United States Patent [19]

Herbener

[11] **3,757,840**

[45] **Sept. 11, 1973**

[54] **BILLFOLDER AND METHOD OF MAKING**

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[21] Appl. No.: **231,655**

[52] **U.S. Cl.** **150/35,** 156/217

[51] **Int. Cl.** **B65d 1/06**

[58] **Field of Search** 150/35, 37; 156/217

[56] **References Cited**

UNITED STATES PATENTS

3,151,651 10/1964 Herbener 150/35

Primary Examiner—Donald F. Norton

Attorney—B. P. Fishburne, Jr.

[57] **ABSTRACT**

A billfolder is constructed from a single pair of blanks formed of woven fabric coated on opposite sides with heat sealable plastic. The various layers or panels of the billfolder are held in assembled relationship by an absolute minimum number of heat seals or "welds," thus minimizing the tendency of the heat sealing operations to stretch and deform the material. Because of a small number of heat seals, a number of the billfolder panels may slide or float relative to one another during usage to preclude wrinkling and to enable the billfolder to adjust to the variable thickness of the contents. The parts of the billfolder requiring the greatest strength are formed with multiple layers of the material and all wear edges and exterior edges are folded and rounded as distinguished from raw cut edges. The billfolder is characterized by compactness with maximum carrying capacity for a variety of articles. It is highly economical in construction and resembles fine leather in appearance and feel.

13 Claims, 26 Drawing Figures

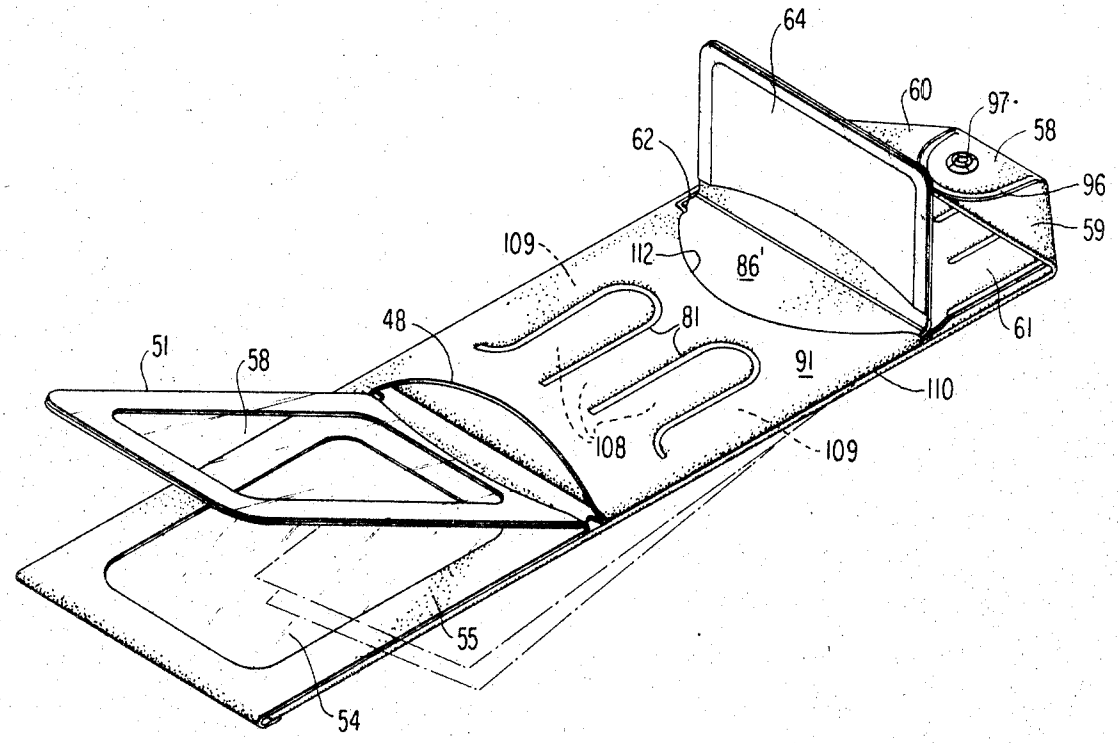
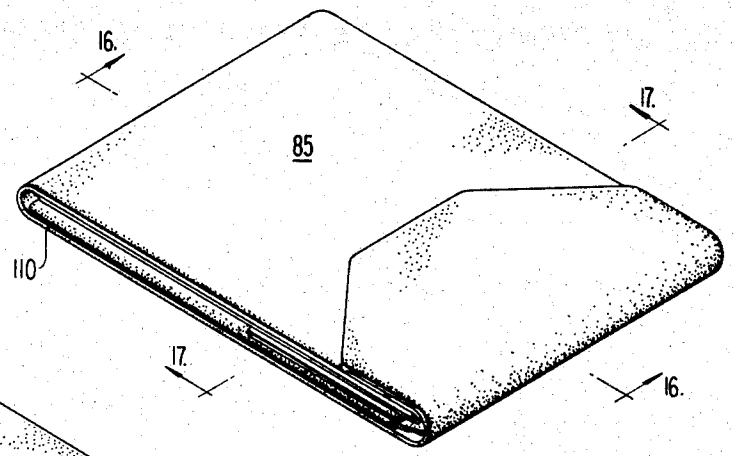


