April 19, 1938. F. X. MALOCSAY 2,114,804

METHOD OF MAKING AND APPLYING CIGAR WRAPPERS

Original Filed April 21, 1936 2 Sheets-Sheet 1

Fig.1.

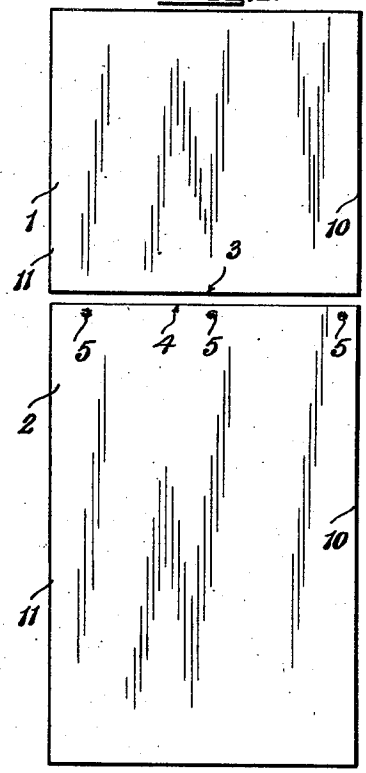


Fig.2.

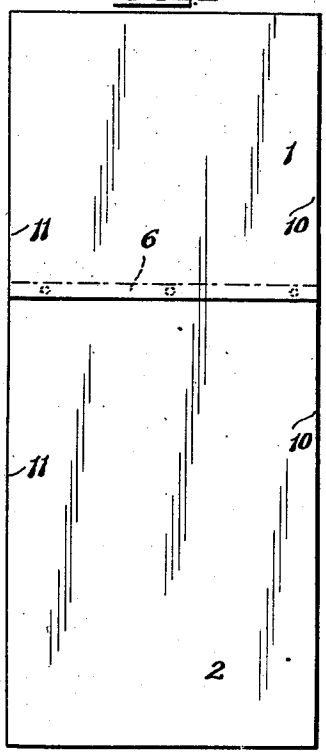


Fig.3.

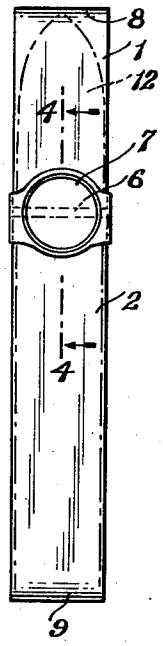


Fig.4.

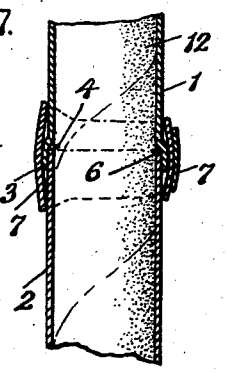


Fig.5.

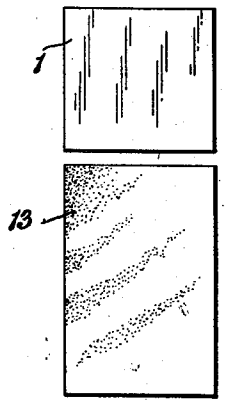


Fig.6.

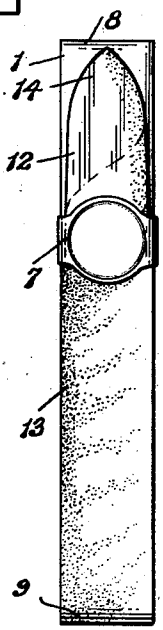
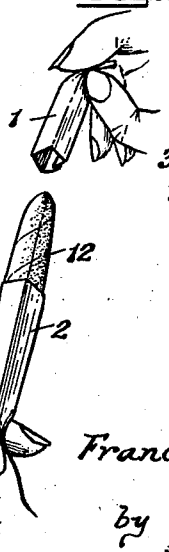


Fig.7.



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April 19, 1938. F. X. MALOCSAY 2,114,804

METHOD OF MAKING AND APPLYING CIGAR WRAPPERS

Original Filed April 21, 1936 2 Sheets-Sheet 2

Fig. 8.

