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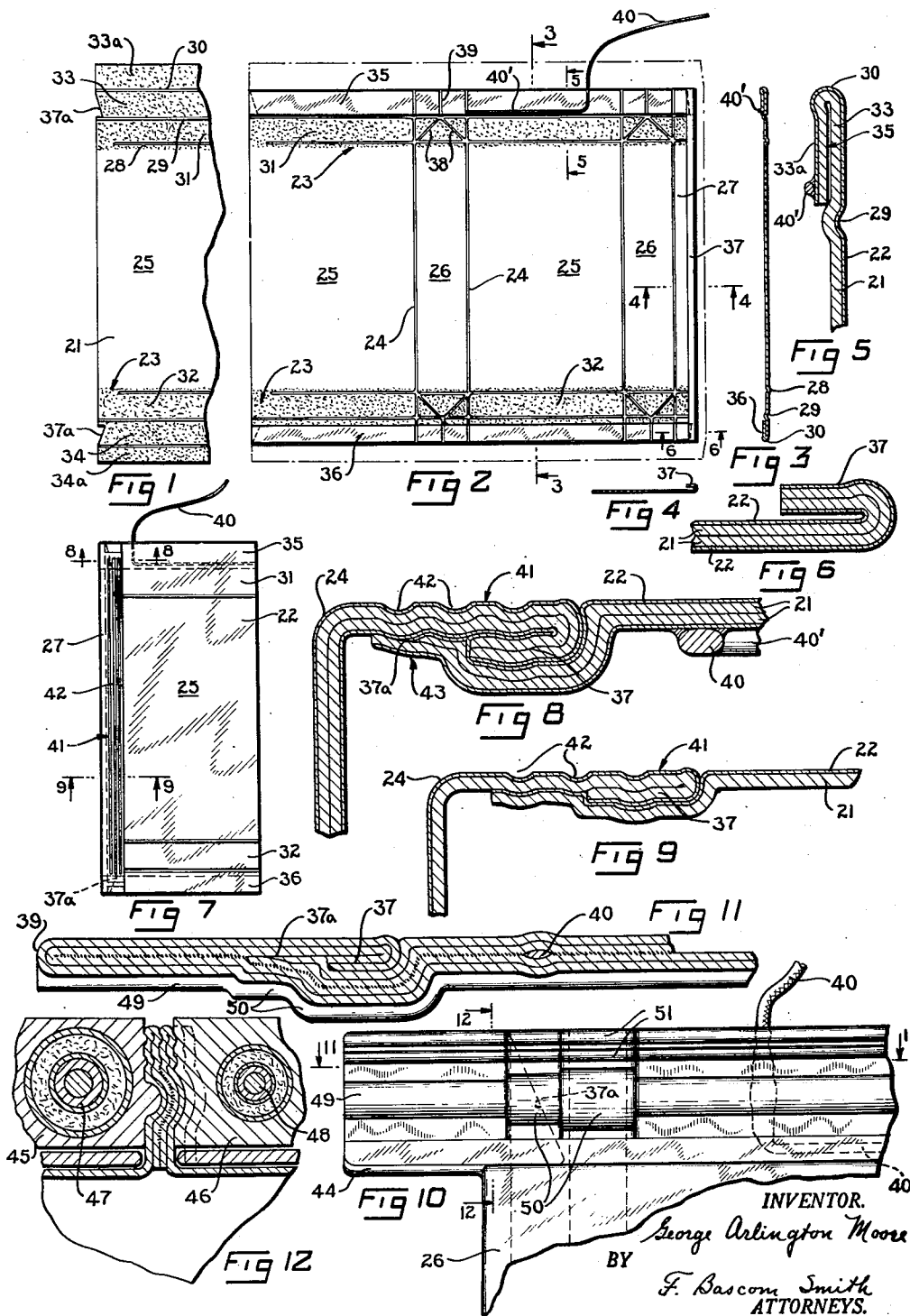
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CONTAINER AND METHOD OF MAKING THE SAME

