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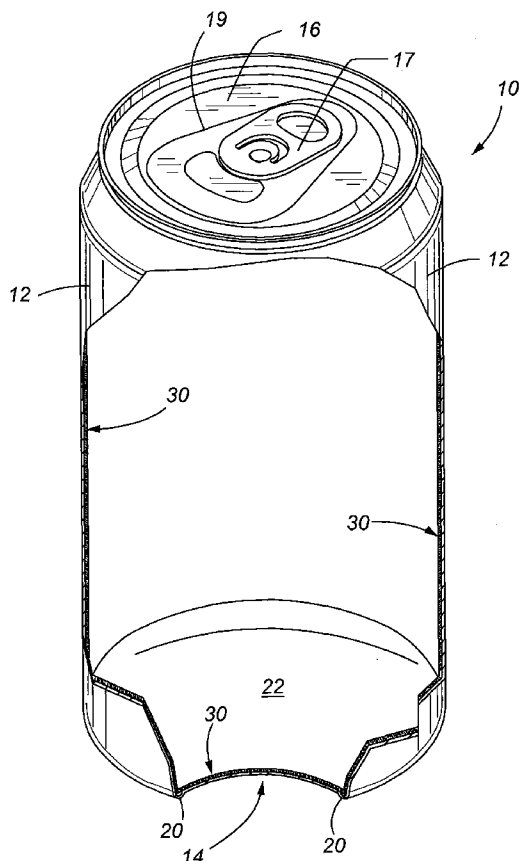


Fig. 1

(57) Abstract: A thermal barrier liner is provided within a container, and makes contact with the internal surface of the container. The thermal barrier liner may include a closed cell substrate, a base layer having gas or liquid filled microcapsules, a base layer having microencapsulated solid-liquid phase change material, or combinations thereof. In closed cell substrate embodiments, when the thermal barrier liner is under pressure within the container such as prior to the container being opened, the thermal barrier liner maintains a minimum profile or thickness. However, when the container is opened and as pressure is released within the container, the barrier liner expands to achieve equilibrium. The liner may be pre-made and mechanically inserted in the container prior to securing the top of the container to the sidewall. In another embodiment, a liner is placed within the container to form an annular gap between the container and the liner.

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INSERTED THERMAL BARRIER LINER FOR CONTAINERS

CROSS REFERENCE TO RELATED APPLICATIONS

Priority is claimed from U.S. Provisional Patent Application No. 60/980,135 filed
5 on October 15, 2007, entitled "INSERTED THERMAL BARRIER LINER FOR
CONTAINERS", which is incorporated herein in its entirety by this reference.

FIELD OF THE INVENTION

The present invention relates to a thermal barrier liner for containers, and more
particularly, to a thermal barrier liner placed in contact with the inner surface of the
10 container and a method of installing the liner by mechanically inserting the liner in the
container.

BACKGROUND OF THE INVENTION

Portable beverage containers are used to hold many types of beverages to include
carbonated soft drinks, fruit drinks, and beer. It is well known to provide a protective
15 internal liner for those containers made of metal such as aluminum or steel to help
preserve the beverage within the container by preventing undesirable chemical reactions
that would otherwise take place over time by direct contact of the beverage with the
metallic container. For containers made of plastic, there is typically no internal liner
provided because the plastic material is inherently non-reactive with respect to most types
20 of beverages.

Many beverages are preferably consumed at relatively cold temperatures, for
example, between about 36° F and 50° F. For carbonated soft drinks and beer, consumers
typically prefer these beverages to be chilled prior to consumption. Traditional chilling or
cooling techniques include placing the containers in a chilled environment such as a
25 refrigerator or cooler, and then serving the beverage once the beverage has reached a
desired chilled temperature.

When the beverage is removed from the chilled environment, the beverage begins
to quickly warm due to a combination of external heat sources including ambient heat of
the surrounding environment, contact with warm surfaces such as the consumer's hand or
30 the surface on which the container is placed, as well as radiant heat from the sun or other
light sources. Heat transfer takes place through the walls, base, and top of the container to
the beverage. Without some means provided for insulating the container, the beverage so

quickly warms that, in many circumstances, it becomes undesirable or unfit for consumption.

There are a number of inventions that have been developed for purposes of insulating a beverage within the container such that it is maintained at a desired
5 temperature prior to and during consumption. For example, it is well known to provide external thermal barriers, such as an insulating sleeve that is applied over the exterior sidewall of the container. It is also known to provide an insulated label on the sidewall of the container. There are a number of disadvantages to these traditional methods of
10 insulating beverages. An insulating label/sleeve only covers the container sidewall, therefore leaving the bottom of the container exposed. For insulated labels, they are typically much thicker than a non-insulated label and, therefore, standard packaging line may have to be substantially modified to accommodate these special labels. For insulating sleeves, these require the consumer to maintain a separate component to maintain the beverage at a desired cold temperature.

15 Some efforts have been made to provide an internal insulating liner for containers. One example is disclosed in U.S. Patent No. 6,474,498. This reference discloses a thermally insulated container for canned beverages including a lining formed from a plastics material. The preferred embodiments suggest using a plastic closed cell material to include closed cell material similar to bubble wrap. The liner is intended to be placed
20 into the container as by a slidable fit within the container so as to be in contact with the cylindrical inner surface of the container wall. The lining member may include an adherent surface allowing the lining to adhere to the internal wall of the container. In an alternative embodiment, this reference discloses a closed cell material that can be provided as a layer on the interior surface of the metal container in addition to or in place of a
25 conventional lacquered coating applied to the interior surface of the container.

U.S. Patent Application Publication No. 2006-0073298 discloses a multi-layer inner liner provided for a container and an extrusion method for a beverage container. The method contemplates blow molding the inner liner by co-extrusion of a first inner layer of a thermoplastics material and a second inner layer made of a foam material having
30 insulating properties. The inner layer of foam is further disclosed as having micro-spheres that expand during the blow-molding process.

U.S. Patent Application Publication No. 2006-0054622 discloses an insulated beverage container having an inner liner that adheres to the inside of the container. The inner liner is made from a crystalline ceramic material.

5 While the foregoing references may be adequate for their intended purpose, there is still a need for an internal thermal barrier to maintain a beverage at a desired temperature wherein the thermal barrier can be incorporated within a liner installed by using standard packaging machinery.

SUMMARY OF THE INVENTION

10 It is one object of the invention to provide a thermally insulated beverage container that can effectively and safely keep beverages at a desired temperature during consumption of the beverage.

It is yet another object of the present invention to provide a thermally insulated beverage container by providing a thermal barrier liner utilizing a single material that exhibits specific common desirable properties resulting in creation of an insulated thermal barrier.

15 It is yet another object of the present invention to provide a unique combination of materials that, when combined, exhibit desirable thermal barrier properties.

It is yet another object of the present invention to provide a method of installing a thermal barrier, such as a mechanically inserted thermal barrier liner having the form of a sheet-like substrate.

20 It is yet another object of the present invention to provide a thermal barrier that can be used in different types of beverage containers, such as those made from metal or made from plastic.

It is yet another object of the present invention to provide a thermally insulated beverage container that can be introduced into existing beverage manufacturing, distribution, and sales sectors without requiring significant alterations in manufacturing machinery or processes.

25 In accordance with the present invention, a thermally insulated beverage container is provided having a thermal barrier liner positioned in contact with inner surface of the container. The container of the present invention may include any known beverage container, such as those made from aluminum or steel that holds beverages such as beer or carbonated soft drinks. The container of the present invention may further include known plastic containers, such as PET bottles or cans.

In a first embodiment of the present invention, the thermal barrier liner may include use of a single material having a cell structure comprising a plurality of voids or pockets and wherein the liner covers the interior surface of the container to include the container sidewall and base of the container. In this embodiment, the liner may also be referred to as a closed cell substrate layer or foam layer. The material used for the barrier liner in this embodiment has a stretchable or elastic capability such that the voids may increase in physical size without rupturing. The particular liner material and manner of installing the liner can be selected such that the cell sizes create a thermal barrier liner of a desired thickness when the container is opened. The thickness of the barrier liner as well as the composition of the barrier liner in terms of the amount of void spaces within the liner can also be adjusted to optimize the thermal barrier liner for purposes of insulating the beverage. The thermal barrier liner may be made from a cavitated or extruded monolayer film substrate containing gas permeable closed cells. The thermal barrier liner could also be made by combining different materials. For example, two rolls of formed material can be laminated them together through the use of adhesives or heat and pressure. One or both materials could incorporate cell structures and when combined, the materials form an integral thermal barrier liner. Further, the thermal barrier liner could be made in a co-extrusion process or a post extruded process. In a co-extrusion process, the materials could be combined by heat and pressure as extrudate is generated from an extruding device, or the materials can be laminated to one another with some assistance from heat and pressure but also from an applied adhesive. In other embodiments of the present invention, the thermal barrier liner includes a base material containing encapsulated gases or phase change materials. The encapsulated gases or phase change materials are dispersed throughout the base layer. In these embodiments, the base material can be made from a laminated, extruded, or coated film structure.

In another embodiment of the present invention, the thermal barrier liner includes a combination of materials that, when combined, exhibit thermal barrier properties. This embodiment may be referred to as a composite liner including a combination of: (i) a cell structure comprising a plurality of voids or pockets; (ii) microencapsulated gases; and/or (iii) microencapsulated phase change materials. In this embodiment, the base material can also be made from a laminated, extruded, or coated film structure including a desired dispersion of gas permeable closed cells.

In another embodiment of the present invention, an interior liner is provided that is offset or spaced from the interior surface of the wall of the container. This liner has one end secured to either the top or bottom/dome of the container and is sealed to the top or bottom to prevent gas and liquid flow through the area of connection. The other end of the
5 liner remains unattached and is spaced from the top or bottom of the container depending on which end of the liner is attached. When the container is filled and prior to consumption, a small amount of gas is trapped in this annular gap along with liquid that fills the container. When the container is opened for consumption, the container is tipped so that the beverage can be poured from the container.

10 If the liner is secured to the top of the container, the unattached lower end is spaced from the bottom of the container. When the container is tipped to a sufficient angle, the unattached lower end of the liner is not submerged in the beverage therefore exposing a portion of the annular gap to the air. When the container is returned to its upright position after the user has poured an amount of the beverage, the unattached end is re-submerged in
15 the beverage thereby trapping air in the annular gap. The trapped air results in the creation of a thermal barrier to keep the beverage cool.

If the liner is secured to the bottom of the container, the unattached upper end is spaced from the top of the container and when the container is tipped to a sufficient angle, the beverage will be poured from the annular gap thus evacuating an amount of liquid in
20 the annular gap and the liquid being replaced by air since the gap is exposed to the air. The liner then acts as a dam to prevent liquid from migrating back into the annular gap.

In either way in which the liner is installed in the container, an increased volume of gas in the annular gap results in the creation of an air barrier that serves as an effective thermal barrier to keep the beverage at the desired temperature for consumption.

25 In yet another embodiment, the liner can be made from a mesh material wherein the material has a pattern of voids or gaps. When the container is opened, the gas bubbles from nucleation will cling to the mesh creating a concentration of gas bubbles on the material. The concentrated gas bubbles form an effective thermal barrier to prevent heat transfer to the beverage within the container. The mesh may have voids or gap sizes that
30 allow the beverage to easily pass through the liner, or the mesh material may have very small voids that somewhat restrict the flow of the beverage through the liner. The void sizes can be selected to optimize the ability of the bubbles to attach to the liner. Other ways in which to maximize the concentration of bubbles on the liner is to provide a

surface treatment/modification wherein the mesh material has surface properties that encourage the formation and retention of bubbles thereon. For example and as discussed below in reference to the preferred embodiments, the surface of the liner could be irregular or textured which greatly assist in the retention of bubbles on the surface of the liner.

5 In order to increase the amount of gas that is able to fill the annular gap for the embodiment in which the unattached end is at the lower end of the container or in order to maximize the gas bubbles that attach to the mesh liner, the liner may incorporate a material that enhances nucleation of the gas in the beverage. Another option available for increasing the amount of gas to fill the annular gap or to create a bubble layer on the liner
10 is to place a conventional widget in the container. A widget is used in some malt beverage containers to increase the rate of de-gassing of the beverage thus creating a more robust head when the beverage is served. A widget used in the present invention creates a greater number of bubbles that can attach to the liner.

 In yet another embodiment of the present invention, a thermal barrier liner may be
15 provided in the form of a multi-layer coating construction wherein voids or gas pockets are found between the layers thereby providing an effective thermal barrier. In this embodiment, a co-extrusion lamination process can produce the multi-layer coating where portions of adjacent layers are sealed to one another while other portions are not sealed thus creating the gas pockets or void areas between the layers.

