Sept. 3, 1946. D. BELCHER 2,406,791

METHOD OF CLOSING BAG TUBE ENDS

Filed Jan. 15, 1943 6 Sheets-Sheet 1

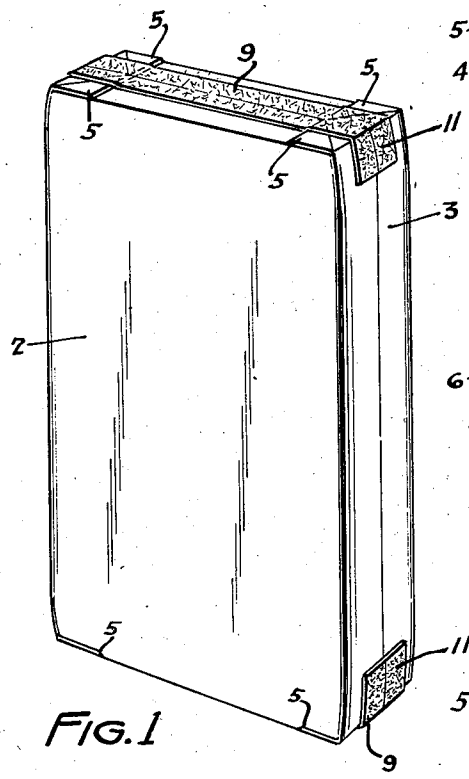


FIG. 1

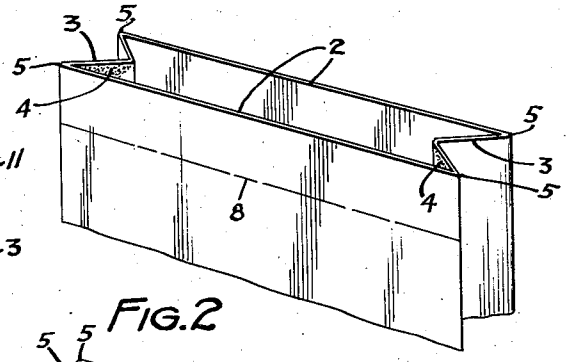


FIG. 2

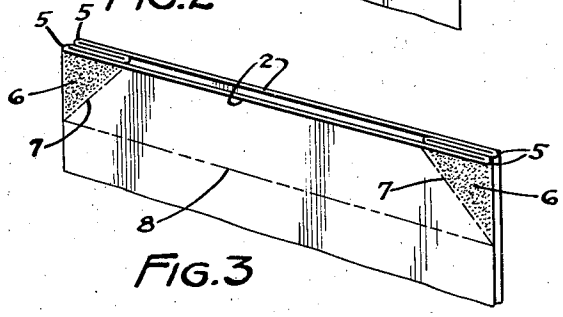


FIG. 3

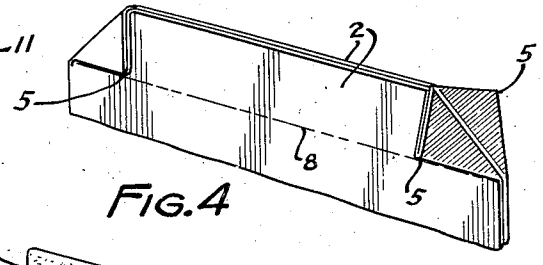


FIG. 4

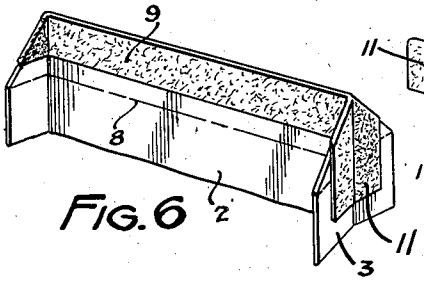


FIG. 6

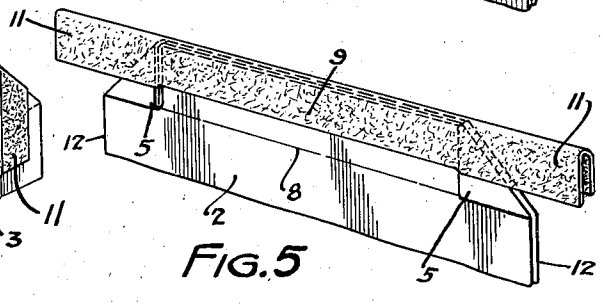


FIG. 5

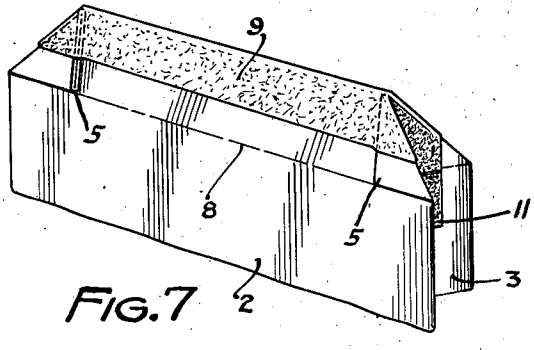


FIG. 7

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Sept. 3, 1946. D. BELCHER 2,406,791