FIG.1



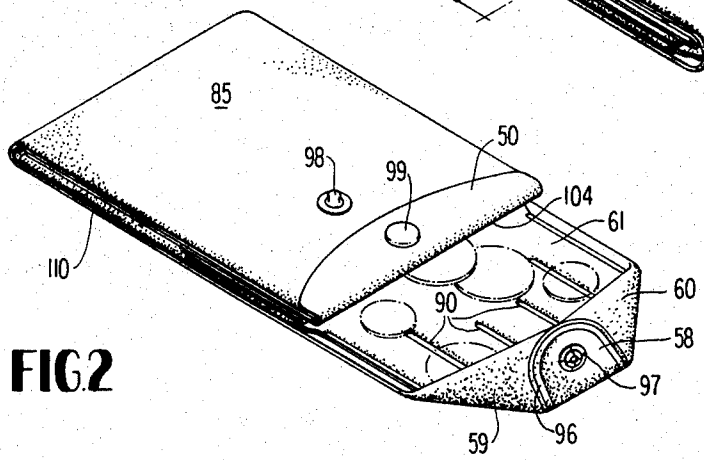


FIG.2

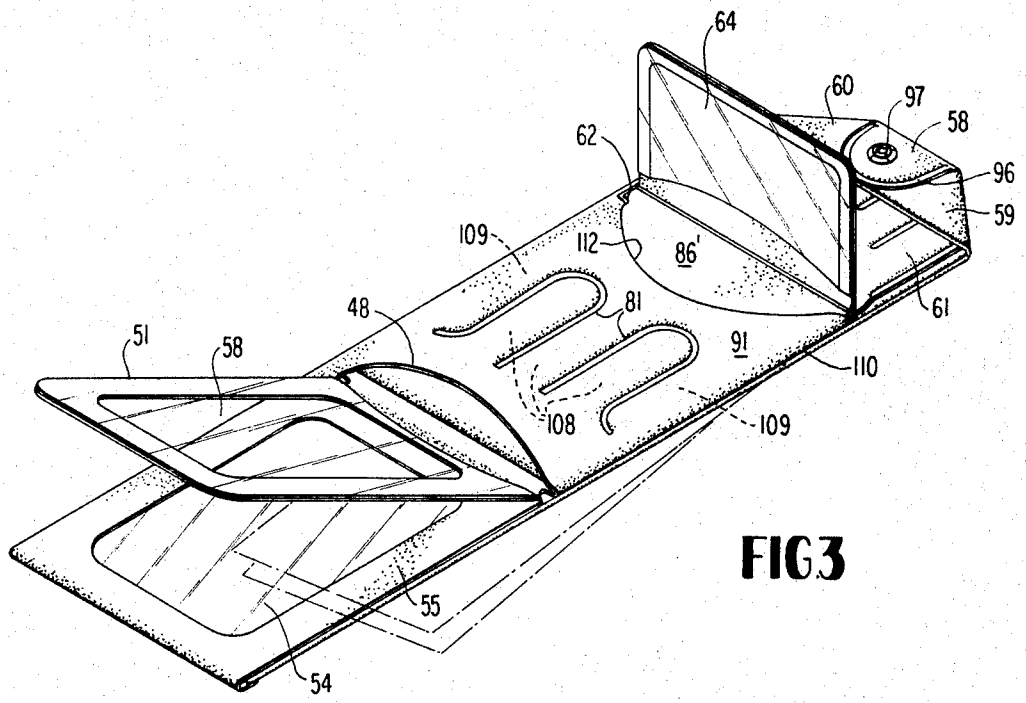


FIG.3

FIG.4

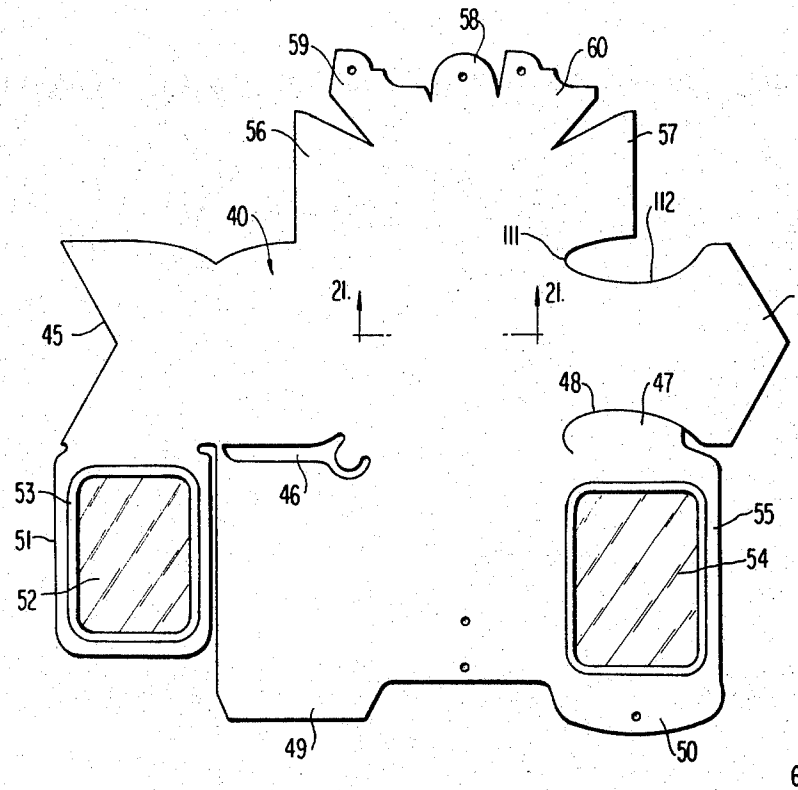


FIG.5

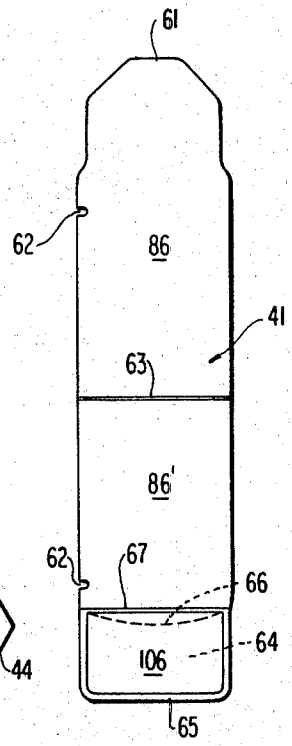


FIG.6

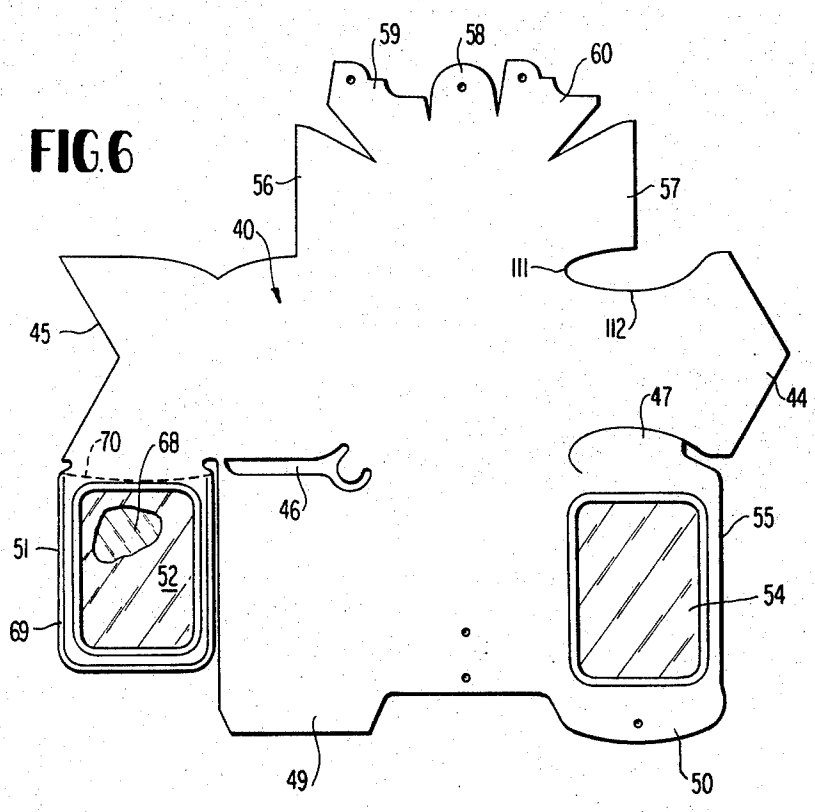
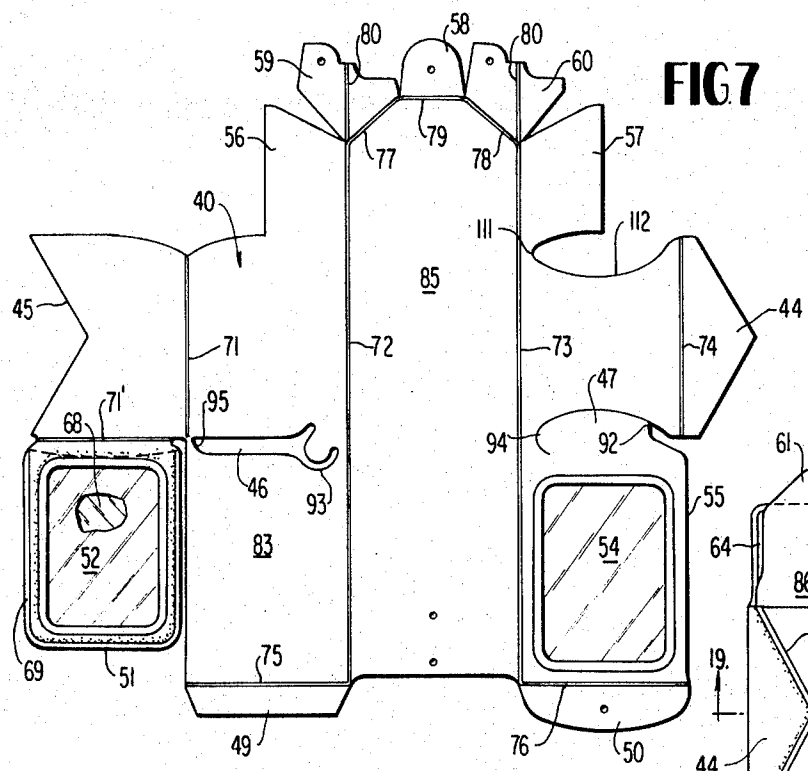


