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INFUSION PACKAGE WITH HANDLES AND THE METHOD OF MANUFACTURING SAME

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Fig. 1-A.

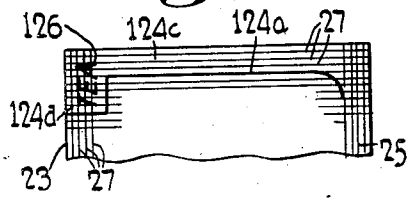


Fig. 1.

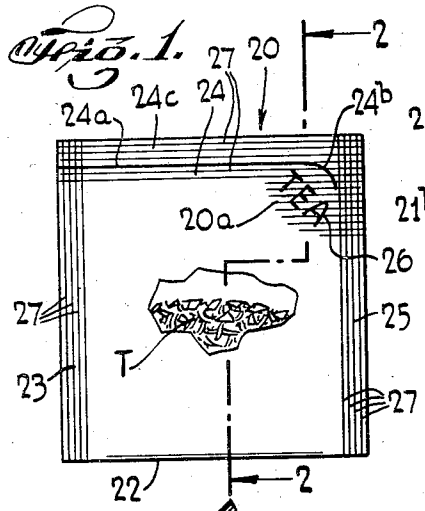


Fig. 2.

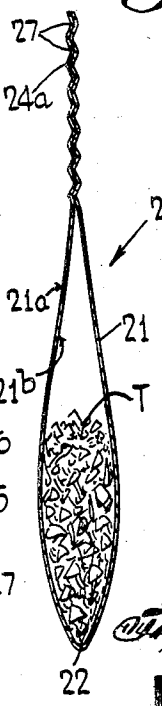


Fig. 3.

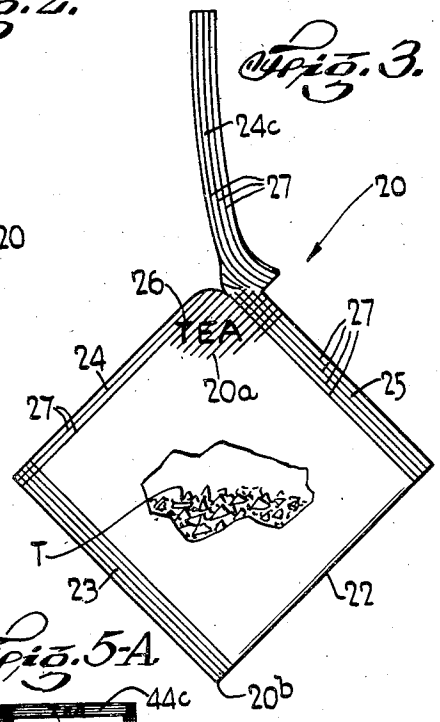


Fig. 5-A.

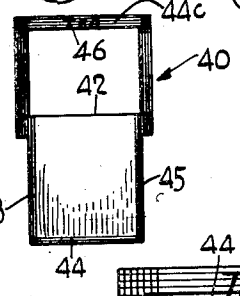


Fig. 4-A.

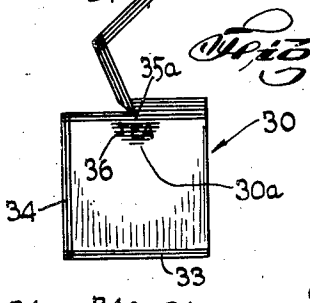


Fig. 4.

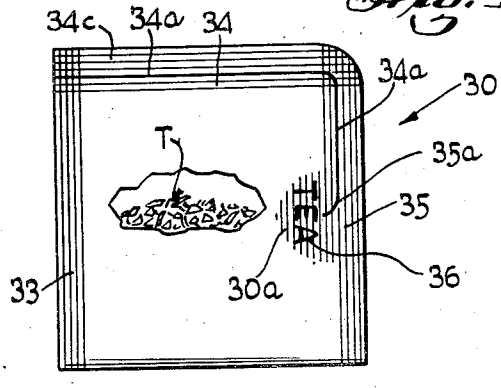
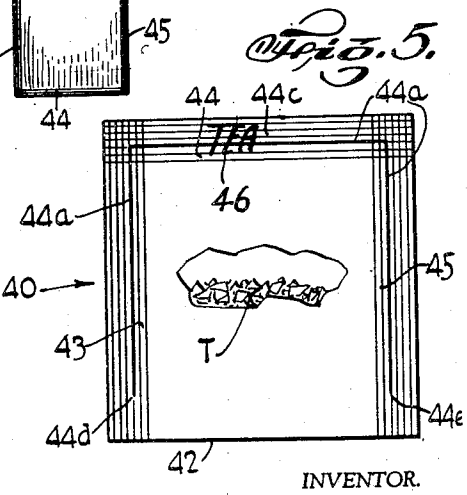


Fig. 5.



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Fig. 8.