METHOD OF CLOSING BAG TUBE ENDS

Filed Jan. 15, 1943 6 Sheets-Sheet 2

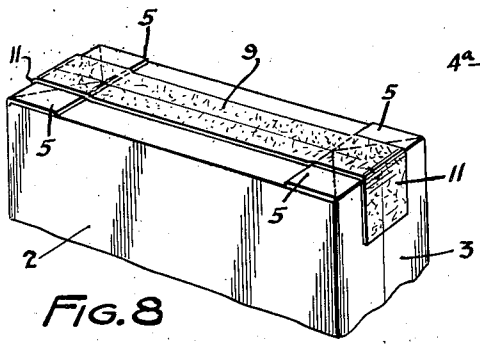


FIG. 8

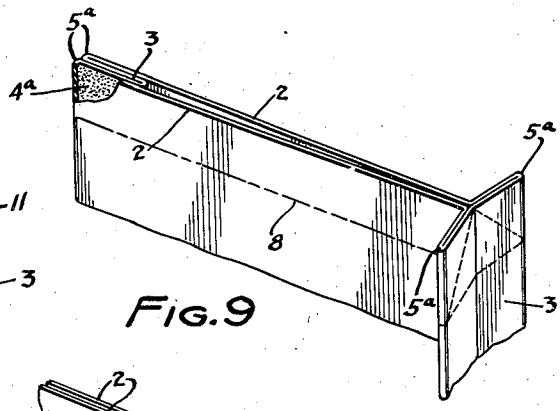


FIG. 9

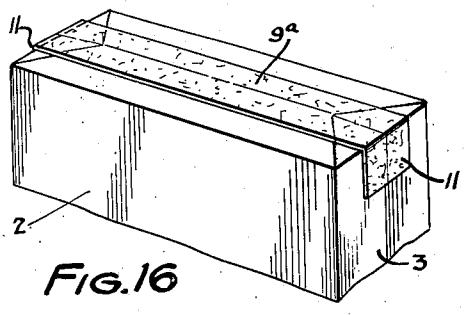


FIG. 16

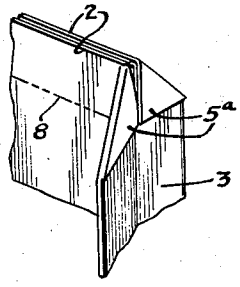


FIG. 10

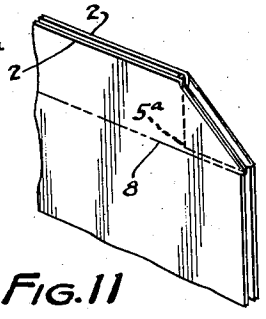


FIG. 11

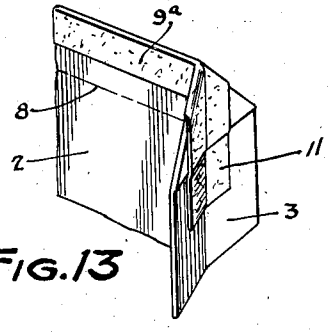


FIG. 13

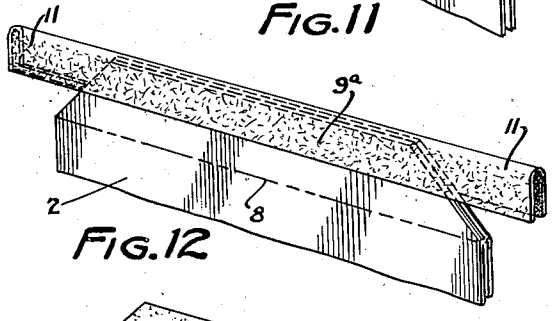


FIG. 12

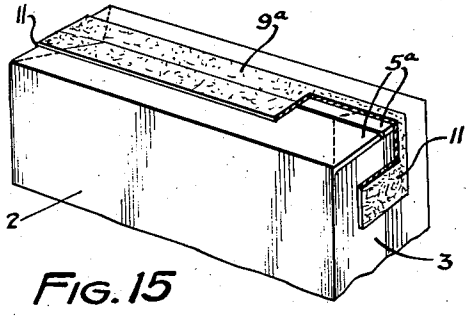


FIG. 15

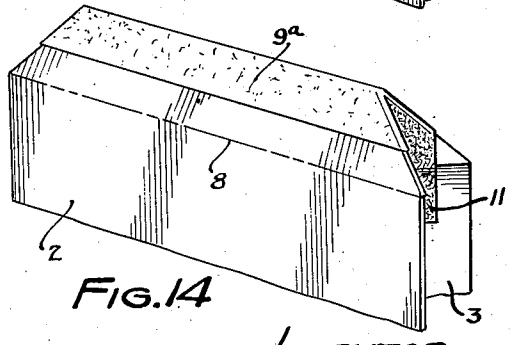


FIG. 14

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Sept. 3, 1946. D. BELCHER 2,406,791