Filed Aug. 16, 1938

2 Sheets-Sheet 1



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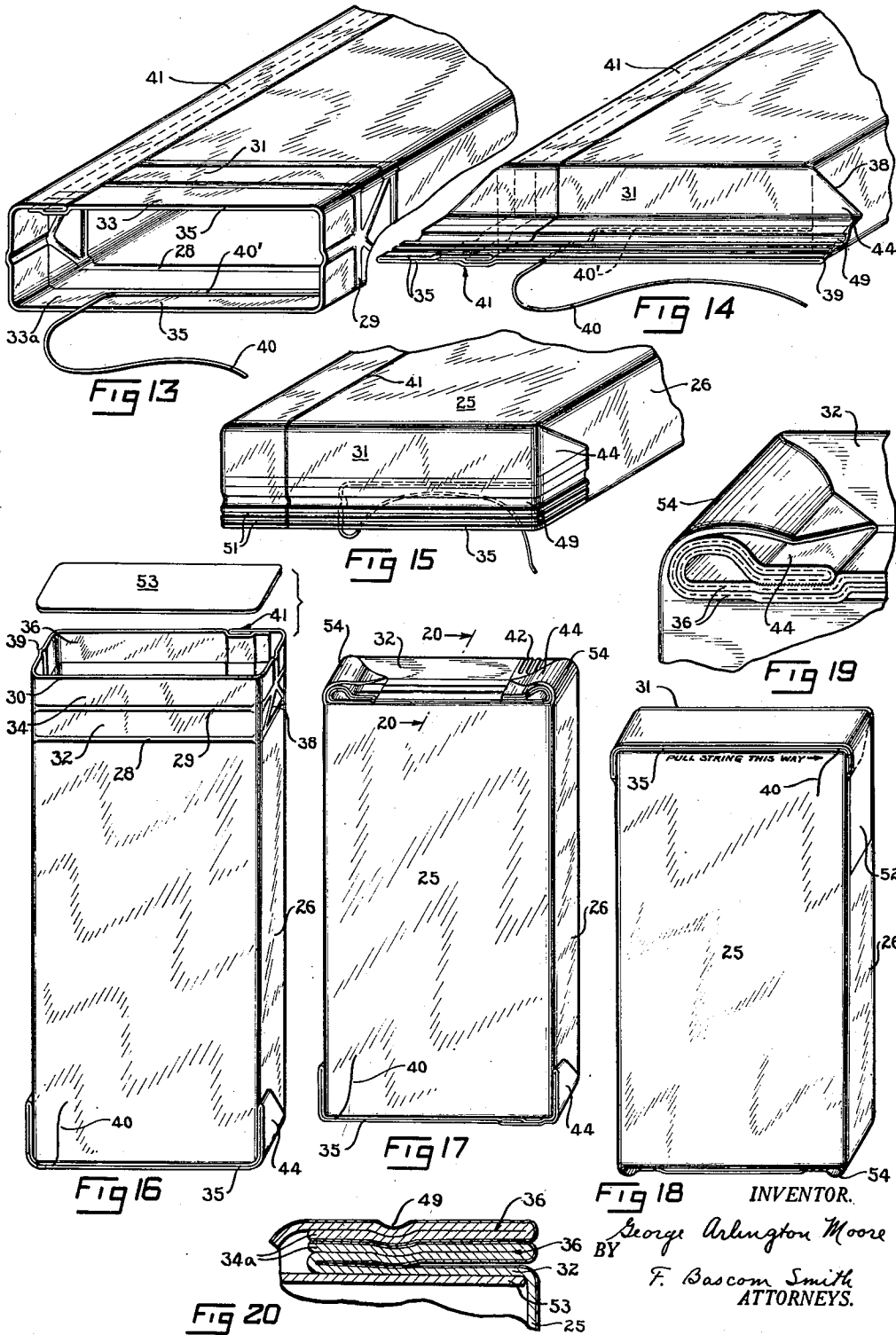
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UNITED STATES PATENT OFFICE

2,268,668

CONTAINER AND METHOD OF MAKING THE SAME

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18 Claims. (Cl. 93—36)

This invention relates to containers of the type formed from a folded blank, and to methods and means for making the same. The invention is particularly applicable to containers of the type used for packaging tobacco and similar products which must be shipped and sold in hermetically sealed containers that are adapted to be opened readily by the user without destroying the package.

