Dec. 14, 1971 J. R. SARE ET AL Re. 27,243

METHOD OF MANUFACTURING CELLULAR PACKING MATERIALS

Original Filed Nov. 13, 1964 3 Sheets-Sheet 1

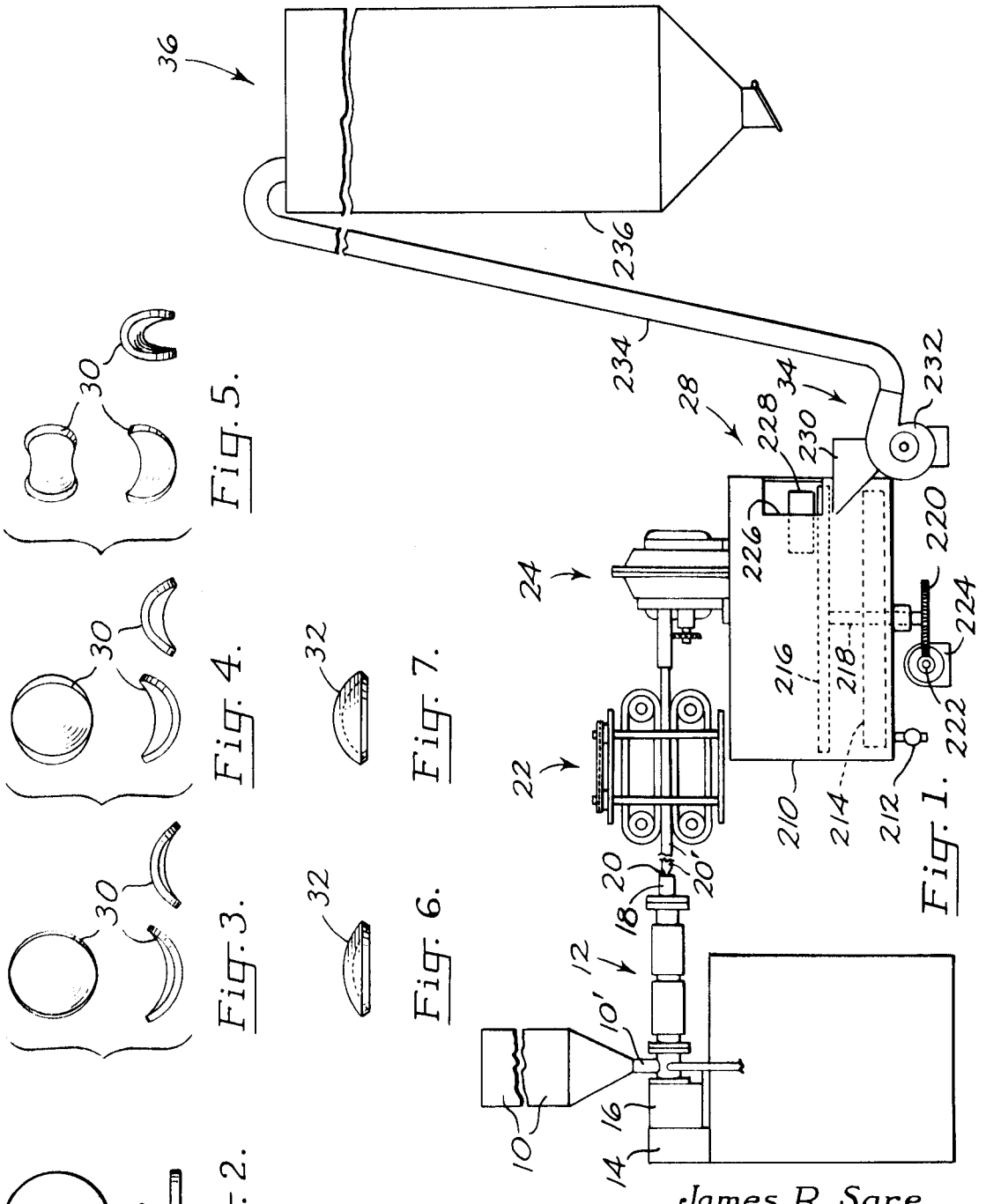


Fig. 1.

Fig. 5.

Fig. 4.

Fig. 3.

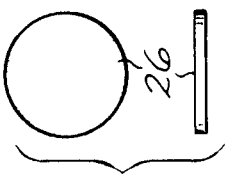


Fig. 2.

Fig. 7.

Fig. 6.

