H. DE ESCOBALES.

PRODUCTION OF PACKAGES.

APPLICATION FILED AUG. 22, 1918.

1,381,087.

Patented June 7, 1921.

2 SHEETS—SHEET 1.

Fig. 1.

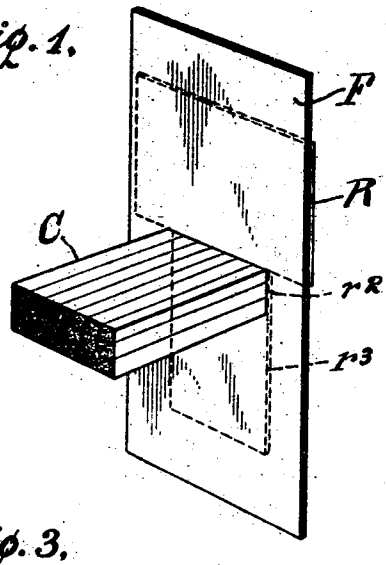


Fig. 2.

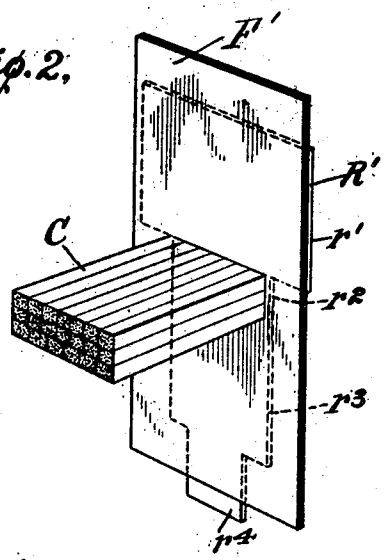


Fig. 3.

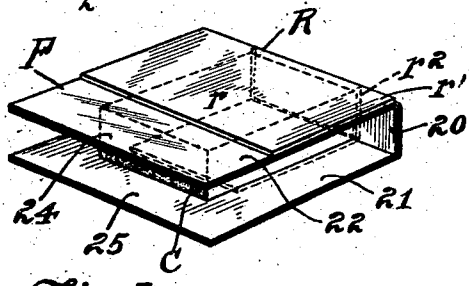


Fig. 4.

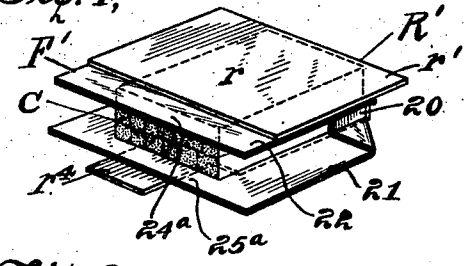


Fig. 5.

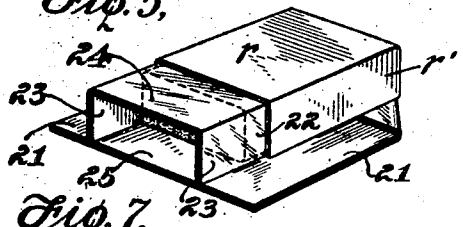


Fig. 6.

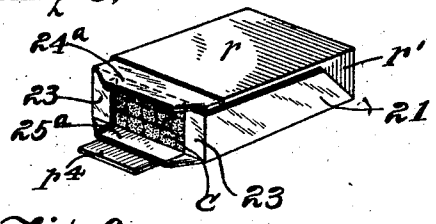


Fig. 7.

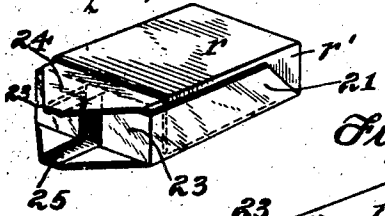


Fig. 9.

