(57) Abrégé/Abstract:

A hermetic, composite container including a non-metallic composite container body and a metal end which are joined by a double seam. The double seam has reduced dimensions resulting in significant savings in material. The metal end is formed of a low basis weight metal having a thickness of less than 0.007 inches wherein substantial wrinkling of the metal end nonetheless is avoided.

-17-

ABSTRACT

5 A hermetic, composite container including a
non-metallic composite container body and a metal end
which are joined by a double seam. The double seam has
reduced dimensions resulting in significant savings in
material. The metal end is formed of a low basis weight
metal having a thickness of less than 0.007 inches
wherein substantial wrinkling of the metal end
10 nonetheless is avoided.

REDUCED DIAMETER DOUBLE SEAM
FOR A COMPOSITE CONTAINER

FIELD OF THE INVENTION

5 The present invention is directed to a
hermetic, composite container having a metal end which
is secured to the body of the composite container by a
reduced double seam resulting in a substantial reduction
of materials within the double seam.

10

BACKGROUND OF THE INVENTION

Containers, such as composite or metal
containers, generally include a container body and metal
ends which are joined together by a process referred to
as double seaming. A double seam refers to the closure
15 formed by interlocking and compressing an end portion of
the metal end which has been preformed with an outer
curl and the container body which has been preformed
with an outer flange. The resulting double seam has a
double lock profile defined by a body hook and a cover
20 hook. The term "cover hook" is used to define that part
of the double seam formed from the curl of the metal
end. "Body hook" defines the portion of the flange of
the container body that is turned down in the formation
of the double seam. The first seaming operation of the
25 double seaming process refers to the operation in which
the curl of the metal end is tucked under the flange of
the container body to form the cover hook and body hook.
The second seaming operation refers to the finishing
30 operation wherein the hooks formed in the first
operation are rolled tightly against each other. To
form a double seam, a rotating seaming chuck and a
spring loaded base plate hold the metal end and
container body together while first and second operation
35 seaming rolls are cam sequenced in and out to form the
double seam.

-2-

Such double seaming processes have been employed with metal cans. While the current technology is effective with metal cans, the technology, prior to this invention, has presented new challenges when sealing composite containers. This is due to many difficulties including wrinkling of the metal can end which commonly occurs in the double seaming operation. When such wrinkles (or "teeth") occur in the seam of a metal can, they may simply be ironed out, such as during the second seaming operation, without affecting the integrity of the metal body or the metal end. The resulting cans are therefore effectively sealed and the seam is hermetic. It has been established that the amount of wrinkling is a function of the metal thickness wherein wrinkle formation increases as the metal thickness, i.e., basis weight, decreases.

U.S. Patent No 5,595,322 to Kramer is an example of a metal can having a double seam joining the metal end and metal container body. A hermetic seal results because the wrinkles which are formed within the metal end during the curling step or the first seaming operation are ironed out during the second seaming operation. The existence of the wrinkles prior to being ironed out does not affect the integrity of the can body because it, too, is metal.

When this technology is applied to composite cans, however, several problems occur. A composite container may include a combination of compressible foil, paper and plastic wherein the foil layer may form the liner layer. The resulting seam is formed by a seaming process to hermetically seal the composite container body to the metallic end. The problems associated with composite containers are numerous. First, when wrinkling of the metal end occurs in the double seam, it often penetrates the composite can thereby destroying its liner layer rendering the

-3-

composite can not hermetic. Second, the wrinkles cannot be easily ironed out from composite cans which often include a paper layer.

Double seams have been employed with composite containers wherein the containers are intentionally not hermetic such as are used in U.S. Patent No. 5,005,728 to Mazurek et al. Wrinkling of the end occurs in these cans but this is desirable because the wrinkles actually assist in rendering these cans not hermetic. It is intended that these cans permit gases to escape, such as may occur during the proofing of packaged dough products. Additionally, wrinkles are encouraged because they assist in gripping and maintaining the end on the composite body of those cans.

15

SUMMARY OF THE INVENTION

The present invention overcomes the associated disadvantages of double seaming a metal end with a composite container body wherein wrinkling of the metal end occurs by providing a reduced diameter metal end for a hermetic, composite container which at least minimizes, if not avoids, wrinkle formation. Moreover, such is achieved with a reduced basis weight metal even though decreased thicknesses of metal generally increase wrinkle formation. The resulting double seam has reduced dimensions thereby utilizing a lesser amount of the container body within the seam. All of these advantages contribute to the significant savings of the resulting double seam having reduced dimensions.

30

The double seam profile according to the present invention permits use of smaller diameter metal blanks for forming the metal end resulting in significant cost savings. The significant savings have been estimated to be as much as 25% or more due to the reduced diameter defined by the cut edge of the blank

35

and savings in labor costs. The labor cost savings result from, at least in part, the increased number of blanks that may be formed per sheet of material. The use of lighter basis weight metal, such as metal having a 55
5 pound basis weight (having a thickness of between .0052 inches and .0061, with a \pm 10% tolerance), as opposed to conventional 75 pound basis weight (having about a .0086 inch thickness), further contributes to the cost savings resulting in about a 30% reduction in the metal required.
10 The decreased length of composite body within the double seam, i.e. the body hook, also contributes to the significant savings because the body blank is likewise reduced. This, in turn, decreases the compound requirements within the double seam.

15 The container having the reduced diameter double seam according to an aspect of the present invention may be produced using, generally, conventional double seaming machines. Additionally, the resulting container sustains abuse and leak tests similar to conventional containers
20 formed by other seaming processes.

The composite container having the reduced seam is produced by the following process. The metal end is formed by a stamp die and the cover is curled with a predetermined profile formed by a curling tool and
25 presented to the end of the body. During the first seaming operation, the body is introduced to the metal end wherein the flange of the container body is reformed into a body hook profile and is interlocked with the cover hook. The second seaming operation compresses the
30 body and cover hooks.

According to an aspect of the invention, a hermetic, composite non-metallic container having a reduced diameter double seam formed between a composite body and

4a

a metal end having a predetermined diameter, said container comprises said composite body including a plurality of layers including a liner layer and body ply and said metal end having a thickness of less than 0.07 inches, said metal end having a formed end portion and said composite body having a flanged end wherein said formed end portion and said flanged end are joined by double seaming operation, wherein said composite body forming said double seam includes a body hook radius and a cut end and said formed end portion forming said double seam includes a chuck wall radius, a seaming panel radius, a cover hook and a cut end, said body hook and said cover hook cooperating to hermetically seal the metal end to the composite container body.

