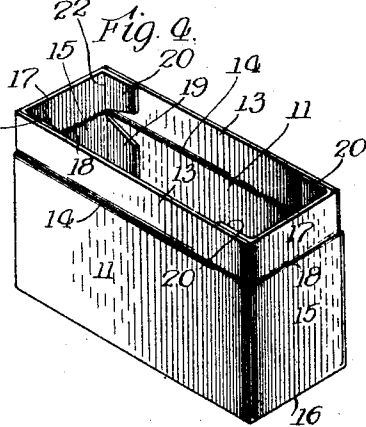
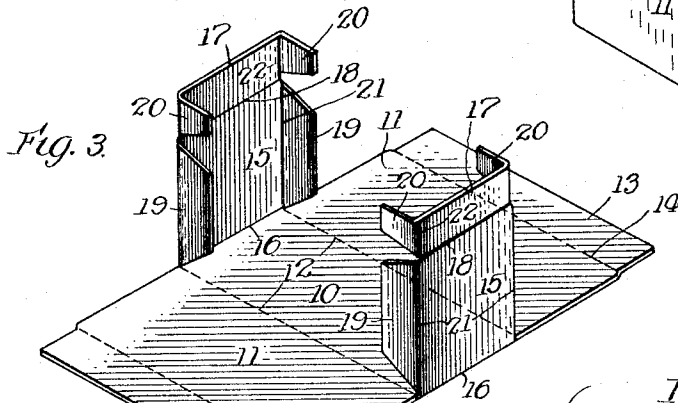
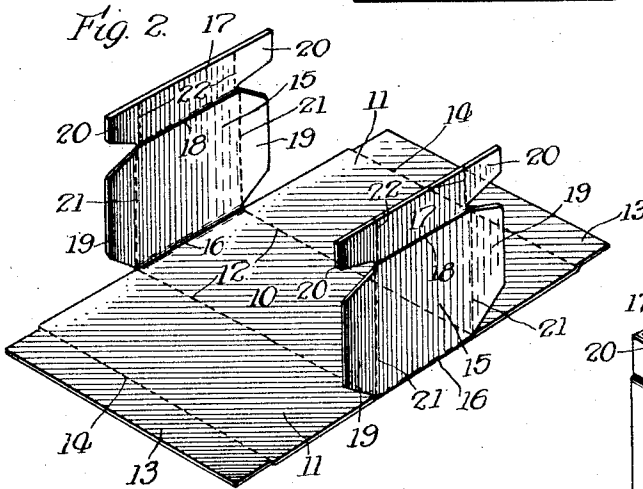
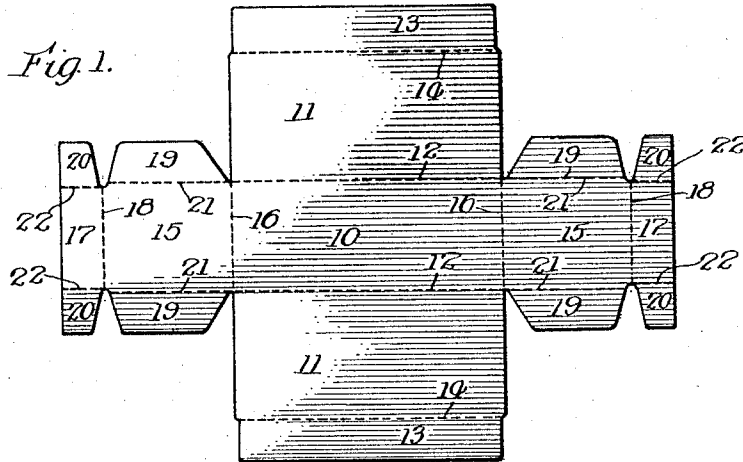


A. J. EVERS.
PASTEBOARD BOX AND METHOD OF MANUFACTURE.
APPLICATION FILED AUG. 24, 1918.

1,308,058.

Patented July 1, 1919.



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PASTEBOARD BOX AND METHOD OF MANUFACTURE.

1,308,058.

Specification of Letters Patent.

Patented July 1, 1919.

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To all whom it may concern:

Be it known that I, ARTHUR J. EVERS, a citizen of the United States, residing in Chicago, in the county of Cook and State of Illinois, have invented certain new and useful Improvements in Pasteboard Boxes and Methods of Manufacture, of which the following is a specification.

My invention is designed to simplify the structure of pasteboard boxes with so-called necks or collars, to facilitate the manufacture thereof, and to decrease the expense of production of such containers or receptacles. To this end the neck or collar, over which the flange of the cover of the box fits when closed, is made integral with the box walls being properly inwardly offset to permit such telescoping of the cover thereover. In one desirable embodiment of the invention, the entire box-body, including the neck, is made from a single blank of pasteboard of suitable shape or form, such blank having tabs or ears overlapping and adhered to the box walls at the corners to hold the parts together in proper assembled relation. Preferably we start with a flat blank and bend or fold up opposite wings to form walls of the box, at the same time inwardly displacing the upper portions thereof designed to constitute parts of the neck and its securing corner tabs or ears. Then the adhesive-coated tabs or ears for the side-walls proper and for the neck are bent over, whereupon the remaining opposite side-wall wings of the blank are bent up and partially inwardly offset to form the remainder of the neck and caused to adhere to the previously bent tabs or ears under suitable pressure, thus securely fastening the corners together. The outer surface of the pasteboard is of such quality that no cover or finish paper is needed, the single piece or blank of pasteboard providing for all parts of the box.