METHOD OF CLOSING BAG TUBE ENDS

Filed Jan. 15, 1943 6 Sheets-Sheet 3

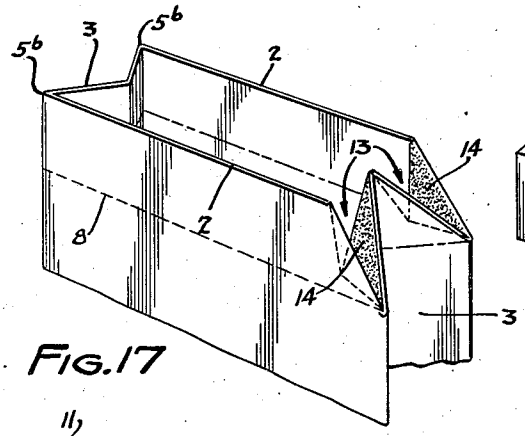


FIG. 17

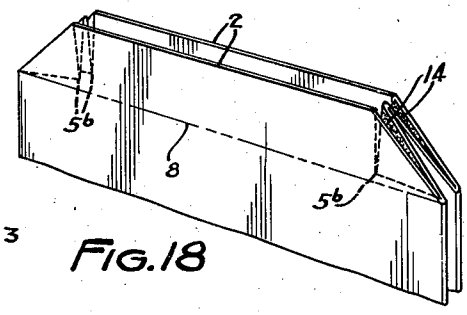


FIG. 18

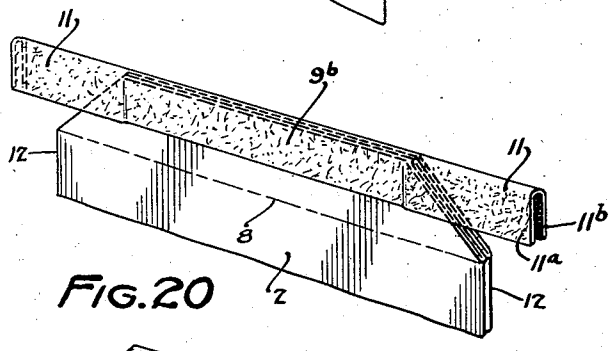


FIG. 20

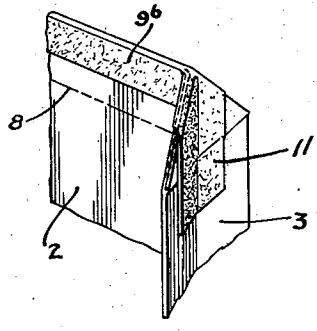


FIG. 19

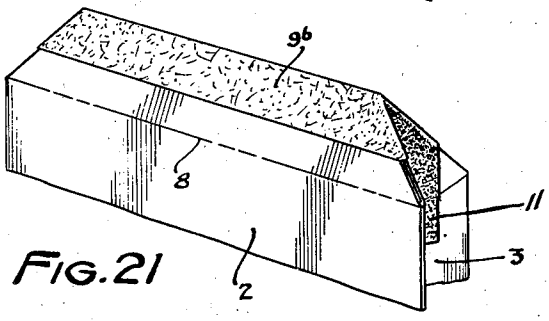


FIG. 21

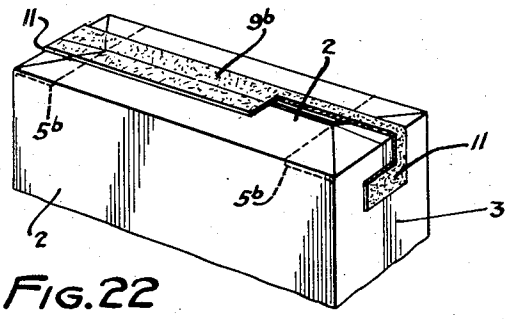


FIG. 22

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Sept. 3, 1946. D. BELCHER 2,406,791

METHOD OF CLOSING BAG TUBE ENDS

Filed Jan. 15, 1943 6 Sheets-Sheet 4

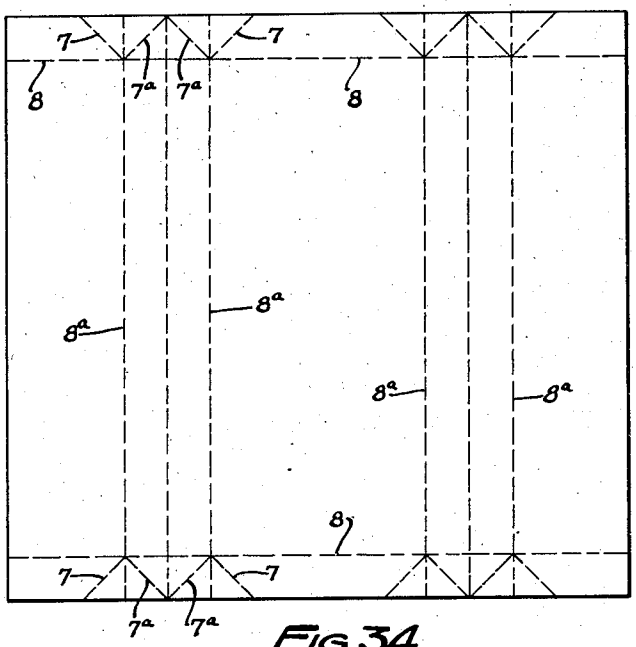


FIG. 34

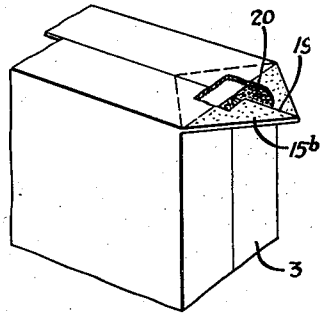


FIG. 39

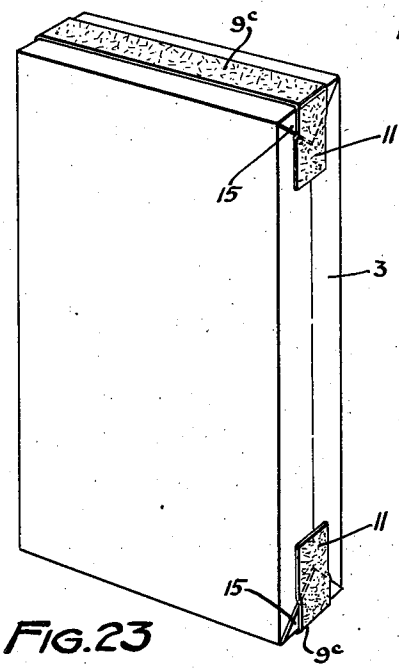


FIG. 23

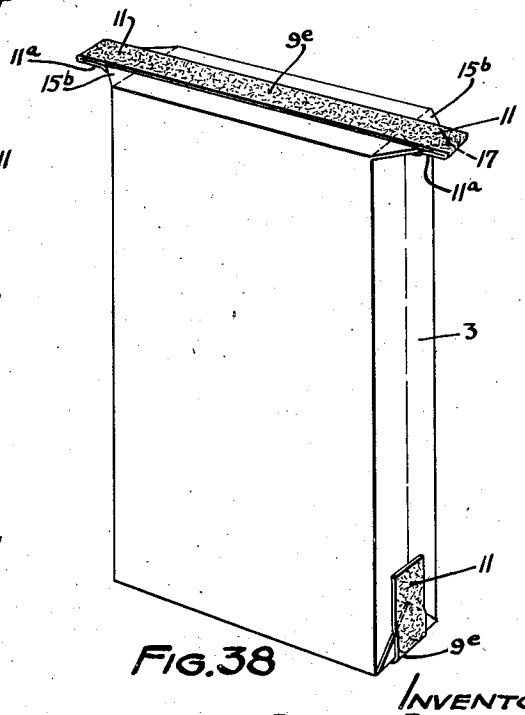


FIG. 38

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Sept. 3, 1946. D. BELCHER 2,406,791

