Sept. 8, 1953 S. M. BODOLAY ET AL 2,651,578

PACKAGE AND METHOD OF MAKING IT

Filed Dec. 13, 1949 2 Sheets-Sheet 1

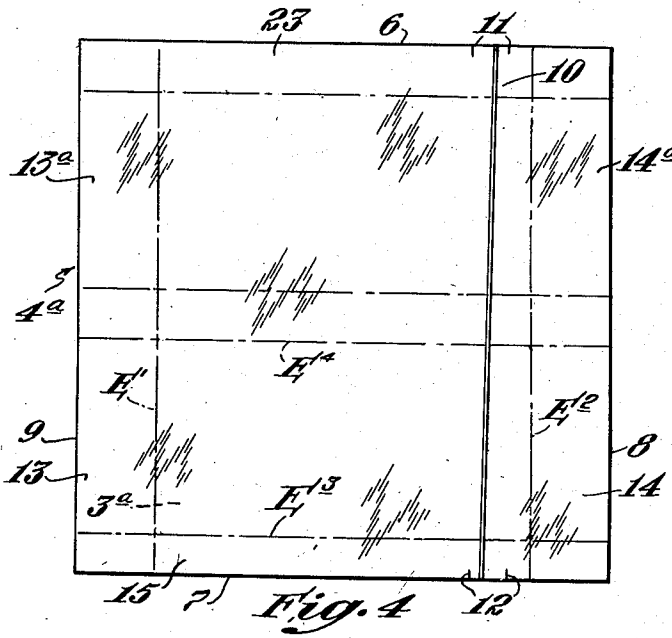



Fig. 4

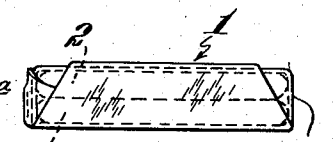



Fig. 3

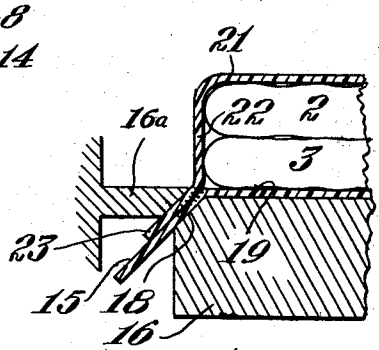



Fig. 5

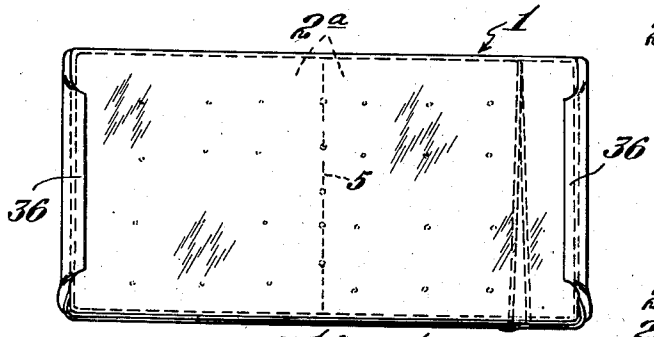



Fig. 1

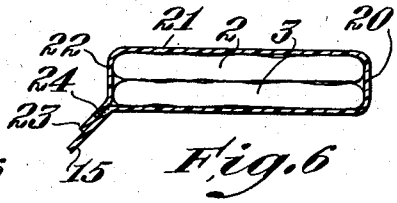



Fig. 6

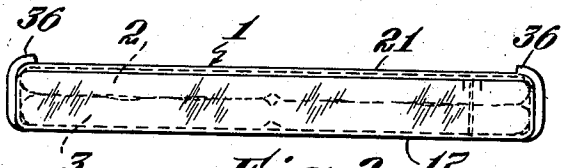



Fig. 2

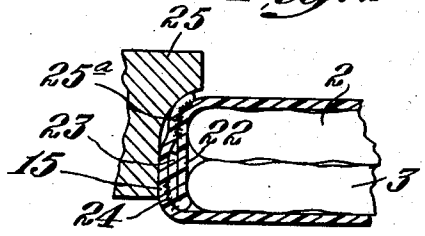



Fig. 7

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Sept. 8, 1953 S. M. BODOLAY ET AL 2,651,578