FIG.7



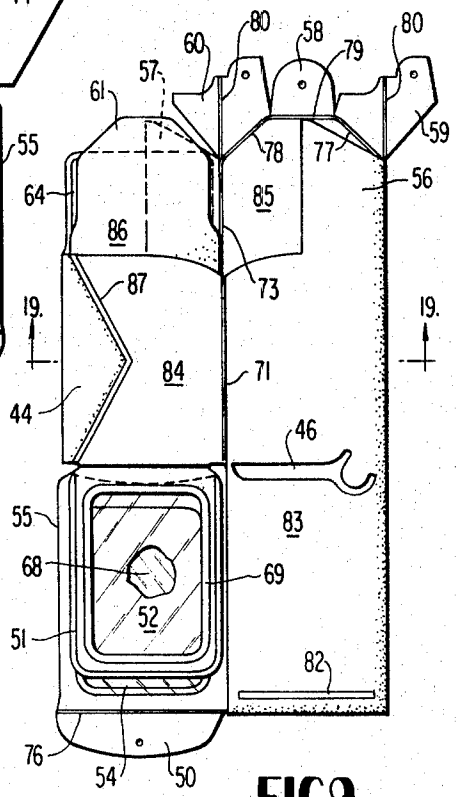


FIG.9

FIG.8

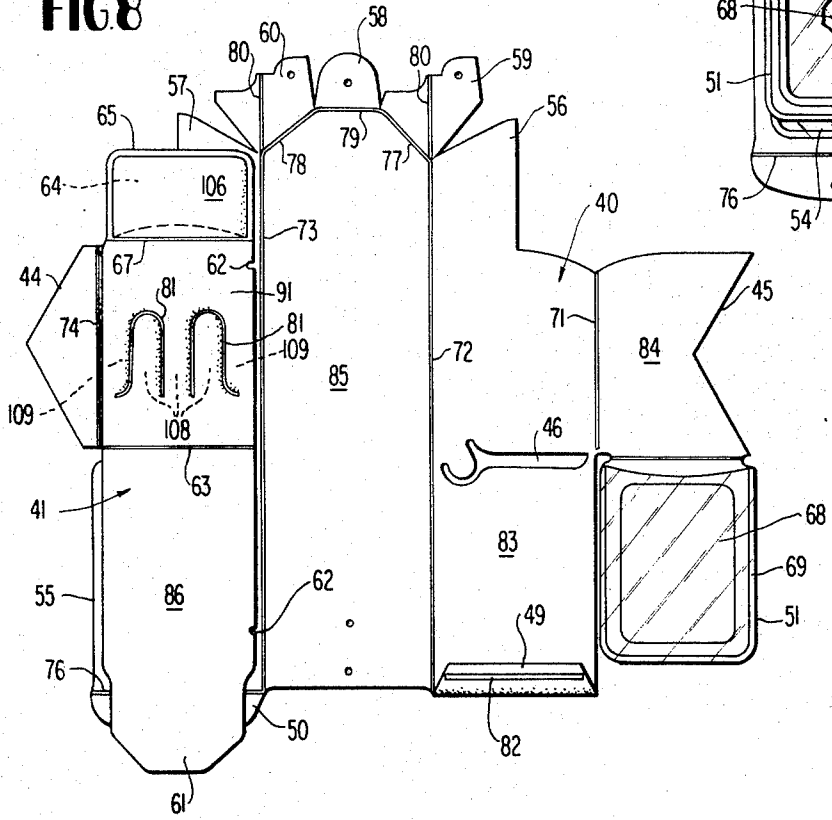


FIG.10

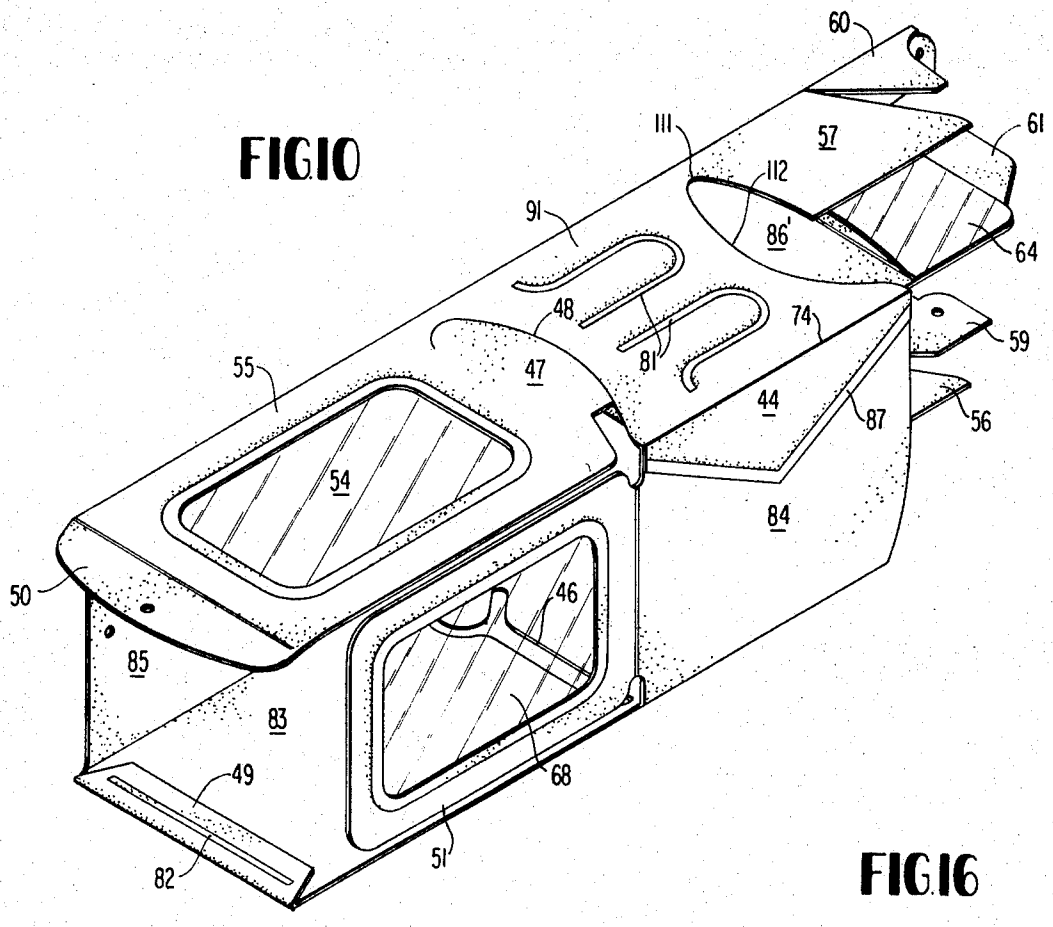
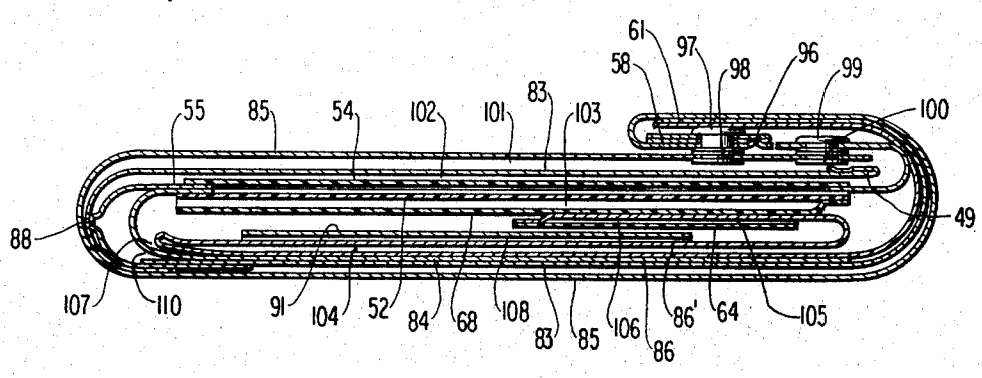