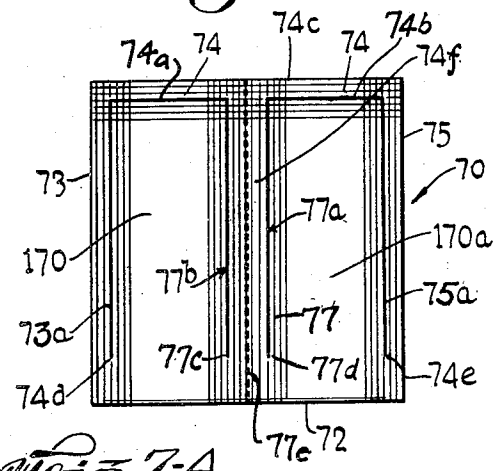


Fig. 8-A.

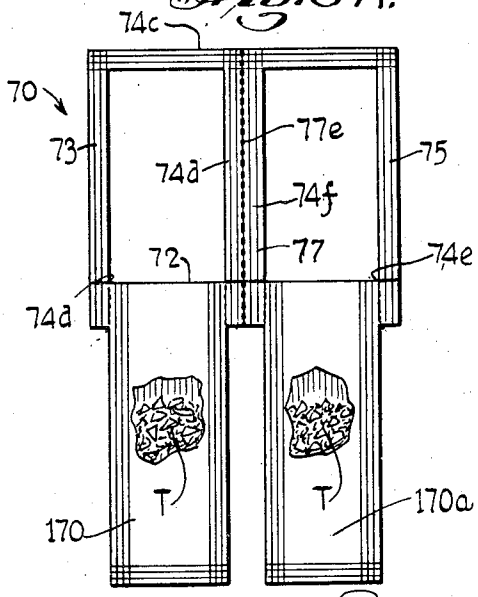


Fig. 7-A.

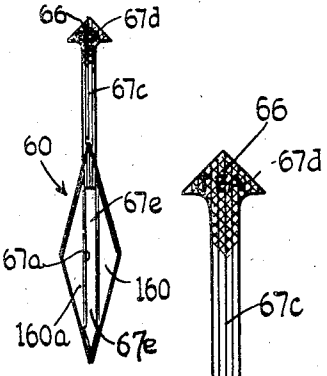


Fig. 6-A.

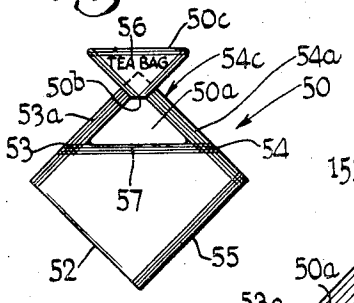
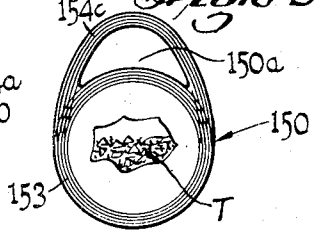


Fig. 6-B.



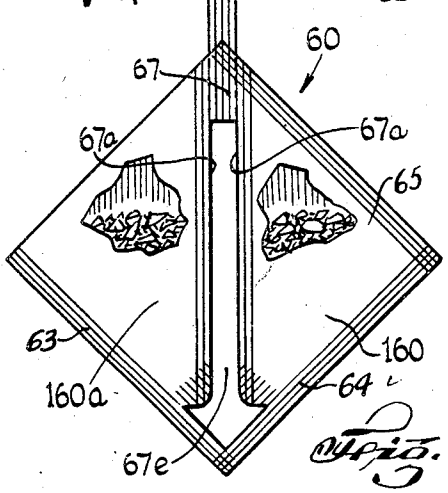


Fig. 7.

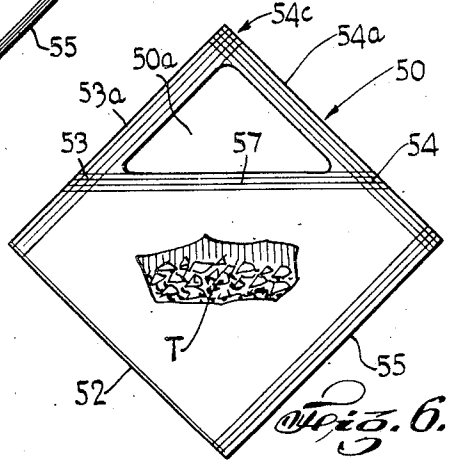


Fig. 6.

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Fig. 9.

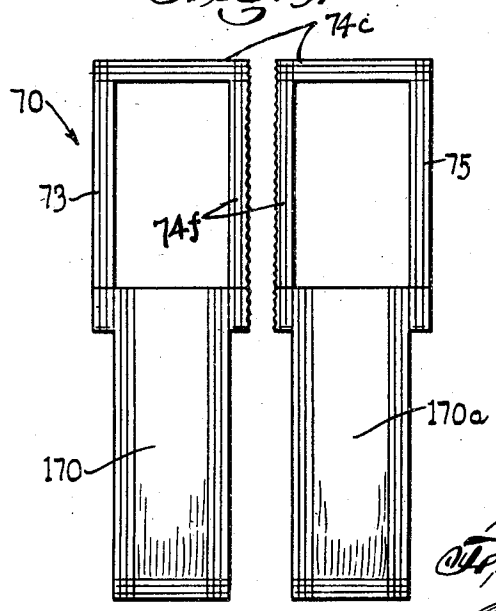


Fig. 10.

