

July 15, 1952

J. D. CRARY

2,603,407

HANDLED CONTAINER AND METHOD OF MANUFACTURE

Filed June 2, 1948

2 SHEETS—SHEET 1

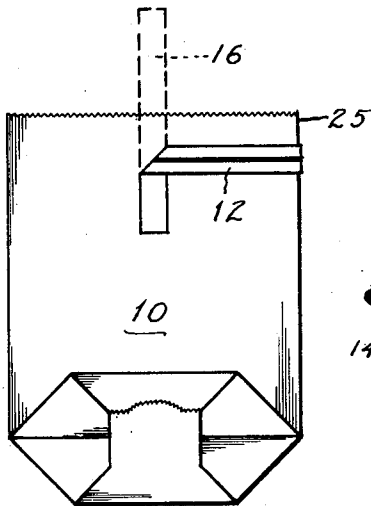


Fig 1

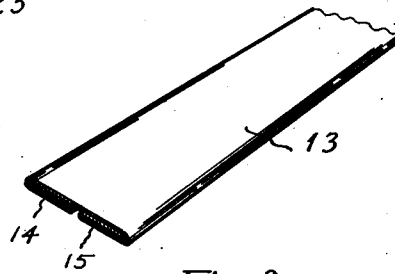


Fig 2

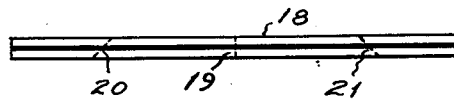


Fig 3

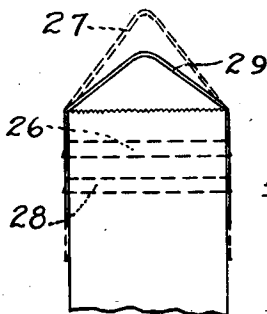


Fig 5

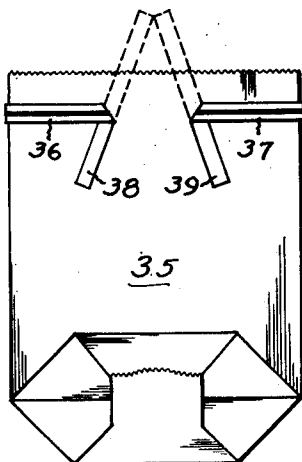


Fig 6

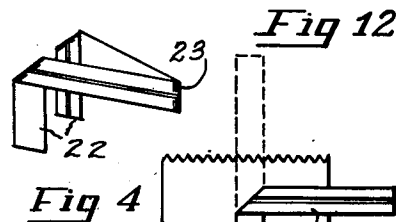


Fig 4



Fig 7

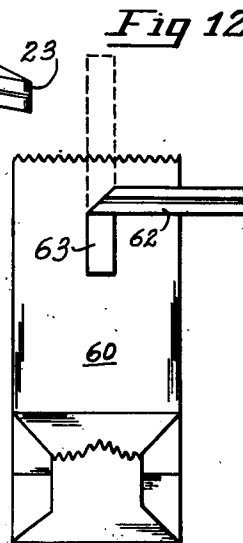


Fig 12

INVENTOR.
Jay D. Crary
BY *E. G. Bussan*
ATTORNEY

July 15, 1952

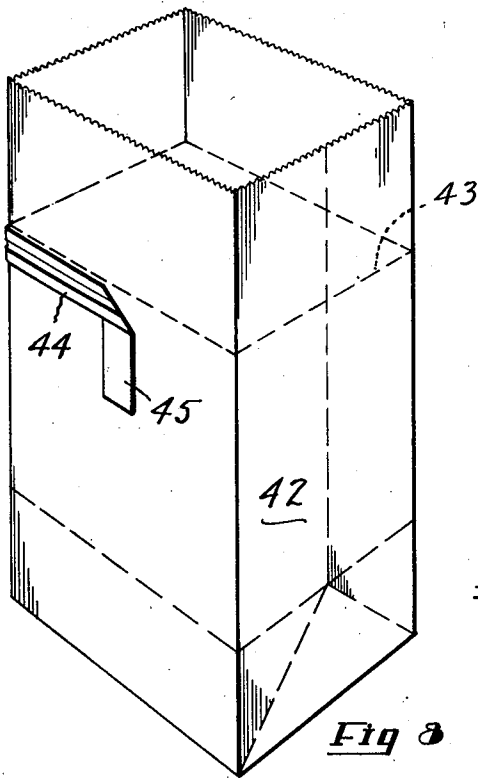
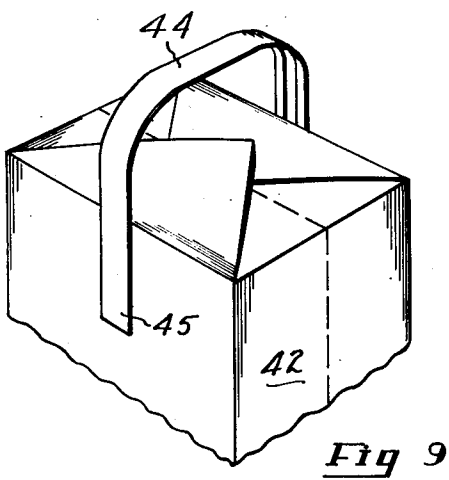
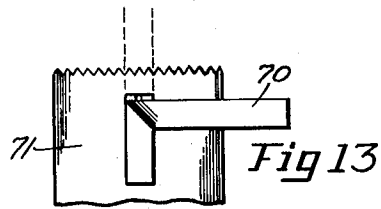
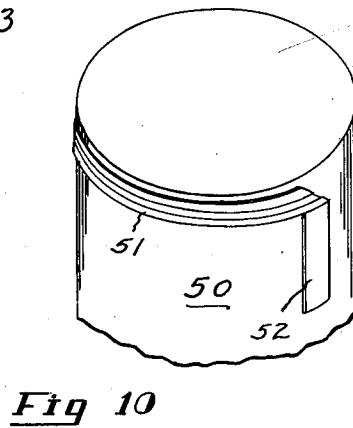
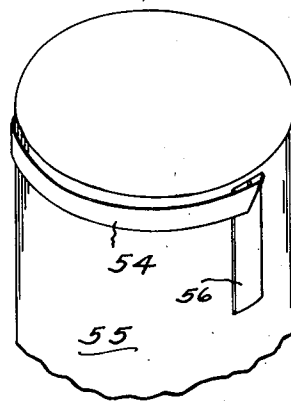
J. D. CRARY

2,603,407

HANDLED CONTAINER AND METHOD OF MANUFACTURE

Filed June 2, 1948

2 SHEETS—SHEET 2



Jay D. Crary
INVENTOR.

BY *E. G. Buchanan*
ATTORNEY

UNITED STATES PATENT OFFICE

2,603,407

HANDLED CONTAINER AND METHOD OF
MANUFACTUREJay D. Crary, Portland, Oreg., assignor to Paper
Strap Incorporated, Portland, Oreg., a corpo-
ration of Oregon

Application June 2, 1948, Serial No. 30,566

15 Claims. (Cl. 229—54)

1

This invention relates to handled containers such as paper bags, packages, cartons and the like.

The present application is a continuation-in-part of my copending application Serial Number 561,665, filed November 3, 1944 and assigned to the same assignee as the present application and now abandoned.

It is a general object of the present invention to provide a new and improved handle and container arrangement in which the handle is of an extremely simple and inexpensive construction and which is firmly attached to the container in a particular manner so that in the inoperative position it fits snugly against the side wall of the container so as not to interfere with the filling thereof, and which may readily be shifted to an operative position to form a bail by which the filled container may conveniently be carried.

A further object of the invention is to provide a new and improved method of attaching a handle to a container.

