April 14, 1964 H. SPECKETER 3,128,913

CONTAINER SPOUT HAVING ITS OUTLET PASSAGE SEALED BY A WALL OF THE CONTAINER

Filed Nov. 29, 1960 3 Sheets-Sheet 1

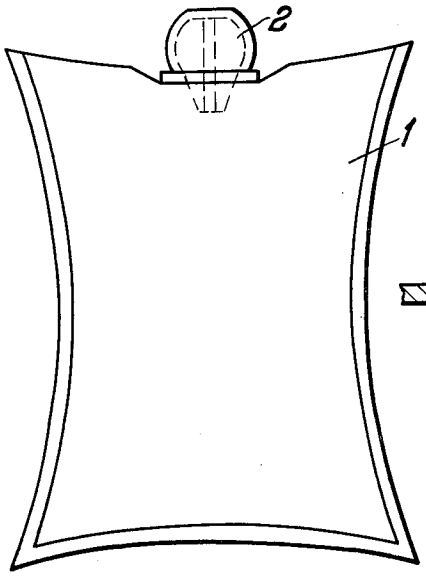


Fig. 1

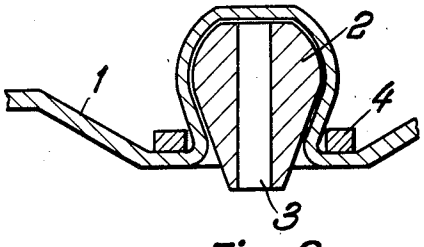


Fig. 2

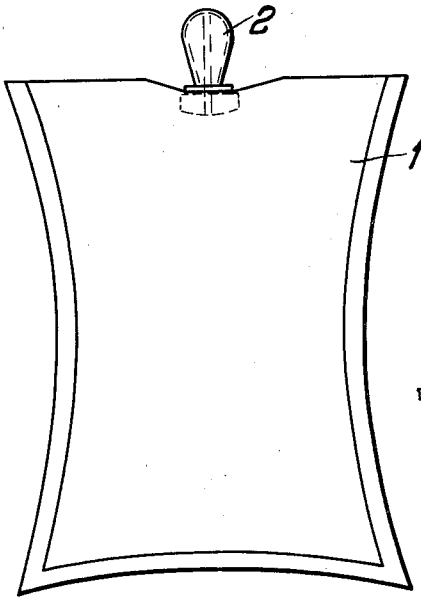


Fig. 3

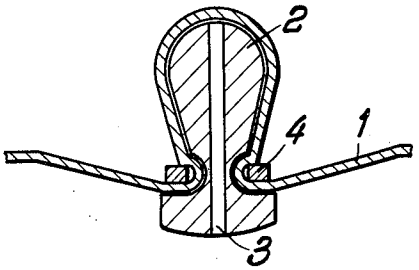


Fig. 4.