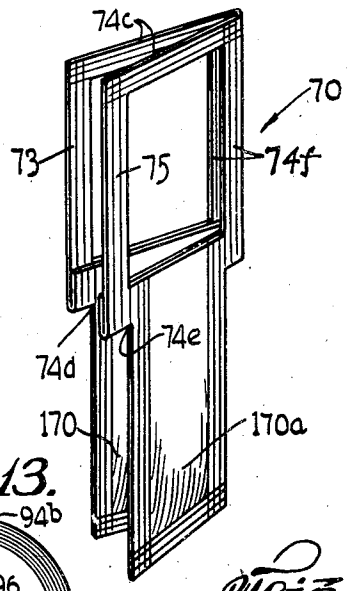


Fig. 13.

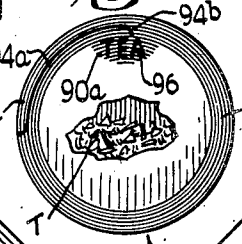


Fig. 11.

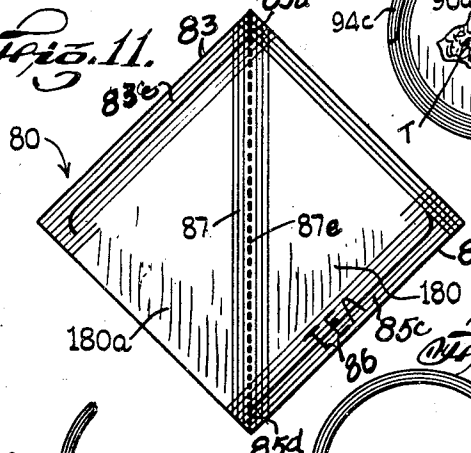


Fig. 12.

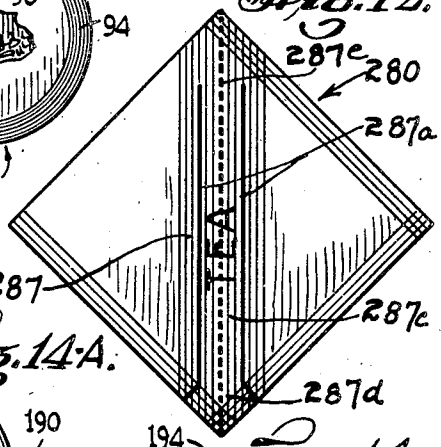


Fig. 14-A.

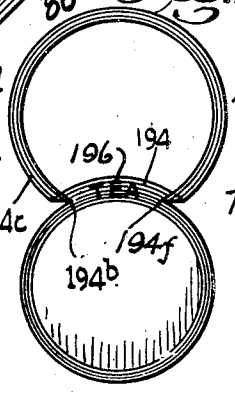


Fig. 13-A.

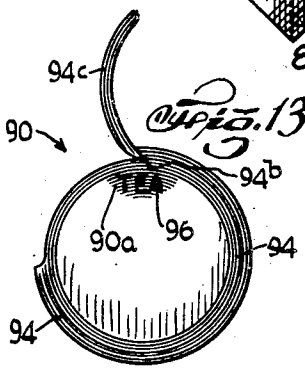
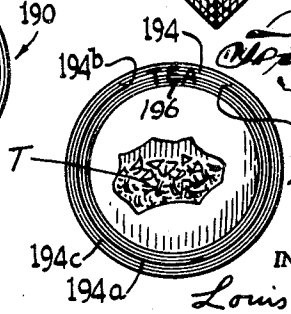


Fig. 14.



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UNITED STATES PATENT OFFICE

2,413,686

INFUSION PACKAGE WITH HANDLE AND THE METHOD OF MANUFACTURING SAME

Louis Barnett, Brooklyn, N. Y., assignor to Millie Patent Holding Co., Inc., a corporation of New York

Application February 26, 1941, Serial No. 380,628

18 Claims. (Cl. 99—77.1)

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This invention relates to the manufacture of filled containers or bags and more particularly is directed to infusion packages, such as tea-balls and like articles of manufacture, and a novel method of producing same.

Among the objects of the invention is to generally improve the construction of filled containers or bags in the form of infusion packages as inexpensive articles of manufacture, which shall comprise few and simple parts, which shall be easy and cheap to manufacture, which shall be capable of quantity production on automatic high-speed packaging machines, which shall have joint seams retained against separation by suitable adhesive means, such for example, as by a heat sealing process, which shall provide an improved form of handle formed integrally of the enclosing bag of the package, and which article and the method of manufacture thereof shall be practical and efficient to a high degree in use.

Other objects of the invention will in part be obvious and in part hereinafter pointed out. The invention accordingly consists of features of constructions and method, combinations of elements, arrangements of parts and steps in the process of manufacture which will be exemplified in the constructions and method hereinafter described and of which the scope of the application will be indicated in the following claims.