In accordance with another aspect of the invention, a hermetic, composite non-metallic container has a reduced diameter double seam formed between a composite body and a metal end having a predetermined diameter, said container comprises said composite body including a plurality of layers including a liner layer and a body ply and said metal end having a thickness of less than 0.007 inches, said metal end having a formed end portion and said composite body having a flanged end wherein said formed end portion and said flanged end are joined by a double seaming operation, wherein said composite body forming said double seam includes a body hook radius and a cut end and said formed end portion forming said double seam includes a chuck wall radius, a chuck wall, a seaming panel radius, a cover hook and a cut end, said chuck wall having two angles to define a doubled angled chuck wall, said body hook and said cover hook cooperating to hermetically seal the metal end to the composite container body.

BRIEF DESCRIPTION OF THE DRAWINGS

The foregoing and other objects, features, and advantages of the present invention will be made apparent from the following detailed description of the

preferred embodiment of the invention and from the drawings, in which:

5 Figure 1 is an enlarged cross-sectional view of the double seam of the composite container according to the present invention;

Figure 2 is an enlarged cross-sectional view of the double seam of a prior art container;

Figure 3 is a cross-sectional view of the metal end according to the present invention;

10 Figure 4 illustrates the first seaming operation according to the present invention;

Figure 5 illustrates an initial view of the second seaming operation;

15 Figure 6 illustrates the second seaming operation thereof; and

Figure 7 is a top plan view of the metal end according to the present invention.

DETAILED DESCRIPTION OF THE DRAWINGS

20

The present invention will now be described more fully in detail with reference to the accompanying drawings, in which a preferred embodiment of the invention is shown. This invention should not, however,
25 be construed as limited to the embodiment set forth herein; rather, it is provided so that this disclosure will be thorough and complete and will fully convey the scope of the invention to those skilled in the art.

The composite container, shown generally at
30 10, according to the present invention includes a composite container body 11 and a metal end 12. The metal end 12 and the composite container body 11 are joined together by a double seam 14. The double seam 14 includes an end portion 15 of the metal end 12 and an
35 end portion 16 of the container body 11 (best depicted

-6-

in Figures 3 and 4).

As illustrated, the composite container body 11 includes a plurality of layers. It is within the scope of this invention, however for the composite container body to be single-ply and yet formed of a non-metallic material. As used herein, "metallic" refers to a material having a substantial basis weight and which material does not include a compressible foil, paper or plastic layer, for example. Accordingly, the term "non-metallic" refers to composite containers formed, for example, of paperboard or the like and which may include one or more metal foil layers. Composite containers typically include at least one structural body ply and are formed by wrapping a continuous strip of body ply material, such as paperboard, around a mandrel of a desired shape to create a tubular structure. The body ply strip may be spirally wound around the mandrel or passed through a series of forming elements so as to be wrapped in a convolute shape around the mandrel. At the downstream end of the mandrel, the tube is cut into discrete lengths and is then fitted with end caps to form the container.

Tubular containers of this type typically include a liner layer or ply 18 on the inner surface of a paperboard body ply. As illustrated, the body ply includes inner 19 and outer 20 body plies. The liner ply 18 prevents liquids such as juice from leaking out of the container and also prevents liquids from entering the container and possibly contaminating the food product contained therein. Preferably, the liner ply 18 is also resistant to the passage of gasses, so as to prevent odors of the food product in the container from escaping and to prevent atmospheric air from entering the container and spoiling the food product. Thus, the liner ply 18 provides barrier properties and the body

ply provides structural properties.

The liner ply 18 is preferably adhered to the inner surface of the inner body ply 19 with a wet adhesive and the overlapping edges of the liner ply are adhered together to ensure that the container 10 is completely sealed. A label ply 21 is preferably adhered to the outer surface of the outer body ply 20 having various indicia printed thereon regarding the product within the container.

The metal end 12 is formed of a lightweight metal which, nonetheless, is capable of being formed into a double seam 14 with a composite container body 11 without causing significant wrinkling of the metal end 12. Accordingly, the liner layer 18 or other layer is not damaged and the hermetic seal is maintained. Preferably, the metal end 12 is formed of a 55 lb. basis weight metal having a thickness of less than .007 inches, such as between .004 inches and .007 inches, for example, about .005 to .006 inches. The metal end 12 is defined by a center panel portion 22 and an end portion 15 having end hook configuration illustrated in Figures 3 and 7. According to the illustrated embodiment, the metal end 12 also includes a reverse panel bead 25.

The end portion 15 of the metal end 12 forming the end hook configuration is defined by a cut end 26, a cover hook 27, a cover hook radius 28, a seaming wall 29, a seaming wall radius 30, a seaming crown 31, a seaming panel radius 32, a chuck wall 33, a chuck wall radius 34, and a chuck panel 35. The chuck panel 35 is adjacent the reverse panel bead 25 in the illustrated embodiment. The end portion 16 of the container of the composite container body 11 is defined by its cut end

-8-

36, a body hook 37, a body hook radius 38, and a compression area 39.

The resulting double seam 14 of the composite container 10 as represented by Figure 1 is formed from a reduced diameter metal end 12 wherein the double seam 14 is formed by a reduced length of the metal end 12 and the container body 11. This is represented by a comparison of Figure 1 and the composite container 10' which is a prior art container as represented by Figure 2. The body hook length 40 of the present invention is represented in Figure 1 and is defined as the vertical distance between the horizontal tangent of the body hook radius 38 and the cut end 36 of the composite container end portion 16. The seam length 41 of the double seam 14 is defined by the vertical distance between the horizontal tangent of the seaming crown 31 of the metal end portion 15 and the horizontal tangent of the cover hook radius 28 of the metal end portion 15. The seam width 42 of the double seam 14 is defined as the horizontal distance defined between the vertical tangent of the seaming wall 29 of the metal end portion 15 and the vertical tangent of the outer surface of the metal end chuck wall 33.

A comparison of the present invention represented in Figure 1 and the prior art container 10' represented in Figure 2 illustrates the material savings of the present invention. The seam length 41 of the present invention is less than the seam length 41' of prior art containers 10'. Similarly, the body hook length 40 is less than the body hook length 40' of the prior art. The corresponding seam width 42' of the prior art, as represented by Figure 2, is significantly

-9-

greater than the seam width 42 of the present invention. Additionally, the cover hook 27 of the present invention is significantly shorter in length than the cover hook 27' of the prior art. Similarly, the length of the body hook 37 defined between the cut end 36 and the body hook radius 38 of the present invention is significantly less than the corresponding length of the body hook 37' of prior art containers 10'. As set forth above, this results in significant savings in material used to form the double seam 14 thereby permitting a reduced diameter metal end 12 to be utilized as well as a shorter blank which forms the container body 11.