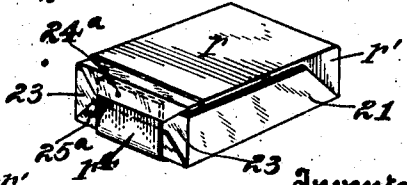
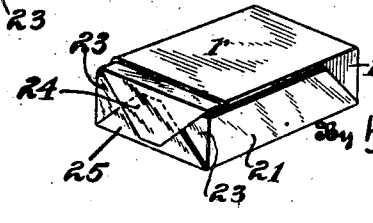


Fig. 8.



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2 SHEETS—SHEET 2.

Fig. 10,

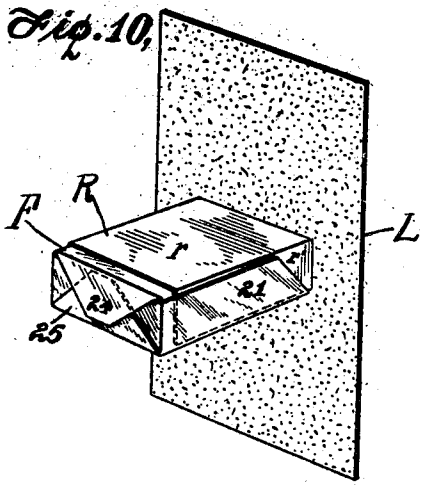


Fig. 11,

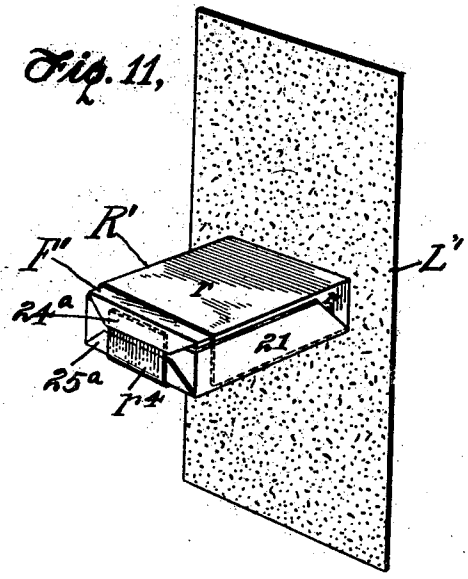


Fig. 12,

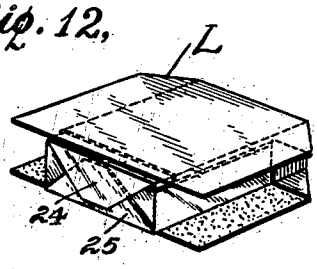


Fig. 13,

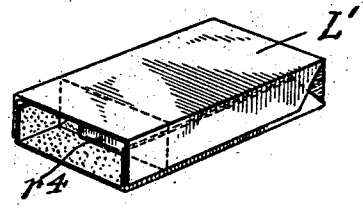


Fig. 14,

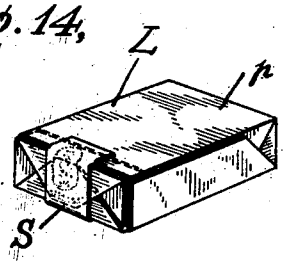
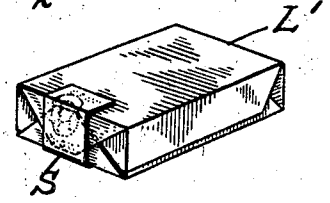


Fig. 15,



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UNITED STATES PATENT OFFICE.

HILARION DE ESCOBALES, OF STATEN ISLAND, NEW YORK, ASSIGNOR TO H. ESCOBALES CO., INC., OF NEW YORK, N. Y., A CORPORATION OF NEW YORK.

PRODUCTION OF PACKAGES.

1,381,087. Specification of Letters Patent. Patented June 7, 1921.

Application filed August 22, 1918. Serial No. 250,924.

To all whom it may concern:

Be it known that I, HILARION DE ESCOBALES, a citizen of the United States, residing at Staten Island, in the county of Richmond and State of New York, have invented new and useful Improvements in the Production of Packages, of which the following is a specification.

This invention relates to the production of packages, pertaining more particularly to the production of a wrapping structure and packages employing such structure.