Such a container may be made from a laminated blank comprising a layer of fibrous material, such as paper, and a layer of impervious material, such as metal foil, a resinous plastic or the like. The impervious layer may be disposed on the inside of the container, or, if disposed on the outside, the marginal edges of the blank may be intumed to provide metal-to-metal seams or joints which may be sealed by suitable thermoplastics such as a thermoplastic lacquer. The container may be opened by pulling the end seam apart so as to break the thermoplastic bond and may be again closed, but not sealed, by refolding the ends. Various forms of containers of this general type and means and methods for making the same are disclosed in detail in my prior applications Serial Nos. 153,705 and 173,101, filed July 15, 1937, and November 6, 1937, respectively, and now issued as Patents Nos. 2,214,172 and 2,229,864, respectively.

This construction is well suited to certain types of materials and provides a moisture-proof container in which tobacco or the like may be kept for long periods of time without change in the moisture content thereof. It has been found, however, that when the container is made of thin, fragile material, such as thin metal foil and paper, there is a tendency for said material to tear when the container is being opened by parting the end closure seam, particularly if the container is sealed by a strong thermoplastic bond.

It is accordingly an object of the present invention to provide a novel and improved means for opening a container without danger of damaging or tearing the thin fragile material from which it is made.

Another object is to provide a novel method for making a substantially hermetic container from fragile materials which may be readily opened without tearing said materials.

Another object is to provide novel and improved opening means which is arranged and adapted to break the strong adhesive bond necessary for such a container closure seam with-

out applying excessive stress to and damaging the material of the container.

Still another object is to provide a novel method for making a container embodying a firm closure seam and means for readily parting said seam.

A further object is to provide an opening device which is impervious to moisture and does not wick moisture by capillary action into or out of the container.

A further object is to provide an opening device of the above type which is so conveniently arranged and is so apparent that it will be readily observed and used by the customer without previous instructions.

A still further object is to provide a novel and improved opening device which may be attached to the blank before the container is formed without necessitating the complications of mechanism which would materially increase the expense of making the container.

Another object is to provide a novel and improved opening device of the above type which may be entirely or substantially concealed when the container is closed and sealed, whereby it does not detract from the neat appearance of the container and is not exposed so that the container might be opened accidentally.

A further object is to provide a novel and improved container of the above type which may be made of thin fragile material, may be sealed with a strong bond, and may be easily opened by an unskilled person without destroying the material of the container.

Another object is to provide a novel method for anchoring a string or the like to metallic or fibrous materials.

The above and further objects and novel features of the invention will more fully appear from the following description when the same is read in connection with the accompanying drawings. It is to be expressly understood, however, that the drawings are for the purpose of illustration only and are not intended as a definition of the limits of the invention, reference for this latter purpose being had primarily to the appended claims.

In the drawings, wherein like reference characters refer to like parts throughout the several views,

Fig. 1 is a development of a portion of the inner surface of a blank which may be employed in making one form of container comprehended by the present invention;

Fig. 2 is a plan view of said blank with the

initial folds therein and novel opening means applied thereto, the original outline of the blank being shown by construction lines;

Figs. 3 and 4 are sectional views taken on lines 3—3 and 4—4, respectively, of Fig. 2;

Figs. 5 and 6 are detail sectional views, on an enlarged scale, taken on lines 5—5 and 6—6, respectively, of Fig. 2;

Fig. 7 is a side elevation of a tubular body formed from the blank of Fig. 2;

Figs. 8 and 9 are detail sectional views, on an enlarged scale, showing different portions of the side seam of said body, the sections being taken on lines 8—8 and 9—9, respectively, of Fig. 7;

Fig. 10 is an enlarged detail view, with parts broken away, showing a portion of said body and an end closure seam therefor in side elevation;

Fig. 11 is an enlarged detail view of said end closure seam, partly in section and with parts broken away, the section being taken on line 11—11 of Fig. 10;

Fig. 12 is a detail view, on an enlarged scale and with parts broken away, showing a vertical section of said end closure seam and means for forming the same, the section through the seam being taken on line 12—12 of Fig. 10;

Fig. 13 is an enlarged scale isometric view of a portion of an open ended body made from the blank of Fig. 2;

Fig. 14 is a similar view after the formation of the top closure seam;

Fig. 15 is also a similar view showing the top closure seam folded down against the body;

Fig. 16 is an isometric view of the container in inverted position ready for having a flat supporting closure inserted therein after being filled with its contents;

Fig. 17 is an isometric view of a completed container in inverted position to show the bottom thereof;

Fig. 18 is an isometric view of the complete container in upright position;

Fig. 19 is a detail isometric view, on an enlarged scale and with parts broken away, of one corner of the bottom of the container when the latter is in inverted position as seen in Fig. 17; and,

Fig. 20 is a detail sectional view, on an enlarged scale and with parts broken away, of the bottom closure seam, the section being taken on line 20—20 of Fig. 17.