20 In yet another aspect of the present invention, a method is provided for installing the thermal barrier liner to the interior surface of a beverage container. The liner is preferably in sheet form, but incorporating the various insulating features.

 The thermal barrier liner is preferably pre-made and stored in a continuous roll of material. The roll is unwound near the area in the manufacturing process where the liner
25 is to be mechanically installed into the beverage container. The roll of barrier material is cut into predetermined sized pieces and placed within respective containers such that the liner material maintains contact with the interior sidewall of the containers.

 The thermal barrier liner in the first embodiment of the present invention is gas permeable thus having the ability to equilibrate with ambient pressure conditions. More
30 specifically, during the application of the liner to the container, the voids or pockets formed in the liner will contain gas of the surrounding environment, and the ambient pressure will determine the void sizes. After the container has been filled and sealed, the interior of the container develops a higher pressure in which the void areas further fill with

gas contained in the container, such as carbon dioxide or nitrogen. This gas resides in the headspace and the gas can also be found dissolved in the beverage if the beverage is carbonated. Since the container is under pressure, the voids may decrease in size as compared to the size of the voids under ambient pressure conditions; however, the voids
5 will contain a greater amount of gas due to the higher pressure conditions in which equilibrium is reached and pressure across the liner is equal. The voids fill with the gas (es) over a relatively short period of time due to the gas permeable nature of the liner material.

Once the container is opened, the thermal barrier liner transitions to equilibrium
10 with ambient pressure wherein the pressurized gas contained within the voids causes an immediate expansion of the size of the voids. The increased size of the voids creates a thickened liner that is an effective thermal barrier liner to maintain beverage at a desired temperature.

Other features and advantages of the present invention will become apparent from
15 a review of the following detailed description, taken in conjunction with a review of the drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a fragmentary perspective view of a beverage container incorporating a thermal barrier liner of the present invention;

20 Figure 2 is an enlarged fragmentary cross section view of the thermal barrier liner of the present invention in a first embodiment characterized by a closed cell substrate layer or foam layer;

Figure 3 is another enlarged fragmentary cross section of the embodiment of Figure 2 showing the closed cell substrate layer after the container has been sealed and
25 pressurized;

Figure 4 is another enlarged fragmentary cross section view of the first embodiment after the container has been opened resulting in expansion of the liner;

Figure 4A is a greatly enlarged view of a portion of Figure 4 showing the structure of the substrate layer after the container has been opened;

30 Figure 5 is an enlarged fragmentary cross section of a barrier liner in another embodiment of the present invention comprising microcapsules containing encapsulated gas or liquid embedded in a base liner material;

Figure 5A is a greatly enlarged view of a portion of Figure 5 showing the barrier liner and gas or liquid filled microcapsules;

Figure 6 is another greatly enlarged view of the portion of Figure 5 when liquid filled microcapsules are used and undergo a phase change to a gas upon warming and
5 wherein the microcapsules expand in the gaseous state;

Figure 7 is an enlarged fragmentary cross section view of a thermal barrier liner in another embodiment of the present invention comprising encapsulated solid phase change materials incorporated within a base liner and showing the thermal barrier liner when the container is sealed and pressurized;

10 Figure 7A is a greatly enlarged view of a portion of Figure 7 showing the barrier liner and the encapsulated solid phase change material within the microcapsules;

Figure 8 is another greatly enlarged view of the embodiment of Figure 7 when the container has been opened and the beverage has warmed to the phase change temperature, showing the phase change material in the microcapsules being in a liquid state after the
15 phase change;

Figure 9 is an enlarged fragmentary cross section view of another embodiment of the present invention illustrating a thermal barrier liner constructed of a multi-layer configuration and illustrating the container when sealed and pressurized;

20 Figure 9A is a greatly enlarged view of the embodiment of Figure 9 showing the multi-layer configuration when the container is sealed and pressurized;

Figure 10 is another greatly enlarged view of the embodiment of Figure 9 illustrating the container after it has been opened and expansion in thickness of the liner;

Figure 11 illustrates yet another embodiment of the present invention in the form of a composite thermal barrier liner including a combination of features of the prior
25 embodiments including a closed cell substrate, and encapsulated gas and/or encapsulated phase change material set within a base liner;

Figure 12 is a perspective view of a bulk roll of the thermal barrier liner and a schematic view of the equipment that may be used to dispense the liner material for subsequent insertion within individual beverage containers;

30 Figure 13 is a perspective view of a cut piece of the liner material sized to be installed within a container and held by processing equipment that inserts the cut piece into the container; and

Figure 14 is a perspective view of the container in which the liner has been installed wherein the barrier material unwinds and thereby places the liner in intimate contact with the interior sidewall of the container.

5 Figure 15 illustrates a cross section of a container in another embodiment of the present invention in the form of a liner that creates an annular gap between the interior surface of the sidewall and the liner in which an upper end of the liner is sealed to the top of the container and the lower end of the liner is unattached and spaced from the bottom of the container;

10 Figure 16 is another cross section of the embodiment of Figure 15 illustrating the container being tipped during consumption allowing the annular gap to be exposed to the air;

Figure 17 is another cross section view illustrating the container being returned to an upright position after being tipped and an increased amount of gas in the annular gap creating a thermal barrier;

15 Figure 18 is another cross section view illustrating a liner in accordance with the embodiment of Figure 15; however the liner is sealed to the bottom of the container and the upper end of the liner is unattached and spaced from the top of the container;

20 Figure 19 is another cross section view of the embodiment of Figure 18 illustrating the container being tipped allowing air to enter the annular gap as the beverage is poured from the gap;

Figure 20 is another cross section view of the embodiment of Figure 18 illustrating the container when returned to an upright position and an enhanced thermal barrier being created by the air replacing the liquid in the annular gap;

25 Figure 21 is a cross section view illustrating a liner in accordance with the embodiment of Figure 15 that does not extend parallel with the sidewall of the container and rather, extends at an angle with respect to the sidewall;

Figure 22 is a cross section view illustrating a liner in accordance with another embodiment wherein the liner comprises a mesh material; and

30 Figure 23 is a greatly enlarged portion of Figure 22 showing one example of how the liner can be attached to the container.

DETAILED DESCRIPTION

With reference to the drawings, Figure 1 shows a beverage container 10, particularly suited for beverages such as beer or carbonated soft drinks, fruit drinks, and like. The container is illustrated as a conventional beverage can having a sidewall or body 5 12, a base 14, and an openable top 16. The openable top 16 may include a closure mechanism, such as a pull-tab 17. The sidewall or body of the container is constructed of conventional materials such as aluminum or steel. The openable closure mechanism 17 is also preferably aluminum or steel and may include the pull-tab 17 that contacts a scored area 19 on the top 16. Activation of the pull-tab 17 breaks the scored area 19 creating an 10 opening or mouth to provide access to the beverage inside the container. As also shown in Figure 1, the conventional container may include the bottom or base 14 having an annular lip 20 and a dome shaped panel 22.

In accordance with a first embodiment of the present invention, a thermal barrier liner 30 is provided as shown in Figures 1-4. The thermal barrier liner in this first 15 embodiment comprises a gas permeable closed cell substrate 32. The substrate 32 is installed so that the liner contacts the interior surface of the container. The gas permeable closed cell substrate includes a pattern of cells 34 defining a plurality of voids, gaps, or open spaces 36 thereby providing the appearance of a foam layer. Figure 2 illustrates the substrate 32 after the substrate has been installed in the container and positioned in contact 20 with the interior surface of the container. The voids or gaps may be of an irregular pattern and the voids or gaps may be of different sizes and shapes. In one aspect of the first embodiment, the thermal barrier liner material may be made from a homogenous material. In another aspect of the first embodiment, the thermal barrier liner may include a combination of materials. In either case, the liner is gas permeable and the cells 34 have 25 walls that are elastic/elastomeric such that the overall size of each of the voids/gaps 36 can change according to ambient pressure conditions.

The arrangement and size of the voids/gaps 36 may be a result of either how the liner 30 is manufactured and/or may be determined during a curing process wherein the voids/gaps form over a period of time. For example during manufacture of the liner, the 30 liner can be oven dried to evaporate any solvents or other compounds used. Curing can also be conducted to condition the state of the microencapsulated gas, liquid, or solid materials used in order to place them in the best state prior to filling and sealing the container. The void areas may be randomly dispersed and randomly sized. However,

depending upon the material used as the liner, a more orderly cellular pattern may result. The percentage of void or open cell space volume can range between about 10 to about 95 percent of the overall volume of the thermal barrier liner.

One important attribute of the substrate 32 is that it be gas permeable such that
5 when placed under pressure, the substrate will equilibrate resulting in a substantially
uniform distribution of gas within the voids 36. Furthermore, when pressure is reduced,
the substrate should have the capability to expand such that the cell walls 34 do not burst,
tear, or otherwise degrade and, rather, will maintain an inflated state for a period of time
thus creating an effective thermal barrier liner realized by the increased volume of the
10 substrate 32.

It has been found through testing that some existing container liner materials have
the capability to be formed into foamed substrates and are elastic such that the substrate
maintains integrity among various pressure ranges. However, in order to optimize the
closed cell substrate configuration and necessary gas permeability, foaming agents can be
15 added to the liner materials. The liner materials can include polymeric or synthetic
formulations of thermoplastics. Two acceptable liner materials may include expanded
styrene and polyethylene foam. These liner materials may be used to form a thermal
barrier liner having a gas permeable closed cell substrate configuration that is able to
equilibrate at working pressure changes.

Referring to Figure 3, this figure represents how the barrier liner 30 appears when
20 the container has been sealed and pressurized. As shown, the overall thickness of the
barrier liner reduces in response to the increased internal pressure within the container.
Accordingly, Figure 2 shows a thickness "a" of the liner that may be somewhat larger than
the thickness "b" of the liner when the container is sealed and pressurized. For carbonated
25 beverages, carbon dioxide is the primary gas that fills the container under pressure.
Accordingly, the substrate must be permeable to allow passage of the carbon dioxide if
used with such carbonated beverages. Within a period of time, the thermal barrier liner
will allow passage of the pressurized gas within the container such that the substrate is
fully entrained with the pressurized gas. Optionally, liquid nitrogen may be added to the
30 beverage just before sealing to assist in pressure development. In most container filling
processes, the end or cap of the container is not attached to the body of the container until
the beverage has been added to the container. When the end or cap is attached, a seal is
created thus preventing liquid or gas from escaping. Pressure within the container will

increase due to a number of factors such as carbonization within the beverage, any added liquid such as nitrogen that will transition to a gas phase, and pasteurization of the beverage by heat treatment. As the thermal barrier liner becomes entrained with the gas, the liner will de-compress as it equilibrates with the internal gas pressure. Some reduction
5 in the area of the headspace of the container may occur by thickening of the liner due to entrainment of the pressurized gas into the liner after the container has been sealed and pressurized. However, normal levels of container pressurization do not have to be significantly altered to account for presence of the liner since the liner even in its fully gas entrained state after pressurization and sealing of the container takes up a minimum
10 volume within the container.

The thermal barrier liner is preferably of a thickness under ambient pressure conditions such that it does not unduly displace the typical amount of the beverage within the container. Thus when the barrier liner expands under ambient pressure conditions, the beverage in the container will not be forced through the opening in the container.

15 Referring to Figure 4, this figure represents the point in time when the container has been opened. In response to the reduction in ambient pressure, the cells 34 expand in size to reach equilibrium. Thus, the thickness "c" of the liner is greater than both the thicknesses "a" and "b". The cells maintain this expanded state for a period of time thus providing an effective thermal barrier liner to maintain the beverage at a desired
20 temperature. Typically, the pressure within the container prior to opening is 10 to 35 psi, depending upon carbon dioxide and/or nitrogen levels and temperature of the beverage. By expanding the overall thickness of the barrier liner 30, and without otherwise altering the dimensions of the container or any other parameters, the thermal barrier liner is enhanced simply by the ambient pressure changes between the unopened and opened
25 container.

An added benefit with respect to first embodiment is that when the container is being chilled (when unopened) fast chilling of the beverage may take place since the thermal barrier liner is in its more compressed or thin state, thereby allowing rapid heat transfer away from the container without having to overcome a relatively thickened
30 insulating member.

The permeability of the thermal barrier liner is such that gas is allowed to permeate through the cell walls over a period when under pressure to reach equilibrium, for example, a few hours, but the cell walls are not so permeable that immediate deflation

takes place when ambient pressure is reduced. Therefore, the thermal barrier liner will maintain a full thickness for at least a period of time in which a consumer would normally consume the beverage. It is contemplated that it may take up to twenty-four hours for pressurized gas within the container when the container is sealed to permeate through the thermal barrier liner but when the container is opened, it will take at least one hour before the thermal barrier liner reaches equilibrium with the reduced pressure of the environment. Thus, a full, thickened barrier liner is maintained during the time period in which a consumer normally consumes the beverage.