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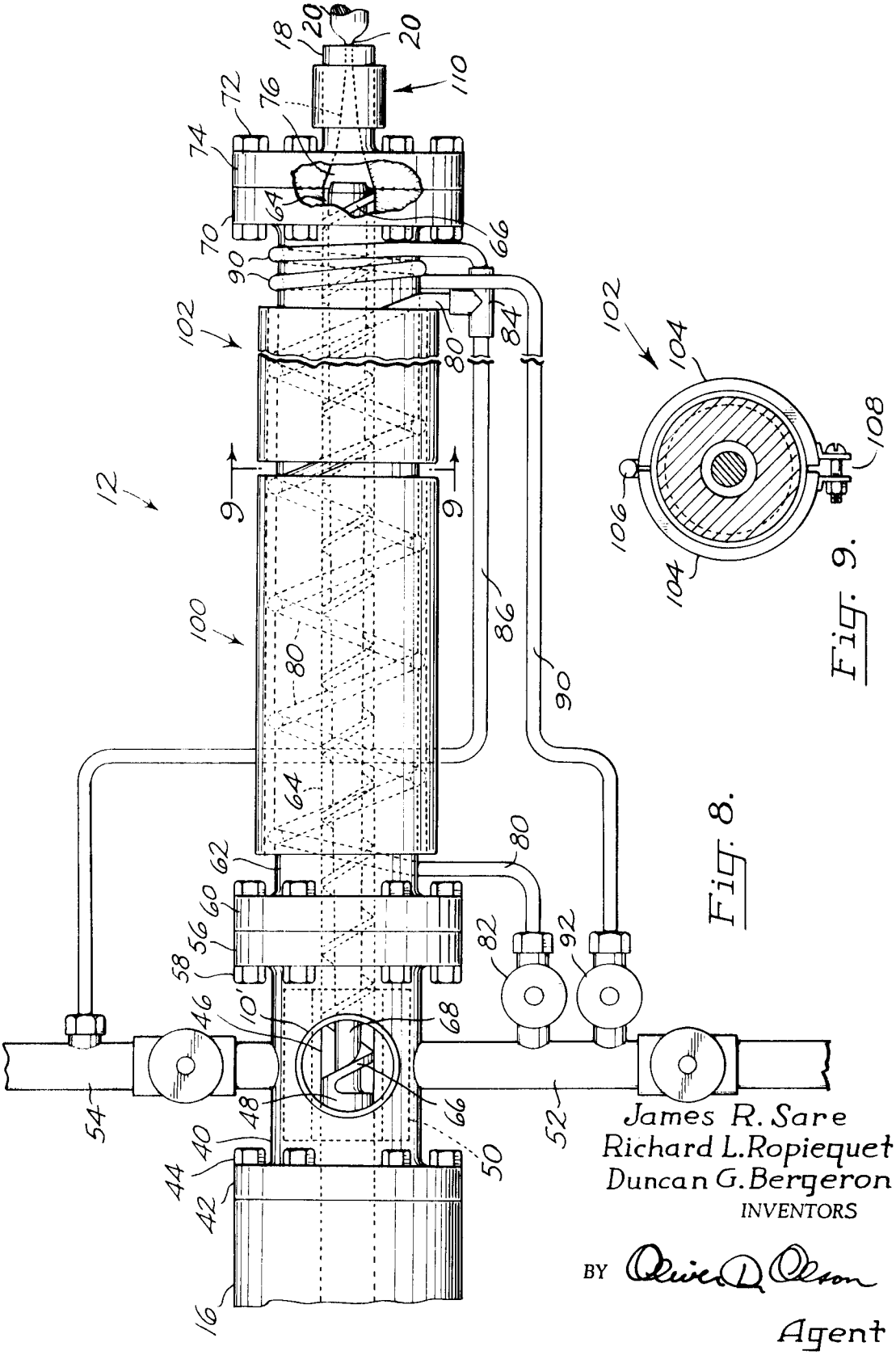


Fig. 8.

Fig. 9.

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METHOD OF MANUFACTURING CELLULAR PACKING MATERIALS

Original Filed Nov. 13, 1964 3 Sheets-Sheet 3

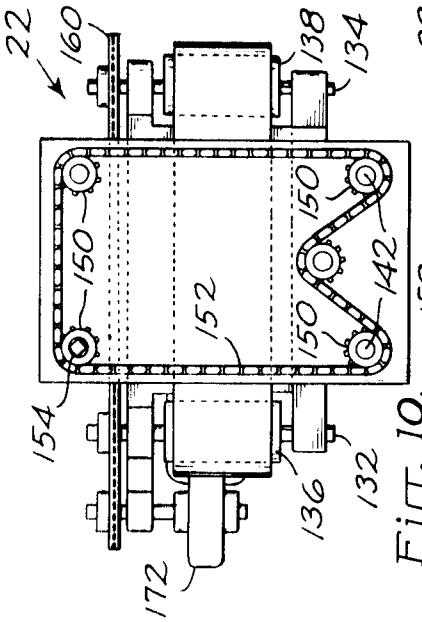


Fig. 10.