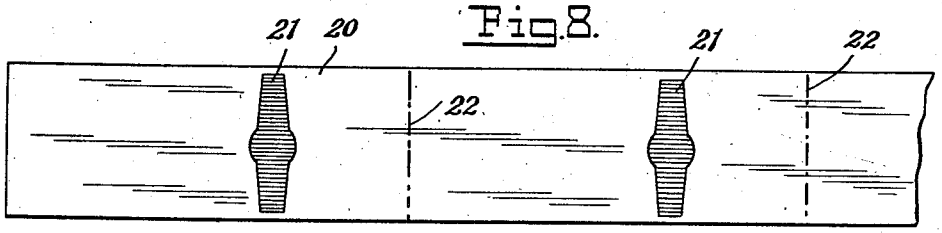


Fig. 9.

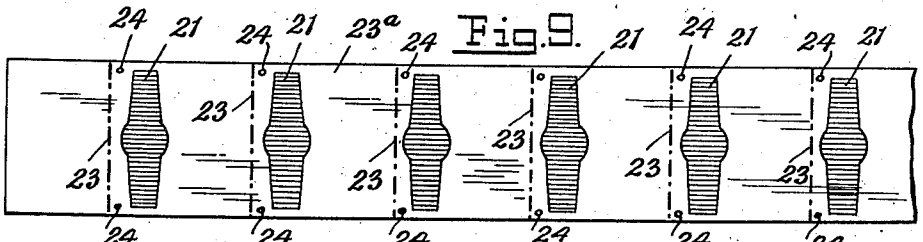


Fig. 10.

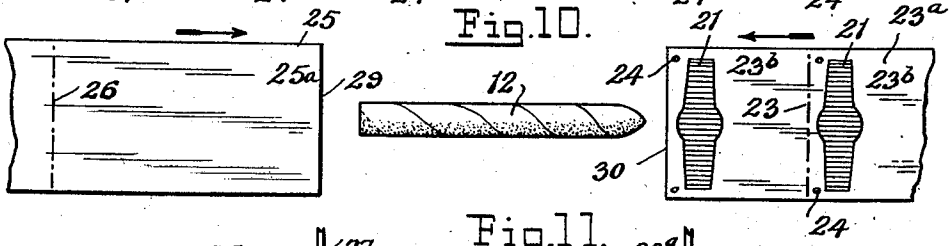


Fig. 11.

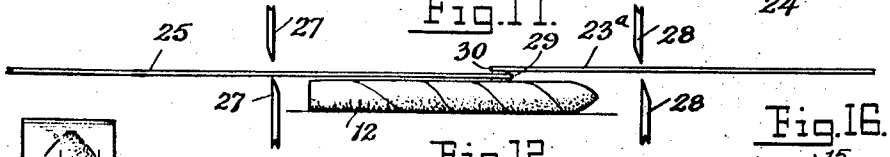


Fig. 16.

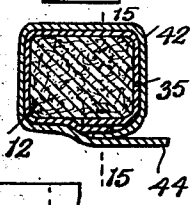


Fig. 13.

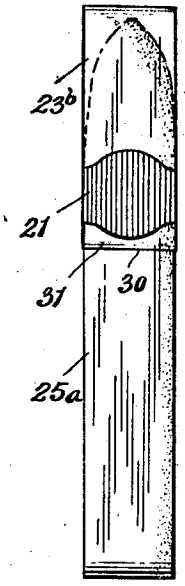


Fig. 12.

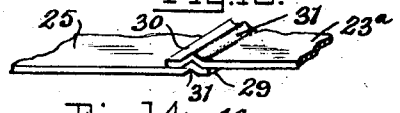


Fig. 14.