While the invention is not limited as to its use or application, it is particularly adapted to the packaging of tobacco products and especially to the packaging of cigarettes, being capable of meeting the problems which result from the inherent characteristics of a commodity of this type.

For instance, while other forms of tobacco products, such for instance, as plug tobacco, are more or less solid and thus inherently provide a shape about which the wrapping can be applied, the inherent shape is not found in connection with a quantity of cigarettes. Each cigarette itself is more or less frail in character, and is therefore somewhat difficult to package, but where a plurality of cigarettes are employed in the formation of the package, the difficulty increases due to the presence of a plurality of the frail cigarettes. Obviously, this characteristic of the frail condition of the individual cigarette not only is present in the packaging operation—through the difficulty of providing a proper shape to the embryo packet—but also is present in the package itself, in that there is always a possibility of application of pressure to the sides of the package, where pressure may have the effect of breaking the wrapper—paper or leaf—or loosening the contents of the cigarette, and render the cigarette less salable or usable.

While the present invention does not pertain particularly to the manner in which the plurality of cigarettes are maintained in shape during the packaging operation—this forming the subject-matter of a companion application relating to apparatus for producing the package—it does pertain to the second of these features, in that the package is of a form in which the inherent characteristics of the cigarettes are maintained and at the same time the package is of such form as to reduce the liability of breakage or damage to the cigarettes of the package by pressure, as when the package is being carried in the pocket by the user.

This problem is met in the present invention by the use of a comparatively stiff member or element which is introduced into and forms a portion of the package wrapping, this member or element serving to stiffen the wrapping in such manner as to resist the action of pressure on the contents and thus reduce the liability of damage.

Various ways may be provided for producing this result, the drawings of the application indicating two different ways, these two forms having many similar characteristics, although the resultant package differs in certain respects in the two formations.

One of the features common in the two forms shown is the fact that while this stiffening medium is employed, it is introduced in such way as to practically be out of contact with the cigarettes themselves, forming part of the wrapping rather than serving as a lining element for an inclosing wrapper. Consequently the usual foil and paper inclosure may be utilized as the direct cover for the cigarettes, this forming the lining of the wrapping.

Another common feature is that while the wrapping is formed of separate elements or members, they are practically united into a composite whole by the use of adhesive on but one of the elements, the wrapping elements being folded and applied in such manner as to make it possible to provide this more or less unitary structure by the use of adhesive carried by but one of the wrapping elements.

One of the features of difference in the two forms shown is provided by the manner in which closing of the package is provided, one form having the folded closing end provided by the foil and paper element of the wrapping, while the other form has this folded closed end provided by the outer wrapping element which may be in the form of a label, it being understood that the Government revenue stamp overlies the closed end in each form.

Another feature which may be employed—being shown in connection with one of the forms—is the utilization of the stiffening element to provide for a restricted opening at the closed end, thus tending to reduce lia-

bility of loss of contents when the package is opened.

The general objects of the invention are the production of packages of these general types which can be provided in a simple and efficient manner and at comparatively low cost, the production being in such form as to permit of ready formation by automatic machinery, thus providing for large capacity operations.

To these and other ends, the nature of which will be readily understood as the invention is hereinafter disclosed, said invention consists in the improved package constructions and combinations, together with the methods of producing the same, as hereinafter more fully described, illustrated in the accompanying drawings, and more particularly pointed out in the appended claims.

In the accompanying drawings, in which similar reference characters indicate similar parts in each of the views:

Figure 1 is a perspective view illustrating an initial stage in the production of one form of package.

Fig. 2 is a similar view where the wrapping blanks are of a type to produce another form of package.

Figs. 3, 4 and 5 are perspective views illustrating succeeding stages in the production of the package of either form.

Figs. 6 and 7 are perspective views showing succeeding stages in the production of the two forms of packages, Fig. 6 being that in which the blanks of Fig. 2 are employed, Fig. 7 indicating the use of the blanks shown in Fig. 1.

Fig. 8 is a perspective view showing the completion of the end folding operation of the embryo package of Fig. 7.