METHOD OF CLOSING BAG TUBE ENDS

Filed Jan. 15, 1943 6 Sheets-Sheet 5

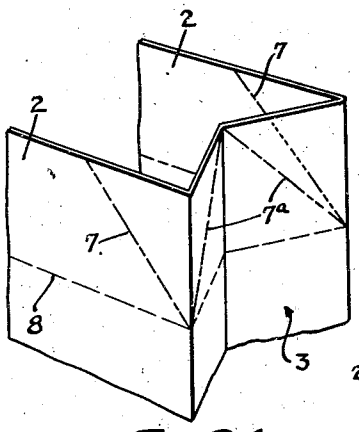


FIG. 24

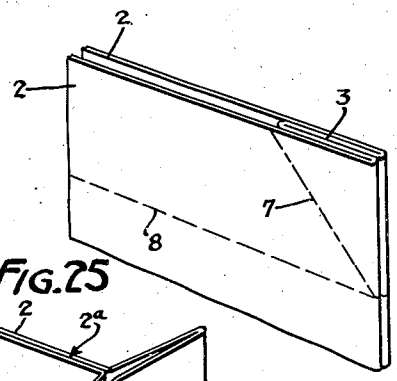


FIG. 25

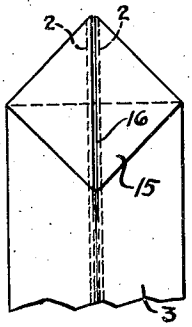


FIG. 29

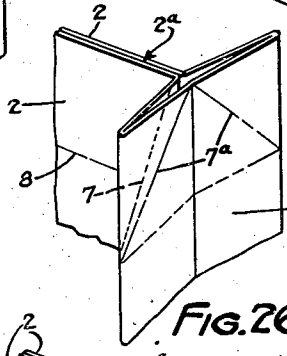


FIG. 26

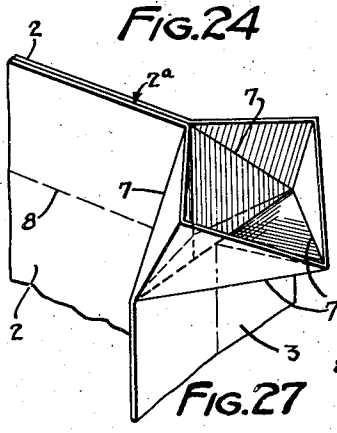


FIG. 27

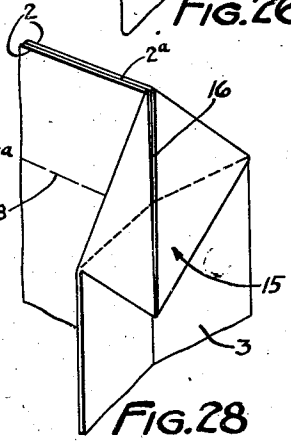


FIG. 28

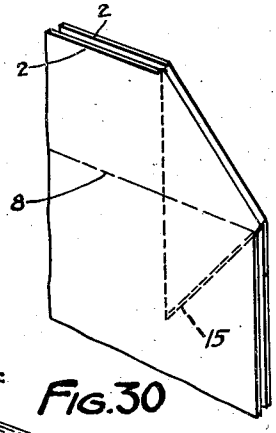


FIG. 30

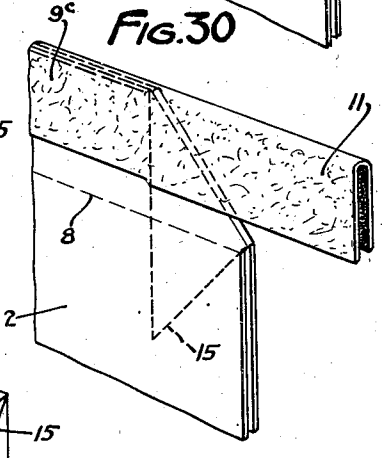


FIG. 31

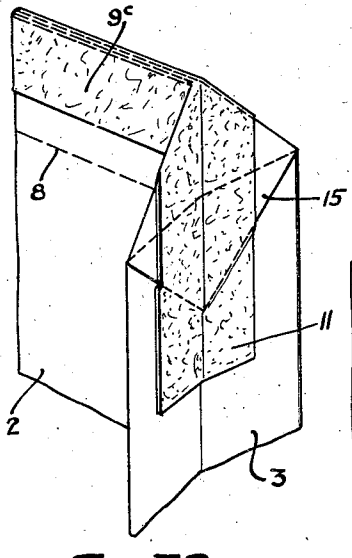


FIG. 32

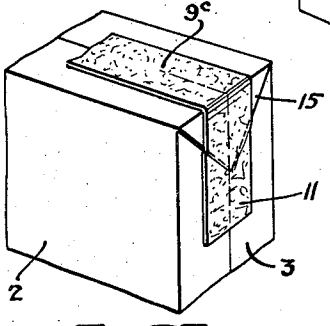


FIG. 33

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Sept. 3, 1946. D. BELCHER 2,406,791

