



(12) **DEMANDE DE BREVET CANADIEN
CANADIAN PATENT APPLICATION**

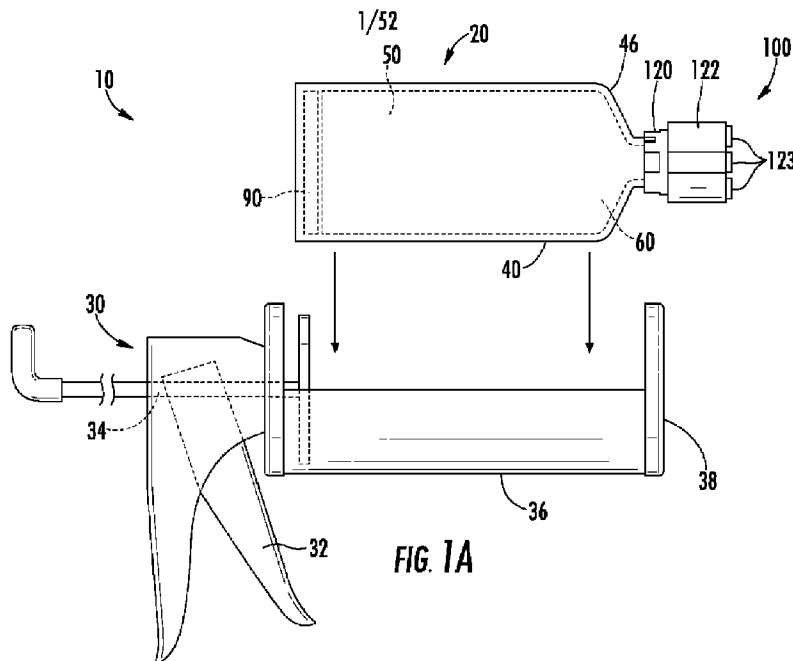
(13) **A1**

(86) Date de dépôt PCT/PCT Filing Date: 2015/07/22
(87) Date publication PCT/PCT Publication Date: 2016/02/04
(85) Entrée phase nationale/National Entry: 2017/01/26
(86) N° demande PCT/PCT Application No.: US 2015/041539
(87) N° publication PCT/PCT Publication No.: 2016/018694
(30) Priorités/Priorities: 2014/07/28 (US62/029,679);
2015/02/05 (US62/112,338); 2015/04/21 (US62/150,360);
2015/06/04 (US62/170,732)

(51) Cl.Int./Int.Cl. *B05C 17/01* (2006.01),
B65B 61/00 (2006.01), *B65D 33/00* (2006.01),
B65D 47/10 (2006.01), *B65D 75/00* (2006.01),
B65D 83/00 (2006.01)
(71) Demandeur/Applicant:
CRYOVAC, INC., US
(72) Inventeurs/Inventors:
COMPTON, STEPHEN F., US;
COOK, HUBERT J., US;
CARROUTH, ANDREW B., US;
BOWEN, JOE MILTON, US;
KISS, CSABA FRANK, US;
ACKERMAN, DAVID L., US;

(54) Titre : SYSTEME DE DISTRIBUTION, SYSTEME D'EMBALLAGE, EMBALLAGE, SYSTEME DE FERMETURE,
SYSTEME DE PISTOLET DE DISTRIBUTION, PROCEDE DE FABRICATION D'UN EMBALLAGE ET PROCEDE DE
DISTRIBUTION D'UN PRODUIT

(54) Title: DISPENSING SYSTEM, PACKAGING SYSTEM, PACKAGE, CLOSURE SYSTEM, DISPENSING GUN
SYSTEM, METHOD OF MAKING A PACKAGE, AND METHOD OF DISPENSING A PRODUCT



(57) **Abrégé/Abstract:**

The present invention includes a dispensing system for dispensing a packaged product, e.g. a condiment, including a pouch (60) having the product therein cooperates with a dispensing gun (30) to dispense a dose of product. In various aspects the invention includes a packaging system that includes a container (40) and a flexible package (50) with a frangible seal (70), and a flexible pouch (60); a dispensing assembly (100) for dispensing a product from the package; a dispensing gun system; a method of making a package; and a method of dispensing a product. The packaging system includes a container such as a rigid sleeve, and a flexible pouch positioned within the container interior, and also includes a valve that enables the product to exit the pouch interior and be dispensed. An optional diffuser coordinates with the valve to dispense product from one or more product outlets.

(72) **Inventeurs(suite)/Inventors(continued)**: CALVERT, STEVEN T., US; CAUDLE, TIMOTHY G., US;
MOEHLENBROCK, ANDREW W., US; CONNER, H. DEAN, US

(74) **Agent**: SMART & BIGGAR

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property
Organization
International Bureau(10) International Publication Number
WO 2016/018694 A3(43) International Publication Date
4 February 2016 (04.02.2016)

(51) International Patent Classification:

B31B 1/00 (2006.01) *B65D 83/00* (2006.01)
B65B 61/00 (2006.01) *B65D 47/10* (2006.01)
B65D 75/00 (2006.01) *B05C 17/005* (2006.01)
B65D 33/00 (2006.01) *B05C 17/01* (2006.01)

(21) International Application Number:

PCT/US2015/041539

(22) International Filing Date:

22 July 2015 (22.07.2015)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

62/029,679	28 July 2014 (28.07.2014)	US
62/112,338	5 February 2015 (05.02.2015)	US
62/150,360	21 April 2015 (21.04.2015)	US
62/170,732	4 June 2015 (04.06.2015)	US

(71) Applicant: **CRYOVAC, INC.** [US/US]; 100 Rogers Bridge Rd., Post Office Box 464, Duncan, SC 29334 (US).(72) Inventors: **COMPTON, Stephen, F.**; 107 Brian Drive, Spartanburg, SC 29307 (US). **COOK, Hubert, J.**; 209 Asheton Springs Way, Simpsonville, SC 29681 (US). **CARROUTH, Andrew, B.**; 3628 Highway 148, Woodruff, SC 29388 (US). **BOWEN, Joe, Milton**; 102 SussexWay, Anderson, SC 29625 (US). **KISS, Csaba, Frank**; 6 Farming Creek Drive, Simpsonville, SC 29681 (US). **ACKERMAN, David, L.**; 125 Ridgeway Drive, Greenville, SC 29607 (US). **CALVERT, Steven, T.**; 15 Cranston Court, Simpsonville, SC 29681 (US). **CAUDLE, Timothy, G.**; 403 Rockland Drive, Simpsonville, SC 29681 (US). **MOEHLENBROCK, Andrew, W.**; 121 Mustang Circle, Simpsonville, SC 29681 (US). **CONNER, H., Dean**; 112 Old Bridges Road, Mauldin, SC 29662 (US).(74) Agents: **QUATT, Mark, B.** et al.; Cryovac, Inc., 100 Rogers Bridge Rd., Post Office 464, Duncan, SC 29334 (US).(81) Designated States (*unless otherwise indicated, for every kind of national protection available*): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IR, IS, JP, KE, KG, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.(84) Designated States (*unless otherwise indicated, for every kind of regional protection available*): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, ST, SZ,

[Continued on next page]

(54) Title: DISPENSING SYSTEM, PACKAGING SYSTEM, PACKAGE, CLOSURE SYSTEM, DISPENSING GUN SYSTEM, METHOD OF MAKING A PACKAGE, AND METHOD OF DISPENSING A PRODUCT

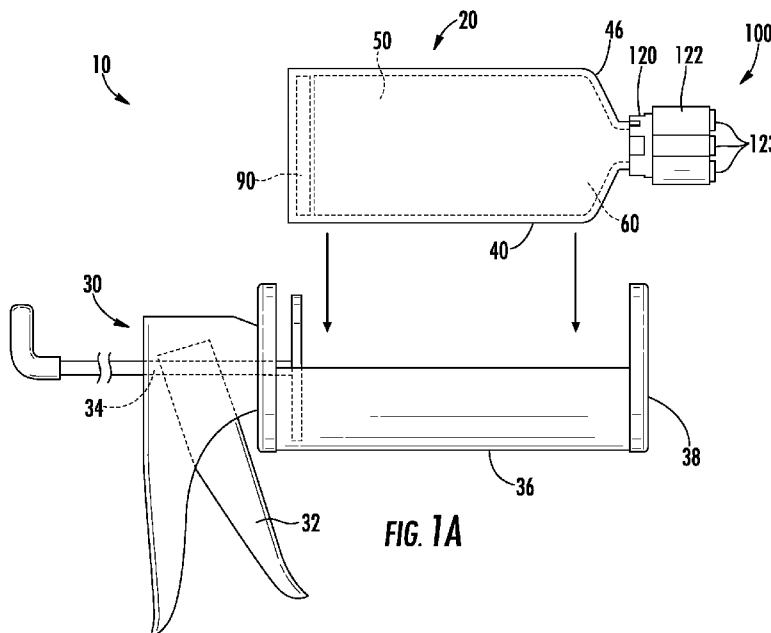


FIG. 1A

(57) Abstract: The present invention includes a dispensing system for dispensing a packaged product, e.g. a condiment, including a pouch (60) having the product therein cooperates with a dispensing gun (30) to dispense a dose of product. In various aspects the invention includes a packaging system that includes a container (40) and a flexible package (50) with a frangible seal (70), and a flexible pouch (60); a dispensing assembly (100) for dispensing a product from the package; a dispensing gun system; a method of making a package; and a method of dispensing a product. The packaging system includes a container such as a rigid sleeve, and a flexible pouch positioned within the container interior, and also includes a valve that enables the product to exit the pouch interior and be dispensed. An optional diffuser coordinates with the valve to dispense product from one or more product outlets.

WO 2016/018694 A3

TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, KM, ML, MR, NE, SN, TD, TG).

— *before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments (Rule 48.2(h))*

(88) Date of publication of the international search report:

3 March 2016

Published:

— *with international search report (Art. 21(3))*

TITLE

DISPENSING SYSTEM, PACKAGING SYSTEM, PACKAGE,
CLOSURE SYSTEM, DISPENSING GUN SYSTEM, METHOD OF
5 MAKING A PACKAGE, AND METHOD OF DISPENSING A PRODUCT

This application claims the benefit of U.S. Provisional Patent
Application No. 62/029679, filed July 28, 2014, U.S. Provisional Patent
Application No. 62/112338, filed February 5, 2015, U.S. Provisional Patent
10 Application No 62/150360, filed April 21, 2015, and U.S. Provisional Patent
Application No. 62/170732, filed June 4, 2015, each of these provisional
applications incorporated herein by reference in its entirety.

FIELD OF THE INVENTION

15 The present invention relates generally to a dispensing system for
dispensing a packaged product; a packaging system that includes a container
and a flexible package; a package with a frangible seal; a dispensing
assembly; a dispensing gun system; a method of making a package; and a
method of dispensing a product.

20

BACKGROUND OF THE INVENTION

In food service, and in particular in the field of high volume fast food
service, it is frequently desired that food be supplemented by condiments
such as ketchup, mustard, mayonnaise, and the like. It has recently become
25 customary in retail fast service chain food outlets to use a wide variety of
devices to dispense a measured quantity of flowable product. For example, a
trigger-activated dispensing gun assembly has commonly been used in "back
of the restaurant" operations for discharging one or more condiments or
sauces. The gun assembly dispenses a quantity of a condiment with each pull
30 of a gun trigger. The gun assembly includes a cylindrical container that
houses the condiment and cooperates with a trigger in a gun to dispense the
condiment out of a nozzle. However, the gun, cylindrical container, and nozzle
are typically disassembled and/or cleaned each time the container is emptied
and/or refilled. In addition, the gun assembly typically can be messy, as
35 condiment can drip from the nozzle between uses; conventional systems can

be labor intensive; and the container can sometimes become damaged and not insert properly into the gun.

SUMMARY OF THE INVENTION

5 In a first aspect, a dispensing system comprises

a) a packaging system comprising a container comprising first and second openings and an interior; a package positioned within the container interior, the package comprising a pouch comprising a first and second panel with a frangible seal positioned between the panels, and a flowable product
10 disposed in the pouch; and a dispensing assembly; and

b) a dispensing gun into which the packaging system is disposed.

In a second aspect, a packaging system comprises a container comprising first and second openings and an interior; a package positioned within the container interior, the package comprising a pouch comprising a first and second panel with a frangible seal positioned between the panels,
15 and a flowable product disposed in the pouch; and a dispensing assembly.

In a third aspect, a package comprises

a pouch comprising a first and second panel with a frangible seal disposed between the panels, and

20 a flowable product disposed in the pouch,

wherein the pouch comprises

a) a first transverse seal at a first end of the pouch,

b) a second transverse seal at a second end of the pouch,

c) a first fold at a first side edge of the pouch,

25 d) a second fold at a second side edge of the pouch, and

e) a longitudinal seal extending from the first end of the pouch to the second end of the pouch;

wherein the first transverse seal comprises

i) a central seal segment intersected by the longitudinal axis of the pouch;

30

ii) a second and third seal segment each arranged oblique to the longitudinal axis of the pouch, the second seal

- segment in communication with the first fold, and the third seal segment in communication with the second fold, and
- iii) a fourth and fifth seal segment each arranged substantially perpendicular to the longitudinal axis of the pouch, the fourth seal segment in communication at one end thereof with the second seal segment, and at the other end thereof with the central seal segment, and the fifth seal segment in communication at one end thereof with the third seal segment, and at the other end thereof with the central seal segment.

In a fourth aspect, a dispensing assembly comprises a valve, a valve housing that retains the valve, and a connecting portion that functionally cooperates with, and is in engagement with a container.

In a fifth aspect, a dispensing gun system comprises a dispensing gun comprising a piston; a cylindrical container having an interior surface; a cylindrical pusher plate, having an annular outside edge, attached to the piston, and configured, when advanced by the piston into the container, to fit within the container in close proximity to the interior surface of the container; and a package disposed within the container, the package comprising a film having a thickness.

In a sixth aspect, a method of making a package in a vertical form/fill/seal process comprises

a) providing a lay-flat web on a first roll, the lay-flat web comprising a first and second surface;

b) providing a film strip on a second roll, a first surface of the film strip comprising a peelable interface, and a second surface of the film strip comprising a permanent sealant;

c) advancing the lay-flat web over a forming device to convert the lay-flat web to a folded web having an interior surface;

d) advancing the film strip to an apparatus that seals the film strip to the lay-flat web, and cuts the film strip into a label, such that when the package is made, the label is disposed between a first and second panel of the package;

e) making a longitudinal seal in the folded web;

f) transversely sealing the folded web to produce a first transverse seal to define a first pouch, wherein the first transverse seal is a bottom transverse seal of the first pouch;

5 g) putting a product in the first pouch;

h) advancing the folded web, with the first pouch, downward a predetermined distance;

i) transversely sealing the first pouch to produce a top transverse seal in the first pouch, and a bottom transverse seal in a second pouch, the
10 second pouch disposed above the first pouch; and

j) transversely cutting the folded web to separate the first pouch from the second pouch to make a package, the package comprising the first and second panels and the label;

wherein at any time before or during the step of making a longitudinal
15 seal in the folded web, the label is sealed to the lay-flat web or the folded web.

In a seventh aspect, a method of dispensing a product comprises

a) providing a packaging system comprising a container comprising a first and second end, first and second openings and an interior; a package positioned within the container interior, the package comprising a
20 pouch comprising a first and second panel with a frangible seal positioned between the panels, and a flowable product disposed in the pouch; and a dispensing assembly;

b) providing a dispensing gun configured to house the packaging system;

25 c) inserting the packaging system into the dispensing gun; and

d) initiating linear movement of a pusher plate toward the second end of the container to cause the product to be dispensed through the dispensing assembly.

In an eighth aspect, a method of making a package in a vertical
30 form/fill/seal process comprises

a) providing a lay-flat web on a roll, the lay-flat web comprising a label having a first surface comprising a peelable interface, and a second

surface comprising a permanent sealant, one of the first and second surfaces adhered to the lay-flat web;

5 b) advancing the lay-flat web with the label adhered thereto over a forming device to convert the lay-flat web to a folded web having an interior surface;

c) making a longitudinal seal in the folded web;

d) transversely sealing the folded web to produce a first transverse seal to define a first pouch, wherein the first transverse seal is a bottom transverse seal of the first pouch;

10 e) putting a product in the first pouch;

f) advancing the folded web, with the first pouch, downward a predetermined distance;

15 g) transversely sealing the first pouch to produce a top transverse seal in the first pouch, and a bottom transverse seal in a second pouch, the second pouch disposed above the first pouch; and

h) transversely cutting the folded web to separate the first pouch from the second pouch to make a package, the package comprising a first and second panel with the label disposed between and sealed to the panels to provide a frangible seal.

20 In a ninth aspect, a method of making a package in a vertical form/fill/seal process comprises

a) providing a lay-flat web;

b) advancing the lay-flat web over a forming device to convert the lay-flat web to a folded web having an interior surface;

25 c) making a longitudinal seal in the folded web;

d) transversely sealing the folded web to produce a first transverse seal to define a first pouch, wherein the first transverse seal is a bottom transverse seal of the first pouch;

e) putting a product in the first pouch;

30 f) advancing the folded web, with the first pouch, downward a predetermined distance;

g) transversely sealing the first pouch to produce a top transverse seal in the first pouch, and a bottom transverse seal in a second pouch, the second pouch disposed above the first pouch; and

h) transversely cutting the folded web to separate the first pouch
5 from the second pouch to make a package having an interior surface;

wherein at any time before or during the step of making a longitudinal seal in the folded web, the lay-flat web or the folded web is selectively treated to produce an area, on the interior surface of the package, that comprises a frangible seal.

10 In a tenth aspect, a method of making a package in a vertical form/fill/seal process comprises

a) providing a lay-flat web on a roll, wherein the lay-flat web has been selectively treated to produce an area, on the interior surface of the package, that comprises a frangible seal;

15 b) advancing the lay-flat web over a forming device to convert the lay-flat web to a folded web having an interior surface;

c) making a longitudinal seal in the folded web;

d) transversely sealing the folded web to produce a first transverse seal to define a first pouch, wherein the first transverse seal is a bottom
20 transverse seal of the first pouch;

e) putting a product in the first pouch;

f) advancing the folded web, with the first pouch, downward a predetermined distance;

g) transversely sealing the first pouch to produce a top transverse
25 seal in the first pouch, and a bottom transverse seal in a second pouch, the second pouch disposed above the first pouch; and

h) transversely cutting the folded web to separate the first pouch from the second pouch to make the package.

30 In an eleventh aspect, a method of making a package in a vertical form/fill/seal process comprises

a) providing a lay-flat web comprising an easy-open sealant;

b) advancing the lay-flat web over a forming device to convert the lay-flat web to a folded web having an interior surface comprising the easy-open sealant;

c) making a longitudinal seal in the folded web;

5 d) transversely sealing the folded web to produce a first transverse seal to define a first pouch, wherein the first transverse seal is a bottom transverse seal of the first pouch;

e) putting a product in the first pouch;

10 f) advancing the folded web, with the first pouch, downward a predetermined distance;

g) transversely sealing the first pouch to produce a top transverse seal in the first pouch, and a bottom transverse seal in a second pouch, the second pouch disposed above the first pouch; and

15 h) transversely cutting the folded web to separate the first pouch from the second pouch to make a package comprising a frangible seal.

In a twelfth aspect, a dispensing assembly comprises a diffuser comprising an outlet, a valve in juxtaposed relation to the outlet, a housing, and a connecting portion that functionally cooperates with, and is in engagement with a container.

20 In a thirteenth aspect, a method of making a package in a horizontal form/fill/seal process comprises:

providing a lay-flat web on a first roll, the lay-flat web having a first and second longitudinal edge;

25 providing a film strip on a second roll, a first surface of the film strip comprising a peelable interface, and a second surface of the film strip comprising a permanent sealant;

advancing the lay-flat web to a forming device to convert the lay-flat web to a folded web having an interior surface;

30 advancing the film strip to an apparatus that seals the film strip to the lay-flat web, and cuts the film strip into a label, such that when the package is made, the label is disposed between a first and second panel of the package;

making side seals in the folded web to produce an open pouch comprising

the first and second panels and the label;

putting a product in the open pouch; and

5 sealing the first panel to the second panel to close the pouch;

wherein

at any time before putting a product in the open pouch, the film strip is attached to the lay-flat web or the folded web:

10 at any time before or during the step of making side seals in the folded web, the label is sealed to the lay-flat web or the folded web; and

the web is cut at the side seals during or after the step of making side

seals in the folded web to make a package comprising a frangible seal.

In a fourteenth aspect, a method of making a package in a horizontal form/fill/seal process comprises:

15 providing a lay-flat web on a roll, the lay-flat web comprising a label having a first surface comprising a peelable interface, and a second surface comprising a permanent sealant, one of the first and second surfaces attached to the lay-flat web;

20 advancing the lay-flat web with the label adhered thereto to a forming device to convert the lay-flat web to a folded web having an interior surface;

making side seals in the folded web to produce an open pouch comprising

the first and second panels and the label;

25 putting a product in the open pouch; and

sealing the first panel to the second panel to close the pouch;

wherein the web is cut at the side seals during or after the step of making side seals in the folded web to make a package comprising a frangible seal.

30 In a fifteenth aspect, a method of making a package in a horizontal form/fill/seal process comprises:

providing a lay-flat web;

advancing the lay-flat web to a forming device to convert the lay-flat web to a folded web having an interior surface;
making side seals in the folded web to produce an open pouch comprising

5 a first and second panel;
putting a product in the open pouch; and
sealing the first panel to the second panel to close the pouch;
wherein

10 the web is cut at the side seals during or after the step of making side seals in the folded web, and
at any time before or during the step of making side seals in the folded web, the lay-flat web or the folded web is selectively treated to produce an area, on the interior surface of the package, that comprises a frangible seal.

15 In a sixteenth aspect, a method of making a package in a horizontal form/fill/seal process comprises:

providing a lay-flat web on a roll, wherein the lay-flat web has been selectively treated to produce an area, on the interior surface of the package, that comprises a frangible seal;

20 advancing the lay-flat web to a forming device to convert the lay-flat web to a folded web having an interior surface;
making side seals in the folded web to produce an open pouch comprising

25 a first and second panel;
putting a product in the open pouch; and
sealing the first panel to the second panel to close the pouch;
wherein the web is cut at the side seals during or after the step of making side seals in the folded web.

30 In a seventeenth aspect, a method of making a package in a horizontal form/fill/seal process comprises:

providing a lay-flat web comprising an easy-open sealant;
advancing the lay-flat web to a forming device to convert the lay-flat web to a folded web having an interior surface;

making side seals in the folded web to produce an open pouch comprising

a first and second panel;

putting a product in the open pouch; and

5 sealing the first panel to the second panel to close the pouch;
wherein the web is cut at the side seals during or after the step of making side seals in the folded web.

In an eighteenth aspect, a segmented pusher plate comprises:

a) an outer plate segment;

10 b) an inner plate segment; and

c) a biasing member;

wherein the outer and inner plate segments are arranged in a coaxial configuration, and are concentrically arranged.

In a nineteenth aspect, a cylindrical composite pusher plate comprises:

15 a) a rigid plate component; and

b) an elastomeric plate component;

wherein the elastomeric plate component has a concave configuration on one surface thereof.

In a twentieth aspect, a package comprises

20 a pouch comprising a first and second panel with a frangible seal disposed between the panels, and

a flowable product disposed in the pouch,

wherein the pouch comprises

a) a first transverse seal at a first end of the pouch,

25 b) a second transverse seal at a second end of the pouch,

c) a first fold at a first side edge of the pouch,

d) a second fold at a second side edge of the pouch, and

e) a longitudinal seal extending from the first end of the pouch to the second end of the pouch;

30 wherein the first transverse seal comprises

i) a central seal segment intersected by the longitudinal axis of the pouch; and

- 5 ii) a second and third seal segment each arranged substantially perpendicular to the longitudinal axis of the pouch, the second seal segment in communication at one end thereof with the first fold, and at the other end thereof with the central seal segment, and the third seal segment in communication at one end thereof with the second fold, and at the other end thereof with the central seal segment.

In a twenty first aspect, a pusher plate system comprises:

- 10 a) a rigid plate component; and
 b) an elastomeric plate component;
 wherein the elastomeric plate component is disposed adjacent and in contacting relationship with the rigid plate.

15 BRIEF DESCRIPTION OF THE DRAWINGS

The present invention is illustrated in various embodiments by reference to the following drawing figures wherein:

 Figures 1a and 1b are side elevational views of a dispensing system, showing loading of the packaging system into a dispensing gun.

20 Figure 2 is a front elevation view of a packaging system.

 Figure 3 is a front elevation view of a container.

 Figure 4 is a sectional view of the neck of the container of Figure 3.

 Figure 5 is a lay flat view of a pouch.

 Figure 6 is a cross-sectional view of a label.

25 Figures 7 and 8 are enlarged fragmentary views of a pouch comprising a label.

 Figure 9 is an enlarged fragmentary view of a method of dispensing from a package.

30 Figures 10 and 11 are enlarged fragmentary views of a package comprising more than one label.

 Figure 12 is an enlarged fragmentary view of another method of dispensing from a disclosed package.

Figure 13 is a fragmentary view of a container spout and valve housing.

Figures 14 and 15 are perspective views of a valve housing.

Figure 16 is a lay flat view of a valve.

5 Figure 17 is a lay flat view of a valve in an open arrangement.

Figures 18 and 19 are perspective views of a diffuser.

Figures 20 to 23 are perspective views of the steps of assembling a packaging system.

Figure 24 is an exploded view of a packaging system.

10 Figure 25 is an exploded view of a portion of a packaging system.

Figure 26 is a lay flat view of a first embodiment of a pouch.

Figure 27 is a lay flat view of a second embodiment of a pouch.

Figure 28 is a lay flat view of a third embodiment of a pouch.

Figure 29 is a perspective view of a package.

15 Figure 30 is a perspective cross-sectional view of a valve housing.

Figure 31 is a perspective view of a valve housing.

Figure 32 is an elevational cross-sectional view of a valve housing.

Figure 33 is a perspective cross-sectional view of a dispensing assembly.

20 Figure 34 is an elevational cross-sectional view of a dispensing assembly.

Figure 35 is a perspective cross-sectional view of a dispensing assembly.

25 Figure 36 is a perspective fragmentary cross-sectional view of a portion of a packaging system.

Figure 37 is a perspective cross-sectional view of a portion of a packaging system.

Figure 38 is an elevational cross-sectional view of a packaging system.

30 Figure 39 is a perspective cross-sectional view of a portion of a dispensing assembly.

Figure 40 is a perspective view of a portion of a dispensing assembly.

Figure 41 is an elevational view of a container.

Figure 42 is a perspective cross-sectional view of a container.

Figure 43 is a perspective view of a diffuser.

Figure 44 is a plan view of a pusher plate.

Figure 45 is a perspective view of a pusher plate.

5 Figure 46 is a schematic elevational view of a portion of a prior art vertical form/fill/seal system.

Figure 47 is a perspective view of a portion of a vertical form/fill/seal system and frangible seal applicator in accordance with the invention.

10 Figure 48 is a schematic elevational view of a portion of a vertical form/fill/seal system and frangible seal applicator in accordance with the invention.

Figure 49 is a top plan schematic view of a portion of a vertical form/fill/seal system and frangible seal applicator in accordance with the invention.

15 Figure 50 is an exploded perspective cut-away view of a dispensing system.

Figure 51 is a perspective cut-away view of a dispensing system.

Figure 52 is an enlarged perspective view of a dispensing system.

Figure 53A is a perspective cross-sectional view of a portion of a packaging system with a segmented pusher plate in a first position.

20 Figure 53B is a perspective cross-sectional view of a portion of a packaging system with a segmented pusher plate in a second position.

Figure 54A is an elevational cross-sectional view of a portion of a packaging system with a segmented pusher plate in a first position.

25 Figure 54B is an elevational cross-sectional view of a portion of a packaging system with a segmented pusher plate in a second position.

Figure 55A is a schematic elevational view of a portion of a packaging system with a segmented pusher plate in a first position.

Figure 55B is a schematic elevational view of a portion of a packaging system with a segmented pusher plate in a second position.

30 Figure 56 is an elevational cross-sectional view of a portion of a packaging system with a segmented pusher plate in a second position.

Figure 57 is a perspective cross-sectional view of a portion of a packaging system with a segmented pusher plate in a first position.

Figure 58 is a perspective cross-sectional view of a portion of a packaging system with a segmented pusher plate in a second position.

Figure 59 is an exploded perspective cut-away view of a portion of a packaging system with a segmented pusher plate.

5 Figure 60 is a schematic elevational view of a portion of a packaging system with a composite pusher plate.

Figure 61 is a schematic elevational view of a portion of a packaging system with a segmented composite pusher plate.

Figure 62 is a lay flat view of another embodiment of a pouch.

10 Figure 63 is a lay flat view of another embodiment of a pouch.

DETAILED DESCRIPTION OF THE INVENTION

I. Definitions

15 "A", "an", and "the" as used herein do not limit to the singular unless expressly so stated. Thus, for example, reference to "a package" can include a plurality of such packages, and so forth.

"Abuse layer" and the like herein refers to an outer film layer and/or an inner film layer, so long as the film layer serves to resist abrasion, puncture, and other potential causes of reduction of package integrity, as well as
20 potential causes of reduction of package appearance quality. Abuse layers can comprise any polymer, so long as the polymer contributes to achieving an integrity goal and/or an appearance goal. In some embodiments, the abuse layer can comprise polyamide, ethylene/propylene copolymer, and/or combinations thereof.

25 "Antifog" and the like herein refers to an agent that can be incorporated into an outermost film layer, be coated onto an outermost film layer, or migrate from an internal layer to an outermost film layer, with the effect of lowering the seal strength of a seal subsequently made. Suitable antifog agents may fall into classes such as esters of aliphatic alcohols, esters of polyglycol, polyethers, polyhydric alcohols, esters of polyhydric aliphatic
30 alcohols, polyethoxylated aromatic alcohols, nonionic ethoxylates, and hydrophilic fatty acid esters. Useful antifog agents include polyoxyethylene, sorbitan monostearate, polyoxyethylene sorbitan monolaurate,

polyoxyethylene monopalmitate, polyoxyethylene sorbitan tristearate, polyoxyethylene sorbitan trioleate, poly(oxypropylene), polyethoxylated fatty alcohols, polyoxyethylated 4-nonylphenol, polyhydric alcohol, propylene diol, propylene triol, and ethylene diol, monoglyceride esters of vegetable oil or
5 animal fat, mono- and/or diglycerides such as glycerol mono- and dioleate, glyceryl stearate, monophenyl polyethoxylate, and sorbitan monolaurate. The antifog agent is incorporated in an amount effective to suitably reduce the seal strength of the film.

"Barrier", "barrier layer", and the like herein refers to the ability of a film
10 or film layer to serve as a barrier to one or more gases. For example, oxygen barrier layers can comprise, but are not limited to, ethylene/vinyl alcohol copolymer, polyvinyl chloride, polyvinylidene chloride, polyamide, polyester, polyacrylonitrile, and the like, as known to those of ordinary skill in the art. In some embodiments, the barrier film or layer has an oxygen transmission rate
15 of no more than 100 cc O₂/m²·day·atm; less than 50 cc O₂/m²·day·atm; less than 25 cc O₂/m²·day·atm; less than 10 cc O₂/m²·day·atm; less than 5 cc O₂/m²·day·atm; or less than 1 cc O₂/m²·day·atm (tested at 1 mil thick and at 25°C in accordance with ASTM D3985, herein incorporated by reference in its entirety).

20 "Bulk layer" and the like herein refer to any layer of a film that is present for the purpose of increasing the abuse-resistance, toughness, and/or modulus of a film. In some embodiments, bulk layers can comprise polyolefin, ethylene/alpha-olefin copolymer, ethylene/alpha-olefin copolymer plastomer, low density polyethylene, linear low density polyethylene, and combinations
25 thereof.

"Condiment" and the like herein refers to (but is not limited to) ketchup, mustard, guacamole, sour cream, salsa, nacho cheese, taco sauce, barbecue sauce, tartar sauce, mayonnaise, jams, jellies, spices, and the like. In some
30 embodiments, the term "condiment" can include any and all additives that a user can choose to add to any food item for any purpose, e.g. for organoleptic, processing, or preservative purposes.

"Container" and the like herein refers to tubes, bottles, jars, tubs, cylinders, vessels, flasks, chambers, and the like, whether pliable or rigid.

“Exterior” refers to the outside portion of an article.

"Filled" and the like herein, with respect to a pouch, refer to a pouch that has been filled with a product in a manner consistent with a commercial filling operation. Thus, a pouch may or may not be 100% filled.

5 “Film” and the like herein refers to a laminate, sheet, web, coating, or the like, that can be used to package a product. The film can be a rigid, semi-rigid, or flexible product. In some embodiments, the film is produced as a fully coextruded film, *i.e.*, all layers of the film emerging from a single die at the same time. In some embodiments, the film is made using a flat cast film
10 production process or a round cast film production process. Alternatively, the film can be made using a blown film process, double bubble process, triple bubble process, or adhesive or extrusion coating lamination.

“Flexible” and the like herein refer to materials that are pliable and easily deform in the presence of external forces.

15 “Frangible seal” and the like herein refer to a seal that is sufficiently durable to allow normal handling and storage, but ruptures or substantially ruptures under applied pressure. In some embodiments, suitable frangible seals will have a peel strength of from 0.5 to less than 5 pounds/inch as measured by ASTM F88.

20 "Heat seal" and the like herein refers to any seal of a first region of a film surface to a second region of a film surface, wherein the seal is formed by heating the regions to at least their respective seal initiation temperatures. Heat-sealing is the process of joining two or more thermoplastic films or sheets by heating areas in contact with each other to the temperature at
25 which fusion occurs, usually aided by pressure. In some embodiments, heat-sealing can be inclusive of thermal sealing, melt-bead sealing, impulse sealing, dielectric sealing, and/or ultrasonic sealing. The heating can be performed by any one or more of a wide variety of means, such as (but not
30 limited to) a heated bar, hot wire, hot air, infrared radiation, ultrasonic sealing, and the like.

“Interior” and the like herein refers to the inside portion of an article.

"Label" and the like herein refer to a portion of sheet or film material that can be used to construct a frangible seal in accordance with some embodiments of the present invention.

"Multilayer film" and the like herein refers to a thermoplastic film having
5 one or more layers formed from polymeric or other materials that are bonded together by any conventional or suitable method, including one or more of the following methods: coextrusion, extrusion coating, lamination, vapor deposition coating, solvent coating, emulsion coating, or suspension coating.

"Outlet" and the like herein refer to an aperture, orifice, opening, chute,
10 passage, or similar channel through which a product can exit the disclosed packaging system.

"Panel" and the like herein refer to a wall or major section of a pouch. A first and second panel can be derived from two pieces of film joined together by any suitable means, such as heat sealing. Alternatively, a single web of
15 film can be folded into a tubular configuration, and longitudinally and transversely sealed to create a pouch exhibiting a first and second panel.

"Peelable sealant" and the like herein refers to any suitable polymer or polymer blend that forms at least a part of a film layer or is applied to a film layer, wherein the peelable sealant exhibits a seal strength that is less than
20 the seal strength of the permanent sealant as described herein. In some embodiments, the peelable sealant can comprise a food grade cold seal adhesive.

"Permanent sealant" and the like herein refers to any suitable polymer or polymer blend that forms at least a part of a film layer or is applied to a film
25 layer, wherein the permanent layer exhibits a seal strength that is greater than the seal strength of the peelable sealant as described herein.

"Pouch" and the like herein refers to any of a wide variety of containers known in the art, including (but not limited to) bags, packets, packages, and the like.

30 "Product" and the like herein refer to any of a wide variety of food or non-food items that can be packaged in the disclosed systems. In some embodiments, the product is a condiment, and/or a flowable product.

"Seal" and the like herein refer to any seal of a first region of a film surface to a second region of a film or substrate surface. In some embodiments, the seal can be formed by heating the regions to at least their respective seal initiation temperatures using a heated bar, hot air, infrared radiation, ultrasonic sealing, and the like. In some embodiments, the seal can be formed by an adhesive. Alternatively or in addition, in some embodiments the seal can be formed using a UV or e-beam curable adhesive seal.

"Seal layer" and the like herein refers to an outermost film layer or layers involved in heat sealing of the film to itself, to another film layer of the same or another film, and/or another article that is not a film. "Outermost" layer herein includes a layer found on the outside of a film, i.e. a layer not bounded on both major surfaces by another film layer. Layers involved in heat sealing can include a second layer, adjacent an outermost layer, that assists in or substantially affects or influences the overall strength of the heat seal. Heat sealing can be performed by any one or more of a wide variety of manners known to those of ordinary skill in art, including using heat seal technique (e.g., melt-bead sealing, thermal sealing, impulse sealing, ultrasonic sealing, hot air, hot wire, infrared radiation, and the like), adhesive sealing, UV-curable adhesive sealing, and the like.

"Tie layer" and the like herein refers to an internal film layer having the primary purpose of adhering two layers to one another. In some embodiments, a tie layer can comprise any nonpolar polymer having a polar group grafted thereon, such that the polymer is capable of covalent bonding to polar polymers such as polyamide and ethylene/vinyl alcohol copolymer. In some embodiments, the tie layers can comprise modified polyolefin, modified ethylene/vinyl acetate copolymer, and/or homogeneous ethylene/alpha-olefin copolymer.

"Transparent" and the like herein refers to the ability of a material to transmit incident light with negligible scattering and little absorption, enabling objects to be seen clearly through the material under typical unaided viewing conditions, i.e. the expected use conditions of the material, as measured in accordance with ASTM D1746.

“Valve” and the like herein refers to any device by which the flow of material can be started, stopped, rerouted or regulated by a movable part that opens, closes, or partially obstructs a passageway through which the material flows. In some embodiments, a suitable valve can comprise any of an umbrella valve, duckbill valve, reed valve, ball valve, flapper valve, poppet valve, Gott valve, check valve, or any suitable combination thereof.

All compositional percentages used herein are presented on a "by weight" basis, unless designated otherwise.

The definitions and disclosure of the present application control over any inconsistent definition or disclosure present in an incorporated reference.

II. Dispensing System 10

The present invention provides a dispensing system and method for dispensing a product onto one or more areas (one or more spots of mustard dispensed on a hamburger bun, for example). In one embodiment, the dispensing system includes a packaging system **20** that cooperates with a dispensing device (such as a dispensing gun **30**) to dispense a dose of product.

As illustrated in the Figures, packaging system **20** comprises outer container **40** with first and second ends **42**, **44**, and package **50** positioned within the container interior **43**. Package **50** includes a pouch **60** that houses product **80**, which in some embodiments can be a condiment. Container first end **42** accommodates dispensing assembly **100**, including a valve housing **120** comprising valve **112** that enables product **80** to exit the package interior, as set forth in more detail herein below. Diffuser **126** coordinates with valve housing **120** to dispense product **80** from one or more product outlets **123**. Pusher plate **90** is in one embodiment configured on the interior **43** of container second end **44** and cooperates with a dispensing gun to dispense product **80**.