Figures 5, 5A and 6 illustrate yet another embodiment of the present invention in the form of a thermal barrier liner 30 comprising a layer of base material 42 interspersed with an additive component 40 such as gas or liquid filled microcapsules. The base material 42 binds to the additive component 40. The additive component 40 can either be a majority component or minority component by volume as compared to the base layer 42. Preferably, the additive component is dispersed randomly throughout the base layer.

One example of an additive component that may be used as a microencapsulated gas includes Expancel®. Expancel® is a commercially available product that includes elastic micro-spheres or microcapsules, roughly ten micrometers in diameter, filled with a small amount of liquid hydrocarbon gas. When heated within a known temperature range, the liquid hydrocarbon gas expands within the micro-spheres causing the micro-spheres to expand to a diameter of nearly four times the size of the liquid state, to approximately forty micrometers. As temperature increases, the gas continues to expand and, thus, the micro-spheres continue to expand in size. The micro-spheres can be used either in an unexpanded liquid state or a pre-expanded gaseous state, depending on application capabilities and the elasticity of the base material 42. With respect to use as an insulation material in the present invention, use of pre-expanded spheres 40 would create a pattern of voids in the base layer.

As mentioned, the microcapsules create voids in the base layer and thereby enhance the thermal barrier capability of the liner. The size and distribution of the voids created by the gas or liquid filled spheres can be selected to provide the desired level of insulation for the container. A greater concentration of micro spheres will produce more voids. The particular gas or liquid selected can be selected to optimize the desired level of insulation.

It is also contemplated that liquid filled micro spheres can be provided so that the liquid changes phase to a gaseous state when the beverage warms during consumption by the consumer. Thus, when the beverage is maintained in its cooled state during storage, the micro-spheres would remain in a liquid state. Referring to Figure 6, when the container is opened and exposed to the warmer environment, the increase in temperature causes the micro-spheres to transition to a larger diameter as the liquid changes phase to the gas state. Thus, the expansion of the thermal barrier liner in this example is activated by temperature and not by ambient pressure changes. A liquid-gas phase change property for the thermal barrier liner of the present invention may be particularly suited for containers that are not pressurized, such as juice, fruit, or vegetable containers.

For both the first and second embodiments, one acceptable base liner material may include expanded styrene or polyethylene foam. During manufacturing of the liner, increased curing times may be required depending upon the addition of an additive component which may, therefore, increase the curing time.

Now referring to Figures 7, 7A and 8, in yet another embodiment of the present invention, a thermal barrier liner is provided comprising a base layer 42, and an additive component 50 in the form of encapsulated phase change material. The encapsulated phase change material 50 may also be microcapsules that are interspersed as shown within the base layer 42. One example of phase change material that may be used includes paraffinic hydrocarbons. Another phase change material may include hydrated salts. One commercially amiable type of phase change material may include MPCM-6, a product sold by MicroTek Laboratories, Inc. MPCM-6 is a microencapsulated paraffin wax (specific latent heat of 188.6 J/g) in a polymer shell with a solid to liquid phase change temperature occurring at 6° C. When chilled to below 6° C, the paraffin exists as a solid. As the spheres absorb heat, the encapsulated paraffin rises in temperature until it reaches 6° C. At that temperature, the paraffin continues to absorb heat, but stays at a relatively constant temperature until it has completely transitioned from a solid to a liquid phase. The heat absorbed by the phase change material, also known as latent heat, would otherwise have caused an increase in the temperature of the beverage within the container. The total amount of heat capable of being absorbed by the paraffin wax can be calculated and adjusted by varying the amount of paraffin used within the barrier layer. For example, 25cc of MPCM-6, which would normally require a minimum liner thickness of one millimeter, absorbs the equivalent heat that would otherwise cause a 5° F increase in

temperature of a 355cc beverage.

Figures 7 and 7A specifically illustrate this third embodiment wherein the container is under pressure and assumedly at a chilled temperature (for example, below 6°C). Figure 8 shows the container removed from refrigeration and warmed to a
5 temperature wherein the solid phase change material has transitioned from a solid to liquid state. More specifically, the materials in the microcapsules 50 are shown in Figures 7 and 8 as transitioning from a solid state 51 to a liquid state 52.

Figures 9, 9A and 10 illustrate yet another preferred embodiment of the present invention. In this embodiment, the thermal barrier liner 30 comprises multiple layers 60
10 of a lining material wherein voids or gaps 62 exist between each of the layers. The voids or gaps between the layers may be provided in an irregular pattern. As shown in Figures 9 and 9A, when the container is under pressure and unopened, the layers 60 form a more compressed, thinner profile. However, as shown in Figure 10, when the container is opened and ambient pressure is reduced, the gas trapped in the voids between the layers
15 results in an expansion of the liner, thereby enhancing thermal barrier properties of the liner.

This multi-layer liner can be constructed of multiple layers of the same material, or may be made of dissimilar materials. With respect to a single material used, if the single material is layered and sealed in a complex pattern, or applied at different times with
20 different temperatures or viscosities, voids or gas pockets may be formed between layers. With respect to use of dissimilar materials, void areas between the layers may be formed more as a function of the ability of layers to adhere to one another, among other factors.

Unlike conventional liners applied to the interior of containers, it is the intent in the embodiment shown in Figures 9 and 10 to install a multi-layered liner wherein intentional
25 voids or gaps are created between the layers of material such that gases may be trapped between the layers. Thus, as mentioned above, the variation of temperatures, viscosities, as well as patterned sealing and/or the use of dissimilar materials can result in the creation of a multi-layered liner having an inconsistent appearance in terms of how the layers adhere to one another. Visually, the liner of this embodiment may appear somewhat
30 wrinkled or may appear as having a roughened surface. These apparent inconsistencies in the liner are a result of the intention to provide gaps or void spaces between the layers of the liner. Thus, this multi-layered liner significantly departs from multi-layered liners, either used internally or externally for containers, wherein the failure to completely adhere

one layer to another may be considered a significant defect.

Referring to Figure 11, a composite thermal barrier liner may be provided by combining one or more of the attributes from the prior embodiments. More specifically, Figure 11 illustrates a liner including a gas permeable closed cell substrate 32 as well as
5 microencapsulated gas and/or microencapsulated solid-liquid phase change material 40/50 set within a base layer 42.

Figure 12 illustrates a bulk roll of liner material 80 as it is dispensed from the roll so that each container being processed can receive a pre-made liner. The liner material is preferably manufactured in an extended continuous strip so that the material maintains a
10 flat or linear position. For example, through an overdriven lamination process, the substrate material has a normally flat or linear configuration. When the material is stored on a bulk roll, the material maintains a spring force such that when the material is released from the roll, the material has a tendency to return to its generally flat, linear configuration. Thus, the liner material has a “stay-flat” memory property that requires no
15 mechanical or physical mechanism to keep the substrate fixed in place with the interior of the container.

The bulk roll 80 may be dispensed from a shaft 82 driven by a dispensing device 84. The roll of liner material may be dispensed so that a predetermined length of the material is placed in alignment with a cutting device 86 having a cutting blade 88 that cuts
20 discrete lengths of pieces of the liner material. One cut piece of material 83 is shown adjacent the cutting blade. Referring to Figure 13, once the piece 83 of liner material has been cut, a handling device 100 is used to secure the piece of liner material and position it so that it may then be inserted within the open top of the container. As shown, the handling device 100 may include a stationary holding element 102 and slideable engaging
25 element 104 that engages the piece of cut liner material in a rolled configuration so that it can be held between elements 102 and 104. The handling device 100 is positioned over the container and inserts the piece of liner material 83 within the container. The slideable engaging element 104 is moved away from the stationary element 102 so that when the inserting element is withdrawn as shown in Figure 14, the liner material unrolls to contact
30 the interior cylindrical sidewall of the container. More specifically referring to Figure 14, when the piece of cut liner 83 has been placed in the container, the liner deploys by opening within the interior of the container to contact the cylindrical sidewall. A small gap 110 separates the opposing side edges 112 of the liner material. Preferably, the side

edges 112 do not contact one another that might otherwise prevent the liner material from fully deploying to contact the interior sidewall of the container. The interference or friction fit of the liner against the interior sidewall of the container is sufficient enough to maintain its position within the container to overcome normal vibration or shock that the container might experience during distribution or use. For the embodiment of Figure 2 that utilizes a closed cell substrate and the embodiment of Figure 12 that utilizes a composite structure including the closed cell substrate, it is desirable to seal the edges of the liner so that liquid does not migrate into the gaps or void spaces between the cells. For the embodiment of Figure 9, it is also desirable to seal the edges of the liner so that liquid does not migrate into the gaps between the layers. Heat and/or pressure may be applied to the edges of the liner in order to seal the opposing surfaces of the liner at the side edges. The sealing of the opposing side edges 112 may occur just before or just after cutting of the liner. The sealed area can be sized so that the cut may be made along the seal resulting in the trailing side edge 112 of one piece of cut liner being sealed as well as the leading side edge 112 of the next cut piece of liner. The upper edge 116 and lower edge 114 of the liner as viewed when installed (see Figure 13) may also be sealed, but preferably prior to cutting. More specifically, when the roll of liner material is manufactured, these edges may be sealed.

After the liner has been installed, the top of the container is secured to the sidewall, the container is filled with the beverage, and finally the container is sealed and pressurized.

The thermal barrier liner of the present invention is installed such that it does not degrade or otherwise damage the conventional protective interior liner of the container that is used to prevent contact between the beverage and the metallic sidewall and base. Thus, while the thermal barrier liner makes intimate contact with the conventional interior liner, the thermal barrier liner is not abrasive and otherwise does not produce an adverse affect on the conventional interior liner.

With respect to a preferred thickness of the thermal barrier liner, it shall be understood that none of the embodiments are strictly limited to a specific range but it has been found that a liner between about 1.0 mm to 3.0 mm provides adequate insulation without displacing a quantity of the beverage that adversely affects desired headspace within the container. For the first embodiment, the thermal barrier liner can be between about .5 mm and 1.5mm in thickness when the container is sealed and pressurized, and the

thermal barrier liner expands to between about 1.0 mm and 3.0mm mm when the container is opened and exposed to the environment.

It shall be understood that the thermal barrier liner of the present invention significantly departs from traditional liners used to coat the interior of a container for purposes of preventing spoilage of the beverage in the container. More specifically, conventional liners are formed to create a very smooth, thin, and non-insulating layer. The thermal barrier liner of the present invention by provision of a closed cell substrate, and/or with microencapsulated materials, or a multi-layer liner provides a unique solution for a thermal barrier, and may optionally be made from similar materials as the conventional interior liner.

As also mentioned above, provision of a gas permeable liner that can equilibrate between different ambient pressures allows creation of a thicker insulated layer once the container is opened. Providing this active or size changing barrier liner also has the benefit of allowing the container to be more easily cooled when unopened, yet allows substantially the same amount of beverage to be maintained in the container since the barrier liner occupies a minimum volume when under pressure or when chilled.

With respect to the embodiment of the present invention providing a multi-layered liner, the structure here is intended to provide voids between layers as opposed to conventional liners where the intent is to minimize void areas between the layers in order to maximize the bond between the layers. In fact, many can liners require additives therefore improving the wetting or contact area to maximize bonding between the layers. However, with the present invention, the bonding areas between the layers is reduced to the point where a balance can be achieved between a bond strength such that the layers maintain integrity and remain bound to one another, yet gaps or void areas are formed to allow permeation of gas and subsequent expansion thereby creating an effective thermal barrier liner. Some techniques to promote rough and irregular surface bonding between the layers may include use of high viscosity materials, cold application temperatures, patterned sealing and use of different materials between layers that are not fully miscible.

While the preferred embodiments of the present invention have been shown specifically with respect to a traditional aluminum or steel container, it shall be understood that the thermal barrier liners of the present invention can be incorporated within any type of container to include plastic containers such as PET bottles, or conventional aluminum or steel cans used to contain fruits, vegetables, soups, meat or other products.

Figure 15 illustrates yet another embodiment of the present invention in which the container incorporates a liner that is spaced from the interior wall of the container thus forming an annular gap 92 between the interior surface of the container and the liner.