METHOD OF CLOSING BAG TUBE ENDS

Filed Jan. 15, 1943 6 Sheets-Sheet 6

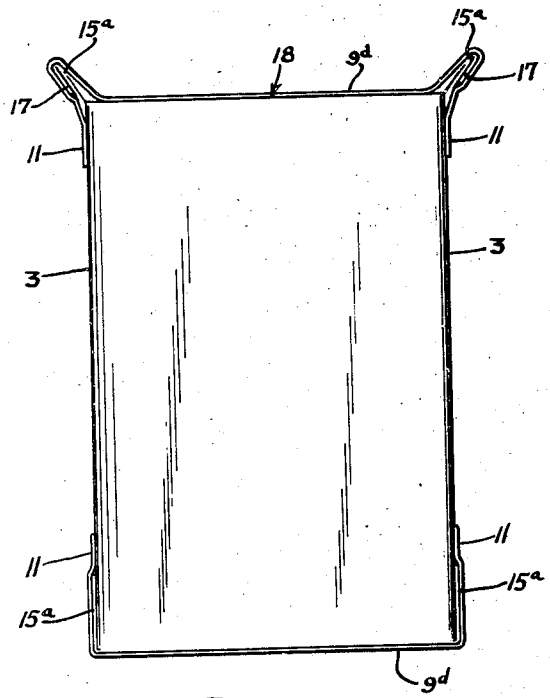


FIG. 35

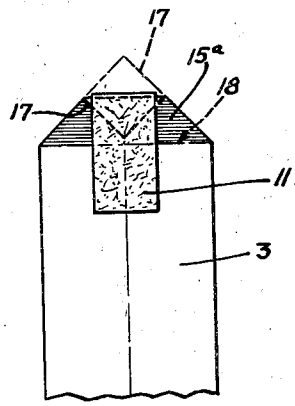


FIG. 37

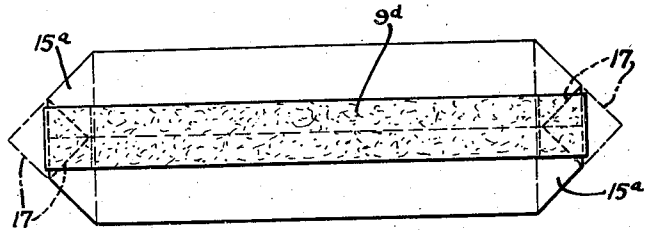


FIG. 36

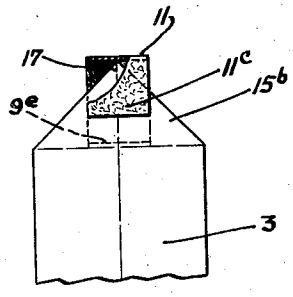


FIG. 40

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Patented Sept. 3, 1946 2,406,791

UNITED STATES PATENT OFFICE

2,406,791

METHOD OF CLOSING BAG TUBE ENDS

Daniel Belcher, Minneapolis, Minn., assignor to Bemis Bro. Bag Co., Minneapolis, Minn., a corporation of Missouri

Application January 15, 1943, Serial No. 472,493

6 Claims. (Cl. 93—35)

1

This invention relates to new and useful improvements in methods of closing and sealing the ends of tubular bag bodies or blanks of the general types disclosed in pending applications, Serial Nos. 452,411 and 458,646, filed respectively, July 27, 1942 and Sept. 17, 1942, by Wm. J. Geimer and Frank R. Linda, as joint inventors.

One of the important objects of the present invention resides in the provision of an improved method of closing and sealing the ends of tubular bag blanks, whereby the closed ends of bags may be hermetically sealed in a manner to permit rough handling of the bags without danger of the sealed ends thereof becoming leaky, and also whereby the closed bag ends will be very neat in appearance.

A further object of the invention is to provide a novel method of closing and sealing an open bag top, whereby the sealed bag top will be substantially flat and rectangular in configuration.

A further object is to provide a novel method of closing bag tops which is particularly applicable to bags of the intucked type, wherein the bag top walls are pressed into flat-wise relation with the edge walls intucked between the side walls, after which the juxtaposed corners of the flattened bag top walls are folded against their respective side walls and preferably adhered thereto, and a strip of tape is then folded over the top edges of the flattened bag top walls and adhered thereto with its end portions secured to the edge wall portions which are subsequently inwardly folded over the contents of the bag body.

A further object is to provide a method of closing the open tops of bags of the intucked type, which consists in inwardly folding the juxtaposed corners of the flattened bag top walls against their respective edge walls, and then applying a strip of tape over the edges of the flattened bag top walls and said inwardly folded wall corners, whereby the closed bag top is sealed against leakage and will be substantially rectangular in formation.

A further object is to provide a bag closure for bags of the intucked type in which the edge walls are intucked between the side walls in the operation of closing the open bag top or end, and whereby juxtaposed corners are provided, each comprising a portion of a side wall and a portion of an edge wall, and the side and edge wall portions constituting such corners being intucked between their respective side and edge walls and preferably bonded together after which a strip of tape is folded over the flattened bag top walls and suitably secured thereto with its end portions

2

suitably bonded to the edge wall portions which are subsequently inwardly folded over the contents of the bag body, thereby to seal the bag top.

A still further object of the invention resides in the provision of a novel method of closing and sealing the ends of tubular bag blanks, whereby the bag end walls may be folded into closing relation and secured in such positions by the application thereto of a single strip of sealing tape, and in a manner to provide a completely and positively sealed bag end closure without the necessity of applying an adhesive to any portions of the bag end walls, prior to adhering the sealing tape thereto.

A further object is to provide a novel method of closing and sealing open bag tops, whereby the bag top walls are so folded as to bring the edges thereof together, and then applying a strip of sealing tape over said edges and adhering it to the marginal edges of the walls, whereby the bag top is completely sealed, and the bag top walls being so folded as to provide a carrying flap or handle at each end of the bag top whereby the filled bags may be conveniently grasped in the operation of moving them about from place to place.

A further object resides in the novel manner of forming the carrying flaps or handles at the corners of the bag top, which is accomplished simultaneously as the bag top walls are folded into closing and sealing relation.

Other objects of the invention will appear from the following description and accompanying drawings and will be pointed out in the annexed claims.

In the accompanying drawings there has been disclosed a structure designed to carry out the various objects of the invention, but it is to be understood that the invention is not confined to the exact features shown, as various changes may be made within the scope of the claims which follow.

In the drawings:

Figure 1 is a perspective view of a bag showing my invention applied thereto;

Figure 2 is a perspective view showing the open end of a tubular bag blank with the edge walls partially intucked between the side walls;

Figure 3 is a view showing the side walls of the bag top pressed into flat-wise relation with the edge walls intucked therebetween;

Figure 4 is a view similar to Figure 3, but showing the juxtaposed corners at the ends of the bag

top folded into bonding engagement with their respective side walls;

Figure 5 is a perspective view of a partially closed bag top showing the tape applied thereto;

Figure 6 is a view similar to Figure 5, but showing the juxtaposed walls provided at the side edges of the bag top spread apart to permit the ends of the tape to be pressed into bonding engagement with the upper portions of the edge walls;

Figure 7 is a perspective view showing the bag top walls closed and sealed;

Figure 8 is a perspective view showing a completed bag top closure, partially broken away to more clearly illustrate how the corner portions of the bag top walls are folded into engagement with the side walls, prior to completing the formation of the closed bag top;

Figure 9 is a perspective view showing the juxtaposed walls at one end of the flattened bag top walls outwardly folded to permit inwardly folding the corner portions of the bag top against their respective edge walls, preparatory to applying a strip of tape over the edges of the flattened bag end walls;