Fig. 9 is a similar view of the embryo package shown in Fig. 6.

Figs. 10 and 11 are perspective views showing a succeeding stage in the production of the package, being the first stage of the application of the outer or label element of the wrapping, Fig. 10 indicating the form utilized in connection with the embryo package of Fig. 8, Fig. 11 illustrating the form of blank used in connection with the embryo package of Fig. 9.

Figs. 12 and 13 illustrate successive stages in the folding of the outer member of the wrapping, these being similar in connection with the two forms, the two views showing the different label formations of Figs. 10 and 11.

Fig. 14 is a perspective view showing the complete package in which the wrapping elements are those disclosed in Figs. 1 and 10, and utilizing the embryo package of Fig. 8.

Fig. 15 is a similar view showing the completed package wherein the wrapping elements are those shown in Figs. 2 and 11, with the embryo package of the type indicated in Fig. 9.

In each of the two forms shown, the wrapping consists of three elements, the inner element F or F′ which may be of a single sheet but which, where the wrapping is to produce a cigarette package, is preferably of the usual foil and paper material; the stiffening element R or R′ formed of suitable material, such for instance as card or pasteboard, and the outer element L or L′ which is preferably of thin paper material and which generally carries the label data. The inner and outer elements are preferably of flexible material, although the invention is not limited in this respect. In addition, the package carries the revenue stamp S. The commodity being packaged is shown as that of a plurality of cigarettes C, this form of commodity being, of course, illustrative. The wrapping elements are shown as in the form of blanks.

As heretofore pointed out, many of the stage operations in the production of the composite wrapping are the same in both forms shown, and in the drawings I have utilized both forms in illustrating such stage operations, but it may be understood that, generally, the elements F, R and L pertain to one form of package, while elements F′, R′ and L′ pertain to the other form, although it will be understood, of course, that this arrangement is not absolute, since, for instance, stiffening blank R may be employed with wrapping blanks F′ and L′.

The inner elements F and F′, as shown, differ from each other simply in the length of the blank, this being the essential difference between the two blanks where the element configurations are of the type shown in the drawings; the outer elements L and L′ differ from each other in the same manner, it being understood that both the inner and outer wrapping elements may have other distinguishing characteristics, as by varying the contours of the blanks to meet particular and preferred types of package formation, the invention not being limited to the particular configurations of inner and outer wrapping blanks employed. In the drawings, these outer and inner wrapper blanks are shown as rectangular.

Blanks R and R′, differ from each other in other respects. Each has a section r having a width substantially equal to the width of the package and a length not greater than the length of the package—preferably slightly less—said section carrying wings r' of substantially the same length as section r and having a width approximately equal to the depth of the package. Each blank also carries a bottom r^2 and a section r^3, said bottom and section corresponding in width to section r. In blank R, section r^3 is approximately of the same length as sec-

tion r; the blank R′, however, preferably has section r^3 substantially equal in length to the length of the package, this section carrying an end wing r^4 of less width than section r^3, this end wing being foldable relatively to an end of the package.

The wrapping is of the type generally known as a "cup" formation, the width of blanks F, F′, L and L′ being such as to provide the material for the production of the "cups".

While the inner and stiffening elements may be assembled separately—as by folding the inner element into a partial cup shape and then presenting the stiffening element and folding it in position thereon—I prefer to provide the folding of these two elements into assembly formation concurrently, this being permitted by bringing the blanks of the two elements into contact as in Figs. 1 and 2, blanks R or R′ being properly positioned with respect to blanks F or F′, the latter being properly positioned relative to the plurality of cigarettes—which may be termed a "packet"—so as to locate the end of the packet in contact with that portion of the blank's design to provide the bottom of the cup formation. The two contacting blanks are then folded on to the opposite sides of the packet, as in Fig. 3, thus laying the foil and paper element on to opposite faces of the packet with the stiffening element overlying the foil and paper element, wings r^2 lying wholly on one side of the packet, wing r^4, when present, lying on the opposite side of the packet. The portions of the foil and paper element located at the sides of the bottom—indicated at 20—are then tucked in, as in Fig. 4, thereby providing side flaps 21 and 22, flaps 21 being formed from the inner element alone while flaps 22 are formed from this element and the wings r'.