In the drawings, Fig. 1 is a side elevation illustrating a paper bag having a handle attached thereto in accordance with one form of the present invention; Fig. 2 is an enlarged fragmentary view illustrating a portion of strap from which the handle shown in Fig. 1 is formed; Fig. 3 is a view illustrating a length of strap prior to folding thereof for attachment to the bag; Fig. 4 is a view in perspective illustrating the strap of Fig. 3 in the folded condition ready for attachment to the bag; Fig. 5 is an end view of a bag illustrating certain features in connection with the method of attachment of the handles to the bag; Fig. 6 is a view of a bag illustrating an arrangement of handles thereon according to a second modification of the invention; Fig. 7 is a view in perspective illustrating a handle folded and in readiness for attachment to a bag in accordance with the modification of Fig. 6; Fig. 8 is a view in perspective of a bag having a handle attached thereto in accordance with a further modification of the invention; Fig. 9 is a fragmentary view illustrating the bag of Fig. 8 in the closed condition; Figs. 10 and 11 are fragmentary views in perspective illustrating containers other than bags having handles attached thereto in accordance with still different forms of the present invention; Fig. 12 is a view of a bag of substantially the same type and size as that shown in Fig. 1 but having the vertical end walls folded inwardly, and Fig. 13 is a fragmentary view illustrating a handle folded as shown in Fig. 11, but applied to a paper bag.

Referring now to the drawings in Fig. 1 is

2

shown a paper bag 10 in the folded condition and having a handle 12 attached to the upper end thereof. While not essential to the practice of the present invention it is preferred that the handle 12 be formed of paper. A section of paper strap is shown at 13 in Fig. 2 consisting of an elongated paper strip having its opposite marginal edge portions folded over upon itself a plurality of times throughout the entire length of the strip as indicated at 14 and 15. The folded portions 14 and 15 have a width somewhat less than one-half of the total width of the strap so that the folded portions lie flat against one side of the strip in a non-overlapping relation. The folded edge portions provide any desired strength for the strap depending upon the number of folds contained therein, the opposite edges being rounded which together with the flat configuration of the strap provides a comfortable grip for the hand even when carrying a relatively heavy load. In the attachment of the strap onto an article the folded side of the strap is secured against the surface of the article so that unfolding of the opposite edge portions will be precluded.

In Fig. 3 a length of paper strap 18 is shown with a central right angular score or fold line indicated at 19 and a pair of oppositely extending 45 degree scores or fold lines at 20 and 21 toward the opposite ends. Referring to Fig. 4 the vertically extending end portions 22 are folded to positions substantially coplanar with the intermediate strap portions next adjacent thereto and in such directions that the sides of the strap having the folded edge portions thereon face each other which surfaces are adapted to be coated with adhesive and pressed against opposite sides of the bag. The distance between the right angularly folded end portions 22 and the central fold, or apex 23, of the handle preferably corresponds substantially with the distance from the side edge of the bag, in the flat folded condition as shown in Fig. 1, to the longitudinal center line thereof.

In the attachment of the handle to the bag no additional reinforcement of the opposite side walls of the bag is required and by so adjusting the length of the strap end portions which are to be adhesively secured to the surface of the bag any desired degree of strength of attachment may be secured. In this regard it is pointed out that it is desirable that the legs 22 of the handle strap extend longitudinally of the bag, that is, in the vertical plane of the bail portion of the handle when in the operative position.

Attention is further directed to the fact that the end portions 22 of handle 12 are preferably attached to the side walls of the bag 10 a slight distance downwardly from the uppermost edge thereof. This is advantageous for numerous reasons. It will be observed that with the bail portion of the handle extending laterally to the side edge of the bag below the upper end thereof, as shown in full line in Fig. 1, it will be necessary for the uppermost corner indicated at 25 to be folded over or pushed in, before the bail can be raised to the upright or vertical operative position. With the handle extending in the inoperative position it will be retained in such a position by the corner 25 against any tendency toward movement to the upright position. After the bag has been filled, of course, the handle can then be raised to the operative position shown by dotted lines 16 over the upper corner 25 of the bag which may be pushed inwardly sufficiently to permit the handle to be raised therepast.