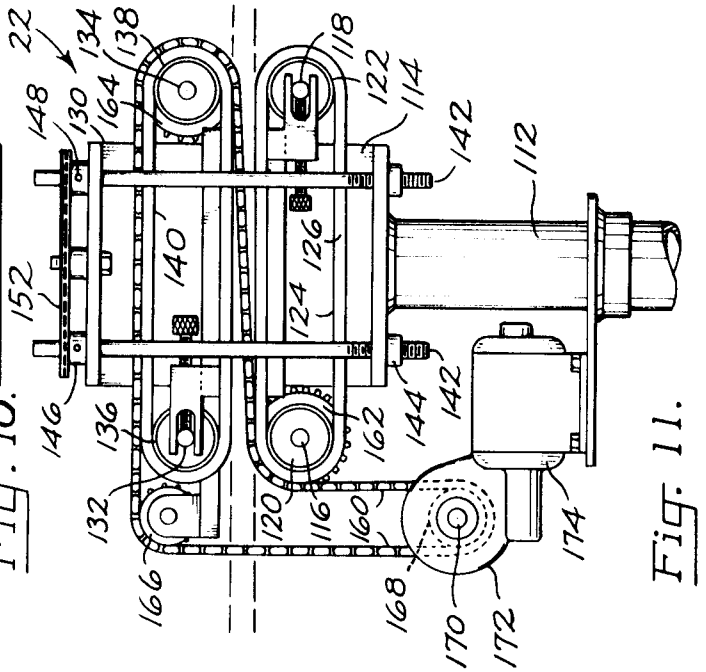


Fig. 11.

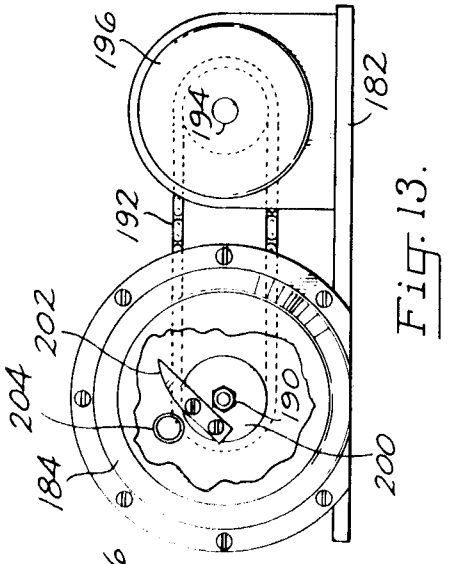


Fig. 13.

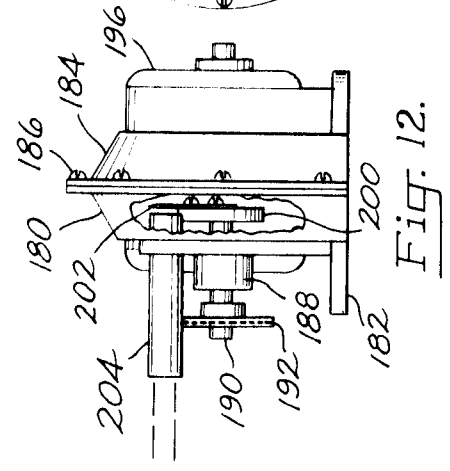


Fig. 12.

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United States Patent Office

Re. 27,243
Reissued Dec. 14, 1971

27,243

METHOD OF MANUFACTURING CELLULAR PACKING MATERIALS

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Original No. 3,400,037, dated Sept. 3, 1968, Ser. No. 411,033, Nov. 13, 1964. Application for reissue Jan. 12, 1970, Ser. No. 7,958.

Int. Cl. B29d 27/00

U.S. Cl. 161—42 12 Claims

Matter enclosed in heavy brackets [ ] appears in the original patent but forms no part of this reissue specification; matter printed in italics indicates the additions made by reissue.

ABSTRACT OF THE DISCLOSURE

This invention relates to articles made of extrudable, expandable synthetic plastic material, and to the method and apparatus for producing such articles.

Extrudable, expandable synthetic plastic materials, such as polystyrene compositions, have been used heretofore in the production of expanded articles of manufacture. Such articles have been produced by extruding foamable synthetic plastic compositions through a die provided with the configuration of the desired external shape of the article. The primary disadvantage in this procedure is represented by the substantial cost involved in the production of such dies.

It is the principal object of the present invention to provide for the production of an article of manufacture the ultimate shape of which is not dependent upon the provision of a correspondingly shaped die.

Another important object of the present invention is the provision of an expanded plastic article of manufacture the ultimate shape of which is produced by the selective warping of a thin, flat wafer of the plastic material.