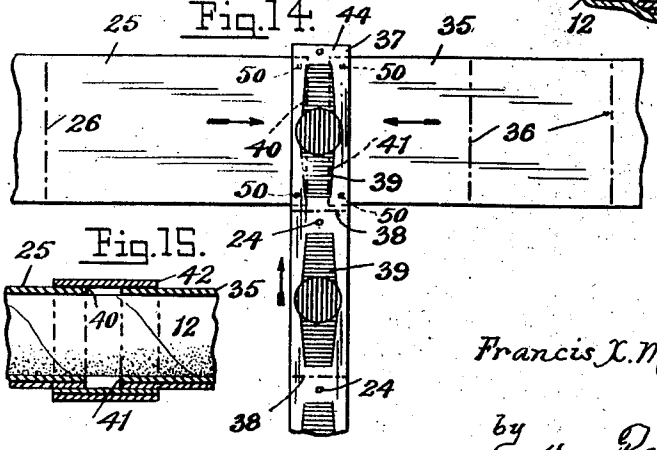


Fig. 15.

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2,114,804

METHOD OF MAKING AND APPLYING CIGAR WRAPPERS

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Original application April 21, 1936, Serial No. 75,580. Divided and this application August 18, 1936, Serial No. 96,584

9 Claims. (Cl. 93—1)

This invention relates to wrappers or enclosures for cigars and similar articles and particularly to methods of making the same. This application is a division of my co-pending application, Serial No. 75,580, filed April 21st, 1936.

At the present time, cigars are usually wrapped or enclosed in transparent wrappers or enclosures, such wrappers or enclosures being generally composed of the clear, transparent sheet material widely known and sold under the trade name of "Cellophane" and also under various other trade designations. This form of wrapper usually consists of a single sheet sufficiently large enough to completely enclose the cigar and protect it while being boxed, carried or handled. In addition to the form of enclosing wrapper just described, each cigar is usually banded. In some cases, the cigar band is located on the inside of the "Cellophane" wrapper. In other cases it is located on the outside of the wrapper. Efforts have also been made, with more or less success, to print the representation of a cigar band directly upon the "Cellophane" wrapper so that the wrapped cigar presents the appearance of being enclosed in a "Cellophane" wrapper and surrounded by a separate cigar band.

While the enclosure of a cigar in a "Cellophane" wrapper has been found advantageous in many respects, various obstacles and objections have arisen with the result that much time and effort has been expended by the trade to produce a more satisfactory enclosure. For example, experts in the tobacco industry have declared that the action of light upon a cigar materially affects the tobacco thereof and seriously impairs its quality, and accordingly have suggested that cigars be wrapped in opaque material rather than in "Cellophane" of the clear transparent variety. Some consumers of cigars have objected to the use of "Cellophane" wrappers on the ground that the "Cellophane" wrapper is difficult to tear off or remove. This has caused some manufacturers to provide the wrappers with tearing tabs and weakened points on the wrapper intended to aid in the removal of the wrapper.

In cases where the cigar band representations have been printed directly upon the wrappers, most manufacturers have found the cost of these wrappers prohibitive, since the wrappers are printed in continuous strip form and the representations of the bands are printed so widely apart upon the strip that the printer's output for a given time is exceedingly low, thus greatly increasing production cost to an almost prohibitive extent.

The object of the present invention therefore, is to provide methods of making and applying several forms of cigar wrappers in which the objections herein set forth are obviated. That is to say, with the improved wrappers, a simplified means of removal is provided whereby the wrappers may be easily removed from the cigar; the wrapper may easily be composed of two or more independent sections of different material, one of which covers the consumable portion of the cigar and may be opaque thereby protecting the consumable part of the body of the cigar from the effects of light, and the wrappers may be so printed with cigar band representations that the said representations will be closely spaced on the "Cellophane" strip during the printing operation whereby the printer's output will be greatly increased and the cost of the wrappers thereby materially lessened.

A further object of the invention is to provide a method of making and applying a wrapper bearing the printed representation of a cigar band arranged and disposed on a relatively small section of the wrapper separable and independent from the remainder of the wrapper whereby the amount of printed "Cellophane" which the cigar manufacturer must keep in stock is thereby materially reduced.