A compound 58 may be used within the double seam 14 of the present invention and is best represented by Figure 4. The compound 58 is a sealing material consisting of a water or solvent dispersion solution of rubber which is placed in the curl 15 of the metal end 12. The compound 58 aids in effecting a hermetic seal by filling spaces or voids in the double seam 14 used to provide further stability to the double seam 14. The compound utilized may be W. R. Grace #9179E-HV. According to the present invention, because reduced dimensions of the metal end 12 and composite container 10 are employed, a reduced amount of compound 58 may be used. This further contributes to the overall material savings of the present invention.

Prior to the formation of the double seam 14 of the composite container 10, the reduced diameter metal end 12 is preformed. Figure 3 represents the preformed metal end 12 according to another aspect of the present invention. The preformed metal end 12 is defined by a center panel portion 22 and an end portion

-10-

15 including a reverse panel bead 25. The reverse panel bead 25 is positioned radially inward of and adjacent to the chuck panel radius 34.

As represented in Figure 3, the chuck wall 33
5 of the metal end 12 defines two angles a and b to present a double angled or compound chuck wall 33. The chuck wall 33 is defined by a first portion 23 and a second portion 24. The first portion 23 extends at an angle a which is between 2.5° and 8.0°, preferably
10 between 3.5° and 4.5°. The second portion 24 extends at an angle b which is between 10° and 20°, preferably between 15° and 17°. The metal end 12 according to this aspect of the invention also includes a seaming panel radius 31, a seaming crown 32, a metal end curl 46, and
15 cover hook end 26.

The reverse panel bead 25 has a bead height 48 defined as the vertical height between the horizontal tangent of the bead 25 and the chuck panel 35. The metal end 12 also defines a countersink 49 which is
20 defined as the vertical height between a horizontal tangent of the seaming panel crown 32 and the chuck panel 35. The ring depth 51 is defined between the horizontal tangent of the seaming panel crown 32 and the tangent of the reverse panel bead 25. The curl height 52
25 is defined between the horizontal tangent of the seaming panel crown 32 and the curl end 26. The reverse panel bead 25 and the compound chuck wall 33 contribute to abuse resistance of the composite container 10.

For example, according to an embodiment of the
30 present invention wherein the metal end is formed of a 55 lb. basis weight metal having a thickness less than

-11-

0.007 inches, the countersink depth is between 0.100 and 0.150 inches, for example about 0.130 inches. The bead height is between 0.040 and 0.070 inches, for example about 0.050 inches, and the curl height is less than 0.040 and 0.070 inches, for example, less than 0.060 inches.

The method of forming the composite container 10 having the double seam between the reduced diameter metal end 12 and the composite container body 11 is best represented by Figures 4-6. The double seaming operation according to the present invention includes conventional double seaming machines but which utilize seaming chucks having a profile corresponding to the profile of the double seam 14 according to the present invention. As set forth above, the metal end 12 is preformed into the configuration illustrated in Figure 3. Similarly, the composite container body 11 is also preformed to include a flange 54 as best illustrated in Figure 4.

The double seaming operation includes a first seaming operation and a second seaming operation. In the first seaming operation, the chuck panel 35 of the metal end 12 is seated against a seaming roll 56 of a closing machine wherein the metal end 12 is urged against a seaming chuck 57. During the first seaming operation the flange 54 of the composite container body 11 is introduced to the preformed metal end 12. A compound 58 may also be introduced. Thereafter, the rotating first operation seaming roll 56 is cammed toward the rotating seaming chuck 57 to initially engage the curl of a metal end 12 to the position illustrated in Figure 4.

The second seaming operation flattens out the

-12-

double seam 14 of the composite container. Figure 5 represents the first position of a second operation seaming chuck 60 which is positioned generally diametrically opposite the first operation seaming chuck 57. The seaming chuck 60 is also cam advanced towards the seaming roll 56 as illustrated in Figure 5. The parts continue to rotate to complete the double seaming operation as illustrated in Figure 6. As represented in Figure 6, substantially no wrinkles are formed during the procedure.

The precise dimensions of the metal end 12 and the resulting double seam 14 will vary depending upon factors including the composite container body 11 thickness and the diameter of the metal end 12 blank selected. Another possible variable is the countersink depth utilized. For instance, the countersink depth may vary depending upon the abuse resistance desired. For instance, the end use of the container such as the contents to be contained, the volume of the container, the strength features required, etc. contribute to the composite container, thickness, and metal end diameter selected. Generalities, however, may be made. For instance, for a composite container 10 having a container body 11 with a wall thickness of between 0.026 and 0.042 inches, such as between 0.028 and 0.032 inches, and disregarding the metal material contributions of the countersink, a cord length of less than 10% of the metal end diameter results. The cord length is the uncompressed or original length of the metal end hook configuration defined between the chuck panel radius 34 and the cut end 36 (as formed). The flange length is defined as the end hook configuration of the metal end 12 if it were straightened, that is, the distance between the chuck wall 33 and the cut end

-13-

36 (when straightened) as shown in dotted lines in Figure 3. According to the present invention, the flange length is less than 7.0% of the metal end diameter. The resulting seam length 41 is less than
 5 0.100 inches, such as about 0.090 inches. The resulting seam width 42 is less than 0.070 inches, such as about 0.060 inches. Regarding the flanged metal end prior to the double seam operation, the reverse panel bead height 48 is between 0.040 and 0.080 inches, the countersink
 10 depth 49 is between 0.100 and 0.200 inches, and the curl height 52 is between 0.045 and 0.065 inches.

This is exemplified by the following examples of a 3 inch metal end (referred to as a "300 diameter blank") and a 4 1/16 inch metal end (referred to as a
 15 "401 diameter blank"), each having a reduced body wall thickness of less than 0.006 inches and used on a composite container having a thickness of less than 0.032 inches. The terms "300 diameter metal end" and "401 diameter metal end" refer in the industry to the
 20 resulting diameter of the container. The ratios following represent a proportion of the specified dimension relative to the diameter of the blank.

