

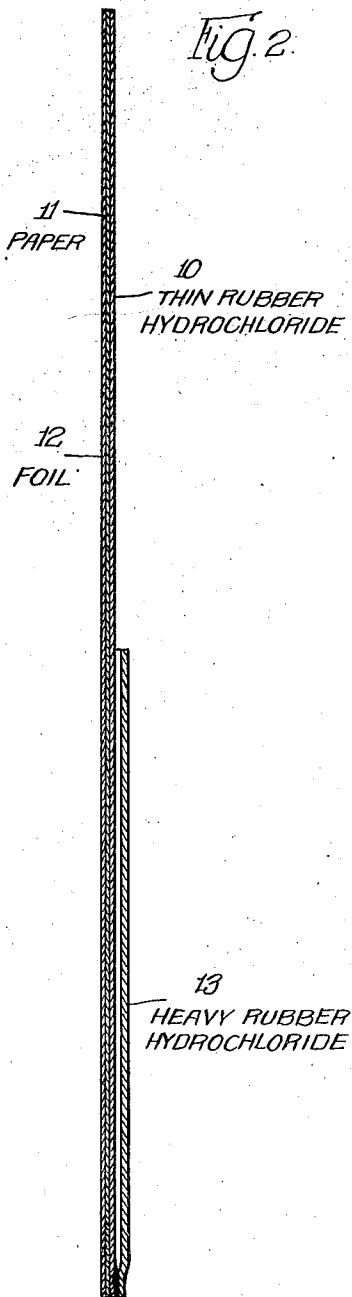
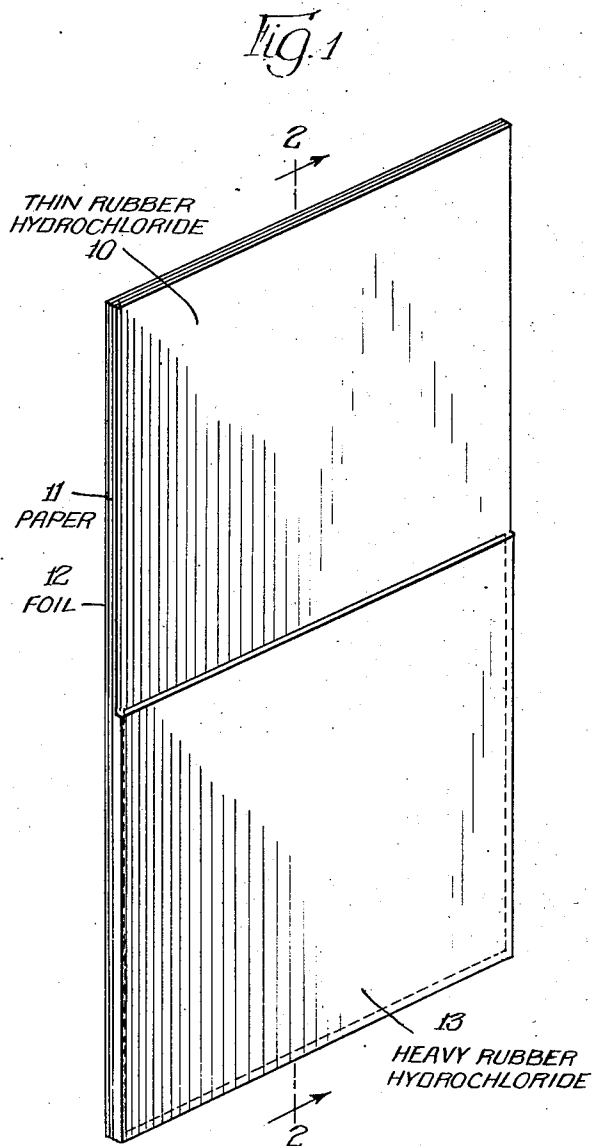
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TOBACCO POUCH AND METHOD OF MAKING SAME

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TOBACCO POUCH AND METHOD OF MAKING
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7 Claims. (Cl. 93—35)

This invention relates to an improved type of tobacco package and to the method by which the package is formed.

Within recent years considerable effort has been expended in development of packages for tobacco, these efforts being occasioned by the desire of the industry to improve upon the tin containers normally employed. Various types of paper, rubber and other materials have been employed in producing pouches, but none of these pouches has met with very extensive commercial success, due to such factors as expense of manufacture and failure to provide adequate preservation of the tobacco.

A principal object of the present invention is the production of a tobacco pouch which is economical of manufacture and which has the characteristic of maintaining the tobacco in substantially the same condition in which it is initially packed for extensive periods of time.

Another object of the invention is to provide a tobacco package in which transparent halogenated rubber material such as rubber hydrochloride is employed to produce a pouch having a patch type pocket and being backed by paper or paper and foil.

Still another object of the invention is to provide a tobacco package in which a relatively thin, transparent rubber hydrochloride backing sheet has thermoplastically joined to it a smaller patch portion of relatively heavy transparent rubber hydrochloride, the backing sheet being supported by a laminated paper or other type of material which will add strength and folding qualities to the container.

These and other objects will be observed upon a consideration of the following specification and by reference to the accompanying drawing, in which

Fig. 1 is a perspective view of a pouch formed in accordance with the invention; and

Fig. 2 is a sectional view taken along line 2—2 of Fig. 1.

In the production of the improved tobacco pouch an initial step consists in the lamination of a thin sheet 10 of transparent rubber hydrochloride to a sheet 11 which preferably is composed of paper or fabric material. In producing this lamination it is possible to use various types of adhesives, but ordinarily it will be preferred to utilize an adhesive having a rubber base. A number of such adhesives are available.