More specifically, Figure 15 illustrates a container having a sidewall 82, a base/dome 84, and a top 88 including rim 89. A liner 86 is disposed within the container and is spaced from the interior surface 83 of the sidewall 82. In the embodiment of Figure 15, the liner 86 is attached to and sealed to the top 88, and lower end of the liner is unattached and is spaced from the base 84. The unattached end of the liner is designated as end 96. The liner may be attached to the top as by an adhesive or heat applied to a liner material that will melt and thus seal itself to the container. For a standard 12oz, 16oz, or 20oz container, the annular gap 92 can be between about 0.5 mm to 1.0 mm in thickness and when filled with air, provides an effective thermal barrier that helps maintain the beverage at a desired temperature. However, this range is not critical and therefore the thickness of the liner can be adjusted for the particular container and beverage to maximize the thermal barrier effect. Optionally, the liner may include a nucleation enhancing material that increases the rate of de-gassing of the beverage as discussed further below. Carbonated or nitrogenated beverages will therefore produce gas bubbles that will rise and become trapped in the annular gap 92. The additional gas entering the annular space contributes to an increased gas column height in the annular gap.

Figure 15 illustrates the container when filled and prior to being opened. In this state, the liquid level of the beverage within a chamber of the container bounded by the liner is shown at liquid level line 112. An amount of gas resides in the head space above the liquid line 112. There is also a liquid level line 110 in the annular gap 92, and the liquid level line 110 is approximately the same the level as the liquid line 112 within the chamber of the container.

Referring to Figure 16, the consumer will tip the container to pour the beverage from the container. When the container is tipped at a sufficient angle, a portion of the unattached end 96 will no longer be submerged in the beverage thus exposing the annular gap to the air.

Referring to Figure 17, when the consumer returns the beverage to an upright position, the unattached end of the liner is again completely submerged and the air that entered the annular gap while the container was tipped is trapped in the annular gap. The trapped air results in an increased gas column height within the annular gap 92 as shown

by the liquid level line 110 being substantially lower than the liquid level line 112.

The distance between the unattached end 96 of the liner and the base of the container can be adjusted to provide an optimal angle at which air is allowed to enter the annular gap for purposes of creating an enhanced thermal barrier.

5 The embodiment of Figure 15 also illustrates that the unattached end 96 may be curved such that the end 96 extends radially inward towards a longitudinal axis A-A of the container. This curved end further facilitates an increased amount of gas that can be trapped within the annular gap from gas originating from gas bubbles in the beverage. The curved end reduces the cross-sectional area of the chamber at that location therefore
10 directing the gas bubbles radially outward and into the annular gap. In terms of attaching the liner shown in Figures 15-17, one way is to place the upper end of the liner between the upper edge of the sidewall 86 and the rim 89 of the top 88. When the top 88 is seamed to the sidewall 82 after filling the container, the liner 86 would also be secured in place.

Referring to Figure 18, a modification is shown to the embodiment of Figure 15,
15 wherein the liner 86 is sealed to the container at the bottom 84 and the unattached end 96 of the liner is disposed at the upper end of the container and spaced from the top 88. Figure 18 also illustrates the container when filled and prior to being opened by the consumer.

Referring to Figure 19, when the container is opened and tipped to pour the
20 beverage from the mouth 93, liquid in the annular gap will be removed.

Referring to Figure 20, when the container is returned to its upright position, the liner acts as a dam to prevent liquid from within the chamber from flooding back into the annular gap. Therefore, an increased amount of air within the annular gap enhances the thermal barrier capability of the container and liner combination.

25 A number of different materials can be used for the liner since the liner itself does not have to have insulating properties. Examples of acceptable liner materials include polyethylene, polyethylene terephthalate (PET), polypropylene, foil, or laminated foil. Alternatively, the liner material could have its own inherent insulating properties in order to further enhance the thermal barrier characteristics of the container. In such a case, the
30 liner could be made from the materials as discussed above with respect to the other embodiments of the present invention shown in Figures 1-12.

In order to keep the liner correctly aligned within the container to maintain a uniformly spaced annular gap, the liner can be stiffened by thermo-formed features in the

material. For example if PET is used as the liner material, small beads or bumps/protrusions can be thermo-formed in the material. If a foil material is used, small protrusions can be formed by embossing.

Referring to Figure 21, another modification is shown to the embodiment of Figure 15 wherein the liner 86 does not extend substantially parallel with the sidewall 82 but, rather extends at an angle to the sidewall 82 thereby causing an upper portion of the liner 86 to be more closely spaced to the sidewall 82. This closer spacing of the liner 86 results in the annular gap having a smaller volume. Thus, a lesser amount of air is required to fill the annular gap and this lessened annular gap volume may be advantageous in more quickly establishing a thermal barrier when the beverage is being first consumed. In any event, the particular volume of the annular gap can be selected to allow creation of the thermal barrier that best suits the particular beverage within the container.

Trapped air in a beverage container is problematic and quality standards for most beverages require that only very small amounts of oxygen are permitted. One solution for evacuating air that may be trapped in the annular gap when the container is filled is to alter the filling nozzle so that the beverage is first directed into the annular gap thereby evacuating the gap from air and then filling the remainder of the container. Use of a purge gas such as Nitrogen can also be used to evacuate trapped air in the container. The purge gas can also be directed into the annular gap to evacuate trapped air in the annular gap, as well as directing purge gas in the head space of the container.

Although the liner of Figures 15-21 has been illustrated as straight or linear in cross section, it shall be understood that the liner can have other shapes to best insulate the beverage. For example, the middle of the container is typically where a consumer grasps the container, so it may be advantageous to increase the thickness of the annular gap at the middle of the container by providing an annular constriction of the liner at the middle of the liner that extends radially inward toward the longitudinal axis of the container. The increased thickness of the liner at this location further assists in preventing heat transfer from the hand of the consumer.

For the embodiments of Figures 15-21, a container is provided in which an automatic insulation feature can be activated by two mechanisms: the first being the normal dispensing action of the beverage by tipping the container in which an increased amount of gas fills the annular gap and second, the optional use of a nucleation enhancing material that increases the rate at which gas is released or de-gassed from the beverage,

and this gas is then transported to the annular gap thereby increasing the amount of gas in the annular gap. Because of the insulating characteristics of air, the gap between the sidewall and liner can be very small, yet achieve a very effective thermal barrier for the time in which the consumer will consume the beverage.

5 Figure 22 illustrates yet another embodiment of the present invention having a liner 100 made of a mesh material. The mesh material has a pattern of interlocking members separated by a corresponding pattern of gaps or openings 101. Like the liners of the previous embodiments, the mesh liner is installed in a concentric fashion within the container to create an annular gap between the interior surface of the container sidewall 82
10 and the outer or facing surface of the liner 100. The mesh type liner has two functional advantages. The first advantage is that during filling of the container, air is able to vent through the mesh and therefore air is more easily evacuated from the container. In the filling of a beverage container, air must be removed to prevent the air from spoiling the beverage and thus many beverages are purged with nitrogen prior to attaching the top of
15 the container. With the use of a solid liner, it may be more difficult to remove the air during filling. The other advantage of the mesh liner is that an insulating barrier can still be created by bubbles that attach to liner and therefore the liner is still able to provide a large enough air space to thermally insulate the beverage. Some example of materials that can be used to make the mesh liner include woven fibers, open cell foam, and a
20 stretched film that incorporates a plurality of slits or openings to create the voids 101. Because of the geometry of the mesh liner with many different surfaces disposed at various angles, bubbles will have a tendency to attach to the irregular surfaces thereby creating a bubble wall or layer within and around the mesh liner. With the use of a mesh liner, it can also be attached to the sidewall since the thermal barrier created by the
25 bubbles can still occur by the exposed side of the liner that will attract the bubbles.

In each of the embodiments of Figures 15-23, the liner material can be especially adapted to nucleate bubbles on the exposed surfaces of the liner thereby either increasing the amount of gas in the annular space or providing a greater concentration of bubbles on the liner. Some examples of how the liner material can be treated or manufactured to
30 encourage an increased rate of nucleation includes (i) providing a textured or roughened liner surface that has a tendency to create greater agitation in the beverage as de-gassing, and this greater agitation results in an increased rate of nucleation of gas in the container; (ii) modifying the surface tension of the liner by corona discharge or by flame treatment

that again increases agitation and an increased rate of nucleation; and (iii) providing a molded, hot formed film to create a textured surfaces on the liner that increases agitation and thus enhances nucleation.

Another way in which to increase nucleation would be to incorporate a widget in
5 the container. One example of a known widget used to create a more robust head on a
malt beverage includes the use of a small plastic nitrogen filled sphere having a very small
hole formed on the sphere. The sphere is typically added to the container before the
container is sealed and the sphere floats with the hole just below the surface of the
beverage. Before the container is sealed, a small shot of liquid nitrogen is added to the
10 beverage. Pressure increases in the container as the liquid nitrogen evaporates, and the
beverage is slowly forced into the sphere thereby compressing the nitrogen gas in the
sphere. When the container is opened, the compressed gas in the sphere quickly forces the
beverage through the hole causing agitation of the beverage which nucleates the gas in the
beverage creating bubbles. The widget could be formed in a ring shape and placed in the
15 annular gap. The widget would therefore provide a way of directing the bubbles 102 in
the annular gap. Figure 22 shows an example widget 103 fitted in the bottom of the
container and within the annular gap. The widget 103 is ring or donut shaped and rests on
the bottom/dome 84. The widget is placed so that it is aligned under the annular gap 92.
The widget has an outer surface or shell that covers the hollow interior. A small hole in
20 the widget allows the compressed gas in the widget to force the beverage out as explained
above.

Referring to Figure 23, one technique is illustrated for attaching the liner to the
container. As shown, the liner can be placed between the neck 106 of the sidewall 82 and
the chuck wall 104 of the top end 88. When the chuck wall and neck are seamed to seal
25 the beverage, the upper end of the liner is squeezed and trapped thus holding the liner in
the concentric configuration within the container. Although the bubbles 102 are only
shown in the gap between the sidewall 82 and the liner 100, it shall be understood that the
bubbles would form a layer on the liner 100 and would fill in some of the gaps/openings
101. The layer of bubbles 102 have not been shown on all portions of the liner for
30 purposes of clarity.

While the present invention has been discussed for use in keeping beverages cool,
it shall also be understood that the present invention can also be used to thermally insulate
a beverage intended to be served at room temperature or warmer. For the first

embodiment of the present invention incorporating the closed cell substrate that is capable of thermally insulating a container by only changes in pressure, this embodiment can certainly be used for those beverages that are intended to be served at room temperature or warmer.

5 The automatic activation of the thermal barrier liner under variable pressure or temperature conditions makes the thermal barrier liner ideal in those commercial applications where the beverages may be stored under pressure, such as the case for carbonated soft drinks and beer.

10 Because the thermal barrier liner of the present invention may be installed by mechanically inserting the liner in an unfinished container, it is unnecessary to significantly alter or otherwise modify known beverage packaging machinery or processes.

15 While the present invention has been described with respect to various preferred embodiments, it shall be understood that various other changes and modifications to the invention may be made, commensurate with the scope of the claims appended hereto.

What is claimed is:

1. A method of manufacturing an insulated beverage container, said method comprising the steps of:
 - providing a beverage container having an interior surface;
 - 5 providing a roll of thermal barrier liner material having a gas permeable, closed cell substrate, wherein the liner equilibrates with ambient pressure conditions over a period of time;
 - cutting the liner to produce a cut piece of a desired length;
 - rolling the piece of cut liner;
 - 10 installing the cut piece of liner in the container;
 - unrolling the liner to contact interior sidewalls of the container;
 - filling the container with the beverage;
 - sealing and pressurizing the container;
 - equilibrating the liner to entrain pressurized gas within the sealed and pressurized
 - 15 container.
2. A method of manufacturing an insulated container, said method comprising the steps of:
 - providing a beverage container including a sidewall and a base connected to the
 - sidewall;
 - 20 providing a thermal barrier made of a sheet of material; and
 - mechanically inserting the thermal barrier material in the container and deploying the liner by unrolling to contact an interior surface of the container to form an interior liner.
3. A method, as claimed in Claim 2, wherein:
 - 25 said method further comprises inserting the thermal barrier material in an open top of the container, and then securing a top of the container to an upper portion of the sidewall.
4. A method, as claimed in Claim 2, wherein:
 - said thermal barrier material is secured by a handling device that maintains said
 - 30 thermal barrier material in a rolled configuration prior to inserting the material in the container.
5. A method, as claimed in Claim 2, wherein:

a closed cell substrate is incorporated in the thermal barrier material, and the thermal barrier material is gas permeable such that voids in the closed cell substrate equilibrate with ambient pressure conditions and such voids change size based on changes in ambient pressure conditions as compared to pressure conditions in the barrier material.

5 6. A method, as claimed in Claim 2, wherein: said thermal barrier material includes:

 a base material, and a plurality of microcapsules containing gas dispersed in said base material, said microcapsules changing shape based upon ambient pressure conditions wherein said microcapsules have a smaller size when placed under pressure when the
10 container is sealed and pressurized, and wherein the microcapsules expand when the container is opened and the thermal barrier liner is exposed to the environment, said thermal barrier liner having a surface in contact and adhered to an interior surface of said sidewall and said base.