	<u>3.0" Diameter</u>	<u>4 1/16" Diameter</u>
Cord length	<9.83%	<7.42%
Flange length	<7%	<4.8%
Cover hook length	<1.2%	<0.9%
Seam length	<0.090 inches	<0.090 inches
Seam width	<0.060 inches	<0.060 inches
Seamed countersink depth	<0.150 inches	<0.160 inches

The preformed metal end 12 includes the following dimensions:

3.0" Diameter 4 1/16" Diameter

-14-

	<u>3.0" Diameter</u>	<u>4 1/16" Diameter</u>
Reverse panel bead height	about 0.050 inches	about 0.060 inches
Countersink depth	about 0.126 inches	about 0.144 inches
Curl height	about 0.055 inches	about 0.056 inches

Of course, any diameter metal end 12 may be utilized and the above are provided as exemplary metal ends 12. A container having a reduced dimension double seam according to the present invention will nonetheless exhibit the aforementioned general characteristics resulting in significant cost savings. While particular embodiments of the invention have been described, it will be understood, of course, the invention is not limited thereto since modifications may be made by those skilled in the art, particularly in light of the foregoing teachings. It is therefore, contemplated by the appended claims to cover any such modifications that incorporate those features of these improvements in the true spirit and scope of the invention.

CLAIMS:

5 1. A hermetic, composite non-metallic
container having a reduced diameter double seam formed
between a composite body and a metal end having a
predetermined diameter, said container comprising said
composite body including a plurality of layers including
a liner layer and a body ply and said metal end having a
10 thickness of less than 0.007 inches, said metal end
having a formed end portion and said composite body
having a flanged end wherein said formed end portion and
said flanged end are joined by a double seaming
operation, wherein said composite body forming said
15 double seam includes a body hook radius and a cut end
and said formed end portion forming said double seam
includes a chuck wall radius, a seaming panel radius, a
cover hook and a cut end, said body hook and said cover
hook cooperating to hermetically seal the metal end to
20 the composite container body.

 2. A composite container according to Claim
1 wherein said formed end portion of said metal end has
a cord length measured between the cut end and the chuck
25 wall radius of less than 10.0% of said predetermined
diameter of said metal end.

 3. A composite container according to Claim
1 wherein said formed end portion has a flange length
30 defined between said cut end and said chuck wall of less
than 8.0% of said predetermined diameter.

 4. A composite container according to Claim
3 wherein said end flange length is less than 7.0% of
35 said predetermined diameter.

-16-

5. A composite container according to Claim 1 wherein said liner layer is liquid and gas impermeable.

5 6. A composite container according to Claim 1 wherein said plurality of layers includes at least said liner layer and an additional body ply including paper as a composition thereof.

10 7. A composite container according to Claim 6 wherein said plurality of layers further includes an outer layer.

15 8. A composite container according to Claim 1 wherein said metal end has a thickness less than about .006 inches.

20 9. A composite container according to Claim 8 wherein said metal end has a thickness less than about .005 inches.

25 10. A composite container according to Claim 1 wherein said composite body forming said double seam is defined by a body wall, a compression area, said body hook radius, a body hook, and said cut end.

30 11. A composite container according to Claim 1 wherein said formed end portion forming said double seam is defined by a chuck panel, said chuck wall radius, a chuck wall, said seaming panel radius, a seaming wall, a cover hook radius, said cover hook, and said cut end.

12. A hermetic, composite non-metallic container having a reduced diameter double seam formed between a composite body and a metal end having a predetermined diameter, said container comprising said composite body including a plurality of layers including a liner layer and a body ply and said metal end having a thickness of less than 0.007 inches, said metal end having a formed end portion and said composite body having a flanged end wherein said formed end portion and said flanged end are joined by a double seaming operation, wherein said composite body forming said double seam includes a body hook radius and a cut end and said formed end portion forming said double seam includes a chuck wall radius, a chuck wall, a seaming panel radius, a cover hook and a cut end, said chuck wall having two angles to define a doubled angled chuck wall, said body hook and said cover hook cooperating to hermetically seal the metal end to the composite container body.

13. A hermetic, composite container according to Claim 12, wherein said metal end includes a center panel portion surrounded by the formed periphery portion.

14. A hermetic, composite container according to Claim 13, wherein the double angled chuck wall defines a first angle (a) of between 2.5° and 8.0° from a plane substantially perpendicular to the center panel portion, and a second angle (b) of between 10° and 20° from a plane substantially perpendicular to the center panel portion.

15. A hermetic, composite container according to Claim 14, wherein the first angle (a) ranges between 3.5°

and 4.5°, and the second angle (b) ranges between 15° and 17°.

16. A hermetic, composite container according to
5 Claims 13, 14 and 15 wherein said periphery portion has a
cord length measured between said cut end thereof and the
chuck wall radius of less than 10% of the diameter of the
metal end.

10 17. A hermetic, composite container according to
any one of Claims 12 to 16, wherein said periphery
portion has a flange length defined between said cut end
thereof when straightened and said double angled chuck
wall of less than 8% of the diameter of the metal end.

15

18. A hermetic, composite container according to
any one of Claims 12 to 17, wherein said metal end has a
thickness less than about 0.006 inches.

20

19. A hermetic, composite container according to
any one of Claims 12 to 18, wherein said metal end has a
thickness less than about 0.005 inches.

25 20. A hermetic, composite container according to
any one of Claims 12 to 19, wherein said body ply
includes paperboard as a composition thereof.