More particularly, the invention contemplates the provision of a cigar wrapper arranged in at least two separate parts, with edge portions thereof overlapped to any predetermined amount on a line extending transversely of the cigar. The two separate parts of the wrapper may be of similar or of different materials whereby the numerous advantageous results hereafter set forth are attained. The invention resides in the provision of improved methods by which these wrappers can be speedily and economically made and applied, preferably by automatic machinery comparable with, if not more effective than that which is in use for making the conventional kinds of wrappers and applying the same about the cigars.

In the accompanying drawings wherein several embodiments of the invention are shown, Fig. 1 is a face view of two wrapper sections which cooperate in the formation of a cigar-enclosing wrapper; Fig. 2 is a view of the same elements, showing how they may be overlapped before their application to a cigar; Fig. 3 is a face view of a cigar enclosed in a wrapper composed of the elements shown in Figs. 1 and 2 with a cigar band applied over and concealing the joint between the wrapper elements; Fig. 4 is a sectional view

on the line 4—4 of Fig. 3, looking in the direction of the arrows; Fig. 5 is a face view of two wrapper elements, the smaller of which is composed of transparent material and the larger of opaque material; Fig. 6 is a face view of a cigar enclosed in a wrapper composed of the two elements shown in Fig. 5; Fig. 7 is a perspective view, illustrating how the smoker may conveniently remove the wrapper; Fig. 8 is a plan view of a strip of "Cellophane" or similar transparent material indicating the manner in which the printed band representations are widely spaced apart when single-piece wrappers are produced according to present day practice; Fig. 9 is a plan view of a similar strip showing how the printed band representations are closely spaced when my improved two-section wrapper is being produced; Fig. 10 is a diagrammatic view indicating how the two sections of a wrapper may be brought together in preparation for application about a cigar; Fig. 11 is a side view of the elements shown in Fig. 10 showing the wrapper sections brought together and slightly overlapped and ready to be severed from their respective strips; Fig. 12 is a perspective view of portions of the two wrapper sections, showing their overlapped parts held together by a transversely extending crimping; Fig. 13 is a face view of a cigar enclosed in a wrapper produced in accordance with the method disclosed in Figs. 9 to 12 inclusive; Fig. 14 is a diagrammatic view showing the method of making a wrapper composed of two sections of transparent material over which a transversely extending narrow transparent strip bearing a printed band representation is attached; Fig. 15 is a longitudinal sectional view through a portion of a cigar bearing a wrapper and band construction according to the suggestion of Fig. 14, the view being taken on the line 15—15 of Fig. 16, and Fig. 16 is a transverse sectional view through the structure of Fig. 15.

In producing a cigar wrapper of the character herein described, I contemplate utilizing two or more wrapper sections whereby smaller pieces of sheet material, co-operating to form a complete wrapper, are used.

Referring first to the structure shown in Figs. 1 to 4 inclusive. There 1 indicates the smaller of the two wrapper sections employed, the larger thereof being indicated at 2. In this embodiment of the invention both of the sections 1 and 2 are indicated as being composed of transparent sheet material generally known as "Cellophane" or by other trade designations. In the application of the two-section wrapper to the cigar, the wrapper sections are first brought together to cause their edges 3 and 4 to either abut or else to overlap to a greater or lesser extent, as illustrated at 6. Preferably, although not necessarily, some means is employed for holding the overlapped portions of the two wrapper sections together. For this purpose, spaced dots 5 of suitable adhesive might be employed. When the two wrapper sections are thus placed together, substantially as shown in Fig. 2, the wrapper so produced may then be applied about the cigar 12 in the conventional way by any of the wrapping machines now used for this purpose or by any suitable automatic wrapping machinery. When the wrapper is placed about the cigar, the longitudinal edges 10 and 11 of the wrapper overlap as usual and are secured together in the conventional manner, such as for example by either glue or by "heat-sealing". The ends of the wrapper sections now projecting beyond the opposite ends of the cigar are next compressed and folded down at 8 and 9, and the enclosing of the cigar is complete.