In the accompanying drawings in which are shown various possible illustrative embodiments of this invention,

Fig. 1 is a plan view of a square-shaped tea-ball constructed to embody the invention;

Fig. 1—A is a front elevational view of a fragmentary portion of a tea-ball similar in construction to that shown in Fig. 1, except that the handle constructed from the edge border flange is terminated by an integrally formed tag;

Fig. 2 is an enlarged sectional view taken on line 2—2 in Fig. 1;

Fig. 3 is a front elevational view of the tea-ball shown in Fig. 1 with the handle thereof extended and the parts of the tea-ball suspended for manipulating the tea-ball during the brewing operation;

Fig. 4 is a front elevational view showing a modified construction of a square-shaped tea-ball embodying the invention, the handle of which is formed from two edge border flange portions thereof;

Fig. 4—A is a front elevational view of the tea-ball shown in Fig. 4 with the handle extended for suspension thereof;

Fig. 5 is a front elevational view showing another modified construction of a square shaped tea-ball embodying the invention, with a ball-handle formed from three edge border flange portions thereof;

Fig. 5—A is a front elevational view of the tea-ball shown in Fig. 5 with the ball-handle thereof extended for manipulation of the tea-ball in brewing;

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Fig. 6 is a front elevational view of another modification of a square shaped tea-ball constructed to embody the invention, showing the handle thereof formed by cutting an opening in an unfilled mid-portion of the tea-ball;

Fig. 6—A is a front elevational view of the improved tea-ball shown in Fig. 6 with the portion from the cut opening retained in attachment to serve as a tag;

Fig. 6—B is a front elevational view of a tea-ball construction like that shown in Fig. 6, except that the bag portion is circular shaped;

Fig. 7 is a front elevational view of still a further modification of a square-shaped sectionalizable tea-ball constructed to embody the invention, showing the handle thereof formed and extended from a mid-portion for manipulation of the tea-ball in brewing;

Fig. 7—A is a front elevational view like Fig. 7 showing the sections thereof folded toward each other;

Fig. 8 is a front elevational view of a further modification of a square-shaped sectionalizable tea-ball embodying the invention, the handle of which is formed of the edge and mid-portions thereof;

Fig. 8—A is a front elevational view of the tea-ball shown in Fig. 8 with the handle thereof extended for manipulation of the tea-ball in brewing;

Fig. 9 is a front elevational view of the sectionalized tea-ball shown in Figs. 8 and 8—A torn apart;

Fig. 10 is a perspective view of the tea-ball shown in Figs. 8 and 8—A showing the sections thereof folded toward each other;

Figs. 11 and 12 are front elevational views of still other modified sectionalized tea-balls constructed to embody the invention;

Figs. 13 and 13—A are front elevational views of further modified tea-ball constructions like that shown in Fig. 1, except made circular in shape; and

Figs. 14 and 14—A are front elevational views of a still further circular shaped tea-ball constructed to embody the invention.

Referring to the drawings, 20 denotes one improved construction of a filled infusion package in the form of a square-shaped tea-ball manufactured to embody the invention. As seen from Figs. 1, 2 and 3, the tea-ball 20 may comprise a bag portion made of a strip of filter sheet material 21 folded over on itself to provide a fold edge 22 forming two superimposed layers, that is, overlying portions providing the flattened sides of tea-ball 20 which are adhesively secured on the marginal areas on the remaining three edge por-

tions at border joint seams or flanges **23**, **24** and **25** to completely seal the tea-ball bag thus formed, said tea-ball bag being partially filled with an essence containing product T, such as tea, forming the contents thereof.

The strip of sheet material **21** may be supplied from a suitable source in the form of a web of the required width (not shown) in the well understood manner, a sufficient length of said web being cut and folded to form the tea-ball bag. Or, precut strips of sheet material **21** of proper shape and length may form such supply source if desired. Sheet material **21** is of foraminous construction, as for example, filter paper, perforated parchment paper or Cellophane, cotton gauze and the like. That used in the practice of the invention here described may comprise a filter paper base layer **21***a* coated on one side with a thermosetting "partially fused" plastic lamina **21***b* of the character described in the application of Theodore F. Menzel, Serial No. 335,794, filed May 17, 1940, or of other suitable filter sheet base layer coated with a thermosetting plastic lamina for forming the heat sealed border joint seams or flanges **23**, **24** and **25** in the manner hereinafter more fully described.

A suitable filter paper sheet for forming base layer **21***a* may be made of a vegetable fibrous pulp stock, said layer **21***a* with thermosetting coating or lamina **21***b* being such that when made into the tea-ball bag has sufficient wet strength to withstand immersion in boiling water without damage or disintegration and without undue loss of tensile strength. The filtering sheet material **21** comprising the layer **21***a* and coating **21***b* when forming the tea-ball bags must be such as to permit ready infusion, that is, passage therethrough of the water of immersion for brewing and straining the filling or tea contents T, said layer **21***a*, coating **21***b* and flanges **23**, **24** and **25** being of such composition that it is non-toxic, insoluble in hot boiling water, and impart no odor or taste even to the slightest degree to the brew.