FIG. 2.
PRIOR ART

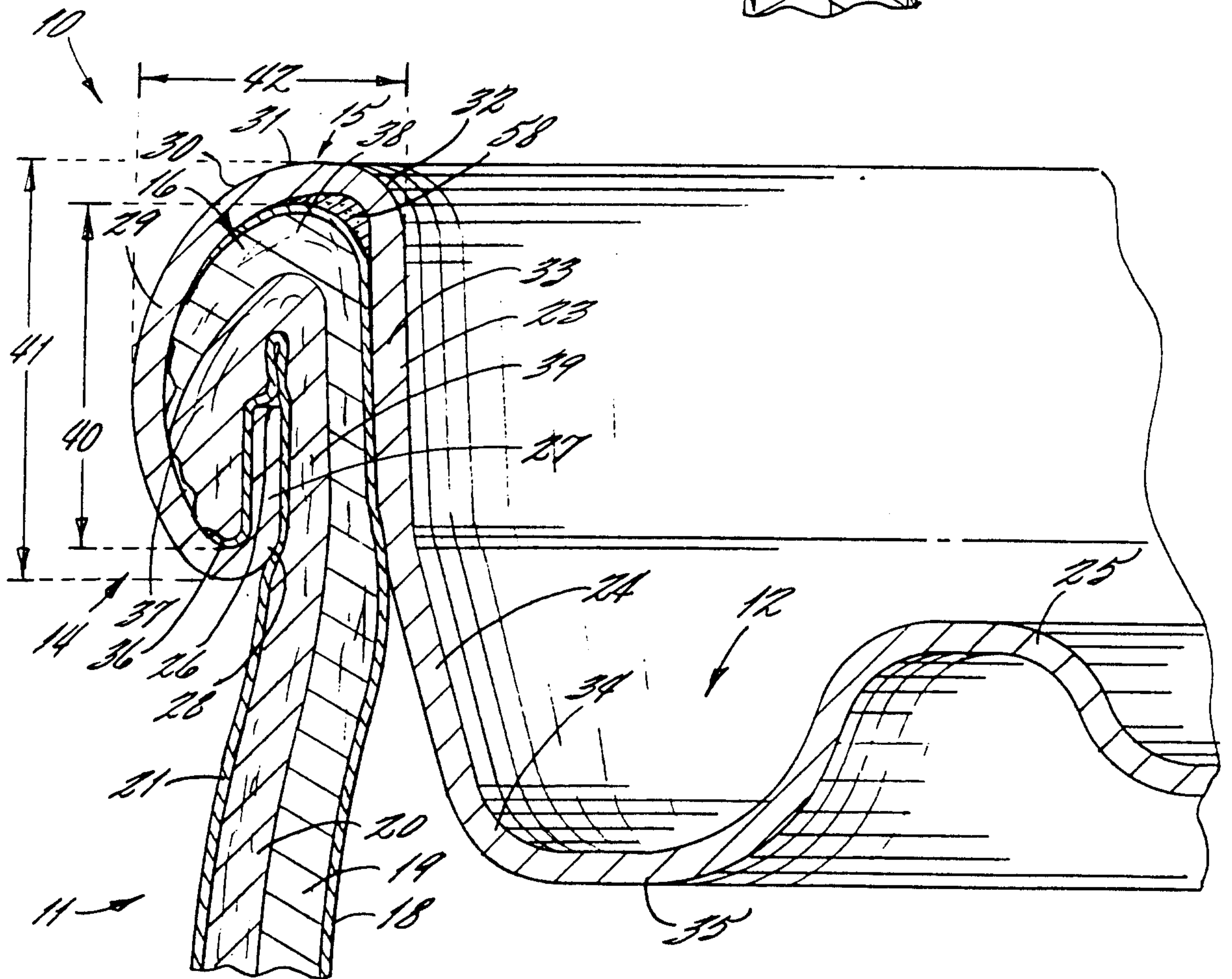
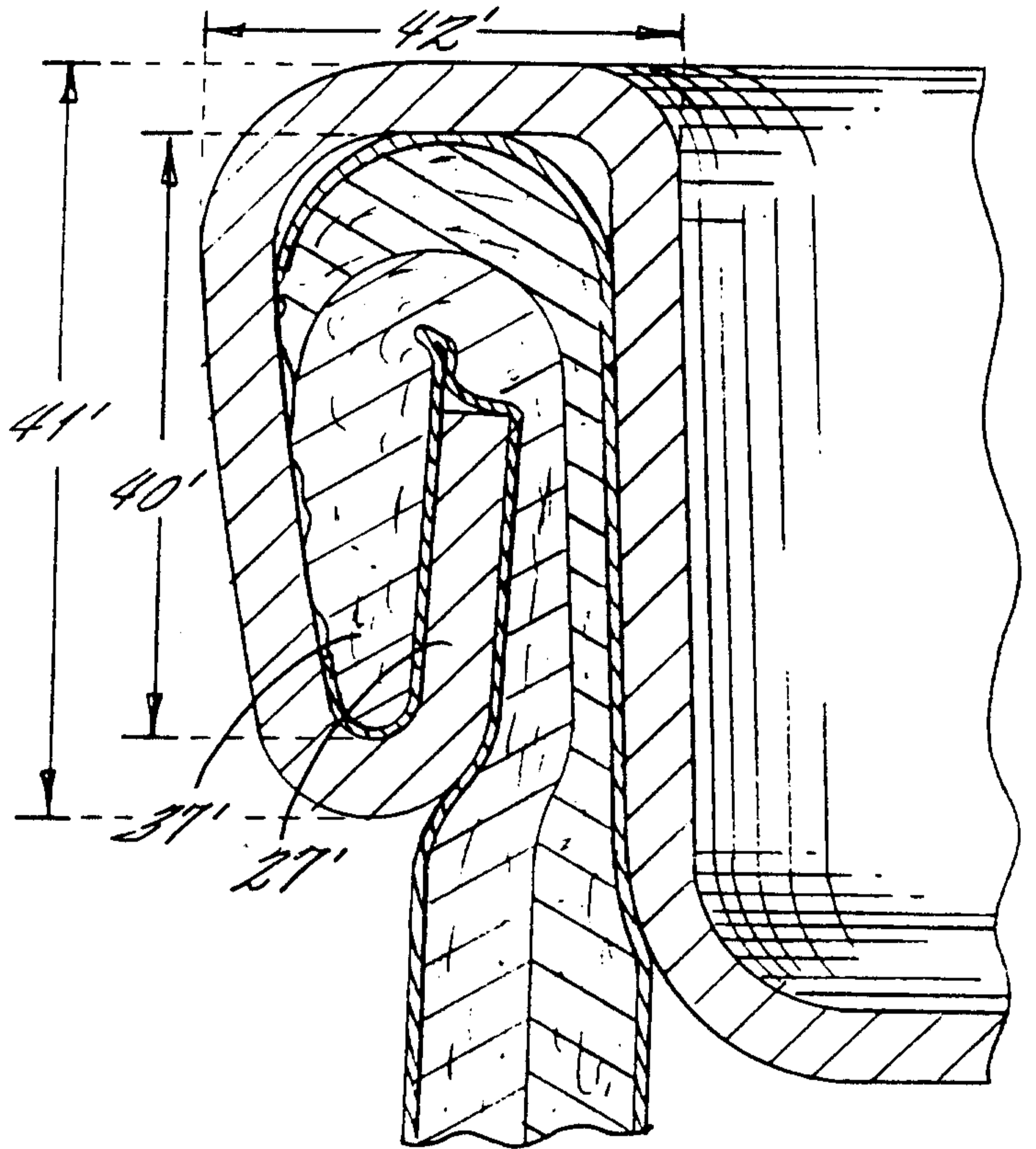