In the following description and in the claims, certain specific terms are used for convenience in referring to various details of the invention. It is to be understood, however, that these terms are to be given as broad an interpretation as the state of the art will permit.

Referring to the embodiment of the invention shown in the drawings, the blank, as shown in Figs. 1 to 5, is composed of an inner layer of fibrous material 21, such as paper or the like, and an outer layer of impervious material 22, such as sheet aluminum foil, tin foil, or other metallic or non-hygroscopic material. It is to be understood that the layers may be of any desired relative thickness and that they may be secured together throughout their entire areas by a suitable adhesive, such as an adhesive which will not crystallize but will have a degree of flexibility adapted to prevent cracking or flaking when the blank is folded. An adhesive made by combining latex and casein has proved satisfactory for this purpose.

Fibrous lamina 21 after being secured to the foil is preferably treated in a novel manner for

the purpose of rendering the fibrous component thereof less absorbent and to lubricate the fibres of said component, thereby facilitating the fabricating process. Said lamina is first coated with a suitable film of wax and then baked until the surface thereof is completely dry and free of wax. This baking process impregnates the fibrous layer and produces a surface capable of receiving films of lacquer or other suitable thermoplastic adhesive material. The layer of impervious material 22 may thereafter be wholly or partially coated with a thin, dry film of thermoplastic lacquer having adhesive properties, such as Beckwith-Chandler Co. lacquer No. 017308, for example, the solids content of which is about 26%. This lacquer has the property of forming a protective film over the surface of the foil and producing a gloss, and at the same time is heat fusible so that superposed surfaces can be joined readily by suitable application of heat and pressure to form an impervious seam. The upper and lower margins of lamina 21 may also be striped, as indicated at 23, with a dry film of thermoplastic adhesive material which is so constituted that it will not have too strong an affinity for the lacquer on foil 22 and hence cause the blanks to adhere to each other at normal factory temperatures and hinder the fabricating process. It has been found that "Pliolite," a chlorinated rubber product, is a suitable substance for this latter purpose.

In preparing blank 21, 22 for folding, the same may be embossed or creased to provide a plurality of fold lines, such for example, as transverse lines 24 which divide the blank longitudinally into wide and narrow panels 25 and 26, adapted to form the side walls of a rectangular container, and an end section or tab 27. Longitudinal lines or grooves 28, 29 and 30 may be disposed parallel to each other and the upper and lower edge of the blank to form top and bottom closure sections 31 and 32, respectively, and top and bottom seam sections 33, 33a and 34, 34a, respectively. Sections 33a and 34a are folded inwardly along grooves 30 into overlapping relation with sections 33 and 34, respectively to thereby form top and bottom sealing flanges or hems 35 and 36 (Fig. 2). The margin of section 27 is also folded inwardly to form a hem 37 and sections 33 and 34 are notched at 37a for purposes to appear hereafter. Diagonal lines 38 may be disposed between lines 28 and 29 on the panels 26 of the blank and transverse lines 39 may extend from the intersection of the diagonal lines 38 to the edges of the blank. These lines 38 and 39 facilitate the proper folding of the top and bottom sealing flanges 35 and 36 in a manner to be hereinafter described.

In order to provide means for readily opening the container to be formed from blank 21, 22, a novel opening device is attached in a novel manner to the inside of hem 35, preferably while the blank is in the partially folded condition illustrated in Fig. 2. In the embodiment shown, this opening device comprises a flexible strip of fibrous material, such as a string 40, a portion of which extends longitudinally of the blank and is disposed at a point near fold line 29 on the portion of sealing flange 35 which forms, in effect, a continuation of one of the side panels 25. String 40 is preferably of a strong grade, such as cotton twine treated with a thermoplastic lacquer in order to render the same substantially moisture or wick proof to prevent moisture from