III. Packaging System 20

III.A. Generally

As illustrated in the Figures, packaging system **20** comprises container **40**, package **50**, and dispensing assembly **100**. System **20** optionally includes diffuser **126**, and pusher plate **90**. In some embodiments, pusher plate **90**

does not form part of system **20** and is instead included as part of dispensing gun **30**.

III.B. Container 40

Several of the figures, including Figures 2, 3, 22 to 24, 41 and 42, illustrate container **40**. Container **40** includes tubular sidewall **47** with open second end **44** sized to house package **50** and accommodate pusher plate **90** within the interior **43** of the container. The container further includes mouth **41** positioned at first end **42**, through which product **80** can be dispensed via valve housing **120** and diffuser **126**. The container sidewall tapers (with a reduced diameter) into container neck **45** at first end **42**. In some embodiments, neck **45** includes a fastening device **49**, such as a screw thread, extending around the neck exterior for engaging dispensing assembly **100**, as will be described below. Alternative methods of attaching a dispensing assembly include a location fit, press fit, twist lock, tab, slot, and/or snap fit arrangements.

Container **40** can be constructed from any of a variety of rigid or semi-rigid materials known in the art, e.g. plastic, metal, wood, cardboard, chipboard, stiff paper, foamed plastics, recycled materials, compostable materials, heavy foil, and/or combinations thereof; such as foamed or solid polystyrene, crystallized polystyrene (CPS), polyethylene terephthalate (PET), polypropylene, polyethylene, or combinations thereof. Such materials are typically suitable for forming, yet stiff or rigid enough to resist buckling, folding, crumbling or collapsing due to compression, handling, and shipping.

In some embodiments, container **40** can be constructed from a material that provides a barrier to the passage of oxygen, e.g., vinylidene chloride copolymer, nylon, polyethylene terephthalate, ethylene/vinyl alcohol copolymer, and the like. In some embodiments, the material(s) from which the container is constructed can comprise an oxygen scavenging material, e.g. Amisorb®. Alternatively or in addition, container **40** can comprise a substantially gas-impermeable sealant film laminated or otherwise bonded to the inner or outer surface thereof. In some embodiments, the material from which the container is made exhibits an oxygen transmission rate of no more

than about 50 cc/m²/24 hr. at 25°C, 0% RH, 1 atm (in accordance with ASTM D 3985), such as no more than 10 cc/m²/24 hr. at 25°C, 0% RH, 1 atm.

Container **40** can be constructed using any conventional process known in the art, such as rotational molding, blow molding, reheat stretch
5 blow molding, injection molding, casting, roll forming, stamping, and the like.

Container **40** is not limited to the cylindrical shape illustrated in the figures, and can have a rectangular, triangular, hexagonal, octagonal or square or other cross-sectional shape, including a combination of any of these shapes. The container be formed as any suitable receptacle with an interior
10 **43** for housing a pouch, e.g. a carton, can, jar, or bottle, and can have different dimensions and volume capacities.

Optionally, container **10** includes one or more vent holes in the upper part of the container, e.g. in the shoulder **46** of the container. Such vent holes can expedite manual removal of a spent package from the container interior
15 after product **80** has been dispensed. The vent holes are in one embodiment small, round holes of the type shown as **92** in Figure 44.

III.C. Package 50

Package **50** includes sealed pouch **60**, with product **80** disposed therein. Pouch **60** can be any of a variety of pouches known in the art,
20 including e.g. a stand-up pouch, a gusseted stand-up pouch, a lay-flat pouch, a pouch comprising at least one longitudinal seal, and the like. In some embodiments, pouch **60** can comprise a pair of films joined together along a pair of opposing sides and a bottom bridging the sides. Alternatively, in some
25 embodiments, pouch **60** can be formed from a single film that has been center folded at one edge, or a pouch that includes one or more lap seals, fin seals, and/or edge seals. In another embodiment, pouch **60** can comprise a continuous tubular material with no longitudinal seal, but with transverse seals as disclosed herein. The description of the pouch herein as having “first and
30 second panels” should be understood to describe a pouch that when filled with product and laid on a surface, will display a major first surface, wall or panel, and, on the opposite side of the pouch, a second major surface, wall, or panel.

As illustrated in Figure 5, pouch **60** comprises first and second panels **74, 76** that are sealed together about the pouch perimeter with perimeter seal **52**. Perimeter seal **52** can be formed using any suitable method, known and used in the art, including e.g. the use of heat, pressure, adhesive, and/or mechanical closure. As shown, perimeter seal **52** does not span top edge **54** of pouch spout **72**. Rather, in some embodiments, pouch spout **72** includes frangible seal **70** positioned between the first and second panels **74** using a heat seal, ultrasonic seal, static seal, RF seal, adhesive, or a combination thereof. Frangible seals are known to those of ordinary skill in the packaging art. See, for example, U.S. Patent No. 6,983,839 and U.S. Patent Application Publication No. 2006/0093765, the entire disclosures of which are hereby incorporated by reference.

Alternatively, as shown in Figures 26 to 29, pouch **60** comprises first and second panels **74, 76**, a first transverse seal **62**, a second transverse seal **64**, a first side fold **66**, a second side fold **68**, a longitudinal seal **71**, a first pouch end **77**, and a second pouch end **78**.

In some embodiments, frangible seal **70** can comprise label **56**. Particularly, label **56** includes permanent sealant **51** positioned on first label face **55** and peelable sealant **53** positioned on second label face **57**, as shown in Figure 6. The sealants can comprise part of a film layer, or can be coated, extrusion coated, or applied to the surface of a film using conventional labeling systems known in the art. As depicted in Figures 7 and 8, pouch spout **72** can comprise label **56** with permanent sealant **51** positioned on one label face, adjacent to second panel **76**, and peelable sealant **53** positioned on the opposing label face, adjacent to first panel **74**. In some embodiments, the label is maintained in proper position using one or more spot seals **58**. Label **56** can be positioned in any suitable location either fully or partially within pouch spout **72**, e.g. adjacent to top edge **54**.

Permanent sealant **51** can comprise any suitable polymer or polymer blend that makes up at least a portion of a film layer or is applied to a film layer (i.e., a coating). Suitable permanent sealants, for example, can be selected from the group comprising: Ziegler-Natta catalyzed linear low density polyethylenes (such as such as DOWLEX® 2045.03, DOWLEX®

2045.04, and DOWLEX® 2247G), metallocene-catalyzed LLDPE (such as EXCEED® 4518PA and EXCEED® 3518CB), polyolefin "plastomer" grade polyethylenes with high comonomer (such as Dow AFFINITY® PL 1888G, Dow AFFINITY® PL 1850G, Dow AFFINITY® PL 1850, EXACT® 4151, and EXACT® 3024), propylene-ethylene copolymer, LDPE (such as ESCORENE® LD-200.48), ionomer resin, such as SURLYN® 1650, ethylene/vinyl acetate copolymers, ethylene/methyl (meth)acrylate copolymers, and ethylene/butyl acrylate copolymers. Materials used as permanent sealant **51** typically melt with the application of heat and/or pressure to form permanent (non-frangible) seals. Typical seal strengths for the permanent sealant can range from 5 pounds/inch to 15 pounds/inch in accordance with ASTM F88-05. In some embodiments, the seal strength of the permanent sealant can be greater than the seal strength of the peelable sealant by a difference of at least 0.5, 1, 2, 3, 5, 10, 15, 20, or 25 pounds per inch.

Peelable sealant **53** can comprise any suitable sealant known in the art, e.g. DuPont APPEEL® resins such as those based on EVA, modified EVA, ethylene/acrylate copolymer, or modified ethylene/acrylate copolymer; blends of immiscible polymers, such as polyethylene and polybutylene; polyethylene, such as low density polyethylene and/or EVA copolymers blended with polypropylene, polyethylene blended with polybutene-1, random propylene/ethylene copolymer blended with polybutene-1, EVA or LDPE blended with polypropylene, LDPE blended with EVA and polypropylene, to introduce a molecular incompatibility into the sealant layer. It is believed that the molecular incompatibility creates discontinuities that reduce the force necessary to rupture the seal. Alternatively or in addition, the sealant can be printed in a pattern on a surface of the film. Typical seal strengths of peelable sealant **53** can in some embodiments be less than about 5 pounds/inch in accordance with ASTM F88-05. A peelable sealant will typically allow the user to open the seal with relatively little effort (e.g. by advancing a pusher plate **90** within the container interior). In some cases, peelable sealant **53** can peel away from the surface to which it is adhered. Alternatively, a rupture of the sealant (cohesive failure) or breakage of the sealant and delamination

along an adjacent layer interface can occur. See, for example, U.S. Patent/Publication Nos. 4,875,587; 5,023,121; 5,024,044; 6,395,321; 6,476,137; 7,055,683; and 2003/0152669, the entire disclosures of which are hereby incorporated by reference herein.

5 After label **56** has been positioned fully or partially within spout **72**, frangible seal **70** can be constructed using the application of heat and/or pressure (i.e., heat sealing). Specifically, the application of heat/pressure activates permanent sealant **51** into an adhesive state. As a result, label **56** becomes permanently sealed to the adjoining pouch panel (second panel **76**
10 in Figure 8). The application of heat and/or pressure further activates peelable sealant **53**, resulting in a frangible seal **70** positioned between label **56** and the adjoining pouch panel (first panel **74** in Figure 8). As a result, label **56** becomes peelably sealed to first panel **74**. The frangible seal can be constructed in any of a variety of patterns, such as straight line, chevron, half
15 moon, and the like, using e.g., targeted application of heat/pressure. In use, after the frangible seal has been constructed, an increase in pouch pressure (such as from the advancement of pusher plate **90**) forces peelable sealant **53** to separate from the adjacent pouch panel. As a result, product **80** is able to flow through the pouch spout **72**, as depicted by Arrow "A" in Figure 9.

20 Alternatively, frangible seal **70** can be constructed using first and second labels as shown in Figures 10 and 11. The two labels include a permanent sealant **51a**, **51b** respectively positioned on outer label faces **132**, adjacent to the pouch panels **76**, **74**. Either or both of the two labels further comprise peelable sealant **53a**, **53b** on their respective inner faces **133** (i.e.,
25 facing each other). After the labels have been positioned fully or partially within spout **72**, frangible seal **70** can be constructed by heat sealing the labels to the pouch films as described earlier, creating permanent seals between the labels and front and rear panels. An alternative to the use of heat sealing to create a permanent seal, is the use of a permanent adhesive. Heat
30 sealing creates a frangible seal **70** between the inner faces of the two labels, as a result of peelable sealant **53a**, **53b**. In some embodiments, the labels can include spot seals **58** to maintain proper positioning in the area outside of the frangible seal. In use, increased pressure within the pouch will rupture

frangible seal **70**, allowing product to flow between the labels to exit the pouch, as shown by Arrow B in Figure 12.

The disclosed labels and pouch **60** can be constructed from any of a wide variety of polymeric materials known in the art, including in some 5 embodiments food safe materials and/or a base film having a food safe material coated thereon. In some embodiments, the label(s) can be a continuous strip of material that spans the entire pouch length in the machine direction, e.g. parallel to the pouch longitudinal seal. In these embodiments, the label(s) can be indexed from a roll and applied (sealed, adhered, or the 10 like) to a pouch. Alternatively, in some embodiments, the label(s) can be an intermittent strip (registered film) positioned in the transverse seal area on one end of pouch **60** in the machine direction, i.e., perpendicular to the longitudinal seal. In these embodiments, the label can be indexed from a roll and applied to the middle of the pouch film web. Alternatively, the frangible 15 strip can run continuously in the transverse or other suitable direction. In some embodiments, the label(s) can be constructed from one or more semi-rigid materials (e.g., EVA sealant/semi-rigid layer/lock down sealant) that can be registered and applied on an end of the pouch parallel to the pouch longitudinal seal. In an alternative embodiment, a food grade cold seal can be 20 used.

A film used to construct the disclosed pouch and/or label(s) can be multilayer or monolayer. Typically, the films employed will have two or more layers to incorporate a variety of properties, such as, for example, sealability, gas impermeability, and toughness into a single film. Thus, in some 25 embodiments, the films can comprise a total of from 1 to 20 layers, such as from 4 to 12, or from 5 to 9 layers. The films can comprise more than 20 layers e.g. in embodiments wherein the films comprise microlayering technology.

The films used to construct pouch **60** and/or the disclosed labels(s) can 30 include one or more barrier layers, bulk layers, tie layers, abuse layers, and/or sealant layers, e.g., at least one barrier layer such that the pouch has an oxygen transmission rate of no more than about $50 \text{ cc/m}^2/24 \text{ hr.}$ at 25°C , 0% RH, 1 atm (in accordance with ASTM D 3985).

The polymer components used to fabricate the films can also comprise appropriate amounts of other additives normally included in such compositions. For example, slip agents (such as talc), antioxidants, fillers, dyes, pigments and dyes, radiation stabilizers, antistatic agents, elastomers, and the like can be added to the disclosed films. See, for example, U.S. Patent Nos. 7,205,040; 7,160,378; 7,160,604; 6,472,081; 6,222,261; 6,221,470; 5,591,520; and 5,061,534, the disclosures of which are hereby incorporated by reference in their entireties. In some embodiments, pouch **60** can be constructed from a food grade material, as would be well known to those of ordinary skill in the art.

The films used to construct pouch **60** and the disclosed label(s) can have any total thickness so long as they provide the desired properties for the particular packaging operation in which they are to be used. Nevertheless, in some embodiments the disclosed films have a total thickness of from 0.1 mils to 20 mils, such as from 0.2 mils to 10 mils; 0.3 mils to about 5.0 mils; and from 1.0 mils to 3.0 mils.

The films can be provided in sheet or film form and can be any of the films commonly used for the disclosed type of packaging, and can be constructed by any suitable process including e.g. coextrusion, lamination, extrusion coating, and combinations thereof. See, for example, U.S. Patent No. 6,769,227, the content of which is herein incorporated by reference in its entirety.

In some embodiments, the films can be transparent (at least in any non-printed regions) such that the packaged product is at least partially visible through the films. The transparency of the films can be at least about any of the following values: 20%, 25%, 30%, 40%, 50%, 65%, 70%, 75%, 80%, 85%, and 95%.

In some embodiments the films used to construct pouch **60** or label **56** can be pigmented, tinted, or printed. Printing can be employed at any time prior to use of the pouch. In some embodiments, pouch **60** can be ink jet or thermal transfer printed using a device mounted on a packaging machine that forms and seals the pouch. In some embodiments, printing can include

branding, product information, use instructions, and/or a mark that identifies the region of the pouch that is to align with the neck of container **40**.

In one embodiment, package **50** can be configured to provide a first transverse seal **62** that facilitates the insertion of package **50** into container

5 **40**. Viewing Figs. 26 to 29, first transverse seal **62** can include

- (i) a central seal segment **140** intersected by the longitudinal axis **25** of the pouch;
- (ii) a second and third seal segment **150a**, **150b** respectively each arranged oblique to the longitudinal axis **25** of the pouch, the
10 second seal segment **150a** in communication with a first side fold **66** of the pouch, and the third seal segment **150b** in communication with a second side fold **68** of the pouch, and
- (iii) a fourth and fifth seal segment **160a**, **160b** respectively each arranged substantially perpendicular to the longitudinal axis **25**
15 of the pouch, the fourth seal segment **160a** in communication at one end thereof with the second seal segment **150a**, and at the other end thereof with the central seal segment **140**, and the fifth seal segment **160b** in communication at one end thereof with the third seal segment **150b**, and at the other end thereof with
20 the central seal segment **140**.

In the embodiment shown in Figure 26, the central seal segment **140** comprises two oblique portions **170a** and **170b**, and a central linear portion, connecting **170a** and **170b**, disposed substantially perpendicular to the longitudinal axis **25** of the pouch. This particular configuration not only
25 facilitates manual loading of package **50** into container **40**, but also improves the centering of spout **72** with relation to neck **45** of the container. Centering of spout **72** in turns facilitates dispensing of product **80** out of the package **50** and through the dispensing assembly **100**.

Alternatively, central seal segment **140** is substantially U-shaped, as
30 shown in Figure 28.

Second transverse seal **64** can take the form of first transverse seal **62**, as shown for example in Fig. 27, but without the presence of a frangible seal **70**. Alternatively, second transverse seal **64** can take the form of a

conventional, linear seal running perpendicular to the longitudinal axis **25** of the pouch. These two alternative configurations are related to the design of the seal bars used, the desired look of the pouch, and the internal pouch volume.

5 In an alternative embodiment, the package can be made with the frangible seal positioned in the machine direction, with waste areas at the side of the package perforated for tear off. The lap seal in this embodiment runs from side to side in the package. In another alternative embodiment, the package can be made without a lap seal, but with a fin seal located at the side
10 of the package.

 In some embodiments, in lieu of a frangible seal, the pouch spout can have a tear-off feature, such as a tear notch optionally combined with a line of weakness such as a score area or line of perforations, that enables access to the pouch contents.

15 In another embodiment, the pouch can have neither a frangible seal nor a tear off feature, and the pouch contents can be accessed by mechanically cutting off a portion of the pouch spout.

 Fig. 62 shows, in an alternative embodiment, a first and second transverse seal **62**, **64** that each include the contoured seal disclosed herein
20 for the embodiment of Figs. 26 and 27. A frangible seal **70** is thus provided at each of the two ends of the pouch **60**. In one embodiment, a single transverse seal bar can, in accordance with the VFFS process disclosed herein, simultaneously produce seals **62** and **64**. As can be seen in Fig. 62, the seal configuration results in a pouch **60** that is symmetrical with respect to the
25 central transverse axis of pouch **60**. The embodiment of Fig. 62 provides for a package **50** that can be loaded into container **40** with either first transverse seal **62** or second transverse seal **64** facing downstream in the container, while still providing a frangible seal in the downstream portion of the pouch.

 In the embodiments disclosed in Figs. 26 to 29, and Fig. 62, production
30 of pouches with a contoured transverse seal in a VFFS process would typically result in the production of scrap as a part of the pouch making process. Although this scrap can be removed during production, it would be beneficial to avoid the necessity of providing for scrap removal, while still

gaining the benefit of the contoured spout. This can be achieved by the embodiment of Fig. 63, where a pouch **60** like that of Fig. 62 is provided, but which includes skirts **172a,b** located on respective sides of the contoured seals **62** and **64**. These skirts, made during the VFFS process, in effect capture what would otherwise be scrap material by retaining these portions of the pouch material on the finished pouch rather than cutting the material away from the pouch. Scrap removal is thus avoided. Skirts **172a,b** can be included in one embodiment at one transverse seal of the pouch **60**, or alternatively at both transverse seals of the pouch.

10 In one embodiment, the embodiment of Fig. 63 can optionally include slits **174**. These slits can be produced during production of the transverse seals, by a suitable cutting device. At point of use, when package **50** is loaded in container **40**, and the packaging assembly is activated by dispensing gun **30**, slits **174** allow skirts **172a,b** to fold or bend back inside container **40**, enhancing the orientation of frangible seal **70** with respect to the first end **42** of container **40**, and dispensing of product **80** from package **50**. The slits **174** as shown in Fig. 63 extend obliquely from respective ends of skirt **172a,b** towards the respective contoured seal **62**, **64**. Those skilled in the art will appreciate, after a review of this disclosure, that the location, length, shape (linear, curved, etc.), and orientation of slits **174** can be selected as needed to optimize the performance of package **50**.

III.D. Product 80

System **20** can be used to house any of a wide variety of food and non-food products. For example, product **80** can include any of a wide variety of condiments, including (but not limited to) mustard, ketchup, salsa, guacamole, cheese sauce, sour cream, taco sauce, mayonnaise, tartar sauce, syrup, gravy, hot fudge, caramel, butterscotch toppings, flowable margarine and butter, horseradish, creamers, cream, yogurt, jelly, peanut butter, and the like. Liquids (such as water, milk, lemonade, and the like) can also be packaged in accordance with the present invention.

III.E. Method of Making a Package 50

FIG. 46 schematically illustrates a vertical form/fill/seal (VFFS) apparatus that can be used in conjunction with the apparatus and process

according to some embodiments of the present invention. VFFS packaging systems are generally well known to those of skill in the art, and described for example in U.S. Patent Nos. 4,589,247 (Tsuruta et al), 4,656,818 (Shimoyama et al.), 4,768,411 (Su), and 4,808,010 (Vogan), all incorporated
5 herein by reference in their entirety.

Apparatus **180** utilizes a lay-flat web **182** as a rollstock. Product **80** is manually or mechanically supplied to apparatus **180** from a source (not illustrated), from which a predetermined quantity of product **80** reaches the upper end portion of forming tube **184** via a funnel (not shown) or other
10 conventional means. The packages are formed in a lower portion of apparatus **180**, and web **182** from which the packages are formed is fed from a feed roll or other feeding device over certain forming bars (not illustrated), is wrapped about forming tube **184** (sometimes known as a “sailor’s collar” or “forming collar”) and is provided with a longitudinal fin seal or lap seal **71** by
15 longitudinal heat sealing device **186**, resulting in the formation of a vertically-oriented folded web in the form of a tube **188**.

Transverse heat seal bars **190** operate to close and seal horizontally across the lower end of vertically-sealed tube **188**, to form a pouch **60** which is thereafter immediately packed with product **80**. Film drive belts **192**,
20 powered and directed by rollers, as illustrated, or by suitable alternative motive means, advance tube **188** and pouch **60** a predetermined distance, after which seal bars **190** close and simultaneously seal horizontally across the lower end of vertically-sealed tube **188** and across the upper end of sealed pouch **60**, to form a package **50** in which a product **80** is disposed in
25 sealed pouch **60**. The next pouch **194**, thereabove, is then filled with a metered quantity of product **80**, forwarded, and the packaging cycle is repeated. It is conventional to incorporate with the seal bars **190** a cut-off knife (not shown) which operates to sever a lower sealed pouch **50** from the bottom of upstream pouch 194.

30 Lay-flat web **182** of Fig. 10 will in operation typically travel vertically upward from a feed roll to forming tube **184**, and then vertically downward for the remaining process steps.

Figures 47 to 49 illustrate a frangible seal applicator **200** that can be used to apply a frangible seal **70**, as disclosed herein, in a package.

Applicator **200** includes a film strip mandrel /unwind **202** for supporting a roll of frangible strip **204** and maintaining tension. This part of the applicator is mounted to the VFFS machine in a location that can be accessed for easy loading of the frangible strip **204**. Applicator **200** also includes an indexer **206**, a heat sealer **208**, and a slitter **207**. Indexer **206** feeds a short section of film strip **204**, e.g. about one inch in length. Heat sealer **208** is then activated, and the film strip **204** is tack sealed to film web **182** along the film path **210** of web **182**. This is done so that frangible strip **204** will stay in position as web **182** is indexed and pull over the forming collar. The result is a film tube with a frangible strip adhered to the inside. Each time apparatus **180** indexes, a new label **56** will be applied to the film web.

While the heat seal is being made, slitter **207** cuts off the small section of film strip **204** that was fed through the indexer, effectively creating a label **56**. Apparatus **180** then indexes, i.e. web **182** is advanced, thus pulling the new sealed label **56** along with it. After the machine cycle completes, applicator **200** indexes, seals, and cuts another label **56**.

Applicator **200** is mounted to apparatus **180** so that the frangible strip **204** is positioned in the center of web **182**, perpendicular to the web path. Strip **204** will be sealed to the surface of web **182** that will comprise the interior surface of the finished package **50**. Where strip **204** meets web **182**, the strip will be parallel to web **182**.

If the apparatus **180** being used is one that makes a fold over seal or a side seal, the location of the strip may be moved from center so that strip **204** will be located in the center of the transverse seal, perpendicular to the film path. Alternately, strip **204** can be located anywhere along the transverse seal, thus resulting in a frangible seal at any location along the transverse seal. By changing the length of each label **56**, the size of the package opening, when product is eventually dispensed, can be changed. Applicator **182** is in one embodiment located so that the position of the applied label **56** will be a distance from the transverse seal that is a multiple of the finished package length. Because of the location of applicator **200**, each label **56**

sealed into the transverse seal **62** of the package. The resulting package **50** has a strong seal all around except for the location of label **56**.

The invention provides the creation of a weak spot in the package that enables dispensing of a flowable product out of the package in a controlled manner, and as desired, while maintaining a strong, integral package during production, shipping and storage. As an alternative to providing a film strip that can be cut into labels and applied to the film web, alternative methods can be employed for achieving a weak spot in a package, including:

- 1) printing an area of web **182** so that the printed area is difficult to seal. This can be done in-line, i.e. during the pouch making process, or using registered film, i.e. registration marks, such as eye-spots. Those skilled in the art will be familiar with the use of eye-spots and registration marks in processing web material in packaging operations. Registration marks are printed in uniformly spaced fashion along or near an edge of a web or tape, and facilitate the controlled production of packages. In the case of an in-line process, the film strip mandrel /unwind, indexer, sealer, and slitter are replaced with a coating applicator. For example, an anti-fog coating can be pattern-coated onto web **182** because such coatings are difficult to seal through.
- 2) treating or crosslinking the web **182**, either by the processor or in advance by the web supplier, at the specific locations on the web where a weak seal is desired.
- 3) mechanically, modifying heat seal bars **190** to produce a transverse seal with a localized weakened area. To produce weak seals in specific areas mechanically, it is necessary to precisely control the time, temperature and pressure of the seal bars. By lowering the time, temperature and/or pressure in specific areas, weak seal can be produced. It is in some embodiments necessary to use multiple seal bars (with separate controls) to accomplish this mechanical method of applying weak (frangible) seals.
- 4) pre- installing labels **56** on lay-flat web **182** prior to the start of the VFFS packaging process. This can be accomplished off-site from the processor, e.g. by the supplier of lay-flat web **182**.

- 5) applying an adhesive, such as a food-grade adhesive, to web **182** using an applicator, or pre-applying an adhesive to the web prior to processing.
- 6) using a printed area on a label like that described above, instead of a peelable sealant, to create a low peel strength interface.
- 7) using a film web comprising an easy-open sealant, and controlling the time, temperature and pressure of the seal bars to produce a package that is sufficiently robust to endure processing, storage and shipment, while exhibiting a frangible seal as described herein when used in the disclosed dispensing system. The easy-open sealant can be produced based on:
- resin selection for an outermost layer of the film web; or
 - a hot stamp coater for coating the exterior surfaces of the film web to impart easy-open characteristics to the package; or
 - the use of a peelable sealant as a thin outermost layer of the film web, and a permanent sealant as a layer of the film adjacent the outermost layer; or
 - the use of a layer of the film web, such as an interior layer, that ruptures by cohesive failure.

In one embodiment, strip **204** and the resulting individual labels **56** are visually colored or patterned in a manner that allows visual verification that each label is positioned correctly in the respective transverse seal, and also for verifying that label **56** is not in the second transverse seal of each package.

Packages **50** can alternatively be made using horizontal form/fill/seal (HFFS) packaging systems, such as those available from Bossar, KHS-Bartelt, Mespac, Laudenberg, and other suppliers; and can also be made using rotary FFS systems such as those marketed by RA Jones, Cloud, etc.

III.F. Dispensing Assembly 100

As illustrated in the drawings, in particular Figs. 13 to 17, and 30 to 40, dispensing assembly **100** comprises a valve **112**, a valve housing **120** that retains the valve, and a connecting portion **122** that functionally cooperates with, and is in engagement with container **40** (valve 112 not shown in Fig. 13).

In particular, dispensing assembly **100** is positioned adjacent to, and connected to container neck **45**.

in one embodiment, as shown in Figures 14 and 15, the valve housing includes a top face **124** and wall **122** configured to extend down onto all or part of container neck **45**. The valve housing interior can in some embodiments include a fastening device **118**, such as inner valve housing threads, for mating with the container screw threads **49** positioned around the external circumference of container neck **45** (see Fig. 13). Alternatively, the valve housing interior can include any other suitable mechanism (such as location fit, press fit, twist lock, tab, slot, and/or snap fit arrangements) to cooperate with the container neck. In some embodiments, the exterior of valve housing body includes a fastening device (such as outer threads **165** or a location fit, press fit, twist lock, tab, slot, and/or snap fit arrangement) that allow coupling with diffuser **126**, as set forth in more detail herein below.

Valve housing **120** includes at least one valve **112** through which product **80** can be dispensed during use. Valve **112** can be of any suitable variety known in the art, and can have (see Figs. 16 and 17) at least one cut **116** to form arms **117** that move in response to increased pressure, such as from the advancement of the pusher plate **90**, to form at least one passageway **114**. Product **80** can travel from the interior of package **50**, through passageway **114** of valve **112**, to be dispensed on an item such as a food product, either directly, or indirectly by first entering and then exiting diffuser **126**. Once pressure ceases, valve **112** closes (i.e., arms **117** resume the original closed position of Figure 16) to shut passageway **114**. Valve **112** may fully close after pressure ceases, or alternatively remain slightly open (i.e., about 1-10% open), partially open (i.e., about 11-30% open), or somewhat open (i.e., about 31-50% open). Valve **112** can be constructed in any suitable shape, e.g. circular, square, oval, and the like. Although depicted as X-shaped in the figures, the valve arms can be also be constructed using any suitably shaped cut, e.g. slits, star, etc.

Valve housing **120** can be constructed from any suitable rigid or semi-rigid material known in the art, such as metal, wood, rubber, plastic, and the like; from polyethylene terephthalate, high density polyethylene, low density

polyethylene, polyvinyl chloride, polypropylene, polystyrene, polycarbonates, or combinations thereof. Although depicted as circular in shape in the drawings, the valve housing can be formed in any desired shape, e.g. oval, circular, square, rectangular, and the like.

5 In some embodiments, valve **112** can be constructed from an appropriately flexible material, e.g. polymeric, rubber, silicone, polyester, thermoplastic polyester elastomer, and the like, including polymeric films that include these materials. In some embodiments, the materials used to form the valve and the shape of the valve cuts can be selected based on the
10 product viscosity, as would be known to those of ordinary skill in the art. For example, products that include particulates (like tartar sauce) can be used with a flexible valve with large cuts to allow the particulates to pass through.

Valve **112** can be of any suitable type, such as an umbrella valve, duckbill valve, reed valve, ball valve, flapper valve, poppet valve, Gott
15 valve, check valve, or any suitable combination thereof.

Valve **112** can be retained or seated in the valve housing in any suitable manner. In one embodiment, as shown in Figs. 30 and 31 to 36, a retainer **111**, such as a retaining ring, is adapted to secure the valve within the valve housing. A retaining clip, or a flange or flanges molded into the valve
20 housing so as to retain the valve **112**, can alternatively be used. In some embodiments, fastening device **118** can function as a retainer for the valve.

Valve housing **120** can in some embodiments also include a fastening device **119** such as external valve housing threads, disposed on the outside surface of wall **122**, and adapted to interconnect with a diffuser **126** discussed
25 in more detail below.

III.G. Diffuser 126

As illustrated in the drawings, in particular Figures 1b, 2, 18 and 19, 22 to 23, and 32 to 38, in some embodiments packaging system **20** comprises diffuser **126** positioned adjacent to and in communication with valve housing
30 **120** to facilitate dispensing of product **80** from package **50**. Figures 18 and 19 illustrate one embodiment of a suitable diffuser comprising top face **128** and wall **127** that extends down onto all or part of valve housing **120**. The interior of diffuser **126** can include a fastening device, such as internal threads **129** or

a location fit, press fit, twist lock, tab, slot, and/or snap fit arrangement) for engaging external valve housing threads or other fastening device **119** of valve housing **120**. In one embodiment, the diffuser is connected to the valve housing by a snap fit. This snap fit can be installed on the valve housing so as to render it not removable from the valve housing in normal use, i.e. is permanently installed on the valve housing. This particular feature of the invention can be beneficial when the use includes use of the combined valve housing/diffuser such that when desired, both are discarded as a unit. In some embodiments, the dispensing assembly does not include a diffuser, i.e. the overall packaging assembly, and the overall dispensing system, does not in every instance require a diffuser.

In some embodiments, the diffuser **126** can further include one or more conduits (not shown) or the like that extends through the interior of the space defined by the valve housing and the diffuser.

Diffuser **126** includes one or more outlets **123**, that can be of any suitable size, shape, distribution and number, these choices dictated at least in part by the properties, e.g. viscosity or particulate content of the product being dispensed.

Diffuser **126** can be constructed from any suitable material, such as metal, wood, rubber, polyethylene terephthalate, high density polyethylene, low density polyethylene, polyvinyl chloride, polypropylene, polystyrene, polycarbonates, and combinations thereof. Although depicted as circular in shape in the drawings, the diffuser **126** and/or outlets **123** can be formed in any desired shape known in the art, e.g. oval, circular, square, rectangular, and the like.

III.H. Alternative Dispensing Assembly

In an alternative embodiment (see Figs. 50 to 52), a dispensing assembly **215** can comprise one or more valves **212**, of any of the types disclosed herein for valve **112**, but in which each valve **212** is juxtaposed adjacent an outlet **223**, analogous to outlets **123**, in a diffuser **226** analogous to diffuser **126** as shown herein. In one embodiment, a single disc **214** of a thermoplastic and/or elastomeric material can be installed inside the diffuser **226**, with a valve **212** positioned in each portion of disc **214** that is juxtaposed

to and in communication with each respective outlet **223**. For example, a diffuser **226** with three outlets **223**, as shown in Figure 52, can be underlain by a thermoplastic and/or elastomeric disc **214** with a reed valve **212** positioned in each portion of disc **214** that underlies a respective outlet **223**.

5 The single disc **214** can have a geometry suitable for fitting inside and suitably attaching to the interior (pouch side) of diffuser **226**.

Alternatively, an individual disc **214** bearing a valve **212** can be separately placed adjacent each outlet **223**, such that e.g. three individual discs **214**, each bearing a valve **212**, are present in the embodiment of Figure
10 52; but such an arrangement may be less convenient and more difficult to install than the embodiment employing a single disc **214**.

Diffuser **226** with the underlain juxtaposed disc **214** bearing valves **212** can be connected, integrally or as a discrete, attached component, to a housing **220** similar to valve housing **120** disclosed herein, but not including a
15 valve. Diffuser **226** can be permanently attached to housing **220**, or alternatively releasably attached thereto (for example, for purposes of cleaning between uses). Housing **220** provides a plenum for product **80** flowing out of package **50** to be directed to diffuser **226** and out through the individual valves **212** and outlets **223**.

20 Dispensing assembly **215** also includes a connecting portion **222**, like connecting portion **122**, that functionally cooperates with, and is in engagement with container **40**. The housing interior can in some embodiments include a fastening device **218**, like device **118**, e.g. inner housing threads, for mating with the container screw threads **49** positioned
25 around the external circumference of container neck **45** (see Fig. 13).

III. I. Pusher plate 90

In one embodiment, packaging system **20** comprises pusher plate **90**, configured to cooperate with piston **34** of a dispensing gun. The pusher plate is sized and shaped to be closely received within the container interior at
30 second end **44** to help ensure that the package **50** is fully retained within the container **40** during dispensing. In some embodiments, pusher plate **90** can be configured to define a mating relationship with the interior surface **48** of container **40** when in contact. The pusher plate **90** is slidable within the

interior of the container to ultimately allow product **80** to be dispensed from the package. When pressure is exerted on pusher plate **90** from a dispensing gun, the pusher plate reacts by slidably moving from container second end **44** towards container first end **42**. As a result, pouch **60** is compressed, thereby increasing pressure on frangible seal **70** to dispense product **80**.

In some embodiments, pusher plate **90** can be slightly undersized in relation to the inner diameter of container **40** allowing it (in conjunction with package **50**) to wipe product as it transverses the length of the container, pushing toward the outlet. The package binds to the pusher plate **90** as it is retracted, thereby permitting easy removal of the used pouch.

Alternatively, the pusher plate can be a component of a dispensing gun instead of, or in addition to, a component of packaging system **20**, as described herein.

Suitable materials for use in constructing pusher plate **90** include (but are not limited to) plastic, wood, metal, rubber, and the like. In some embodiments, pusher plate **90** is configured as part of a dispensing gun. Alternatively, in some embodiments, the pusher plate can be configured as part of packaging system **20**.

An alternative embodiment to the pusher plate **90** described above, is a segmented pusher plate **290** (see Figs. 53A through Fig. 59) that includes in various embodiments an outer plate segment **291**, an inner plate segment **292**, a biasing member **293** such as a spring, an upper plug **276**, a lower plug **278**, and a retaining pin **280** (for simplicity, package **50** is not shown in Figs. 53A through Fig. 61, but in practice is present inside container **40** as indicated elsewhere in the description and drawings.) In one embodiment, segmented pusher plate **290** has a telescopic coaxial configuration, such that the outer and inner plate segments **291** and **292** are concentrically arranged, either within a single plane or within two planes. As shown in various embodiments in Figs. 53A, 54A, 55A, 56, and 57, pusher plate **290** has been advanced to the container first end **42**, with the inner plate segment **292** in a retracted position. Inner plate segment **292** is attached to piston rod **34**, and is retained in this retracted position by biasing member **293**, such as a mechanical or elastomeric spring.

In practice, at this stage of the dispensing cycle, the package 50 inside container 40 is nearly completely collapsed, and most of the contained product 80 has already been dispensed from the pouch 60.

5 With further advancement of the pusher plate, by additional force put on piston rod 34, outer plate segment 291 remains essentially stationary, but inner plate segment 292 advances further, overcoming the biasing action of biasing member 293 (e.g. by compressing a spring), to take an extended position, i.e. move further toward or up the container neck 45. Figs. 53B, 54B, 55B, and 58 show in various embodiments the inner plate segment 292 in its
10 extended position. This action results in removal of much of the remaining product 80 inside pouch 60. Thus, segmented pusher plate 290 in use provides a method of reducing the product 80 left in package 50 at the completion of a dispensing cycle, this configuration leading to higher dispensing yield, i.e. the percentage of product 80 that is dispensed from
15 pouch 60.

In one embodiment (see Fig. 56), the shoulder 46 of the first end 42 of container 40 is configured as a flat, circular planar surface (disregarding container neck 45) that is positioned at right angles to the longitudinal axis of container 40, i.e. at right angles to side wall 47 of container 40. In certain
20 technologies such as blow-molding and injection-molding, however, a certain “draft”, i.e. an amount of taper for molded or cast parts perpendicular to the parting line is necessary. Thus, for example as shown in Figs. 53A through 54B, as well as Figs. 57 through 59, at least a shallow draft, of e.g. about 5 degrees, is included for shoulder 46. For an embodiment where some draft is
25 required for container 40, a discrete shim 282 (see e.g. Fig. 59) can be separately made and then installed inside container 40, juxtaposed against the interior surface of shoulder 46, in a “donut” fashion, to accommodate the draft on the container by providing a first surface matching the taper of the first end, while providing a second surface with a flat configuration, i.e. a
30 planar surface that is positioned at right angles to the longitudinal axis of container 40. It can be seen that this arrangement will provide a geometry that maximizes the utility of either an unsegmented pusher plate 90 or a

segmented pusher plate 290 by allowing the collapsing pouch 60 to operate against a flat surface.

In some embodiments, the segmented pusher plate **290** can be arranged so that, when inner plate segment **292** is in a retracted position, as shown in Figs. 53A and 54A, the downstream surface of inner plate segment **292** is not in substantially the same plane as the downstream surface of outer plate segment 291. In other embodiments, the segmented pusher plate **290** can be arranged so that, when inner plate segment **292** is in a retracted position, as shown in Figs. 55A, the downstream surface of inner plate segment **292** is in substantially the same plane as the downstream surface of outer plate segment **291**.