 7. A method, as claimed in Claim 2, wherein: said thermal barrier material
15 comprises a base material and a plurality of microcapsules containing phase change material therein, said microcapsules being dispersed in said base material, wherein said microcapsules absorb heat upon a temperature increase within the interior of the container and the phase change material changes from solid to liquid.

 8. A method, as claimed in Claim 2, wherein: said thermal barrier material
20 liner comprises at least a first layer of barrier material contacting the interior surface, and at least a second layer secured to said at least first layer wherein gaps are formed between the first and second layers and gas occupying the gaps.

 9. A method, as claimed in Claim 2, wherein: said thermal barrier material
25 liner comprises a composite structure, said composite structure comprising (i) a closed cell substrate having a plurality of cells defining voids, said closed cell substrate being gas permeable to allow gas to pass through the cells based upon ambient pressure changes within the interior of the container, and (ii) a plurality of microcapsules dispersed in said closed cell substrate, said plurality of microcapsules including at least one of gas filled microcapsules and phase change material filled capsules.

30 10. A method, as claimed in Claim 2, wherein:
 said thermal barrier material has a thickness that changes based upon changes in ambient pressure conditions.

 11. A method, as claimed in Claim 2, wherein:

said thermal barrier material is made of a thermoplastic material.

12. A method, as claimed in Claim 2, wherein:

said thermal barrier material is elastic.

13. A method, as claimed in Claim 2, wherein:

5 said thermal barrier material is between about 0.5mm and 1.5 mm in thickness when the container is sealed and pressurized, and the thermal barrier material expands to between about 1.0 mm and 3.0 mm when the container is opened and exposed to the environment.

14. A method, as claimed in Claim 2, wherein:

10 said thermal barrier material has a thickness that changes based upon changes in ambient pressure conditions.

15. A method, as claimed in Claim 2, wherein:

said thermal barrier material is made of a thermoplastic material.

16. A method, as claimed in Claim 2, wherein:

15 said thermal barrier material is elastic.

17. A method, as claimed in Claim 2, wherein:

20 said thermal barrier material is between about 0.5mm and 1.5mm in thickness when the container is sealed and pressurized, and the thermal barrier material expands to between about 1.0mm and 3.0mm when the container is opened and exposed to the environment.

18. A method, as claimed in claim 5, wherein:

cells of said cell substrate are randomly dispersed in said substrate and said cells have a plurality of different sizes.

19. A method, as claimed in Claim 5, wherein:

25 said cells are substantially uniformly dispersed in the substrate.

20. A method, as claimed in Claim 5, wherein:

said cells have different sizes.

21. A method, as claimed in Claim 5, wherein:

30 cells of said cell substrate are randomly dispersed in said substrate and said cells have a plurality of different sizes.

22. A method, as claimed in claim 5, wherein:

said cells are substantially uniformly dispersed in the substrate.

23. A method, as claimed in Claim 5, wherein:

said cells have different sizes.

24. A method of manufacturing an insulated beverage container, said method comprising the steps of:

providing a beverage container having an interior surface;

5 providing a roll of thermal barrier liner material having a gas permeable, closed cell substrate, wherein the liner equilibrates with ambient pressure conditions over a period of time;

cutting the liner to produce a cut piece of a desired length;

rolling the piece of cut liner;

10 installing the cut piece of liner in the container;

unrolling the liner to contact the interior sidewalls of the container;

filling the container with the beverage;

sealing and pressurizing the container;

15 equilibrating the liner to entrain pressurized gas within the sealed and pressurized container.

25. A method of manufacturing an insulated container, said method comprising the steps of:

providing a beverage container including a sidewall and a base connected to the sidewall;

20 providing a thermal barrier made of a sheet of a material; and

mechanically inserting the thermal barrier material in the container and deploying the liner by unrolling to contact an interior surface of the container to form an interior liner.

26. A method, as claimed in Claim 25, wherein:

25 said method further comprise inserting the thermal barrier material in an open top of the container, and then securing a top of the container to an upper portion of the sidewall.

27. A method, as claimed in Claim 25, wherein:

30 said thermal barrier material is secured by a handling device that maintains said thermal barrier material in a rolled configuration prior to inserting the material in the container.

28. A method, as claimed in Claim 25, wherein:

a closed cell substrate is incorporated in the thermal barrier material, and the thermal barrier material is gas permeable such that voids in the closed cell substrate equilibrate with ambient pressure conditions and such voids change size based on ambient pressure conditions as compared to pressure conditions in the barrier material.

5 29. A method, as claimed in Claim 25, wherein said thermal barrier material includes:

 a base material, and a plurality of microcapsules containing gas dispersed in said base material, said microcapsules changing shape based upon ambient pressure conditions wherein said microcapsules have a smaller size when placed under pressure when the
10 container is sealed and pressurized, and wherein the microcapsules expand when the container is opened and the thermal barrier liner is exposed to the environment, said thermal barrier liner having a surface in contact and adhered to an interior surface of said sidewall and said base.

 30. A method, as claimed in Claim 25, wherein said thermal barrier material
15 comprises a base material and a plurality of microcapsules containing phase change material therein, said microcapsules being dispersed in said base material, wherein said microcapsules absorb heat upon a temperature increase within the interior of the container and the phase change material changes from solid to liquid.

 31. A method, as claimed in Claim 25, wherein:
20 said thermal barrier material liner comprises at least a first layer of barrier material contacting the interior surfaces, and at least a second layer secured to said at least first layer wherein gaps are formed between the first and second layers and gas occupying the gaps.

 32. A method, as claimed in Claim 25, wherein:
25 said thermal barrier material liner comprises a composite structure, said composite structure comprising (i) a closed cell substrate having a plurality of cells defining voids, said closed cell substrate being gas permeable to allow gas to pass through the cells based upon ambient pressure changes within the interior of the container, and (ii) a plurality of microcapsules dispersed in said closed cell substrate, said plurality of microcapsules
30 including at least one of gas filled microcapsules and phase change material filled capsules.

 33. An insulated beverage container comprising:

a sidewall, a base connected to said sidewall, and a top forming an upper portion of the container;

a liner placed within said container, said liner being spaced from said sidewall thereby forming a gap between said liner and said sidewall, the open space within said container bounded by said liner defining a chamber for receiving a liquid therein, said
5 liner having an upper end secured to either an upper edge of said sidewall or said top, and said liner having an unattached lower end spaced from said base; and

an amount of gas residing within said gap thereby providing a thermal barrier to keep the liquid at a desired temperature.

10 34. A container, as claimed in Claim 33, further including:

a nucleation enhancing material incorporated on at least a portion of said liner wherein the nucleation enhancing material increases the rate of de-gassing of the liquid thereby generating an increased number of gas bubbles that are trapped within the gap which in turn increases a volume of gas in the gap.

15 35. A container, as claimed in Claim 33 wherein:

said unattached lower end of said liner curves radially inward towards a longitudinal axis of the container.

36. A container, as claimed in Claim 33, wherein:

20 said container has a cylindrical shape and said liner is disposed within said container in a concentric fashion to produce said gap in an annular shape.

37. A container, as claimed in Claim 34, wherein:

said nucleation enhancing material is incorporated on the unattached end of said liner.

38. A method of insulating a beverage in a container, said method comprising:

25 providing a beverage container having a sidewall, a top, a base, and a liner disposed within the container and spaced from an interior surface of the sidewall thereby forming a gap, said liner having a first end attached to either said top or base of the container, and the liner having a second unattached end that extends substantially along a height of the container and is spaced from the other of the top or base of the container;

30 filling the container with the beverage;

opening the container to expose the beverage the air;

tipping the container from an upright position to a tipped position;

exposing the unattached end of the liner to the air; and

returning the container to the upright position wherein an increased amount of gas is trapped within the gap thereby increasing a gas column height in the gap.

39. A method, as claimed in Claim 38, further including:

5 providing a nucleation enhancing material on said liner wherein said nucleation enhancing material increases the rate of de-gassing of the beverage thereby generating an increased number of gas bubbles that are trapped within the gap which in turn increases a volume of gas in the gap.

40. A method, as claimed in Claim 38, wherein:

10 said container is cylindrical shaped, and said liner is placed concentrically within the container thereby forming an annular gap between the container and the liner.

41. A method, as claimed in Claim 39, wherein:

said nucleation enhancing material is applied to said liner as by spray coating.

42. An insulated beverage container comprising:

15 a sidewall, a base connected to said sidewall, and a top forming an upper portion of the container;

a liner placed within said container, said liner being made of a mesh material and said liner having an upper end secured to said top and said liner having an unattached lower end spaced from said base;

said liner material having a pattern of openings formed therein;

20 wherein gas dissolved in said beverage is nucleated to release bubbles that attach to said liner forming a layer of bubbles on at least one surface of said liner, and said liner and said bubbles thereby providing a thermal barrier to keep the beverage at a desired temperature.

43. An insulated beverage, as claimed in claim 42, further including:

25 a widget placed in said container, said widget including an outer shell covering a hollow interior, an opening formed in said outer shell, and an amount of the beverage in the outer shell.

44. An insulated beverage, as claimed in claim 42, wherein:

30 said liner is spaced from said sidewall thereby forming an annular gap between said sidewall and said liner, and wherein bubbles rise within the annular gap and attach to the liner.

45. An insulated beverage, as claimed in claim 42, wherein:

said liner has an upper end secured between a neck of said sidewall and a chuck wall of said top, and said liner having an unattached lower end spaced from said base;

46. An insulated beverage, as claimed in claim 42, wherein: said liner is attached to said sidewall leaving one face of said liner exposed within said container.

5 47. An insulated beverage, as claimed in claim 42, wherein: said liner incorporates enhanced nucleation material selected from at least one of woven fibers, open cell foam, and a stretched film with slits formed therein.

48. A method of insulating a beverage in a container, said method comprising: providing a beverage container having a sidewall, a top, a base, and a liner
10 disposed within the container and being made from a mesh material, said container having a beverage therein and an amount of gas dissolved in the beverage causing the beverage to be stored under pressure;

opening the container to expose the beverage the air;

increasing a rate of nucleation in the beverage to produce a quantity of bubbles;

15 and

attaching the bubbles to said liner forming a layer of bubbles on a surface of the liner thereby creating a thermal barrier to maintain the beverage at a desired temperature;

49. A method, as claimed in claim 48, further including:

20 providing a widget in said container, said widget having a shell, an opening formed in the shell, and a quantity of the beverage and gas in the widget wherein the opening of the container causes beverage to be forced out of the widget thereby enhancing nucleation to increase rate of bubbles forming in the beverage.

50. A method, as claimed in claim 48, further including:

25 enhancing the capability of the liner to nucleate gas in the beverage by altering a surface characteristic of an exposed surface of the liner upon which the bubbles attach, said enhancing including at least one of (i) providing a textured or roughened liner surface and (ii) modifying a surface tension of the liner by corona discharge or by flame treatment.