It will also be observed that with the handle attached to the opposite sides of the bag a distance below the uppermost edge thereof the top of the bail portion in the raised position may be kept reasonably close to the upper end of the bag. This may best be illustrated by reference to Fig. 5 in which the dotted lines 25 indicate a handle attached adjacent the uppermost edge of the bag and which when raised extends in an operative position as indicated by the lines 27. Such a handle might be too long for a child or short person. By attaching the handle below the upper edge of the bag as indicated by the lines 28 then when raised to the operative position as indicated at 29 it will be conveniently short to make the carrying of the bag more satisfactory. It will thus be apparent that, while the length of the strap portion between the opposite adhesively fastened end portions is at least as great as one-half the circumferential distance around one side of the bag, the length of the strap portion between the upper end edges of the bag, as viewed in Fig. 5, is substantially less than one-half the circumferential distance around one side of the bag.

A further, important reason for attachment of the handle end portions 22 below the upper edge of the bags is that the attachment operation by automatic machinery is greatly simplified. If it were attempted to press the adhesive coated end portions 22 against the opposite side walls of the bag closely adjacent the upper edges thereof, there would be a danger for some of the adhesive to be squeezed over the upper edges of the bag and thus seal the opposite upper edge portions together. Critical adjustment of the handle and bag feeding mechanisms is not required where the end portions 22 are brought into engagement with the opposite bag side walls a considerable distance below the upper edges.

For heavy duty bags such as those designed for prolonged use or use for a plurality of times, such as shopping bags, a more rugged handle arrangement might be preferred. As illustrated in Fig. 6 the bag 35 is provided with a pair of handles 36 and 37 each of which are attached to the opposite side walls of the bag by leg portions 38 and 39 respectively. It will be observed that the distance between the upper ends of the leg portions 38 and 39 is less than the distance between the lower ends thereof so that the apices of the bails of the two handles lie closely adjacent each other in the upright or operative position. When the two handles are grasped in one hand the line of pull through each will ex-

tend linearly through the leg portions 38 and 39 toward the lowermost end corners of the bag. By this arrangement a pair of handles may be used to greatest advantage in providing a bag structure of great strength and utility. In the case of a heavy duty bag of this type it may be desirable to fold in the uppermost end of the bag in order to strengthen the edge. In Fig. 7 is shown a handle preformed for attachment to the bag 35 in the manner as previously described. In this instance the leg portions are folded at an angle less than 90 degrees with respect to the bail portion while the bail portions are of a decreased length corresponding to the distance between the directly opposite points of anchorage of the handle legs which, as previously mentioned, may be determined by the spacing between the two handles on opposite sides of the vertical center line of the bag.

The invention has been described thus far with particular regard to open ended bags, that is, bags which are not intended or adapted to be sealed closed at their upper ends. In Figs. 8 and 9 is illustrated a further modification of the invention as applied to a bag which is adapted to be filled and then sealed closed such as bags commonly used for packaging sugar, flour, dry beans and the like goods. The bag 42 is adapted for being filled to a predetermined level as indicated by the dotted line 43 with a measured quantity of material. A handle 44 is attached to diametrically opposite points on the bag by the legs 45 in much the same manner as previously described except that in this case, the point of attachment is spaced upon the bag slightly below the filling line 43. It will be observed that the handle will not in any way interfere with the normal filling, folding and sealing of the bag which operations are usually accomplished by automatic machinery. The filled and sealed packages will normally be shipped and distributed with the handles extending in the inoperative position for greater convenience. The merchant in placing the packages upon the display table will normally raise the handles to the operative position as illustrated in Fig. 9 to place them in readiness for pick-up by the customer.

It will be recognized that the bag 42 illustrated in Figs. 8 and 9 is of the bellows or in-folded side type while the bags 10 and 35 of Figs. 1 and 6 are of the flat or square type. In Fig. 12 the bag 60 is of the same size as the bag 42, but is shown in the bellows folded condition and with a handle 62 attached to the upper end in approximately the same relative position as in the case of Fig. 1. It is pointed out that in the inoperative position and with the bag folded, the end of the handle will extend beyond the side edge of the bag by a distance corresponding to substantially one half of the width of the inwardly folded wall as shown in full line in Fig. 12. As in the case of the previously described modifications the length of the handle between the leg portions 63 corresponds substantially to the peripheral distance around the side of the bag in the unfolded condition between the points of attachment, and as indicated in Fig. 8.