Although the segmented pusher plate **290** is shown in one embodiment as having an outer plate segment **291**, an inner plate segment **292**, and a biasing member **293**, in yet another alternative embodiment, a segmented pusher plate can comprise more than two segments, for example a multisegmented pusher plate having an outer plate segment, an inner plate segment, and an intermediate plate segment, wherein the intermediate plate segment is disposed between the outer and inner plate segments, and the respective plate segments are concentrically arranged, either within a single plane or within multiple planes. In such an embodiment, a first biasing member can regulate the relative axial movement of the outer and intermediate plate segments, and a second biasing member can regulate the relative axial movement of the intermediate and inner plate segments, in a telescoping coaxial configuration.

Another alternative embodiment to the pusher plate **90** described above, is a composite pusher plate **390** (see Fig. 60) that includes a rigid plate component **391**, and an elastomeric plate component **392** attached to the rigid plate component. Plate component **391** is in one embodiment made from a rigid material such as a metal or metal alloy, or a hard, rigid plastic. It will typically have substantially the same geometry, although not necessarily the same thickness, as pusher plate 90 shown e.g. in Figs. 24 and 45. Plate component **392** is in one embodiment made from an elastomeric material that will under load exhibit a certain degree of flexibility, but return to its original

position when the load is removed. Plate component **392** in one embodiment has a concave configuration on its downstream surface, i.e. on the surface of plate component **392** that faces the first end of container 40. This concavity can be in the form of a curved surface, or as shown in Fig. 60, in the form of a beveled surface having one or more planar portions, where the depth or thickness of the plate component **392** is greater along the outside circumference of the plate component than at its center. Thus, the change in thickness of the plate component, moving from the outside edge of the plate component **392** to the radial center of plate component **392** can be linear or non-linear. An advantage of the configuration of composite pusher plate **390** is to distribute the load forces on package 50 such that product **80** inside pouch **60** will tend to move toward the longitudinal center axis of the dispensing system, that is, towards the pouch spout, to expedite dispensing of product out of the pouch. Rigid plate component **391** and an elastomeric plate component **392** can be attached to each other by any suitable means, including a mechanical or chemical bond or seal, using for example an adhesive.

In another embodiment, a pusher plate system can be used similar to composite pusher plate **390** (see Fig. 60) that includes a rigid plate component **391**, but in which the elastomeric plate component **392** does not have a concave profile, but instead has two major surfaces that are each substantially planar. In one embodiment, the elastomeric plate component **392** can have an annular or circumferential bead or protrusion along the outside cylindrical periphery of the component, the bead disposed on the downstream surface of plate component **392**, i.e. on the surface of plate component **392** that faces the first end of container **40**.

In both this and the other described alternative embodiments of a composite pusher plate, the rigid component **391** and the elastomeric component **392** can be attached at their mating surfaces by any suitable means, including a mechanical means such as an external coaxial screw or bolt that holds the rigid and elastomeric components together, or a chemical bond or seal, or using for example an adhesive.

Also, in both this and the other described alternative embodiments of a composite pusher plate, the rigid component **391** and the elastomeric component **392** can typically have substantially the same geometry, although not necessarily the same thickness, as pusher plate 90 shown e.g. in Figs. 24 and 45. Alternatively, the elastomeric plate component can have a slightly larger OD (outside diameter) than the rigid plate component.

Yet another alternative embodiment to the pusher plate **90** described above, is a segmented composite pusher plate **351** (see Fig. 61) that includes a rigid plate component comprising an outer rigid plate segment **352** and an inner rigid plate segment **353**; and an elastomeric plate component **355** attached to the rigid plate component. Plate segments **352** and **353** are in one embodiment made from a rigid material such as a metal or metal alloy, or a hard, rigid plastic. Elastomeric plate component **355** is in one embodiment made from an elastomeric material that will under load exhibit a certain degree of flexibility, but return to its original position when the load is removed, and in one embodiment has a concave configuration on its downstream surface, i.e. on the surface of plate component **355** that faces the first end of container 40. This concavity can be in the form of a curved surface, or a beveled surface having one or more planar portions, where the depth or thickness of the plate component **355** is greater along the outside circumference of the plate component than at its center. In another embodiment, the elastomeric plate component **355** can be substantially planar on both major surfaces, and optionally can include a circumferential bead or protrusion as described above on its downstream surface.

Thus, the pusher plate **351** of Figure 61 is in at least one respect like pusher plate **290** of Figs. 53A through 59, in that the pusher plate has a segmented outer and inner portion. Pusher plate **351** of Figure 61 is in at least one respect like pusher plate **390** of Fig. 60, in that the pusher plate has a rigid and an elastomeric portion. One advantage of the embodiment of Figure 61 is that no separate biasing member, such as a spring, is needed, since a load force put on piston rod **34** pushes inner rigid plate segment **353** up against the central portion of elastomeric plate component **355**, tending to move plate component **355** downstream, assisting in removal of much of the

remaining product **80** inside pouch **60**. The concavity of elastomeric plate component **355** can provide the same beneficial effect in distributing the load forces on package 50, as described above for the embodiment of Figure 60. Outer and inner rigid plate segments **352** and **353** and an elastomeric plate component **355** can be attached to each other by any suitable means, including a mechanical or chemical bond or seal, using for example an adhesive; or as shown in Figure 61, by an interlocking joint **356** including a groove in each of plate segments **352** and **353**, and a mating fastener in preselected portions of plate component **355**. Of course, the inverse could also accomplish the same attachment, i.e. a groove present in preselected portions of plate component **355**, and a mating fastener in each of plate segments **352** and **353**. In another alternative embodiment, plate segments **352** and **353**, and an elastomeric plate component **355** can be comolded.

IV. Dispensing Gun System 130

The dispensing gun system **130** includes a dispensing gun **30**, a cylindrical container **40**, a cylindrical pusher plate **90**, and a package **50** disposed within the container.

Dispensing gun **30** can comprise any apparatus that comprises a component of the disclosed dispensing system **10**, and/or functions in cooperation with the disclosed packaging system **20**, to dispense a product; as disclosed for example in U.S. Patent Nos. 4,681,524; 5,211,311; 5,242,115; 5,462,204; 5,589,226; 5,812,355; and 5,875,922, the entire contents of which patents are hereby incorporated by reference herein. Dispensing gun **30** will typically comprise a mechanical device that can accommodate a packaging system as described herein, and can effect movement of a flowable product, contained in a flexible package, out of the package, through a dispensing valve, and onto an area. As shown in Figs. 1a and 1b, the dispensing gun in one embodiment includes a trigger **32** to activate the dispensing system **10**; a piston **34** to drive pusher plate **90** through the container **40** and thus push the flexible package **50** toward the first end **42** of the container; a barrel **36** to house packaging system **20**; and a wall **38** against which the container **40** of packaging system **20** can abut.

The cylindrical pusher plate **90**, is configured, when advanced by the piston into the container, to fit within the container in close proximity to the interior surface of the container. In one embodiment, the space between the annular outside edge of the pusher plate and the interior surface of the container, as the pusher plate passes through the interior of the container, is less than three times the thickness of the film thickness of the package; such as less than two times the film thickness of the package.

V. Assembly of Packaging System 20

As a first step, package **50**, including a sealed pouch **60** containing product **80**, can be inserted into the interior of container **40** through second end **44** such that the pouch spout **72** is positioned in container neck **45**, as illustrated in Figure 20. Valve housing **120** is then seated flush atop the container mouth **41**. In some embodiments, valve housing **120** includes interior screw threads **118** that align with threads **49** on the neck of container **40** to allow coupling of the valve housing and the container, as depicted in Figures 21 and 36. Diffuser **126** can then be releasably or permanently attached to the distal end of the valve housing (the end furthest from the container **40**) by aligning the diffuser internal threads **129** with the valve housing external threads **119**, as shown in Figure 22. Alternatively, diffuser **126** can be snap fit in a releasable or permanent arrangement onto valve housing **120**. Pusher plate **90** (if present as part of the packaging assembly) can then be inserted within the interior of container **40** at second end **44**, as shown in Figure 23. Alternatively or additionally, the pusher plate can be a component of a dispensing gun as described herein.

It should be appreciated that the methods used to assemble packaging system **20** disclosed above are not limited and can be performed in any suitable order. In some embodiments, the packaging system can be partially or fully pre-assembled such that a user need not perform all of the steps described herein.

VI. Methods of Using Dispensing System 10

After assembly, packaging system **20** can be inserted into a dispensing gun **30**, as shown in Figures 1a and 1b. In some embodiments, dispensing gun **30** can be of the type that dispenses a portion of the contents of pouch **60**

upon each actuation. To this end, dispensing gun **30** can include trigger **32** that forms part of an actuating structure. Specifically, trigger **32** can be coupled to piston **34** that is movable within the interior of container **40** via contact with pusher plate **90**. The actuating structure functions such that upon each movement of trigger **32**, the piston **34** moves towards first end **42** of the container **40**, and a bias spring returns the trigger to its original position. In some embodiments, dispensing gun **30** includes wall **38** that is configured to abut against the front end of system **20** (i.e. the first end **42** of container **40**) so that pressure applied by the trigger **32** is effective to dispense product **80**.

5

10 Packaging system **20** can be used with any of a variety of dispensing guns known in the art. See, for example, U.S. Patent Nos. 3,687,370; 3,945,569; 4,681,524; 5,462,204; 5,812,355; 5,875,922; 6,286,718; 6,454,138; 6,533,187; 6,691,899; and 7,011,238, the entire contents of which are hereby incorporated by reference.

15 To dispense product **80** disposed within pouch **60**, a user can initiate trigger **32** on the dispensing gun **30**. When trigger **32** is pulled, piston **34** advances pusher plate **90** within the interior of container **40** toward first end **42**. Such movement reduces the volume of pouch **60**, thereby collapsing the pouch and increasing the pouch internal pressure. As a result, frangible seal

20 **70** ruptures, allowing product **80** to exit the pouch through spout **72** and passageway **114** of valve **112** of valve housing **120**. Product then passes through diffuser **126** and out of system **20** through outlets **123**. In this way, product can be dispensed in a desired pattern associated with the outlets in the diffuser. For example, a diffuser with three exit outlets **123** will allow

25 dispensing of three areas of product. Once the trigger has been pulled, a metered dose of product is dispensed and the diffuser and valve housing prevent any substantial leakage of product.

Piston **34** will continue to move towards the second end **44** of container **40** with continued application of pressure (i.e., each pull of trigger **32**), thereby

30 dispensing product **80**. When pusher plate **90** has reached an abutting position with container shoulders **46**, the mating relationship ensures that a maximum amount of product housed within pouch **60** has been dispensed. System **20** can then be removed from dispensing gun **30** and replaced with a

new system. As set forth above, in some embodiments, container **40**, valve housing **120**, diffuser **126**, and/or pusher plate **90** can be used repeatedly such that only pouch **60** is replaced.

VII. Advantages of Some Embodiments of the Present Invention

5 In some embodiments, the invention lowers costs associated with materials and assembly and with sufficient ruggedness to survive filling, closing, packing and shipping.

System **20** and/or pouch **60** can also be economically disposed of after a single use, or after the pouch contents have been dispensed.

10 The pouch is flexible, reducing storage space needed to house the pouch prior to use. Similarly, the space needed to ship the pouch is less than other alternatives. Further, the flexible pouch requires less space (in trash and in landfills) at the time of disposal.

15 In addition, pouch **60** is constructed to be substantially free of voids and to have suitable mechanical integrity and flexibility. As a result, the pouch can withstand high pressure treatment, such as can be used to reduce unwanted microorganisms in the packaged product.

20 The package further allows the dispensing of multiple doses of product in each dispensing application. For example, a package that includes a diffuser with five outlets will allow five spots of product to be dispensed with each pull of the dispensing gun trigger.

VIII. Statement of Embodiments of the Invention

25 The present application is directed in various embodiments to the subject matter described in the following paragraphs. These are alternative embodiments of any of the first (dispensing system), second (packaging system), third (package), fourth (dispensing assembly), fifth (dispensing gun system), sixth (method of making a package), seventh (method of dispensing a product), eighth (method of making a package), ninth (method of making a package), tenth (method of making a package), eleventh (method of making a package),
30 package), twelfth (dispensing assembly), thirteenth (method of making a package), fourteenth (method of making a package), fifteenth (method of making a package), sixteenth (method of making a package), seventeenth (method of making a package), eighteenth (segmented pusher plate),

nineteenth (cylindrical composite pusher plate), twentieth (package), and twenty first (pusher plate system) aspects of the invention as described hereinabove in the Summary of the Invention. For each aspect, these features can be incorporated alone or in any suitable combination of these features:

- 5 a) a pusher plate positioned either within the container interior, or in the dispensing gun, and adapted to movably close the first opening and effect dispensing of product.
- b) the container comprises a rigid cylindrical container.
- c) the container comprises a neck portion adapted to connect to a
10 dispensing assembly.
- d) the container comprises a neck portion adapted to house an exterior fastening member.
- e) the fastening member of d) is selected from the group comprising: a location fit, a press fit, a screw thread, a twist lock, a tab, a slot,
15 a snap fit, or combinations thereof.
- f) the pouch comprises a flexible, thermoplastic pouch.
- g) the pouch has an oxygen transmission rate of no more than 50 cc/m²/24 hr. at 25°C, 0% RH, 1 atm in accordance with ASTM D 3985.
- h) the pouch comprises a spout.
- 20 i) the frangible seal is positioned within the spout of h).
- j) the frangible seal comprises a single label with a first face and a second face, the first face comprising a permanent sealant and the second face comprising a peelable sealant; or first and second labels, each label comprising a first face, wherein the first face of the first label comprises a
25 permanent sealant positioned adjacent the pouch front sheet and wherein the first face of the second label comprises a permanent sealant positioned adjacent to the pouch rear sheet; and a second face, wherein the second face of the first label comprises a peelable sealant positioned adjacent to the second label second face, and/or wherein the second face of the second label
30 comprises a peelable sealant positioned adjacent to the first label second face.
- k) the permanent sealant is selected from the group comprising metallocene catalyzed polyethylene, Ziegler-Natta catalyzed linear low density

polyethylene, propylene-ethylene copolymer, LDPE, ionomer resin, ethylene/vinyl acetate copolymers, ethylene/methyl methacrylate copolymers, ethylene/butyl acrylate copolymers, and combinations thereof.

l) the peelable sealant is selected from the group comprising:
5 blends of polyethylene and polybutylene, polyethylene, polyethylene blends, random propylene/ethylene copolymer blends, EVA/polypropylene blends, LDPE/polypropylene blends, or combinations thereof.

m) the flowable product comprises a condiment.

n) the dispensing assembly comprises a valve, a valve housing
10 that retains the valve, and a connecting portion that functionally cooperates with, and is in engagement with a container.

o) the valve is selected from the group comprising an umbrella valve, a duckbill valve, a reed valve, a ball valve, a flapper valve, a poppet valve, a Gott valve, a check valve, and combinations thereof.

p) the valve comprises four arms defined by a cross-cut in a central
15 portion of the valve.

q) the dispensing assembly comprises a retainer adapted to secure the valve within the valve housing.

r) the retainer is selected from a retaining ring, a retaining clip, or a
20 flange.

s) the valve housing comprises an interior surface and an exterior surface, at least one of which comprises a fastening member selected from the group comprising a location fit, a press fit, a screw thread, a twist lock, a tab, a slot, a snap fit, or combinations thereof.

t) the dispensing assembly further comprises a diffuser connected
25 to the valve housing.

u) the diffuser of t) is connected to the valve housing with a snap fit.

v) the diffuser comprises two or more outlets.

w) a product is positioned within the interior of the pouch, wherein
30 the product is a flowable food product.

x) the diffuser comprises an interior comprising a fastening member selected from the group comprising: a location fit, a press fit, a screw thread, a twist lock, a tab, a slot, a snap fit, or combinations thereof.

5 y) movement of the pusher plate is accomplished by displacing a dispensing gun trigger.

z) a metered volume of product is dispensed.

aa) the central seal segment intersected by the longitudinal axis of the pouch is a substantially linear segment arranged substantially perpendicular to the longitudinal axis of the pouch.

10 bb) the central seal segment is substantially "U" shaped.

cc) the dispensing gun comprises a barrel having a substantially hemispheric cross section.

dd) the dispensing gun comprises a piston and a trigger.

15 ee) the cylindrical pusher plate is configured, when advanced by the piston into the container, to fit within the container in close proximity to the interior surface of the container, with a gap between the outside diameter of the pusher plate and the interior surface of the container, of between 0.05 mm and 1 mm.

20 ff) the cylindrical pusher plate comprises a first and second planar surface, the first and second planar surfaces substantially parallel to one another,

a circumferential edge having a thickness "T", the circumferential edge normal to and joining the first and second planar surfaces, and a circumferential bevel located on the first planar surface and joining the first planar surface to
25 the circumferential edge.

gg) movement of the pusher plate is accomplished by displacing a dispensing gun trigger.

hh) a metered volume of product is dispensed.

ii) the container comprises an interior surface having a low COF.

30 jj) the container comprises an interior surface that exhibits a COF of between 0.05 and 0.5.

kk) the film comprises an exterior surface having a low COF.

ll) the film comprises an exterior surface that exhibits a COF of between 0.05 and 0.5.

mm) the valve housing comprises interior and exterior surfaces that each comprise a fastening member selected from the group comprising: a location fit, a press fit, a screw thread, a twist lock, a tab, a slot, a snap fit, or combinations thereof.

nn) the valve housing is positioned proximate to the second opening.

oo) the label includes a peelable interface selected from a peelable sealant, or a printed area on a surface of the film strip that when sealed to the film web, results in a peelable surface.

pp) the label includes a peelable interface selected from a printed area comprising an antifog material.

qq) in a vertical form/fill/seal process, a lay-flat web is selectively treated by any of printing a selective area of the lay-flat web or folded web with a material that lowers the seal strength of the selected area; cross-linking a selective area of the lay-flat web or folded web to lower the seal strength of the selected area; and/or applying an adhesive on a selective area of the lay-flat web or folded web that lowers the seal strength of the selected area.

rr) in a dispensing assembly, a valve lies in juxtaposed relation to the outlet;

ss) in a dispensing assembly, a single disc, juxtaposed adjacent the diffuser, bears a valve.

tt) in a dispensing assembly, a single disc, juxtaposed adjacent the diffuser, bears a plurality of valves, each valve positioned adjacent a respective outlet.

uu) in a packaging system, a segmented pusher plate comprises an outer plate segment, an inner plate segment, and a biasing member, the outer and inner plate segments in a coaxial and concentric arrangement.

vv) in a packaging system, a composite pusher plate comprises a rigid plate component, and an elastomeric plate component attached to the rigid plate component, the elastomeric plate component having a concave configuration on the surface thereof furthest from the rigid plate component.

ww) in a packaging system, a composite pusher plate comprises a rigid plate component, and an elastomeric plate component attached to the rigid plate component, the elastomeric plate component having a concave configuration on the surface thereof furthest from the rigid plate component, and the rigid plate component comprising an outer rigid plate segment, and an inner rigid plate segment, wherein the outer and inner rigid plate segments are arranged in a coaxial configuration, and are concentrically arranged.

xx) the package comprises a contoured seal at the first and second ends of the package.

yy) the package comprises first and second transverse seals each comprising a skirt extending laterally from each side of the respective central seal segment.

zz) the package comprises a slit disposed in each skirt, and extending obliquely from the longitudinal end of each skirt to the respective contoured seal.

aaa) In a packaging system, a pusher plate system comprises a rigid plate component, and an elastomeric plate component, wherein the elastomeric plate component is disposed adjacent and in contacting relationship with the rigid plate.

bbb) In a packaging system of aaa), the elastomeric plate component comprises an annular protrusion along the outside cylindrical periphery of the component.

ccc) In a packaging system of aaa), the elastomeric plate component has an outside diameter greater than the outside diameter of the rigid plate component.

CLAIMS

What is claimed is:

1. A dispensing system comprising:
 - 5 a) a packaging system comprising
 - 10 i) a container comprising first and second openings and an interior;
 - ii) a package positioned within the container interior, the package comprising a pouch comprising a first and second panel with a frangible seal disposed between the panels, and a flowable product disposed in the pouch; and
 - iii) a dispensing assembly; and
 - 15 b) a dispensing gun into which the packaging system is disposed.

2. The dispensing system of claim 1 further comprising a pusher plate positioned either within the container interior, or in the dispensing gun, and adapted to movably close the first opening and effect dispensing
20 of product.

3. The dispensing system of one of claims 1 or 2, wherein the container comprises a rigid cylindrical container.

- 25 4. The dispensing system of one of claims 1 to 3, wherein the container comprises a neck portion adapted to connect to a dispensing assembly.

- 30 5. The dispensing system of claim 4, wherein the neck portion comprises a fastening member adapted to connect to the dispensing assembly, the fastening member selected from a location fit, a press fit, a screw thread, a twist lock, a tab, a slot, a snap fit, or a combination thereof.

6. The dispensing system of one of claims 1 to 5, wherein the pouch comprises a flexible, thermoplastic pouch.

5 7. The dispensing system of one of claims 1 to 6, wherein the pouch has an oxygen transmission rate of no more than 50 cc/m²/24 hr. at 25°C, 0% RH, 1 atm in accordance with ASTM D 3985.

8. The dispensing system of one of claims 1 to 7, wherein the pouch comprises a spout.

10

9. The dispensing system of claim 8, wherein the frangible seal is positioned within the spout.

15 10. The dispensing system of one of claims 1 to 9, wherein the frangible seal comprises:

a) a single label with a first face and a second face, the first face comprising a permanent sealant and the second face comprising a peelable sealant; or

b) first and second labels, each label comprising:

20

i) a first face, wherein the first face of the first label comprises a permanent sealant positioned adjacent the pouch front sheet and wherein the first face of the second label comprises a permanent sealant positioned adjacent to the pouch rear sheet; and

25

ii) a second face, wherein the second face of the first label comprises a peelable sealant positioned adjacent to the second label second face, and/or wherein the second face of the second label comprises a peelable sealant positioned adjacent to the first label second face.

30

11. The dispensing system of claim 10, wherein the permanent sealant is selected from the group comprising metallocene catalyzed

polyethylene, Ziegler-Natta catalyzed linear low density polyethylene, propylene-ethylene copolymer, LDPE, ionomer resin, ethylene/vinyl acetate copolymers, ethylene/methyl methacrylate copolymers, ethylene/butyl acrylate copolymers, and combinations thereof.

5

12. The dispensing system of one of claims 10 or 11, wherein the peelable sealant is selected from the group comprising blends of polyethylene and polybutylene, polyethylene, polyethylene blends, random propylene/ethylene copolymer blends, EVA/polypropylene blends, LDPE/polypropylene blends, or combinations thereof.

10

13. The dispensing system of one of claims 1 to 12, wherein the flowable product comprises a condiment.

15

14. The dispensing system of one of claims 1 to 13, wherein the dispensing assembly comprises

- a) a valve,
- b) a valve housing, and
- c) a connecting portion that is in engagement with the container.

20

15. The dispensing system of claim 14, wherein the valve is selected from the group comprising an umbrella valve, a duckbill valve, a reed valve, a ball valve, a flapper valve, a poppet valve, a Gott valve, a check valve, and combinations thereof.

25

16. The dispensing system of one of claims 14 or 15, wherein the valve housing comprises a valve seat.

30

17. The dispensing system of claim 16 wherein the valve seat comprises a retaining ring, retaining clip, or flange.

18. The dispensing system of one of claims 1 to 17, further comprising a diffuser connected to the valve housing.

5 19. The dispensing system of claim 18, wherein the diffuser is connected to the valve housing with a snap fit.

20. The dispensing system of one of claims 18 or 19, wherein the diffuser comprises two or more outlets.

10 21. A packaging system comprising:
a) a container comprising first and second openings and an interior;
b) a package positioned within the container interior, the package comprising a pouch comprising a first and
15 second panel with a frangible seal positioned between the panels, and a flowable product disposed in the pouch;
and
c) a dispensing assembly.

20 22. The packaging system of claim 21 further comprising a pusher plate positioned within the container interior and adapted to movably close the first opening and effect dispensing of product.

25 23. The packaging system of one of claims 21 or 22, wherein the container comprises a rigid cylindrical container.

24. The packaging system of one of claims 21 to 23, wherein the container comprises a neck portion adapted to connect to a dispensing assembly.

30 25. The packaging system of claim 24, wherein the neck portion comprises a fastening member adapted to connect to the dispensing assembly, the fastening member selected from a location fit, a press fit, a

screw thread, a twist lock, a tab, a slot, a snap fit, or a combination thereof.

5 26. The packaging system of one of claims 21 to 25, wherein the pouch comprises a flexible, thermoplastic pouch.

10 27. The packaging system of one of claims 21 to 26, wherein the pouch has an oxygen transmission rate of no more than $50 \text{ cc/m}^2/24 \text{ hr.}$ at 25°C , 0% RH, 1 atm in accordance with ASTM D 3985.

15 28. The packaging system of one of claims 21 to 27, wherein the pouch comprises a spout.

20 29. The packaging system of claim 28 wherein the frangible seal is positioned within the spout.

25 30. The packaging system of one of claims 21 to 29, wherein the frangible seal comprises:

30 a) a single label with a first face and a second face, the first face comprising a permanent sealant and the second face comprising a peelable sealant; or

b) first and second labels, each label comprising:

35 i) a first face, wherein the first face of the first label comprises a permanent sealant positioned adjacent the pouch front sheet and wherein the first face of the second label comprises a permanent sealant positioned adjacent to the pouch rear sheet; and

40 ii) a second face, wherein the second face of the first label comprises a peelable sealant positioned adjacent to the second label second face, and/or wherein the second face of the second label

comprises a peelable sealant positioned adjacent to the first label second face.

5 31. The packaging system of claim 30, wherein the permanent sealant is selected from the group comprising metallocene catalyzed polyethylene, Ziegler-Natta catalyzed linear low density polyethylene, propylene-ethylene copolymer, LDPE, ionomer resin, ethylene/vinyl acetate copolymers, ethylene/methyl methacrylate copolymers, ethylene/butyl acrylate copolymers, and combinations thereof.

10

32. The packaging system of one of claims 30 or 31, wherein the peelable sealant is selected from the group comprising blends of polyethylene and polybutylene, polyethylene, polyethylene blends, random propylene/ethylene copolymer blends, EVA/polypropylene blends, 15 LDPE/polypropylene blends, or combinations thereof.

33. The packaging system of one of claims 21 to 32, wherein the flowable product comprises a condiment.

20

34. The packaging system of one of claims 21 to 33, wherein the dispensing assembly comprises

- a) a valve,
- b) a valve housing, and
- c) a connecting portion that is in engagement with the 25 container.

25

35. The packaging system of claim 34 wherein the valve is selected from the group comprising an umbrella valve, a duckbill valve, a reed valve, a ball valve, a flapper valve, a poppet valve, a Gott valve, a check 30 valve, and combinations thereof.

30

36. The packaging system of one of claims 34 or 35, wherein the valve housing comprises a valve seat.

37. The packaging system of claim 36, wherein the valve seat comprises a retaining ring, retaining clip, or flange.

5 38. The packaging system of one of claims 21 to 37, further comprising a diffuser connected to the valve housing.

39. The packaging system of claim 38 wherein the diffuser is connected to the valve housing with a snap fit.

10

40. The packaging system of one of claims 38 or 39, wherein the diffuser comprises two or more outlets.

41. A package comprising:

15

- a) a pouch comprising a first and second panel with a frangible seal disposed between the panels, and
- b) a flowable product disposed in the pouch,
wherein the pouch comprises

20

- i) a first transverse seal at a first end of the pouch,
- ii) a second transverse seal at a second end of the pouch,
- iii) a first fold at a first side edge of the pouch,
- iv) a second fold at a second side edge of the pouch, and
- v) a longitudinal seal extending from the first end of the pouch to the second end of the pouch;

25

wherein the first transverse seal comprises

- (i) a central seal segment intersected by the longitudinal axis of the pouch;
- (ii) a second and third seal segment each arranged oblique to the longitudinal axis of the pouch, the second seal segment in communication with the first fold, and the third seal segment in communication with the second fold, and
- (iii) a fourth and fifth seal segment each arranged substantially perpendicular to the longitudinal axis of the

30

5 pouch, the fourth seal segment in communication at one end thereof with the second seal segment, and at the other end thereof with the central seal segment, and the fifth seal segment in communication at one end thereof with the third seal segment, and at the other end thereof with the central seal segment.

10 42. The package of claim 41 wherein the pouch comprises a flexible, thermoplastic pouch.

15 43. The package of one of claims 41 or 42, wherein the pouch has an oxygen transmission rate of no more than $50 \text{ cc/m}^2/24 \text{ hr.}$ at 25°C , 0% RH, 1 atm in accordance with ASTM D 3985.

20 44. The package of one of claims 41 to 43, wherein the pouch comprises a spout.

25 45. The package of claim 44 wherein the frangible seal is positioned within the spout.

30 46. The package of one of claims 41 to 45, wherein the frangible seal comprises:

a) a single label with a first face and a second face, the first face comprising a permanent sealant and the second face comprising a peelable sealant; or

b) first and second labels, each label comprising:

35 i) a first face, wherein the first face of the first label comprises a permanent sealant positioned adjacent the pouch front sheet and wherein the first face of the second label comprises a

permanent sealant positioned adjacent to the pouch rear sheet; and

- ii) a second face, wherein the second face of the first label comprises a peelable sealant positioned adjacent to the second label second face, and/or wherein the second face of the second label comprises a peelable sealant positioned adjacent to the first label second face.

5

10 47. The package of claim 46 wherein the permanent sealant is selected from the group comprising metallocene catalyzed polyethylene, Ziegler-Natta catalyzed linear low density polyethylene, propylene-ethylene copolymer, LDPE, ionomer resin, ethylene/vinyl acetate copolymers, ethylene/methyl methacrylate copolymers, ethylene/butyl acrylate copolymers, and combinations thereof.

15

48. The package of one of claims 46 or 47, wherein the peelable sealant is selected from the group comprising blends of polyethylene and polybutylene, polyethylene, polyethylene blends, random propylene/ethylene copolymer blends, EVA/polypropylene blends, LDPE/polypropylene blends, or combinations thereof.

20

49. The package of one of claims 41 to 48, wherein the central seal segment intersected by the longitudinal axis of the pouch comprises a substantially linear segment arranged substantially perpendicular to the longitudinal axis of the pouch.

25

50. The package of one of claims 41 to 49, wherein the flowable product comprises a condiment.

30

51. A dispensing assembly comprising:

- a) a valve,

- b) a valve housing that retains the valve, and
- c) a connecting portion that functionally cooperates with, and is in engagement with a container.

5 52. The dispensing assembly of claim 51 wherein the valve is selected from the group consisting of an umbrella valve, duckbill valve, reed valve, ball valve, flapper valve, poppet valve, Gott valve, check valve, or any suitable combination thereof.

10 53. The dispensing assembly of one of claims 51 or 52 wherein the valve comprises four arms defined by a cross-cut in a central portion of the valve.

15 54. The dispensing assembly of one of claims 51 to 53 further comprising a retainer adapted to secure the valve within the valve housing.

 55. The dispensing assembly of claim 54 wherein the retainer is selected from a retaining ring, a retaining clip, or a flange.

20 56. The dispensing assembly of one of claims 51 to 55 wherein at least one of the valve housing and the connecting portion comprises an interior surface and an exterior surface, at least one of which comprises a fastening member selected from the group comprising a location fit, a press fit, a screw thread, a twist lock, a tab, a slot, a snap fit, or
25 combinations thereof.

 57. The dispensing assembly of one of claims 51 to 56 further comprising a diffuser connected to the valve housing.

30 58. The dispensing assembly of claim 57 wherein the diffuser connected to the valve housing by a snap fit.

59. The dispensing assembly of one of claims 57 and 58 wherein the diffuser comprises at least one outlet configured to facilitate the flow of the flowable product through the diffuser.

- 5 60. A dispensing gun system comprising:
- a) a dispensing gun comprising a piston;
 - b) a cylindrical container having an interior surface,
 - c) a cylindrical pusher plate, having an annular outside edge, attached to the piston, and configured, when
10 advanced by the piston into the container, to fit within the container in close proximity to the interior surface of the container; and
 - d) a package disposed within the container, the package comprising a film having a thickness.

15

61. The dispensing gun system of claim 60, wherein the space between the annular outside edge of the pusher plate and the interior surface of the container, as the pusher plate passes through the interior of the container, is less than three times the thickness of the
20 film of the package

20

62. The dispensing gun system of one of claims 60 or 61, wherein the dispensing gun comprises a barrel having a substantially hemispheric cross section.

25

63. The dispensing gun system of one of claims 60 to 62, wherein the dispensing gun comprises a piston and a trigger.

30

64. The dispensing gun system of one of claims 60 to 63, wherein the cylindrical pusher plate is configured, when advanced by the piston into the container, to fit within the container in close proximity to the interior surface of the container, with a gap between the outside diameter of the

pusher plate and the interior surface of the container, of between 0.05 mm and 1 mm.

5 65. The dispensing gun system of one of claims 60 to 64, wherein the cylindrical pusher plate comprises:

- 10 a) a first and second planar surface, ,
- b) a circumferential edge, the circumferential edge normal to and joining the first and second planar surfaces, and
- c) a circumferential bevel located on the first planar surface and joining the first planar surface to the circumferential edge.

15 66. The dispensing gun system of claim 65, wherein the first and second planar surface are substantially parallel to one another.

67. A method of making a package in a vertical form/fill/seal process comprising:

- 20 a) providing a lay-flat web on a first roll, the lay-flat web comprising a first and second surface;
- b) providing a film strip on a second roll, a first surface of the film strip comprising a peelable interface, and a second surface of the film strip comprising a permanent sealant;
- 25 c) advancing the lay-flat web over a forming device to convert the lay-flat web to a folded web having an interior surface;
- d) advancing the film strip to an apparatus that seals the film strip to the lay-flat web, and cuts the film strip into a label, such that when the package is made, the label is disposed between a first and second panel of the package;
- 30 e) making a longitudinal seal in the folded web;
- f) transversely sealing the folded web to produce a first transverse seal to define a first pouch, wherein the first

transverse seal is a bottom transverse seal of the first pouch;

- 5
- g) putting a product in the first pouch;
 - h) advancing the folded web, with the first pouch, downward a predetermined distance;
 - i) transversely sealing the first pouch to produce a top transverse seal in the first pouch, and a bottom transverse seal in a second pouch, the second pouch disposed above the first pouch; and
 - 10 j) transversely cutting the folded web to separate the first pouch from the second pouch to make a package, the package comprising the first and second panels and the label;

15 wherein at any time before or during the step of making a longitudinal seal in the folded web, the label is sealed to the lay-flat web or the folded web.

68. The method of claim 67 wherein the peelable interface comprises

- 20
- a) a peelable sealant, or
 - b) a printed area on a surface of the film strip that when sealed to the film web, results in a peelable surface.

69. The method of claim 68 wherein the printed area comprises an antifog material.

25 70. A method of dispensing a product, comprising:

- 30
- a) providing a packaging system comprising
 - i) a container comprising a first and second end, first and second openings and an interior,
 - ii) a package positioned within the container interior, the package comprising a pouch comprising a first and second panel with a frangible seal positioned

between the panels, and a flowable product disposed in the pouch; and

iii) a dispensing assembly;

b) providing a dispensing gun configured to house the packaging system;

c) inserting the packaging system into the dispensing gun;

and

d) initiating linear movement of a pusher plate through the interior of the container to cause the product to be dispensed through the dispensing assembly.

71. The method of claim 70 wherein movement of the pusher plate is accomplished by activating a dispensing gun trigger.

72. The method of one of claims 70 or 71, wherein a metered volume of product is dispensed.

73. The method of one of claims 70 to 72, wherein the product is a condiment.

74. The method of one of claims 70 to 73, wherein the dispensing assembly comprises a diffuser.

75. A method of making a package in a vertical form/fill/seal process comprising:

a) providing a lay-flat web on a roll, the lay-flat web comprising a label having a first surface comprising a peelable interface, and a second surface comprising a permanent sealant, one of the first and second surfaces adhered to the lay-flat web;

b) advancing the lay-flat web with the label adhered thereto over a forming device to convert the lay-flat web to a folded web having an interior surface;

c) making a longitudinal seal in the folded web;

- 5
- 10
- 15
- d) transversely sealing the folded web to produce a first transverse seal to define a first pouch, wherein the first transverse seal is a bottom transverse seal of the first pouch;
 - e) putting a product in the first pouch;
 - f) advancing the folded web, with the first pouch, downward a predetermined distance;
 - g) transversely sealing the first pouch to produce a top transverse seal in the first pouch, and a bottom transverse seal in a second pouch, the second pouch disposed above the first pouch; and
 - h) transversely cutting the folded web to separate the first pouch from the second pouch to make a package, the package comprising a first and second panel with the label disposed between and sealed to the panels to provide a frangible seal.

- 20
76. The method of claim 75 wherein the peelable interface comprises
- a) a peelable sealant, or
 - b) a printed area on a surface of the film strip that when sealed to the film web, results in a peelable surface.

- 25
77. The method of claim 76 wherein the printed area comprises an antifog material.

- 30
78. A method of making a package in a vertical form/fill/seal process comprising:
- a) providing a lay-flat web on a first roll, the lay-flat web comprising a first and second surface;
 - b) advancing the lay-flat web over a forming device to convert the lay-flat web to a folded web having an interior surface;

- 5
- c) making a longitudinal seal in the folded web;
 - d) transversely sealing the folded web to produce a first transverse seal to define a first pouch, wherein the first transverse seal is a bottom transverse seal of the first pouch;
 - e) putting a product in the first pouch;
 - f) advancing the folded web, with the first pouch, downward a predetermined distance;
 - 10 g) transversely sealing the first pouch to produce a top transverse seal in the first pouch, and a bottom transverse seal in a second pouch, the second pouch disposed above the first pouch; and
 - 15 h) transversely cutting the folded web to separate the first pouch from the second pouch to make a package, the package comprising the first and second panels and the label;

20 wherein at any time before or during the step of making a longitudinal seal in the folded web, the lay-flat web or the folded web is selectively treated to produce an area, on the interior surface of the package, that comprises a frangible seal.

79. The method of claim 78 wherein the lay-flat web is selectively treated by a process selected from any of:

- 25
- a) printing a selective area of the lay-flat web or folded web with a material that lowers the seal strength of the selected area;
 - b) cross-linking a selective area of the lay-flat web or folded web to lower the seal strength of the selected area; and
 - 30 c) applying an adhesive on a selective area of the lay-flat web or folded web that lowers the seal strength of the selected area.