being wicked by capillary action into or out of the container thereby. The lacquer may be applied to string or cord 40 in a novel manner by first passing the same through a bath of lacquer solvent, such, for example, as acetone, or through a lacquer thinner suitable for use in combination with the lacquer used. While in this saturated state, the string is passed through a bath of the selected lacquer, preferably a nitro-cellulose lacquer having thermoplastic adhesive properties. Beckwith-Chandler's lacquer No. 017,308 has been found suitable for this purpose. After coating the string with lacquer, the same is thoroughly dried and preferably respooled for the attaching machine. The lacquer coated string is then attached to the metallic foil component 22 of blank 21, 22 in the position illustrated in Fig. 2 by the application of suitable heat and pressure. The lacquer coatings on the string and foil constitute prime surfaces which are rendered tacky by heat and pressure and thereby effect a strong bond or anchorage between the string and the material. The pressure also serves to flatten the portions of string 40 acted upon, thereby increasing its retaining surface.

The blank, when thus prepared, is first folded about a mandrel along transverse lines 24 to form a tubular body, as shown in Fig. 7, the end tab 27, 37 being folded into overlapping relation with the opposite end of the blank and joined thereto to form a lapped body seam 41. The overlap is preferably such that the foil surface of hem 37 will engage the foil side of the opposed end of the blank, thereby forming a metal-to-metal longitudinal body seam. The engaging surfaces of seam 41 are preferably joined by applying heat and pressure to activate the thermoplastic coating on the foil component 22. A dry film of thermoplastic adhesive, such as Pliolite, may also be applied to the paper component of tab 27 for securing the engaging surfaces of hem 37 together and for assisting in the sealing of seam 41. In order to insure the impermeability of seam 41 and to make it easier to withdraw the sealing iron, the latter is provided with ribs for pressing longitudinally extending flutes 42 into said seam. Preferably the application of pressure and heat during the formation of seam 41 extends only to the inner edges of hems 35 and 36 so that the lacquer film on the inner surfaces of the latter will not be affected. As best seen at 43 in Fig. 8, notches 37a serve to provide a gradual reduction transversely, in the thickness of the end portions of the seam 41, which end portions include hems 35 and 36. This reduction of thickness is obtained without interrupting the inner foil surface of said hems, and materially facilitates the formation of the impervious end closure seams to be hereinafter described.

One or both ends of the body thus formed may be closed by folding the marginal portions 31, 35 (or 32, 36) of sides 25 inwardly about fold lines 28 and 39 and outwardly about fold line 29, thereby forming a two-part end wall 31, 31 and bringing the inner metallic surfaces of opposed halves of hem 35 into engagement, as best seen in Fig. 14, to form a projecting end closure flange 35, 35. At the same time, the blank folds inwardly along lines 38 and outwardly along portions of lines 28 to form laterally projecting triangular tabs 44. String 40 is thus disposed between engaging portions of hem 35 that form the top closure seam, a portion 40' of said string extending parallel to the top of the container and another portion ex-

tending outwardly and being accessible for opening the container in a manner to be described. It will be noted that string 40 is preferably so positioned on blank 21, 22 that it does not pass into or across the longitudinal body seam 41.

The opposed halves of sealing flange 35 may be imperviously sealed together and, hence, imperviously close the upper end of the container by the application of heat and pressure to activate the thermoplastic coating on the engaging metallic surfaces thereof. Heat and pressure may be applied for the above purpose by means of sealing irons 45 and 46 (Fig. 12) which, for the best results, are maintained at different temperatures, such as approximately 450° F. and 300° F., respectively, by suitable electric heating elements 47 and 48. The differential in temperatures insures a proper flow of heat through seam 35, 35 quick and sufficient activation of the sealing medium, and quick setting of the adhesive after retraction of sealing irons 45 and 46. The latter are preferably provided with one or more complementary ribs and grooves for embossing closure tab 35, 35 as indicated at 49 (Figs. 10 and 14). Embossed groove or rib 49 may extend parallel to the end of the container and the embossing groove in female sealing iron 46 is preferably radially enlarged for receiving the extra thicknesses where seam 41 passes through seam 35, 35 as at 50, thereby insuring a substantially even application of pressure throughout the length of the latter seam and hence insure an hermetic closure. The closure seam may also be embossed at 51, if desired, to afford additional assurance of a tight seam. Irons 45 and 46 are also slightly relieved to allow for string 40 where the latter passes through seam 35, 35, (Fig. 11), in order to prevent any cutting of the foil or paper thereby when pressure is applied. The string is flattened considerably, however, by the sealing pressure and possibility of leakage along the same is removed by a caulking of lacquer thereabout.