FIG.16



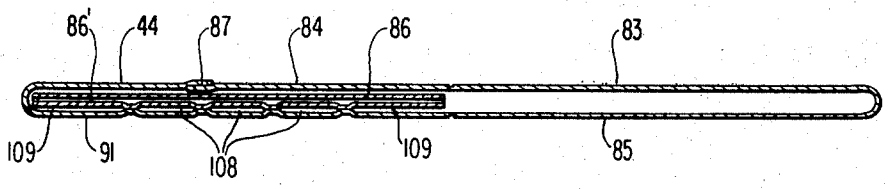


FIG.19

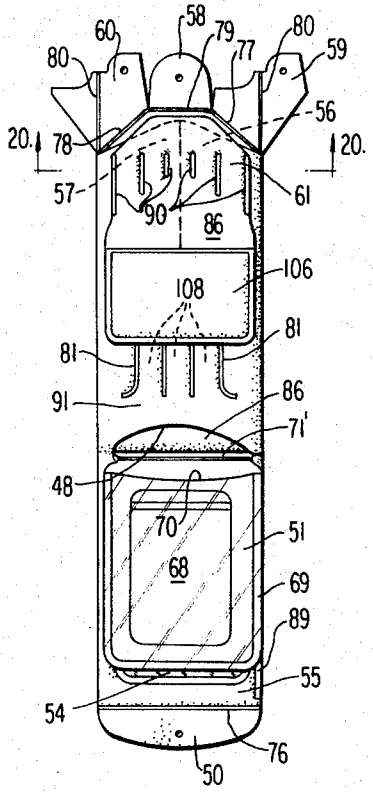


FIG.11

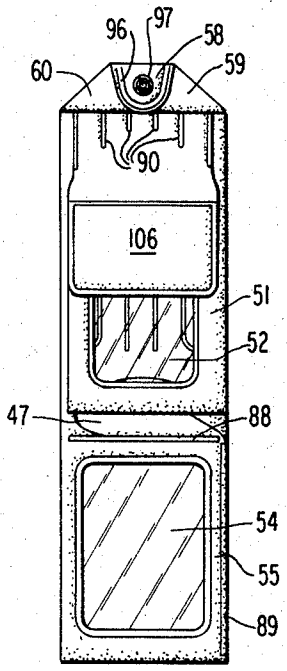


FIG.15

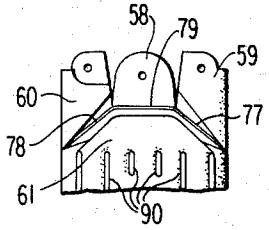


FIG.12

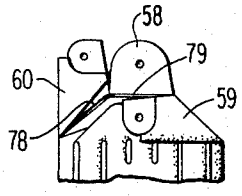


FIG.13

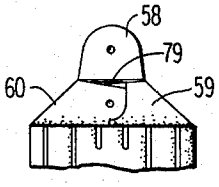


FIG.14

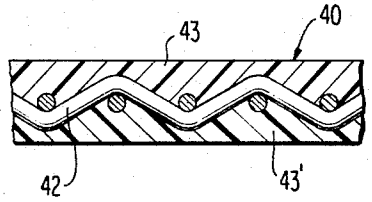


FIG.21

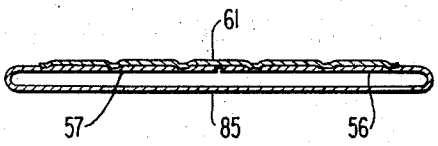


FIG.20

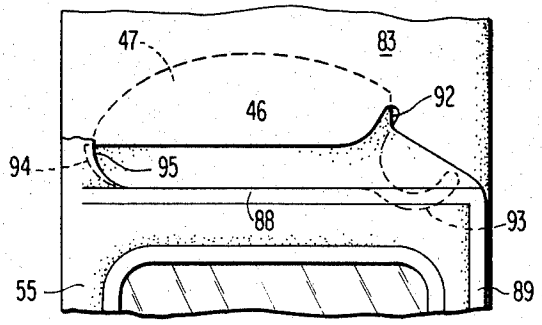


FIG.22

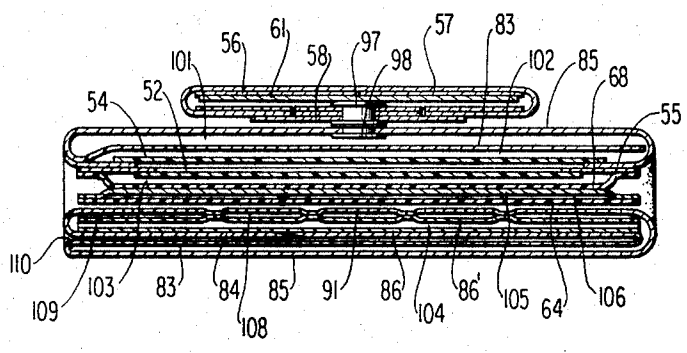


FIG.17

FIG.18

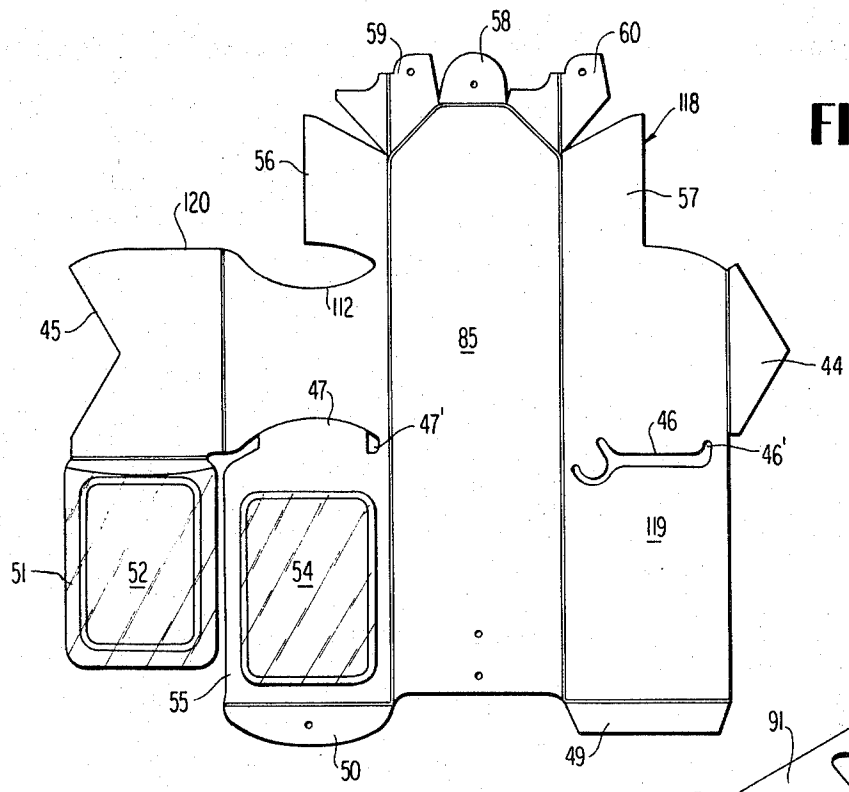


FIG.23

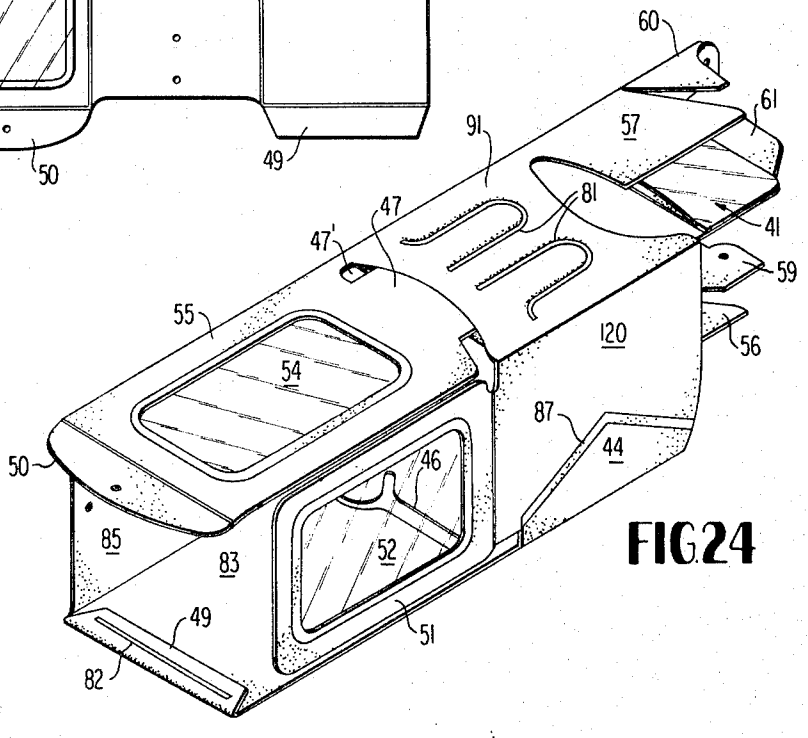


FIG.24

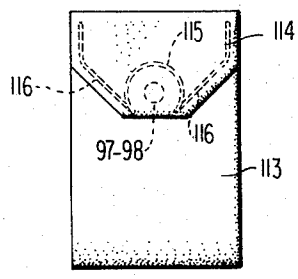


FIG.26

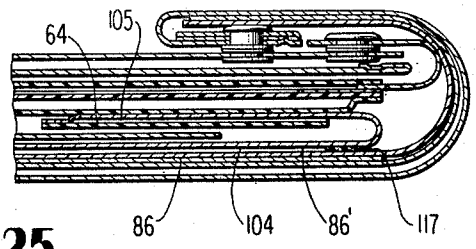


FIG.25

BILLFOLDER AND METHOD OF MAKING

BACKGROUND OF THE INVENTION

The objective of the present invention is to improve upon and simplify the constructions for billfolders shown in prior U.S. Pat. Nos. 2,589,546; 2,863,484; 2,863,485; 2,863,486 and 3,151,651, all issued to Henry M. Herbener. In the first of the above-noted patents, the billfolder is constructed of leather and the various sections thereof are secured together by lines of stitching. Certain other Herbener patents prior to U.S. Pat. No. 2,589,546 also disclose broadly similar billfolders fabricated from leather. Such billfolders, while being of excellent quality, are necessarily expensive due to the materials and labor involved.

In the three later patents noted above, the billfolders are constructed entirely of flexible thermoplastic sheet material with the different sections of the product joined by heat seals or welds. These prior patented structures, while highly economical to manufacture and closely resembling the genuine leather product in appearance and feel, have the inherent disadvantage of tending to crack and tear particularly in regions of repeated bending after long usage.

The construction in U.S. Pat. No. 3,151,651 sought to overcome this lack of durability in the all-plastic billfolders by the use of a woven fabric blank or body coated on one side with heat sealable plastic. In the resulting product, the visible exterior surfaces of the billfolder were substantially all plastic coated and the uncoated fabric surfaces were to a great extent concealed. A difficulty with the billfolder produced according to U.S. Pat. No. 3,151,651 was that a separate piece of thermoplastic material had to be employed between any adjacent uncoated fabric surfaces which were required to be joined since no stitching was employed. This presented some rather difficult and costly manufacturing steps and mainly for this reason the billfolder construction according to U.S. Pat. No. 3,151,651 has not proven to be the complete or final answer in the production of an inexpensive and durable billfolder of the class in question having physical characteristics closely resembling genuine leather billfolders of the prior art.

