



US 20080008406A1

(19) **United States**(12) **Patent Application Publication****Russell et al.**(10) **Pub. No.: US 2008/0008406 A1**(43) **Pub. Date: Jan. 10, 2008**(54) **POUCHES HAVING RECLOSABLE POUR SPOUT IN SIDE GUSSET**(52) **U.S. Cl. 383/63; 383/120; 383/906; 383/64; 383/61.2; 383/203; 383/207**(76) **Inventors: Glyn Russell, New City, NY (US); Leslie A. Wilson, Schnecksville, PA (US)**

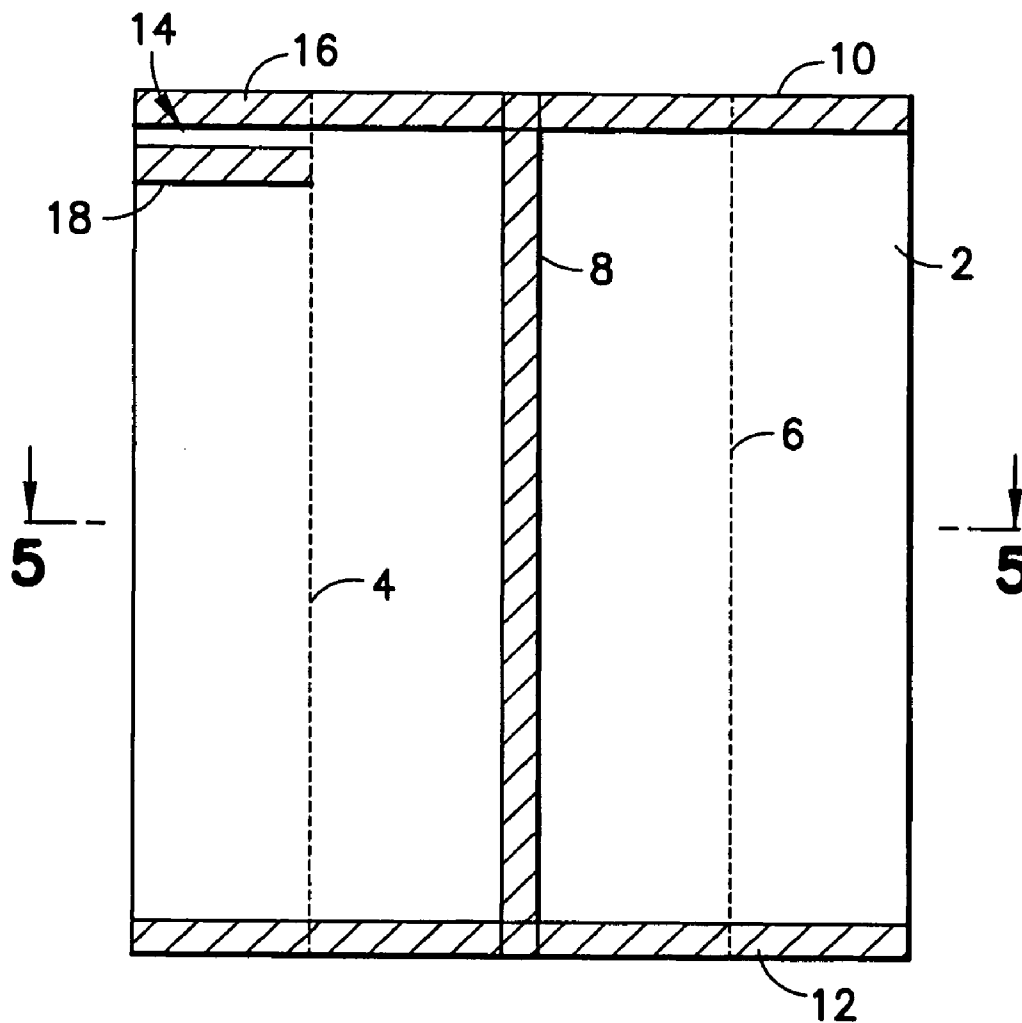
Correspondence Address:
Dennis M. Flaherty, Esq.
Ostrager Chong Flaherty & Broitman P.C.
570 Lexington Avenue
New York, NY 10022-6894

(21) **Appl. No.: 11/482,620**(22) **Filed: Jul. 7, 2006****Publication Classification**

(51) **Int. Cl.**
B65D 33/16 (2006.01)
B65D 30/20 (2006.01)
B65D 33/00 (2006.01)

(57) **ABSTRACT**

A package comprising: a gusseted tube of film sealed at a top and a bottom thereof by top and bottom cross seals respectively, the bottom seal extending the full width of the package and the top seal extending along a major portion of the package width. The gusseted tube comprises a side gusset extending from the top to the bottom of the tube, wherein the side gusset and the top seal do not overlap. The package further comprises a flexible zipper comprising a first zipper strip joined to a portion of and extending across the width of the side gusset, and a second zipper strip joined to portions of the tube. After the zipper is opened, an upper portion of the side gusset to which the zipper is attached can be inverted to form a pour spout.