After flange or tab 35, 35 has been sealed in the manner above described, it may be folded flat against the top wall 31 of the container, as illustrated in Fig. 15, with the major portion of the free end of string 40 tucked thereunder. The projecting ends of said flange or tab and triangular tabs 44 are then bent downwardly against the walls 26 and secured in position either by adhesively tacking the same in place, or by a revenue stamp 52 or the like (Fig. 18) which may be placed over the entire top and may extend beyond the turned down tabs 44.

When the top of the container has been sealed in the above manner the same is filled with the desired contents through the open bottom end thereof, and a flat secondary closure 53 (Fig. 16) is then inserted in said open end to the plane of bending line 29. Thereafter the bottom of the container is closed and hermetically sealed by seam 36, 36 in the same manner as the top, the flat closure 53 serving as an internal support during the folding operation. Secondary closure 53 not only acts to support the container body for orderly manipulations of the folds, but also serves as a foundation upon which tabs 44 may be pressed when the same are tacked in place. It also serves as a firm base for the finished container thereby preventing crushing of the end thereof and insuring a firm rectangular foundation on which the container may set in upright position. To afford further assurance that the filled container will stand upright, tabs 44 at the

bottom thereof are folded inwardly and adhesively tacked against the end of the container in a manner to provide a bulge or leg 54 at each corner (Fig. 17). Also, by controlling the folding of the multiple ply tabs 44 to provide bulges 54, any danger of breaking the foil component during the 180° bend is substantially obviated.

The particular way in which the blank is folded to form the body and end closures is more fully set forth in the copending applications above referred to and it is to be understood that the present invention is applicable to the various embodiments set forth therein. While the container has been shown for purposes of illustration as formed from a laminated blank with a layer of metal foil on the outside, it is to be understood that the blank could be folded with the metal foil on the inside, if desired. In that event, however, it would be unnecessary to form top and bottom hems 35 and 36 and the string 40 would be attached to the inner metal foil surface adjacent the upper margin of the body.

When a container embodying the present invention is to be opened for dispensing the contents thereof, the revenue stamp 52 is first broken and the ends of sealing flange 35, 35 together with end tabs 44 are bent upwardly into the plane of the top wall 31, 31. The flange 35, 35 is then bent into upstanding position, as shown in Fig. 14, and the free end of string 40 is grasped by the fingers and pulled outwardly or in the direction indicated by printed instructions on the package. (Fig. 18.) As the string is pulled between the juxtaposed flanges 35, the thermoplastic bond, at least in the area above the horizontal leg 40' of the string, is cleanly severed or sheared without any tearing of or damage to the material constituting the container. During this opening or shearing operation the inner end of the string is firmly anchored, by the lacquer coatings on it and foil layer 22, to at least one of the flanges 35, thereby obviating any danger of the string being pulled out without breaking the seal between flanges 35. The two separated flanges 35 may then be grasped by the fingers and pulled apart to break the remainder of the seal and expose the contents of the container. In this way, the seal is easily broken without rupturing or tearing the material, even though the latter be comparatively weak and fragile and a strong thermoplastic bond be employed for making the seal. The container may be again temporarily closed, without sealing, by refolding the top in the manner above described.

In lieu of treating string 40 as a single strand and then respooling the same when dry, the treating process may be carried out while the string is spooled. The spool of string may be placed under a vacuum and successively dipped in the lacquer solvents and the lacquer. The spool may then be removed from the vacuum and dried ready for use.

The above-described container is light in weight and sufficiently flexible to be readily and comfortably carried in the consumer's pocket, and yet is airtight, durable and highly efficient in preventing transfer of moisture between the contents thereof and the atmosphere. In one form, the container is entirely closed by metal-to-metal seams. The string which is used for breaking the seal is disposed between the upstanding flanges and does not contact with the contents of the container. In order to provide a tight seal around the string where it passes through the

end closure seam and to avoid any wicking of moisture by the string, the same is impregnated and coated, in a novel manner, with thermoplastic lacquer or its equivalent, as above described. The thermoplastic lacquer also insures a strong bond or anchorage between the string and the metal foil, thereby preventing the string from pulling out except in the manner intended for breaking the end closure seal. The string adheres firmly to the blank and easily withstands all of the handling necessary to the fabrication of the blank into a complete container. When treated and attached in the manner above described, the string does not in any way interfere with the maintenance of an air-tight, moisture-proof seal. The string may be easily applied without materially increasing the cost of the container and the proper manipulation thereof is obvious to the customer without previous instructions. The construction accordingly provides a cheap, compact and efficient container for tobacco or the like which can be hermetically sealed but can be easily opened without injury to the fragile material thereof.