Another and more specific object of the present invention is the provision of an expanded plastic article of manufacture produced by the selective warping of a thin, flat wafer of the plastic material and having a concavo-convex shape or the shape of a hyperbolic paraboloid.

Still another and specific object of this invention is the provision of an expanded plastic article especially useful as loose-fill packing material, in that a multiplicity of the articles is readily pourable from a bulk supply into a container housing an object to be packed, the shape of the articles contribute to their ability to interlock with each other to prevent shifting of the articles and the object within the package container, and the articles are characterized by very low bulk density whereby to reduce to a minimum the gross weight of the package and the cost of shipment thereof.

A further important object of the present invention is the provision of a method and apparatus for producing the expanded plastic article of manufacture of this invention.

The foregoing and other objects and advantages of this invention will appear from the following detailed description, taken in connection with the accompanying drawings in which:

FIG. 1 is a foreshortened schematic view in side elevation of apparatus for producing the article of manufacture of the present invention;

FIG. 2 shows plan and side views of a wafer of initially expanded synthetic plastic composition before processing for selective warping to ultimate shape;

FIGS. 3, 4 and 5 each shows plan side and end views of articles having varying degrees of hyperbolic paraboloid shapes resulting from the processing of the wafer of FIG. 2 under varying conditions;

FIGS. 6 and 7 are side views of articles having varying degrees of concavo-convex shape resulting from the processing of the wafer of FIG. 2 under still further varying conditions;

FIG. 8 is a foreshortened plan view, partly broken away to disclose details of internal construction, of the extruder component of the apparatus shown in FIG. 1;

FIG. 9 is a sectional view taken along the line 9—9 in FIG. 8;

FIGS. 10 and 11 are plan and side views, respectively, of the puller component of the apparatus shown in FIG. 1; and

FIGS. 12 and 13 are side and front views, respectively, with portions broken away to disclose internal details, of the cutter component of the apparatus shown in FIG. 1, FIG. 13 being viewed from the right in FIG. 12.

In its basic concept, the present invention involves the production of an expanded plastic article of manufacture from a thin flat wafer of the plastic material, initially expanded under predetermined conditions and subsequently subjected to an environment of steam, to produce the desired type and degree of warping either to concavo-convex shape or to the shape of a hyperbolic paraboloid.

Referring first to FIG. 1 of the drawings, the apparatus illustrated schematically therein includes a hopper **10** adapted to contain a supply of the extrudable, expandable plastic material, preferably in granular form. There are many types and varieties of such materials well known in the art, representative of which are the compositions disclosed in U.S. Letters Patent Nos. 2,941,964 and 2,941,965.

The constricted, bottom discharge end **10'** of the hopper communicates with the infeed end of an extruder component **12** driven by the electric motor **14** through a gear reduction unit **16**. The granular raw material is subjected to elevated temperature and pressure as it progresses through the extruder, causing the material to melt. The molten material then is forced through the outlet orifice of the extruder die **18** in a continuous, unexpanded filament **20**.

It is an important feature of the present invention, as will become apparent hereinafter, that the outlet orifice of the extruder die need simly be a round hole, rather than a complex configuration which heretofore has been required for predetermining the ultimate exterior shape of the finished article.

As the molten filament extrudes from the outlet orifice of the extruder die, exposure to the atmosphere results in rapid and substantial expansion to a rod **20'** many times the diameter of the orifice. This expansion is accompanied by simultaneous cooling of the expanded rod sufficiently to render the rod self-supporting, though quite flexible. Accordingly, the initially expanded rod is fed through a puller component **22** which performs the multiple functions of supporting the flexible rod a distance forwardly of the extruder component, stretching the rod slightly as it conveys the latter away from the extruder die, and feeding the leading end of the rod continuously to the cutter component **24** of the apparatus.

The cutter component functions to cut the initially expanded rod continuously into a multiplicity of thin, flat wafers **26** (FIG. 2). These wafers are fed into the post-expansion component **28** of the apparatus, wherein the wafers are deposited onto a moving conveyor in an atmosphere of steam. As these wafers progress through the post-expansion component to a point of discharge

from the latter, the environment of elevated temperature and steam causes the wafers to warp by being expanded further from the condition of initial expansion at the extruder component. Depending in part upon the conditions of extrusion and the thickness of the wafer, as discussed hereinafter, the latter will warp to various degrees either to the hyperbolic paraboloid shapes **30** illustrated in FIGS. 3, 4 and 5, or to the concavo-convex shapes **32** illustrated in FIGS. 6 and 7.

The warped wafers discharge from the post-expansion component and are conveyed by suitable means **34** to storage **36**, from whence they are packaged for shipment.