It has been found in practice that a 6½ pound fibrous pulp stock sheet of approximately .001 inch thick of high wet tensile strength forms a practical filter paper layer **21***a* for the purposes described herein. On such layer **21***a* a finely powdered copolymer of vinyl chloride and vinyl acetate may be uniformly sprinkled or sprayed, "partially fused" by heat to 60° C. and pressure rolled thereon for providing a satisfactory, pervious, dry and extremely thin coating or lamina **21***b* which does not materially affect the filtering capacity of the layer **21***a*. Approximately three ounces of such vinyl powder for each pound of said layer **21***a* will form said coating or lamina **21***b* of normally less than .0005 inch thick.

Sheet material **21** after taken from a supply source is cut to the required size, made into the tea-ball bags and filled with the contents T, the tea-ball bags each having the coating **21***b* of the sheet material **21** positioned on the interior surfaces thereof so that the border edge joint seams or flanges **23**, **24** and **25** are sealed on placing the coating portion thereof in face to face relation and applying pressure and heat to a fusion temperature by suitable clamping means of any well known construction. With the coating or lamina **21***b* formed of the "partially fused" vinyl powder permanent sealing fusion will take place when pressure and heat of approximately 130° C. is applied.

In the manufacturing of infusion packages for tea-balls and the like, it has heretofore been found desirable to include as part of the package some form of handle to manipulate the tea-ball during the brewing operation which may be carried out in a cup, and also to provide a tag which bears a legend such as the name or trade-mark of the manufacturer, grade of tea, etc. Such handles are most frequently provided by a string or stitched thread attached to the tea-ball bag, the free end of the string handle being terminated by the tag. The provision of such string handles and tags in the construction of such complete tea-balls not only increases the cost of manufacturing by employing various additional materials, but also complicates the production process by requiring additional steps and when made on high speed automatic machines necessitates the use of expensive apparatus.

To simplify the method of manufacture and to make available less expensive high-speed automatic machines for the production of tea-balls with handles and means for carrying legends, tea-ball **20**, made as above described and shown in Figs. 1 to 3, inclusive, with heat sealed joint seams or flanges **23**, **24** and **25** is provided, one of said flanges, as for example, **24**, being partially severed by a through split or cut **24***a* through a mid-portion of the length thereof. Said cut **24***a* extends from the outer edge of the flange **23** and terminating at **24***b* a short distance from the edge of the flange **25**. The portion of the flange **24** partially severed by through cut **24***a* provides a non-tangling handle **24***c* for the tea-ball **20**. The inner end **24***b* of said cut **24***a* may be curved in a direction of the length of the flange **25** to "tear-proof," that is, serve as an effective means for preventing the accidental tearing of the material between said inner end **24***b* and the adjacent free edge of the flange **25**. The curvature of the cut at **24***b* also aids in producing a balanced stabilized suspension of the tea-ball **20** when manipulated by the handle **24***c*, as is clear from Fig. 3. The utility of the invention when constructed like tea-ball **20** described above will now be apparent. The tea-ball bags may be manufactured in the usual manner and instead of applying separate string handle and tag, a portion of heat-sealed joint seam extending about the bag is made sufficiently wide to permit partial severing a portion thereof as by means of cut or split **24***a* in the manner described above and shown in Fig. 1. Such tea-balls **20** are thereby provided with completely formed handles **24***c* which are integrally formed with the tea-ball bag structure, and because no other material need be incorporated into the tea-ball structure or attached thereto, the tea-ball **20** can be made by the simplified method above described and can be readily produced at a higher rate of speed on less expensively constructed automatic machines than is possible with the usual string handles and tags.

The tea-ball **20** above described may also be provided with a legend bearing portion **20***a* incorporated therein for indicating a brand-name or trade-mark of the distributor or manufacturer. As shown in Figs. 1 and 3, a legend **26** may be embossed or otherwise imprinted in said tea-ball portion **20***a* which, as shown, occupies an unfilled corner of the tea-ball **20**, that is, said portion **20***a* adjacent the handle portion **24***b*, so that when the tea-ball **20** is lifted by the handle **24***c* the legend **26** may appear in an upright legible position in said corner **20***a*.

As shown in Fig. 1—A, handle **124***c* is made similar to the handle **24***c* above described by mak-

ing the through cut or split 124a except that it has an enlarged free end 124d formed from a portion of flange 23 upon which a legend 126 may be embossed or otherwise imprinted.

Tea-balls made with handle 24c or 124c when used to lift the tea-ball suspend the bag thereof as shown in Fig. 3, with corner 20b of the tea-ball 20 on the junction of the flange 23 and fold edge 22 positioned to control the drip from said corner 20b for returning the drip to the vessel or receptacle (not shown) in which the brew is being made in the well understood manner.

The heat sealing of the joint seams or flanges 23, 24 and 25 may be imposed with finely spaced crimps or flutings 27 upon said flanges. The ridges of the crimps 27 may extend longitudinally each flange, that is, parallel to the free edge thereof, as shown in Figs. 1 to 3, said crimps 27 being applied in the longitudinal direction of the flanges and particularly lengthwise each handle 24c or 124c, thereby providing a construction which tends to strengthen the structure thereof against tension strains and accidental tearing.