Although only one embodiment of the invention has been illustrated and described, it is to be expressly understood that the invention is not limited thereto. Various changes may be made, for example, in the particular materials and examples specified, without departing from the spirit and scope of the invention, as will be readily understood by persons skilled in the art. For a definition of the limits of the invention, reference is had primarily to the appended claims.

What is claimed is:

1. In the container making art, the method which comprises applying a thin coating of a thermoplastic substance having adhesive properties to the surface of a blank of sheet material, applying a thermoplastic substance having adhesive properties to a strand of fibrous material, securing said strand to a coated portion of said blank by the application of heat and pressure, folding said blank to form a container, and applying heat and pressure to form a closure seam for said container extending across a portion of said strand so that the ends of the latter are on opposite sides of said seam.

2. In the container making art, the method which includes applying a thin, dry film of thermoplastic lacquer to a metallic surface, coating a strand of fibrous material with a thermoplastic lacquer, securing a portion of said strand to said surface by the application of heat and pressure, disposing said surface in juncture-forming relation with a similar surface, and applying heat and pressure to activate said lacquer for adhesively joining said surfaces along a line which extends across said strand.

3. A container comprising a body having an end closure seam, the engaging surfaces of which are joined by a thermoplastic adhesive, and a strand of material having a moisture-proof, thermoplastic substance applied thereto adhesively secured to one of said surfaces inside the container adjacent the inner edge of said seam and extending through said seam, a free end of said strand extending outside of the container.

4. A container comprising a body having an end closure seam formed by joining engaging surfaces with a thermoplastic substance having adhesive properties, and means for readily separating said surfaces including a moisture-proof

cord having a portion secured to one of said surfaces inside the container at one side of said seam and a portion extending through said seam to the outside of the container.

5. A container having a metal-to-metal closure seam embodying a thermoplastic substance having potential adhesive qualities, and means for readily separating the engaging surfaces of said seam comprising a cord secured to said container interiorly of said seam and having a portion extending between said surfaces and outside of the container, said cord being coated with a moisture-proof, thermoplastic substance having adhesive properties, and said thermoplastic substances being blended together in the seam to render the latter substantially impervious to air and moisture.

6. A container made from a laminated blank comprising a layer of fibrous material and a layer of impervious material, said blank being folded to form a tubular body, the top portion of said blank being folded inwardly to close the top and thence upwardly to form a pair of juxtaposed upstanding sealing flanges, the blank being folded so that the impervious layers of said sealing flanges are in contact, adhesive means between said sealing flanges sealing the same together, and an elongated fibrous member interposed and secured between said sealing flanges and having a free end extending to the outside thereof, said fibrous member having a coating of thermoplastic lacquer and being adapted to be progressively pulled from between said flanges so as to break the adhesive seal whereby the container may be readily opened without damage by tearing or breaking the material thereof.

7. A container made from a laminated blank comprising a layer of fibrous material and a layer of impervious material, said blank being folded to form a tubular body, the top portion of said blank being folded inwardly to close the top and thence upwardly to form a pair of juxtaposed upstanding sealing flanges, the blank being folded so that the impervious layers of said sealing flanges are in contact, a thermoplastic adhesive interposed between said sealing flanges and sealing the same together and a string interposed and secured between said sealing flanges, a portion of said string extending along said flanges parallel to said top and another portion extending to the outside of said container, said string having a thermoplastic lacquer coating and being adapted to be progressively pulled from between said flanges so as to break the adhesive seal.

8. A container made from a laminated blank comprising a layer of fibrous material and a layer of impervious material, said blank being folded to form a tubular body, the top portion of said blank being folded inwardly to close the top and thence upwardly to form a pair of juxtaposed upstanding sealing flanges, the blank being folded so that the impervious layers of said sealing flanges are in contact, a thermoplastic adhesive interposed between said sealing flanges and sealing the same together and a string interposed and secured between said sealing flanges, a portion of said string extending along said flanges parallel to said top and another portion extending to the outside of said container, said string being impregnated with a thermoplastic lacquer whereby wicking of moisture into or out of the container thereby is prevented and being adapted to be progressively pulled from between said flanges so as to break the adhesive seal.