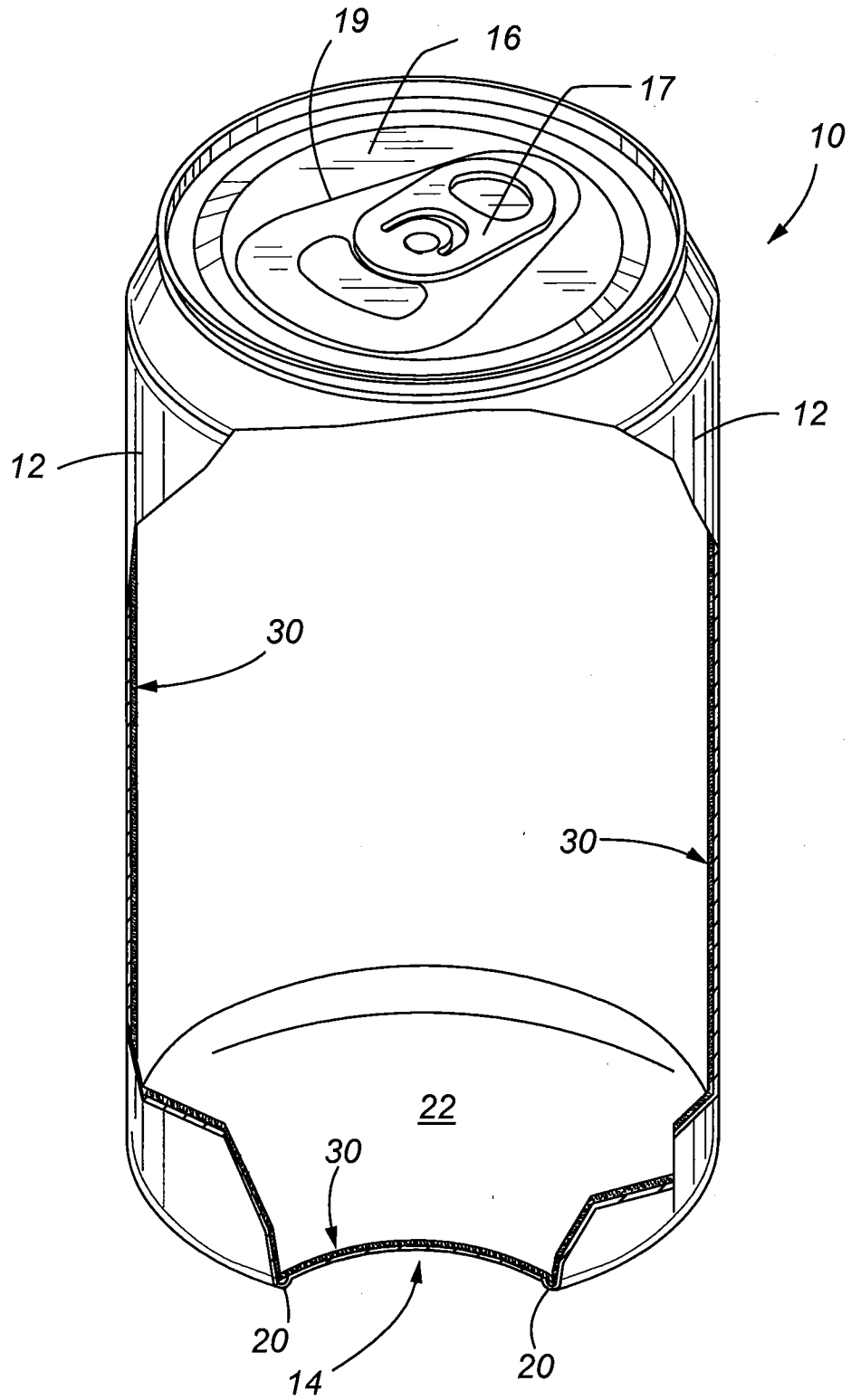


Fig. 1

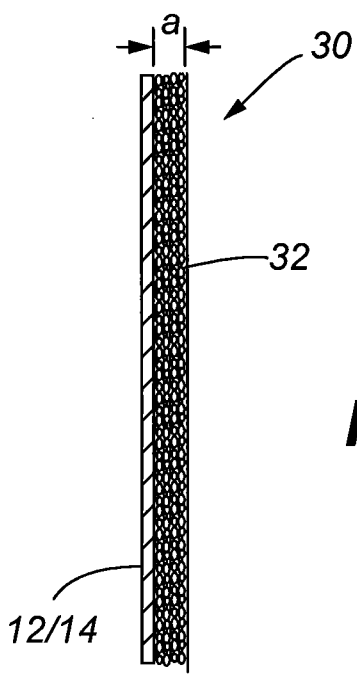


Fig. 2

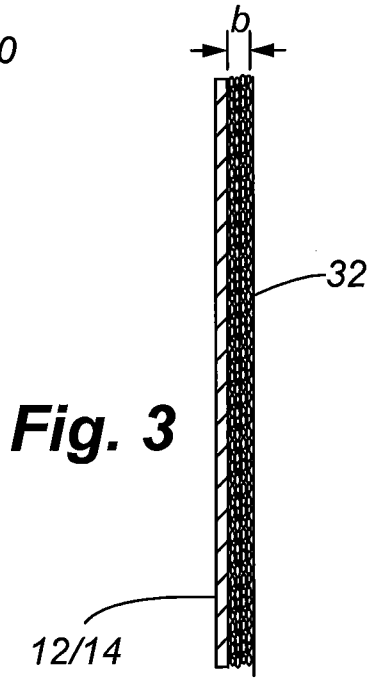


Fig. 3

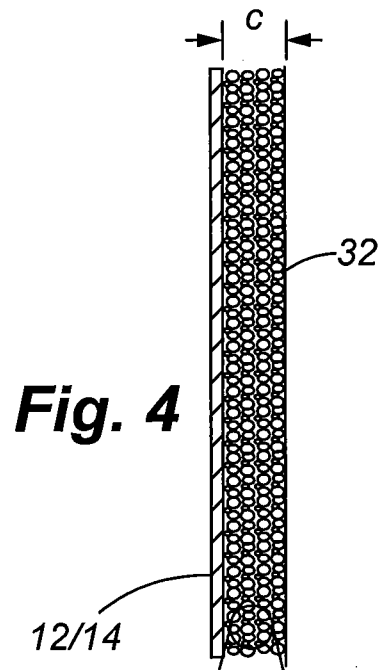


Fig. 4

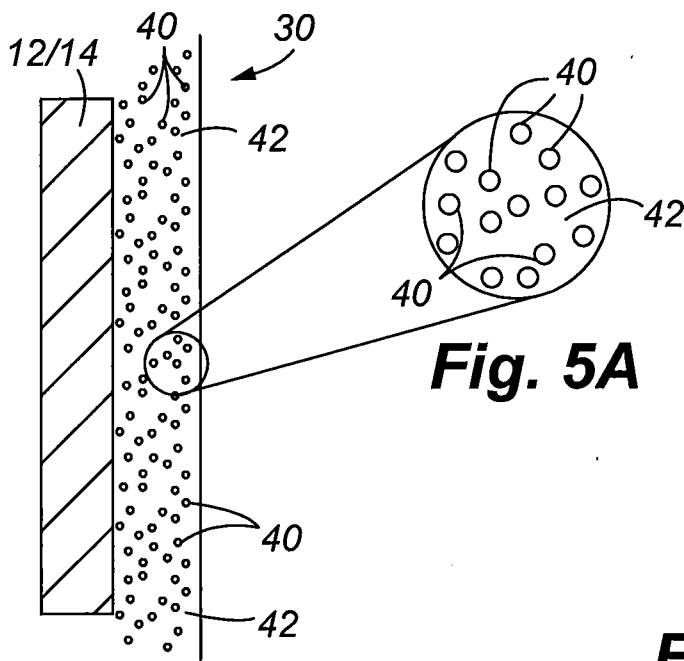


Fig. 5

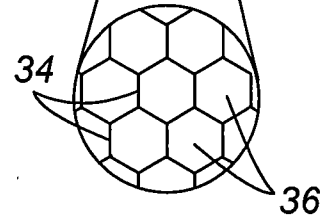


Fig. 4A

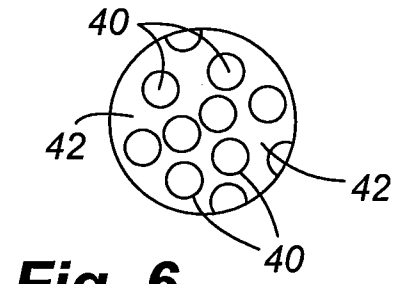


Fig. 6

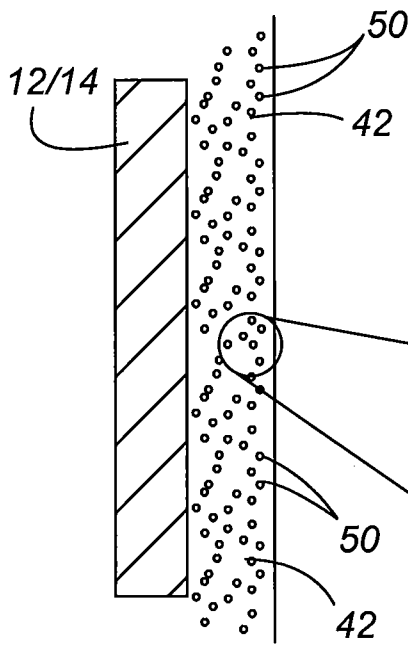


Fig. 7

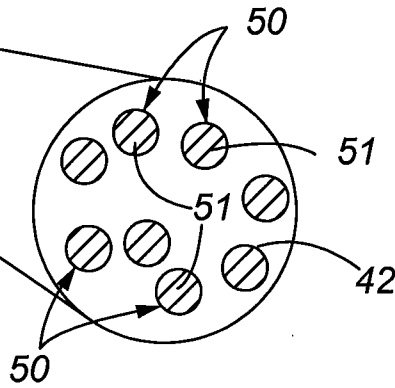


Fig. 7A

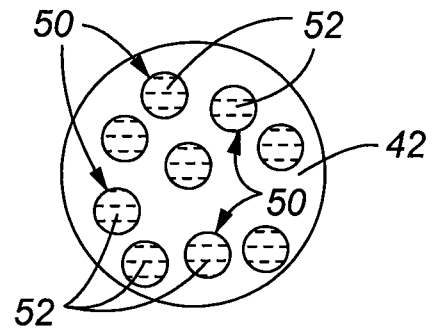


Fig. 8

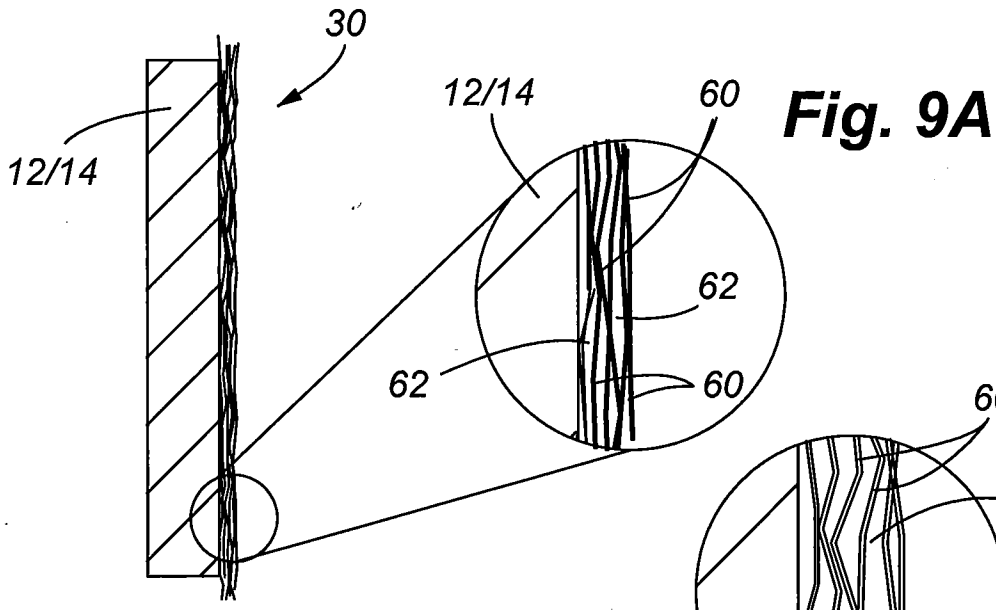


Fig. 9

Fig. 9A

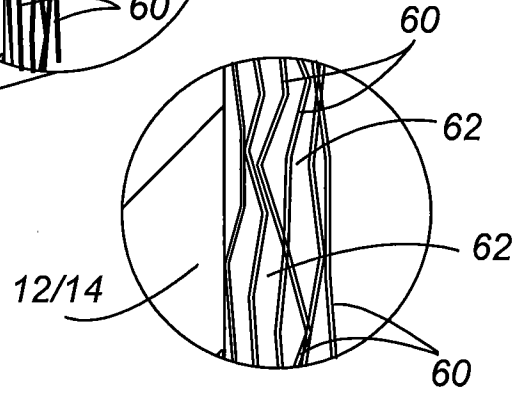


Fig. 10

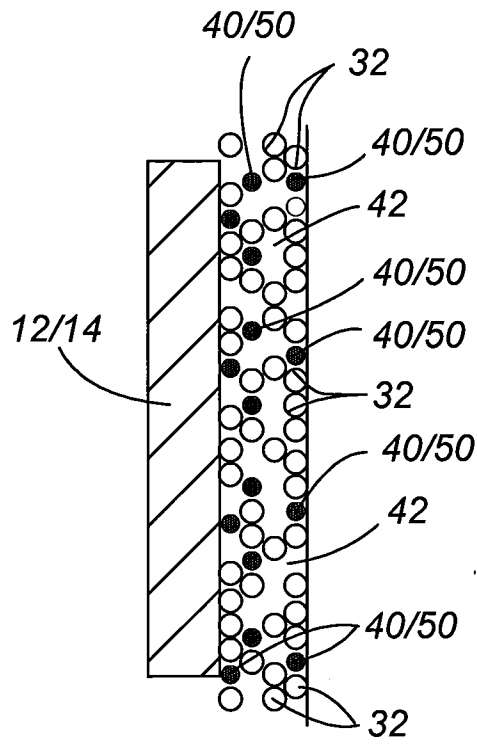


Fig. 11

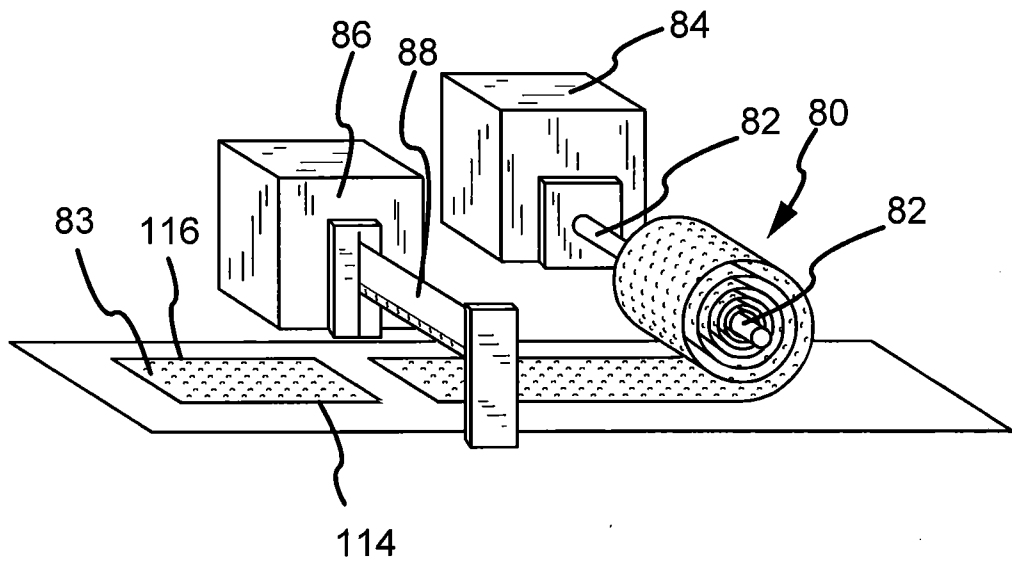


Fig.12

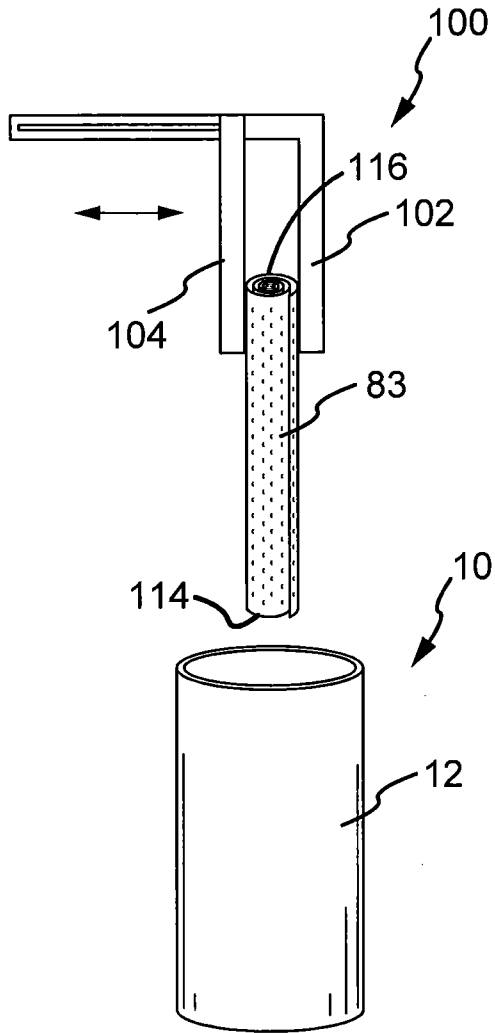


FIG. 13

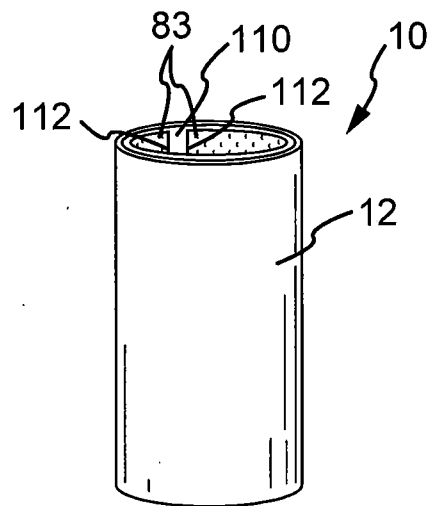


FIG. 14

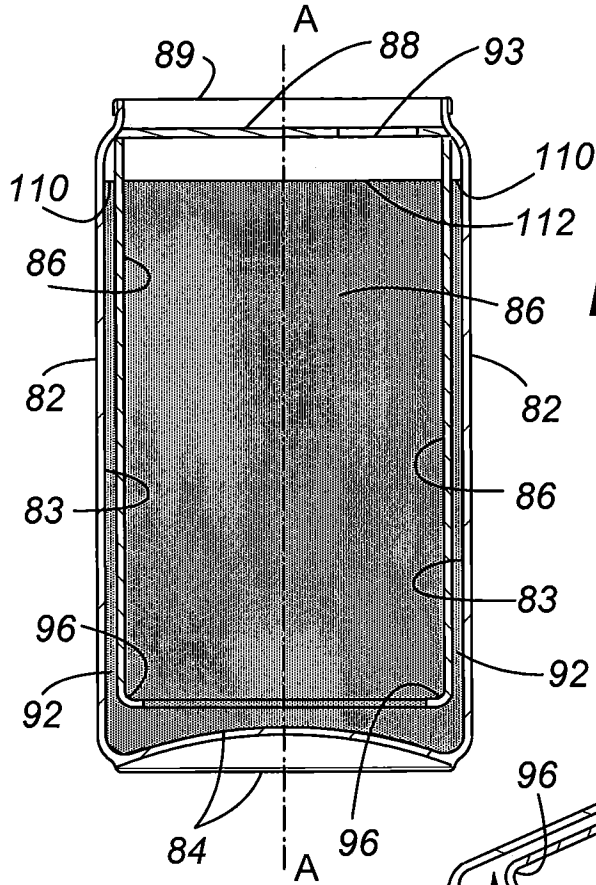


Fig. 15

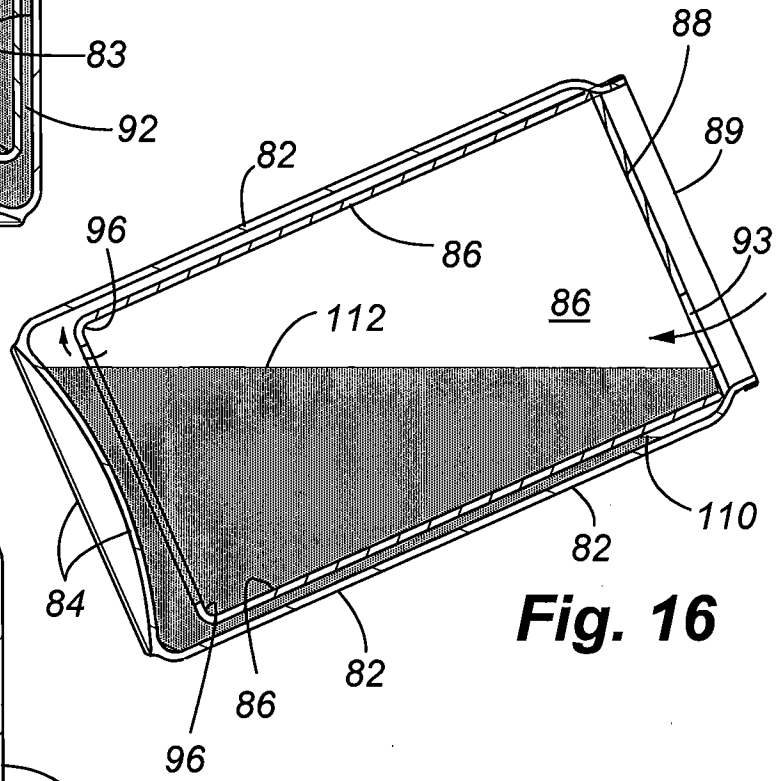


Fig. 16

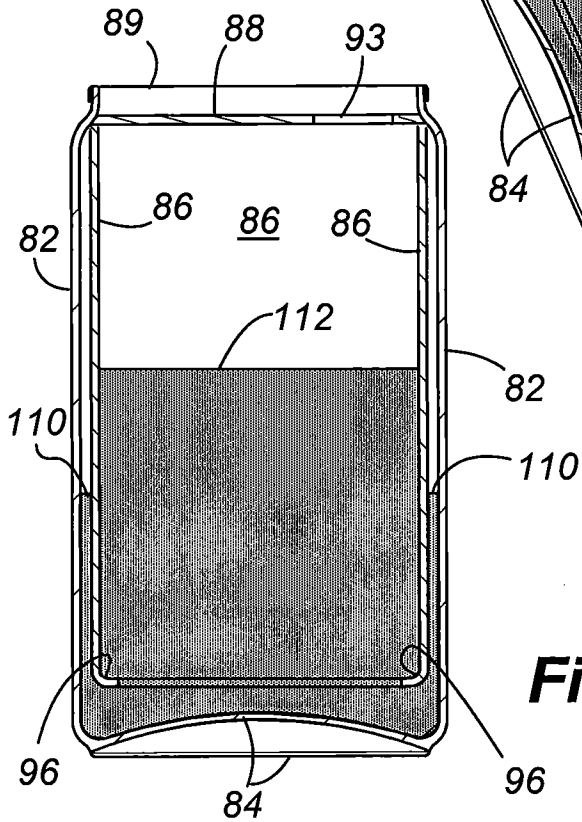


Fig. 17

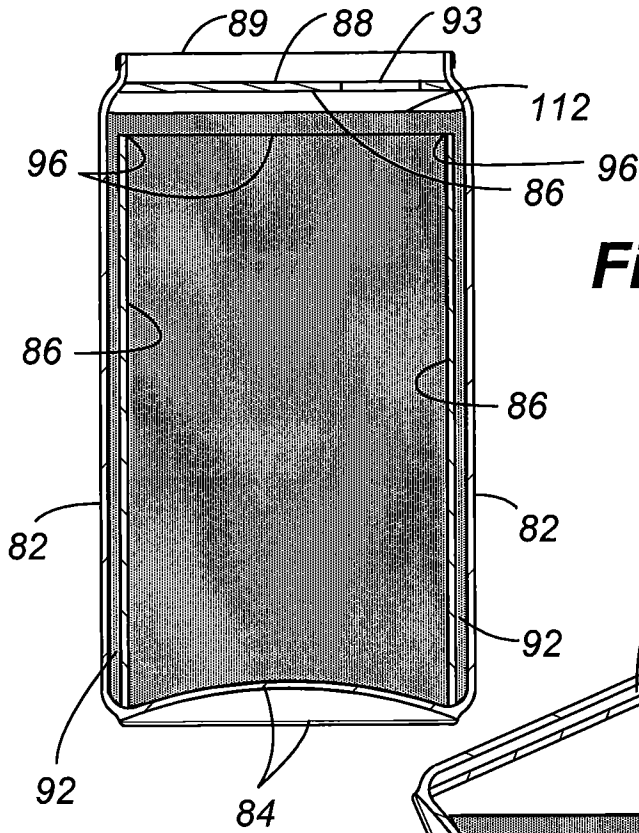


Fig. 18

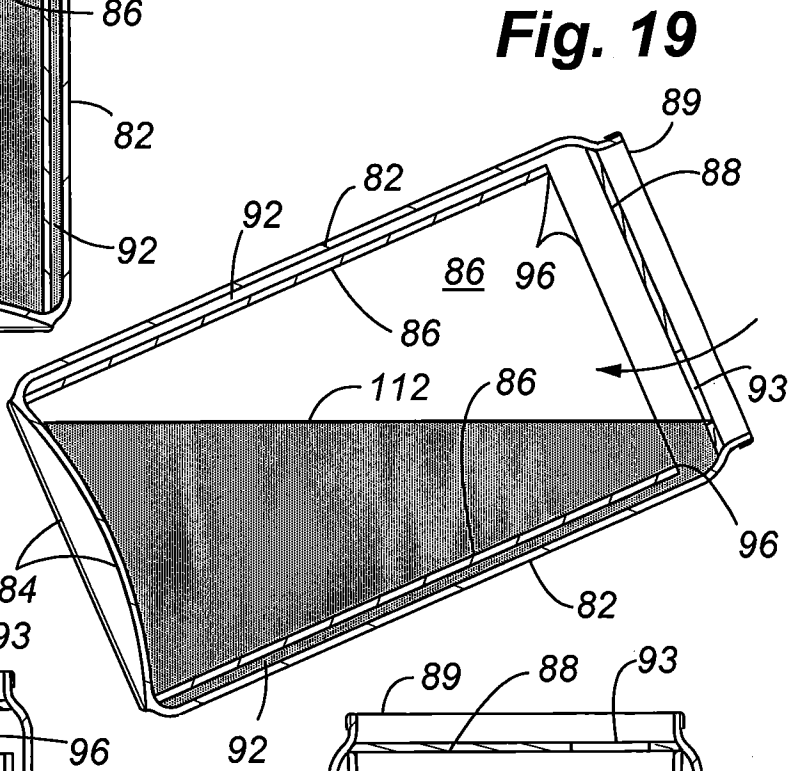


Fig. 19

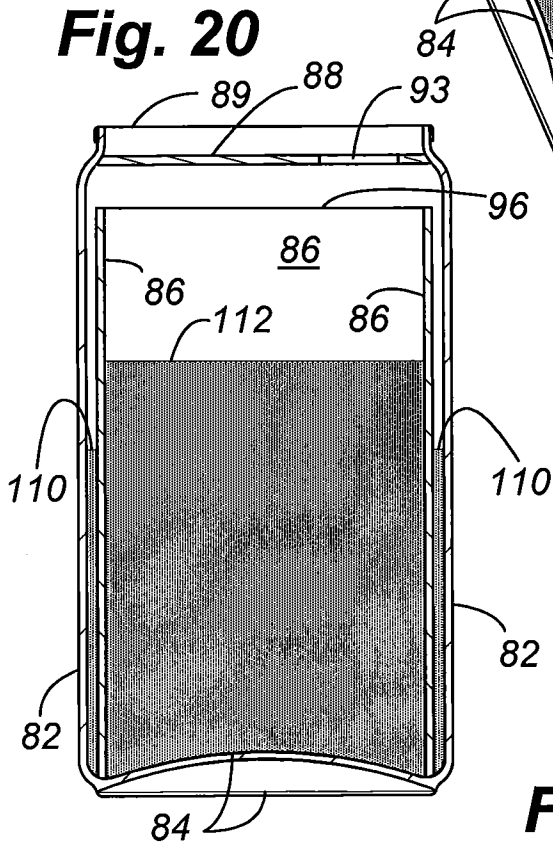


Fig. 20

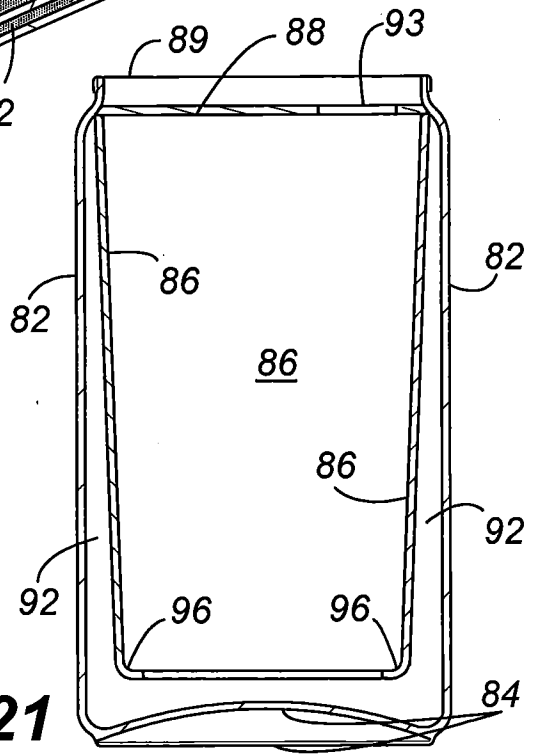


Fig. 21

Fig. 22

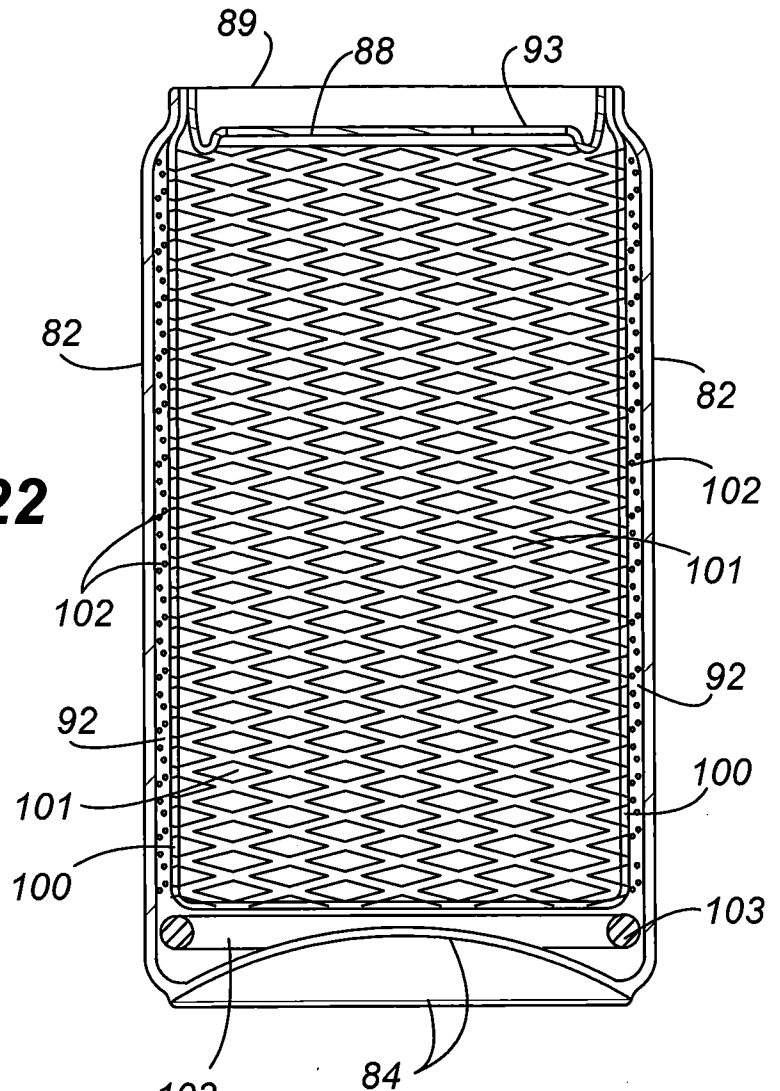
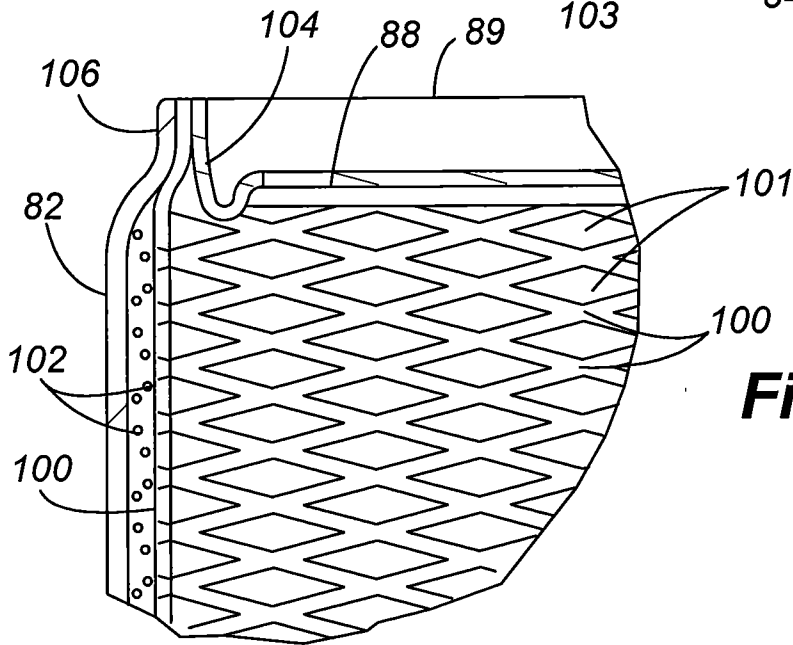


Fig. 23



INTERNATIONAL SEARCH REPORT

International application No.
PCT/US 08/79844

A. CLASSIFICATION OF SUBJECT MATTER
 IPC(8) - A47J 39/00,41/00; B65D 81/38,83/72 (2008.04)
 USPC - 220/592.17
 According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED
 Minimum documentation searched (classification system followed by classification symbols)
 USPC: 220/592.17

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched
 USPC: 220/592.01,495.03,23.9.62.11,62.12,62.15,62.22,906,592.09,592.1,592.05,592.17,592.2,592.25,592.26 - term limited - see search terms below -

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)
 PubWest (PGPB,USPT,EPAB,JPAB), Google
 Search Terms: beverage, can, thermal, temperature, barrier, isolat, liner, roll, pressure, void, cavity, microcapsule, foam, phase change

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 2006/0186125 A1 (Tew) 24 August 2006 (24.08.2006), para [0017]-[0022], [0048]-[0076], Fig 1-8	1-32
Y	US 5,952,068 A (Neale et al.) 14 September 1999 (14.09.1999), col 2, ln 3 to col 3, ln 9, col 5, ln 41 to col 6, ln 16	1-32
Y	US 5,499,460 A (Bryant et al.) 19 March 1996 (19.03.1996), col 3, ln 56 to col 4, ln 28	7,9,30,32