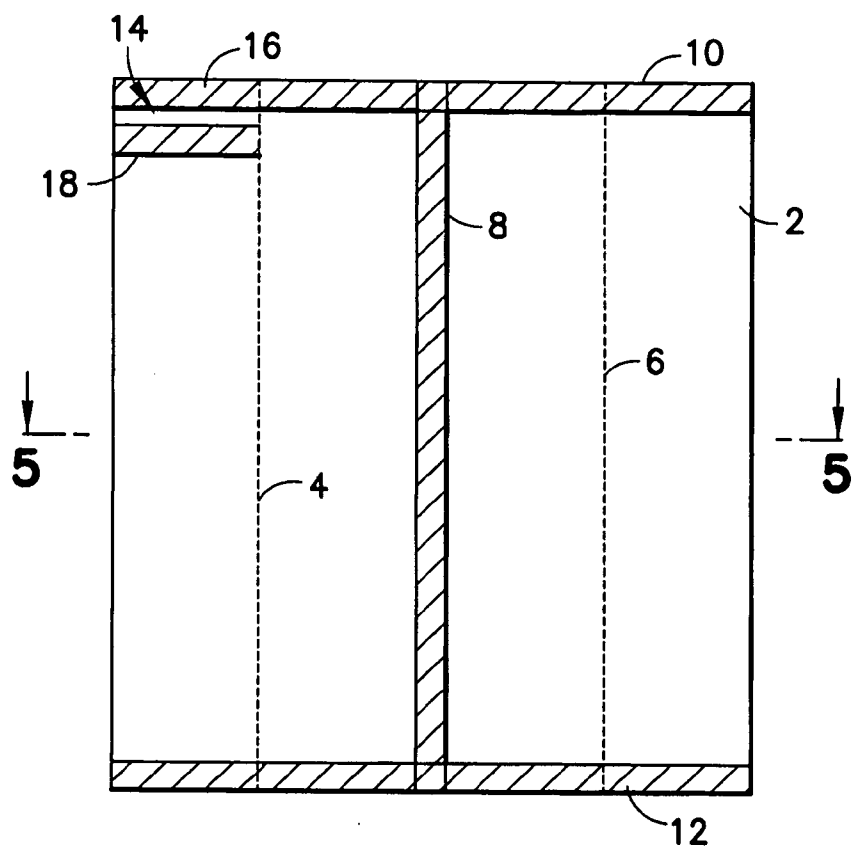


FIG. 1

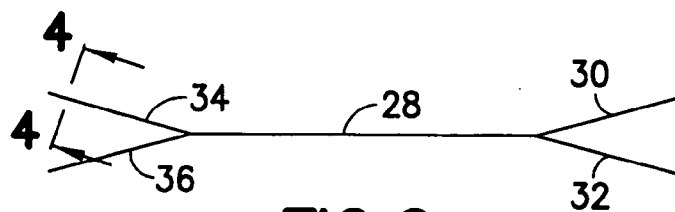


FIG. 2

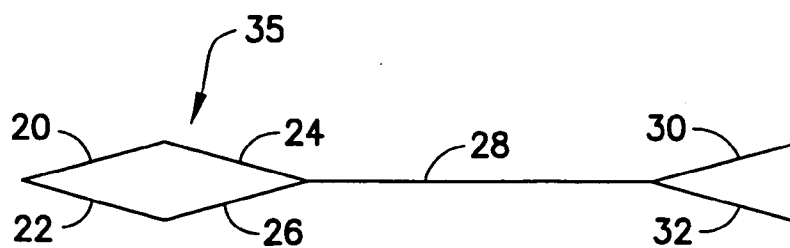


FIG. 3

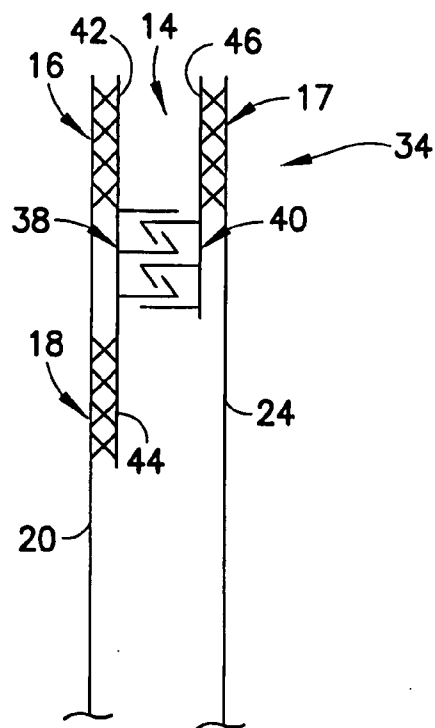


FIG. 4

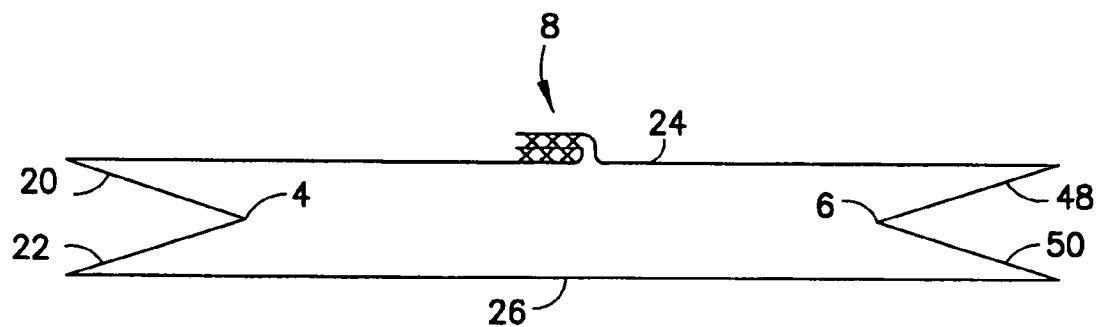


FIG. 5

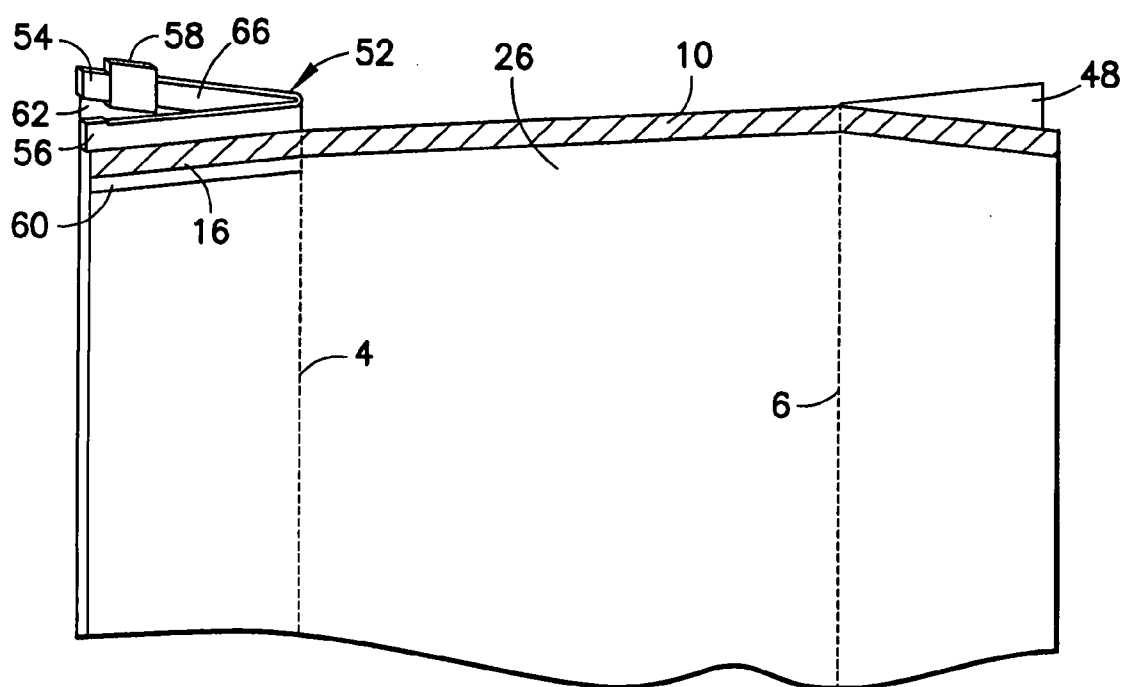


FIG.6

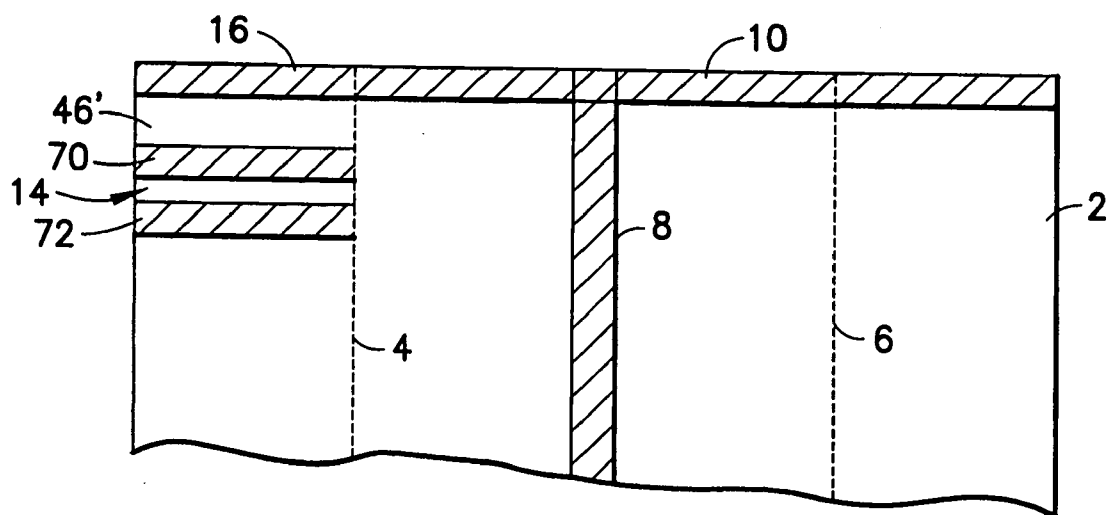


FIG. 7

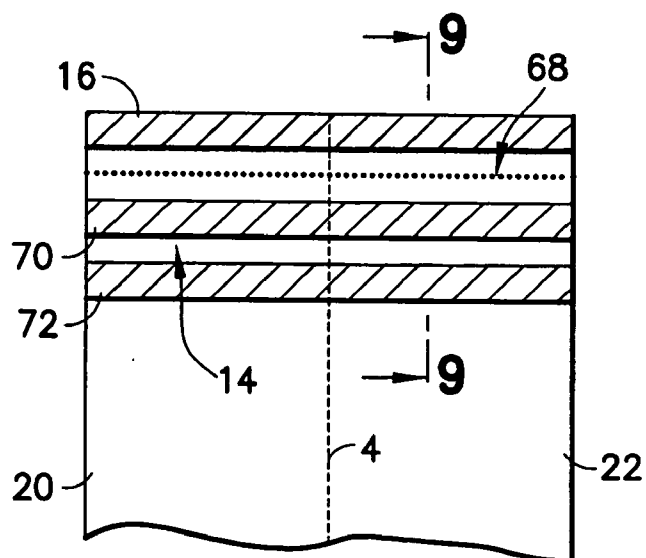


FIG. 8

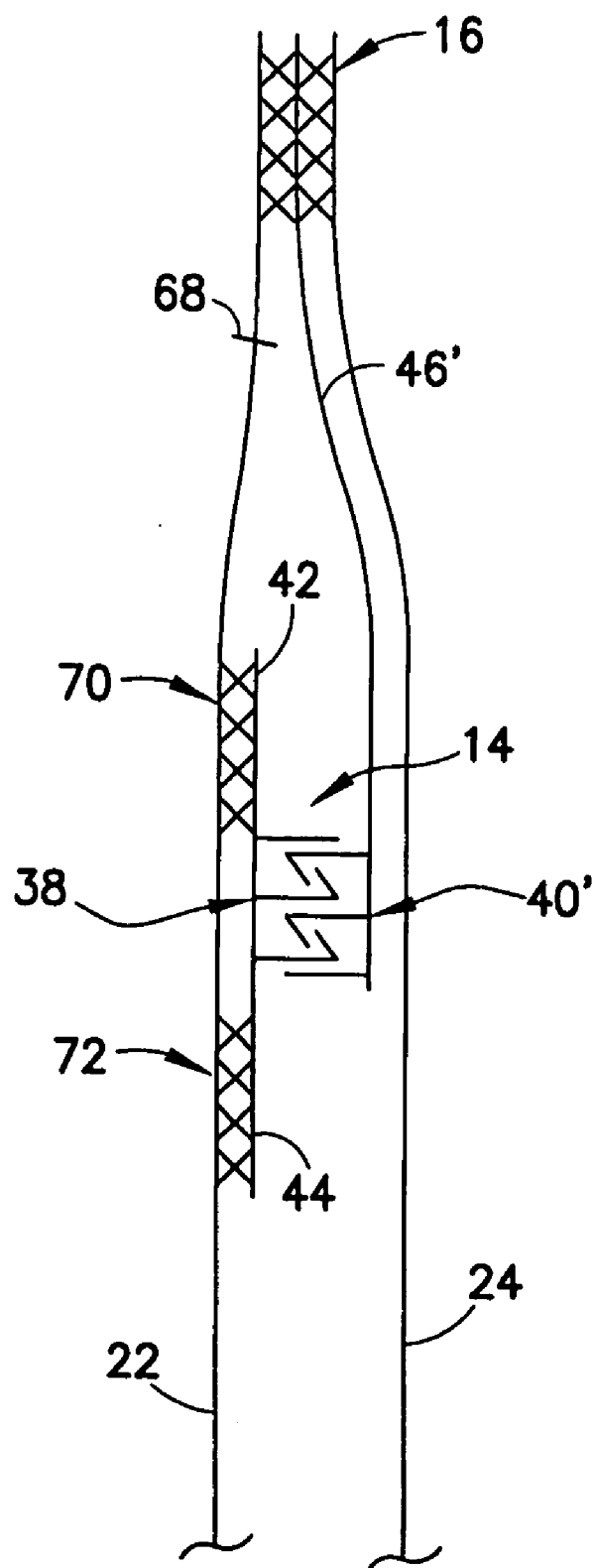


FIG. 9

POUCHES HAVING RECLOSABLE POUR SPOUT IN SIDE GUSSET

BACKGROUND OF THE INVENTION

[0001] This invention generally relates to packaging for containing pourable contents such as breakfast cereal, snack food product and the like. More particularly, the invention relates to flexible pouches provided with a reclosable pour spout.

[0002] It is known to package breakfast cereal by sealing the dry cereal product inside a plastic pouch and then placing the filled pouch within a paperboard box or carton. A disadvantage with this type of packaging is that once the sealed pouch is opened, it is difficult to reseal the pouch in a moisture-tight manner necessary to maintain freshness of the cereal product.

[0003] In order to close a conventional cereal pouch after the sealed top end has been opened, the user will typically fold the opened end of the pouch over onto itself one or more times. Closing the pouch in this way is awkward. Oftentimes the user will simply stuff the opened end of the pouch down into the box without regard to properly sealing of the opening. As additional serving portions of the cereal product are emptied from the pouch, it becomes more difficult to roll up or fold the empty portion of the pouch within the depth of the box or carton. However, even when the opened end of the plastic pouch is folded or rolled up, an effective seal cannot be assured since the plastic material has a degree of stiffness and does not adhere to itself.