9. A container made from a laminated blank comprising a layer of fibrous material and a layer of impervious material, said blank being folded to form a tubular body, a marginal portion at an end of said body being folded inwardly to close the same and thence upwardly to form a pair of juxtaposed upstanding sealing flanges, said marginal portion being folded so that the impervious layers of said sealing flanges are in contact, a string having a portion extending longitudinally between said flanges substantially parallel to the edge of said flanges and thence extending outwardly beyond said edges, thermoplastic adhesive means securing said flanges together and securing said string thereto, a portion of said flanges being compressed to form a groove extending longitudinally thereof and crossing a portion of said string whereby a strong bond is obtained and wicking of moisture into and out of said container is prevented, said string being adapted to be progressively pulled from between said flanges so as to separate the latter and open the container.

10. A container made from a laminated blank comprising a layer of paper and a layer of metal foil, said blank being folded to form a tubular body, the ends of said blank being folded to form an overlapped side seam having a metal-to-metal contact and being sealed by a coating of thermoplastic adhesive, the ends of said container being closed by infolding the blank to form sealing flanges with the layers of foil in the juxtaposed flanges in contact, a string interposed between the flanges, one end of said string having a portion extending along said flanges and another portion extending to the outside of the container, said string and said flanges being secured together by a thermoplastic adhesive, said string being coated with a thermoplastic material and being adapted to be progressively pulled from between said flanges so as to break the adhesive seal for opening the container.

11. A blank for making a moisture-proof container comprising a layer of paper and a layer of metal foil secured thereto, and a string coated with a thermoplastic material and attached to said metal foil in a position to extend between the sealing flanges of the finished container and adapted to be used for breaking the bond therebetween for opening the container.

12. The method of making a moisture-proof container which comprises joining a layer of fibrous material and a layer of impervious material to form a blank, applying a coating of thermoplastic material to said layer of impervious material, coating a string with a thermoplastic material, attaching said string to said layer of impervious material by the application of heat and pressure, and folding the blank to form a container having top sealing flanges between which said string extends and sealing said flanges by the application of heat and pressure to effect a moisture-proof closure which may be broken by pulling said string therefrom.

13. The method of making a blank for forming a moisture-proof container which comprises joining a layer of fibrous material and a layer of impervious material, impregnating a string with a solvent, passing the saturated string through a bath of thermoplastic lacquer, drying the same and attaching said string to said layer of impervious material by the use of heat and pressure in a position such that the string is adapted to extend through a closure seam of the

completed container for use in breaking the seal thereof.

14. In combination, a blank comprising fibrous material for making a container, a thin, dry film of thermoplastic material having adhesive properties on one surface of said blank and a second thin, dry film of another thermoplastic material having adhesive properties on the other surface of said blank, said films of thermoplastic materials having relatively little affinity for each other at normal atmospheric temperatures.

15. A container comprising a body having an end closure seam formed by joining engaging surfaces with a thermoplastic substance having adhesive properties, and means for readily separating said surfaces including an elongated non-wicking element having a portion secured to one of said surfaces inside the container adjacent the inner edge of said seam and a portion extending through said seam to the outside of the container.

16. A container comprising a body having an end closure seam formed by joining engaging surfaces with a thermoplastic lacquer having potential adhesive properties, and means for readily separating said surfaces to open said container including a strand coated with thermoplastic lacquer, the lacquer in said seam and on

said strand being the same, said strand having a portion thereof secured to one of said surfaces adjacent the inner edge of said seam and a portion thereof extending through said seam to the outside of the container.

17. A container comprising a body having an end closure seam formed by joining engaging surfaces with a substance having adhesive properties, and means for readily separating said surfaces including an elongated element having a portion secured to one of said surfaces inside the container adjacent the inner edge of said seam and a portion extending through said seam to the outside of the container.

18. In combination, a blank comprising fibrous material for making a container, a thin, dry film of thermoplastic material having adhesive properties on one surface of said blank, and a thin, dry film of another thermoplastic material having adhesive properties on the other surface of said blank, the affinity of one of said films of thermoplastic material for the other of said films at normal factory temperatures being insufficient to result in the sticking together of adjacent contacting blanks during the process of fabricating containers therefrom.

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