In the attachment of the handles to square bags as shown in Figs. 1 and 6, the folded strap is moved relatively to a straddling position over the bag until the end 23 of the folded handle engages with the side edge of the bag. Obviously this method must be modified for adaptation to bellows type bags as shown in Fig. 12. In the latter case, the handle will have to be ad-

5

justed to a straddling position relative to the bag with the central folded end thereof spaced from the side edge of the bag and held in such position while the angularly folded opposite end portions are attached to the outer side walls of the bag in the desired position.

From the descriptions given above it will be obvious that the handles of the invention and method of attachment may equally well be applied to packages, containers, cartons, or even unpackaged articles as illustrated further in Figs. 10 and 11. In Fig. 10 is illustrated in article 50 of cylindrical configuration, which, for example may be a metal can, glass jar, or even an unpackaged solid article. Attached to the upper end of the article 50 is a handle 51 the depending legs 52 of which are secured such as by adhesive to diametrically opposite points of the article 50. The bail portion of the handle 51 fits snugly around the side of the article below the upper edge thereof where it is retained until its use is required when it may readily be shifted to the upright or operative position.

From Fig. 10 it will be observed that the bail portion of the handle is folded through a single 45 degree turn from the leg portion 52 or, in other words, the bail portion of the handle is in effect turned inside out in the inoperative position. It will, of course, be obvious that this particular fold is not essential and in the modification of Fig. 11 a handle 54 is shown attached to an article 55 of cylindrical configuration but which is folded in a different manner. The leg portions 56 of the handle 54 are secured as before by a suitable adhesive to diametrically opposite points of the article 55 in a downwardly depending relation. The bail portion of the handle instead of being turned inside out is folded downwardly to the inoperative position by a double fold adjacent the leg portion. In Fig. 13, a handle 70, similar to the handle 54, is shown attached to the upper end of a paper bag 71 of a type, for example, similar to that illustrated in Fig. 12.

From a perusal of the foregoing specification, it will be obvious that it is not essential to the practice of the present invention that the opposite end portions of the handle straps be preformed, or folded, to a position extending at right angles to the longitudinal direction of the midportion of the handle strap prior to attachment of the handles onto the bags. If desired, the handle strap may merely be doubled endwise upon itself and the opposite end portions of the handle strap adhesively attached to the opposite outer side walls of the collapsed bag in the position illustrated by dotted lines 16 in Fig. 1. It is essential, however, that the length of the intermediate portion of the handle, that is, the length of the handle strap between the adhesively fastened end portions be at least as great as the circumferential distance around one side of the container between the points of attachment whereby the handle may be folded, such as upon the score lines 20 and 21, to the inoperative position as shown and described. It is also an important feature of the present invention that the opposite end portions be adhesively fastened to the opposite outer side walls of the collapsed bag in such a position that the uppermost end of the adhesive film is spaced a substantial distance below the uppermost end edges of the bag and also that the length of the intermediate portion of the handle strap between the uppermost end edges of the bag and with handle in the operative position is sub-

6

stantially less than the circumferential distance around the side of the bag between the points of attachment of the end portions. With the handle secured to the bag in this manner, it may be folded to an inoperative position extending around the side of the bag so as to permit wide opening of the bag mouth and providing free access thereto while, with the handle in the operative position, the bail or grip portion is relatively close to the upper end of the bag as illustrated in Fig. 5 of the drawings.

Reference is made to my copending application Serial No. 171,512, filed June 30, 1950, entitled Handled Containers, which copending application is a continuation-in-part of the parent application Serial No. 561,663, filed November 3, 1944, the latter application having been abandoned. The above-mentioned copending application discloses and claims the generic idea of a container having an edgewise folded paper strap carrying handle attached thereto.

Having described the principle of the invention in what are considered to be preferred embodiments thereof, it is desired that it be understood that the various specific forms shown are merely illustrative and that the invention may be carried out in other ways.