Inventor:
Hellmut Specketer

by: Michael S. Striker
Atty

April 14, 1964 H. SPECKETER 3,128,913

CONTAINER SPOUT HAVING ITS OUTLET PASSAGE SEALED BY A WALL OF THE CONTAINER

Filed Nov. 29, 1960 3 Sheets-Sheet 2

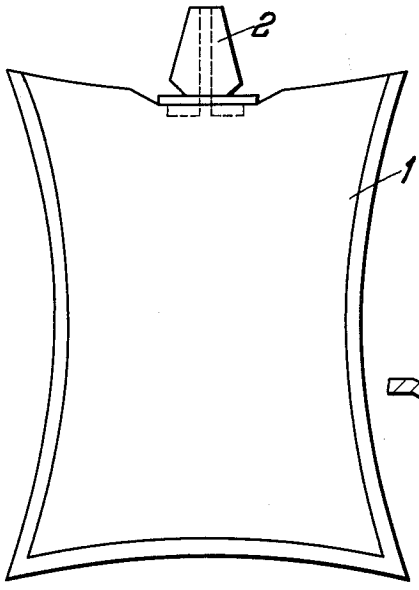


Fig. 5

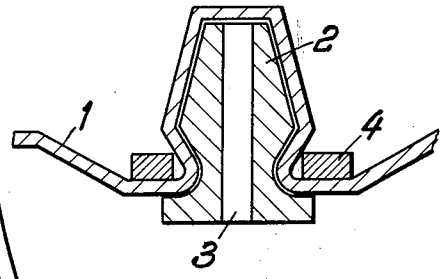


Fig. 6

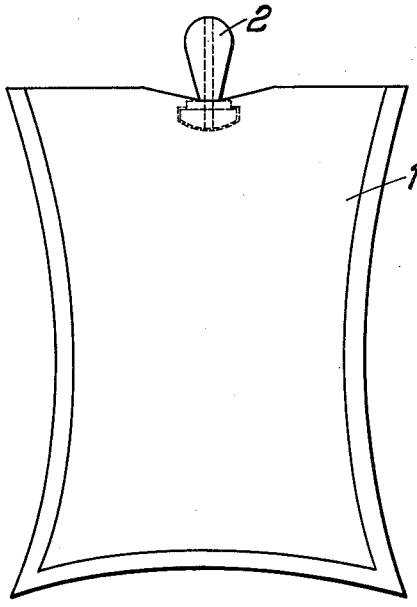


Fig. 7

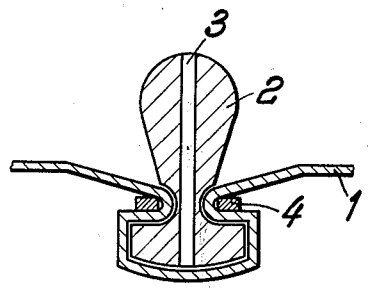


Fig. 8

Inventor:
Hellmut Speketer
by: Michael S. Striker
Atty

April 14, 1964 H. SPECKETER 3,128,913

CONTAINER SPOUT HAVING ITS OUTLET PASSAGE SEALED BY A WALL OF THE CONTAINER

Filed Nov. 29, 1960

3 Sheets-Sheet 3

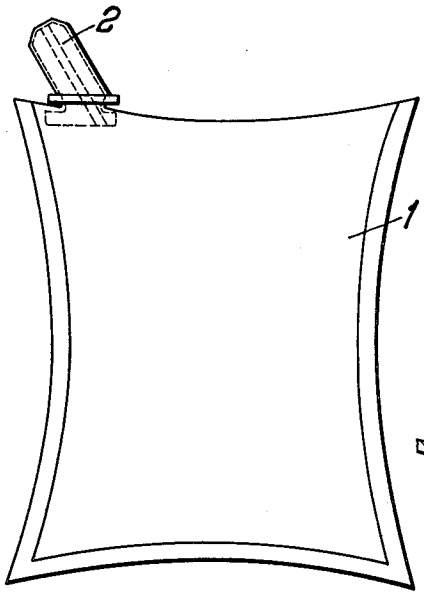


Fig. 9

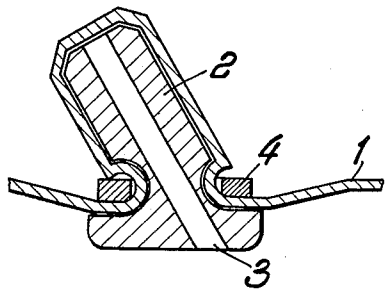


Fig. 10

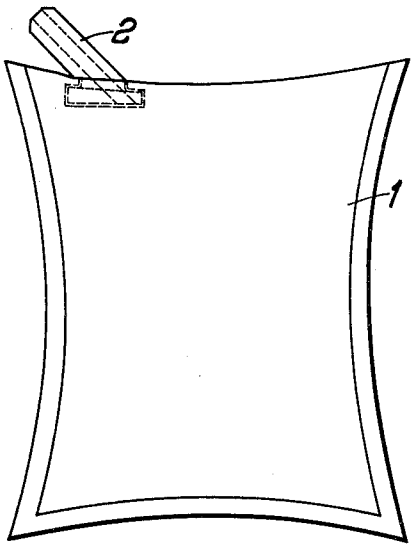


Fig. 11

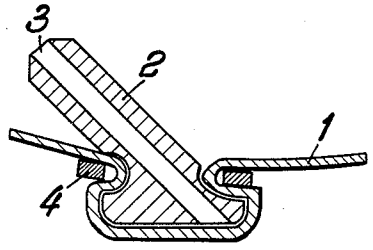


Fig. 12

Inventor:
Hellmut Specketer.
By: Michael S. Striker
Atty

United States Patent Office 3,128,913 Patented Apr. 14, 1964

3,128,913

CONTAINER SPOUT HAVING ITS OUTLET PASSAGE SEALED BY A WALL OF THE CONTAINER

Hellmut Specketer, Frankfurt am Main, Germany, assignor to Pantaplast G.m.b.H., Eschborn, Taunus, Germany