80. A method of making a package in a vertical form/fill/seal process comprising:

- 5
- a) providing a lay-flat web on a roll, wherein the lay-flat web has been selectively treated to produce an area, on the interior surface of the package, that comprises a frangible seal;
- b) advancing the lay-flat web over a forming device to convert the lay-flat web to a folded web having an interior surface;
- 10
- c) making a longitudinal seal in the folded web;
- d) transversely sealing the folded web to produce a first transverse seal to define a first pouch, wherein the first transverse seal is a bottom transverse seal of the first pouch;
- 15
- e) putting a product in the first pouch;
- f) advancing the folded web, with the first pouch, downward a predetermined distance;
- g) transversely sealing the first pouch to produce a top transverse seal in the first pouch, and a bottom transverse seal in a second pouch, the second pouch disposed above the first pouch; and
- 20
- h) transversely cutting the folded web to separate the first pouch from the second pouch to make the package.

25

81. The method of claim 80 wherein the lay-flat web has been selectively treated by a process selected from any of:

- a) printing a selective area of the lay-flat web with a material that lowers the seal strength of the selected area;
- b) cross-linking a selective area of the lay-flat web to lower the seal strength of the selected area; and
- 30
- c) applying an adhesive on a selective area of the lay-flat web that lowers the seal strength of the selected area.

82. A method of making a package in a vertical form/fill/seal process comprising:

- 5
- a) providing a lay-flat web comprising an easy-open sealant;
 - b) advancing the lay-flat web over a forming device to convert the lay-flat web to a folded web having an interior surface comprising the easy-open sealant;
 - c) making a longitudinal seal in the folded web;
 - d) transversely sealing the folded web to produce a first transverse seal to define a first pouch, wherein the first transverse seal is a bottom transverse seal of the first pouch;
 - e) putting a product in the first pouch;
 - f) advancing the folded web, with the first pouch, downward a predetermined distance;
 - 15 g) transversely sealing the first pouch to produce a top transverse seal in the first pouch, and a bottom transverse seal in a second pouch, the second pouch disposed above the first pouch; and
 - 20 h) transversely cutting the folded web to separate the first pouch from the second pouch to make a package comprising a frangible seal.

83. A dispensing assembly comprising:

- 25
- a) a diffuser comprising an outlet valve;
 - b) a valve in juxtaposed relation to the outlet;
 - c) a housing; and
 - c) a connecting portion that functionally cooperates with, and is in engagement with a container.

30 84. The dispensing assembly of claim 83 wherein the valve is selected from the group consisting of an umbrella valve, duckbill valve, reed valve, ball valve, flapper valve, poppet valve, Gott valve, check valve, or any suitable combination thereof.

85. The dispensing assembly of one of claims 83 or 84 wherein the valve comprises four arms defined by a cross-cut in a central portion of the valve.

5

86. The dispensing assembly of one of claims 83 to 85 further comprising a retainer adapted to secure the valve within the diffuser.

87. The dispensing assembly of claim 86 wherein the retainer is selected from a retaining ring, a retaining clip, or a flange.

10

88. The dispensing assembly of one of claims 83 to 87 wherein the housing comprises an interior surface and an exterior surface, at least one of which comprises a fastening member selected from the group comprising a location fit, a press fit, a screw thread, a twist lock, a tab, a slot, a snap fit, or combinations thereof.

15

89. The dispensing assembly of one of claims 83 to 88 wherein the connecting portion comprises an interior surface and an exterior surface, at least one of which comprises a fastening member selected from the group comprising a location fit, a press fit, a screw thread, a twist lock, a tab, a slot, a snap fit, or combinations thereof.

20

90. The dispensing assembly of one of claims 83 to 89 wherein the diffuser is connected to the housing by a snap fit.

25

91. The dispensing assembly of one of claims 83 to 90 further comprising a single disc, juxtaposed adjacent the diffuser, that bears the valve.

30

92. The dispensing assembly of one of claims 83 to 90 further comprising a single disc, juxtaposed adjacent the diffuser, that bears a plurality of valves, each valve positioned adjacent a respective outlet.

93. A method of making a package in a horizontal form/fill/seal process comprising:

- 5
- a) providing a lay-flat web on a first roll, the lay-flat web having a first and second longitudinal edge;
 - b) providing a film strip on a second roll, a first surface of the film strip comprising a peelable interface, and a second surface of the film strip comprising a permanent sealant;
 - 10 c) advancing the lay-flat web to a forming device to convert the lay-flat web to a folded web having an interior surface;
 - d) advancing the film strip to an apparatus that seals the film strip to the lay-flat web, and cuts the film strip into a label, such that when the package is made, the label is disposed between a first and second panel of the
 - 15 e) making side seals in the folded web to produce an open pouch comprising the first and second panels and the label;
 - f) putting a product in the open pouch; and
 - 20 g) sealing the first side panel to the second side panel to close the pouch;

wherein

at any time before putting a product in the open pouch, the film strip is attached to the lay-flat web or the folded web:

25 at any time before or during the step of making side seals in the folded web, the label is sealed to the lay-flat web or the folded web; and

30 the web is cut at the side seals during or after the step of making side seals in the folded web to make a package comprising a frangible seal.

94. A method of making a package in a horizontal form/fill/seal process comprising:

- 5
- a) providing a lay-flat web on a roll, the lay-flat web comprising a label having a first surface comprising a peelable interface, and a second surface comprising a permanent sealant, one of the first and second surfaces attached to the lay-flat web;
- b) advancing the lay-flat web with the label adhered thereto to a forming device to convert the lay-flat web to a folded web having an interior surface;
- 10 c) making side seals in the folded web to produce an open pouch comprising the first and second panels and the label;
- d) putting a product in the open pouch; and
- e) sealing the first side panel to the second side panel to close the pouch;
- 15 wherein the web is cut at the side seals during or after the step of making side seals in the folded web to make a package comprising a frangible seal.
- 20 95. The method of one of claims 93 or 94 wherein the peelable interface comprises
- a) a peelable sealant, or
- b) a printed area on a surface of the film strip that when sealed to the film web, results in a peelable surface.
- 25 96. The method of claim 95 wherein the printed area comprises an antifog material.
- 30 97. A method of making a package in a horizontal form/fill/seal process comprising:
- a) providing a lay-flat web;
- b) advancing the lay-flat web to a forming device to convert the lay-flat web to a folded web having an interior surface;

- 5
- c) making side seals in the folded web to produce an open pouch comprising a first and second panel;
 - d) putting a product in the open pouch; and
 - e) sealing the first panel to the second panel to close the pouch;

wherein

the web is cut at the side seals during or after the step of making side seals in the folded web, and

10 at any time before or during the step of making side seals in the folded web, the lay-flat web or the folded web is selectively treated to produce an area, on the interior surface of the package, that comprises a frangible seal.

15 98. The method of claim 95 wherein the lay-flat web is selectively treated by a process selected from any of:

- a) printing a selective area of the lay-flat web or folded web with a material that lowers the seal strength of the selected area;
- 20 b) cross-linking a selective area of the lay-flat web or folded web to lower the seal strength of the selected area; and
- c) applying an adhesive on a selective area of the lay-flat web or folded web that lowers the seal strength of the selected area.

25 99. A method of making a package in a horizontal form/fill/seal process comprising:

- a) providing a lay-flat web on a roll, wherein the lay-flat web has been selectively treated to produce an area, on the interior surface of the package, that comprises a frangible seal;
- 30 b) advancing the lay-flat web to a forming device to convert the lay-flat web to a folded web having an interior surface;

- 5
- c) making side seals in the folded web to produce an open pouch comprising a first and second panel;
 - d) putting a product in the open pouch; and
 - e) sealing the first panel to the second panel to close the pouch;

wherein the web is cut at the side seals during or after the step of making side seals in the folded web.

10 100. The method of claim 99, wherein the lay-flat web has been selectively treated by a process selected from any of:

- 15
- a) printing a selective area of the lay-flat web with a material that lowers the seal strength of the selected area;
 - b) cross-linking a selective area of the lay-flat web to lower the seal strength of the selected area; and
 - c) applying an adhesive on a selective area of the lay-flat web that lowers the seal strength of the selected area.

20 101. A method of making a package in a horizontal form/fill/seal process comprising:

- 25
- a) providing a lay-flat web comprising an easy-open sealant;
 - b) advancing the lay-flat web to a forming device to convert the lay-flat web to a folded web having an interior surface;
 - c) making side seals in the folded web to produce an open pouch comprising a first and second panel;
 - d) putting a product in the open pouch; and
 - e) sealing the first panel to the second panel to close the pouch;

wherein the web is cut at the side seals during or after the step of making side seals in the folded web.

30 102. A segmented pusher plate comprising:

- a) an outer plate segment;
- b) an inner plate segment; and.

c) a biasing member;
wherein the outer and inner plate segments are arranged in a coaxial configuration, and are concentrically arranged.

5 103. The segmented pusher plate of claim 102 wherein the outer and inner plate segments are concentrically arranged within a single plane.

104. The segmented pusher plate of claim 102 wherein the outer and inner plate segments are concentrically arranged within two planes.

10

105. The segmented pusher plate of claim 102 comprising:

- i) an intermediate plate segment, concentrically disposed between the outer and inner plate segments;
- ii) a first biasing member that regulates the relative axial movement of the outer and intermediate plate segments, and
- iii) a second biasing member that regulates the relative axial movement of the intermediate and inner plate segments.

15

20 106. A composite pusher plate comprising:

- a) a rigid plate component; and
- b) an elastomeric plate component attached to the rigid plate component;

wherein the elastomeric plate component has a concave configuration on the surface thereof furthest from the rigid plate component.

25

107. The composite pusher plate of claim 106 wherein the rigid plate component comprises:

30

- a) an outer rigid plate segment; and
- b) an inner rigid plate segment;

wherein the outer and inner rigid plate segments are arranged in a coaxial configuration, and are concentrically arranged.

108. The package of one of claims 41 to 50 wherein the second transverse seal comprises

- 5
- (a) a central seal segment intersected by the longitudinal axis of the pouch;
- (b) a second and third seal segment each arranged oblique to the longitudinal axis of the pouch, the second seal segment in communication with the first fold, and the third seal segment in communication with the second fold, and
- 10
- (c) a fourth and fifth seal segment each arranged substantially perpendicular to the longitudinal axis of the pouch, the fourth seal segment in communication at one end thereof with the second seal segment, and at the other end thereof with the central seal segment, and the
- 15
- fifth seal segment in communication at one end thereof with the third seal segment, and at the other end thereof with the central seal segment.

20

109. The package of claim 108 wherein each of the first and second transverse seals comprises a skirt extending laterally from each side of the respective central seal segment.

25

110. The package of claim 109 comprising a slit disposed in each skirt, and extending obliquely from the longitudinal end of each skirt to the respective contoured seal.

30

111. A package comprising:

a) a pouch comprising a first and second panel with a frangible seal disposed between the panels, and

b) a flowable product disposed in the pouch,

wherein the pouch comprises

i) a first transverse seal at a first end of the pouch,

ii) a second transverse seal at a second end of the pouch,

- iii) a first fold at a first side edge of the pouch,
- iv) a second fold at a second side edge of the pouch, and
- v) a longitudinal seal extending from the first end of the pouch to the second end of the pouch;

5 wherein the first transverse seal comprises

- (i) a central seal segment intersected by the longitudinal axis of the pouch; and
- (ii) a second and third seal segment each arranged substantially perpendicular to the longitudinal axis of the pouch, the second seal segment in communication at one end thereof with the first fold, and at the other end thereof with the central seal segment, and the third seal segment in communication at one end thereof with the second fold, and at the other end thereof with the central seal segment.

10

15

112. A pusher plate system comprising:

- a) a rigid plate component; and
- b) an elastomeric plate component;

20

wherein the elastomeric plate component is disposed adjacent and in contacting relationship with the rigid plate.

25

113. The pusher plate system of claim 112 wherein the elastomeric plate component comprises an annular protrusion along the outside cylindrical periphery of the component.

114. The pusher plate system of one of claims 112 and 113 wherein the elastomeric plate component has an outside diameter greater than the outside diameter of the rigid plate component.

30

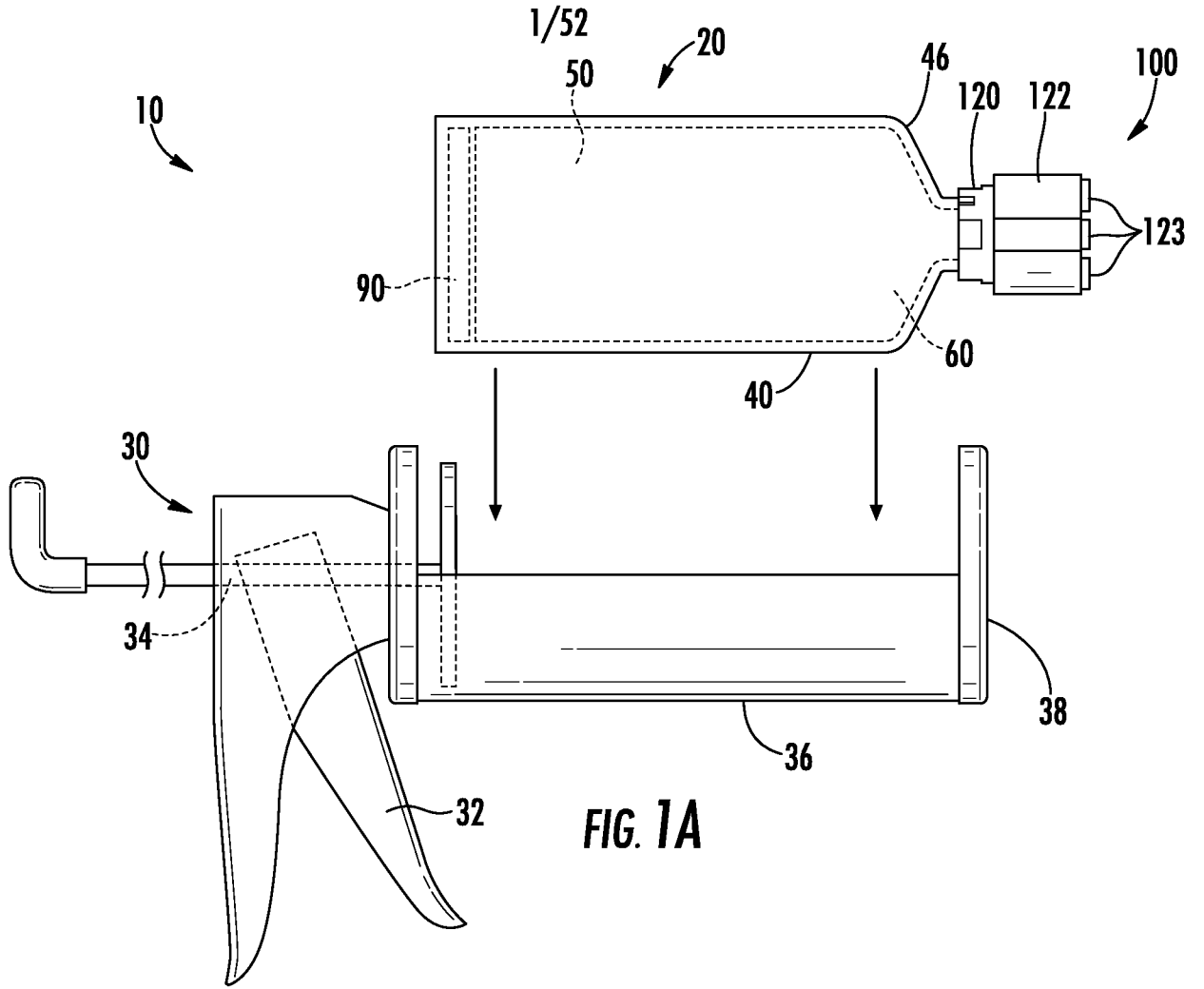


FIG. 1A

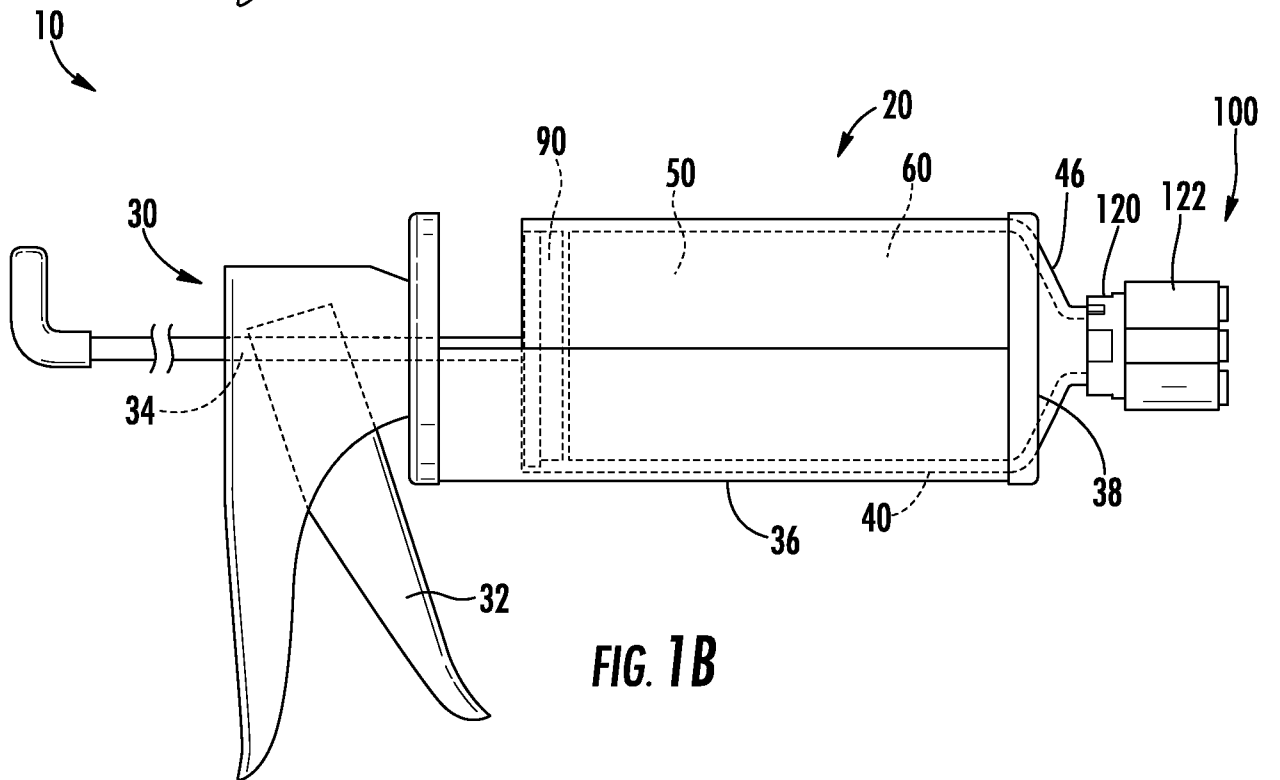


FIG. 1B

2/52

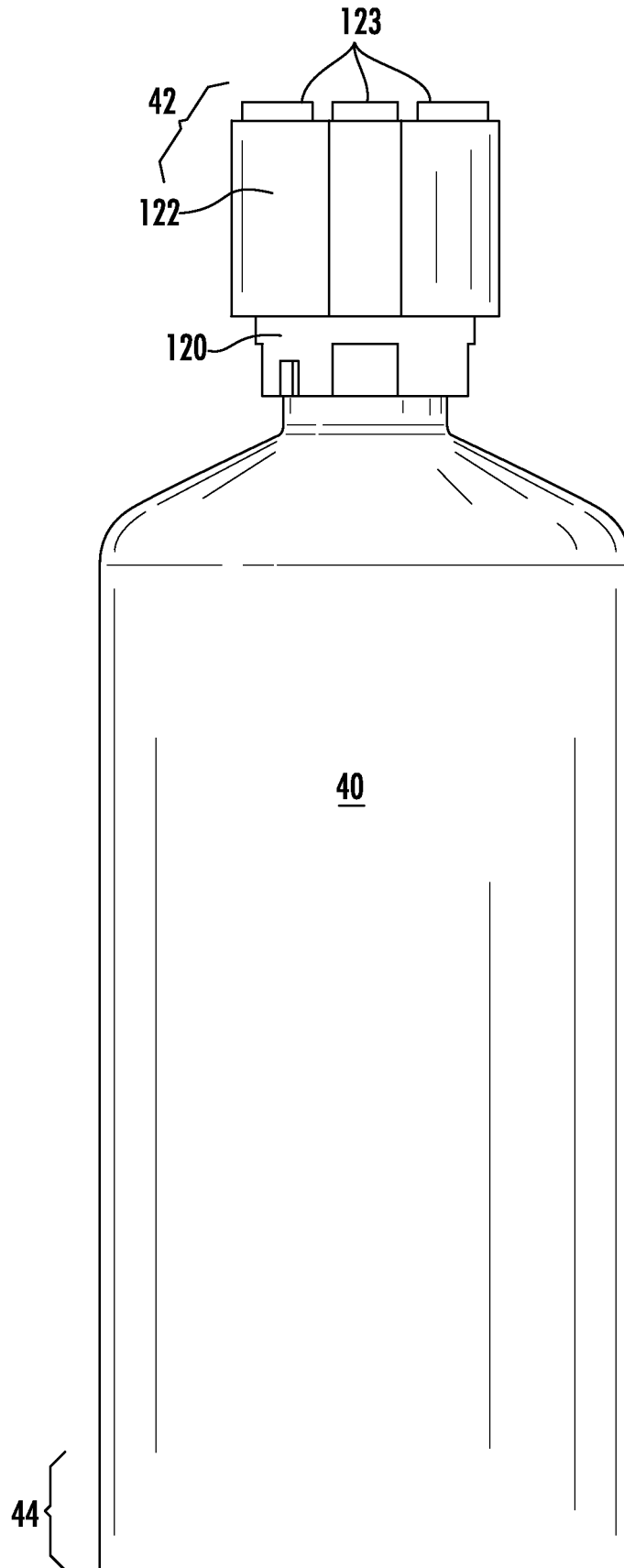
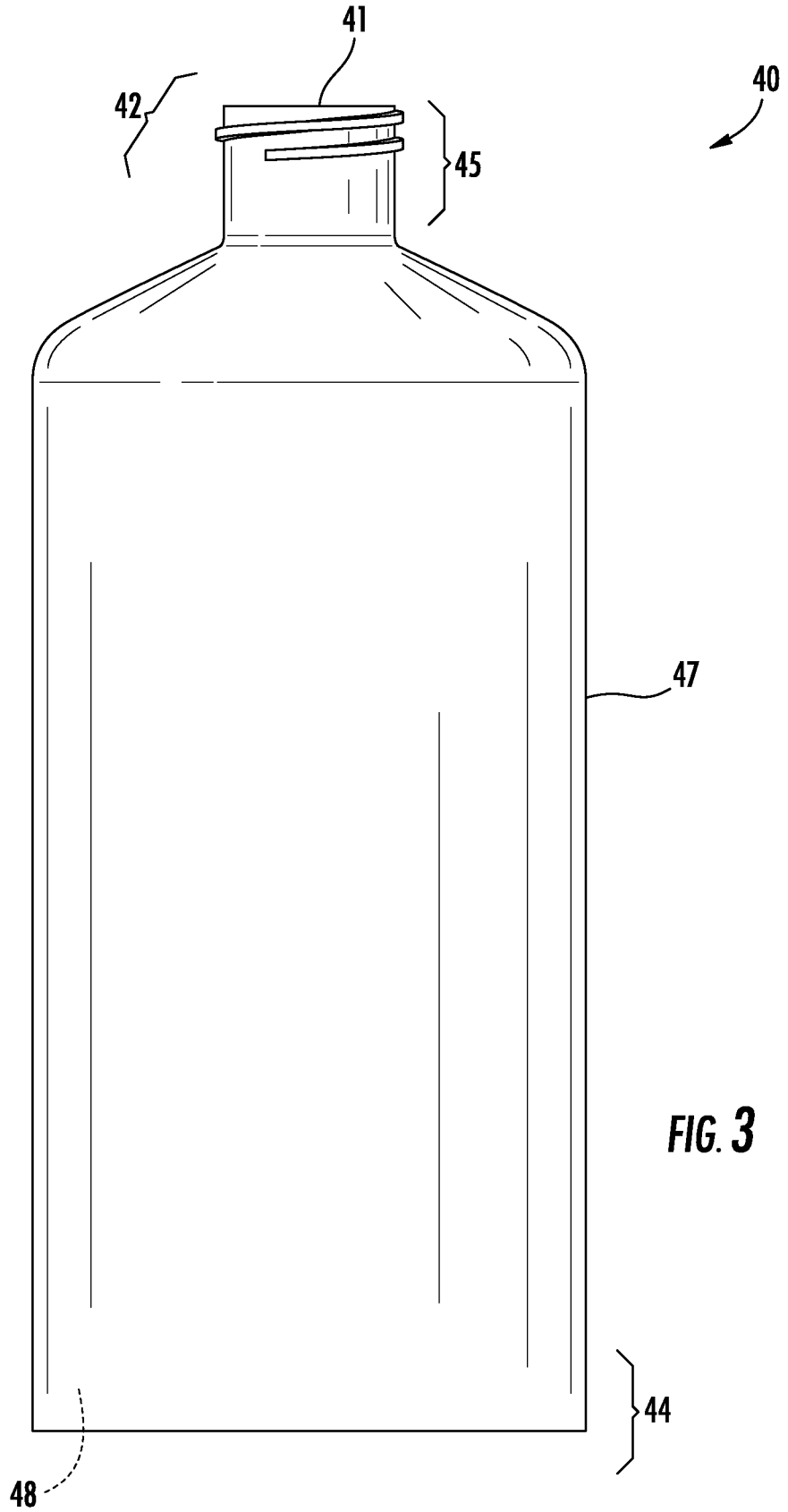


FIG. 2

3/52



4/52

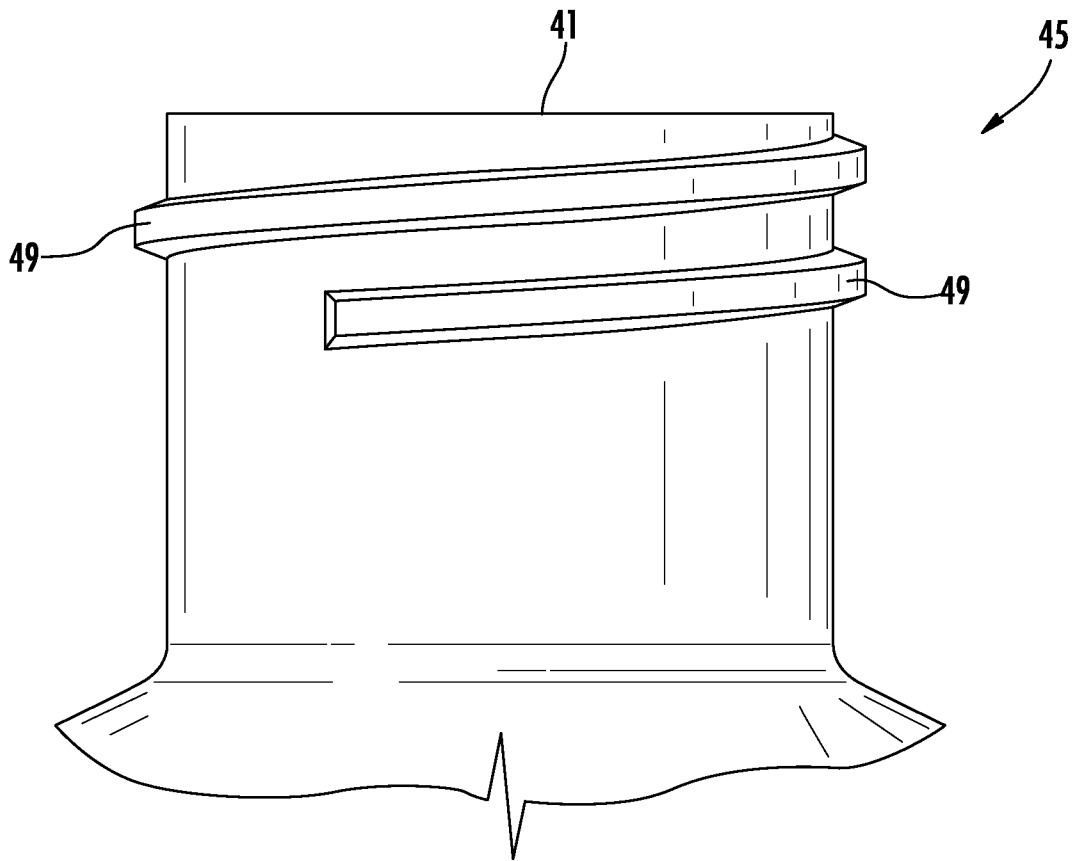
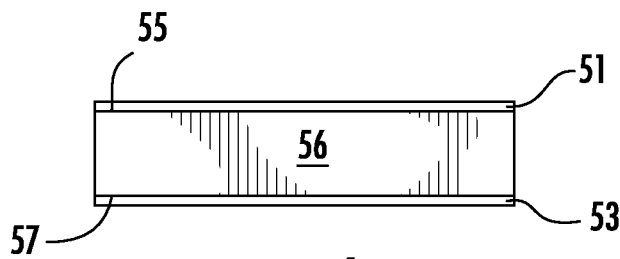
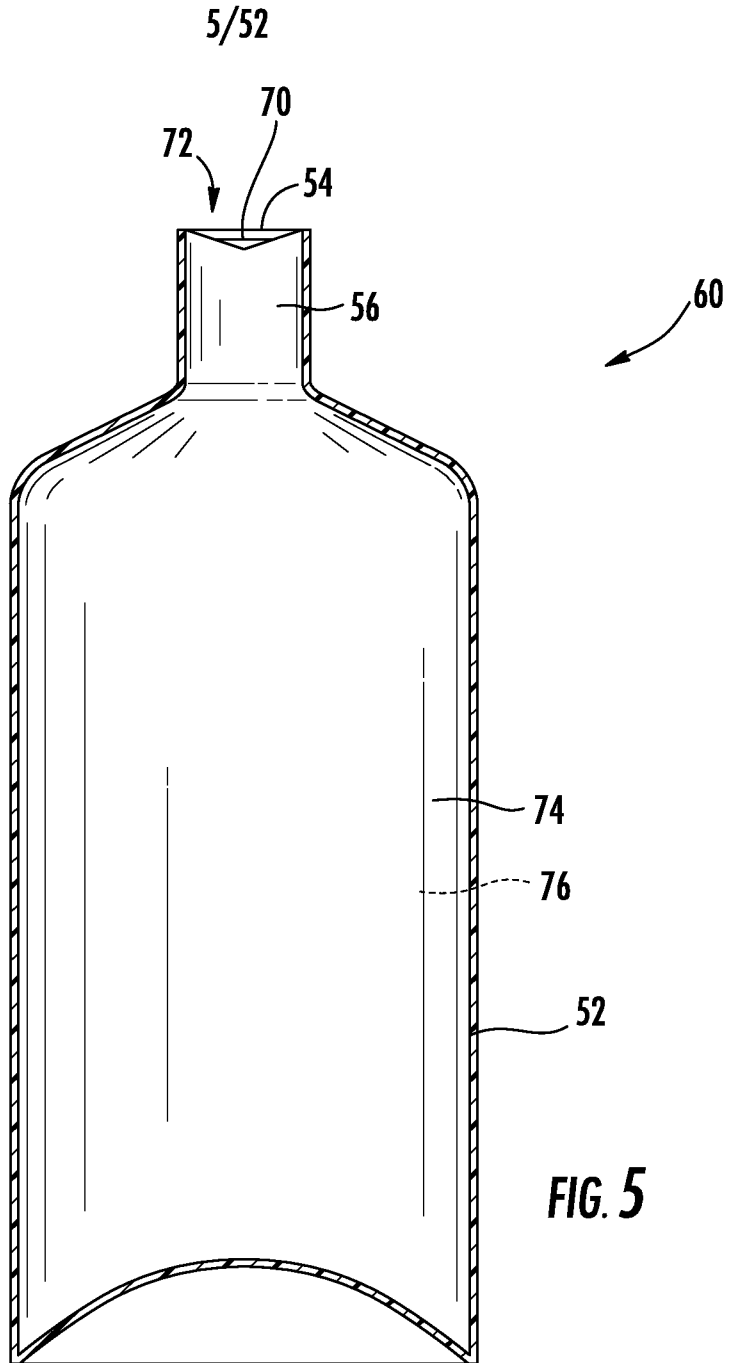