A modified construction of tea-ball embodying the invention is shown in Figs. 4 and 4—A at 30. The construction of tea-ball 30 is like tea-ball 20 but differs therefrom by providing a through split or cut 34a extending not only along the mid-portion of flange 34, but also part way along the mid-portion of the adjacent flange 35, preferably terminating at 35a the central portion thereof. A legend 36 may also be applied to legend portion 30a adjacent flange cut terminal 35a. By extending said cut 34a along flange 35 a longer handle 34c than handle 24c of tea-ball 20 is provided, as seen by comparing Fig. 3 with Fig. 4—A. Tea-ball 30 permits suspension thereof by handle 34c with the flange 33 extending horizontally, the legend 36 then being in an upright legible position.

Another modification of construction of tea-ball embodying the invention is shown at 40 in Figs. 5 and 5—A which is seen to include a displaceable U-shaped segment to provide bail handle 44c, said segment-handle 44c being formed by a continuous cut or split 44a successively through the mid-portions of flanges 43, 44 and 45, said split 44a having the ends 44d and 44e thereof terminating on flanges 43 and 45, respectively, just short of the edge fold 42. The segment-handle 44c or the latter with the adjoining portions of flanges 43, 44 and 45 may be utilized to carry an embossed or printed legend 46 thereof, if desired. The segment-handle 44c may be swung as a bail about cut ends 44d and 44e from the position shown in Fig. 5 to an effective position shown in Fig. 5—A for manipulating tea-ball 40 for brewing. The bag of tea-ball 40 with flanges 43, 44 and 45 may be constructed like the bag of tea-ball 20 with heat sealed flanges 23, 24 and 25.

A further modified construction of tea-ball embodying the invention is shown in Figs. 6 and 6—A at 50, and is seen to comprise in addition to heat-sealed border edge seams or flanges 53, 54, 55 and edge fold 52, a heat sealed transversing portion 57 extending through an unfilled section of the bag merging as a junction with two adjacent flanges 53 and 54. Said transversing portion 57 may have a suitable cut-out, such as triangular shaped opening 50a. Said opening 50a may be made by splitting through a mid-portion of flanges 53, 54 and transversing portion 57. Instead of cutting flange portions 53a and 54a to make said openings 50a entirely free, a very small length 50b of the perimeter is left attached to

triangular section 50c which may be folded back in use, as shown in Fig. 6—A. When the section 50c is retained a legend 56 may be embossed or printed thereon. In both forms above described the portions 53a and 54a of flanges 53 and 54, respectively, serve as a bail handle 54c for supporting the tea-ball 50 in the brewing operation.

It is to be understood that instead of making the tea-ball 50 square-shaped as shown in Figs. 6 and 6—A, it may be made of circular or oval contour as shown in Fig. 6—B at 150 with a continuous heat-sealed border edge seam 153, and the opening 150a corresponding to opening 50a may be made circular, sector-shaped or other configuration suitable to form an integral bail handle 154c of the original bag structure of such tea-ball 150.

Still another modification of the construction of tea-ball embodying the invention is shown at 60 in Figs. 7 and 7—A. Said tea-ball 60 may be like tea-ball 20 described above, except that there is provided a heat-sealed diagonally extending portion 67 which forms said tea-ball 60 into two triangular shaped tea containing sections 160 and 160a. Parallel spaced through-cuts or splits 67a along the middle of said portion 67 form segment 67c which is displaceable from the plane of said portion 67 to serve as a handle. An enlargement 67d provided at the free end of handle 67c may bear an embossed or printed legend 66. It will be noted, as seen from Fig. 7—A, that in lifting tea-ball 60 by the handle 67c, the weight of the tea in sections 160 and 160a causes said sections to fold on a line extending substantially along the cut-out portion 67e of tea-ball 60 which was formerly occupied by the handle 67c, thereby bringing said sections 160 and 160a more closely in face to face relation. This folding serves to reduce the effective width of said tea-ball 60, giving more clearance to tea-ball 60 in such folded condition when manipulated in and out of a tea-cup during the brewing operation.

Whereas tea-ball 60 is square-shaped, having straight flanges 63, 64 and 65 for forming triangularly-shaped sections 160 and 160a, it is to be understood that tea-balls may be similarly constructed of circular form having a closure border flange extending along the perimeter thereof, in which case a diametrical sealed-portion corresponding to the diagonal portion 67 of tea-ball 60 would divide such circular tea-ball into two semi-circular sections and said diametrical sealed-portion may be cut to form a handle which when lifted folds such semi-circular sections in the manner above described for tea-ball 60.