Filed Nov. 29, 1960, Ser. No. 72,483
Claims priority, application Germany Dec. 2, 1959
12 Claims. (Cl. 222—107)

The present invention relates to a container closure and more particularly the invention is concerned with containers made of thermoplastic tubular or sheet material and provided with a spout-like element for dispensing the contents of the flexible container.

In recent times, the continuous packaging of liquid and paste-like products into thermoplastic tube or foil material has become of increasing importance. It is possible in this manner to package individual portions so that upon opening of the package the entire contents of the same are to be removed. However, frequently it is desired to remove only a portion of the contents from the package and thus the problem arose to provide a closure which could be incorporated in the package in such a manner as not to interfere with the continuous packaging process and which closure would permit to remove only a portion of the contents of the package and to safely retain the residual portion within the package, without danger of leakage or contamination.

It has been suggested to attach to the flexible container a closable withdrawal device such as a spout. However, these suggestions require the forming of the package with an opening and closing this opening by sealing the spout or the like to the container portion surrounding the opening. This and other suggestions have not met with full success, particularly due to the frequently required sealing operation, the difficulty of controlling the adhering of the spout to the already filled package so that firm adherence of the spout without damage to the container will be accomplished even when the degree of filling of the flexible container and thus the resiliency of the same cannot be fully controlled.

It is therefore an object of the present invention to overcome the above-discussed difficulties as well as other difficulties well-known to those skilled in this art which are encountered when it is desired to form and fill containers of thermoplastic material with a liquid or paste like or flowable substance in such a manner that part of the substance can be removed and the remainder thereof can be further stored in the container.

It is another object of the present invention to provide a container of the type described which can be produced in a simple and economical manner and which will permit the withdrawal of any desired portion of the contents of the container without interfering with the subsequent storage of the residual portion.

It is a further object of the present invention to provide a container made of resilient sheet material, preferably thermoplastic sheet or tubular material and including a spout which is maintained in the desired position relative to the container without requiring sealing, adhesively adhering or the like.

Other objects and advantages of the present invention will become apparent from the further reading of the description and of the appended claims.

With the above and other objects in view, the present invention contemplates in a container having a container wall, in combination, a flexible container wall portion formed of flexible sheet material, spout means arranged in contact with the flexible container wall portion and having a surface portion in contact with one face of the flexible container wall portion, the spout means formed

with a conduit one end of which opens into the interior of the container and the other end of which opens into the surface portion of the spout means which is in contact with the one face of the flexible container wall portion, and holding means holding the spout means within the container with the surface portion thereof in contact with the one face of the flexible container wall portion, whereby the holding means are holding the spout means in inoperative condition without any possibility of removal of substance from the container through the spout means without forming an opening through at least a portion of the flexible container wall portion and whereby upon forming an opening through a portion of the flexible container wall portion overlying the other end of the conduit of the spout means the same is adapted for removal of substance from the container.

Thus, the present invention solves the problem of combining a container formed of thermoplastic tubular or sheet material with a spout, without requiring any welding, sealing or adhesively adhering of spout and flexible container. The package or container according to the present invention includes the spout and is eminently suitable for the packaging of liquid or paste-like substances in a continuous manner.

The present invention achieves this result by surrounding one end of a spout with wall portions of the flexible container in a bag-like manner and by then arranging a holding means, for instance a thread which will hold the bag-forming container portion and the spout portion inserted therein firmly connected to each other. This manner of connecting the container wall to the spout is possible due to the fact that the sheet material of which the container is formed, preferably a thermoplastic foil, is flexible and to some extent expansible so that it is possible to form the bag-like portion in which a part of the spout is inserted. The holding together of the spout and the surrounding portion of the flexible container wall may be accomplished by means of a metal ring or a metal clamp. However, it is also possible to use a ring or a collar having an opening corresponding to the cross-section of the spout at the point at which spout and container wall are to be connected (allowing for the thickness of the container wall sheet), and consisting of another material for instance of a heat hardenable synthetic resin or an elastomeric or plastomeric material. The spout may be made of metal or preferably of a hard synthetic resin or hard rubber. Due to the difference in the resiliency of the spout material and of the wall-forming thermoplastic sheet, it is possible to form a tight connection at the point of contact between the spout and the container wall on the one hand and the container wall and the holding means such as a heat hardened synthetic resin ring on the other hand, whereby, of course, the tight seal between the spout and the container wall is of primary importance.