Further documents are listed in the continuation of Box C.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"E" earlier application or patent but published on or after the international filing date	"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
"O" document referring to an oral disclosure, use, exhibition or other means	"&" document member of the same patent family
"P" document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search 29 January 2009 (29.01.2009)	Date of mailing of the international search report 06 FEB 2009
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Name and mailing address of the ISA/US Mail Stop PCT, Attn: ISA/US, Commissioner for Patents P.O. Box 1450, Alexandria, Virginia 22313-1450 Facsimile No. 571-273-3201	Authorized officer: Lee W. Young PCT Helpdesk: 571-272-4300 PCT OSP: 571-272-7774
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INTERNATIONAL SEARCH REPORT

International application No.
PCT/US 08/79844

Box No. II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:

2. Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:

3. Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box No. III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:
This application contains the following inventions or groups of inventions which are not so linked as to form a single general inventive concept under PCT Rule 13.1. In order for all inventions to be examined, the appropriate additional examination fees must be paid.

- Group 1, claims 1-32, drawn to a beverage container having a thermal sheet barrier attached to the inside of the container.
- Group 2, claims 33-41, drawn to a beverage container having a gaseous thermal barrier in a gap between a liner and the inside of the container.
- Group 3, claims 42-50, drawn to a beverage container having a thermal barrier made up of a layer of bubbles formed on a mesh liner.

The inventions listed as Groups 1-3 do not relate to a single general inventive concept under PCT Rule 13.1 because, under PCT Rule 13.2, they lack the same or corresponding special technical features for the following reasons:

--- Continued in the extra sheets at the end of this form ---

1. As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. As all searchable claims could be searched without effort justifying additional fees, this Authority did not invite payment of additional fees.
3. As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:

4. No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:
1-32

Remark on Protest