FIG. 4



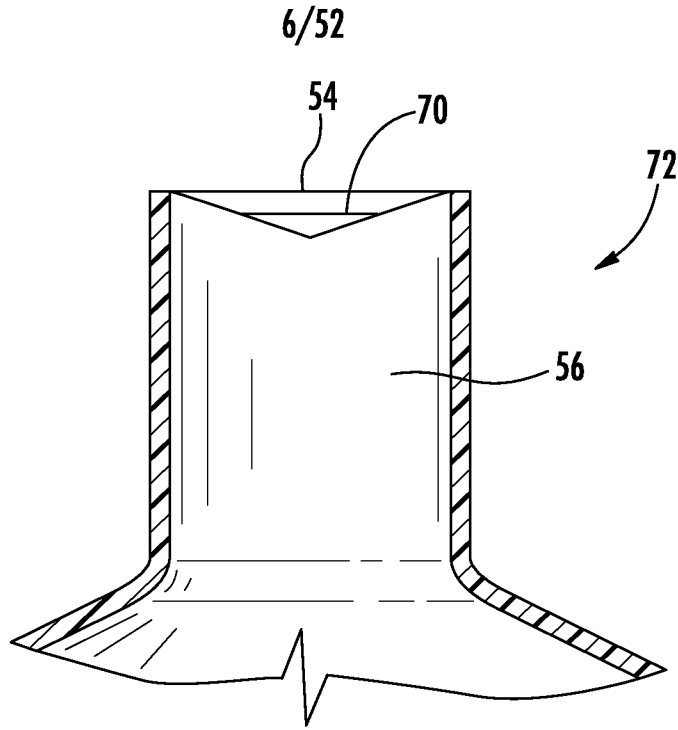


FIG. 7

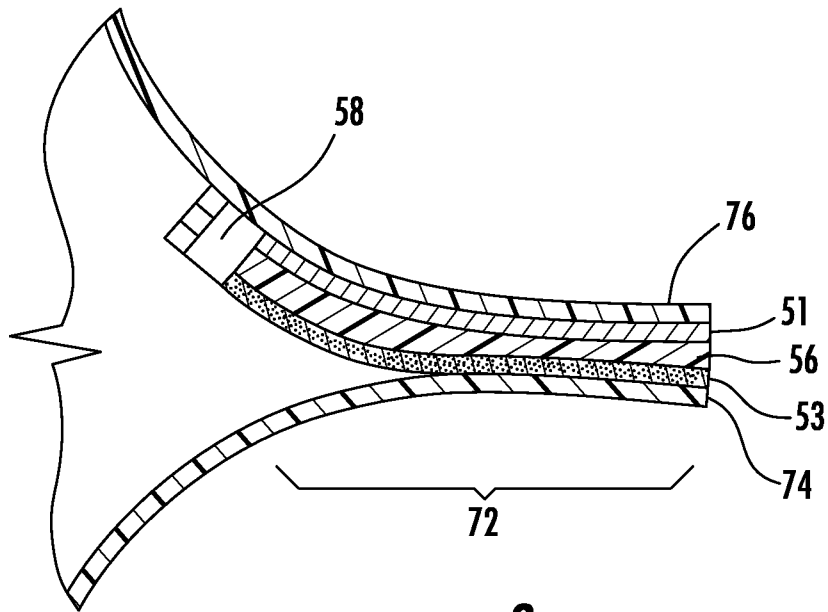


FIG. 8

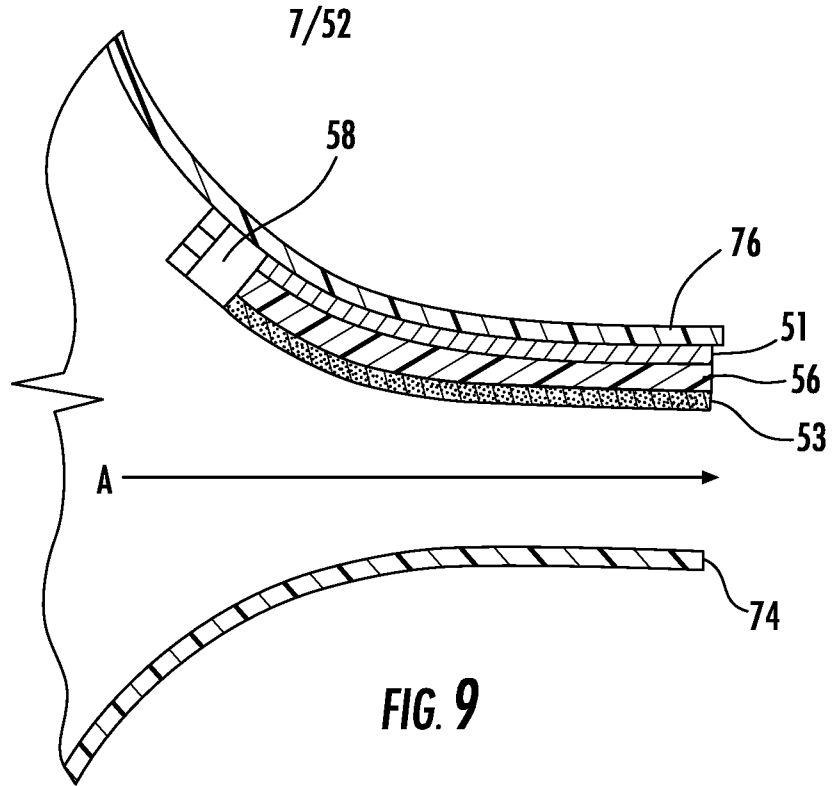


FIG. 9

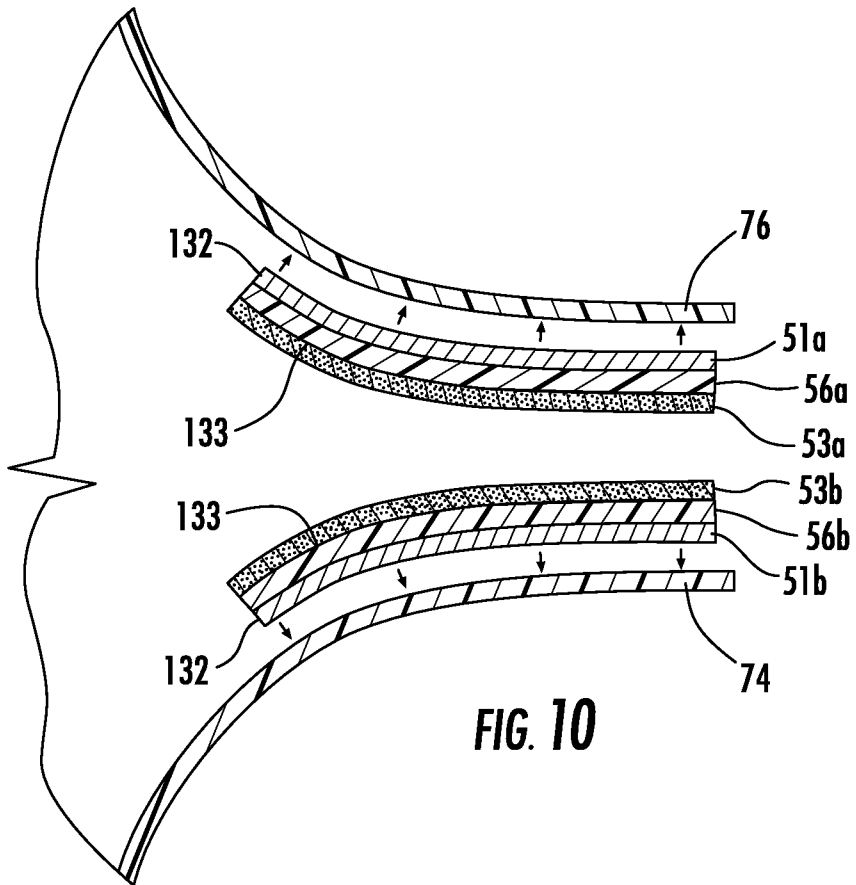


FIG. 10

8/52

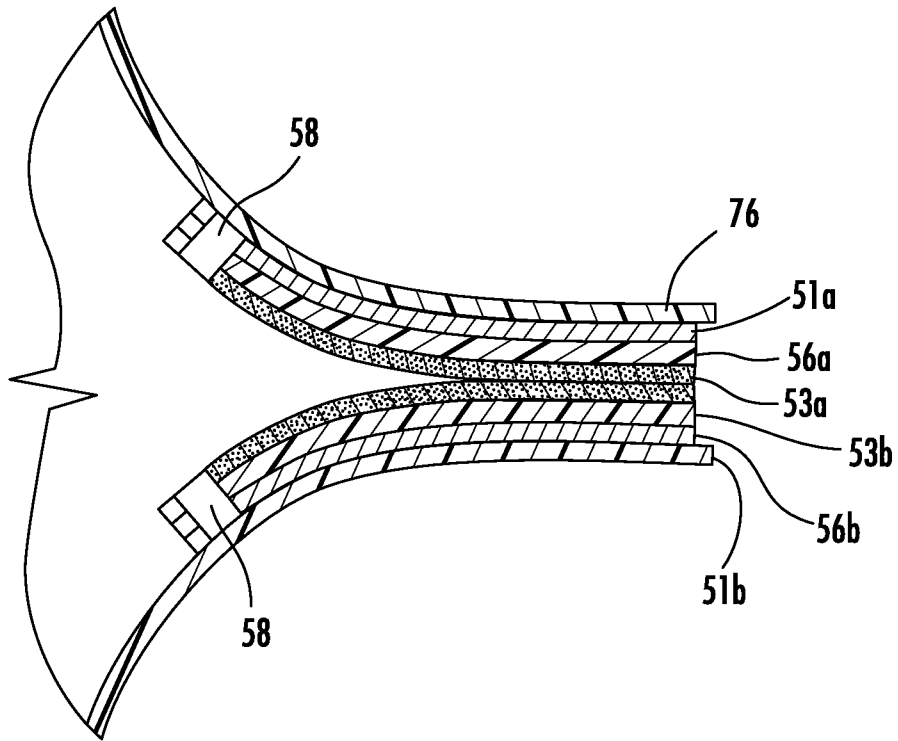


FIG. 11

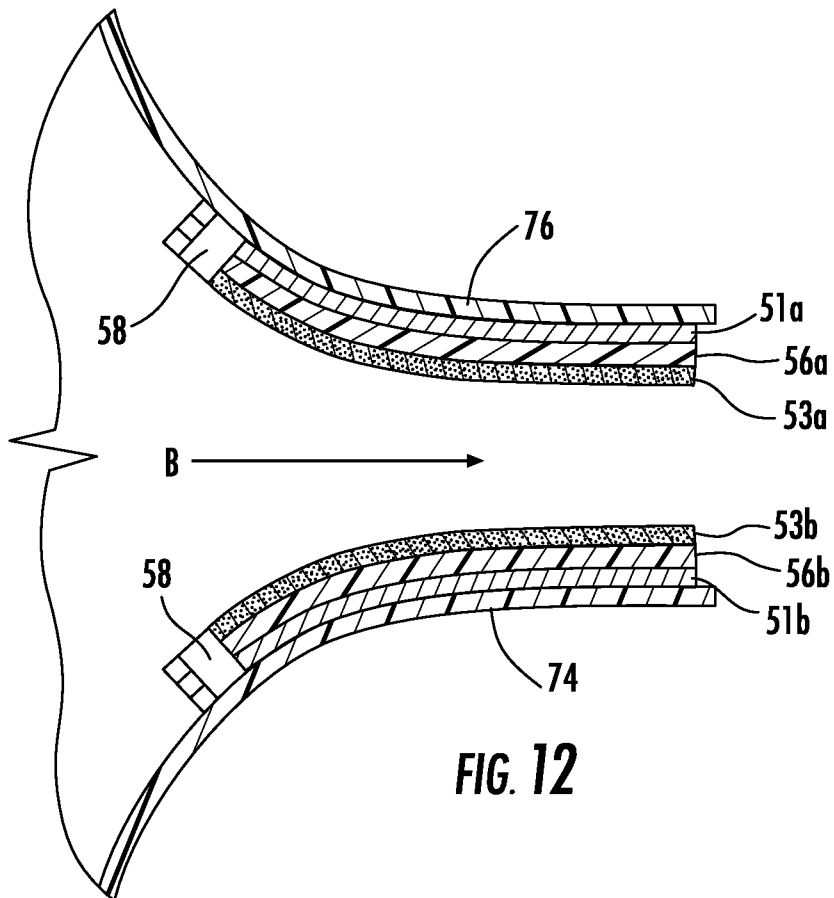


FIG. 12

9/52

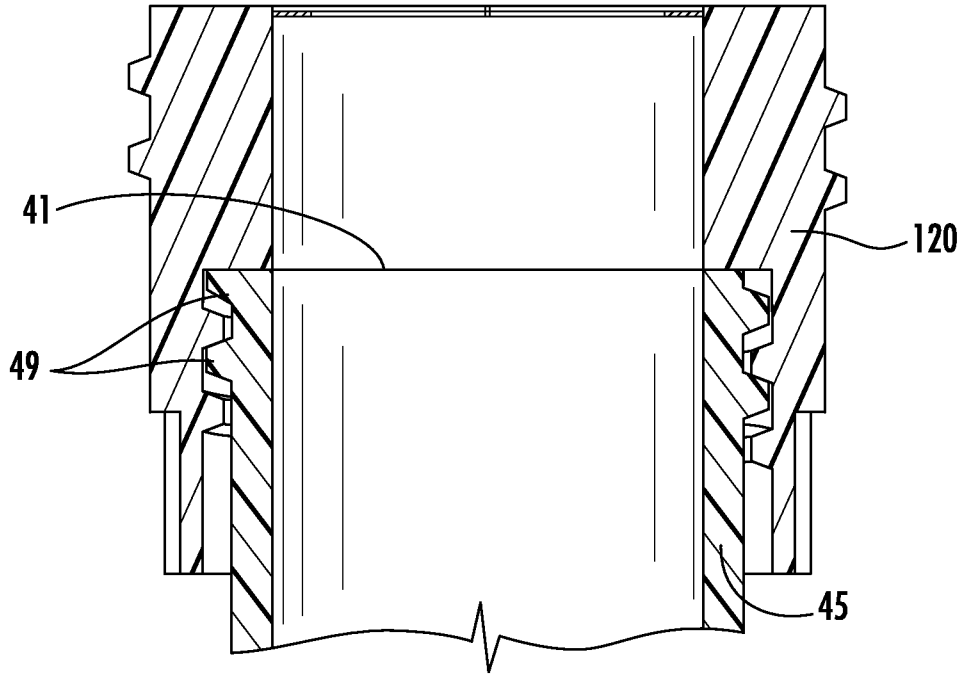


FIG. 13

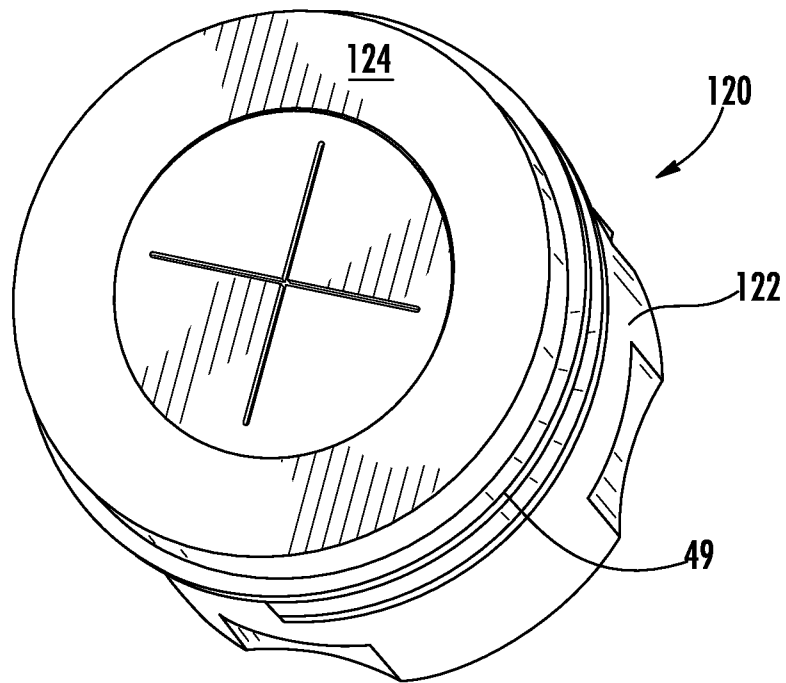


FIG. 14

10/52

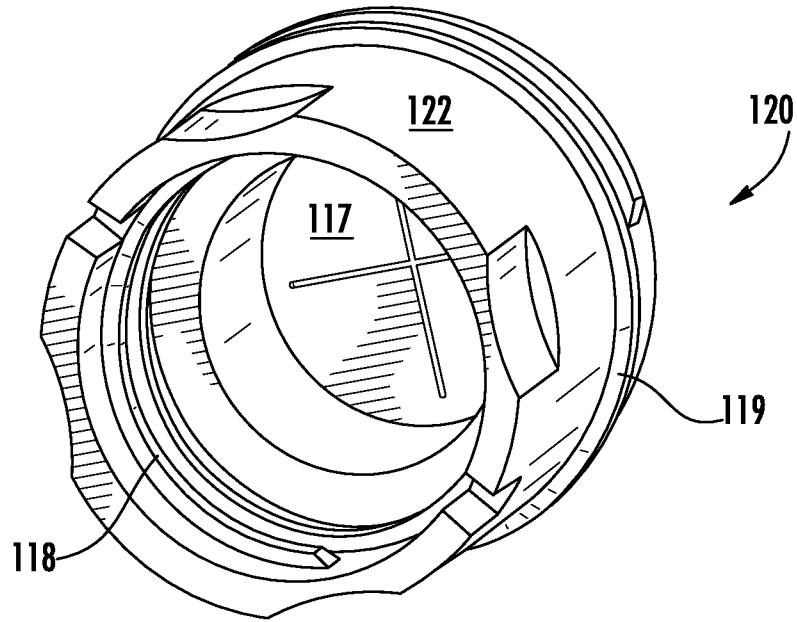


FIG. 15

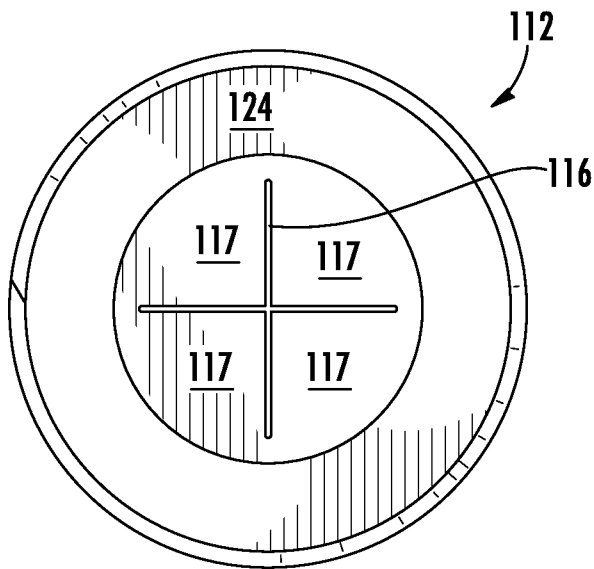


FIG. 16

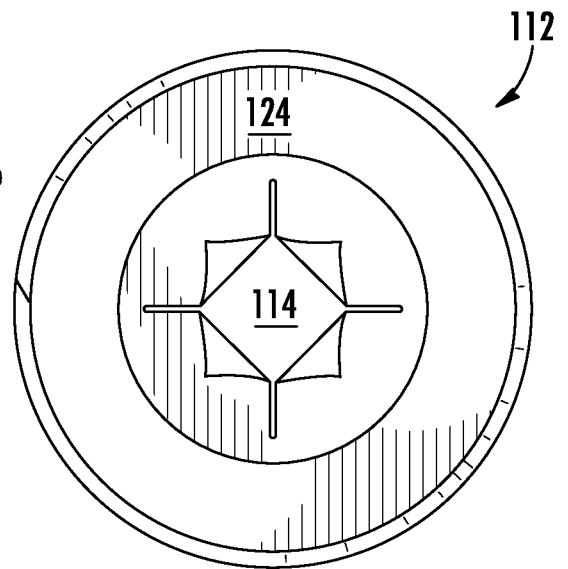


FIG. 17

11/52

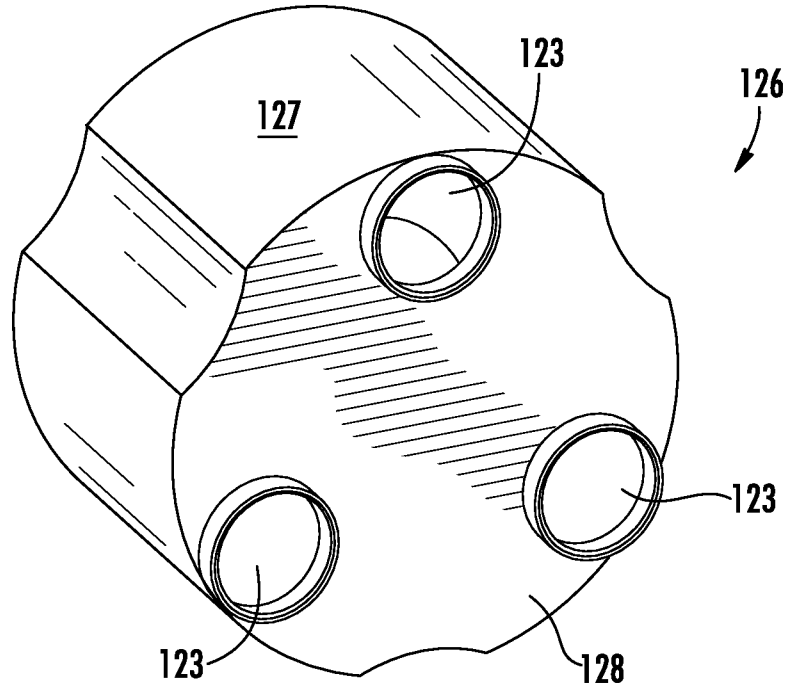


FIG. 18

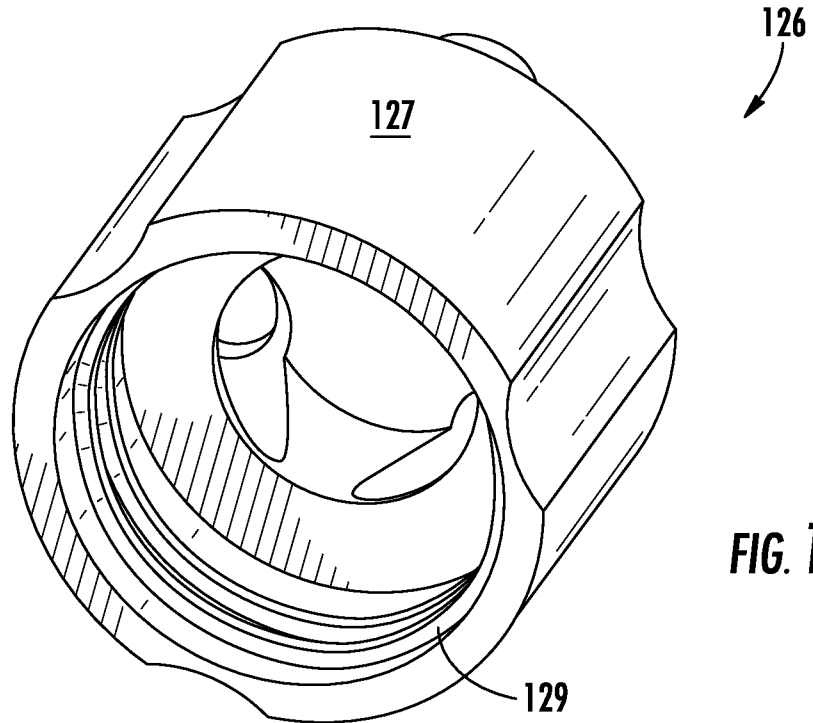


FIG. 19

12/52