According to the present invention, it is believed that the above final answer in terms of a completely satisfactory economical billfolder possessing the physical qualities of a fine leather billfolder has been realized. Additionally, the construction of the basic billfolder blank or body portion and the method of folding and joining the various panels together in the final product has been simplified to such an extent that only a very few heat seals or welds need to be utilized. This, in turn, minimizes the stretching and distortion of the basic material and enables certain panels or walls of the billfolder to float and adjust automatically to different thicknesses in the contents of the billfolder pockets and compartments. Most importantly, the use of fabric coated on both sides with vinyl resin or another suitable thermoplastic greatly simplifies the fabrication of the product in comparison to the structure of U.S. Pat. No. 3,151,651 and entirely eliminates the need for separate pieces of thermoplastic formerly required to join uncoated fabric surfaces.

Additional important improvements and advantages of the present structure over the prior art will appear as the detailed description proceeds.

BRIEF DESCRIPTION OF DRAWING FIGURES

FIG. 1 is a perspective view of a finished billfolder embodying the invention in a completely closed condition.

FIG. 2 is a perspective view of the billfolder with the coin cup released and extended for use.

FIG. 3 is a further perspective view of the billfolder in a full open position to illustrate the various components thereof.

FIG. 4 is a plan view of a basic blank employed for the body portion of the billfolder.

FIG. 5 is a plan view of an auxiliary blank later to be joined to the main blank in the construction of the billfolder.

FIG. 6 is a further plan view of the main blank showing a first step in the fabrication of the billfolder.

FIG. 7 is a further plan view of the main blank showing the provision of permanent folding creases produced therein by heat sealing means.

FIG. 8 is another plan view of the main blank looking at the reverse side thereof and showing the step of attaching the auxiliary blank thereto with heat seals that also form key pockets.

FIG. 9 is a further plan view showing a folding operation on the main and auxiliary blanks and the joining by heat sealing of interfitting extensions on opposite sides of the main blank.

FIG. 10 is a perspective view of the partially completed billfolder in the stage illustrated by FIG. 9 but with the parts opened up into rectangular tubular formation.

FIG. 11 is an additional plan view showing additional folding and heat sealing steps.

FIGS. 12, 13 and 14 are fragmentary plan views depicting additional folding steps in the formation of a multilayer coin cup.

FIG. 15 is a plan view showing the final folding step and final heat sealing of the coin cup.

FIG. 16 is an enlarged longitudinal vertical section taken on line 16—16 of FIG. 1.

FIG. 17 is an enlarged transverse vertical section taken on line 17—17 of FIG. 1.

FIG. 18 is an enlarged central vertical section through the billfolder in the plane of FIG. 16 with the billfolder opened and the components thereof unfolded.

FIG. 19 is an enlarged transverse vertical section taken on line 19—19 of FIG. 9.

FIG. 20 is an enlarged transverse vertical section taken on line 20—20 of FIG. 11.

FIG. 21 is an enlarged fragmentary vertical section through the coated blank taken on line 21—21 of FIG. 4.

FIG. 22 is a fragmentary plan view of the interior surface of the billfolder with the partition broken away and showing a self-adjusting hinge tongue to facilitate folding the billfolder without wrinkling or buckling.