- The additional search fees were accompanied by the applicant's protest and, where applicable, the payment of a protest fee.
- The additional search fees were accompanied by the applicant's protest but the applicable protest fee was not paid within the time limit specified in the invitation.
- No protest accompanied the payment of additional search fees.

INTERNATIONAL SEARCH REPORT
Information on patent family members

International application No.

PCT/US 08/79844

Continued from Box III.

Groups 2 and 3 do not include the inventive concept of providing a thermal barrier made of a sheet of a material and mechanically inserting the thermal barrier material in the container and deploying the liner by unrolling to contact an interior surface of the container to form an interior liner, as required by Group 1.

Groups 1 and 3 do not include the inventive concept of a liner placed within said container, said liner being spaced from said sidewall thereby forming a gap between said liner and said sidewall, the open space within said container bounded by said liner defining a chamber for receiving a liquid therein, said liner having an upper end secured to either an upper edge of said sidewall or said top, and said liner having an unattached lower end spaced from said base; and an amount of gas residing within said gap, as required by Group 2.

Groups 1 and 2 do not include the inventive concept of a liner placed within said container, said liner being made of a mesh material and said liner having an upper end secured to said top and said liner having an unattached lower end spaced from said base; said liner material having a pattern of openings formed therein; wherein gas dissolved in said beverage is nucleated to release bubbles that attach to said liner forming a layer of bubbles on at least one surface of said liner, as required by Group 3.

Groups 1-3 share the technical feature of a thermal barrier liner in a beverage container. However, this shared technical feature does not represent a contribution over the prior art of US 6,474,498 B1 (Markham) (05 November 2002), which teaches a thermal barrier for a beverage container in the form of a liner (Abstract, FIG. 1). As the above thermal barrier liner in a beverage container was known at the time, as evidenced by the teaching of Markham, this cannot be considered a special technical feature that would otherwise unify the groups. Groups 1-3 therefore lack unity under PCT Rule 13 because they do not share a same or corresponding special technical feature.