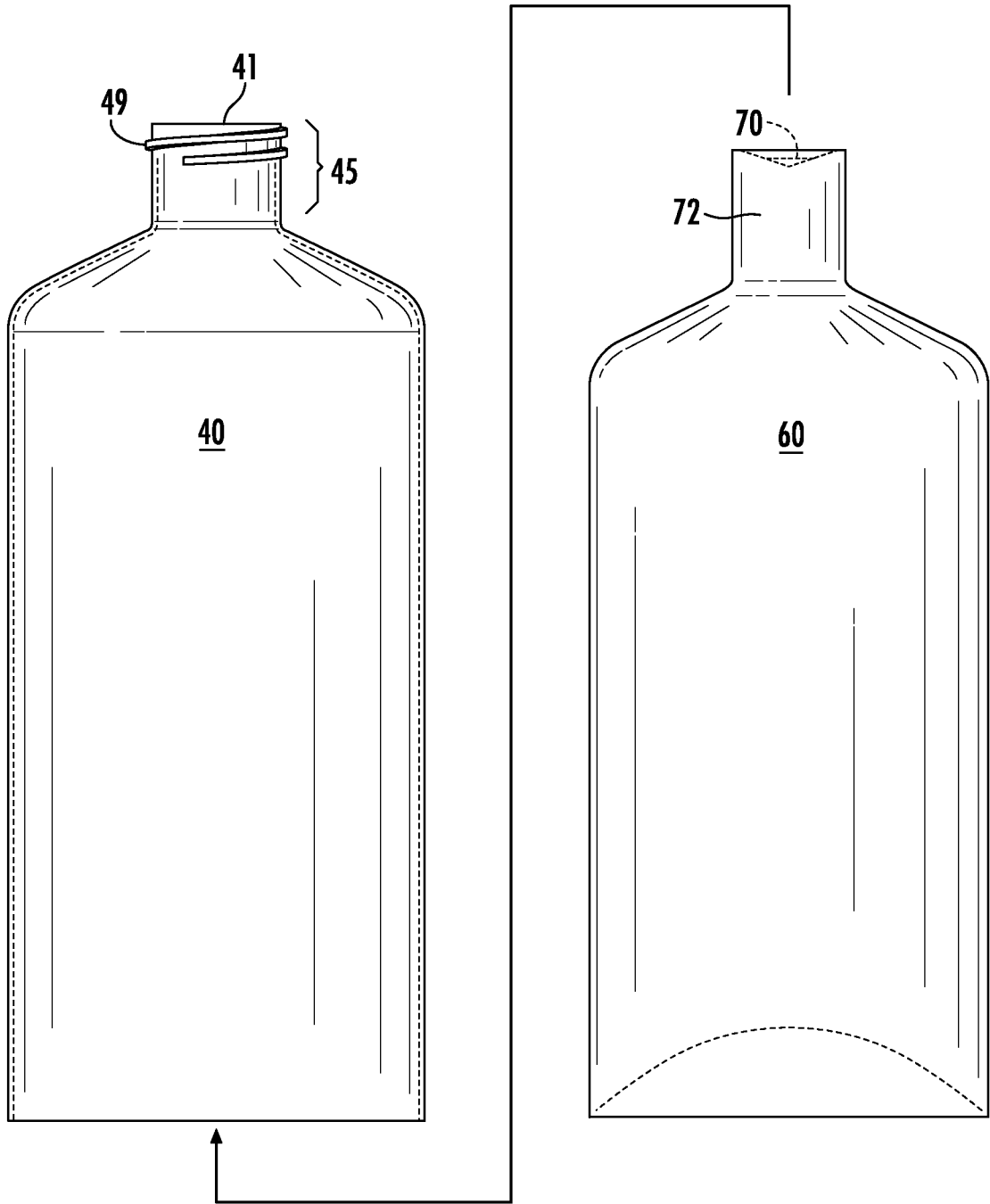


FIG. 20

13/52

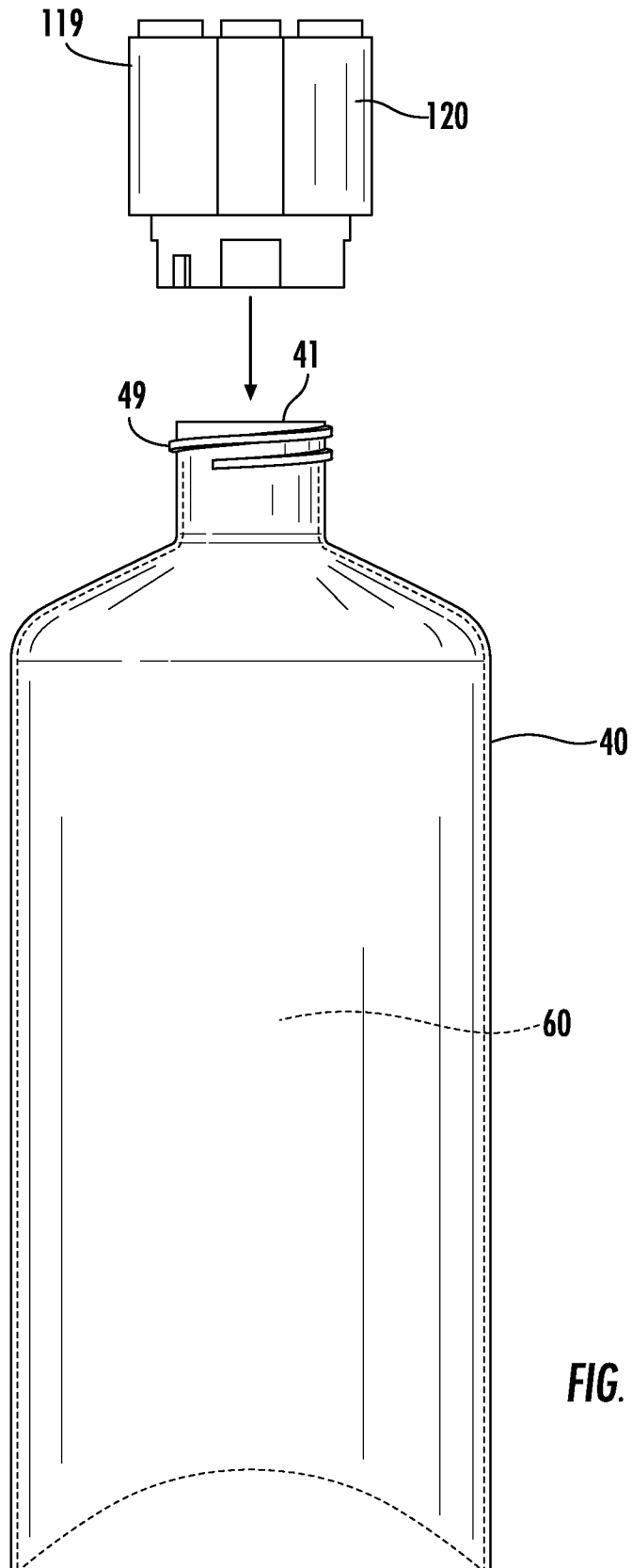


FIG. 21

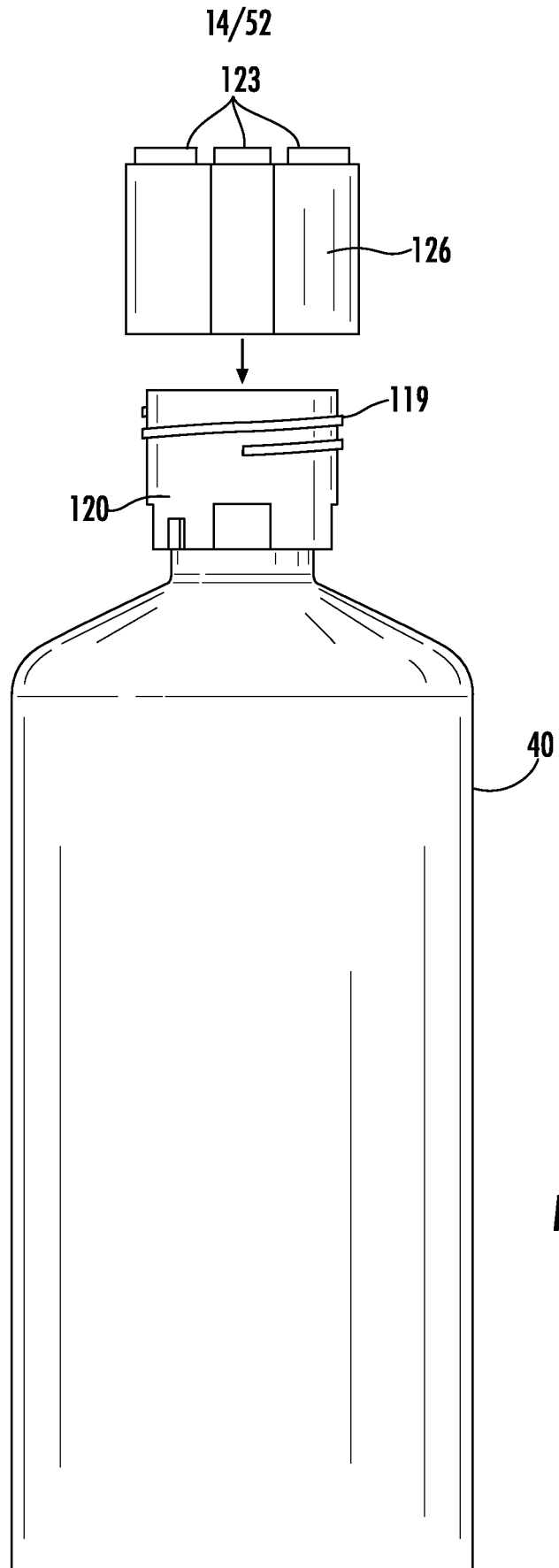


FIG. 22

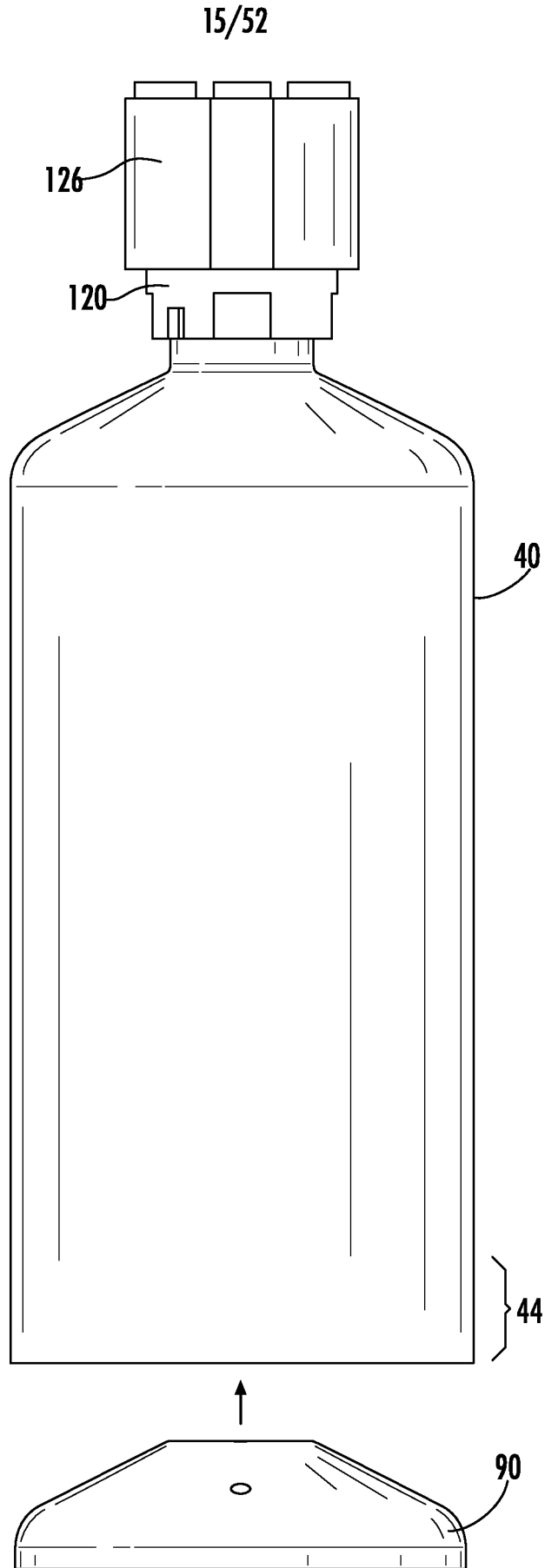


FIG. 23

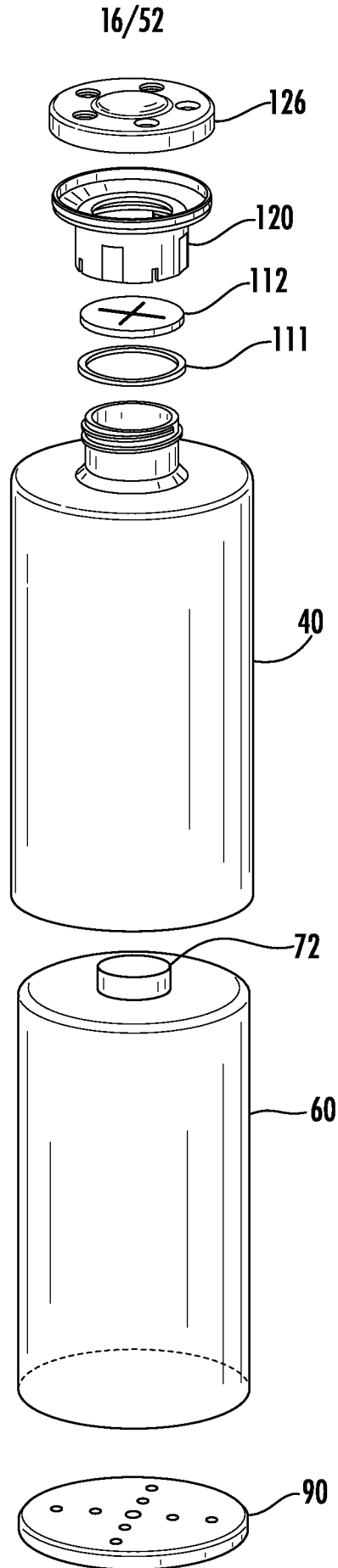


FIG. 24

17/52

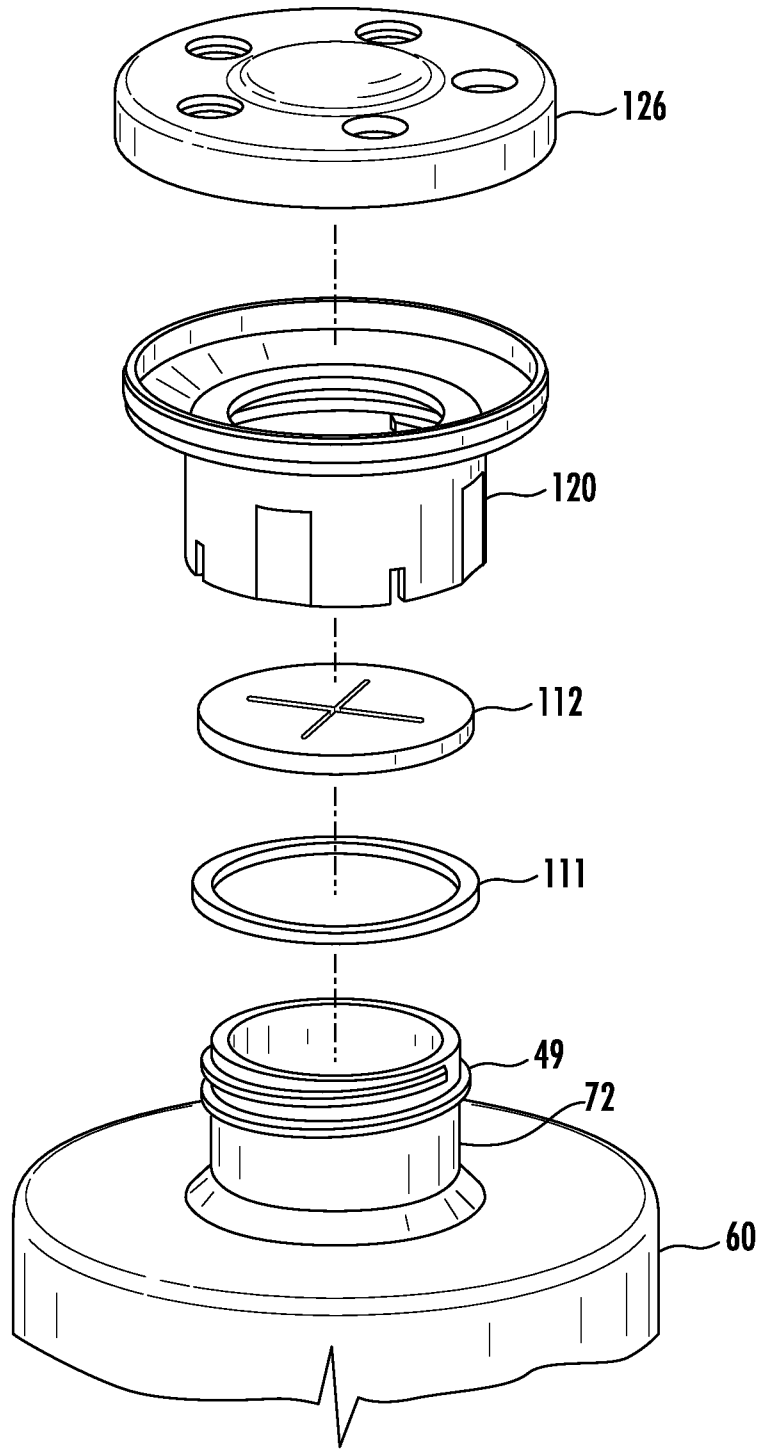


FIG. 25

18/52

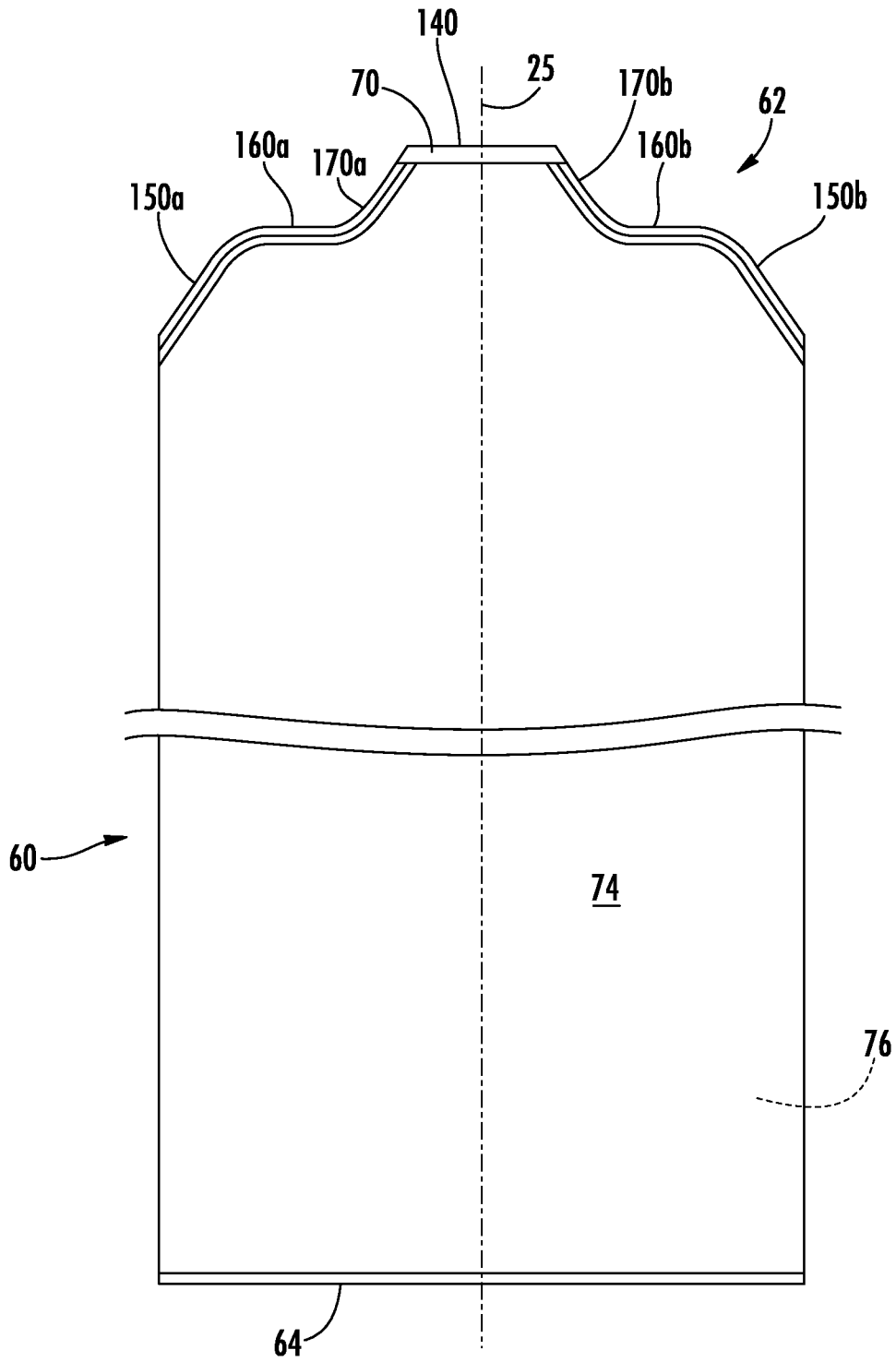


FIG. 26

19/52

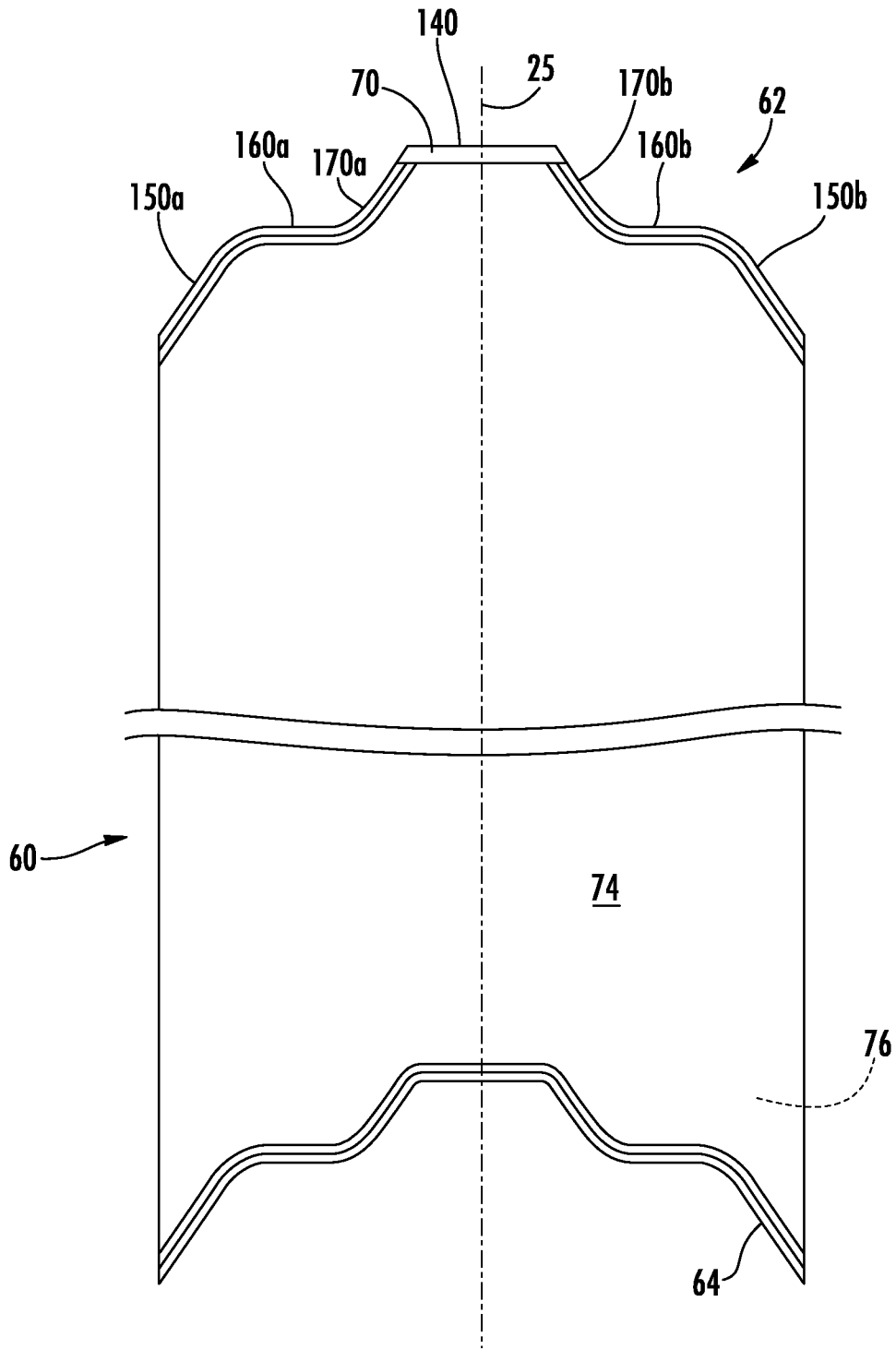


FIG. 27

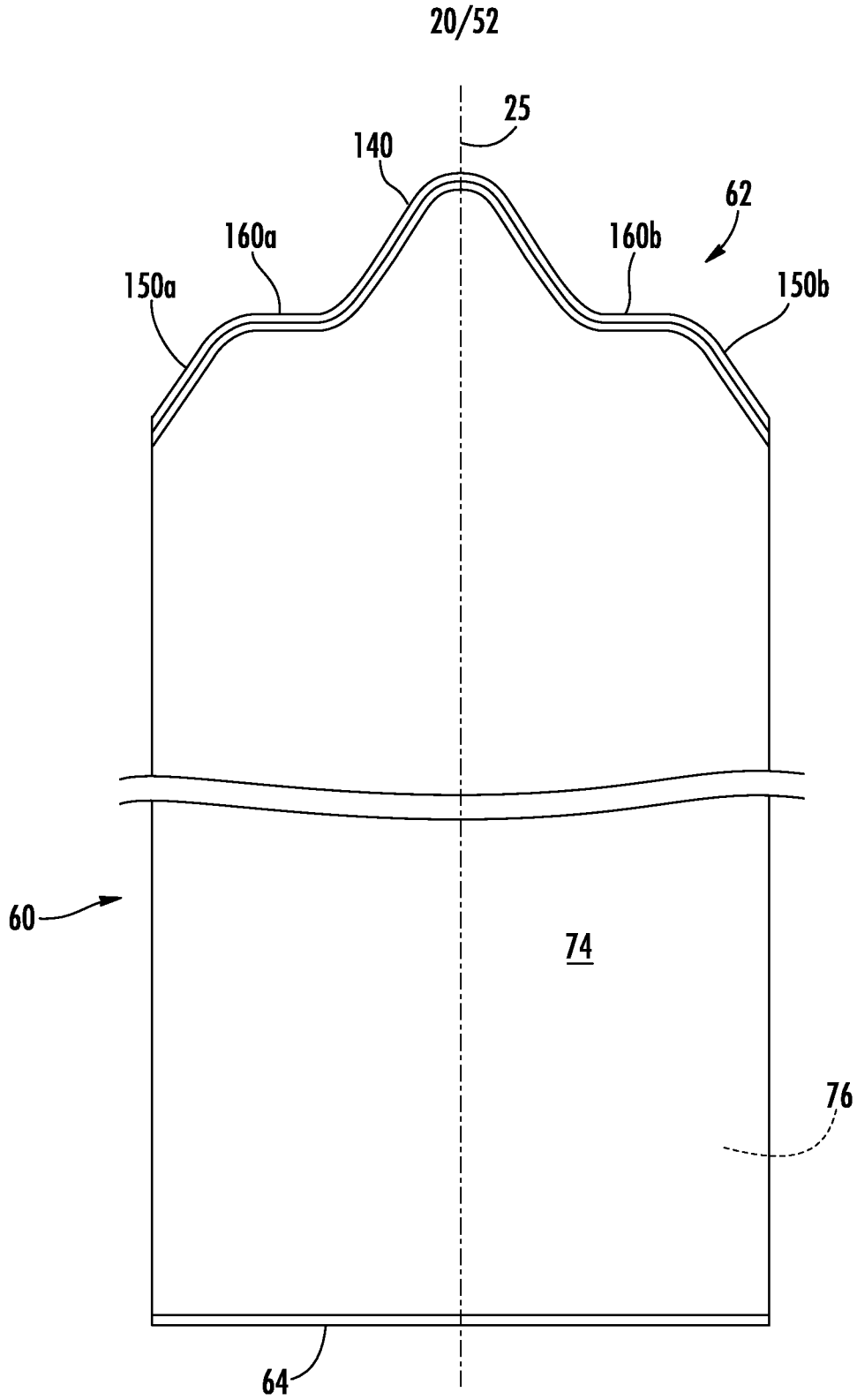


FIG. 28

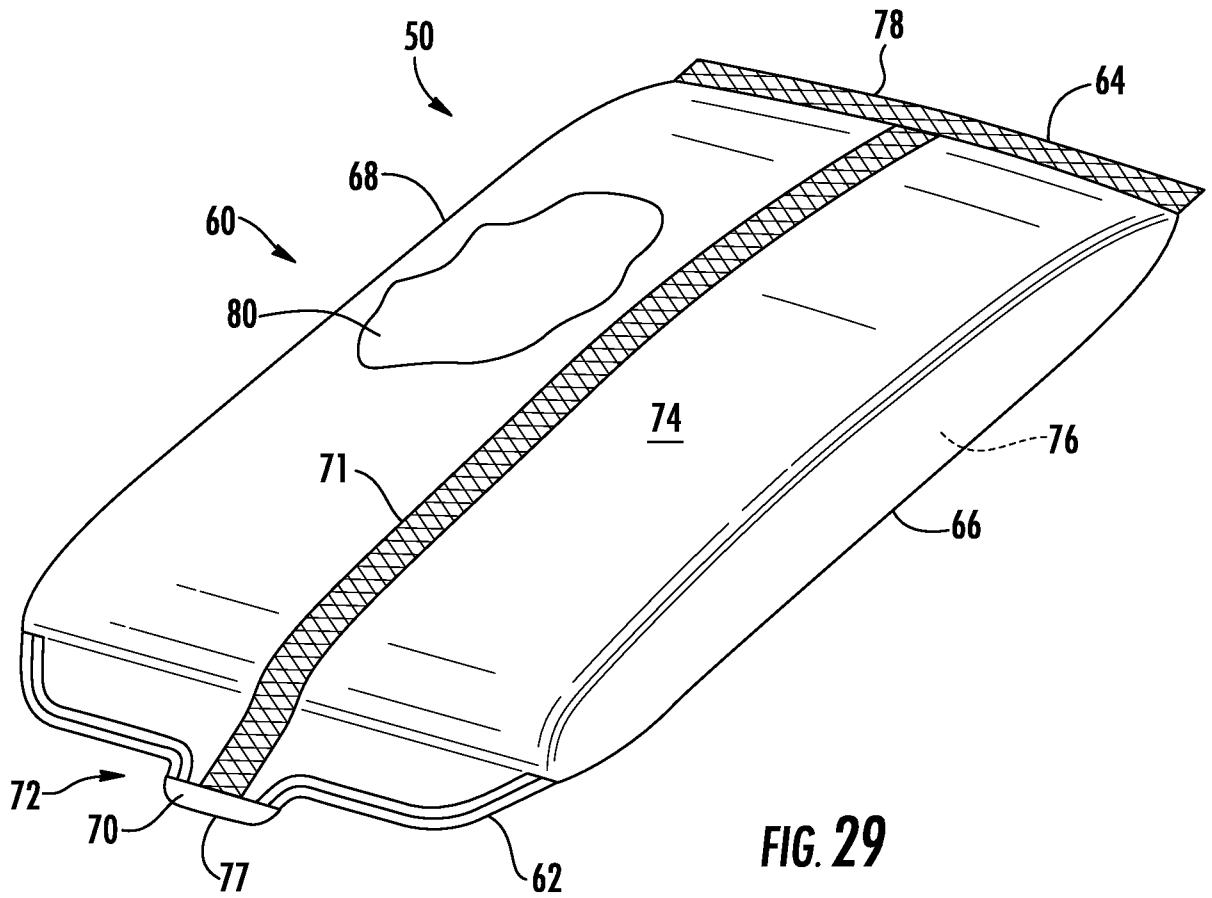


FIG. 29

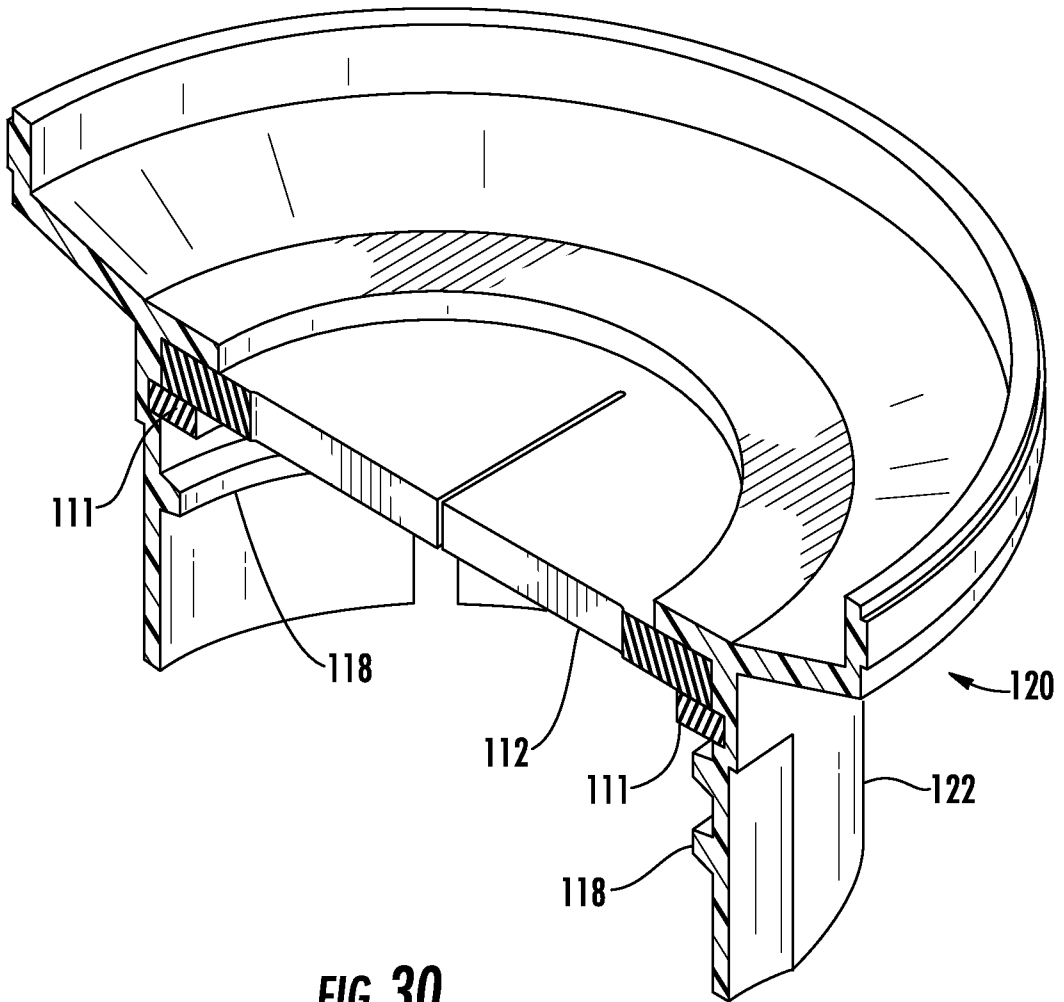


FIG. 30

23/52

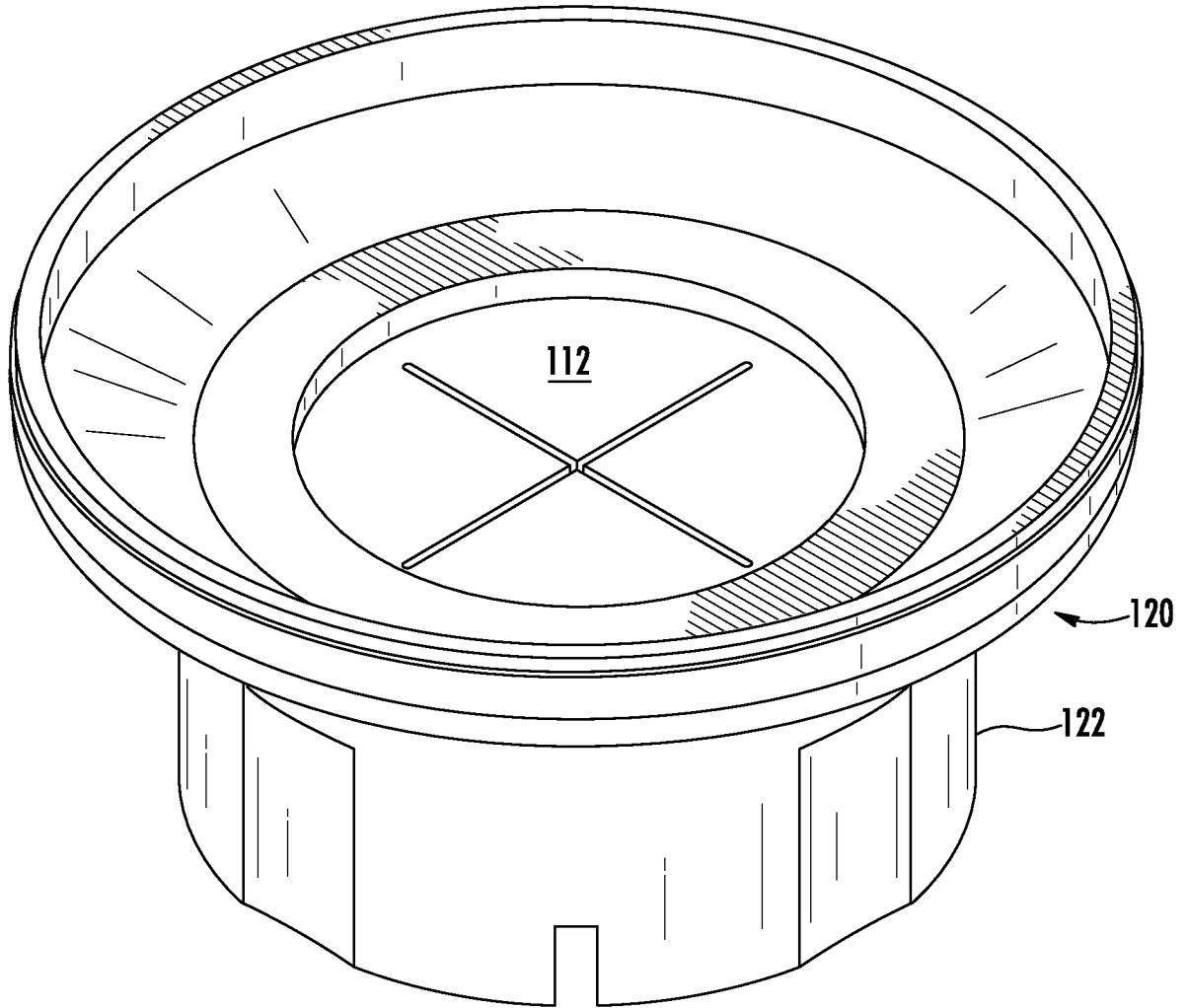


FIG. 31

24/52

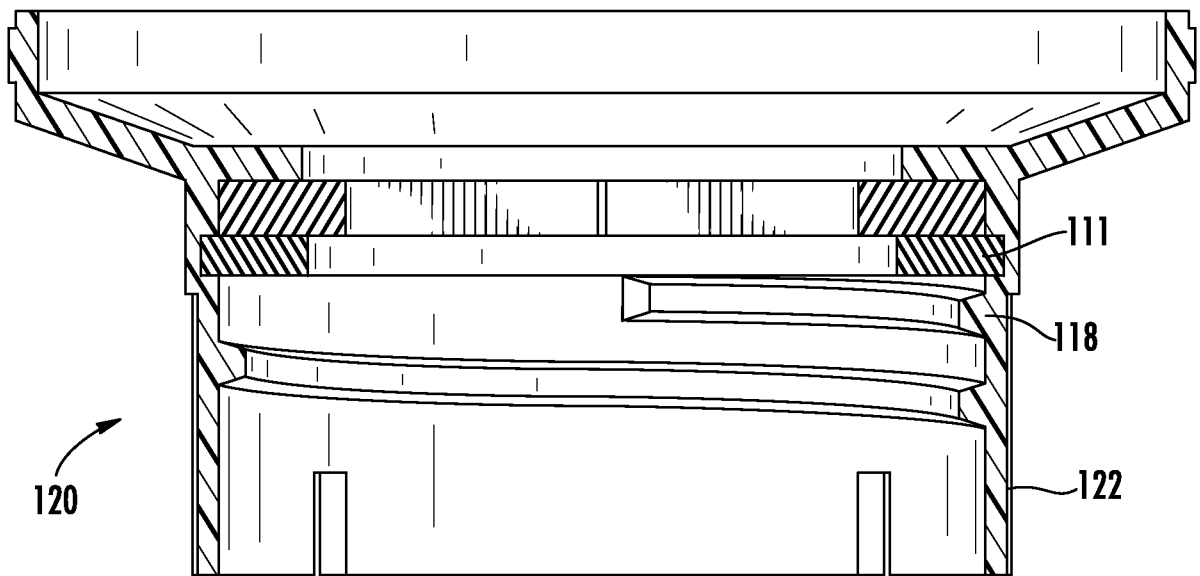
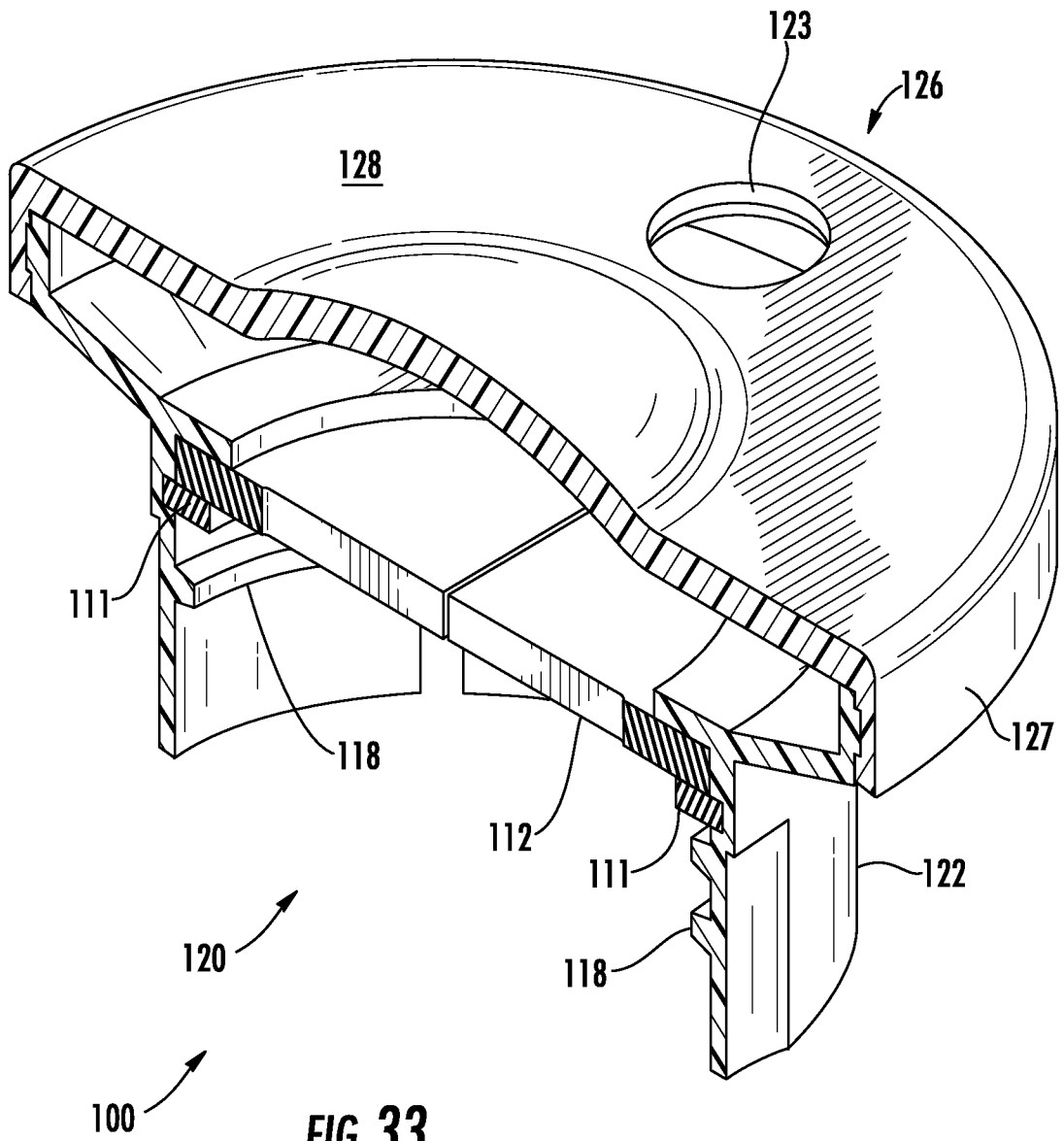