The novel features which are considered as characteristic for the invention are set forth in particular in the appended claims. The invention itself, however, both as to its construction and its method of operation, together with additional objects and advantages thereof, will be best understood from the following description of specific embodiments when read in connection with the accompanying drawings, in which:

FIGS. 1, 3, 5, 7, 9 and 11 illustrate in schematic elevational view various embodiments of the container according to the present invention; and

FIGS. 2, 4, 6, 8, 10 and 12 are cross-sectional views of the spout and the adjacent container area drawn on a larger scale than the first described figures.

According to FIGS. 1, 2, 3, 4, 5, 6, 9 and 10, the free end of conduit 3 is in the interior of container 1, while

according to FIGS. 7, 8, 11 and 12 the free end of conduit 3 extends outwardly of container 1.

In FIGS. 1 and 2, the spout 2 is illustrated as being of pear-shaped configuration having a flat outer end, and holding means 4 are arranged adjacent a portion of spout 2 from which the spout flares outwardly in outward direction relative to the container. Thus, holding means 4 will be prevented by the outwardly flaring portion of spout 2 from losing their grip and moving outwardly thus releasing the spout. According to FIGS. 3 and 4, the portion at which the spout and the container wall are held against each other is groove-shaped and thus will prevent dislocation of the holding means 4.

FIGS. 5 and 6 illustrate a spout which in the area thereof which is in contact with the container wall is of primarily trapezoidal cross-section and which, in addition, is formed with a groove located in a plane perpendicular to conduit 3 and adapted to receive not only a portion of the resilient container wall but also the inner portion of holding means or ring 4.

FIGS. 7 and 8 correspond to some extent to FIGS. 3 and 4, however, the spout is now arranged in such a manner that the free end of conduit 3 extends outwardly of the container. This arrangement will facilitate the closing of the outer end of conduit 3 with a cap, screw, plug or the like.

In all cases, the container will remain hermetically sealed until the portion of container wall 1 which covers one end of conduit 3 will be removed or pierced or an opening will have been formed therethrough. Thereafter, all or part of the contents of the container can be removed through conduit 3 of spout 2. When the desired quantity has been removed, the residual quantity of the contents of the container will be retained therein until the container is again brought into a position in which the residual contents will flow out of conduit 3. Or, it is also possible to close the open outer end of conduit 3 which may have been a free end initially as illustrated in FIG. 8 or which may have become a free end by the piercing of the covering portion of container wall 1, with a suitable closure device such as a cap, screw or plug.

According to FIGS. 9, 10, 11 and 12, the spout comprises an upper portion and a base portion and the axes of the upper and base portion are arranged under an acute angle relative to each other. Between the upper and the base portion of the spout is a connecting portion of reduced cross-sectional dimensions. According to FIGS. 9 and 10, the container wall surrounds the outer portion of the spout and is held by holding means 4 in the intermediate portion of reduced cross-section, while according to FIGS. 11 and 12 the container wall surrounds the base portion of the spout and is again held in contact with the spout by holding means 4 and arranged adjacent to the intermediate portion of the spout which is of reduced cross-sectional dimensions.

Furthermore, the spout according to FIGS. 9–12 is arranged close to an edge of the envelope-like container, while according to FIGS. 1–8, the spout is arranged equidistant from two opposite edges of the container. In other words, the spout may be arranged in the center or closer to the edge of one end face of the container. Particularly, when—as illustrated in FIGS. 9–12—the spout is arranged laterally displaced and close to the side wall of container 1, it is frequently desirable to have conduit 3 extend as illustrated in FIGS. 9–12, i.e. under an acute angle to the axis of container 1, and extending in the direction of the nearest lateral edge of the container. Particularly, when the container is shaped as illustrated in FIGS. 9 and 11, i.e. with outwardly pointing edge portions, the last described arrangement permits a squeezing out of substantially all of the contents of the container.