[0004] It is also difficult to open the sealed top end of conventional cereal pouches without also ripping or tearing the walls of the pouch. An unevenly opened pouch may have an overhanging portion that blocks or traps cereal during pouring. In the case where the pouch is used as a liner within a box, an overhanging portion of the ripped open pouch may also cause spillage of the cereal contents into the crevice space between the pouch and the box as the box is returned to the upright position.

[0005] There is a need for improvements in flexible pouches of the type having a reclosable pour spout.

BRIEF DESCRIPTION OF THE INVENTION

[0006] The present invention is directed to flexible pouches having a plastic zipper installed in a side gusset. The zipper comprises one zipper strip attached to an upper portion of the side gusset and another zipper strip attached to confronting portions of the pouch walls. After the zipper is opened, an upper portion of the side gusset to which the zipper is attached can be inverted to form a pour spout.

[0007] One aspect of the invention is a package comprising a receptacle having an interior volume and a spout that, when in an opened state, allows the package exterior to communicate with the interior volume, the receptacle comprising first and second walls and a side gusset connected to the first and second walls, the spout being formed by an upper portion of the side gusset and adjoining first upper portions of the first and second walls respectively, wherein confronting second upper portions of the first and second walls contiguous with the first upper portions of the first and second walls respectively are sealed together at or near a top of the receptacle; and further comprising a flexible zipper attached to the spout in a manner such that the spout is closed when the zipper is closed and the spout is open to the

extent that the zipper is opened, the zipper comprising a first zipper strip joined to the side gusset and a second zipper strip joined to the first and second walls.

[0008] Another aspect of the invention is a package comprising: a gusseted tube of film sealed at a top and a bottom thereof by top and bottom cross seals respectively, the bottom seal extending the full width of the package, the top seal extending along a major portion of the package width, and the gusseted tube comprising a side gusset extending from the top to the bottom of the tube, wherein the side gusset and the top seal do not overlap; and further comprising a flexible zipper comprising a first zipper strip joined to a portion of the side gusset, and a second zipper strip joined to portions of the tube.

[0009] A further aspect of the invention is a package comprising a receptacle having a reclosable spout in one corner, the receptacle having an interior volume that communicates with the exterior of the package via the spout when the zipper is in the opened state, the receptacle comprising first and second walls and a side gusset connected to the first and second walls, the side gusset comprising first and second gusset panels that are connected to each other at a first fold line, the first gusset panel being connected to the first wall at a second fold line, and the second gusset panel being connected to the second wall at a third fold line, the spout comprising respective portions of the first and second gusset panels and respective portions of the first and second walls, wherein the first zipper strip is joined to the portions of the first and second gusset panels, and the second zipper strip is joined to the portions of the first and second walls.