Figure 10 is a view showing the manner of inwardly folding the corners of the bag top walls against the edge walls thereof;

Figure 11 is a view showing a flattened bag top with the wall corners intucked between the flattened bag top walls;

Figure 12 is a view similar to Figure 6, showing a strip of tape applied over the edges of the flattened bag top walls with its ends overlying the inwardly folded corner portions of the edge walls;

Figure 13 is a view showing a strip of tape applied to the flattened bag top walls;

Figure 14 is a view showing the bag top substantially completed;

Figure 15 is a view showing the completed bag closure, partially broken away to more clearly illustrate the construction thereof;

Figure 16 is a perspective view showing the completed bag top;

Figure 17 is a view showing another form of closure wherein the edge walls of the bag top are intucked between the side walls, after which the corners of the juxtaposed walls are inwardly intucked between their respective side and edge wall portions and suitably bonded together;

Figure 18 is a view showing the bag top walls of Figure 17 partially pressed into flat-wise relation preparatory to having the tape applied thereto;

Figure 19 is a perspective view showing a corner of the sealed bag top with an end of the tape secured to one of the edge walls;

Figure 20 is a view showing the flattened bag top illustrated in Figure 18, with the tape applied thereto;

Figure 21 is a view showing the bag top or end completely closed and sealed;

Figure 22 is a perspective view of a sealed bag top, partially broken away to more clearly illustrate how the wall corners are folded into closing relation in the operation of closing and sealing the bag top;

Figure 23 is a perspective view showing a sealed bag with a somewhat different type of closure;

Figure 24 is a perspective view showing the preferred manner of scoring the bag top walls for the closure shown in Figure 23;

Figure 25 is a view showing the first step in making the closure illustrated in Figure 23, wherein the bag top walls are pressed into flat-wise relation with the edge wall between the side walls;

Figure 26 is a view showing the next step in which the edge walls are unfolded;

Figure 27 shows the uppermost portion of one of the edge walls folded downwardly to provide, in effect, a triangular flap which is folded against the edge wall;

Figure 28 shows the triangular flap seated against its respective edge wall;

Figure 29 is an edge view of Figure 28;

Figure 30 is a perspective view showing the upper marginal edges of the bag top walls folded into flat-wise relation, prior to applying the tape thereto;

Figure 31 is a view similar to Figure 30, showing the tape folded over the edges of the bag end walls;

Figure 32 is a view showing the end of the tape folded downwardly into engagement with the edge wall to secure the triangular flap in sealed position;

Figure 33 is a perspective view showing an upper corner of a sealed bag top;

Figure 34 is a plan view showing the manner of scoring the blanks to complete the closure illustrated in Figure 23;

Figures 35 to 37, inclusive, illustrate another form of closure in which carrying handles are provided at the corners of the sealed bag top; and

Figures 38 to 40, inclusive, illustrate another form of bag closure wherein carrying handles are provided;

In the embodiment of the invention, as shown in Figures 1 to 8, inclusive, there is illustrated the end of a bag body or tube, comprising side walls **2** and edge walls **3**, the edge walls being intucked between the side walls in the initial operation of closing and sealing the bag end, as is well known in the art.

To close and seal the bag top in accordance with the present invention, a suitable adhesive **4** is preferably applied to the inner surfaces of the ends of the edge walls adjacent to the side walls **2**, as shown in Figure 2, whereby when the edge walls are intucked between the side walls, and all of said walls are pressed into flatwise relation, as shown in Figure 3, the upper portion of the edge walls will be secured to the adjacent surfaces of the side walls as a result of the adhesive **4**. If desired, the adhesive may be applied to the upper adjacent surfaces of the side walls, provided it is applied at such locations that when the bag top walls are pressed into flat-wise relation, the plies of the juxtaposed corners **5** of the flattened bag top will be suitably bonded together, as will readily be understood by reference to Figures 2 and 3.

In the next operation of closing the bag top, a suitable adhesive **6** is preferably applied to the upper outer surfaces of the juxtaposed corners **5**, and these corners are then folded against their respective side walls **2** and may be bonded thereto, as will be understood by reference to Figure 4. To facilitate folding the bag top walls, suitable diagonal score lines **7**, **7**—*a* and **8** may be provided, as shown in Figure 3, along which the upper portions of the edge and side walls are folded, in the operation of completing the closure, as will be understood by reference to Figure 1. Other score lines **8**—*a* may also be provided to facilitate folding the blank to form the bag body, as may be noted by reference to Figure 34. If desired, the corners **5** need not be adhered to the side walls, as above stated, as a comparatively tight closure

is provided without thus adhering them to the side walls.

When the juxtaposed corners **5** have been folded against their respective side walls **2**, as shown at the left hand side of Figure 4, a strip of tape, generally designated by the numeral **9**, is folded over the upper edges of the flattened bag top walls and adhered thereto by a suitable adhesive, the tape ends **11** preferably projecting beyond the side edges **12** of the flattened bag top, as shown in Figure 5.

In the next step, the folded bag top walls are expanded or so unfolded as to cause the edge walls to straighten out, as shown in Figures 1 and 6, after which the tape ends **11** may be pressed downwardly into bonding engagement with the upper portions of the edge walls **3** and suitably adhered thereto, as shown in Figure 1, whereby the bag top is completed.

In Figures 9 to 16, inclusive, there is shown another form of bag closure in which the corners **5**—*a* of the bag tube end or top are folded inwardly against the edge walls, as shown in Figure 10, after which the edge walls are folded upon themselves, as shown in Figure 11, whereby the corners **5**—*a* will be concealed between the side walls, as shown. Before inwardly tucking the corners **5**—*a* between the side walls, as shown in Figure 11, a suitable adhesive **4**—*a*, shown in Figure 9, is preferably inserted between the plies thereof in a manner similar to the adhesive **4** shown in Figure 2, whereby the plies of the inwardly folded corners **5**—*a* will be suitably bonded together to prevent the contents of the bag from filtering through the inwardly folded corners.

