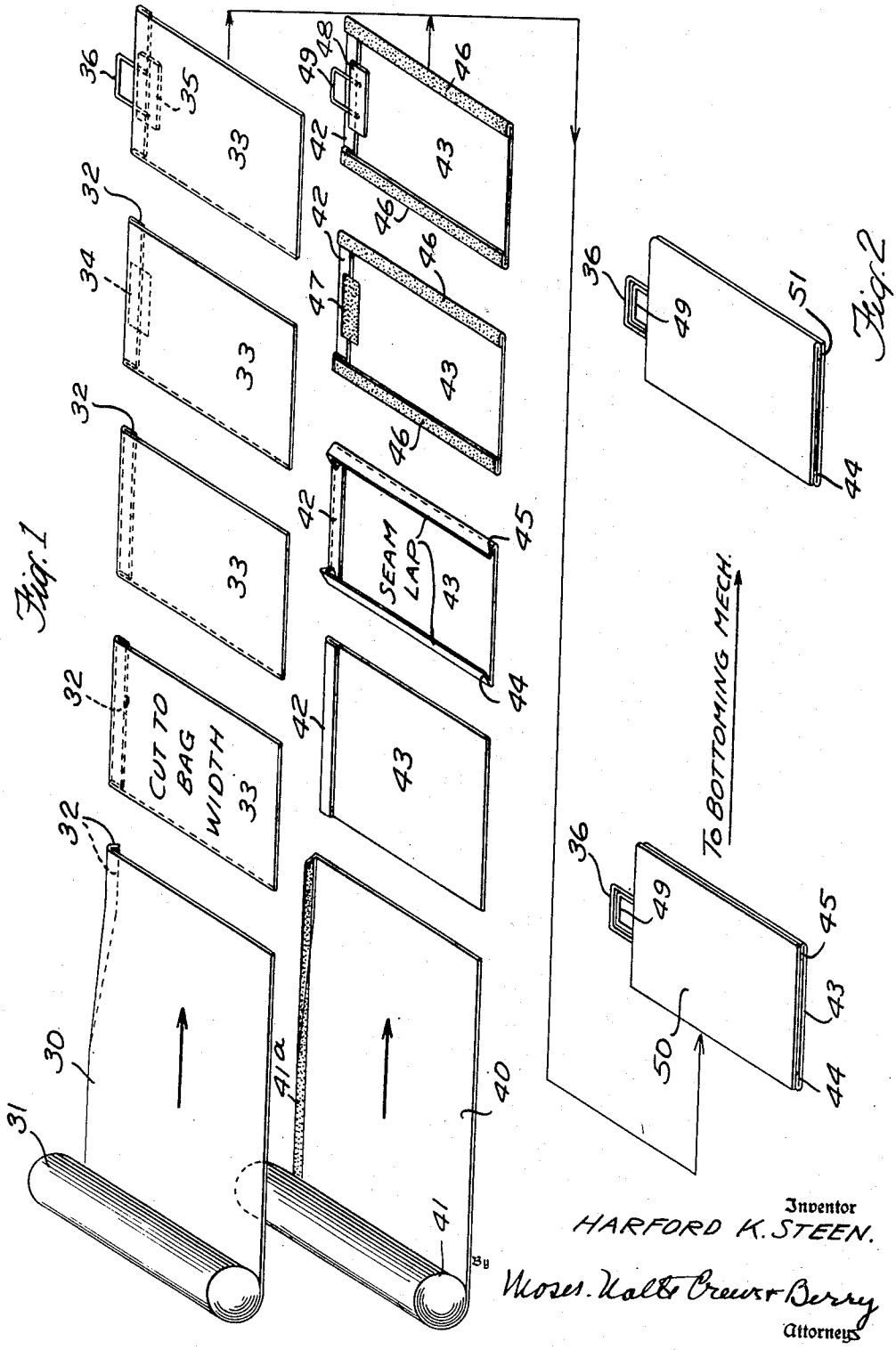
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METHOD OF MAKING SHOPPING BAG HAVING TURNED OVER EDGES

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METHOD OF MAKING SHOPPING BAG HAVING TURNED OVER EDGES

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3 Claims. (Cl. 93—35)

My present invention relates to bag making, and more particularly to methods of making handled shopping bags having the edges constituting the open ends folded over within the bags themselves, thereby adding strength to the bags and presenting a smooth edge at the opening. It has previously been proposed to turn in the top edge of the otherwise finished bag by hand as in Patent 1,799,072 of March 31, 1931.