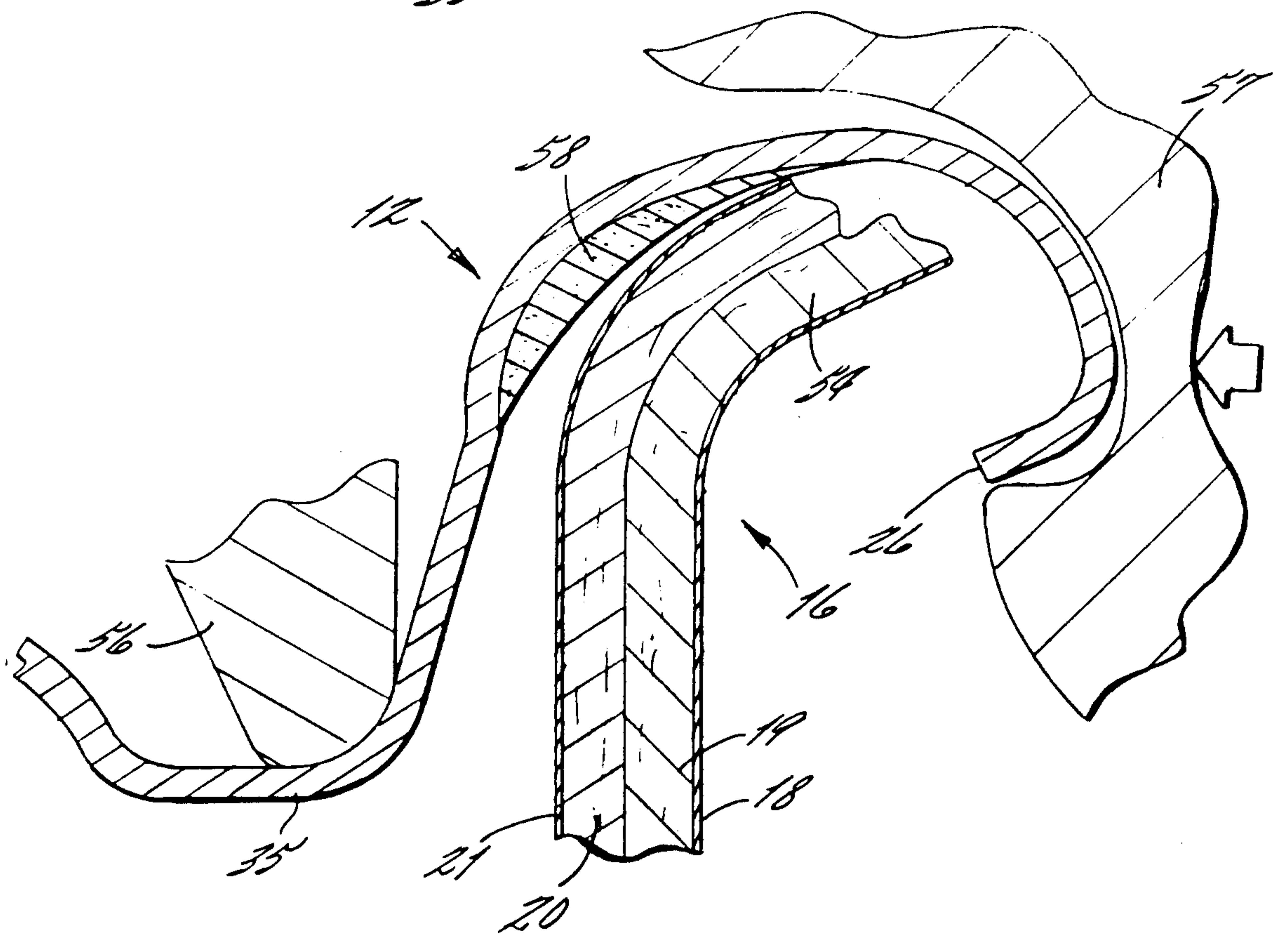
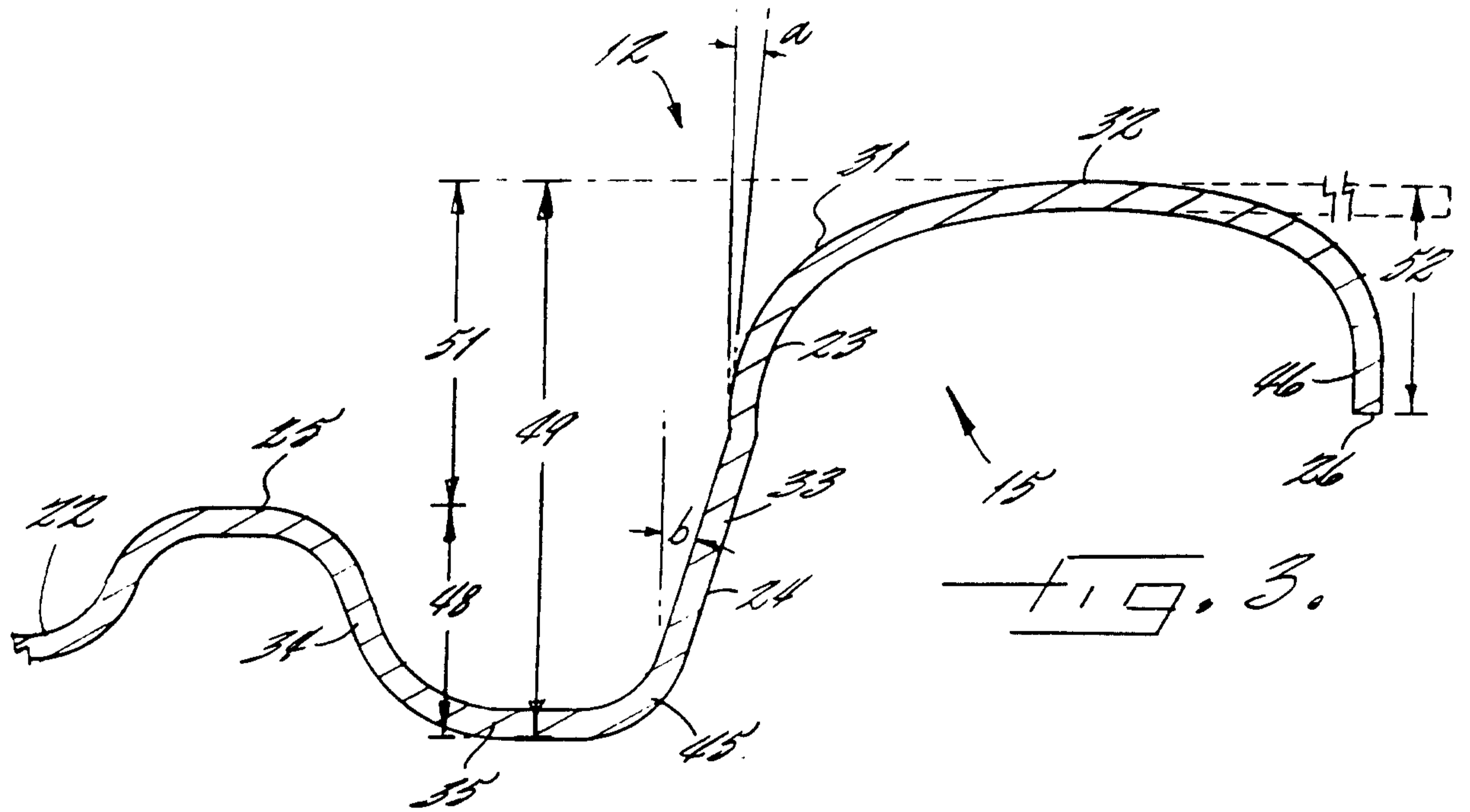