FIG. 23 is a plan view of a slightly modified form of main blank.

FIG. 24 is a perspective view of a partially completed billfolder made from the main blank in FIG. 23 with the auxiliary blank in FIG. 5.

FIG. 25 is a fragmentary vertical section similar to FIG. 16 showing a modification in the form of a stop element for coins at the mouth of the billfolder coin pocket.

FIG. 26 is a fragmentary plan view of the billfolder in the closed condition on a reduced scale showing a spring wire insert for the coin cup.

DETAILED DESCRIPTION

In the following description, the heat sealing or "welding" operations may be performed with the high frequency die means disclosed in U.S. Pat. No. 2,631,646 or by equivalent conventional means.

Referring to the drawings in detail, wherein like numerals designate like parts throughout, and referring first to FIGS. 4 and 5, the numerals 40 and 41 designate main and auxiliary blanks, respectively, employed in the construction of the billfolder shown in completed form in FIGS. 1–3 and FIG. 15. The material employed in the blanks 40 and 41 comprises woven fabric 42, see FIG. 21, coated on opposite sides with thermoplastic, such as a vinyl resin, as indicated at 43 and 43'. The coating 43 on the top of the blank 40 in FIG. 4 to produce the visible exterior surfaces of the completed billfolder is opaque and colored in any desired manner. The coating 43' on the bottom of the blank 40 may be clear or transparent or, if preferred, may be the same as the coating 43. In either case, the fabric body or reinforcement 42 is totally encased in thermoplastic so that the resulting flexible composite sheet may have its various layers formed by folding heat sealed or welded to adjacent layers in the necessary manner to construct the billfolder and without the necessity of using separate pieces of thermoplastic between layers to produce adhesion. The coated sheet material employed for the blanks 40 and 41 is soft and pliable and closely resembles fine leather in texture, feel and appearance.

The two blanks 40 and 41 are initially produced from rectangular sheets of the required size. As shown in FIG. 4, the blank 40 is cut to provide on opposite sides a tapered tongue 44 to be subsequently joined with the edges of a V-shaped notch 45 formed in the opposite side of the blank. A slot 46 and a coacting tongue 47 produced by the curved cut 48 serve an important function in the assembled billfolder, to be fully described. Flaps 49 and 50 are formed on the lower edge of the blank 40 as well as an integral generally rectangular hinged extension 51 to subsequently form one side wall of a transparent pocket for identification cards and the like. The extension 51 is shown already equipped with a transparent window insert 52 of thermoplastic sheet vinyl or the like heat sealed at 53 around its margin to the extension 51, in registry with a preformed opening in the extension. A similar transparent window insert 54 is mounted in the blank 40 in its opposite corner section 55 for the subsequent formation of an additional billfolder pocket having one transparent side wall. At the top of the blank 40, side tabs 56 and 57 are produced on the blank 40 along with center and divergent flaps 58, 59 and 60, to be subsequently employed in the formation of a reinforced coin cup or receptacle on one end of the finished billfolder.

The auxiliary blank 41 is initially formed with a tapered tongue 61 of somewhat reduced width at one end thereof and a pair of small notches 62 in one longitudinal edge for a purpose to be described. A permanent transverse crease or folding line 63 is produced in the auxiliary blank by the same heat sealing die means employed to weld or seal various parts of the billfolder together. A transparent panel 64 is mounted on the underside of the auxiliary blank 41 and sealed thereto around three sides at 65 so as to form a small pocket for postage stamps and the like having an open mouth 66 where the transparent panel 64 is unattached to the auxiliary blank. Another transverse crease or folding line 67 is formed across the blank 41 at the top of the transparent panel 64 in parallel relation to the crease 63, the latter being located approximately at the center of the elongated blank 41. When the blank 41 is folded in two on the crease 63, the two small notches 62 will move into registration for a purpose to be described.

Referring to FIG. 6 showing a preliminary step in the formation of the billfolder, an additional transparent thermoplastic panel or wall 68 is mounted on the underside of the rectangular extension 51 and heat sealed thereto around three sides by a continuous heat sealing line 69. The upper transverse preferably curved edge 70 of the transparent wall 68 remains unattached to the extension 51 so as to form the open mouth of a pocket having two transparent side walls of windows.

Referring to FIG. 7, the next step in the formation of the billfolder comprises producing in the main blank 40 the additional permanent creases or folding lines required to fold the blank into its component parts for constructing the billfolder. More particularly, spaced parallel creases 71, 72, 73 and 74 are formed in the bank 40 longitudinally by the heat sealing die means and transverse creases 71', 75 and 76 are formed near the lower edge of the blank to facilitate folding the flaps 49 and 50. Diagonal creases 77 and 78 are produced at the bases of the flaps 59 and 60 along with a transverse crease 79 and the base of the flap 58. Longitudinal extensions 80 of the creases 72 and 73 facilitate folding of the flaps 59 and 60 in the formation of the coin cup, to be described.

Referring to FIG. 8 and immediately following the formation of the various permanent folding creases in the blank 40, the auxiliary blank 41 is now attached permanently to the main blank 40 by a single pair of generally U-shaped welding or heat sealing lines 81. FIG. 8 shows the main blank 40 inverted from its position in the previous figures and the auxiliary blank 41 is reversed end-for-end from its position of FIG. 5. The auxiliary blank is placed flat and longitudinally upon the portion 55 of the main blank and the portion immediately inwardly of the tongue 44 between the creases 73 and 74, prior to the formation of the permanent sealing lines 81. The small postage stamp pocket now overlies the flap 57 and the tongue 61 overlies the lower flap 50. The creases 67 and 63 are in alignment with the two side edges of the tapered tongue 44. Additionally, flap 49 is now folded on the crease 75 and heat sealed at 82 to the adjacent panel 83 margined by the crease 72, slot 46 and pocket extension 51. The auxiliary blank 41 is unattached except at the two sealing lines 81.

FIG. 9 depicts the next stage in completing the billfolder. In this figure, the lower panel 86 of the auxiliary blank 41, FIG. 8, is folded upwardly on the transverse crease 63 so as to overlie the sealing lines 81 and stamp pocket 64. Next, the main blank 40 is folded longitudinally on the crease 72 so that the panel 84 adjacent the notch 45 and the depending transparent pocket extension 51 will overlie the panel 86 and the extension 55. At the same time, the panel 83 having the slot 46 and the tab 56 will be caused to overlie the center long panel 85 in FIG. 9. The tab 57 continues to underlie the stamp pocket 64 and the flaps 59, 60 and 58 remain flat

or unfolded at this time. The longitudinal crease 71 is now in registry with the underlying crease 73. With the parts so arranged in FIG. 9, the tapered tongue 44 is folded on the crease 74 into registry with the notch 45 and is joined along the margin of this notch by a sturdy sealing line 87. At this time, the previously-folded flap 49 lies between the panels 83 and 85 but is sealed only to the panel 83 to produce a reinforcement and a folded edge on the lower edge of this panel.

At this stage of completion shown in FIG. 9, the billfolder has become a unit and can be opened up into a rectangular tubular form, as shown in FIG. 10, and can be placed over a rectangular cross section form or block for smoothing of various components if desired.