Flaps 22 are then folded on to the sides of the packet, as in Fig. 5, after which flaps 21 are folded on to the outer sides of flaps 22, as in Fig. 6, thus completing the assembly and providing an embryo wrapping or cup formation.

As will be seen, this folding places wings r' in overlying relation to the foil and paper portion of flaps 22 and in underlying relation to flaps 21, these wings extending between these two portions of the foil and paper cup, the stiffening element thus having an overlying and underlying relation to the inner wrapping element.

These operations described are the same with both forms shown, but the resulting formations differ. For instance, when blanks F and R are employed, the ends of blank R do not extend beyond the end of the packet—they are preferably spaced therefrom a small distance—while the ends of blank F project a distance sufficient to provide for folding thereof into a complete closure for the open end of the cup, thus causing the portion of the wrapping which projects beyond the ends of the packet to be formed entirely from the inner or foil and paper element. On the contrary, when blanks F′ and R′ are employed, the projecting portions of the inner element F′ are of less length than element F, and end wing r^4 projects beyond the end of this inner element, as shown in Figs. 4 and 6.

The more or less tube-like end of either form thus produced, is then folded by tucking in inner element portions 23, thus producing end flaps 24 and 25 of one form and 24^a and 25^a of the other form, flaps 24 and 25 having a length to provide overlapping of these flaps when folded, as in Fig. 8, while flaps 24^a and 25^a are of shorter length and preferably do not overlap, flap 25^a including the projecting wing r^4. Flaps 25 and 25^a—the latter with wing r^4—are then folded on to the end of the packet, this being followed by the folding of flaps 24 and 24^a, thus placing flap 24 in overlying relation to flap 25 and flap 25^a in underlying relation to flap 24^a and wing r^4.

As will be understood, this folding will produce an embryo package. In case blanks F and R are employed, this package will have the end entirely closed by the folded end formation of the inner element as in Fig. 8. When, however, blanks F′ and R′ are employed, the folding does not provide the overlapping relations produced in the first form, the arrangement more closely approaching the formation shown in Fig. 9.

As will be seen by comparing Figs. 8 and 9, the embryo package of each form has the exposed faces of its body portion of similar formation, the bottom, front and rear faces being provided by element R or R′, while the side faces are provided by portions of element F or F′ in addition to the small portion of wings r' exposed on these side faces. In other words, the exposed faces of the body portion of the assembly will be provided from both the stiffening and the inner wrapping elements, these elements, carrying no adhesive faces, being in unsecured relation one to the other. This provision of exposed faces from both elements is of particular advantage in connection with the completion of the package as presently pointed out.

In addition, the wrapping of each face of the body portion includes a ply of the stiffening element R or R′, thus producing a more or less stable form or shape to the body of the package. There is, however, a difference between the formations at the open end of the cup, as pointed out.

The package is completed by the application of the outer wrapping or label element

L or L′ and the application of the revenue stamp. As shown in Figs. 10 and 11, blanks L and L′ differ from each other in length, element L having a length approximately equal to the combined length of the bottom, front and rear faces of the embryo package—as seen in Fig. 12—while element L′ has a sufficiently greater length to provide the tube-like end formation indicated in Fig. 13, this end formation being folded as heretofore pointed out in connection with element F to produce the closed end of the package, as indicated in Fig. 15, this end overlying the end formation shown in Fig. 9.

Since the end closure of the form employing blank F is provided by that blank—Fig. 8—it will be understood that no supplemental end closure need be provided, so that the product—shown in Fig. 14—has the exterior of its body portion provided by folded element L with the end closure produced by element F. This differs from the arrangement of the other form wherein the exterior of the body portion as well as the end closure is provided by element L′.