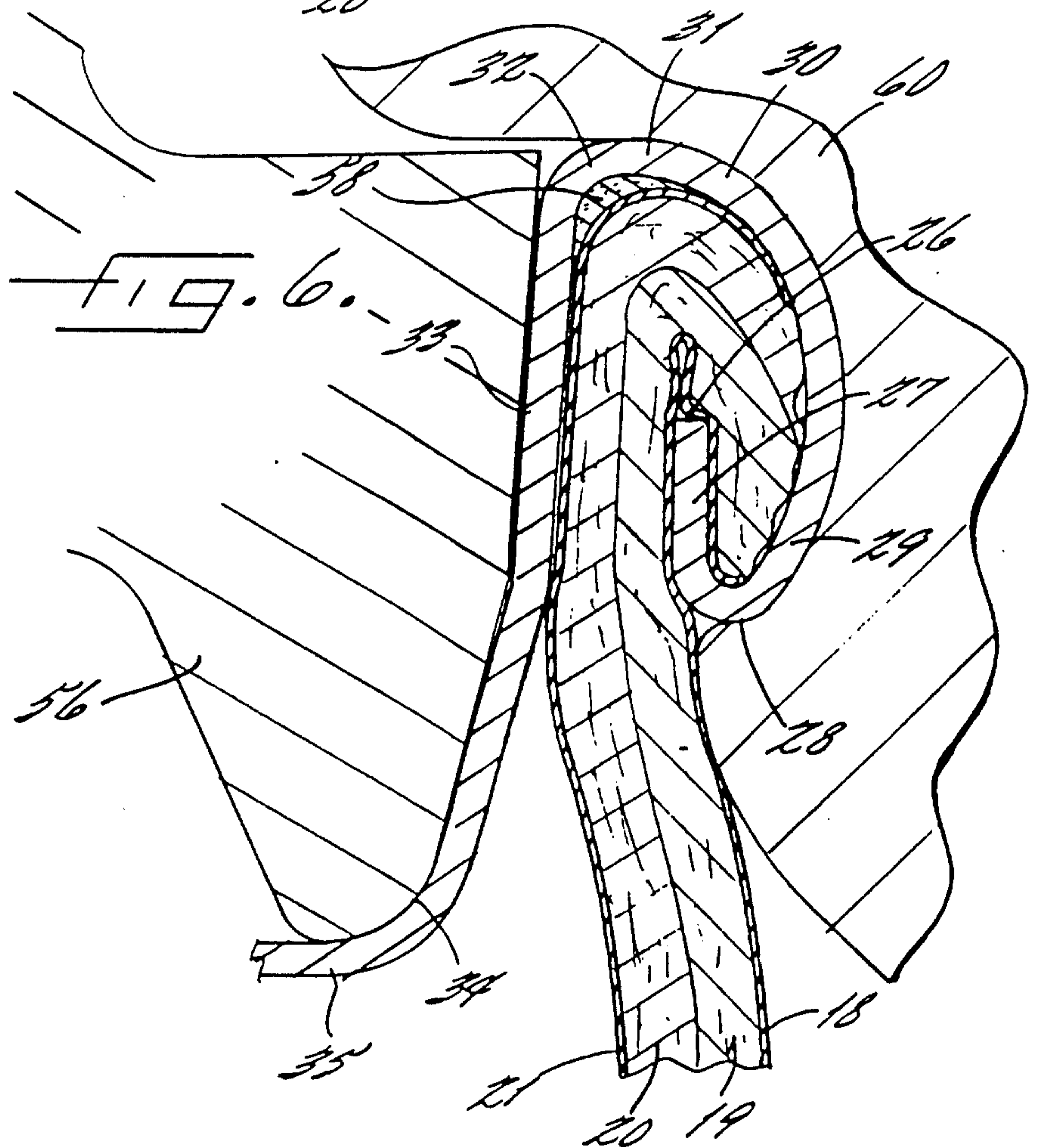
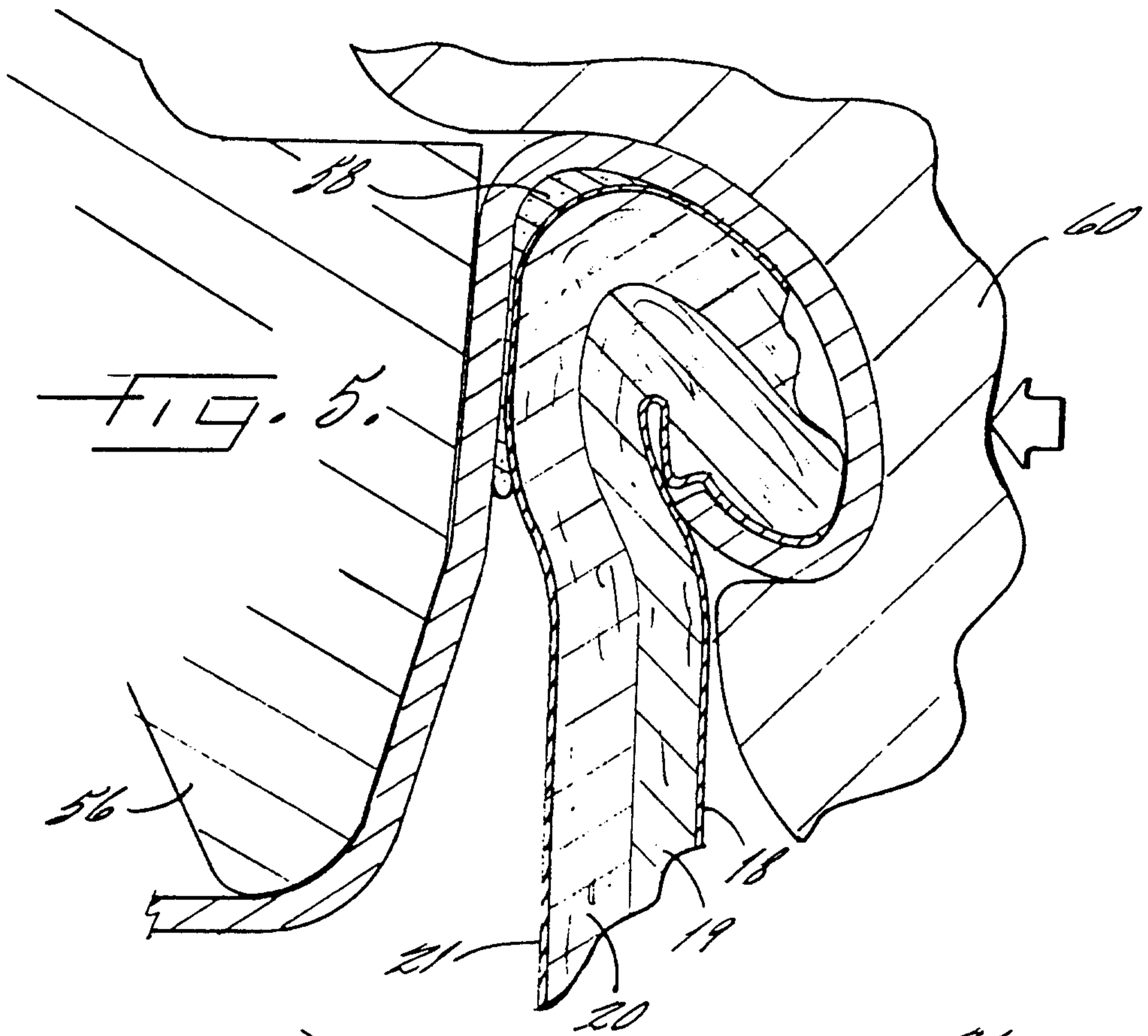