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2 Sheets-Sheet 2

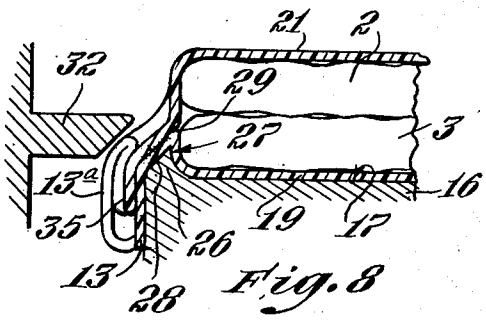



Fig. 8

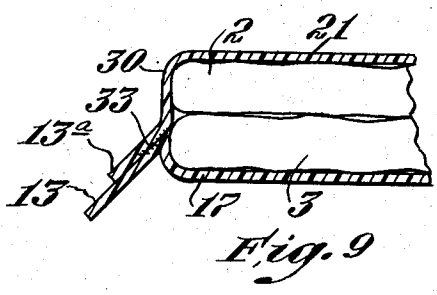



Fig. 9

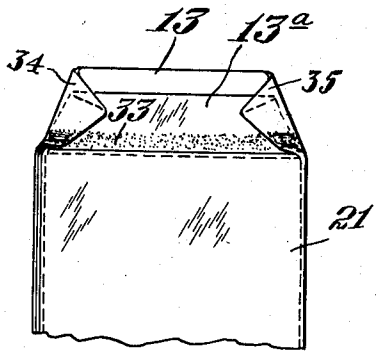



Fig. 10

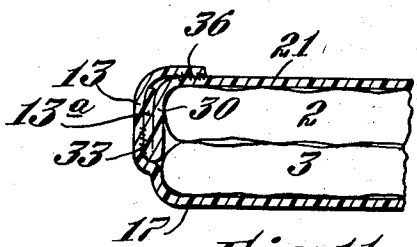



Fig. 11

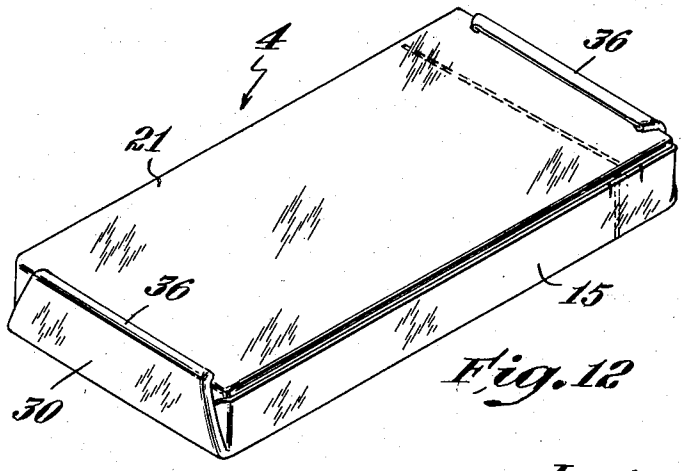



Fig. 12

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# UNITED STATES PATENT OFFICE

2,651,578

## PACKAGE AND METHOD OF MAKING IT

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Application December 13, 1949, Serial No. 132,696

14 Claims. (Cl. 99—171)

1

This invention pertains to the packaging of wafer-like articles such, for example, as crackers, thin cookies, fancy biscuits and the like, hereinafter referred to as "wafers," and relates more particularly to a novel method of making an enclosing wrapper for such wafer-like articles and to a novel package resultant from the practice of said method.

Crackers are customarily served as an accompaniment to soups, fruit juices and other foods and drinks and when thus served, should be crisp and fresh. In the endeavor to retain the original crispness and flavor and for sanitary and other reasons, the better class of restaurants and other eating places customarily serve crackers in individual packages. Since crackers of the same kind differ from each other in dimensions and to some extent in shape, previous attempts to encase them in a wrapper of sheet material, so as to form a package for individual serving, have not been successful—the crackers being too fragile to withstand the pressure to which they are subjected by customary wrapping machinery. Moreover, if wrapped too tightly, the wrapper often bursts by reason of shrinkage of the wrapper or swelling of the contents. For these reasons it has become customary to prepare such individual servings by placing two or more crackers loosely in an envelope of cellophane or the like, but while this mode of packaging assists in protecting the crackers from dust and to some extent from moisture, it is not adequate to prevent the crackers from absorbing moisture and losing their crispness if they are not used for some considerable time after packaging. Moreover, the looseness of the crackers within the envelope may result in causing them to crumble and crack and thus lose the desired fresh appearance. The present invention has for one object the provision of a novel casing or wrapper for crackers or the like. A further object is to provide a novel package comprising two or more crackers disposed one above the other and in registry, and a wrapping or casing designed to prevent substantial relative movement and consequent crumbling but which permits normal swelling of the crackers or shrinkage of the wrapper itself without bursting or opening of its seams, and which at the same time is so well sealed as adequately to prevent the entry of moisture. A further object is to provide a cracker package comprising a plurality of crackers of the saltine type arranged one above the other and in registry, and a casing or wrapping of thin, transparent moisture-impervious sheet material having