A still further modification embodying the invention is shown in Figs. 8, 8—A, 9 and 10 as tea-ball 70 which combines certain features of construction of tea-balls 40 and 60 already described or shown in Figs. 5 and 7. Tea-ball 70 has a bail-handle 74c similar to bail segment-handle 44c of tea-ball 40 with the addition of a mid-rib 74f formed by parallelly spaced through-cuts 77a and 77b on a central heat sealed seam joint portion 77 which divides the tea-ball 70 into two rectangular shaped sections 170 and 170a. The segment-handle 74c as shown in Fig. 8 is formed by two sets of continuous through-cuts 73a and 74a in flanges 73 and 74, respectively, joining with said through-cut 77b to form one set, the other set comprising cuts 75a and 74b in flanges 75 and 74, respectively, joining with cut 77a. Through-cuts 73a and 75a may have ends 74d and 74e terminating on flanges 73 and

75, respectively, just short of edge fold 72, while through-cuts 77a and 77b may have ends 77d and 77c, respectively, terminating just short of fold edge 72 in alignment with said through-cut ends 74d and 74e. The mid-rib 74f may be of sufficient width to permit bisection thereof lengthwise by a tear line formed of spaced through-cuts 77e so that tea-ball 70 may be divided into two tea-balls 170 and 170a, each with a bail handle similar to tea-ball 40, thus permitting the use of half the tea-ball 70 when a weak brew of tea is desired, as shown in Fig. 9. The tea-ball 70 may also be used, if desired, as shown in Fig. 10, without tearing apart sections 170 and 170a, in which case the tea-ball 70 may be folded along tear line 77e so that the sections 170 and 170a are brought in close proximity and in more compact form for brewing.

A modification embodying the invention in the form of tea-ball 80 is shown in Fig. 11. Tea-ball 80 has certain features of tea-balls 20 and 60 described above and shown in Figs. 1 and 7, respectively, but differing therefrom in that it has a diagonally extending sealed joint portion 87 formed with a tear line of spaced disconnected cuts 87d for dividing tea-ball 80 in two sections 180 and 180a. Integrally formed segment-handles 85c and 83c may be provided for tea-ball 80, each being similar to handle 24c of tea-ball 20 described above and shown in Figs. 1 to 3, by splitting through each mid-portion of flanges 83 and 85, respectively. The free end of said segment-handles 83c and 85c may be temporarily secured by ready tearable connections 83d and 85d, respectivelv, which may be severed when either of said handles 83c and 85c are displaced for use as desired.

By separating the section 180 from section 180a along the tear line of spaced cuts 87e, the halves of tea-ball 80, each with an integral handle, may be used for brewing tea at substantially half the strength, if desired. Said handles 83c and 85c alone or with the adjoining portion of flanges 83 and 85 from which said handles are formed may serve to carry embossed or imprinted legend 86.

Tea-ball 280, shown in Fig. 12, like tea-ball 60, has a handle 287c formed from a heat sealed diagonally extending portion 287. The handle 287c, however, may have the legend carrying end 287d extended to the edges of the adjacent border. There is also provided tear-line perforations 287e extending between the spaced through-splits 287a which form said handle 287c. Tea-ball 280 takes the position such as shown in Fig. 7—A for tea-ball 60 when used as a single package and can be sectionalized to provide two tea-balls each with a handle by tearing the sections apart along perforations 287c.

Still another and further modification in the form of the tea-ball 90 embodying the invention may comprise a circular-shaped structure as shown in Figs. 13 and 13—A, which is formed of superimposed layers of filter sheet material, such as used for tea-ball 20 above described, but having a circumferential heat sealed joint closure forming an integral marginal border or flange 94. A through-cut or split 94a through a mid-portion of said border flange 94 is extended from the perimeter thereof to a terminal end 94b to provide segment 94c. Said segment 94c when displaced from the position shown in Fig. 13 to that shown in Fig. 13—A forms a handle. An unfilled portion 90a adjacent to the cut end 94b

may serve as a legend carrier embossed or printed with legend 96.

It is clear from Figs. 14 and 14—A that circular shaped tea-ball 190 there shown may be provided with circular through-cut 194a extended centrally through the flange 194 and terminate at 194b and 194f in a mid-portion thereof instead of extending to the perimeter as is the case in forming handle 94c of tea-ball 90. This cut 194a forms an annulus 194c which when displaced out of the plane of said flange 194 will serve as a bail-handle which alone or with the adjoining portion of flange 194c may serve to carry a legend 196.

In the above described tea-ball constructions and all modifications embodying the invention, the flange closures or sealed joints thereof after being cut through or split to form segment-handles leave such closures or joints of sufficient width and strength to positively retain the essence product T sealed therein for the brewing operation.

It is to be understood that the tear-proof means of tea-ball 20, such as, the curved extension 24b of the cut 24a beyond the length of the segment-handle 24c, may be used in conjunction with any of the through-cuts or splits in the border flanges of any of the other modifications wherever desired. Other means for accomplishing like results may also be employed, as for example, through perforations terminating such cuts or splits.

It will be noted that tea-balls 40, 50, 60, 70 and 190 may be readily used with a stirrer in brewing beverages and the like, such tea-balls being attached by their bail-handles to the end of the stirrer in the well understood manner. Inexpensive forms of detachable stirrers may be supplied with tea-balls as a premium or as part of an advertisement therefor.

It is thus seen, therefore, that there is provided an improved method of operation and articles in which the objects of the invention are achieved and which are well adapted to meet all conditions of practical use.

As various possible embodiments may be made in the above invention for use for different purposes and as various changes might be made in the embodiments and method above set forth, it is understood that all of the above matters here set forth or shown in the accompanying drawings are to be interpreted as illustrative and not in a limiting sense.