In order that those skilled in this art may have a full and complete understanding of the invention, and an appreciation of its various advantages, I have illustrated the manufacture of such an improved box in the accompanying drawing forming a part of this specification and throughout the various views of which like reference characters refer to the same parts.

In this drawing:

Figure 1 is a face view of the blank employed for forming one particular style of box;

Fig. 2 shows in perspective the first folding and bending operation;

Fig. 3 illustrates in similar manner the next step in the process of bending over the corner tabs or ears; and

Fig. 4 depicts perspective the completed box.

The pasteboard, strawboard, cardboard, or similar blank from which the box is made is desirably perfectly flat and comprises a central, rectangular section 10 to form the bottom of the box, oppositely-extended wings 11, 11 to constitute side-walls when folded up on lines 12, 12, and extensions 13, 13 of such wings of slightly less length than the wings adapted when offset or crimped on lines 14, 14 to form opposite portions of the box-neck. Such blank also has opposite wings 15, 15 which, when bent up on parallel lines 16, 16, make the box end-walls, each of which has a supplementary or auxiliary portion 17 adapted to form the corresponding part of the neck when creased at 18.

Each wing or section 15 has a pair of oppositely-extended tabs 19, 19, adhesive coated on their under faces, adapted, when bent on lines 21, 21, to fasten the corners of the box-walls together by overlapping and adhering to the inner faces of the parts 11, 11. In similar manner each such section 17 has a pair of ears 20, 20, designed to play a corresponding part or perform a like function for the box-neck, when folded over on lines 22, 22 which are slightly out of register with lines 21, 21, by overlying and being secured or cemented to the inner surfaces of the companion neck sections 13, 13.

The method of making the box occurs practically as follows: The two opposite wings or sections 15, 15 with their adjunct elements 17, 19, and 20 are bent up along lines 16, 16 into parallel planes at right angles to the box-bottom portion 10 and at substantially the same time, or immediately thereafter, the neck sections 17 and their ears 20 are offset inwardly an amount approximately equal to the thickness of the pasteboard employed (see Fig. 2). Then all the tabs or ears 19, 20 are folded over inwardly on lines 21, 22, as shown in Fig. 3, whereupon the remaining wings 11, 11, and their appurtenant sections 13 are bent up at right angles to the base along lines 12, 12 and pressed into contact with the glue-coated faces of their respective tabs and ears,

19 and 20. At the same time the portions 13, 13 are crimped or offset inwardly at 14, 14 to form their portions of the neck, the completed box having the appearance indicated in Fig. 4.

To those skilled in the art it will be apparent that these boxes can be produced economically and with great rapidity and with small waste of material, the resulting box possessing a pleasing appearance and adequate strength and reinforcement for all practical purposes. It is quite immaterial whether the tabs and ears are coated with the adhesive, such as glue, or whether proper portions of the parts 11 and 13 are thus supplied. It is also of small moment as to which particular parts shall carry the corner reinforcing tabs and ears, as obviously changes could be readily made in this respect without departing from the essence of the construction and method employed. It is desirable, however, that owing to their off-set relation, the ears for the corners of the neck be separate and independent of the corner tabs for the main body-walls. While I prefer to crimp or off-set the neck sections when they are bent to form, thus permitting me to start conveniently with a perfectly flat blank, it should be obvious that such crimping can be provided in the blank before the bending up of the walls.

It is to be understood that many minor changes may be made in the blank, the box

produced therefrom, and in the method employed in such manufacture without departure from the substance of the invention and without the sacrifice of any of its substantial benefits and advantages.

I claim:

1. A pasteboard-box composed of a single piece of pasteboard having a bottom-wall, side-walls upstanding from said bottom-wall and inwardly offset at their upper portions to unitedly constitute the neck of the box, box-body corner-tabs integral with some and overlapping and adhered to other of said side-walls, and box-neck corner-ears independent of said box-body tabs integral with some and overlapping and adhered to other of the neck sections of the box, substantially as described.

2. The method of making a pasteboard-box with an integral neck from a single piece of pasteboard having a bottom-section and side-wall wings outstanding from said bottom-section, some at least of said wings having tabs for the corners of the box-body and independent ears for the corners of the neck, consisting in bending up said side-wall wings and inwardly offsetting their upper portions to form the neck when such wings reach substantially their final position, including bending over the tabs and ears to overlap and adhere to the box-walls and neck, substantially as described.

ARTHUR J. EVERS.

Copies of this patent may be obtained for five cents each, by addressing the "Commissioner of Patents, Washington, D. C."