When the bag top walls have been folded, as shown in Figure 11, a strip of tape **9**—*a* is folded over and adhered to the edges of the flattened bag top walls, as will be understood by reference to Figure 13. The end portions of the tape are then secured to the upper portions of the edge walls, whereby they overlie the infolded corners **5**—*a* as shown in Figure 12. The above described method of applying the strip of sealing tape to the bag end or top may readily be accomplished, because when the tape is applied, the adhesive is sufficiently wet to permit the juxtaposed or contiguous wall portions **11**—*a* and **11**—*b* of the projecting tape ends to be readily separated from their folded condition, shown in Figure 13, to the unfolded or flattened condition shown in Figure 12, when the tape ends are pressed into bonding engagement with the edge walls **3**, to complete the sealing of the bag end or top. By thus adhering the ends of the tape to the upper portions of the edge walls, the corners **5**—*a* of the bag end will be secured in position, as will readily be understood by reference to Figures 15 and 16, and in such a manner that the bag top will be hermetically sealed against leakage. If desired, the corners, **5**—*a* may be adhered to the edge walls, particularly if the bags are to be used for packaging finely pulverized materials, but for general use, this may be unnecessary.

In Figures 17 to 22, inclusive, there is shown another form of closure which, while similar in appearance to the closures illustrated in Figures 1 to 15, is somewhat differently formed.

In the initial operation of making the bag closure shown in Figure 22, the bag top walls are folded into flat-wise relation with the edge walls **3** intucked between the side walls **2**, as shown in Figure 17, thereby providing corners **5**—*b*, similar to the corners **5** shown in Figure 2. In the next step the corners **5**—*b* are intucked between the

adjacent portions of their respective side walls **2** and edge walls **3**, as shown at **13** in Figure 17, after which a suitable adhesive **14** is preferably applied to one or both surfaces of the intucked walls of the corners **5**—*b*. The bag top walls are then pressed into flat-wise relation, as will be understood by reference to Figure 18, whereby the intucked corners **5**—*b* will be secured in position within the upper portions of the bag body.

A strip of tape **9**—*b* is next folded over the flattened bag top walls, as shown in Figure 20, and suitably adhered thereto, with its end portions **11** extending beyond the side edges **12** of the flattened bag top, as shown in Figure 20. The wall portions **11**—*a* and **11**—*b* of the tape ends are then separated and pressed firmly into engagement with their respective edge walls and adhered thereto, as shown in Figure 21, whereby the bag closure is completed. When the bag top walls have been folded into closing and sealing relation, as shown in Figures 17 to 21, the completed bag closure, shown in Figure 22, will be substantially identical in appearance to the closures illustrated in Figures 8 and 15, the only distinction between the various forms residing in the novel manner in which the bag top corners **5**, **5**—*a* and **5**—*b* are folded with respect to the side and edge walls of their respective bag tops.

In Figures 23 to 34, inclusive, there is shown another form of bag closure in which the blank, shown in Figure 34, is scored in a manner similar to the blanks used for the bag closures illustrated in the previous figures.

In Figure 24 the bag end is shown with one of its edge walls **3** partially intucked between the side walls **2**, prior to pressing all of said walls into flat-wise relation as shown in Figure 25. When the walls have thus been pressed into flat-wise relation, the edge walls are unfolded, as shown in Figure 2, it being understood that the upper marginal edges **2**—*a* of the side walls **2** are retained in flat-wise relation by suitable means not shown in the drawings.

In the next step, the upper-most portions of the edge walls **3** are unfolded or pulled outwardly, as shown in Figure 27, and thence downwardly to the position shown in Figure 28, whereby each edge wall is provided at its upper portions with what may be termed a triangular flap **15**, formed as a result of the outward folding of the upper portions of the edge walls, facilitated by the score lines **7** and **7**—*a*, as will be understood by reference to Figures 28 and 29.

The bag top walls may then be pressed into flat-wise relation, as shown in Figure 30, after which a strip of sealing tape **9**—*c* may be adhered thereto in a manner similar to that shown in the previous figures.

The end portions **11** of the tape are subsequently brought into bonding engagement with the edge walls **3**, as shown in Figure 32, it being understood that in so doing the edge walls are unfolded from the position shown in Figure 31 to that shown in Figure 32, whereupon the bag closure is completed, as shown in Figures 23 and 33.

An important feature of the form of bag closure illustrated in Figures 23 to 34 resides in the fact that this bag closure may be completed without applying an adhesive between any of the wall portions which constitute the bag top or end, and with the assurance that the bag end will be completely sealed. This results because the strip of tape **9**—*c* completely seals the upper marginal edge portions of the side walls, and also completely seals the joint **16** formed by the con-

tiguous edges of the bag top walls, shown in Figure 28. The tape ends 11, it will be noted, completely conceal the joints 16, and preferably have their terminals secured to their respective edge walls 3 below the flaps 15, as best illustrated in Figures 23, 32 and 33.

In Figures 35, 36 and 37 there is shown a bag closure in which the bag top walls are folded in a manner similar to that illustrated in Figures 23 to 34, except that the triangular flaps 15—*a* are not folded downwardly into flat-wise relation with their respective edge walls 3, and secured thereto, as shown in Figures 32 and 33. In the form shown in Figures 35 to 37, the tip 17 of each flap 15—*a*, shown in dotted lines in Figures 36 and 37, is folded inwardly against the body of the flap, after having a strip of tape 9—*d* secured to the upper edges of the bag top walls, whereby the end portions 11 of the tape are folded into bonding engagement with the bottoms of the flaps simultaneously as the tip portions 17 of the flaps are folded under, as will be understood by reference to Figure 35. The terminals of the sealing tape may be extended downwardly below the top 18 of the bag body, as shown in Figures 35 and 37, whereby the flaps 15—*a*, which may serve as carrying handles for the filled bag, are greatly strengthened.

An important feature of the form of closure illustrated in Figures 35, 36 and 37, resides in the fact that the bag top walls need not be adhered together by an adhesive, as the sealing tape 9—*d* with its end portions 11 securely bond together the bag top walls in a manner to completely seal the bag top against leakage, as will readily be understood by reference to Figures 35 and 36.