Referring now particularly to FIG. 8 of the drawings, the extruder component **12** of the apparatus includes an infeed housing **40**, secured at one flanged end **42**, as by the bolts **44**, to the output end of the gear reduction unit **16**. The infeed housing is provided with a central bore **46** receiving removably therein the infeed end of an extruder screw **48** which projects outwardly from its connection to the gear reduction unit. The bottom discharge end **10'** of the hopper communicates with this bore **46** and projects upwardly therefrom through the housing **40**. An annular chamber **50** in the housing surrounds the bore **46**, except for the area occupied by the discharge end **10'** of the housing and this chamber communicates with infeed and drain conduits **52** and **54**, respectively, for the circulation of cooling water therethrough. The inlet housing **40** thus is maintained at a temperature sufficiently low to prevent melting of the plastic material in the inlet end of the bore **46** and in the discharge end **10'** of the hopper.

The forward flanged end **56** of the inlet housing **40** supports, as by the bolts **58**, the rearward flanged end **60** of the elongated extruder housing **62**. This housing is provided with an axial bore **64** which is coaxial with and of the same diameter as the bore **46** in the inlet housing, for receiving the extruder screw **48** therein.

In the preferred embodiment illustrated, the extruder screw **48** is provided with a helical rib **66** of constant pitch and diameter projecting from a spindle **68** whose diameter increases uniformly from the infeed end to the outfeed end of the screw. By this construction the plastic composition is compressed progressively as it is fed forward along the bore **64**. To the forward flanged end **70** of the extruder housing **62** there is secured, as by the bolts **72**, the rearward flanged end **74** of the extruder die **18**. This die is provided with a central bore **76**, coaxial with the bore **64** in the extruder housing. The die bore tapers forwardly from a diameter substantially the same as the diameter of the bore **64** to a smaller diameter which predetermines the desired diameter of the extruded filament **20** prior to expansion.

Means is provided for controlling the temperature of the plastic material as it progresses forwardly along the bore **64**. To this end a cooling conduit **80** is coiled helically about the extruder housing **62**, being retained in a helical groove provided in the outer surface of the housing. The rearward end of the conduit is connected through the control valve **82** to the infeed conduit **52**. The valve may be of the manual type, but preferably is of the well-known type which is actuated by an electric solenoid. The forward end of the conduit **80** terminates rearwardly of the forward end of the extruder housing **62** and is connected through the T-coupling **84** to the outlet conduit **86** communicating with the drain pipe **54**.

A second cooling conduit **90** is coiled helically about the forward end of the extruder housing **62**. One end of this conduit is connected through the control valve **92** to the infeed pipe **52**, and the opposite end of the conduit is connected through the T-coupling **84** to the outlet conduit **86**.

Removably enclosing the cooling coil **80** and the extruder housing **62** is a pair of electrical heater units **100** and **102**. Each unit comprises a pair of elongated, semicircular members **104** of electrically non-conducting material each housing therein an electrical resistance heater element. The pair of semi-circular members of each unit are joined together at one of their adjacent edges preferably by such means as the piano hinge **106**, to permit the halves to be swung apart so that the unit may be installed upon or removed from the extruder housing. Clamp means **108** is provided adjacent the opposite edges of the semicircular members of each unit for securing them together releasably.

A third heater unit **110** of similar construction removably encircles the extruder die **18** forwardly of the mounting flange **74**.

As will be explained more fully hereinafter, each of the three heater units **100**, **102** and **110** is connected to a source of elastic supply through its own adjustable control (not shown), such as a potentiometer, so that each associated zone of the extruder component may be varied in temperature independently of the others.

Referring now to FIGS. 10 and 11 of the drawings, the puller component **22** of the apparatus is shown to include an upstanding pedestal **112** mounting at its upper end the bracket **114** which supports longitudinally spaced shafts **116** and **118**. These shafts rotatably mount rollers **120** and **122**, respectively, which support an endless belt **124** having a surface layer of sponge rubber **126** or other similarly soft material.

A second bracket **130**, supporting a similar assembly of longitudinally spaced shafts **132** and **134**, rollers **136** and **138** and endless belt **140**, is positioned above the lower belt assembly and supported for vertical adjustment relative thereto by means of the plurality of vertically extended, elongated adjustment screws **142**. Each of these screws is threaded through a boss **144** secured to a laterally extending plate on the lower bracket **114**, and the upper end of each screw projects freely through a collar **146** secured to a similar lateral plate on the upper bracket **130**. A set screw **148** in the collar extends radially inward thereof into an annular groove provided in the screw, whereby to secure the upper bracket **130** to the screw while permitting rotation of the latter. The upwardly projecting end of each screw mounts a sprocket **150** over which the endless chain **152** is trained.