Proceeding from FIG. 9 to FIG. 11, the extension or panel 55 with window 54 and flap 50 is now folded on crease 73 so as to overlie panel 83. These parts are now permanently joined by sealing lines 88 and 89 best visible in FIG. 15. The transparent pocket extension 51 is overlying and partially concealing the extension 55 and window 54 in FIG. 11. The sealing lines 88 and 89 serve to complete one of two pockets in the main body of the billfolder remote from the coin cup and these two pockets have their mouths simultaneously closed by the flap 50, as will be further described. Further in connection with FIG. 11, after the folding and sealing of the extension 55, the structure is further folded longitudinally on the registering creases 71 and 73 to cause panel 84, tongue 61 and pocket extension 51 to lie upon the panel 83 and flap 56. The flap 57 at this time is also folded over into side-by-side abutting relation with the flap 56 to form a complete reinforcing wall between the tongue 61 and the exterior wall of the coin cup formed by the end portion of panel 85. At this time, the tongue 61 and the two folded flaps 56 and 57 are permanently joined by relative short parallel longitudinal lines of welding 90, FIG. 11. These welding or sealing lines being spaced and longitudinal do not interfere with the manual squeezing of the coin cup at its sides to open the same for the reception of coins, as depicted in FIG. 2. At this stage of completion, FIG. 11, the sealing lines 90 cause the billfolder to be permanently folded in the narrow elongated form shown, whereby the elements 51 and 91 form an inner partition in the billfolder when the same is folded transversely into the closed form shown in FIG. 1. At this time, the tongue 47 may be introduced into the slot 46 in the manner clearly shown in enlarged FIG. 22 to form a mechanical sliding and self-adjusting connection between the panels 83 and 55 at the critical point where transverse folding of the completed billfolder takes place. The shoulder 92 of tongue 47 is caused to interlock securely but adjustably with the arcuate extension 93 of the slot 46 so that the parts will not readily separate. A similar interlocking action between the rounded end 94 of the tongue 47 and the curved end 95 of slot 46 takes place. In practice, this sliding and self-adjusting connection is positioned slightly above the point where the billfolder is repeatedly folded transversely in the middle of its length, and the adjustable connection prevents wrinkling and buckling in this critical region which, in turn, lessens wear and improves the appearance of the product. No heat sealing whatsoever is employed at this point of mechanical connection between the tongue 47 and slot 46.

The final steps in completing the billfolder are shown in FIGS. 12 through 15. Referring to FIG. 12, the side flaps 59 and 60 are first folded longitudinally on the creases 80. Following this, in FIGS. 13 and 14, first the flap 59 and then the flap 60 are folded diagonally on the creases 77 and 78 and finally, in FIG. 15, the center flap 58 is folded down onto the folded flaps 59 and 60 and secured thereto by an essentially U-shaped heat sealing line 96. A snap fastener element 97 is applied to the center of the triple thickness cup wall formed by the three folded flaps and this element coacts with a mating snap fastener element 98 on the exterior of panel 85 or body portion of the bill-folder near one end thereof. By this means, the billfolder is held in the completely closed condition shown in FIG. 1 and in cross sectional FIG. 16. Another two-part snap fastener 99–100 is provided for maintaining the closure flap 50 closed across the mouths of the two pockets or compartments 101 and 102 formed in the body portion adjacent the transparent window 54.

FIGS. 1–3 and cross sectional FIGS. 16, 17 and 18 show the completed billfolder in closed and opened conditions. The various pockets and compartments of the billfolder may readily be identified in these views with reference to additional numerals as follows. In addition to the previously-noted longitudinal pockets 101 and 102 in the billfolder body portion formed by panels 85, 83 and 55, there is a single pocket 103 formed by the transparent panels or windows 52 and 68 in the partition extension 51. This pocket 103 opens longitudinally from the center of the billfolder toward the end thereof remote from the coin cup.

A pocket 104 for coins exists between the two folded walls of what was the auxiliary blank 41, namely the panels 86 and 86′, see FIGS. 5 and 18. As previously noted, a small pocket 105 for stamps is formed between the transparent wall 64 and the adjacent flap 106 foldable on the crease 67. A secret pocket for cards or other items shown at 107 exists between the panel 86 and the adjacent wall or panel 84 of the billfolder partition. This pocket opens at the center of the billfolder in opposed relation to the pocket 103.

The previously-noted sealing or welding lines 81 between panels 91 and 86′ form oppositely longitudinally opening pockets 108 for keys or the like including two outside pockets 109 which will accommodate a key or a nail file.

A main longitudinal compartment 110 for bills exists between the interior panel 83 of the body portion and the partition panel 84. This bill compartment extends for the major portion of the length of the billfolder inwardly of the coin cup.

An additional improvement feature in the instant billfolder resides in the previously-noted notches 62 of the auxiliary blank 41 which coincide or register when the auxiliary blank is folded to produce the panels 86 and 86′. The registering notches 62 are shown in FIG. 3 where they interlock with the abruptly curved end 111 of a recess or cut-out 112 in the main blank 40. This interlocking of the folded auxiliary blank with the main blank in the completed billfolder stabilizes the construction and aids in preventing undesirable wrinkling or buckling in this region. It may be noted in FIG. 3, for example, that the curved edges 112 and 48 at the opposite ends of the panel 91 form the entranceway to the pockets 108 and 109.

The mode of use and the versatility of the billfolder for carrying various items including bills and coins is amply described in prior U.S. Pat. Nos. 2,863,845;

2,863,846; 3,151,651 and others, and therefore need not be repeated herein.

FIG. **26** shows an additional improvement or modification which is optional in the completed billfolder described in connection with FIGS. **1** through **22.** The same completed billfolder illustrated in FIGS. **1–3** is shown in the closed position in FIG. **26** with the folded body portion indicated by the numeral **113** and the closure flap also forming the coin dispensing cup indicated by the numeral **114.** Within the coin cup proper is mounted a light tension wire spring having a central circular portion **115** and divergent spring arms **116** which lie in a separate plane from the circular portion when the spring is relaxed or free of tension. The circular portion **115** may be disposed between the folded flaps or layers **58–59–60** which form the wall of the coin cup and the snap fastener **97–98** will aid in anchoring the circular portion **115.** The spring arms **116** lie within the margins of the cup, as shown. When the coin cup **114** is opened to a use position, such as indicated in FIG. **2,** the spring, composed of the elements lying in two planes, will cause automatic opening of the coin cup so that the coins sliding out of the coin pocket **104** will be properly captured. The use of the spring tends to eliminate the need for the user to squeeze the side edges of the cup to cause opening thereof, as described in said prior patents. Instead, the spring serves to automatically open the cup. When the billfolder is closed as in FIG. **1** with the snap fastener **97–98** engaged, the spring yields readily and the circular loop portion **115** moves into the same plane occupied by the arms **116.**

FIG. **25** shows a further improvement in the billfolder which is applicable to the invention in FIGS. **1** through **22.** As shown in this figure, at the mouth of the coin storage pocket **104** between the panels **86** and **86'**, a stop element **117** in the form of a foam plastic strip or the like is provided. This strip of stop element extends across the mouth of the coin pocket **104** and is secured in any suitable manner to the adjacent panel **86'** as by adhesive means. The strip **117** is readily bendable to allow proper dispensing of coins from the pocket **104** into the previously-described coin cup. However, when the billfolder including the pocket **104** is in the normal flat condition, the strip or stop element **117** will prevent coins from sliding prematurely toward or into the coin cup.