[0010] Yet another aspect of the invention is a method of manufacturing a package having a reclosable spout, comprising the following steps: interlocking respective segments of first and second zipper strips together; joining the first zipper strip segment to a web of packaging material; forming the web into a tube; forming a gusset in the tube, the gusset being situated such that the first zipper strip segment extends across the width of the gusset and no further; forming a bottom seal across the gusseted tube; filling the tube above the bottom seal with product; joining the second zipper strip segment to respective portions of the tube; and forming a top seal across a portion of the tube adjacent the zipper.

[0011] Other aspects of the invention are disclosed and claimed below.

BRIEF DESCRIPTION OF THE DRAWINGS

[0012] FIG. 1 is a drawing showing a front view of a package having a reclosable pour spout and constructed in accordance with one embodiment of the invention. The hatching in FIG. 1 (and other front views) indicates the positions of various heat seals.

[0013] FIGS. 2 and 3 are drawings showing the configurations of the top of the package depicted in FIG. 1 when the spout is closed (FIG. 2) and open (FIG. 3) respectively.

[0014] FIG. 4 is a drawing showing a sectional view of a portion of the package depicted in FIGS. 1-3. The section is taken through a vertical plane indicated by section line 4-4 in FIG. 2. Each series of Xs in FIG. 4 (and other sectional views) indicates a respective permanent heat seal.

[0015] FIG. 5 is a drawing showing a sectional view of a portion of the gusseted receptacle of the package depicted in

FIG. 1. The section is taken through a horizontal plane indicated by section line 5-5 in FIG. 1.

[0016] FIG. 6 is a drawing showing an isometric view of a portion of a package having a slider-operated reclosable pour spout and constructed in accordance with another embodiment of the invention.

[0017] FIG. 7 is a drawing showing a front view of a portion of a gusseted package having a reclosable pour spout and constructed in accordance with a further embodiment of the invention. The receptacle is shown in a flattened state with folded and flattened side gussets and a folded zipper. Only the outline of one closure profile is seen in FIG. 7.

[0018] FIG. 8 is a drawing showing a side view of the zipper-supporting portions of the gusseted package seen in FIG. 7, wherein the zipper and attached side gusset have been unfolded and are disposed in a plane transverse to the plane of still flattened other portions of the receptacle.

[0019] FIG. 9 is a drawing showing a sectional view of a portion of the package depicted in FIGS. 7 and 8. The section is taken through a vertical plane indicated by section line 9-9 in FIG. 8.

[0020] Reference will now be made to the drawings in which similar elements in different drawings bear the same reference numerals.

DETAILED DESCRIPTION OF THE INVENTION

[0021] Various embodiments of the invention will now be described. Each of the packages described below may be manufactured on a VFFS machine. Each disclosed embodiment comprises a tube of flexible packaging material, such as thermoplastic pouch making film, formed by wrapping the packaging material around a fill tube and then sealing confronting longitudinal edges together, e.g., by conventional conductive heat sealing. Either a lap seal or a fin seal can be formed. Then opposing side gussets are formed in the tube. The gusseted tube is cross sealed to form a bottom seal. The pocket above the bottom seal is then filled with product. Then the tube is again cross sealed at an elevation above the product fill line to form a top seal that extends across a major portion of the package width. The top and bottom cross seals are typically formed by conductive heat sealing using reciprocating heated sealing bars.

[0022] The embodiments disclosed hereinafter also incorporate structure that can be configured to form a pour spout, that pour spout being reclosable by means of a zipper-type fastener comprising a pair of flexible zipper strips that are mutually interlockable. The zipper may be transversely applied to the film before the latter enters the VFFS machine, one zipper strip being attached to the film and the other zipper strip being interlocked with and carried by the attached zipper strip. The length of the zipper is slightly less than the width of the side gusset with attached zipper that will be formed in the VFFS machine. The unattached zipper strip may be attached to respective portions of film at the same time when the top cross seal is made.

[0023] The technology for transverse application of flexible zippers at spaced intervals on an intermittently advancing web of pouch making film (during dwell times) at a station upstream of a VFFS machine is well known. A distal portion of a fastener tape is oriented transversely in overlying relationship with a tensioned section of a web of pouch making film situated upstream of the VFFS machine. A distal section of the fastener tape is then severed from the

remainder of the fastener tape to form a zipper assembly that will be joined to the web. The equipment for manufacturing the fastener tape may be placed in line with the zipper application station. Alternatively, the fastener tape may be manufactured at a different site, wound onto a supply reel that is transported to the site of the VFFS machine, and then paid out from that supply reel during operation of the VFFS machine.

[0024] The fastener tape comprises a pair of zipper strips, each zipper strip being formed by extruding thermoplastic material to form a respective closure profile and one or two zipper flanges connected thereto. The closure profiles have complementary shapes that interlock, the shapes being constant in the lengthwise direction. The fastener tape may be manufactured using a process involving concurrent formation of slider end stop structures and sealing of zipper flanges at spaced intervals.

[0025] A package in accordance with one embodiment of the invention is shown in FIGS. 1-5. FIG. 1 shows a front view, while FIG. 5 shows a sectional view taken along the plane indicated by line 5-5 in FIG. 1. The package comprises a receptacle 2 that is optionally placed inside a paperboard box or carton (not shown). In this embodiment, the receptacle 2 comprises front and rear walls (only the front wall is visible in FIG. 1) that are connected by respective side gussets.