FIG. 32



26/52

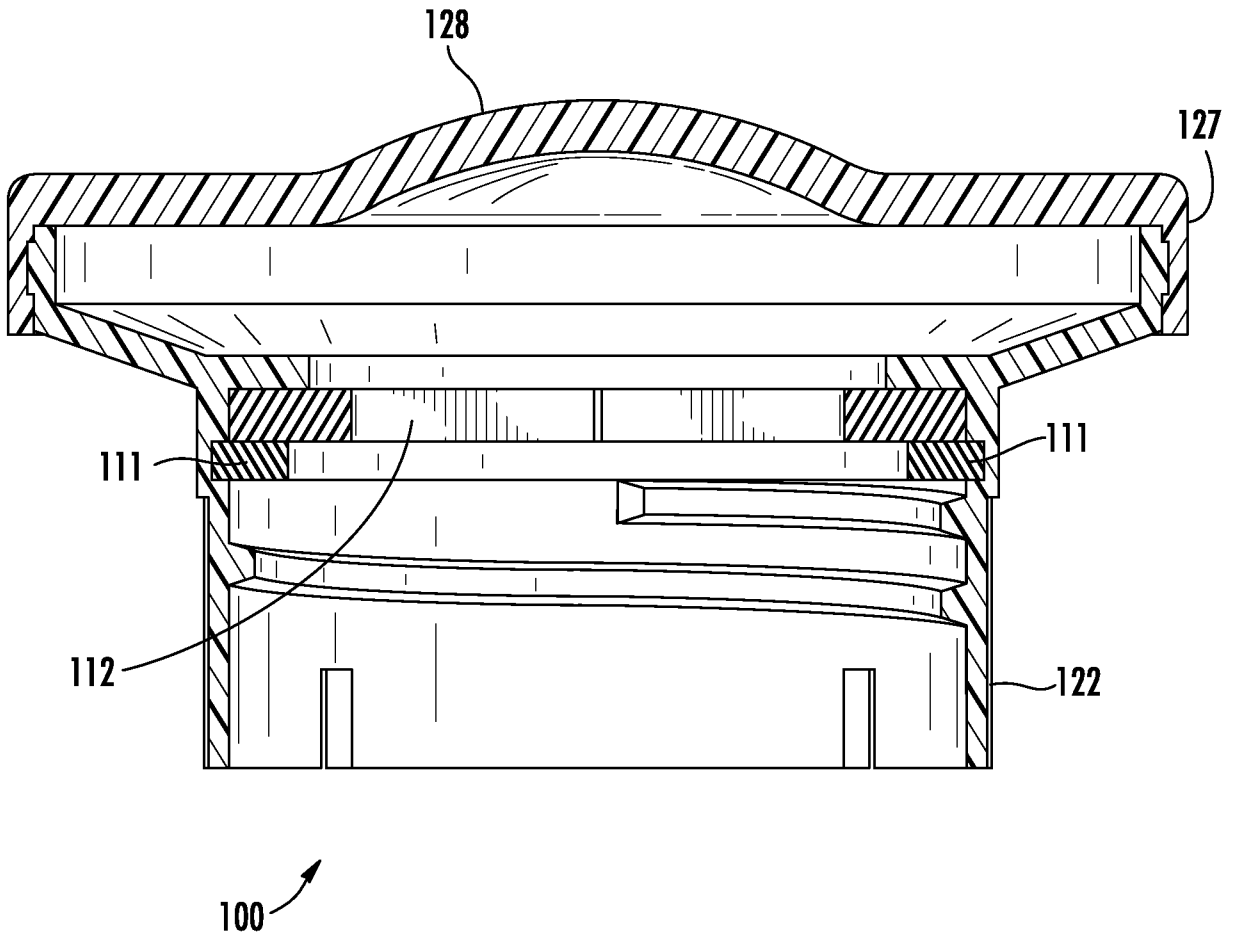


FIG. 34

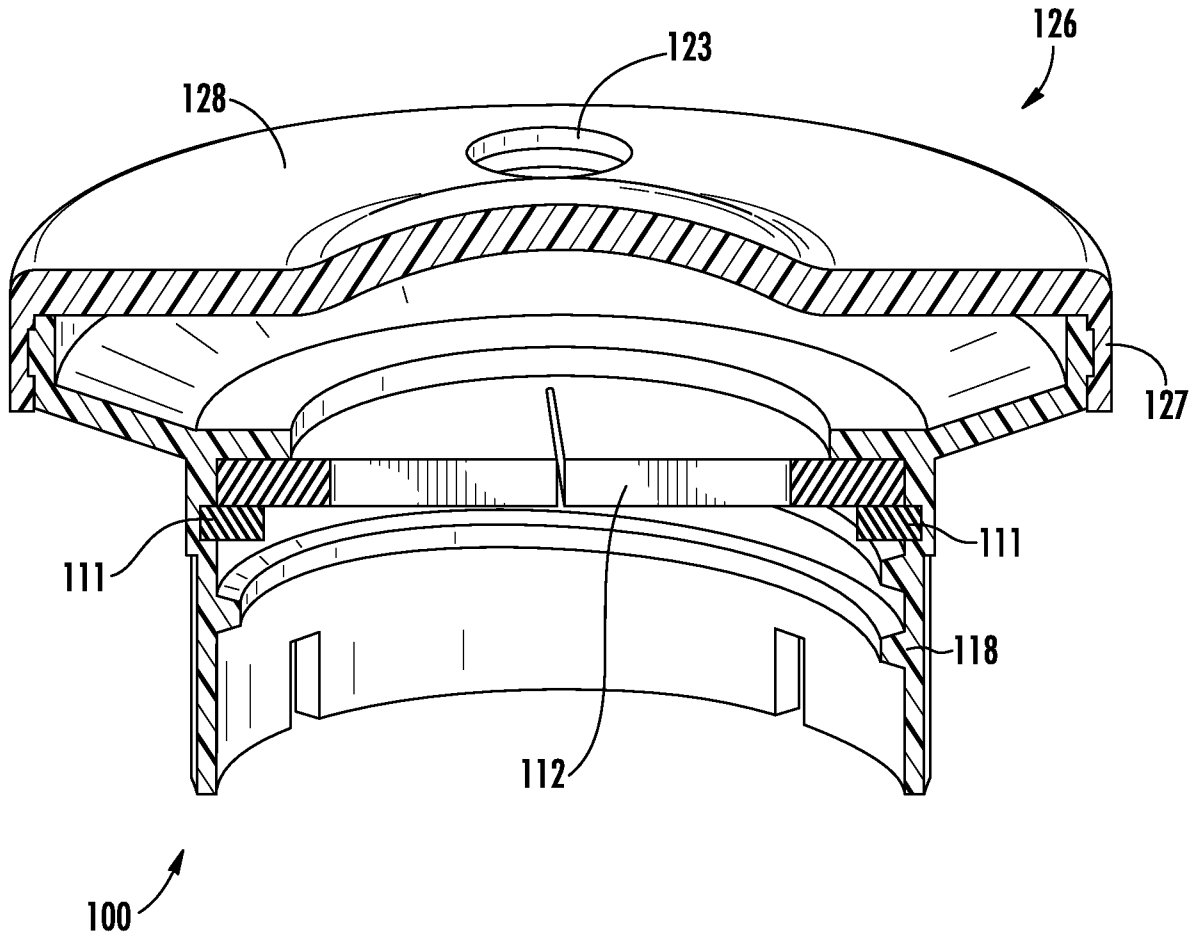


FIG. 35

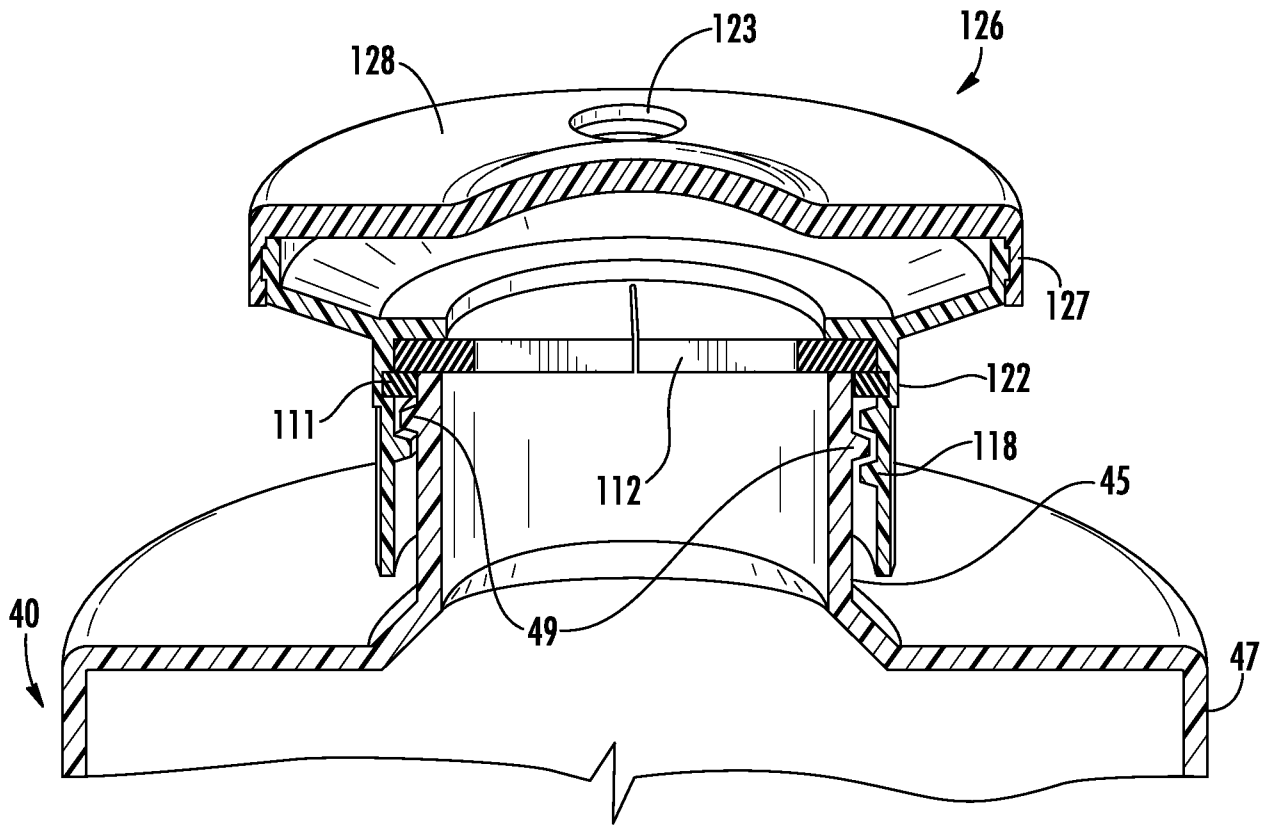


FIG. 36

29/52

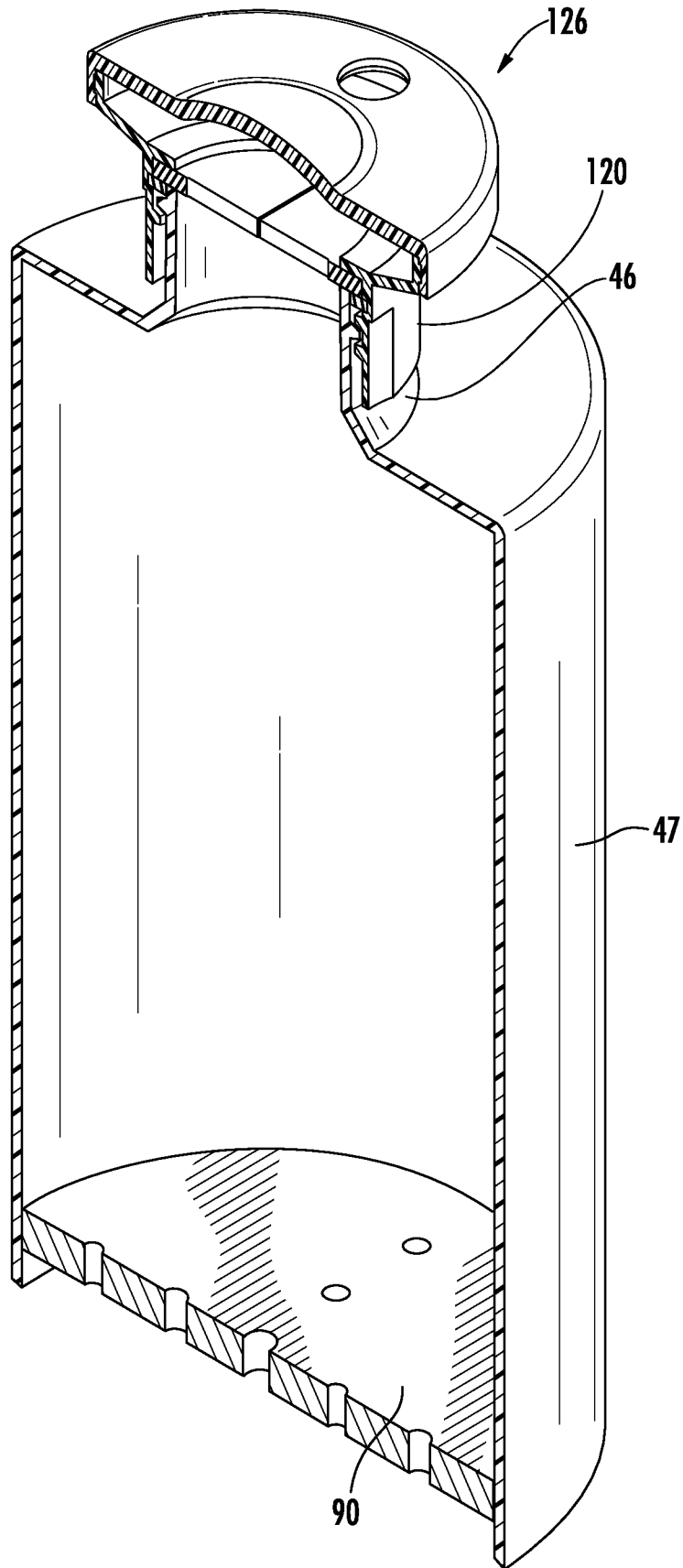


FIG. 37

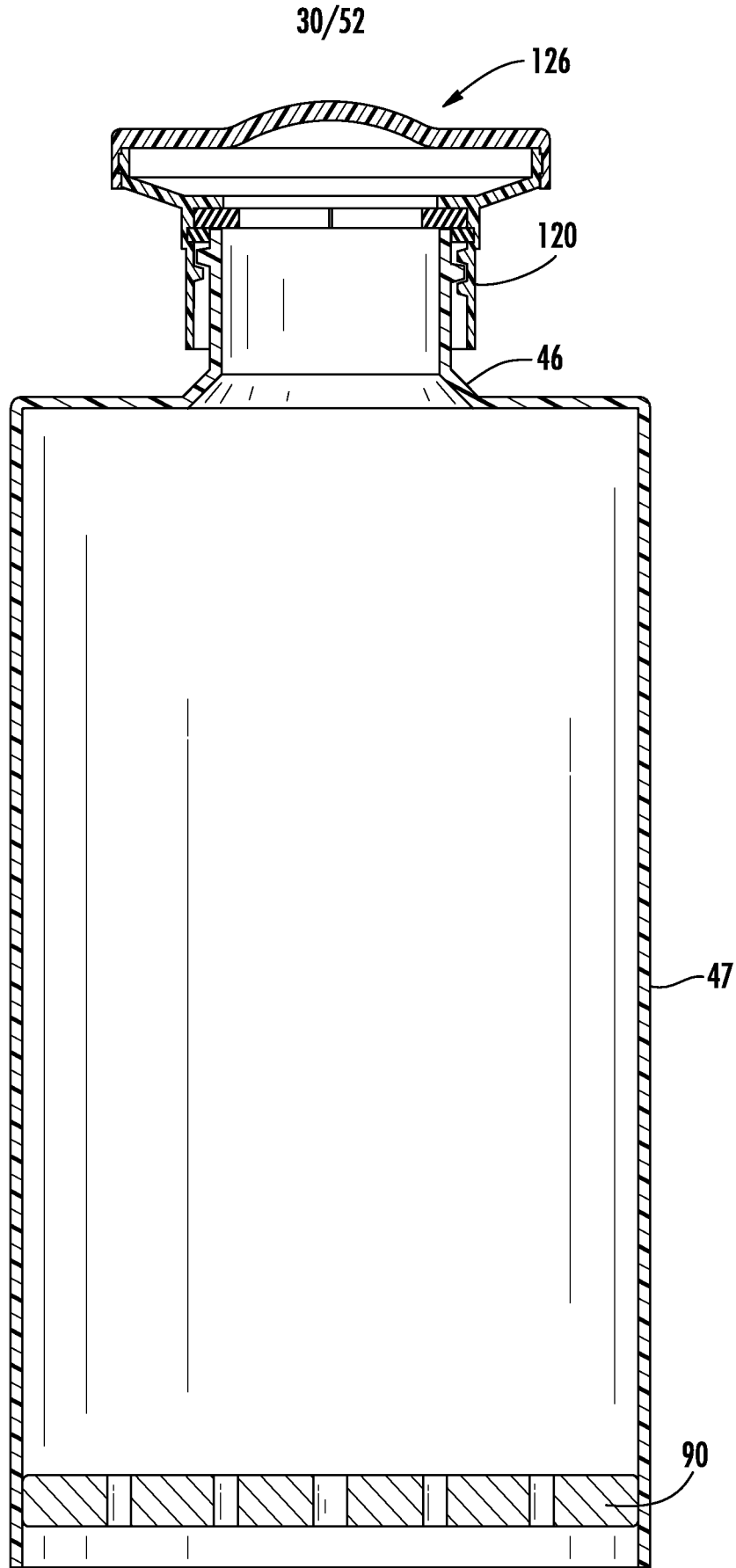


FIG. 38

31/52

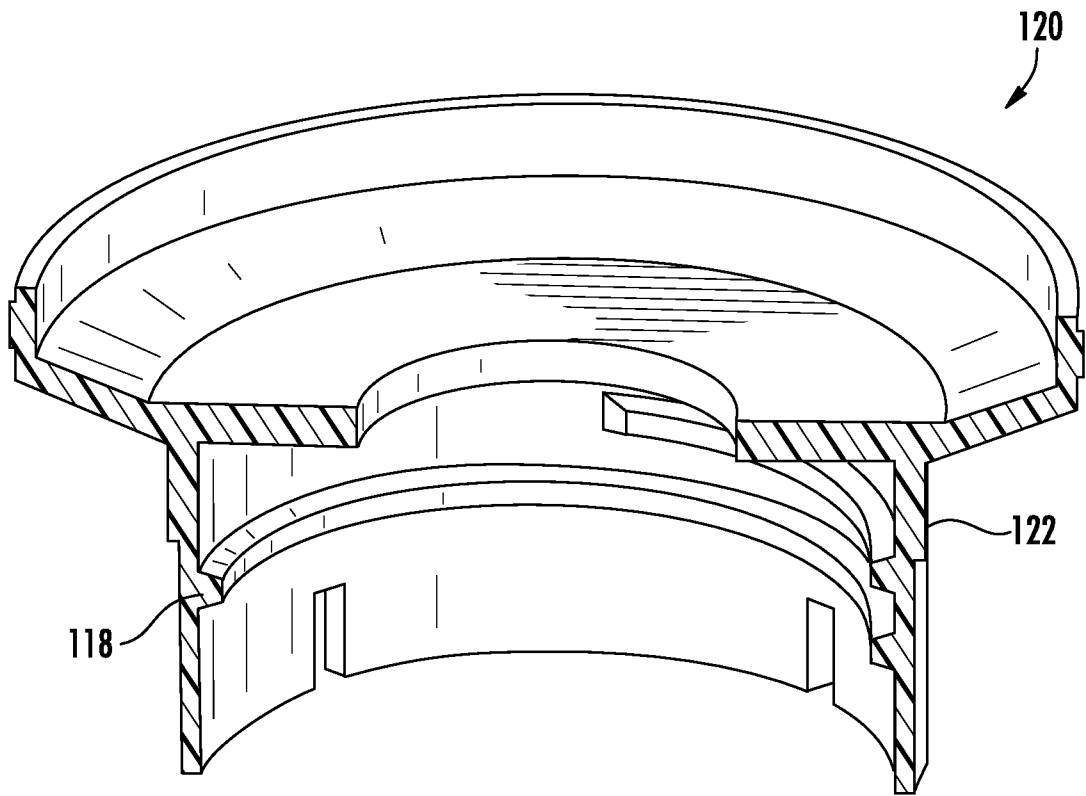


FIG. 39

32/52

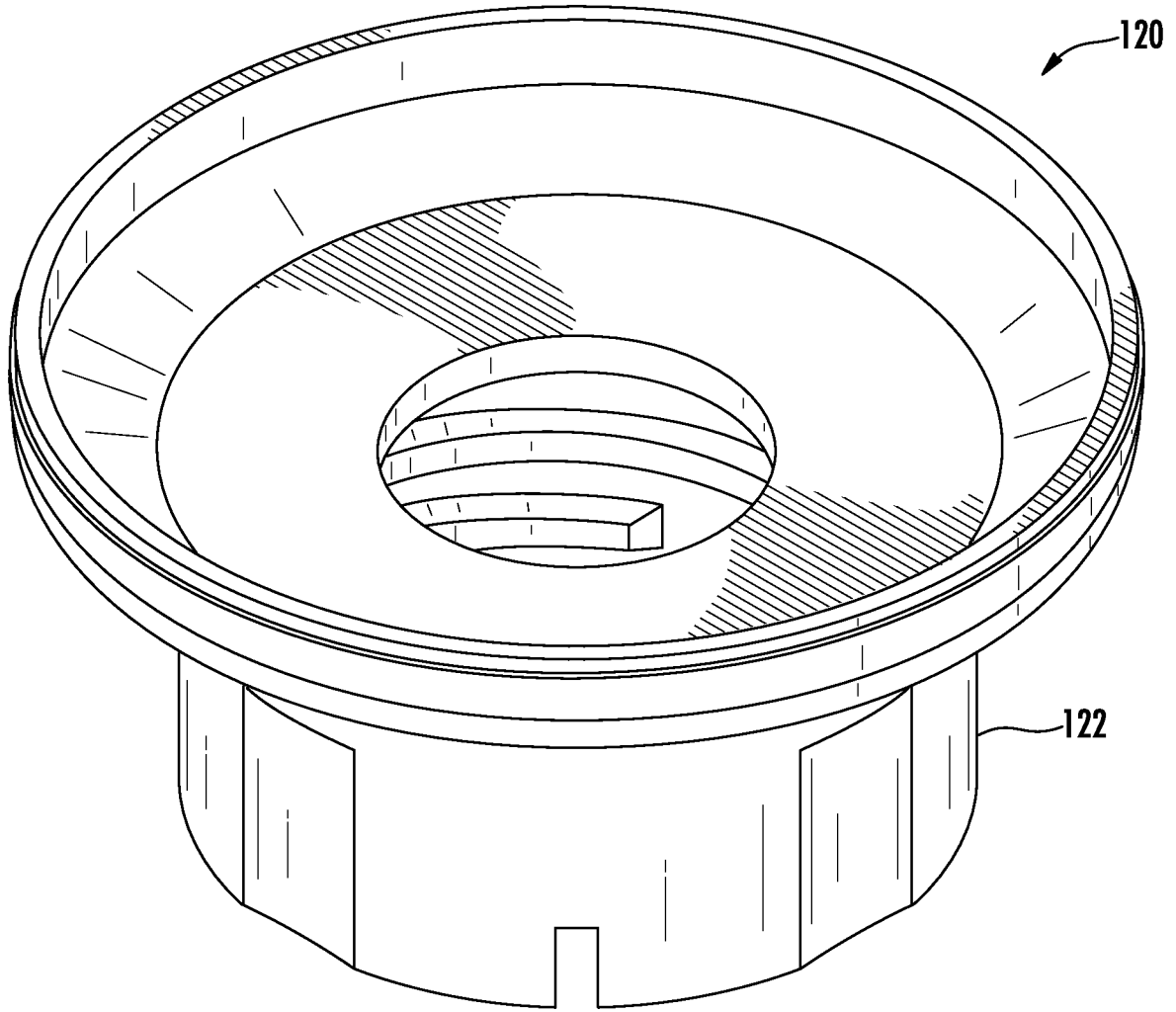


FIG. 40

33/52

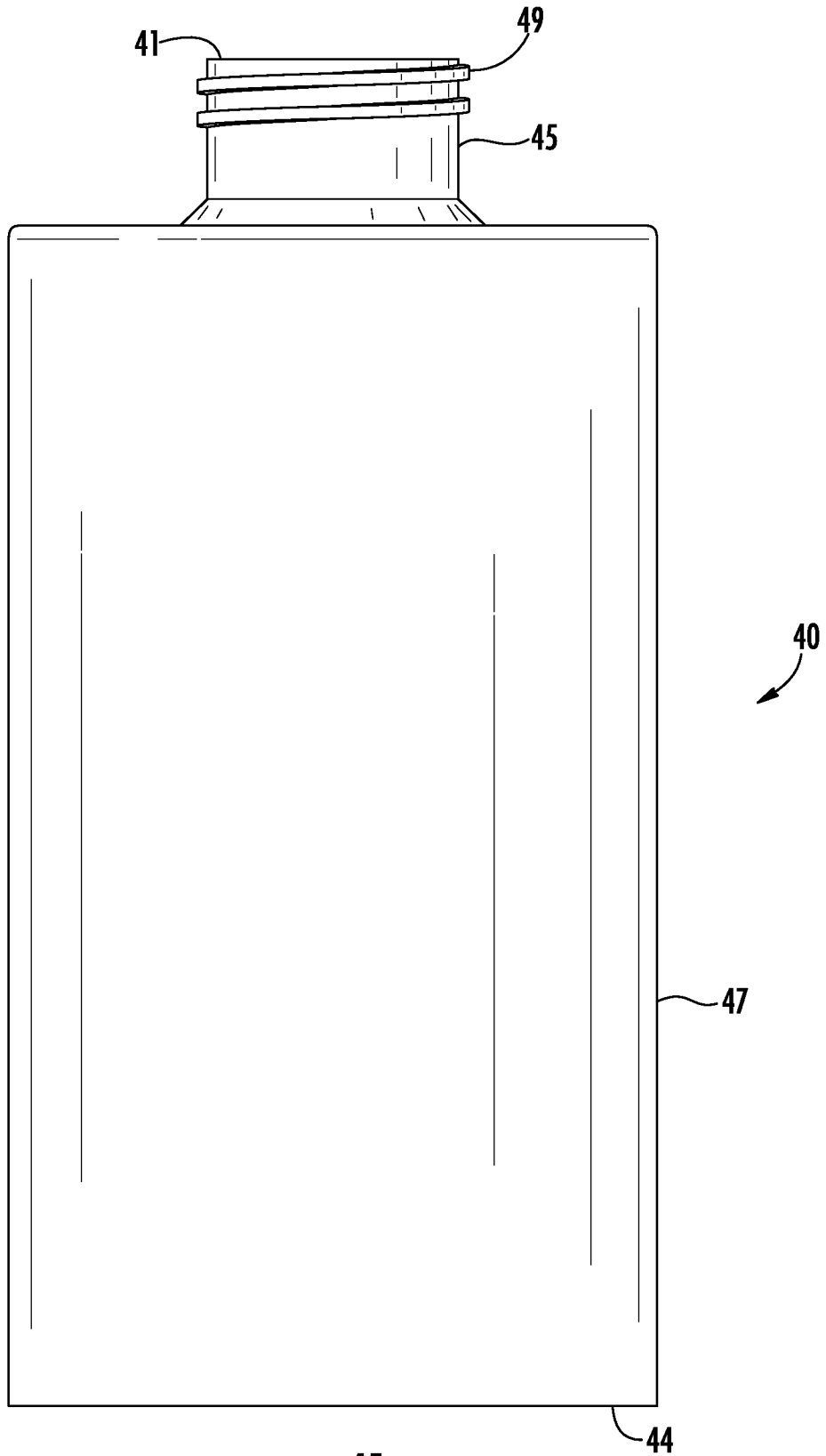


FIG. 41

34/52

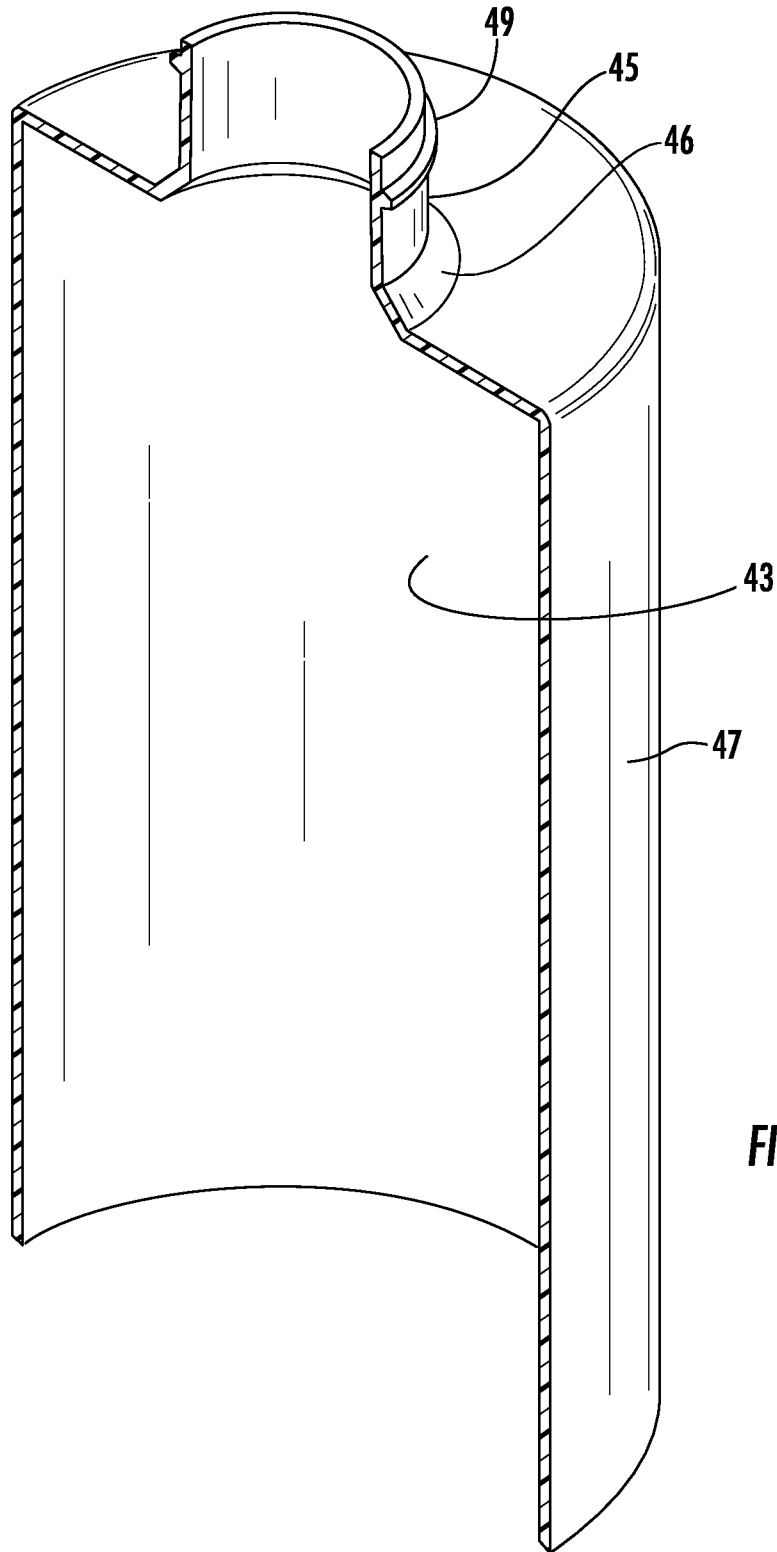


FIG. 42

35/52

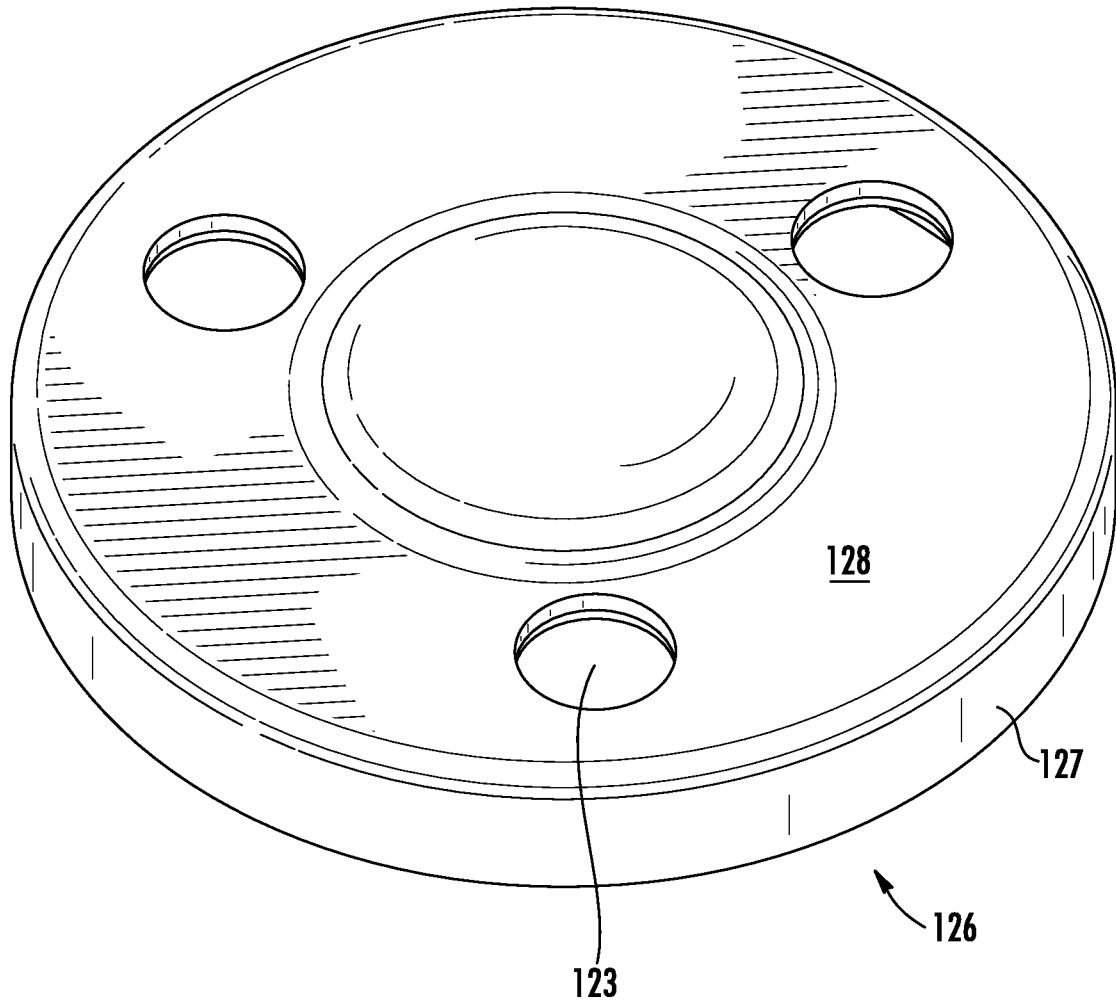


FIG. 43

36/52

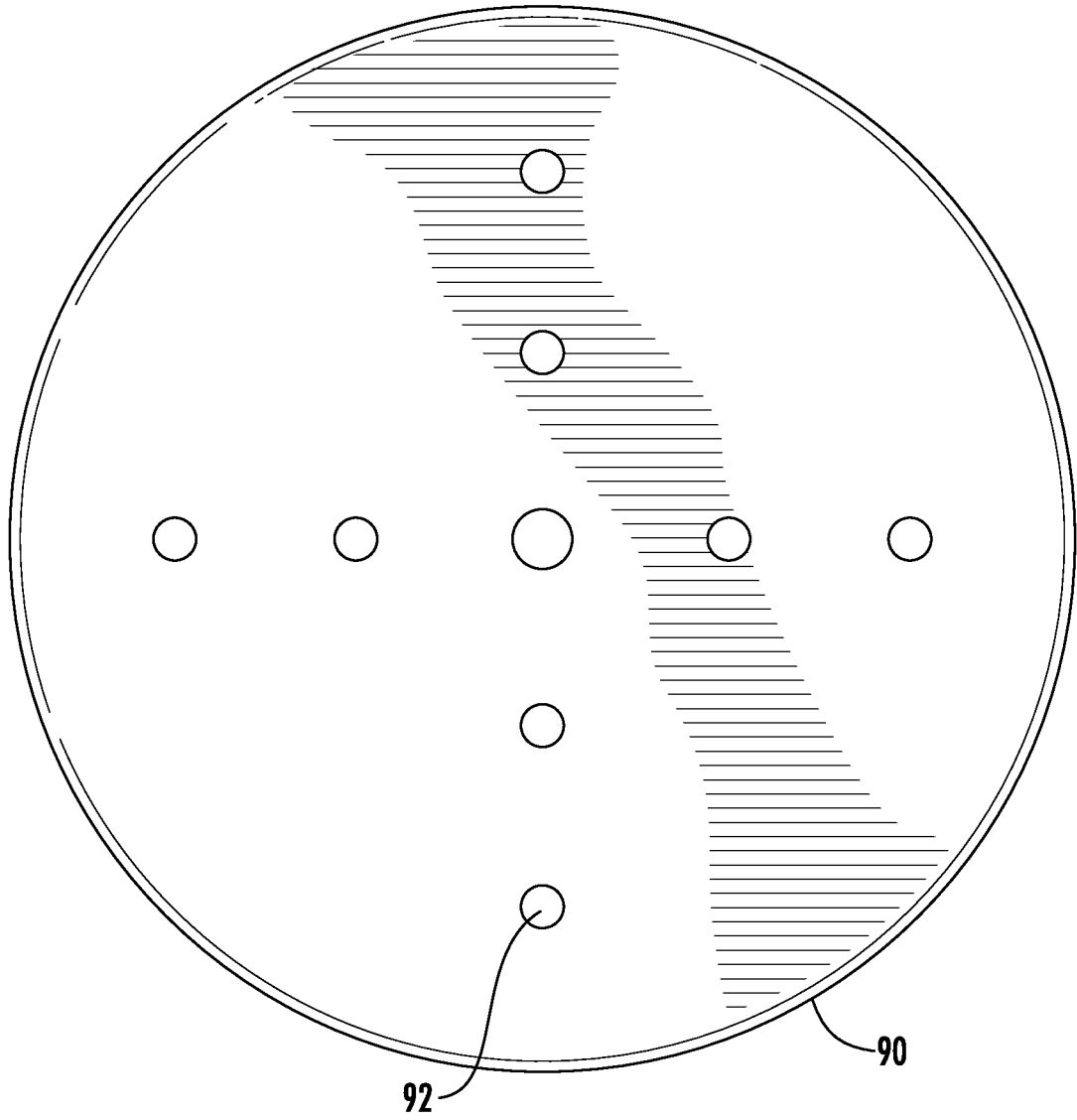


FIG. 44

37/52

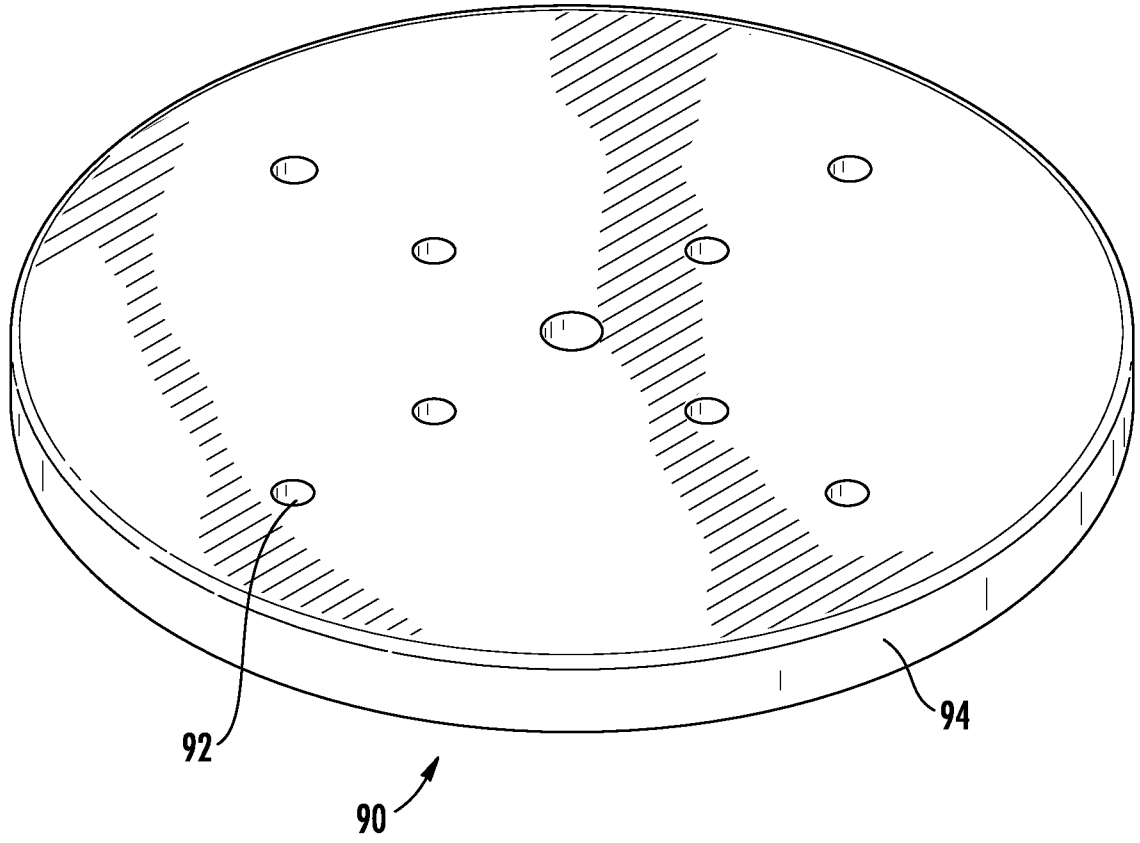


FIG. 45

38/52

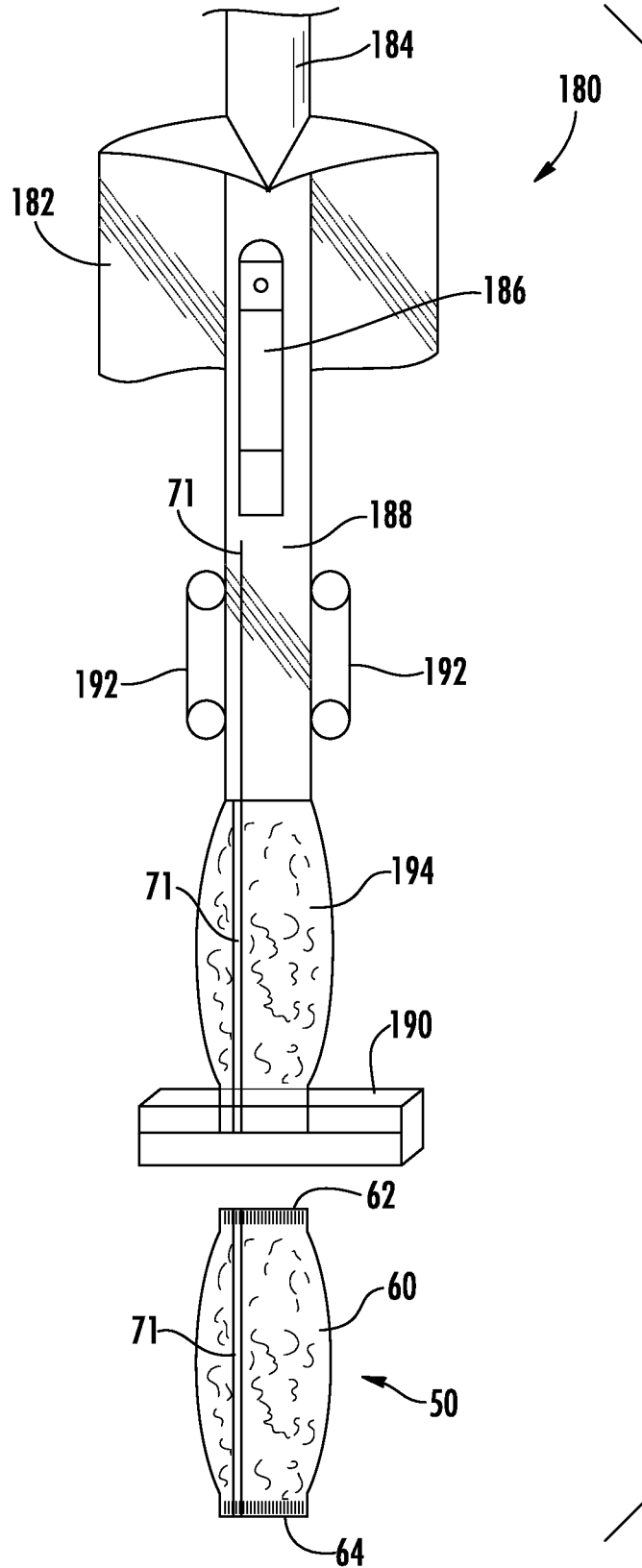


FIG. 46
(PRIOR ART)