What I claim as my invention is:

1. The combination comprising a paper bag, a strap defining a handle for said bag, said strap being doubled endwise upon itself substantially at the center, the end portions of said doubled strap being preformed by folding in the same direction at right angles to the intermediate portion of said strap, said end portions being substantially coplanar with said intermediate portion of said strap next adjacent thereto, said end portions of said strap being adhesively fastened to the bag surface and in a downwardly depending relation from the upper end thereof, the upper end of said folded end portions being spaced below the uppermost end of the bag, the length of the intermediate portion of said strap corresponding substantially to the distance between the point of fastening of said end portions and the side edge of said bag.

2. The combination comprising a paper bag, a strap defining a handle for said bag, said strap consisting of a strip of paper having opposite marginal edge portions folded upon itself a plurality of times throughout the full length thereof, said handle being doubled endwise upon itself, the opposite end portions of said strap being folded in the same direction substantially at right angles with respect to the intermediate portion, said end portions being substantially coplanar with the intermediate portion of said strap next adjacent thereto, said end portions being secured to the opposite side walls of said bag on the outer surfaces thereof and below the uppermost ends of said bag substantially along the longitudinal center line thereof, the folded surface of said strap being next adjacent the surface of said bag, the length of the intermediate portion of said strap corresponding substantially to the distance between the center and the side edge of said bag so that in the assembled position the intermediate portion of said handle extends around the side of said bag.

3. A combination comprising a paper bag, straps defining a pair of handles for said bag, said straps each being doubled endwise upon itself and having the end portions folded in the same direction extending substantially at right angles with respect to the intermediate portion, said

end portions being substantially coplanar with the intermediate portion of said strap next adjacent thereto, said end portions of each of said straps being fastened to the outer surface of each of the opposite sides of said bag in a spaced apart relation with respect to the longitudinal center line of the bag, the intermediate portion of said straps extending around opposite edges of said bag, the length of the intermediate portion of said straps corresponding substantially to the distance between the points of fastening of said handles and the adjacent side edge of said bag.

4. The combination comprising a container, a paper strap defining a handle for carrying said container, the opposite ends of said strap being folded substantially at right angles with respect to the intermediate portion thereof, said end portions being substantially coplanar with said intermediate portion of said strap next adjacent thereto, said end portions being secured to the outer surface of said container at diametrically opposite points and below the uppermost end thereof, the intermediate portion of said handle fitting relatively closely around the side of said container in an inoperative position and being movable to an operative position extending across the upper end of said container.

5. The method of attaching a strap handle to a folded paper bag which comprises doubling a length of strap endwise upon itself, folding the end portions of said strap in the same direction to a position substantially coplanar with and substantially at right angles to the intermediate portion next adjacent said end portions, applying adhesive to the facing surfaces of said folded end portions, moving said folded handle over the side edge of the folded bag adjacent the upper end thereof until the folded end of said intermediate handle portion abuts the side edge of said bag, and pressing said folded end portions of said strap into an engagement with the opposite sides of said bag for adhesively uniting said end portions thereto.

6. The method of attaching a handle to a container comprising the steps of folding the ends of a paper strap in the same direction to a position substantially coplanar with and substantially at right angles to the intermediate portion next adjacent said end portions, adjusting said folded strap against the side of a container until said strap fits snugly thereagainst adjacent the upper end thereof and securing said folded end portions to the opposite outer surfaces of said container.

7. The method of attaching a handle to a container comprising the steps of doubling a length of paper strap endwise upon itself, folding the end portions of said strap in the same direction to a position substantially coplanar with and substantially at right angles to the intermediate portion thereof next adjacent said end portions, the length of said intermediate portion corresponding substantially to one half of the circumference of said container adjacent the upper end portion thereof, moving said handle around the side of said container adjacent the upper end thereof until said intermediate handle portion fits relatively snugly against the side of said container, attaching said end portions in a depending relation to diametrically opposite points of said container, said handle being shiftable to an operative position extending above the upper end of said container and in an aligned relation with respect to said end portions.

8. The method of attaching a handle to a con-

tainer comprising the steps of doubling a length of paper strap endwise upon itself, folding the end portions of said strap in the same direction to a position substantially coplanar with and substantially at right angles to the intermediate portion thereof next adjacent said end portions, the length of said intermediate portion corresponding substantially to one-half of the circumference of said container adjacent the upper end portion thereof, moving said handle relatively to a straddling position with respect to said container adjacent the upper end thereof, attaching said end portions in a depending relation to central diametrically opposite points of said container, said handle being shiftable to an operative position extending above the upper end of said container and in an aligned relation with respect to said end portions.