Blanks L and L′ are provided with an adhesively-coated face—either solid, in zones, or otherwise stenciled, as may be preferred. The blanks are folded into the cup shaped formations similar to those heretofore explained and as indicated in Figs. 10 to 15. In applying the element to the assembly or embryo package, it will be readily seen that the adhesive face is brought into direct contact with the exposed faces of both underlying elements—the side faces of the inner wrapper element F or F′ and the remaining faces provided by stiffening element R or R′—the result being that while elements F and R or F′ or R′ are unsecured to one another—with element R or R′ capable of being readily withdrawn from the folded element F or F′ by endwise movement—this application of element L or L′ serves to not only secure the element L or L′ in position but also to fixedly position the two other elements relatively to each other. In other words, the application of the adhesively coated element L or L′ serves to secure the three elements of the wrapping in fixedly positioned relation to each other, forming a composite wrapping embodying an inner wrapping element (shown as of foil and paper), an outer wrapping or label element, and a stiffening element interposed between said inner and outer elements, the composite wrapping being substantially the equivalent of a unitary wrapping element having the positive advantage of being produced from different forms of material and in a manner by which the elements can be readily folded mechanically.

The folded end of the package is then closed by the application of stamp S which preferably extends on to the opposite faces of the package as indicated in Figs. 14 and 15.

As heretofore indicated, the package shown in Fig. 14 has the open end of the cup wrapping closed by the end closure formed from the inner wrapping element produced by the overlapping folded end flaps of that element; the overlapping folds, however, not being secured together, the practically sealed condition is provided by the application of the stamp which maintains the flaps closed. Hence, it is necessary only to break the stamp in order that the folded end may be opened up, this being the usual practice in the "cup" type of wrapping.

In the product of Fig. 15, however, this usual practice is changed. Here, the closure is provided by the folding of element L′ and the flaps are "tacked" together by the adhesive, in addition to which the entire flap is similarly tacked to the exposed portion of wing r^4 and the flap of element F′ which overlaps this wing, so that not only are the elements of the body portion of the package secured together but the closure formation is of a more or less composite arrangement with the elements thereof adhesively connected. As a result, removal of the stamp will not permit the closure to be opened; in practice, therefore, a different procedure is had in opening the package. In this form, the user opens up but a portion of the closure end, this result being had by tearing the flap material of element L′ at one side of the stamp—a portion which does not overlie wing r^4—exposing the underlying flap material of element F′ which may be opened out or torn off, the edge of wing r^4 forming a guide during the tearing operation. When this is done, the major portion of the closure remains intact, leaving an opening of sufficient extent to permit removal of the cigarettes as may be desired, thus tending to produce a delivery opening in the closure instead of entirely opening the closure. This restricting of the delivery opening is preferred in some instances, and where so desired, the particular formation of the package is of advantage in the production of the opening as will be understood. In addition, however, there is a positive advantage presented in the arrangement in that each of the faces of the package is reinforced by the stiffening element, the closure face not being reinforced in this manner in the form shown in Fig. 14.

As will be understood, the "cup" type of folding to produce the wrapping is preferred owing to the readiness with which it can be produced, but it is to be understood that this form is more or less illustrative, the invention not being limited thereto excepting as may be specifically indicated in the claims,

since the broad idea of providing a composite wrapping employing two normally unsecured elements which are relatively fixedly positioned by the adhesive application of a third element may be utilized with other forms of folding, and it is my desire to reserve the right to such use in so far as the scope of the claims, when broadly construed, will permit.

While I have herein shown and described several ways in which my invention may be carried out, it will be understood that changes and modifications therein may be found desirable or necessary in meeting the exigencies of use, and I desire to be understood as reserving the right to make any and all such changes or modifications therein as may be found desirable or essential, in so far as the same may fall within the spirit and scope of the invention, as expressed in the accompanying claims, when broadly construed.

What I claim is:—

1. Commodity packaging means comprising a wrapping consisting of inner and outer flexible wrapping elements and an interposed stiffening element, the portions of the inner wrapping element located at the sides of the package being entirely within the outer wrapping element, said stiffening and inner wrapping elements being fixedly positioned against relative movement by the application of the outer wrapping element.