One of the screws **142** is provided at its upper end with a non-circular drive connection **154** for a crank or other appropriate tool by which to rotate the screw. By virtue of the interconnection of all of the screws by the chain **152**, simultaneous rotation of all of the screws in the same direction is achieved, thereby moving the upper belt assembly vertically with respect to the lower belt assembly. Thus, the space between the adjacent working stretches of the opposed belts may be adjusted to accommodate varying diameters of initially expended plastic rod material **20'** emanating from the extruder component **12**.

Means for driving the upper and lower belt assemblies is provided by the endless chain **160** trained over a sprocket **162** on the shaft **116**, thence over another sprocket **164** on the upper shaft **134** and an idler sprocket **166** mounted on the upper bracket **130**, and thence around a sprocket **168** secured to the output shaft **170** of the gear reduction unit **172** driven by the electric motor **174**.

The puller unit **22** functions to grip the initially expanded plastic rod **20'** between the soft gripping surfaces of the opposed belt assemblies, and to continuously withdraw the rod from the extruder unit **12**. By adjustment of the variable speed drive motor **174**, the speed of the belt assemblies may be adjusted to provide a desired degree of pull upon the rod, thus to assist in controlling the diameter of the rod and hence the diameter of the flat, thin wafers **26** cut from it.

The initially expanded rod is fed from the puller component to the cutter unit **24** wherein the rod is cut into a multiplicity of thin flat wafers **26**. The cutter unit illustrated in FIGS. 12 and 13 comprises a hollow housing including a fixed section **180** mounted on a base **182** and a

removable section **184** secured to the fixed section by such means as the bolts **186**. The side wall of the fixed section supports a bearing **188** which mounts a rotary cutter shaft **190**. This shaft extends through the fixed housing wall, and the outer end of the shaft mounts a sprocket which is connected through the endless chain **192** to a sprocket mounted on the output shaft **194** of an electric drive motor **196**. This motor preferably is of the variable speed type, whereby to control the rotational speed of the shaft and hence the rotational speed of a cutter head mounted on the shaft within the housing.

In the embodiment illustrated, the cutter head comprises a disc **200** removably secured to the cutter shaft **190** and removably mounting a cutter blade **202** for rotation therewith. The cutting edge of the blade is disposed to intercept the path of the initially expanded plastic rod **20'** which is fed into the cutter housing through the guide tube **204**.

It will be understood that the thickness of the wafers **26** cut from the rod is dependent upon the relative speed of longitudinal movement of the rod into the cutter housing and the rotational speed of the cutter blade. Either or both of these factors may be controlled by appropriate adjustment of speed of the variable drive motors **174** and **196** respectively.

The post expansion unit **28** comprises a hollow closed tank **210** provided with a valved inlet **212** at its bottom for introducing water. Electrical heater means **214** is contained within the tank adjacent the bottom thereof for heating the water to boiling and thus providing an atmosphere of steam within the tank. A perforate plate **216** within the tank and above the level of water therein is supported for rotation with the vertical shaft **218** which extends downward through the bottom of the tank. The lower end of the shaft supports a gear **220** which meshes with a worm **222** on the output shaft of the electric drive motor **224**.

An opening **226** is provided in the side of the tank, to permit the discharge of treated wafers from the tank. To this end there is mounted on the side wall within the opening an elongated deflector blade **228** which closely overlies the perforate conveyor plate **216**. The blade extends inwardly of the outer edge of the plate **216** to intercept the wafers previously deposited upon a conveyor plate behind the blade **216** and subjected to the atmosphere of steam. The deflector plate thus directs the treated wafers outwardly through the opening **226** for collection and storage.

In the embodiment illustrated in FIG. 1, the treated wafers discharged from the post-expansion unit **28** fall by gravity through a hopper **230** from whence they are blown or otherwise conveyed, by such means as the fan **232**, upwardly through the duct **234** into the storage container **236**. This container preferably is made of perforate material, such as screen or other open mesh material, to permit the free circulation of air through the finished articles stored therein, to facilitate drying. From the storage container the finished articles may be poured into plastic bags or other containers for shipment.

To illustrate the operation of the apparatus described hereinbefore, the polystyrene composition disclosed in U.S. Letters Patent No. 2,941,964 and marketed by Koppers Company, Inc. under the trademark Dylite, was fed to the extruder unit **12** wherein the extruder screw **48** was approximately 20" long and 1" in diameter, and the outlet orifice of die **18** was ⅛" in diameter. The screw was rotated between 50 and 73 r.p.m., the working stretches of the belts **124** and **140** of the puller unit **22** were moved at a speed of about 30 lineal feet per minute, and the single cutter blade **202** was rotated at about 2,800 r.p.m.