9. An article of commerce consisting of a collapsed bag, a length of paper strap consisting of a strip of relatively thin, tough paper folded edgewise upon itself a plurality of times throughout its entire length, said length of paper strap being of uniform width throughout its entire longitudinal extent, a fold line extending at right angles transversely of said strap intermediate the opposite ends thereof, said strap being doubled endwise upon itself about said fold line, the corresponding strap portions on each of the opposite sides of said fold line being aligned with each other in a superposed parallel relation, said doubled strap handle being substantially coplanar with said collapsed bag throughout the full extent thereof whereby a plurality of said handled bags may be compactly stacked flatwise upon each other, the opposite end portions of said strap being secured to the outer surface of a pair of opposite side walls of said bag in a downwardly depending relation from the upper end thereof, a film of adhesive binding each of said opposite end portions of said strap onto said bag side walls, the upper ends of said adhesive films being spaced below the upper end edges of said bag side walls, the length of the strap between said upper ends of said adhesive films being at least as great as the distance around one side of the bag between the points of attachment of said end portions to said bag side walls, said strap defining a handle for said bag and which in the operative position extends across the upper end of said bag, the length of the intermediate strap portion between the upper end edges of said bag, with said handle in the operative position, being less than said distance around said one bag side.

10. An article of commerce consisting of a paper bag in collapsed condition and having opposed side walls lying closely adjacent each other, a handle at the mouth end of the bag, said handle consisting of a strip of relatively thin, tough paper folded longitudinally upon itself a plurality of times throughout its entire length so as to constitute a multiple ply flat strap of uniform width, said strap having one end thereof extending longitudinally and centrally of the outer surface of one of the side walls of the bag and its other end extending longitudinally and centrally of the outer surface of the other side wall of the bag, an adhesive film between a substantial portion of each end of said strap and the adjacent outer surface of the bag, said adhesive films providing the sole means for securing the handle to the outer surfaces of said bag, said adhesive films terminating a substantial distance below the mouth edges of said side

walls whereby accidental bonding together of said mouth edges is precluded, and said strap being folded upon itself midway between its secured ends so that the unsecured portions thereof lie flat in substantially the same plane as that of said collapsed bag whereby said article is capable of being stacked flat with a plurality of similar articles.

11. An article of commerce consisting of a collapsed paper bag, a length of paper strap consisting of a strip of relatively thin, tough paper folded edgewise upon itself a plurality of times throughout its entire length, said length of paper strap being of uniform width throughout its entire longitudinal extent, a fold line extending at right angles transversely of said strap intermediate the opposite ends thereof, said strap being doubled endwise upon itself about said fold line, the corresponding strap portions on each of the opposite sides of said fold line being aligned with each other in a superposed parallel relation, said doubled strap handle being substantially coplanar with said collapsed bag throughout the full extent thereof whereby a plurality of said handled bags may be compactly stacked flatwise upon each other, the opposite end portions of said strap being secured to the outer surface of a pair of opposite side walls of said bag and in a downwardly depending relation from the upper end thereof, a film of adhesive bonding each of said opposite end portions of said strap onto said bag side walls, the upper ends of said adhesive films being spaced substantially below the upper end edges of said bag side walls whereby accidental bonding together of the upper end edges of said bag side walls is precluded.

12. The method of manufacturing handled bags which comprises folding a strip of relatively thin, tough paper longitudinally edgewise upon itself a plurality of times throughout its entire length to form a multiple ply paper strap of uniform width, doubling a predetermined length of said strap endwise upon itself, applying films of tacky adhesive to the one flat surface of each of the opposite end portions of said length of strap, said adhesive films facing each other in the doubled condition of said length of strap, moving a collapsed, folded paper bag relatively to said length of strap to a position such that the mouth end of said bag extends between said end portions and said strap end portions being aligned with the longitudinal center line of the opposite outer side walls of said bag and the extremities of said end portions extending toward the bottom of said bag, the upper ends of said adhesive films being spaced below the mouth edges of said bag side walls, and applying pressure to said end portions of said length of strap to press the same into engagement with the opposite outer side walls of said bag and maintaining such pressure until said adhesive films have set for bonding said strap end portions to said bag, said doubled length of paper strap defining a handle which, in the folded condition of said bag, extends substantially coplanar with said bag.