[0026] As best seen in FIG. 5, the front wall 26 is connected to the rear wall 24 by means of a pair of side gussets. One side gusset comprises first and second gusset panels 20 and 22 which are connected to each other at a fold line 4, while the other side gusset comprises third and fourth gusset panels 48 and 50 which are connected to each other at a fold line 6. The first and third gusset panels 20 and 48 are connected to the rear wall 24 at respective fold lines on opposite sides thereof, while the second and fourth gusset panels 22 and 50 are connected to the front wall 26 at respective fold lines on opposite sides thereof.

[0027] The rear wall 24 also comprises a vertical fin seal 8 that extends the full height of the package, as best seen in FIG. 1 (vertical seal 8 is indicated by hatching). The fin seal 8 is made on the VFFS machine after the packaging film has been wrapped around the fill tube, thereby forming a tube of film. As seen in FIG. 1, the vertical seal 8 extends from a top seal 10 to a bottom seal 12 of the package.

[0028] The top seal 10 is preferably formed by conductive heat sealing and comprises the following sections (described with reference to FIGS. 2 and 5): a central portion 28 (see FIG. 2) where upper marginal portions of the front and rear walls 26 and 24 are joined to each other (see FIG. 5); a second portion 30 (see FIG. 2) where an upper marginal portion of the rear wall 24 is joined to an upper marginal portion of side gusset panel 48 (see FIG. 5); and a third portion 32 (see FIG. 2) where an upper marginal portion of the front wall 26 is joined to an upper marginal portion of side gusset panel 50 (see FIG. 5). As used herein, the term "top seal" does not include the reclosable feature installed in the side gusset.

[0029] The bottom seal 12 is also preferably formed by conductive heat sealing and comprises the following sections (described with reference to FIG. 5): a central portion (extending between dashed lines 4 and 6 seen in FIG. 1) where lower marginal portions of the front and rear walls 24 and 26 are joined to each other; a second portion where a lower marginal portion of the rear wall 24 is joined to a

lower marginal portion of side gusset panel 48; a third portion where a lower marginal portion of the front wall 26 is joined to a lower marginal portion of side gusset panel 50; a fourth portion where a lower marginal portion of the rear wall 24 is joined to a lower marginal portion of side gusset panel 20; and a fifth portion where a lower marginal portion of the front wall 26 is joined to a lower marginal portion of side gusset panel 22. The configuration of the bottom seal, when viewed from the bottom, is the same as the configuration seen in FIG. 2.

[0030] The embodiment shown in FIG. 1 further comprises a press-to-close zipper comprising two zipper strips having mutually interlockable closure profiles generally indicated by the numeral 14 in FIGS. 1 and 4. The zipper has a length slightly less than the width of a side gusset in a planar state. One zipper strip is attached to respective portions of gusset panels 20 and 22, while the other zipper strip is attached to respective portions of the front and rear walls respectively adjoining the respective portions of gusset panels 20 and 22. A closed state of the zipper is represented in FIG. 2 by lines 34 and 36, each of which represents a respective half of the closed zipper and attached portions of the gusseted receptacle. More specifically, portion 34 (see FIG. 2) comprises the zipper half attached to gusset panel 20 and rear wall 24 (see FIG. 5), while portion 36 (see FIG. 2) comprises the zipper half attached to gusset panel 22 and front wall 26 (see FIG. 5).

[0031] The structure and position of the zipper are shown in more detail in the sectional view of FIG. 4. In this particular example, the zipper comprises a zipper strip 38 having an upper flange 42 and a lower flange 44, and a zipper strip 40 having an upper flange 46 only. The portions of flanges 42 and 44 on one half of zipper strip 38 are joined to respective portions of the gusset panel 20, as seen in FIG. 4, while the portions of flanges 16 and 18 on the other half of zipper strip 38 are joined to respective portions of the other gusset panel (not shown in FIG. 4; item 22 in FIG. 5). The zones of gusset panel/zipper strip joinder 16 and 18, indicated by Xs in FIG. 4, are preferably permanent heat seals. Similarly, the portion of flange 46 on one half of zipper strip 40 is joined to a portion of the rear wall 24, as seen in FIG. 4, while the portion of flange 46 on the other half of zipper strip 40 is joined to a portion of the front wall (not shown in FIG. 4; item 26 in FIG. 5). The zone of receptacle wall/zipper strip joinder 17, indicated by Xs in FIG. 4, is also preferably a permanent heat seal.

[0032] While FIG. 4 shows the half of the closed zipper that is attached to gusset panel 20, the other half of the closed zipper has a similar structure and position as that shown in FIG. 4, except that portion of the zipper is attached to gusset panel 22 and front wall 26 instead of to gusset panel 20 and rear wall 24. When the zipper is opened, zipper strip attached to gusset panels 20 and 22 is separated from the zipper strip attached to front and rear walls 26 and 24. The side gusset comprising gusset panels 20 and 22 can then be inverted, as shown in FIG. 3, to form a spout 35. While the spout 35 is represented in FIG. 3 as a rhombus, this is for illustrative purposes only. A person skilled in the art of plastic reclosable packaging will readily appreciate that a plastic zipper that has memorized a fold during the time between manufacture and initial opening of the zipper will not so easily form a fold in the opposite direction, as depicted in FIG. 3. For example, in reality the contour of the

zipper strip that is attached to the side gusset may be more semicircular or parabolic than V-shaped during pouring of product out of the package.

[0033] A package in accordance with a second embodiment is shown in FIG. 6. This package is similar to the package depicted in FIG. 1, except that a slider-operated zipper 52 is installed in the spout portion of the package. In this embodiment, zipper 52 consists of a pair of zipper strips having a length slightly less than the width of the side gusset in a planar state. One zipper strip comprises a closure profile 64 and a flange 60 connected to and extending downward from the closure profile 64; the other zipper strip comprises a closure profile 66 and a flange 62 connected to and extending downward from the closure profile 66. The zipper flange 62 is joined to the panels of the side gusset by a permanent heat seal; the zipper flange 60 is joined to adjoining portions of the front and rear walls of the receptacle by a permanent heat seal 16 (only the seal to the front wall is shown in FIG. 6), which may be formed at the same time that top seal 10 is formed.