39/52

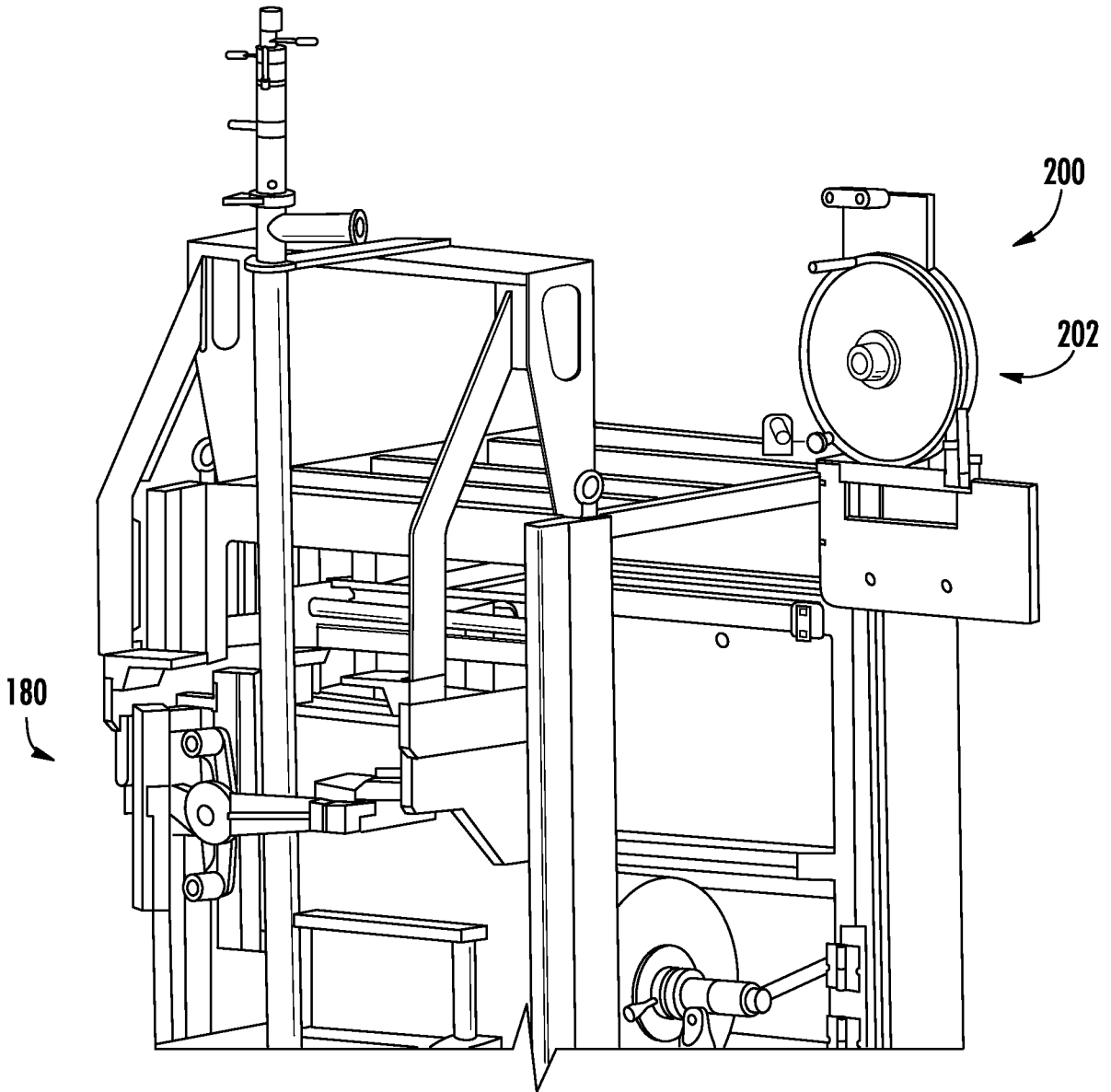


FIG. 47

40/52

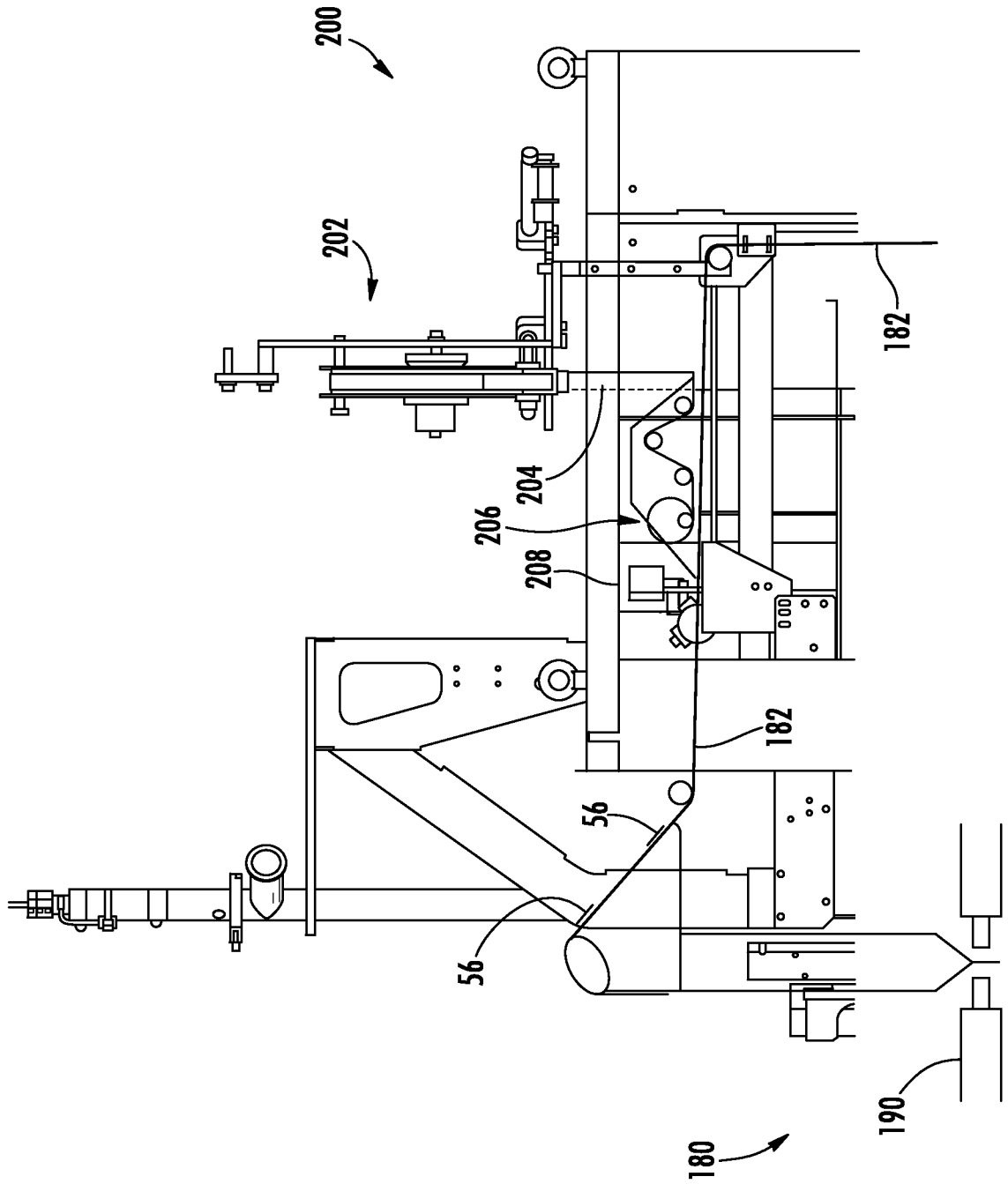


FIG. 48

41/52

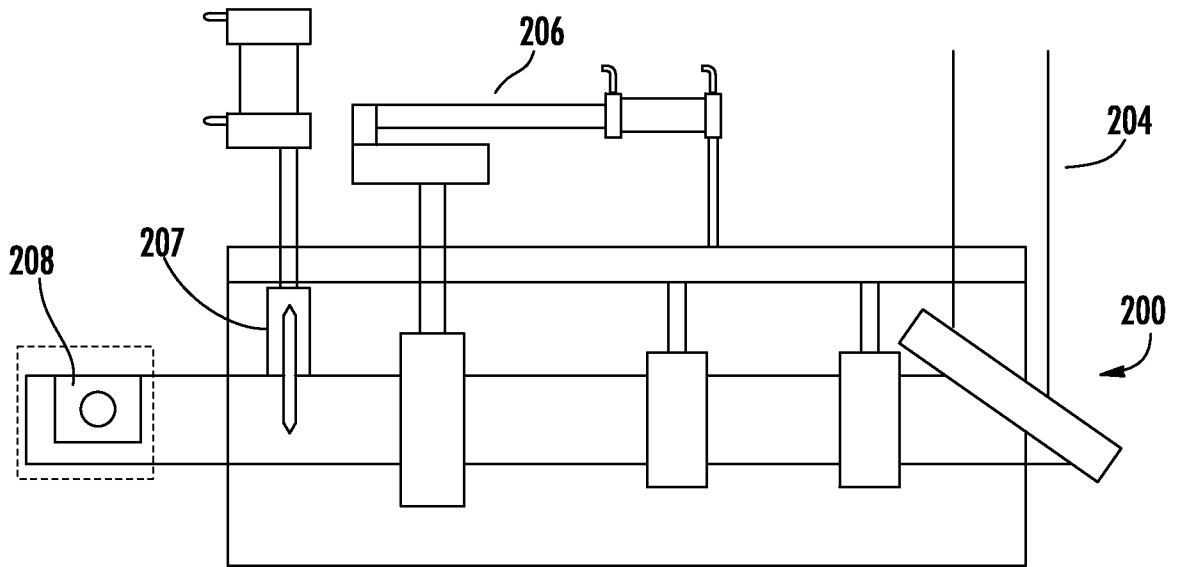


FIG. 49

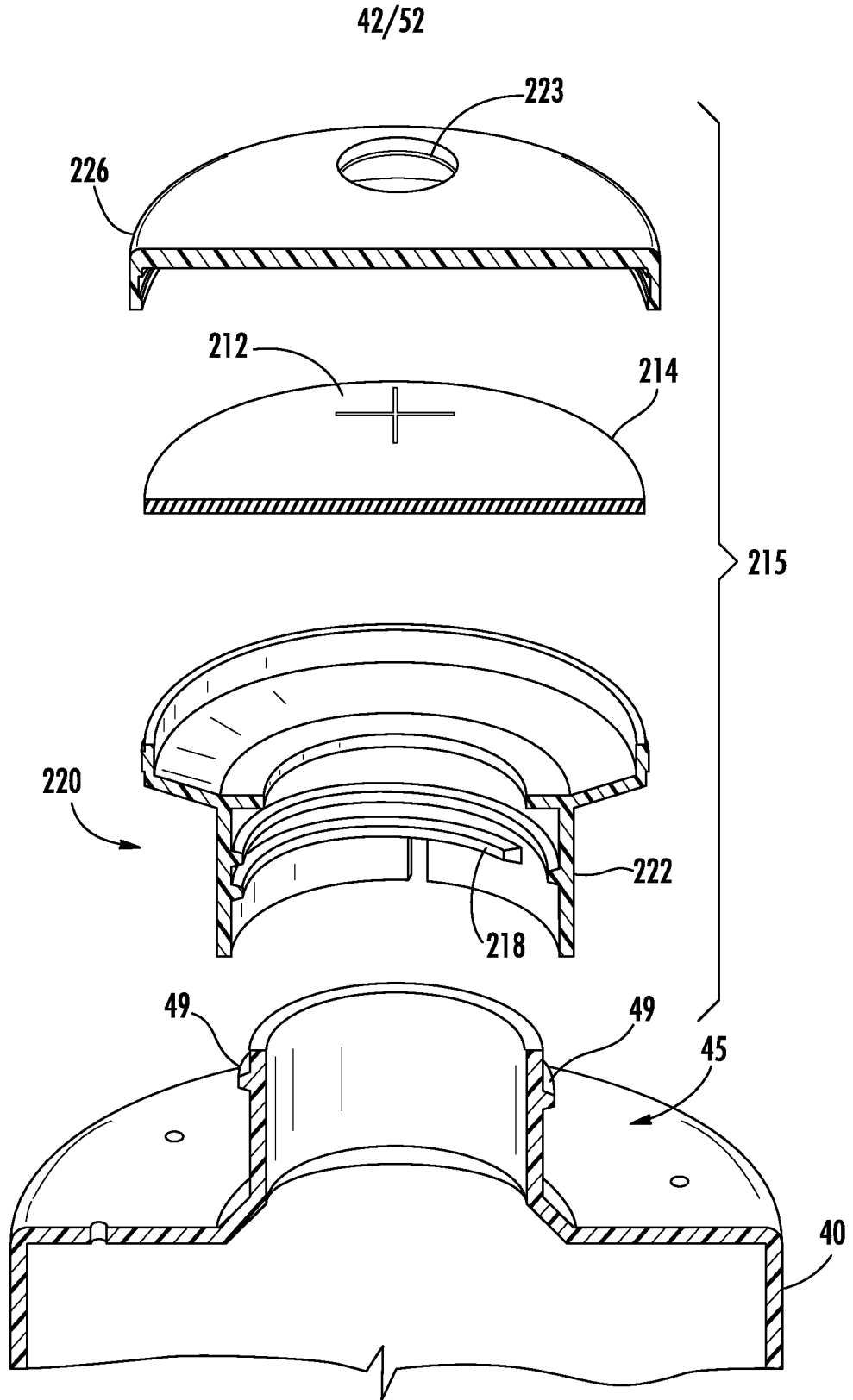


FIG. 50

43/52

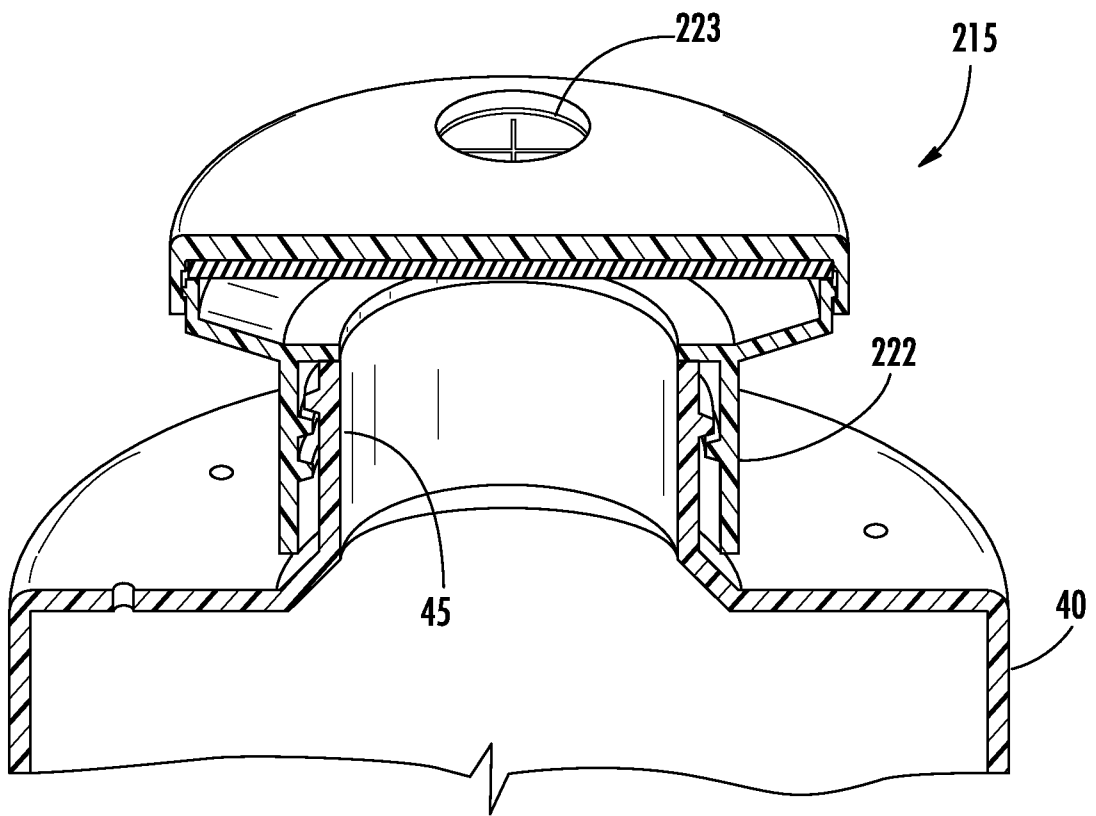


FIG. 51

44/52

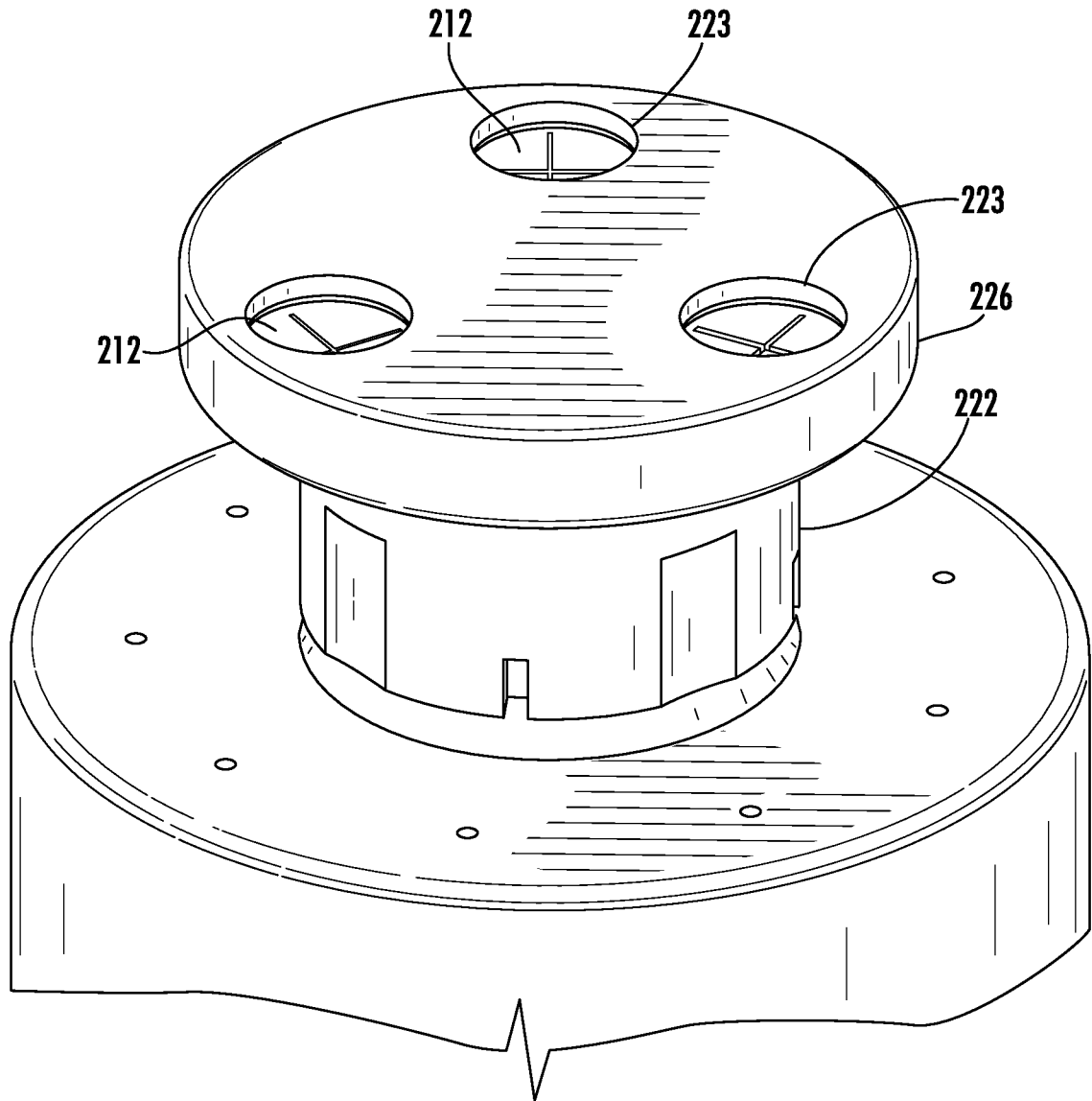


FIG. 52

45/52

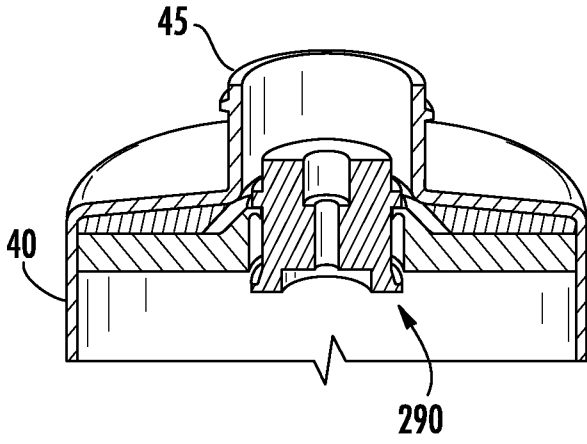


FIG. 53A

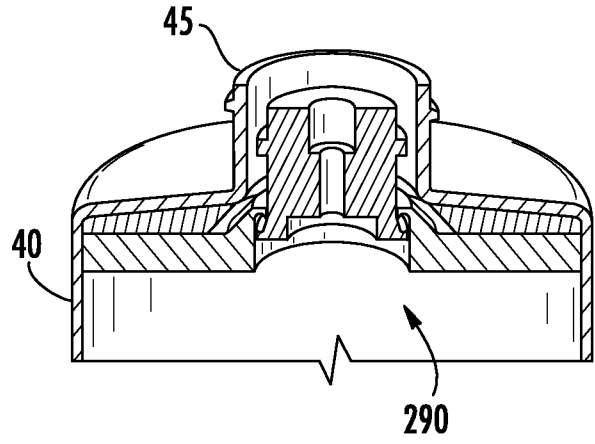


FIG. 53B

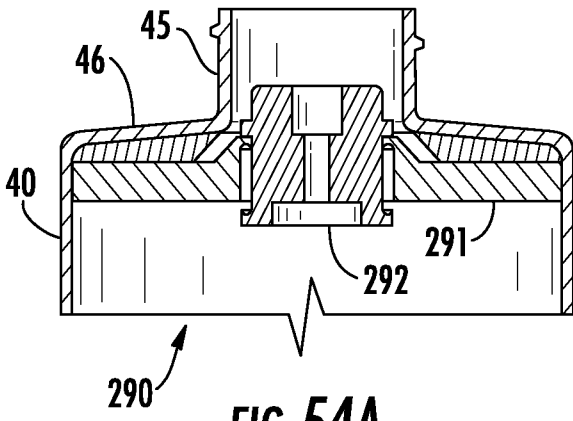


FIG. 54A

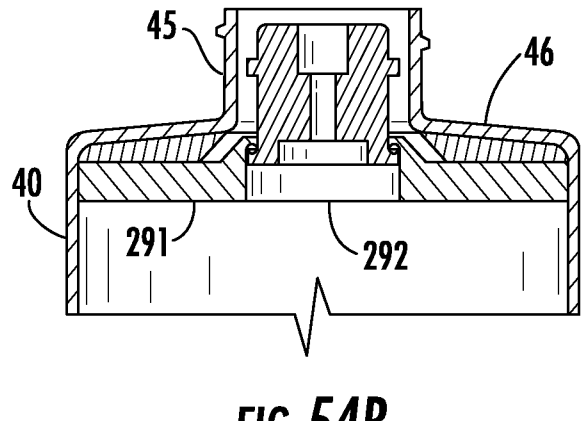


FIG. 54B

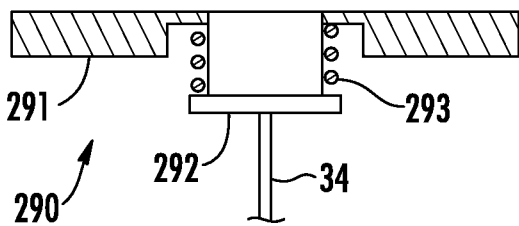


FIG. 55A

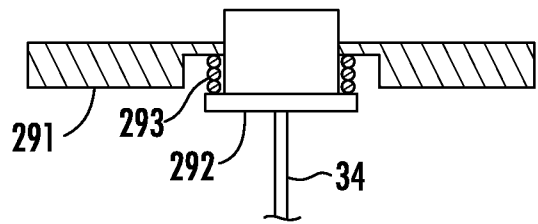


FIG. 55B

46/52

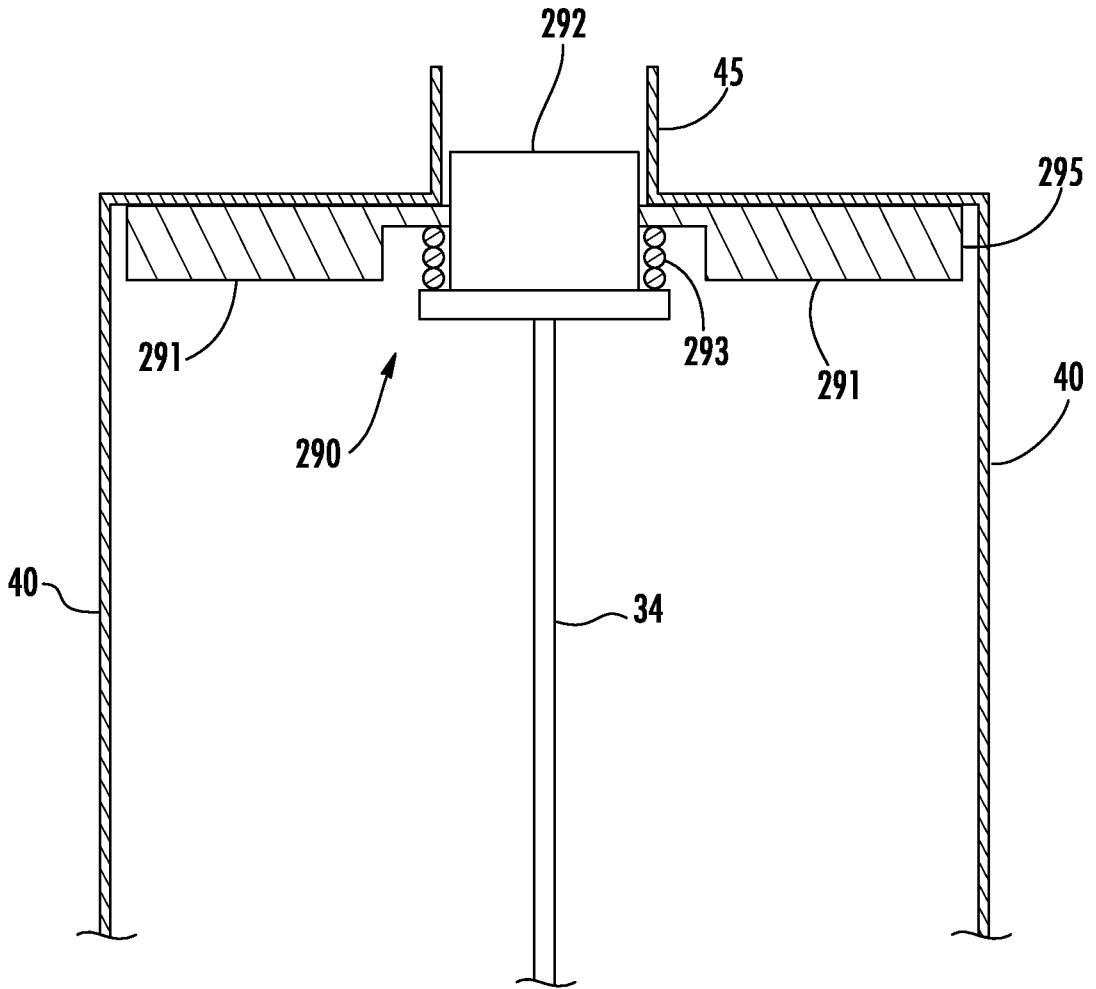


FIG. 56

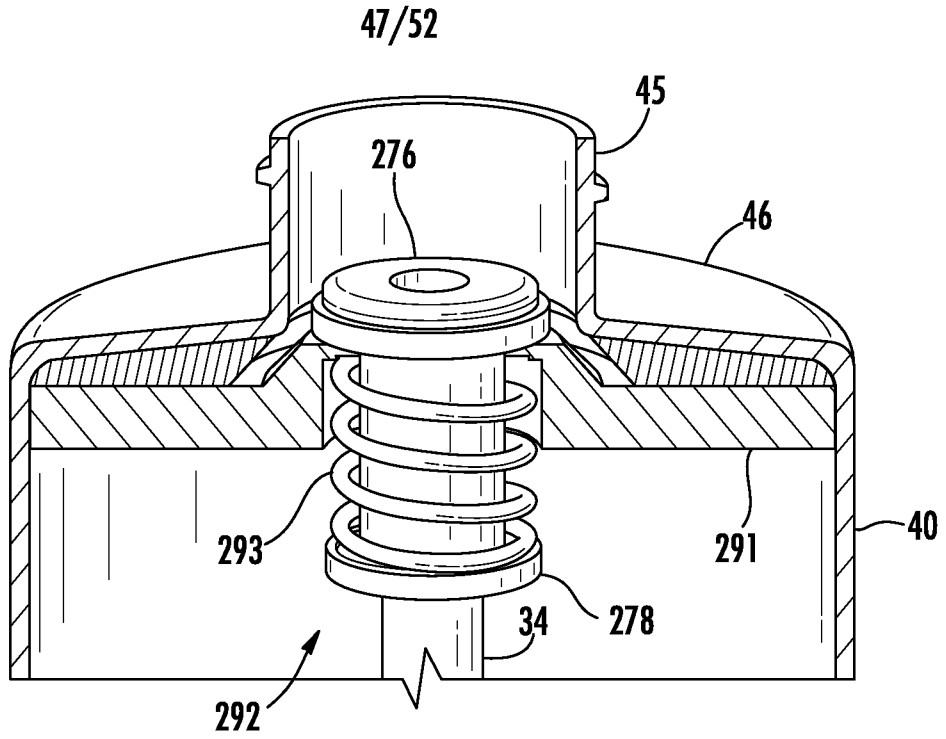


FIG. 57

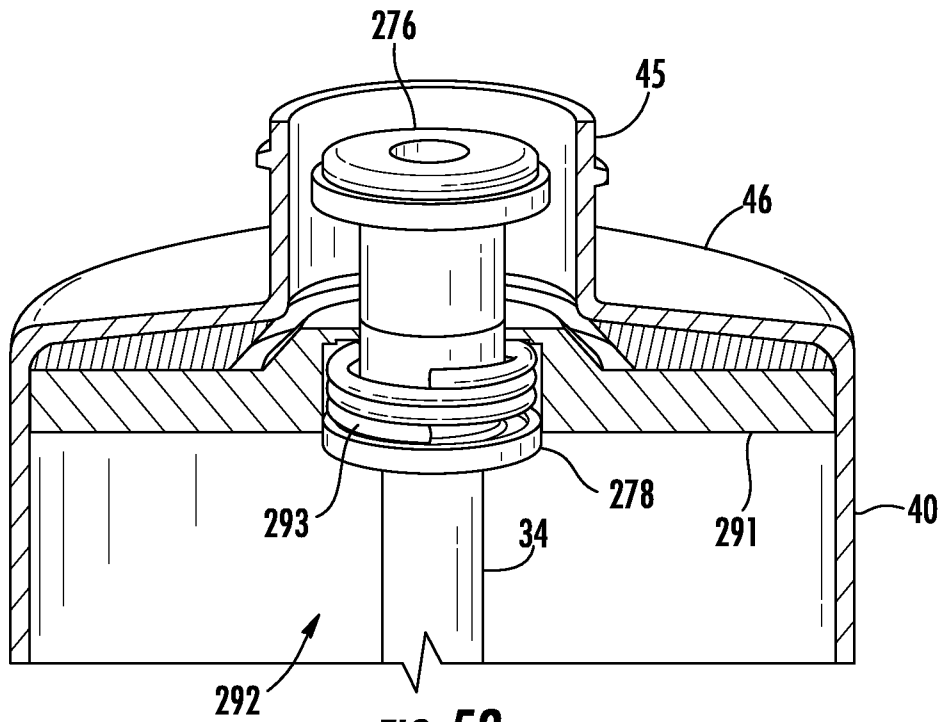


FIG. 58

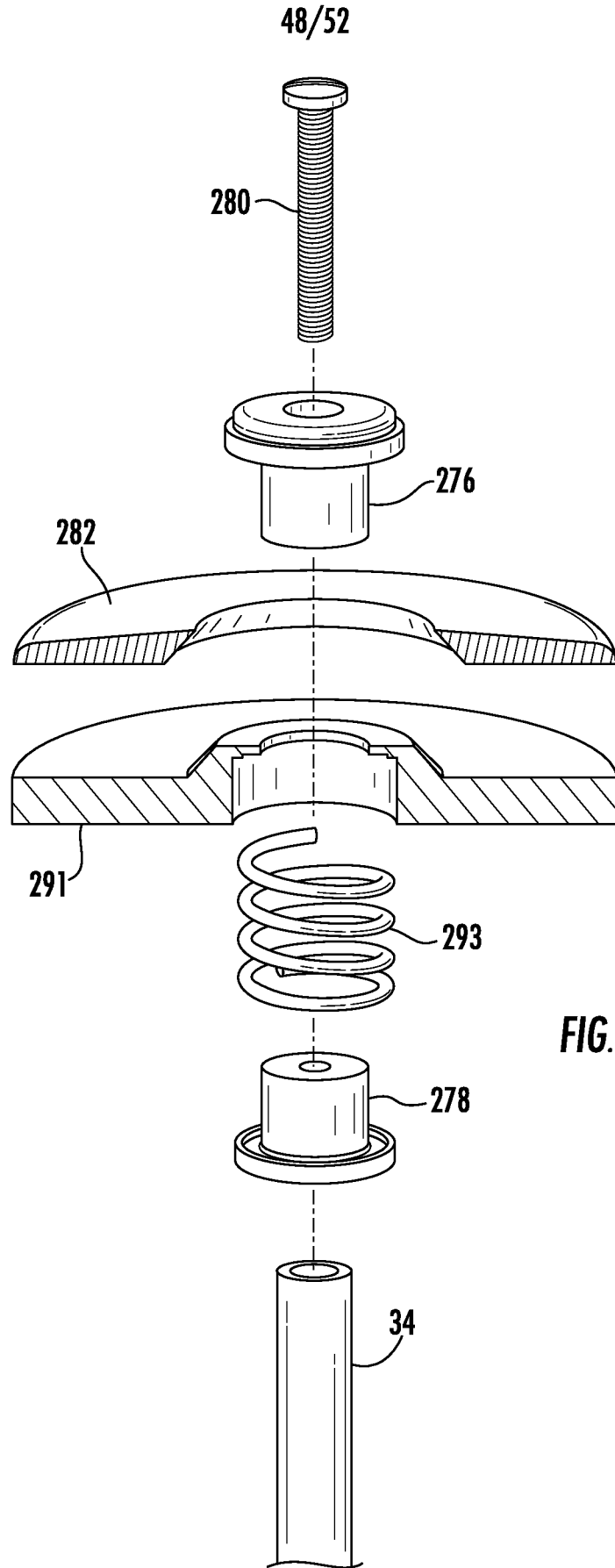


FIG. 59

49/52

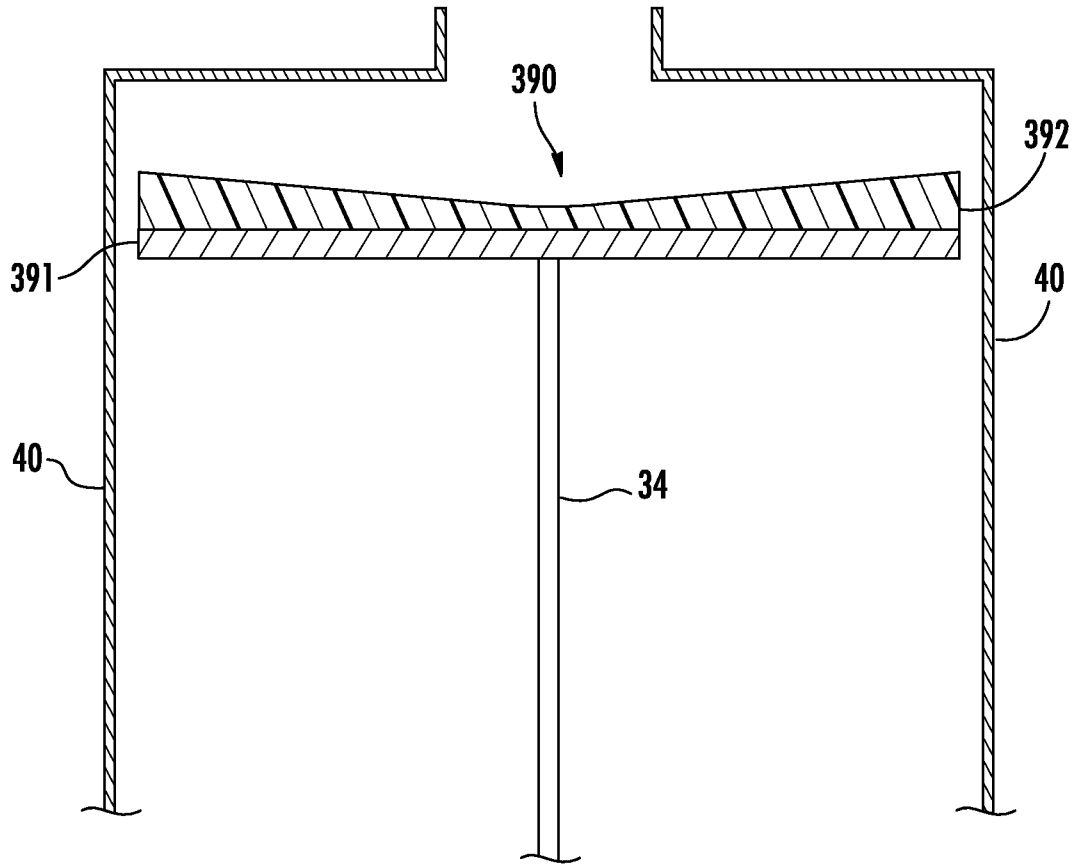


FIG. 60

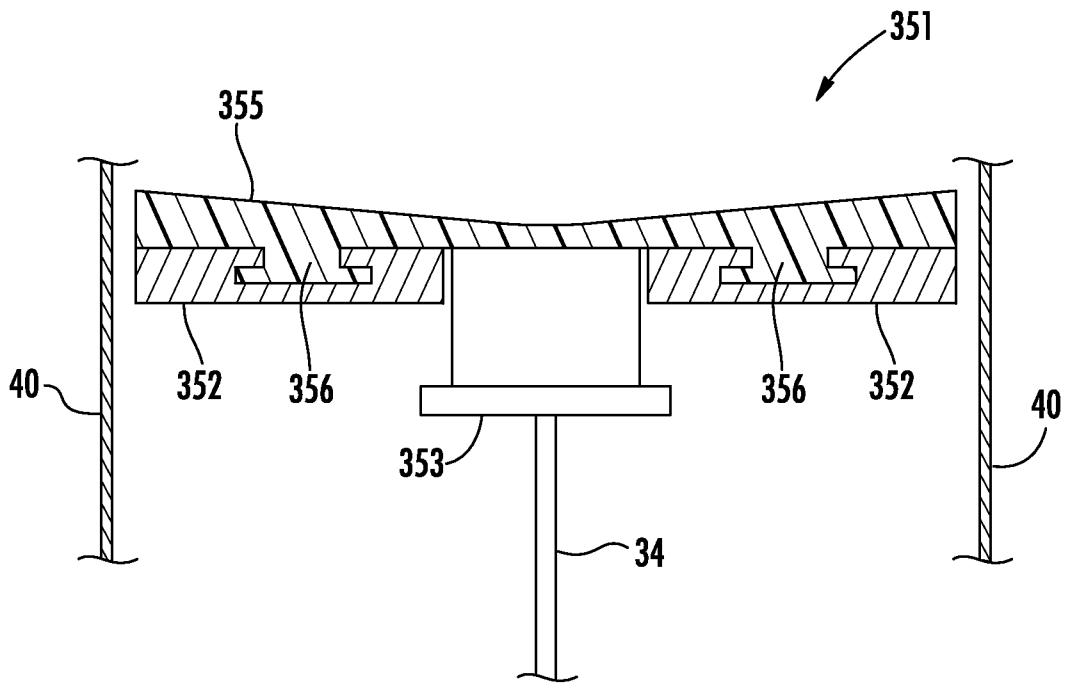


FIG. 61

51/52

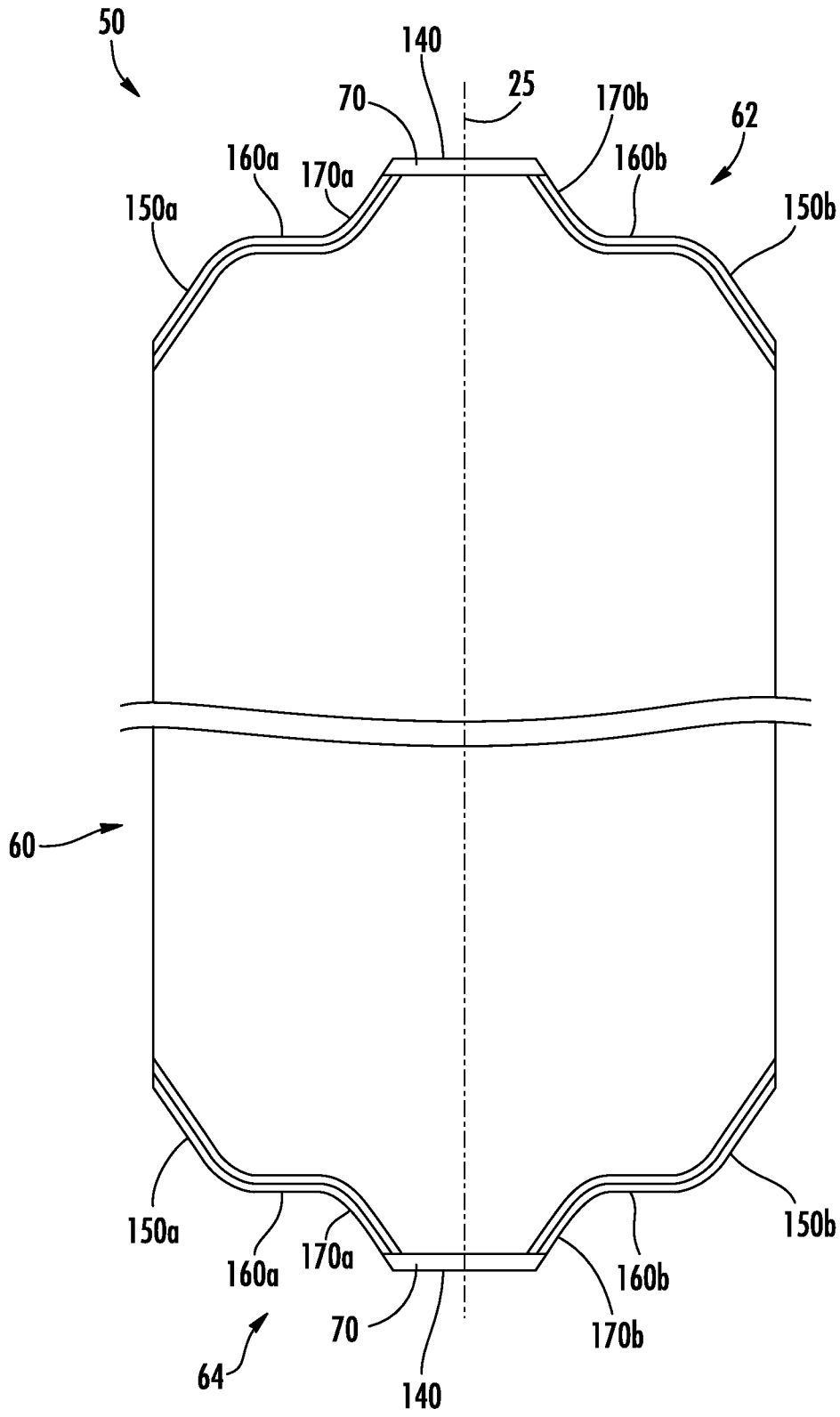


FIG. 62

52/52

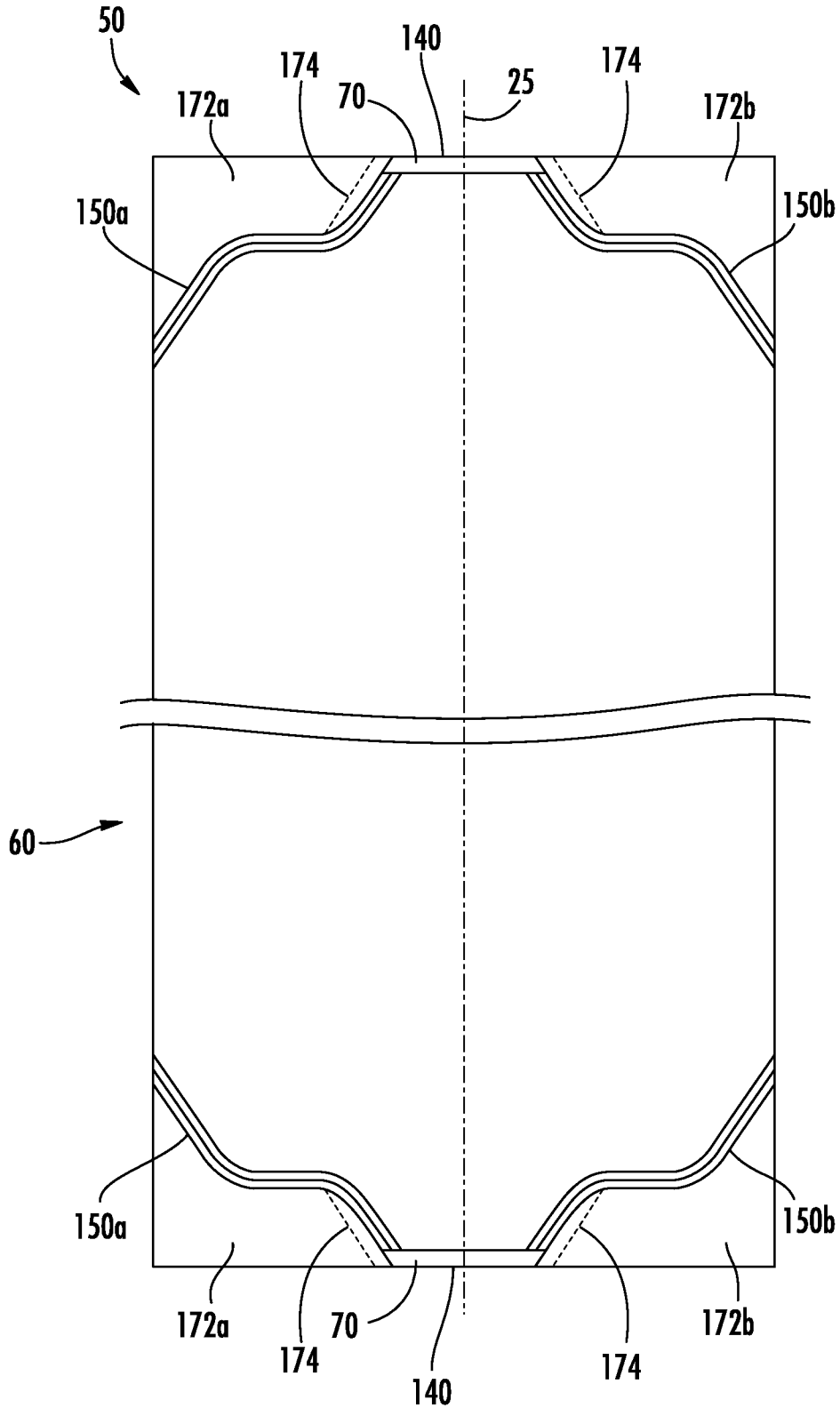


FIG. 63