As illustrated in the drawing, it is advisable to arrange the holding means, ring, collar, thread or the like adjacent an area of the spout which is of reduced cross-section as shown in FIGS. 4, 6, 8, 10 and 12 according to which the area of reduced cross-section is intermediate areas of larger cross-section, or, as shown in FIG. 2, the holding means may be arranged adjacent an area of the spout from which the sheet covered spout surface extends outwardly, so that the holding means are maintained in position on the one hand by the outwardly flaring portion of the spout, and on the other hand by the resilient pressure of the underlying container wall portion.

In either case, the described configuration of the spout serves for securing the holding means and thereby securing the bag-shaped container wall portion to the spout.

The free end of conduit 3 may extend outwardly as illustrated in FIGS. 8 and 12, or may extend inwardly into the container as illustrated in FIGS. 2, 4, 6 and 10. For purposes of continuous production, this is necessary when the tubular thermoplastic sheet material is to be processed into filled containers, whether the arrangement of FIGS. 2, 4, 6 and 10 or the arrangement of FIGS. 8 and 10 is to be produced. However, when the container is to be produced from flat sheet material, the spout can be placed on the sheet material while the same passes through the production line, either in such a position that the embodiment of FIGS. 2, 4, 6 and 10 will be produced, or so as to produce the embodiment of FIGS. 8 and 12. In both cases, the spouts will be arranged on the sheet material at the desired distance from each other so that each container will be provided with one spout.

The thus produced soft package is hermetically closed due to the fact that the spout is arranged in the bag-like protuberance of the container wall. The container is then opened by perforating the thermoplastic sheet material which covers one end of conduit 3. If the free end of conduit 3 of the closed package extends outwardly, it will be necessary for perforation of the container wall to insert a suitably pointed member into and through conduit 3 so as to pierce the container wall covering the inner end of conduit 3. The cross-sectional dimension of conduit 3 will depend on the type of material which is to be packed in the container in such a manner that the contents of the container can be suitably emptied by applying pressure against the container walls and thereby squeezing the contents through conduit 3. Thus, highly viscous contents will require a greater cross-sectional area of conduit 3 than thin liquids.

In certain cases, it will be desirable to provide the filled and closed container with a special closure member for conduit 3. Such closure member will not be required in all cases, for instance not when the contents of the container are of high viscosity or paste-like consistency so that there is little danger of having the contents of the container flow out through opened conduit 3. It is a particular advantage of the spout arrangement according to the present invention that the soft container walls need not be damaged or torn to an excessive extent when opening the container. Furthermore, the spout particularly as illustrated in FIGS. 9–12 will also serve to determine the direction of flow of the contents of the container.

When it is desired to provide a closure member, the same may conveniently be formed as a cap or a plug with or without a threaded contact surface. The cap, preferably will be clamped onto the spout, while the plug will be at least partially inserted into the outer end portion of conduit 3. A plug-type closure member can be formed with a pointed end portion which will serve for piercing the container wall covering the outer end of conduit 3.

It can be readily seen that the bag-like extension of the container wall will protrude outwardly in such cases where the free end of conduit 3 is located inside the container, while in cases where the free end of conduit 3 is located outside of the container, for instance according to FIG. 12, the bag-like portion of the container wall extends inwardly of the container.

In arrangements wherein the free end of conduit 3

is inside the container, it is possible to use the holding means 4 which then for instance may be formed by a thread or a band, simultaneously as holding means for a label, a flag or the like, or for holding a handle-type element. When a band or the like is used for forming holding means 4, then a portion of the band might extend outwardly for instance forming a loop and thus serving as a handle for the package. Obviously, the holding means may be imprinted or in other ways provided with indicia or characteristic color combinations.

In either case, i.e. whether the free end of conduit 3 extends inwardly or outwardly of the container, the inner end of conduit 3 need not be located in the axis of spout 2.

In order to prevent disengagement of spout and container wall, particularly after an opening has been formed through the portion of the flexible container wall which overlies one end of the conduit, it has been found advantageous to provide the portion of the spout surface which is covered by and in contact with a portion of the flexible container wall, with a roughened surface or a somewhat ribbed, serrated or knurled surface in order to prevent sliding disengagement between spout and container wall.