The relative sizes of the two wrapper sections 1 and 2 are such that the meeting or joinder line such as the overlap 6 extends transversely of the cigar at normal cigar band position. Therefore, when the cigar band 7 is applied about the cigar and over the wrapper, it surrounds the cigar directly over the joint 6 and completely conceals the same so that the wrapper cannot be distinguished from the usual one-piece wrapper. The wrapper when applied to the cigar thus consists of two tubular sections having their meeting edges telescopically overlapping preferably, although not necessarily, at cigar-band position. The removal of the wrapper is extremely simple and is illustrated in Fig. 7. To remove the wrapper, the projecting ends of the wrapper sections are held in the hands and pulled in opposite directions, preferably after the band is removed. One of the sections will easily pull off the cigar in a direction axially of the cigar, thus permitting the second section to easily slide off.

The means employed for holding the overlapping portions of the wrapper sections together, such as the glue dots 5, and other means to be hereinafter described, should be such as to hold the two wrapper sections together during the application of the wrapper to the cigar and during boxing and normal handling of the cigar, yet permitting the two halves of the wrapper to be easily separated in the manner indicated in Fig. 7 when the smoker wishes to remove the wrapper. In fact, a snugly applied cigar band located over the joint between the wrapper sections is quite sufficient to hold the wrapper in position and prevent separation of the wrapper sections without the use of the glue dots or other means for holding the two-wrapper sections together.

In the embodiment of the invention shown in Figs. 5 and 6 is shown a wrapper composed of two sections 1 and 13. The section 1 is similar to that described with respect to Figs. 1, 2 and 3 and is preferably composed of transparent "Cellophane" or other similar sheet material. The larger section 13 is preferably composed of an opaque sheet material, such as a foil or the like. After the two sections 1 and 13 are applied to the cigar in the manner similar to that described in respect to the sections 1 and 2, the cigar band 7 is applied over the joint between the two sections and conceals the same. It will be seen that the greater portion of the cigar, and particularly the consumable portion thereof, is enclosed in the opaque portion 13 of the wrapper and is thus protected from the effects of light, while the non-consumable portion 14 of the cigar, including the tip portion which enters the mouth of the smoker is enclosed in the transparent or "Cellophane" portion 1 of the wrapper, so that a sufficient portion of the cigar is thus exposed to the view of the purchaser who can select his cigar in the usual manner by the shade of the tobacco.

At the present time, efforts are being made to produce a unitary cigar wrapper and band by forming a printed reproduction of the band directly upon a wrapper-shaped section of transparent material such as "Cellophane", which when wrapped about a cigar presents the appearance of a wrapper and separate band. Such wrappers are usually produced from a lengthy "Cellophane" strip, a part of which is shown at 20 in Fig. 8, and which is printed with the cigar band representations 21 widely spaced apart so that one of said representations will appear at

the proper location on each wrapper when it is cut from the strip. The lines of severance of the strip, to divide it into wrapper-shaped sections, are indicated at 22. Due to the relatively great distance between each printed band on the strip (each wrapper being approximately 6⅞ inches long for a six inch cigar), a six pound roll of "Cellophane" of the thickness and width generally employed for cigar wrappers, receives only approximately 6,600 printed band impressions. Therefore the printing of these wrappers is relatively slow, and accordingly expensive.

In Fig. 9 is shown a "Cellophane" strip 23*a* also bearing printed band representations 21. This strip is arranged to be severed into wrapper sections to be applied in the manner of section 1 shown in Figs. 1 to 7, or as section 23*b* in Fig. 13. Since these small wrapper sections enclose a portion only of the cigar, the printed band representations are accordingly placed relatively close together (approximately 2¼ inches apart for the six inch cigar) with the result that a six pound roll of "Cellophane" will produce between 19,000 and 20,000 printed band impressions, thereby greatly speeding up the printing process and accordingly reducing the cost of the wrappers considerably. Since these relatively small wrapper sections bear the printed cigar band representations, and the remaining larger portions of the wrappers are of plain or unprinted material, always easily procurable in the open market, the cigar manufacturer is not compelled to keep in stock large quantities of the "Cellophane" normally required per wrapper when single-piece printed wrappers of full size are employed. To produce the wrapper sections 23*b*, the strip 23*a* is transversely severed on the lines 23, each of the severed sections 23*b* bearing a printed band representation 21. To aid in accurate feeding of the strip and to insure severance on the lines 23, the strip may be perforated as indicated at 24 for engagement by positive feeding elements. An "electric eye" mechanism can also be used to insure accurate feeding and severing of the strip.