2. Commodity packaging means comprising a composite wrapping consisting of inner and outer flexible wrapping elements and an interposed stiffening element, the portions of the inner wrapping element located at the sides of the package being entirely within the outer wrapping element, said stiffening and inner wrapping elements being folded to locate portions of each in facial contact with the outer wrapping element, said latter element being adhesively secured to such contacting faces.

3. Commodity packaging means comprising a composite wrapping consisting of an inner flexible wrapping element and a stiffening element folded to provide an embryo package having exposed faces of its body portion formed from said elements, and an outer wrapping element overlying and adhesively secured to such exposed faces, the portions of the inner wrapping element located at the sides of the package being entirely within the outer wrapping element, whereby the several elements will be fixedly positioned relatively to each other by the outer element.

4. A composite wrapping for commodity packages comprising an inner flexible wrapping blank, a stiffening blank, said blanks differing from each other as to configuration and foldable to produce an embryo formation in which both blanks are present in the exposed faces of the body portion of the embryo package, the portions of the inner wrapping element located at the sides of the package being entirely within the outer wrapping element and an adhesively coated outer wrapping blank folded to overlie and be secured to said exposed faces.

5. A composite wrapping for commodity packages comprising a flexible inner wrapping blank foldable to provide a face of overlapping flap formation, a stiffening blank foldable to locate a portion between said flaps and other portions in overlying relation to other faces of the folded inner blank, whereby the exposed faces of the embryo formation will include portions of both blanks, and an outer blank overlying and adhesively secured to such exposed faces to maintain the blanks in fixedly positioned relation.

6. A composite wrapping for commodity packages comprising a flexible inner wrapping blank foldable into cup formation with opposite faces of the cup of overlapping flap formations, a stiffening blank overlying faces of the folded inner wrapping blank and having wings extending between the flaps at said sides, whereby the exposed faces of the embryo formation will include portions of both blanks, and an outer blank overlying and adhesively secured to such exposed faces to maintain the blanks in fixedly positioned relation.

7. A composite wrapping of the "cup" type for commodity packages, comprising inner and outer flexible wrapping blanks each foldable into cup formation, and a stiffening blank interposed between said inner and outer blanks, said stiffening blank having wings extending into the cup formation of the inner blank to locate faces of both inner and stiffening blanks in contact with inner faces of the outer blank, said outer blank being adhesively secured to said contacting faces.

8. A composite wrapping for commodity packages comprising inner and outer flexible wrapping elements and an interposed stiffening element, said stiffening and inner wrapping elements being fixedly positioned against relative movement by the application of the outer wrapping element, the portions of the inner wrapping element located at the sides of the package being entirely within the outer wrapping element, one of said wrapping elements being foldable to form the closure of an end of the package.

9. A composite wrapping of the "cup" type for commodity packages comprising inner and outer flexible wrapping elements foldable into cup formations, and an interposed stiffening element, said stiffening and inner wrapping elements being fixedly positioned against relative movement by the ap-

plication of the outer wrapping element, one of said wrapping elements being foldable to close the open end of the composite cup formation.

10. A composite wrapping of the "cup" type for commodity packages comprising inner and outer flexible wrapping elements foldable into cup formations, and an interposed stiffening element, said stiffening and inner wrapping elements being fixedly positioned against relative movement by the application of the outer wrapping element, said inner wrapping element having a length to permit formation of an end closure of the cup when folded.

11. A composite wrapping of the "cup" type for commodity packages comprising inner and outer flexible wrapping elements foldable into cup formations, and an interposed stiffening element, said stiffening and inner wrapping elements being fixedly positioned against relative movement by the application of the outer wrapping element, said outer wrapping element having a length sufficient to provide a closure formation for the open end of the cup when folded.

12. A composite wrapping of the "cup" type for commodity packages comprising inner and outer flexible wrapping elements foldable into cup formations, and an interposed stiffening element, said stiffening and inner wrapping elements being fixedly positioned against relative movement by the application of the outer wrapping element, said inner wrapping element having a length to overlie the end of the commodity when folded, said outer wrapping element having a length sufficient to provide a closure formation overlying the end formation of the inner wrapping element.