[0034] As seen in FIG. 6, the closure profiles 64 and 66 project above the upper edge of the receptacle. The slider 58 travels along the closure profiles from a zipper fully closed position to a zipper fully opened position. When the slider 58 is moved to the zipper fully opened position, the side gusset with zipper strip attached thereto can be inverted to form a spout. The contents of the package can then be poured out through that spout. When pouring is finished, the side gusset can be restored to its original position (in which the fold line 4 is positioned as indicated in FIG. 6) and then the slider is operated to close the zipper, thereby reclosing the package.

[0035] The slider 58 is preferably of the straddling type, i.e., the slider has no separating finger and thus requires that slider end stops be provided at the ends of the zipper. As seen in FIG. 6, the ends of the zipper strips are fused together and deformed at their respective ends to form respective slider end stops 54 and 56, the slider being movable along the zipper between the slider end stops. Alternatively, clips or other slider end stop devices could be attached to the ends of the zipper. It should be appreciated, however, that the present invention does not require the use of a straddling-type slider. Alternatively, a slider having a plow or separating finger can be employed, in which case the zipper strip joints at the ends of the zipper can serve as slider end stops.

[0036] Preferably, the slider/zipper assembly 58/52 is of the type disclosed in U.S. Pat. No. 6,047,450, in which the slider has no separating finger and the closure profiles provide a moisture-tight, if not airtight, seal when the zipper is fully closed. Alternatively, the zipper may comprise interlocking alternating hook-shaped or ball-shaped closure elements. The zipper strips are made of thermoplastic material. The preferred zipper material is polyethylene or polypropylene. To facilitate the joinder of the zipper flanges to the packaging material, the zipper flanges may have a surface layer of sealant material that melts at a temperature lower than the melting point of the material making up the remainder of the zipper.

[0037] A further embodiment of the invention is shown in FIGS. 7-9. FIG. 7 shows a front view of a portion of a gusseted package having a reclosable pour spout. The receptacle is shown in a flattened state with folded and flattened side gussets and a folded zipper. FIG. 8 shows a side view of the zipper-supporting portions of the gusseted package seen in FIG. 7, wherein the zipper and attached side gusset

have been unfolded and are disposed in a plane transverse to the plane of still flattened other portions of the receptacle. FIG. 9 shows a sectional view of a portion of the package depicted in FIGS. 7 and 8. The section is taken through a vertical plane indicated by section line 9-9 in FIG. 8.

[0038] The embodiment shown in FIGS. 7-9 is similar to the embodiment of FIG. 1, with differences in the configuration and positioning of the zipper as explained hereinafter. The differences in zipper construction can be seen by comparing FIGS. 4 and 9. The primary difference is that zipper strip 40' seen in FIG. 9 has a long upper flange 46' that extends beyond the edge of the upper flange 42 of zipper strip 38. In contrast, in the zipper depicted in FIG. 4, the upper flanges 42 and 46 of zipper strips 38 and 40 have substantially the same length. The profiles 14 may be substantially the same in both zippers. Likewise the zipper strips 30 comprising upper and lower flanges 42 and 44 may be substantially the same in both zippers.

[0039] The purpose of the extended length of upper flange 46' is that it allows the upper flanges of both zipper strips to be joined to the side gusset at different elevations. As seen in FIGS. 8 and 9, a portion of the upper flange 46' is joined to both the side gusset (i.e., gusset panels 20 and 22) and confronting portions of the receptacle (i.e., the front and rear walls) by a permanent heat seal 16. The heat seal 16 is aligned with (see FIG. 7) and may be formed concurrently with the top seal 10 using the same heated sealing bars. The upper and lower flanges of the other zipper strip are joined to the gusset panels 20 and 22 by respective permanent heat seals 70 and 72.

[0040] The portions of gusset panels 20 and 22 that are joined to the respective upper flanges 42 and 46' are connected by a portion of the side gusset in which a line of weakened tear resistance 68 (hereinafter "tear line") has been formed. The tear line 68 extends horizontally across the width of the side gusset, i.e., across gusset panels 20 and 22, as seen in FIG. 8. As seen in FIG. 9, the tear line 68 is situated at an elevation between the permanent heat seals 16 and 70. The tear line can be formed by any conventional means, including lines of spaced perforations, laser scoring, and so forth. When a user wishes to open a package containing pourable matter (e.g., particles or liquid), the user must first tear the gusset panels 20 and 22 along the tear line 68. Then the zipper strips are pulled apart to open the zipper. In the latter process, the zipper-carrying portion of the side gusset is at least partially inverted to form a spout. The package may then be upended to pour the contents out.

[0041] In accordance with yet another embodiment, the reclosable spout may comprise a zipper of the type wherein the zipper strips have respective pull flanges for opening the zipper, while a clip of a type adapted for pressing the closure profiles of the zipper strips into interlocking relationship is mounted to the zipper strips. In other words, the clip is used to close the zipper, but serves no role in opening the zipper.

[0042] While the invention has been described with reference to preferred embodiments, it will be understood by those skilled in the art that various changes may be made and equivalents may be substituted for members thereof without departing from the scope of the invention. In addition, many modifications may be made to adapt a particular situation to the teachings of the invention without departing from the essential scope thereof. Therefore it is intended that the invention not be limited to the particular embodiment disclosed as the best mode contemplated for carrying out this

invention, but that the invention will include all embodiments falling within the scope of the appended claims.

[0043] As used in the claims, the verb "joined" means fused, bonded, sealed, or adhered, whether by application of heat and/or pressure, application of ultrasonic energy, application of a layer of adhesive material or bonding agent, interposition of an adhesive or bonding strip, etc. As used in the claims, the term "wall" is used in a broad sense to include both a discrete piece of packaging material and a portion of a folded piece of packaging material. Furthermore, in the absence of explicit language in any method claim setting forth the order in which certain steps should be performed, the method claims should not be construed to require that steps be performed in the order in which they are recited.