13. An article of commerce consisting of a collapsed paper bag, a length of relatively wide flat paper strap of uniform width throughout its length defining a handle for carrying said bag, a fold line extending at right angles transversely across said strap intermediate the opposite ends thereof, said strap being doubled endwise upon itself about said fold line, the cor-

responding strap portions on each of the opposite sides of said fold line being aligned with each other in a superposed parallel relation, said doubled strap handle being substantially coplanar with said collapsed bag throughout the full extent thereof whereby a plurality of said handled bags may be compactly stacked flatwise upon each other, adhesive films securing the opposite end portions of said strap length to the outer surface of a pair of opposite side walls of said bag in a downwardly depending relation from the upper end thereof, the upper ends of said adhesive films being spaced below the uppermost end of said bag whereby accidental sealing together of the bag mouth by said adhesive films is precluded.

14. An article of commerce consisting of a collapsed paper bag, a length of relatively wide flat paper strap of uniform width throughout its length defining a handle for carrying said bag, a fold line extending at right angles transversely of said strap intermediate the opposite ends thereof, said strap being doubled endwise upon itself about said fold line, the corresponding strap portions on each of the opposite sides of said fold line being aligned with each other in a superposed parallel relation, said doubled strap handle being substantially coplanar with said collapsed bag throughout the full extent thereof whereby a plurality of said handled bags may be compactly stacked flatwise upon each other, adhesive films securing each of the opposite end portions of said strap length to the outer surface of a pair of opposite side walls of said bag in a downwardly depending relation from the upper end thereof, the upper ends of said adhesive films being spaced below the uppermost end of said bag whereby accidental sealing together of the bag mouth by said adhesive films is precluded, the length of said strap between said adhesively fastened end portions being at least as great as the distance around one side of said bag between the points of attachment of said end portions, the length of the strap portion between the upper end edges of said bag side walls with the handle extending over the top of the bag being substantially less than the distance around said one side of said bag, said handle strap being foldable adjacent each of said opposite adhesively fastened end portions along lines extending transversely across the strap at substantially 45° angles between an operative position extending across the top of the bag and an inoperative position extending around one side of the bag.

15. The method of manufacturing handled bags which comprises doubling a predetermined length of strap endwise upon itself, applying films of tacky adhesive to the one flat surface of each of the opposite end portions of said length of strap, said adhesive films facing each other in the doubled condition of said length of strap, moving a collapsed, folded paper bag relatively to said length of strap to a position such that the mouth end of said bag extends between said end portions and said strap end portions being aligned with the longitudinal center line of the opposite outer side walls of said bag and the extremities of said end portions extending toward the bottom of said bag, the upper ends of said adhesive films being spaced below the mouth edges of said bag side walls, and applying pressure to said end portions of said length of strap to press the same into engagement with the opposite outer side walls of said bag and

11

maintaining such pressure until said adhesive films have set for bonding said strap end portions to said bag, said doubled length of paper strap defining a handle which, in the folded condition of said bag, extends substantially coplanar with said bag.

JAY D. CRARY.

REFERENCES CITED

The following references are of record in the file of this patent:

UNITED STATES PATENTS

Number	Name	Date
356,093	Blowers	Jan. 18, 1887

Number
1,354,253
1,406,148
1,829,533
1,837,652
2,021,787
2,233,799
2,272,462

12

Name	Date
House	Sept. 28, 1920
Brandenberger	Feb. 7, 1922
Ondricek	Oct. 27, 1931
Choate	Dec. 22, 1931
Janowitz	Nov. 19, 1935
Seifer et al.	Mar. 4, 1941
Hanford	Feb. 10, 1942

FOREIGN PATENTS

Country	Date
France	Oct. 24, 1906