A modification of the invention as described in FIGS. **1** through **22** is shown in FIGS. **23** and **24.** This modification or improvement is largely to improve the appearance of the product as regards the location of the elements **44** and **87** as they appear in FIG. **10** or whenever the bill storage compartment is exposed to view by lifting the partition away from the main body of the billfolder made up by the walls **83, 85** and **55.** Referring to FIGS. **23** and **24,** a modified main blank **118** is utilized in conjunction with the same auxiliary blank **41** shown in FIG. **5.** The modified main blank utilizes the identical central elongated panel **85** shown in FIGS. **7** and **8** but comparing FIGS. **7** and **23** it may be observed that the panel **119** containing slot **46** and corresponding to the panel **83** in FIG. **7** now lies on the opposite side of the central panel **85** and carries the tapered tongue **44.** In a like manner, the panel or extension **55** carrying flap **50,** tongue **47** and window **54** is reversed from its position in FIG. **7** and now lies on the opposite side of the panel **85.** The extension **120** having the V-notch **45** is also reversed laterally from the position shown in FIG. **7** along with the transparent pocket extension **51.** Consequently, when the blank **118** is processed with the auxiliary blank **41** to produce the tubular formation shown in FIG. **24** and corresponding to FIG. **10,** it will be observed that the tongue **44** now heat sealed at **87** to the panel **120** in FIG. **24** is reversed from the arrangement of the elements **44, 87** and **84** in FIG. **10.**

A further modification of the blank and the billfolder in FIGS. **23** and **24** resides in the provision of a notch **46'** at the outer end of slit **46** and an additional cutting of material from one side of the tongue **47,** as shown at **47',** to form a square shoulder and partially eliminate the rounded end **94** of the tongue **47** depicted in FIG. **22.** When the parts are assembled in the final formation of the billfolder, the above construction or changes allows the tongue **47** to move upwardly approximately one-eighth inch in the longitudinal body portion of the billfolder. This, in turn, allows the lower left hand corner of the billfolder, as depicted in FIG. **26** for example, to curve properly without buckling and this has the effect of greatly reducing wear at this particular location, thereby appreciably lengthening the life of the entire billfolder. Throughout the improved billfolder, all similarly interlocking parts have been positioned with care so that all corners are smoothly curved in the interest of increased wear. All interlocking components have been positioned slightly away from the points of folding in order to obtain the above desirable results.

In other respects, the billfolder structure remains the same as for the prior embodiment, and corresponding numerals are used to designate like elements in the prior embodiment.

As a result of relocating the tongue **44** and sealing line **87,** these parts are virtually concealed from view in the finished product, even when the partition is separated from the body portion of the billfolder to fully open the bill compartment.

It is to be understood that the forms of the invention herewith shown and described are to be taken as preferred examples of the same, and that various changes in the shape, size and arrangement of parts may be resorted to, without departing from the spirit of the invention or scope of the subjoined claims.

I claim:

1. A billfolder comprising a folded body portion and an attached partition hinged to the body portion at one longitudinal edge of the latter, said body portion and partition formed from initially flat blank means and said blank means formed of fabric coated on opposite sides with thermoplastic material, whereby adjacent wall faces of the billfolder body portion and partition may be permanently heat sealed in assembled relationship to produce storage compartments and a coin cup on the billfolder without the necessity for separately formed adhesive material.

2. A method of producing a billfolder from a pair of initially flat fabric blanks coated on opposite sides thereof with thermoplastic material, said method comprising the steps of arranging said blanks in superposed relation and heat sealing local surfaces thereof along narrow lines only to permanently join said blanks, folding the permanently joined blanks and permanently joining by heat sealing interfitting opposite side portions on one blank to form a tubular structure for the partially completed billfolder, folding said tubular structure into a substantially finished billfolder form

and permanently joining by additional heat sealing localized portions of said blanks to thereby produce a flexible coin cup at one end of the billfolder body portion.

3. In a billfolder, a coin storage pocket, and a flexible coin dispensing cup hingedly secured to one end of the billfolder and forming a closure element for the coin storage pocket when the billfolder is in a folded closed condition, said cup extendable longitudinally of the billfolder to a use position in advance of the mouth of the coin storage pocket, said extended coin cup tending to assume a flat configuration until opened by manual pressure on the opposite side edges thereof, the improvement comprising a spring element inserted into the coin cup and having parts lying in two divergent planes whereby the spring element serves automatically to open the cup for the reception of coins from said storage pocket when the cup is extended to said use position, the spring element yielding and lying in a single plane with the cup when the cup is shifted to a closed position with relation to the billfolder and said coin storage pocket and is secured in such closed position, the coin cup then returning to a normal substantially flat condition.

4. The structure of claim 3, and a flexible stop element disposed at the mouth of the coin storage pocket and serving to close said mouth and prevent premature discharge of coins from said pocket prior to opening said mouth with manual pressure on the opposite sides of the billfolder.

5. The structure of claim 4, and said stop element comprsing a rubber-like strip extending across the mouth of said coin storage pocket and adhered to one side wall of said pocket, said strip yielding to allow normal opening of the mouth of said pocket when coins are to be dispensed therefrom.

6. In a billfolder, a main blank formed of fabric and having a thermoplastic coating on both opposite sides thereof permitting direct heat sealing of various portions of the blank with other portions, the main blank having folding lines dividing the main blank into panels facilitating the formation of the finished billfolder, and an auxiliary blank formed of fabric and being coated on both opposite sides with thermoplastic, whereby the auxiliary blank is directly heat sealable to the main blank at one localized area, the auxiliary blank having folding lines to facilitate folding the auxiliary blank with portions of the main blank in the formation of a billfolder partition.

7. A billfolder comprising an elongated body portion defining one side wall of a flexible compartment for paper bills and being foldable transversely substantially at the longitudinal center of the body portion, said body portion having two thicknesses of flexible sheet material throughout its length and a third thickness of said material being mounted upon approximately one-half of the interior side of the body portion and forming one wall of a longitudinal pocket in the body portion, means forming an elongated flexible partition on the billfolder in superposed relation with the body portion and being foldable transversely with the body portion when the billfolder is closed, means forming a flexible coin cup on corresponding ends of the body portion and partition and said last-named means serving to join the body portion and partition adjacent one end of the partition, the partition also being hinged along one longitudinal edge to the corresponding edge of the body portion, and interlocking sliding tongue and slot connection means on the interior wall of the body portion immediately above the transverse folding line of the body portion and partition and serving to prevent buckling and wrinkling of the body portion when the billfolder is folded.

8. The structure of claim 7, and expansion spring means carried by the flexible coin cup and operable to expand the cup to a coin receiving configuration when the cup is in an extended use position relative to the body portion and partition, and engageable fastener means on the coin cup and body portion for securing the coin cup in a closed position folded around the body portion and partition, said expansion spring being then held in a substantially flattened condition within the folded and secured coin cup.

9. A main blank for use in constructing a billfolder said blank being formed of flexible fabric coated on both sides with flexible thermoplastic, said blank having permanent creases formed therein by heated die means to facilitate folding of the blank into the configuration of a billfolder embodying compartments for bills, cards, coins and keys, and interfitting projection means carried by the opposite sides of the blank and movable into registration when the blank is folded into a rectangular tubular form, and a heat seal permanently joining the interfitting projection means along their registering edges.

10. The structure of claim 9, and said interfitting projection means comprising a tapered tongue on one side of the blank projecting outwardly of such side, and a V-shaped notch in the opposite side edge of the blank extending inwardly of such side edge, the centers of said notch and tongue being in alignment across the blank to facilitate registration when the blank is folded into said tubular form.

11. The structure of claim 9, and said tapered tongue and V-shaped notch being so arranged on the main blank that upon completion of the billfolder the tongue and notch are disposed deeply in the bill compartment close to the main longitudinal folding line of the partition and billfolder body portion so as to be substantially concealed from view.

12. The structure of claim 9, and said main blank having a mechanically interlocking tongue and slot on spaced lateral portions thereof prior to folding the main blank, said tongue entering the slot in interlocking self-adjusting relationship therewith in the completed billfolder to facilitate folding the billfolder transversely without wrinkling or buckling.

13. The structure of claim 12, and said slot having a short notch extension at its outer end and said tongue being recessed at a corresponding location on the tongue to allow the tongue to move upwardly longitudinally in the completed billfolder sufficiently to avoid the point of maximum bending in the transverse folding of the billfolder thus assuring smooth rounded corners on the billfolder at the point of main transverse folding.

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