1. A package comprising:

- a receptacle having an interior volume and a spout that, when in an opened state, allows the package exterior to communicate with said interior volume, said receptacle comprising first and second walls and a first side gusset connected to said first and second walls, said spout being formed by an upper portion of said first side gusset and adjoining first upper portions of said first and second walls respectively, wherein confronting second upper portions of said first and second walls contiguous with said first upper portions of said first and second walls respectively are sealed together at or near a top of said receptacle; and
- a flexible zipper attached to said spout in a manner such that said spout is closed when said zipper is closed and said spout is open to the extent that said zipper is opened, said zipper comprising a first zipper strip joined to said first side gusset and a second zipper strip joined to said first and second walls.

2. The package as recited in claim 1, wherein said first zipper strip comprises a first closure profile and a first flange connected to said first closure profile, and said second zipper strip comprises a second closure profile that is engageable with said first closure profile and a second flange connected to said second closure profile, said first flange being joined to said first side gusset, and said second flange being joined to said first and second walls.

3. The package as recited in claim 2, further comprising a slider mounted to said zipper, said slider being movable in a closing direction to cause portions of said first and second closure profiles to engage and in an opening direction to cause portions of said first and second closure profiles to disengage.

4. The package as recited in claim 3, further comprising a first slider end stop positioned at one end of said zipper to stop said slider from moving further in said closing direction; and a second slider end stop positioned at the other end of said zipper to stop said slider from moving further in said opening direction.

5. The package as recited in claim 1, wherein said first zipper strip comprises a first closure profile and first and second flanges connected to said first closure profile, and said second zipper strip comprises a second closure profile and a third flange connected to said second closure profile, said first and second flanges being joined to said first side gusset, and said third flange being joined to said first and second walls.

6. The package as recited in claim 5, wherein said third flange is also joined to said first side gusset, the respective

zones of joinder of said first and third flanges to said first side gusset being connected by a section of said first side gusset having a line of weakness.

7. The package as recited in claim 6, wherein said line of weakness comprises a line of spaced perforations.

8. The package as recited in claim 1, wherein said receptacle further comprises a second side gusset.

9. The package as recited in claim 1, wherein confronting lower portions of said first and second walls are sealed together at or near a bottom of said receptacle.

10. The package as recited in claim 1, wherein said first side gusset extends from said top to a bottom of said receptacle.

11. A package comprising:

a gusseted tube of film sealed at a top and a bottom thereof by top and bottom cross seals respectively, said bottom seal extending the full width of the package, said top seal extending along a major portion of said package width, and said gusseted tube comprising a first side gusset extending from said top to said bottom of said tube, wherein said first side gusset and said top seal do not overlap; and

a flexible zipper comprising a first zipper strip joined to a portion of said first side gusset, and a second zipper strip joined to portions of said tube.

12. The package as recited in claim 11, wherein said first zipper strip comprises a first closure profile and a first flange connected to said first closure profile, and said second zipper strip comprises a second closure profile that is engageable with said first closure profile and a second flange connected to said second closure profile, said first flange being joined to said first side gusset, and said second flange being joined to said portions of said tube.

13. The package as recited in claim 12, further comprising a slider mounted to said zipper, said slider being movable in a closing direction to cause portions of said first and second closure profiles to engage and in an opening direction to cause portions of said first and second closure profiles to disengage.

14. The package as recited in claim 11, wherein said first zipper strip comprises a first closure profile and first and second flanges connected to said first closure profile, and said second zipper strip comprises a second closure profile and a third flange connected to said second closure profile, said first and second flanges being joined to said first side gusset, and said third flange being joined to said first and second walls.

15. The package as recited in claim 14, wherein said third flange is also joined to said first side gusset, the respective zones of joinder of said first and third flanges to said first side gusset being connected by a section of said first side gusset having a line of weakness.

16. The package as recited in claim 11, wherein said receptacle further comprises a second side gusset.

17. A package comprising a receptacle having a reclosable spout in one corner, said reclosable spout comprising a zipper having closed and opened states, said receptacle having an interior volume that communicates with the exterior of said package via said spout when said zipper is in said opened state, said receptacle comprising first and second walls and a side gusset connected to said first and second walls, said side gusset comprising first and second gusset panels that are connected to each other at a first fold line, said first gusset panel being connected to said first wall at a second fold line, and said second gusset panel being connected to said second wall at a third fold line, said spout comprising respective portions of said first and second gusset panels and respective portions of said first and second walls, wherein said first zipper strip is joined to said portions of said first and second gusset panels, and said second zipper strip is joined to said portions of said first and second walls.

18. The package as recited in claim 17, further comprising a slider mounted to said zipper, said slider being movable in a closing direction to close said zipper and in an opening direction to open said zipper.

19. The package as recited in claim 17, wherein said first zipper strip comprises a first closure profile and first and second flanges connected to said first closure profile, and said second zipper strip comprises a second closure profile and a third flange connected to said second closure profile, said first and second flanges being joined to said side gusset, and said third flange being joined to said first and second walls.

20. The package as recited in claim 19, wherein said third flange is also joined to said side gusset, the respective zones of joinder of said first and third flanges to said side gusset being connected by a section of said side gusset having a line of weakness.

21. A method of manufacturing a package having a reclosable spout, comprising the following steps:

interlocking respective segments of first and second zipper strips together;

joining said first zipper strip segment to a web of packaging material;

forming said web into a tube;

forming a gusset in said tube, said gusset being situated such that said first zipper strip segment extends across the width of said gusset and no further;

forming a bottom seal across said gusseted tube;

filling said tube above said bottom seal with product;

joining said second zipper strip segment to respective portions of said tube; and

forming a top seal across a portion of said tube adjacent said zipper.

* * * * *