It has also been proposed to turn over the edge of the blank destined to form the mouth of the bag as a preliminary operation as in Patent 2,221,617 of November 12, 1940. However, this requires that the web first be severed into blanks before any folding operations have been performed upon them, and moreover turning the leading or advancing edge and pasting it down upon the web requires relatively complicated mechanisms. Moreover, when operations are performed upon the unsevered web, the matter of keeping exact spacing between folds or paste spots, for example, is facilitated over having to operate on the separated individual blanks.

It is therefore an object of my present invention to devise a satisfactory method of making handled shopping bags having a turned in mouth edge which will involve constituting a lateral or side edge of the web as the bag mouth edge whereby I may turn the same over by use of simplified mechanism such as stationary turning blades.

It is a still further object so to contrive the operation as to keep the blanks when cut in uninterrupted movement in a single direction, without having to stop the motion and recommence it in a different direction, i. e., so as to constitute what had been the lateral edge, the leading or trailing edge.

A still further object is to devise a method in which separate blanks may be had for the front and back sides of the bag and in which each set of blanks will move uninterruptedly in a given direction and will have performed upon them the necessary bag making operations whereupon they will be superimposed. Thereby the completed bag tube will be formed in which different kinds of papers may be used for the two bag sides and which the ordinary tubing operations—which otherwise would have to be performed while the blank is moving laterally—will be dispensed with.

Other objects will be apparent as the description proceeds and the features of novelty will be pointed out in the claims.

My invention will be best understood by reference to the following detailed description taken in connection with the annexed drawings in which

Fig. 1 is a schematic showing of the steps comprising a preferred embodiment; and

Fig. 2 shows a modification.

Referring to the drawings in detail, a web 30 is given a longitudinal movement so as to unwind from roll 31. During this movement the lateral edge destined to constitute the bag mouth is turned at 32 and pasted down beneath the web and secured in such position by the action of a paste stripe, not shown, and the web severed into a blank 33. During the continued travel of the blank in the same direction, a paste spot 34 is applied to the under side thereof after which a patch 35 bearing handle 36 is applied over such spot. Simultaneously with the movement of web 30, web 40 is likewise paid out from roll 41, an edge paste stripe 41*a* applied, and the top edge folded over to create a fold 42 whereupon the web is severed into a blank 43. Next both the leading and trailing edges are folded to constitute seam laps 44, 45 whereupon the same are given a coating of paste 46, 46 and a paste spot 47 applied at the top of the blank. Then a patch 48 bearing a handle 49 is applied over said spot thereby producing a counterpart of blank 33 whose travel has brought it in juxtaposition to blank 43. Then the two blanks 33 and 43 are superimposed, thereby making a completed bag tube 50 which is then bottomed in any desired manner.

Fig. 2 shows a modification in which one seam lap 44 is formed on the lower blank and a single seam lap 51 is formed in the upper blank.

It will be noted that the patches 35 and 48 each span the turned over edges 32 and 41*a*, respectively, although they do not extend beyond the folded edge of the web. Thereby they also aid in retaining the folded edge flaps in place.

This application is a division of my application Serial No. 289,279, filed May 22, 1952, now abandoned.

I claim:

1. The method making handled shopping bags which comprises the following steps: forwardly feeding a first web of sheet material, turning a lateral edge of said web along a line parallel to the direction of travel of the web thereby forming a flap destined to reinforce the top edge of the completed bag, severing said web into blanks destined to form one side of the bag, and continuing the forward movement of said blanks in a first line, forwardly feeding a second web of sheet material, turning a lateral edge of said web along a line parallel to the direction of travel of said second web thereby forming a flap destined to reinforce the top of a completed bag, severing said web into blanks destined to form the reverse side of the bag, attaching handles to each of said blanks adjacent said edge thereof destined to become the top of the bag, and continuing the forward movement of said last mentioned blanks in a second line forming a pair of seam laps in blanks of a pair whose members are destined to be superimposed, such laps extending at right angles to their direction of travel, applying adhesive to said laps, and superimposing corresponding blanks of said lines to form completed bag tubes and bottoming said tubes.

2. Method according to claim 1 in which said lines of movement of said blanks are substantially parallel.

3. The method according to claim 1 in which said handles are secured to the blanks by means of patches which span the edge of said reinforcing flap but do not extend beyond the folded edge of the web.

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