The heater units **100**, **102** and **110** and the flow of cooling liquid through the chamber **50** and coils **80**, **90** were adjusted to maintain the temperature at the infeed end of the screw at about 100° F., the temperature of the screw in the area of heater element **100** at about 220° F., the temperature of the screw in the area of heater element **102** at about 250° F., and the temperature at the die **18** at about 230° F.

The post-expansion unit **28** provided steam at atmospheric pressure, and the movement of the perforate conveyor provides a treatment time of about 30 seconds.

As the ⅛" diameter filament **20** extruded from the die orifice, it expanded to approximately ¾" diameter. The cutter unit **24** reduced this rod to a multiplicity of flat, thin wafers about 1/16" thick.

In the illustrated operation of the apparatus described hereinbefore, various factors contribute beneficially or adversely to the characteristics of the resultant article. For example, it has been found that when the extruder screw **48** is rotated at a speed below a predetermined minimum, for example below about 50 r.p.m., the thin, flat wafers **26** produced at the cutter unit **24** do not warp when subjected to the steam treatment in the post-expansion unit **28**. On the other hand, when the extruder screw is rotated at a speed in excess of about 73 r.p.m., the post-expansion treatment results in the wafers being warped excessively and exhibiting too high bulk density.

When the extruder screw is rotated at a speed from about 50 to about 69 r.p.m., the post-expansion treatment results in the production of the concavo-convex shapes **32** illustrated in FIGS. 6 and 7. Rotation of the extruder screw from about 69 to about 73 r.p.m. produces the hyperbolic paraboloid shapes **30** of FIGS. 3, 4 and 5 in the post-expansion unit.

Additionally, the degree of expansion and warping in the post-expansion unit varies with the time of exposure of the wafers to the elevated temperature of the steam atmosphere. In the example illustrated, an exposure time of about 30 seconds provided optimum expansion and warping. When the exposure time was reduced to about 20 seconds the degree of warping was not sufficient to provide the shapes illustrated in FIGS. 3 and 6. On the other hand, when the exposure time was extended to about 50 seconds, the degree of warping was excessive, i.e. it produced a degree of curl substantially greater than that illustrated in FIGS. 5 and 7. Moreover, the cellular structure of these wafers collapsed, rendering the product unsuitable as a loose-fill packing material.

It will be understood that the exposure time in the post-expansion unit **28** may be reduced materially by constructing the tank so that it may be pressurized with steam.

Another factor contributing to the ultimate characteristics of the finished article is the degree of heating of the plastic material in the extruder unit **12**. For example, it has been found that proper expansion and warping in the post-expansion unit **28** does not occur with the plastic material described hereinbefore, when the temperature of the die **18** is equal to or higher than the temperature in the zone of heating unit **102**. Moreover, excessive warping occurs when the temperature in the zone of heating unit **102** exceeds about 265° F.

The finished articles as discharged from the post-expansion unit may be used for various purposes. For example, they may be strung on threads in the manner of popcorn or beads, to provide Christmas tree or other decorations. They may be impaled upon wires to form various ornamental structures. Of particular importance, however, is the use of the articles as a loose-fill packing material for packing fragile objects for shipment. Thus, whereas popcorn, excelsior and other well known material have been used, for example, in packing of delicate and expensive glassware, the articles of manufacture of the present invention provide advantages not attainable by these other materials.

For example, the warped shapes **30** and **32** illustrated in FIGS. 3–7 have much lower bulky density, are chemically inert, and are much less expensive than popcorn. They flow freely, in the manner of grain, to completely fill a container and surround an object contained therein.

thus eliminating the tedious and time consuming procedure of hand packing required in the use of excelsior and other stringy materials, while simultaneously achieving a substantially uniform bulk density throughout the packing.

Further, the warped shapes of the articles illustrated herein tend greatly to interlock with each other when massed together. In the case of the dome shaped structures **32** of FIGS. 6 and 7, the concave surface of one tends to lock the convex surface of another with it, and the firmness of the lock is enhanced by the highly frictional character of the surfaces of the expanded material.

In the case of the hyperbolic paraboloid shapes **30** of FIGS. 3, 4 and 5, it is to be noted, with particular reference to the side and end views, that these shapes provide a pair of saddles disposed substantially normal to each other (one defined by the top surface and the other by the bottom surface). Accordingly, one saddle of one article tends to seat in one saddle of another article and to be locked in such position by the frictional contact between the abutting surfaces.

Although the shapes described hereinbefore have been produced by the extrusion of the expandable plastic material through a simple round orifice die, it will be apparent that non-circular die orifices may be employed if it is desired to produce the intermediate flat, thin wafers **26** of non-circular shape for post-expansion treatment in the manner described hereinbefore. In any event, the finished article is characterized by having curvilinear top and bottom surfaces and a cross sectional thickness substantially less than its peripheral dimensions.