A method in which the wrapper sections 23*b* can be united with the co-operating sections 25*a* to form the two-part wrappers is disclosed in detail in Figs. 10 and 11. There the strip 23*a* shown in Fig. 9, and made up of the sections 23*b*, is fed by suitable feeding mechanism to the left and over a cigar 12 resting on a suitable support. The strip 25, arranged to be severed into wrapper sections 25*a* on the lines 26, is fed from the opposite end of the cigar and toward the right. Both strips are moved in the respective directions mentioned until they reach a position over the cigar with their respective edges 29 and 30 slightly overlapping as indicated in Fig. 11 or overlapping to any desired extent. For example, if edge 29 overlaps edge 30 for a considerable extent, a part of strip 25 will then extend behind the printed cigar band representation, and if the band representation is printed on the under side of strip 23*a*, as is customary in this art, a part of strip 25 will be located between the printing and the cigar and thus protect the cigar from contact with the ink used in the printing. The overlapped portions of the two strips are now joined together by any suitable means, as for example, the dots 5 of glue as shown in Fig. 1, or by a simple crimping device which applies a transverse crimp 31 across the overlapped parts of the two strips as shown in Fig. 12. While the crimping action is taking place, knives 27 and 28 sever the strips 25 and 23*a* on one of each of the lines 26 and 23 respectively, and any suitable wrapping means then wraps the two-part wrapper about the cigar. The wrapped cigar is shown in Fig. 13. Due to the transparent, glossy nature of the "Cellophane" material employed, the crimping 31 extending transversely of the cigar is scarcely noticeable and does not seriously detract from the appearance of the wrapped cigar, and in fact adds to its appearance.

In Fig. 14 another method of producing a satisfactory wrapper is disclosed. There two unprinted "Cellophane" strips 25 and 35 are fed toward one another, and preferably over the cigar to be wrapped as described with respect to the method shown in Figs. 10 and 11. A third narrower strip 37, also of "Cellophane" or similar transparent material, is fed in a direction at right angles to the direction of movement of strips 25 and 35. Strip 37 bears spaced printed band representations 39, and is being adapted to be severed on the transverse lines 38, one of the sections thus severed from strip 37 overlying the adjacent edges of the strips 25 and 35 when said strips are brought together with their adjacent edges beneath the strip 37. Said edges on the strips 25 and 35, shown at 40 and 41 respectively in Figs. 14 and 15, may be brought to a position of overlap in the manner described with respect to the edges 29 and 30 in Fig. 11, or they may be slightly spaced apart, as shown in Figs. 14 and 15, and be thus bridged by the band-bearing cut section from strip 37. Said cut section, when cut from strip 37, is adhesively or otherwise secured to the faces of strips 25 and 35, the glue dots 50 in Fig. 14 indicating such securing means, or by any suitable means. Strips 25 and 35 are cut on the transverse lines 26 and 36 respectively, and a three-part wrapper, consisting of sections severed from strips 25, 35, and 37 is thus produced.

In applying the strip 37 across the strips 25 and 35, one end 44 of each band section cut from strip 37 is caused to slightly project beyond one of the longitudinal edges of strips 25 and 37, so that when the three-part wrapper is applied about a cigar, this projecting portion 44 forms a tab, as indicated in Fig. 16 which projects sufficiently from the wrapper to enable it to be easily grasped by the fingers to strip the band section from the cigar, thereby permitting the other wrapper sections to be very easily removed.

In the structure shown in Figs. 5 and 6 the wrapper is disclosed as being composed of a small "Cellophane" section and a larger section of foil or other opaque material. In some cases it may be found desirable to make the "Cellophane" or transparent section in the form of a full sized wrapper to completely enclose the cigar. In such event, the opaque or foil section 13 will be of the shape shown in Figs. 5 and 6, and will extend from one end of the cigar to substantially cigar-band position and the larger "Cellophane" wrapper will then completely enclose the entire cigar including the opaque section 13. The general appearance of the wrapped cigar will be quite similar to that shown in Fig. 6, its disadvantage thereover being that it requires a greater amount of "Cellophane" or transparent material.