FIG. 1.





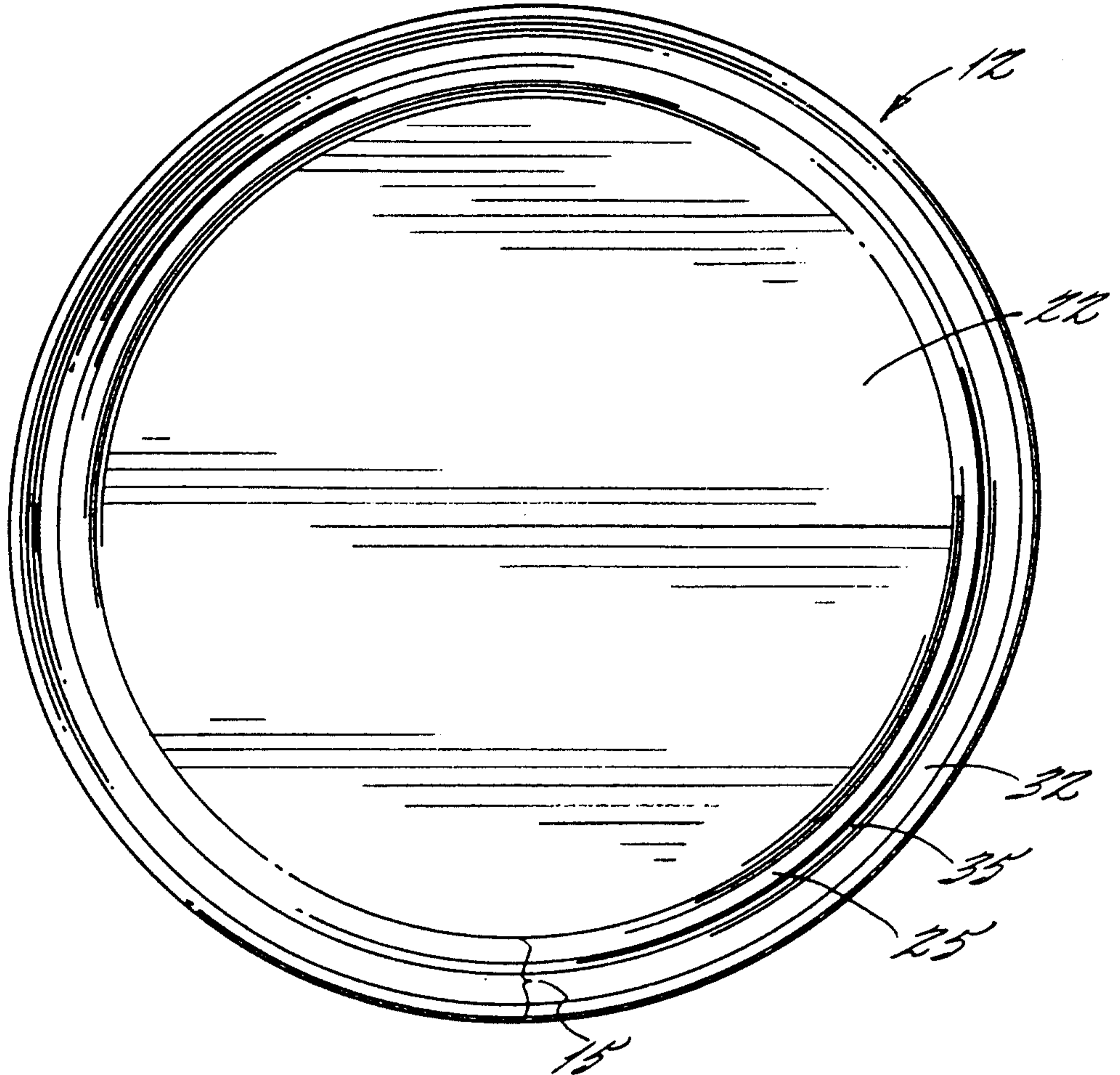


FIG. 7.