For the same purpose, it may also be provided that the holding means, particularly when the same consists of hard plastic material, are welded to the container wall.

It is of course within the scope of the present invention to provide a roughened spout surface and to weld the holding means to the container wall, or to provide only one or none of these two features.

It will be understood that each of the elements described above, or two or more together, may also find a useful application in other types of containers differing from the types described above.

While the invention has been illustrated and described as embodied in a container made of flexible thermoplastic sheet material, it is not intended to be limited to the details shown, since various modifications and structural changes may be made without departing in any way from the spirit of the present invention.

Without further analysis, the foregoing will so fully reveal the gist of the present invention that others can by applying current knowledge readily adapt it for various applications without omitting features that, from the standpoint of prior art, fairly constitute essential characteristics of the generic or specific aspects of this invention and, therefore, such adaptations should and are intended to be comprehended within the meaning and range of equivalence of the following claims.

What is claimed as new and desired to be secured by Letters Patent is:

1. In a container having a container wall, in combination, a flexible container wall portion formed of flexible sheet material; elongated spout means arranged within said container inside of said flexible container wall portion and having a surface portion in contact with the inner face of said flexible container wall portion, said spout means formed with an elongated conduit one end of which opens into the interior of said container and the other end of which opens into said surface portion of said spout means which is in contact with the inner face of said flexible container wall portion said elongated spout means including a portion of smaller transverse dimensions interposed between end portions of greater transverse dimensions; and holding means surrounding and situated between the ends of said elongated spout means in the area of said portion of smaller transverse dimensions thereof and engaging said flexible container wall portion, with a portion of said flexible container wall portion and of said spout means extending outwardly in contact with each other for holding said spout means within said container with said surface portion thereof in contact with said inner face of said flexible container wall portion, whereby said holding means are holding said spout means in inoperative condition without any possibility of removal of substance from said container through said spout means without removal of at least a portion of said flexible container wall portion and whereby upon removal of a portion of said flexible container wall portion overlying the other end of said conduit of said spout means the same is adapted for removal of substance from said container.

2. In a container having a container wall, in combination, a flexible container wall portion formed of flexible sheet material; substantially rigid, elongated spout means arranged within said container inside of said flexible container wall portion and having a surface portion in contact with the inner face of said flexible container wall portion, said spout means formed with an elongated conduit one end of which opens into the interior of said container and the other end of which opens into said surface portion of said spout means which is in contact with the inner face of said flexible container wall portion said spout means including portions of different transverse dimensions with a portion of greater transverse dimension closer to the other end of said conduit and a portion of smaller transverse dimension farther distant from said other end of said conduit; and holding means surrounding and situated between the ends of said elongated spout means and engaging the outer face of said flexible container wall portion adjacent to said portion of smaller transverse dimension of said spout means, with a portion of said flexible container wall portion and of said spout means extending outwardly in contact with each other for holding said spout means within said container with said surface portion thereof in contact with said inner face of said flexible container wall portion, whereby said holding means are holding said spout means in inoperative condition without any possibility of removal of substance from said container through said spout means without removal of at least a portion of said flexible container wall portion and whereby upon forming an opening through a portion of said flexible container wall portion overlying the other end of said conduit of said spout means the same is adapted for removal of substance from said container.

3. In a container having a container wall, in combination, a flexible container wall portion formed of flexible sheet material; substantially rigid, elongated spout means arranged within said container inside of said flexible container wall portion and having a surface portion in contact with the inner face of said flexible container wall portion said surface portion including an annular groove, said spout means formed with an elongated conduit one end of which opens into the interior of said container and the other end of which opens into said surface portion of said spout means which is in contact with the inner face of said flexible container wall portion; and holding means surrounding and situated between the ends of said elongated spout means and engaging the outer face of said flexible container wall portion opposite said annular groove, with a portion of said flexible container wall portion and of said spout means extending outwardly in contact with each other for holding said spout means within said container with said surface portion thereof in contact with said inner face of said flexible container wall portion, whereby said holding means are holding said spout means in inoperative condition without any possibility of removal of substance from said container through said spout means without forming an opening through at least a portion of said flexible container wall portion and whereby upon forming an opening through a portion of said flexible container wall portion overlying the other end of said conduit of said spout means the same is adapted for removal of substance from said container.