Having thus described my invention, I claim as new and desire to secure by Letters Patent:

1. In a method of making an infusion bag package formed with a closure portion, the steps of heat sealing a marginal area of said closure portion to form a border flange, through-splitting a substantial continuous length of said flange short of complete severance while retaining said sealed closure intact to provide an integral handle when only a portion thereof is displaced from the plane of said flange for suspending said package by said handle in manipulating said package during brewing.

2. The method defined in claim 1 in which said step of through-splitting is continued beyond a length necessary to form the segment-handle to a cut termination for eliminating accidental tearing and stabilizing the suspension of the bag by said handle.

3. The method of manufacturing an infusion package of the character described including the steps of enclosing an essence containing product

in a filter sheet material to form a package with a seam joint closure, and constructing solely from an integral portion of said seam joint closure a dependent elongated handle as and for the purpose described and specified.

4. The method of making an infusion bag package defined in claim 3 including the step of crimping the seam joint closure including the handle forming portion with the ridges produced thereby extending longitudinally said closure and handle to strengthen the structure against tension strains and accidental tearing.

5. A method of manufacturing infusion packages of the character described including the steps of enclosing an essence containing product in a filter sheet material to form a package with a sealed joint seam closure flange, and through-cutting a mid-portion of the flange wholly within the border of the flange to provide an integral bail-handle segment for suspending the package by said bail-handle segment in manipulating the package during brewing while retaining the sealing of the joint seam closure flange intact.

6. A method of manufacturing infusion packages of the character described including the steps of enclosing an essence containing product in a filter sheet material to form a package with a sealed joint seam closure flange extending more than half way about the periphery of the package, through-cutting a mid-portion of the flange wholly within the border of the flange to provide an integral bail-handle segment displaceable from the plane of said flange for suspending the package by said bail-handle segment in manipulating the package during brewing while retaining the sealing of the joint seam closure flange intact, and shaping the ends at the through-cutting to provide terminals for eliminating accidental tearing of the bail-handle segment from the package.

7. The method of manufacturing an infusion package of the character described including the steps of sectionalizing an essence containing product in a filter sheet material bag, sealing the sections along a border flange to form a seam joint, constructing solely from an integral portion of the seam joint a dependent handle, and weakening a mid-portion of said seam along a line for folding said sections toward each other when suspending the package by the handle during brewing.

8. The method defined in claim 7 in which the step of weakening a mid-portion of said seam includes perforating said line to provide tearing means for separating the sections for independent use.

9. An infusion package of the character described comprising a filled bag having a seam joint closure, and a dependent handle transformed solely from a portion of said closure structure one end of the handle integrally connected with said structure and other portions thereof being displaceable out of the plane of said structure for suspending the package by said handle.

10. An infusion package of the character described comprising a filter sheet material bag filled with an essence containing product, a marginal area of said bag having a sealed joint seam closure forming an edge border, a portion of said border adjacent the edge having a through-cut short of complete severance from another portion thereof adjacent the product enclosed in the bag, the latter portion having sufficient structure to retain said closure sealed, said edge adjacent

portion having at least one end thereof continuous with the said other portion and forming a segment-handle to serve as a sole suspension means during a brewing operation.

11. An infusion package of the character described comprising a filter sheet material bag filled with an essence containing product, a sealing closure extending along at least an edge portion of said bag to form a marginal joint seam border, said closure border having a through-cut of sufficient length therein for forming an elongated segment displaceable out of the plane of said border to serve as a handle, uncut portions of said border joining the segment-handle to the bag having a cross-section structure of sufficient tensile strength for withstanding strains due to immersion and manipulation of the package during brewing with the bag suspended by said segment-handle.

12. An infusion package defined in claim 11 having said through-cut terminating with means for "tear-proofing" the segment handle to serve as an effective means for preventing accidental tearing of the material as described and specified.

13. An infusion package defined in claim 11 having crimps formed with ridges extending longitudinal said closure border and handle for strengthening the latter against tension strain.

14. An infusion package of the character described comprising a filter sheet material bag filled with an essence containing product, a sealing closure extending along at least an edge portion of said bag to form a joint seam border flange, said flange having a through-cut extending along a mid-portion thereof wholly within the border of the flange to form an integral bail-handle segment of the flange portion between the through-cut and the adjacent edge of the package for suspending the package during the brewing operation.

15. A package of the character described comprising two layers of filter sheet material with an essence containing product interposed and sealed therebetween, a median joint seam dividing said package into a plurality of product containing sections, said median joint seam having a through-cut short of complete severance to form an integral handle, and a weakened portion extending along said mid-portion between said sections for folding the latter toward one another when suspending the package by the handle during brewing.

16. The package defined in claim 15 in which said weakened portion has spaced perforations to form tearing means for separating the sections for independent use.

17. An infusion package of the character described comprising two superimposed layers of filter sheet material with an essence containing product interposed therebetween, marginal areas of said layers secured together to form a joint seam border sealing said product between said layers, said sealing border being split through a mid-portion thereof for a sufficient length short of complete severance to provide a handle integrally attached to said border to form the sole suspension support for the package in brewing.

18. The method defined in claim 1 in which said step of through-splitting is continued inwardly the edge of the flange to form a "tear-proof" termination end and to provide stabilization to the bag suspension by the handle.

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