After lamination of the relatively thin film of transparent rubber hydrochloride to the web of paper it then is desirable to laminate the outer

face of the paper to a web of foil indicated at 12. Again, it is possible to use various types of adhesives for producing the adhesion between the paper and foil, these adhesives being well known in the art. The outer face of the foil 12 may be provided with any desired type of printing. It also is desirable to print in reverse the under side of the sheet 10 prior to laminating it to the paper. This printing may include advertising matter or the like.

The composite web formed by the lamination of the sheet of thin transparent rubber hydrochloride to the paper and the lamination of foil to the opposite side of the paper is cut into pouch blanks, and there is subsequently secured to the inner face of the sheet 10 a patch type of pocket indicated at 13 in the drawing. This relatively small sheet constituting the pocket portion of the package consists of a sheet of transparent rubber hydrochloride which preferably is of greater thickness than the sheet 10 to which it is attached.

In producing the completed pouch, blanks of the laminated sheets are brought into registration with the relatively small sheets 13 so that the lower edges of the latter register with the lower edges of the thin rubber hydrochloride sheet 10. The adjacent edges of the thin rubber hydrochloride and the relatively heavy rubber hydrochloride sheets then are brought into contact with a hot plate which produces a thermoplastic bond between the two sheets of rubber hydrochloride to complete the formation of the pouch. The temperature of the plate and the time of the contact with the edges of the materials to be joined may vary considerably, it being sufficient to produce an edge heating effect that causes the two films of rubber hydrochloride to become integral. A bond of this type may extend inwardly a distance comparable to the thickness of one of the films, so that the pocket formed by the union of the two materials utilizes substantially the entire space between the transverse edges thereof.

The height of the sheet 13 will determine the capacity of the pouch and the lip portion formed by the extension of the laminated sheets is sufficiently long to enable the extension to be folded over against the sheet 13. The extension of the laminated material may be greater than the height of the sheet 13 so that it may be folded completely around the sheet 13 and in overlapped relation with respect to the back of the laminated material.

After completion of the formation of the pack-

age, tobacco is loaded in the pocket between the sheets 13 and 10 and the mouth of the package may be raised to a temperature which renders the material slightly tacky to produce a moisture-
 5 proof bond therebetween sufficiently strong to preserve the moist condition of the tobacco. In effecting the seal between the sheets 13 and 10 it is preferred that a stack of these blanks be thermoplastically sealed together at their edges in a
 10 unitary operation. In such an operation a hot plate is brought adjacent the edges of a plurality of the pouches so as to distribute the heating operation throughout the stack.

The patch type of pocket provided by the sheet 15 13 makes a highly desirable tobacco pouch. The pouch is inexpensive and it is not necessary to use but a small portion of the relatively heavy rubber hydrochloride. The pouch has a relatively large capacity for tobacco, due to the type of seal
 20 effected between the sheets 13 and 10 and is sufficiently durable to withstand normal use without being broken apart.

Various changes may be made in the container and its method of manufacture without departing
 25 from the scope of the invention as defined in the appended claims. For instance, the strength-imparting sheets laminated to the relatively thin sheet 10 may be other than described. If desired, a material such as transparent cellulose
 30 sheeting may be substituted for the foil. In some cases it will be desirable to omit the foil. Fabric may be substituted for the paper sheet, or natural or artificial leather may be employed as the strength-imparting backing member.

35 I claim:

1. The method of forming a tobacco pouch, which comprises laminating a sheet of transparent rubber hydrochloride to a supporting sheet, and thermoplastically patching three edges of a
 40 smaller sheet of unlaminated rubber hydrochloride to one end of said first named sheet of rubber hydrochloride.

2. The method of forming a tobacco pouch, which comprises laminating a sheet of transpar-

ent rubber hydrochloride to one side of a sheet of paper, laminating the opposite side of said sheet of paper to a layer of metallic foil, and thermoplastically uniting to three edges of said sheet of rubber hydrochloride a pocket-forming, relatively
 5 small sheet of unlaminated rubber hydrochloride.

3. The method of forming a tobacco pouch, which comprises laminating a relatively thin sheet of transparent rubber hydrochloride to one side of a sheet of paper, positioning on said sheet
 10 of rubber hydrochloride a smaller sheet of relatively heavy unlaminated rubber hydrochloride having three edges adjacent three edges of said first named sheet of rubber hydrochloride, and bringing the adjacent edges of rubber hydrochloride
 15 adjacent a heating element to produce a thermoplastic bond therebetween.

4. The method of forming a tobacco pouch, which comprises laminating a sheet of rubber hydrochloride to a supporting sheet, and welding
 20 onto said sheet of rubber hydrochloride a pouch-forming portion consisting of a relatively small sheet of rubber hydrochloride.

5. A tobacco pouch, comprising a relatively thin sheet of rubber hydrochloride, a sheet of paper
 25 laminated to one side of said sheet of rubber hydrochloride, and a patch pocket of rubber hydrochloride integrally joined to three edges of said first named sheet of rubber hydrochloride.

6. A tobacco pouch, comprising a laminated
 30 backing member composed of an outer sheet of foil, an intermediate sheet of paper, and an inner sheet of relatively thin rubber hydrochloride, said backing member being integrally joined at one end to a pouch-forming smaller sheet of
 35 relatively heavy rubber hydrochloride.

7. A tobacco pouch, comprising a laminated backing member composed of paper and a sheet of relatively thin rubber hydrochloride, and a
 40 pouch-forming section of relatively heavy rubber hydrochloride integrally bonded to three edges of the backing member.

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