4. In a container having a container wall, in combination, a flexible container wall portion formed of flexible sheet material; substantially rigid, elongated spout means

arranged within said container inside of said flexible container wall portion and having an outwardly flaring surface portion in contact with the inner face of said flexible container wall portion, said spout means formed with an elongated conduit one end of which opens into the interior of said container and the other end of which opens into said surface portion of said spout means which is in contact with the inner face of said flexible container wall portion; and annular holding means surrounding and situated between the ends of said elongated spout means and engaging said flexible container wall portion, with a portion of said flexible container wall portion and of said spout means extending outwardly in contact with each other for holding said spout means within said container with said outwardly flaring surface portion thereof in contact with said inner face of said flexible container wall portion, whereby said holding means are holding said spout means in inoperative condition without any possibility of removal of substance from said container through said spout means without forming an opening through at least a portion of said flexible container wall portion and whereby upon forming an opening through a portion of said flexible container wall portion overlying the other end of said conduit of said spout means the same is adapted for removal of substance from said container.

5. In a container having a container wall, in combination, a flexible container wall portion formed of flexible sheet material; substantially rigid, elongated spout means arranged within said container inside of said flexible container wall portion and having a surface portion in contact with the inner face of said flexible container wall portion, said spout means formed with an elongated conduit one end of which opens into the interior of said container and the other end of which opens into said surface portion of said spout means which is in contact with the inner face of said flexible container wall portion, said spout means including portions of different transverse dimensions with a portion of greater transverse dimension closer to the other end of said conduit and a portion of smaller transverse dimension farther distant from said other end of said conduit; and ring-shaped, flexible holding means surrounding and situated between the ends of said elongated spout means and engaging said flexible container wall portion, with a portion of said flexible container wall portion and of said spout means extending outwardly in contact with each other for holding said spout means within said container with said surface portion thereof in contact with said inner face of said flexible container wall portion, whereby said holding means are holding said spout means in inoperative condition without any possibility of removal of substance from said container through said spout means without forming an opening through at least a portion of said flexible container wall portion and whereby upon forming an opening through a portion of said flexible container wall portion overlying the other end of said conduit of said spout means the same is adapted for removal of substance from said container.

6. In a container having a container wall, in combination, a flexible container wall portion formed of flexible sheet material; spout means arranged outside said flexible container wall portion and having a surface portion in contact with the outer face of said flexible container wall portion, said spout means formed with a conduit having one free end and the other end of which opens into said surface portion of said spout means which is in contact with the outer face of said flexible container wall portion; and holding means separate from said spout means and contacting the inner face of said flexible container wall portion for holding said spout means in contact with said container with said surface portion of said spout means in contact with said outer face of said flexible container wall portion, whereby said holding means are holding said spout means in inoperative condition without any possibility of removal of substance from said container through said spout means without removal of at least a portion of said flexible container wall portion and whereby upon removal of a portion of said flexible container wall portion overlying the other end of said conduit of said spout means the same is adapted for removal of substance from said container.

7. In a container having a container wall, in combination, a flexible container wall portion formed of flexible sheet material; substantially rigid spout means arranged outside of said flexible container wall portion and having a surface portion in contact with the outer face of said flexible container wall portion, said spout means formed with a conduit having one free end and the other end of which opens into said surface portion of said spout means which is in contact with the outer face of said flexible container wall portion, said spout means including portions of different transverse dimensions with a portion of smaller transverse dimension interposed between portions of greater transversal dimensions; and holding means contacting the inner face of said flexible container wall portion adjacent to said portion of smaller transverse dimension of said spout means for holding said spout means in contact with said container with said surface portion thereof in contact with said outer face of said flexible container wall portion, whereby said holding means are holding said spout means in inoperative condition without any possibility of removal of substance from said container through said spout means without forming an opening through a portion of said flexible container wall portion overlying the other end of said conduit of said spout means, and whereby upon forming an opening through a portion of said flexible container wall portion overlying the other end of said conduit of said spout means the same is adapted for removal of substance from said container.