It will also be noted, by reference to the drawings, that the construction of the carrying handles or flaps 15—*a* is such that the contents of the bag cannot leak or filter therefrom, even though the filled bags be roughly handled. By extending the ends 11 of the tape downwardly and securing them to the upper portions of the bag body, as shown in Figures 35 and 37, the tape, in addition to providing the only sealing means for the closed bag top, also greatly reinforces the carrying flaps or handles 15—*a*, whereby relatively large bags may readily and conveniently be handled by grasping the flaps 15—*a*, without danger of fracturing the bag walls and causing leakage. Because of the flexibility of the flaps 15—*a*, they may readily be folded into flat-wise relation to the top or edge walls of the bag body, when desired, to facilitate shipping and storage.

In Figures 38, 39 and 40, there is shown a bag closure similar to the one shown in Figures 35 to 37, inclusive, except that the flaps 15—*b* which provide carrying handles for the filled bags, do not have their tips 17 folded under, as in Figures 35 to 37.

In the form shown in Figures 38, 39 and 40, the sealing tape 9—*e* has its end portions 11 folded around the tips 17 of the flaps 15—*b*, whereby the joints 19 between the contiguous wall edges of the upper folded portions of the edge walls are completely and thoroughly sealed against leakage, as will readily be understood by reference to Figures 38 and 39. It will also be noted, by reference to Figure 40, that the terminal ends 11—*c* of the tape ends do not extend downwardly into engagement with the edge walls of the bag body, as in Figure 37, but are secured directly to the bottom faces of the flaps. They may, however, be extended downwardly, as shown in Figure 37, if desired, thereby to strengthen or reenforce the flaps 15—*b*.

In the forms shown in Figures 35 to 40, inclusive, a suitable adhesive may be interposed between the plies of the carrying flaps 15—*a* or 15—*b*, as indicated at 20 in Figure 39, but for most purposes, this has been found unnecessary.

The various forms of bag closures herein disclosed are particularly applicable to larger sizes of bags, although it is to be understood that they may be used for small bags with equal results. The various forms illustrated are closely related in that in each closure, portions of the bag top walls are folded to provide right-angle triangular corners, the only difference between them residing in the manner of folding the corners of the bag tube ends. By folding the walls of the bag top or tube end into closing and sealing relation, as herein disclosed, the bag closures, when completed, will be substantially leak tight, whereby there is little or no danger of any of the contents of the filled bag bodies sifting through the closed ends thereof, even though the bags may be roughly handled.

It will be apparent to those skilled in the art that I have accomplished at least the principal objects of my invention, and it will also be apparent to those skilled in the art that the embodiments herein described may be variously changed and modified, without departing from the spirit of the invention, and that the invention is capable of uses and has advantages not herein specifically described.

I claim as my invention:

1. The method of closing and sealing an open end of a flexible walled tubular bag body, which consists in pressing the walls of the bag end into flat-wise relation with the edge walls intucked between the side walls, whereby the flattened bag end is provided at each side edge with juxtaposed corners each comprising at least two plies, adhering together the plies of each corner, folding said juxtaposed corners against their respective side walls along diagonal fold lines and adhering them thereto, said diagonal fold lines being so disposed that said corners will be located within the perimeter of the bag end, when the bag body is filled, and subsequently folding a strip of tape over the edges of the flattened bag end walls and said folded corners and adhering it thereto.

2. The method of closing and sealing an open end of a flexible walled tubular bag body, which consists in pressing the walls of the bag end into flat-wise relation with the edge walls intucked between the side walls, whereby the flattened bag end is provided at each side edge with juxtaposed corners each comprising at least two plies, adhering together the plies of each corner, folding said juxtaposed corners against their respective side walls, along diagonal fold lines which are so disposed that said corners will be located within the perimeter of the bag end when the bag body is filled, and subsequently folding a strip of tape over the edges of the flattened bag end walls and said folded corners with the ends of the tape adhered to the intucked edge walls of the bag end.

3. The method of closing and sealing an open end of a flexible walled tubular bag body, which consists in pressing the walls of the bag end into flat-wise relation with the edge walls intucked between the side walls, whereby the flattened bag end is provided at each side edge with juxtaposed corners each comprising at least two plies, adhering together the plies of each corner, fold-

ing said juxtaposed corners against their respective side walls along diagonal fold lines and adhering them thereto, said diagonal fold lines being so disposed that said corners will be located within the perimeter of the bag end, when the bag body is filled, and subsequently folding a strip of tape over the edges of the flattened bag end walls and said folded corners with the ends of the tape secured directly to the edge walls of the bag end below said inwardly folded corners.

4. The method of closing and sealing an open end of a flexible walled tubular bag body, which consists in pressing the walls of the bag end into flatwise relation with the edge walls intucked between the side walls whereby the flattened bag end is provided at each side with juxtaposed corners, each comprising at least two plies, folding each juxtaposed corner upon itself along a diagonal fold line which fold lines are so disposed that said corners will be located within the perimeter of the sealed bag end, when the bag body is filled, and subsequently folding a strip of tape over the flattened bag end walls and said folded corners and adhering the tape thereto.

5. The method of closing and sealing an open end of a flexible walled tubular bag body, which consists in pressing the walls of the bag end into flatwise relation with the edge walls intucked

between the side walls whereby the flattened bag end is provided at each side with juxtaposed corners, each comprising at least two plies, adhering together the plies of each corner, folding each juxtaposed corner upon itself along a diagonal fold line which fold lines are so disposed that said corners will be located within the perimeter of the sealed bag end, when the bag body is filled, and subsequently folding a strip of tape over the flattened bag end walls and said folded corners and adhering the tape thereto.

6. The method of closing and sealing an open end of a flexible walled tubular bag body, which consists in pressing the walls of the bag end into flatwise relation with the edge walls intucked between the side walls whereby the flattened bag end is provided at each side with juxtaposed corners, each comprising at least two plies, adhering together the plies of each corner, folding each juxtaposed corner upon itself along a diagonal fold line which fold lines are so disposed that said corners will be located within the perimeter of the sealed bag end, when the bag body is filled, and adhering it in such position, and subsequently folding a strip of tape over the flattened bag end walls and said folded corners and adhering the tape thereto.

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