I have herein referred to the materials employed in the production of the several wrappers disclosed as "Cellophane" for convenience in enabling the character of the material most useful

for the purpose described to be easily identified. I wish to be understood however, as in no way limiting myself to the use of that specific material or any other material of similar characteristics, since a great number of different sheet materials can be satisfactorily and effectively used. I have herein described the wrapper as being composed of two sections of sheet material. It will be understood, however, that it may well be composed of additional sections in cases where saving of material, the utilization of small sections of material and various printing effects are desired.

What I claim is:

1. The method of making a cigar wrapper consisting in feeding two narrow lengthy strips of sheet material toward one another to bring their narrower ends into overlapped relationship, attaching the overlapped portions together, and severing a section from each of the strips.

2. The method of making cigar wrappers consisting in placing together at least two sections of sheet material in overlapped relationship, one of said sections bearing a printed cigar band representation and the other section being unprinted, and in overlapping the unprinted section with the printed section to an extent necessary to cause a part of the unprinted section to extend behind and become concealed by the cigar band representation.

3. The method of making cigar wrappers, consisting in feeding two narrow lengthy strips of sheet material toward one another to bring their narrower ends into overlapped relationship, crimping the overlapped portions to hold them together yet permitting them to be manually pulled apart to separate them after the wrapper has been applied to a cigar, and severing a section from each of the strips.

4. In the method of making cigar wrappers, the steps of feeding a narrow strip of transparent material bearing printed cigar band representations toward an unprinted strip of similar width until the edges of the two strips are brought into overlapped position, attaching said overlapped portions together, severing a short section from the printed strip and severing a longer section from the unprinted strip.

5. The method of making cigar wrappers consisting in the steps of feeding a pair of narrow strips of sheet material toward one another to bring their edges together, and in feeding a narrow strip of transparent sheet material bearing cigar band representations transversely across the faces of the strips and over the meeting point of the edges of said strips, adhesively attaching said narrow strip to the pair of strips, and severing a section from said narrow strip of a length substantially the width of the pair of strips.

6. The method of making cigar wrappers consisting in the steps of feeding two narrow strips of thin transparent sheet material toward one another to bring their adjacent ends into close proximity but slightly spaced apart, feeding a narrow strip of transparent material transversely across the ends of the two strips to bridge the same, attaching said narrow strip to the two first mentioned strips to cover the space between the ends of the same, and severing the applied section from the narrow strip, said section bearing the printed representation of a cigar band.

7. The method of making cigar wrappers consisting in the steps of feeding two transparent wrapper sections toward one another to bring their ends together, feeding a narrow strip of transparent material bearing printed cigar band representations transversely across the two strips and over the adjacent end portions thereof, securing said narrow strip across the end portions of the two strips, severing a section bearing a band representation from the narrow strip, said section so severed being longer than the width of the two strips to which it is attached whereby it has a part projecting beyond one of the longitudinal edges of the two strips to form a pull tab.

8. The method of making a cigar wrapper consisting in bringing two sections of flat sheet material together to cause the adjacent ends of the sections to be located at substantially what constitutes cigar band position in the conventional one-piece cigar wrapper, and in applying means for connecting and holding the two sections together, said means including a cigar band or cigar band representation.

9. In the method of making cigar wrappers, the steps of printing a plurality of spaced apart cigar band representations upon a lengthy strip of transparent wrapper sheet material, with said representations spaced apart a distance less than the length of a cigar to be wrapped, severing the strip between said representations to thereby divide the strip into wrapper sections each of which is larger than the cigar band representations but smaller than is required to wrap a cigar and each of which bears one of the printed cigar band representations, and utilizing an additional cooperating section of sheet material in conjunction with one of the printed severed sections to form a complete cigar-enclosing wrapper.

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