8. In a container having a container wall, in combination, a flexible container wall portion formed of flexible sheet material; substantially rigid spout means arranged outside of said flexible container wall portion and having a surface portion in contact with the outer face of said flexible container wall portion, said spout means formed with a conduit having one free end and the other end of which opens into said surface portion of said spout means which is in contact with the outer face of said flexible container wall portion, said spout means including portions of different transverse dimensions with a portion of smaller transverse dimension interposed between portions of greater transversal dimensions; holding means contacting the inner face of said flexible container wall portion adjacent to said portion of smaller transverse dimension of said spout means for holding said spout means in contact with said container with said surface portion thereof in contact with said outer face of said flexible container wall portion; and closing means for removably closing said free end of said conduit, whereby said holding means are holding said spout means in inoperative condition without any possibility of removal of substance from said container through said spout means without removal of said closing means and forming an opening through at least a portion of said flexible container wall portion and whereby upon forming an opening through a portion of said flexible container wall portion overlying the other end of said conduit of said spout means the same is adapted for removal of substance from said container.

9. In a container having a container wall, in combination, a flexible container wall portion formed of flexible sheet material; substantially rigid spout means arranged outside of said flexible container wall portion and having a surface portion in contact with the outer face of said flexible container wall portion, said spout means formed with a conduit having one free end and the other end of which opens into said surface portion of said spout means which is in contact with the outer

face of said flexible container wall portion, said spout means including portions of different transverse dimensions with a groove-shaped portion of smaller transverse dimensions interposed between portions of greater transversal dimensions; and holding means contacting the inner face of said flexible container wall portion adjacent to said portion of smaller transverse dimension of said spout means for holding said spout means in contact with said container with said surface portion thereof in contact with said outer face of said flexible container wall portion, whereby said holding means are holding said spout means in inoperative condition without any possibility of removal of substance from said container through said spout means without forming an opening through a portion of said flexible container wall portion overlying the other end of said conduit of said spout means, and whereby upon forming an opening through a portion of said flexible container wall portion overlying the other end of said conduit of said spout means the same is adapted for removal of substance from said container.

10. In a container having a container wall, in combination, a flexible container wall portion formed of flexible sheet material; substantially rigid, elongated spout means arranged within said container inside of said flexible container wall portion and having a surface portion in contact with the inner face of said flexible container wall portion, said spout means formed with an elongated conduit one end of which opens into the interior of said container and the other end of which opens into said surface portion of said spout means which is in contact with the inner face of said flexible container wall portion, said substantially rigid, elongated spout means including a portion of smaller transverse dimensions interposed between end portions of greater transverse dimensions; and thermoplastic holding means integral with said flexible container wall portion surrounding and situated between the ends of said elongated spout means in the area of said portion of smaller transverse dimensions and engaging said flexible container wall portion with a portion of said flexible container wall portion and of said spout means extending outwardly in contact with each other for holding said spout means within said container with said surface portion thereof in contact with said inner face of said flexible container wall portion, whereby said holding means are holding said spout means in inoperative condition without any possibility of removal of substance from said container through said spout means without removal of at least a portion of said flexible container wall portion and whereby upon forming an opening through a portion of said flexible container wall portion overlying the other end of said conduit of said spout means the same is adapted for removal of substance from said container.

11. A container as defined in claim 7, wherein the surface portion of said spout means which is in contact with the outer face of said flexible container wall portion includes roughened portions to prevent sliding disengagement of said spout surface and said container wall portions.

12. A container as defined in claim 7, wherein said holding means are welded to said outer face of said flexible container wall portion.

References Cited in the file of this patent

UNITED STATES PATENTS

1,124,495	Mahn	Jan. 12, 1915
1,287,935	Fegley	Dec. 17, 1918
2,202,652	Glidden	May 28, 1940
2,349,962	Harris	May 30, 1944
2,525,360	Lage	Oct. 10, 1950
2,628,911	Horan	Feb. 17, 1953
2,628,912	Horan	Feb. 17, 1953
2,696,342	Toborg	Dec. 7, 1954
2,780,396	Larrabee	Feb. 5, 1957
2,812,764	Crisp	Nov. 12, 1957
2,844,290	Slade	July 22, 1958
2,939,598	Donleavy	June 7, 1960

FOREIGN PATENTS

505,271	France	July 27, 1920
708,850	Great Britain	May 12, 1954