13. A composite wrapping of the "cup" type for commodity packages comprising inner and outer flexible wrapping elements foldable into cup formations, and an interposed stiffening element, said stiffening and inner wrapping elements being fixedly positioned against relative movement by the application of the outer wrapping element, said outer wrapping element having a length sufficient to provide a closure formation for the open end of the cup when folded, said stiffening element having a wing underlying said closure.

14. A composite wrapping of the "cup" type for commodity packages comprising inner and outer flexible wrapping elements foldable into cup formations, and an interposed stiffening element, said stiffening and inner wrapping elements being fixedly positioned against relative movement by the application of the outer wrapping element, said outer wrapping element having a length sufficient to provide a closure formation for the open end of the cup when folded, said stiffening element having a wing underlying said closure, said wing being of less length than the length of the closure face of the package, whereby a portion of such package end will be unreinforced by said wing.

15. A composite wrapping of the "cup" type for commodity packages comprising inner and outer flexible wrapping elements foldable into cup formations, and an interposed stiffening element, said stiffening and inner wrapping elements being fixedly positioned against relative movement by the application of the outer wrapping element, said inner wrapping element having a length to overlie the end of the commodity when folded, said outer wrapping element having a length sufficient to provide a closure formation overlying the end formation of the inner wrapping element, said stiffening element having a wing entering into the folded formation of the end of the inner wrapping element and underlying the end closure of the outer element.

16. A composite wrapping of the "cup" type for commodity packages comprising inner and outer flexible wrapping elements foldable into cup formations, and an interposed stiffening element, said stiffening and inner wrapping elements being fixedly positioned against relative movement by the application of the outer wrapping element, said inner wrapping element having a length to overlie the end of the commodity when folded, said outer wrapping element having a length sufficient to provide a closure formation overlying the end formation of the inner wrapping element, said stiffening element having a wing entering into the folded formation of the end of the inner wrapping element and underlying the end closure of the outer element, with a wing portion exposed to contact with said end closure.

17. A composite wrapping for commodity packages comprising an inner flexible wrapping element, an outer adhesively coated flexible wrapping element, and an interposed stiffening element foldable to provide a composite wrapping with the inner and stiffening elements fixedly positioned by the application of the outer wrapping element, said stiffening element having a wing adapted to overlie an end of the commodity at an end of the package, said outer element being foldable to form an end closure for such package end and provide an adhesive connection of the end closure with said wing.

18. A composite wrapping for commodity packages comprising an inner flexible wrapping element, an outer adhesively coated flexible wrapping element, and an interposed stiffening element foldable to provide a composite wrapping with the inner and stiffening elements fixedly positioned by the application of the outer wrapping element, said inner element being foldable into overlying relation to an end of the commodity at a

package end, said stiffening element having a wing extending into said inner element end formation, said outer element being foldable to provide an end closure for such package end and be adhesively secured to the inner element and said wing at such end.

19. The method of producing a composite wrapping for commodity packages which consists in producing an embryo wrapping from a flexible inner wrapping element and a stiffening element with both elements forming exposed faces of the wrapping, and applying an adhesively coated outer wrapping element to such faces to secure the outer wrapper element to both inner and stiffening elements.

20. The method of producing a composite wrapping for commodity packages which consists in folding a flexible inner wrapper blank and a stiffener blank into a wrapping formation with the stiffener blank extending in both overlying and underlying relation to the wrapper blank, and applying an adhesively coated outer wrapper blank to the exposed faces of such wrapping formation.

21. The method of producing a composite wrapping for commodity packages which consists in folding a flexible inner wrapper blank and a stiffener blank in unsecured relation to produce an embryo wrapping formation having exposed faces provided from both blanks, and applying an adhesively-coated outer wrapper blank in overlying relation to said faces to secure the assembly blanks to the outer blank and fixedly position the assembly blanks relative to each other.

In testimony whereof I have hereunto set my hand.

HILARION DE ESCOBALES.