Other foamable synthetic plastic compositions well known in the art may be employed for the purpose of the present invention, it being recognized that in such event the temperature conditions previously illustrated may require modification in accordance with the physical properties of the particular composition.

The foregoing and other modifications in structure and process conditions may be made without departing from the spirit of this invention and the scope of the appended claims.

Having now described our invention and the manner in which it may be used, what we claim as new and desire to secure by Letters Patent is:

1. The method of making an article of extrudable, expandable synthetic plastic material, comprising:

(a) extruding the material under pressure through a die orifice to an atmosphere of lower pressure to initially expand the extruded filament to rod form of larger cross sectional dimension,

(b) cutting the expanded rod form transversely into a multiplicity of flat, thin wafers each having a cross sectional thickness substantially less than its peripheral dimensions, and

(c) subjecting the wafers to the action of steam at elevated temperature for a time sufficient to effect warping of the wafers to a shape having curvilinear top and bottom surfaces and a cross sectional thickness substantially less than their peripheral dimensions.

2. The method of claim **1** wherein the material is extruded through a circular die orifice to produce an initially expanded cylindrical rod.

3. An article of manufacture comprising an expanded synthetic plastic [material] *wafer* having curvilinear top and bottom surfaces and a cross sectional thickness substantially less than its peripheral dimensions.

4. An article of manufacture comprising an expanded synthetic plastic [material] *wafer* having a concavo-convex shape and a cross sectional thickness substantially less than its peripheral dimensions.

5. An article of manufacture comprising an expanded synthetic plastic material having a hyperbolic paraboloid shape and a cross sectional thickness substantially less than its peripheral dimensions.

6. A packing material designed for free-flow installation about an object for forming a shock-resistant barrier around the object comprising

a multiplicity of wafer-shaped members of expanded synthetic plastic material, each of said members having curvilinear top and bottom surfaces for contacting adjacent members, and

each of said members having a cross-sectional thickness substantially less than its peripheral dimension.

7. A packing material as described in claim 6 wherein said members have highly frictional top and bottom surfaces to enhance nonshifting contact of said members when said members are massed together.

8. A chemically inert loose-fill packing material designed for free-flow installation about an object to form an interlocked, shock-resistant barrier around the object when the material is compressed, comprising

a multiplicity of warped wafers of expanded synthetic plastic material, each of said wafers having highly frictional, curvilinear top and bottom surface means thereon contacting adjacent wafers for enhancing nonshifting contact between said wafers only when said material is compressed, and

each of said wafers having a cross-sectional thickness substantially less than its peripheral dimension.

9. A uniform bulk density packing material comprising,

a multiplicity of resilient, warped members of expanded synthetic material residing in mutual nonsliding contact only when said material is compressed, at least some of said members having highly frictional surface means thereon of concavo-convex shape for enhancing said nonsliding contact between members, and

each of said members having a cross-sectional thickness substantially less than its peripheral dimension.

10. A packing material as described in claim 9 wherein at least some of the warped members having surface means of concavo-convex shape are of graded size whereby the convex surface means of some of said members lock in nonsliding contact with the concave surface means of other adjacent members when the members are massed together.

11. The method of making loose-fill packing material from extrudable, expandable synthetic elastic material, comprising:

(a) extruding the material under pressure through a die orifice to an atmosphere of lower pressure initially to expand the extruded filament to rod form of larger cross-sectional dimension,

(b) cutting the expanded rod form transversely into a multiplicity of flat, thin wafers each having a cross-sectional thickness substantially less than its peripheral dimensions, and

(c) subjecting the wafers to successive stages of steam heat and cooling to warp the wafers, and

(d) conveying the warped wafers by air to a storage container.

12. The method of making loose-fill packing material from extrudable, expandable synthetic plastic material, comprising:

(a) extruding the material under pressure through a die orifice to an atmosphere of lower pressure initially to expand the extruded filament to rod form of larger cross-sectional dimension,

(b) cutting the expanded rod form transversely into a multiplicity of flat, thin wafers each having a cross-sectional thickness substantially less than its peripheral dimensions and a diameter of suitable size that said wafers can be massed together as loose-fill packing material, and

(c) subjecting the wafers to the action of steam at elevated temperature for a time sufficient to effect warping of the wafers to a shape having curvilinear

top and bottom surfaces and a cross-sectional thickness substantially less than their peripheral dimensions, so that the top and bottom surfaces lock in nonsliding contact with corresponding surfaces of other wafers when massed together to form said loose-fill packing material.

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U.S. Cl. X.R.

161—125, 168; 264—51, 53, 141, 143