2

marginal portions which are overlapped and having means so uniting the overlapped marginal portions along spaced substantially parallel lines as to provide a double seal for the exclusion of moisture. A further object is to provide a cracker package wherein a plurality of substantially rectangular crackers are arranged in registry, one above the other, and including a thin, moisture-impervious casing or wrapper which houses the crackers and whose marginal portions are overlapped and sealed together along a line parallel to and closely adjacent to the outer longitudinal edge of the lowermost cracker. A further object is to provide a cracker package comprising a plurality of substantially rectangular crackers disposed one above the other in registering relation and a thin moisture-impervious wrapper of synthetic plastic, the wrapper having marginal portions which extend beyond the end edges of the crackers and also having marginal portions which extend beyond one longitudinal edge of each cracker, the marginal portions adjacent to each of said edges being overlapped and being fused together along spaced lines thereby providing a double seal to prevent the entry of moisture. A further object is to provide a method of making a casing or wrapper for crackers or the like comprising sheet material having lapped, heat-sealed seams or joints formed without applying substantial pressure to the crackers or other enclosed articles, thereby avoiding the crushing of the crackers and providing a casing of substantially fixed dimensions, regardless of minor variations in size of the enclosed articles. A further object is to provide a method of sealing the wrapper by pressing the overlapped margins of the wrapper material between substantially parallel, rigid surfaces, independent of the contents of the package being made. A further object of the invention is to provide a novel method of packaging crackers or the like so that they are thoroughly and adequately sealed against atmospheric moisture. Other and further objects and advantages of the invention will be pointed out in the following more detailed description and by reference to the accompanying drawings wherein

Fig. 1 is a plan view of a cracker package according to the present invention and comprising superposed duplex crackers of the saltine type;

Fig. 2 is an edge elevation of the package of Fig. 1;

Fig. 3 is an end elevation of the package of Fig. 1;

Fig. 4 is a plan view of a wrapper sheet useful

in the performance of the method of the present application;

Fig. 5 is a fragmentary, vertical section, to larger scale, illustrating the step of heat-sealing the overlapped marginal portions of the wrapper at one longitudinal edge of the package;

Fig. 6 is a view similar to Fig. 5, to smaller scale, showing the arrangement of the wrapper at the completion of the heat-sealing operation;

Fig. 7 is a view similar to Fig. 6 showing the overlapped, longitudinal, marginal portions of the wrapper as having been turned upwardly and heat-sealed adjacent to the upper surface of the package;

Fig. 8 is a view similar to Fig. 5 but illustrating the first heat-sealing step in uniting the overlapped margins of the wrapper at one end of the package;

Fig. 9 is a fragmentary section showing the overlapped margins of the wrapper at the completion of the first heat-sealing operation at the end of the package;

Fig. 10 is a fragmentary plan view showing the folded-in corners of the end margins subsequent to the first heat-sealing of the end margins;

Fig. 11 is a view similar to Fig. 9 but showing the end margins at the completion of the second heat-sealing operation; and

Fig. 12 is a perspective view of the completed casing or wrapper, but omitting the contents.

Referring to the drawings, the numeral 1 designates a package of crackers illustrative of the present invention. This package comprises two crackers 2 and 3 (Fig. 2) disposed one above the other in registering relation and enclosed in an airtight wrapper 4 (Fig. 12) which is of thin, flexible, moisture-impervious, sheet, heat-sealing material, preferably transparent, although it may be colored if desired. For instance, the sheet material may be a synthetic plastic, for example, cellophane, or a thermoplastically coated metal foil, such as aluminum foil.

The crackers here illustrated by way of example of the utility and practice of the invention are of the saltine type, being duplex crackers each having a line of weakness formed by perforations indicated at 5 so that the two parts of the cracker may be separated easily. These crackers (here illustrated by way of example) are customarily 4 inches long and 2 inches wide and slightly less than $\frac{5}{16}$ inch in thickness so that the package consisting of two superposed crackers may approximate $\frac{9}{16}$ of an inch in thickness. However, the above dimensions are given merely by way of illustration, it being understood that the invention is applicable to the formation of packages employing crackers of all sizes and dimensions and of different types as well as other wafer-like articles, for example cookies or fancy biscuits.

The wrapper 4 is made from a sheet $4^a$ (Fig. 4) of the selected wrapping material, preferably a synthetic plastic such for instance as cellophane, which is capable of being heat sealed. For use in making the package here illustrated, comprising the crackers above referred to, this sheet or blank $4^a$ may be approximately 5½ inches wide, that is to say horizontally, and 5⅝ inches long, having the parallel, transverse top and bottom edges 6 and 7 and the parallel right and left edges 8 and 9 respectively.

Preferably this blank $4^a$ is provided with a strong rip cord 10, preferably a cord made of cotton with a synthetic plastic coating. Such a cord may be heat sealed to the sheet material preparatory to the cutting of the blanks $4^a$. This thermoplastically coated cord may be united to the sheet material by heat and pressure alone and without the use of a solvent. If a solvent be employed in providing an easy opening tab, the odor of the solvent persists even after the solvent has apparently evaporated, and would impart an offensive flavor to the crackers encased within the wrapper. This cord extends from one edge 6 to the other edge 7, preferably being slightly inclined with reference to the edge 8. Preferably, to facilitate the ripping operation, slits 11 and 12 are provided at each side of the cord 10, extending inwardly from the transverse edges 6 and 7. These slit portions are provided at the opposite ends of the rip cord to facilitate grasping the cord in ripping the wrapper from the package.

Having prepared this wrapper blank $4^a$, the cracker 3 which is to be the lowermost cracker in the package, is located on this wrapper blank in the space $3^a$ in Fig. 4, with its lateral edges at $E'$ and $E^2$, spaced inwardly from the edges 9 and 8 respectively, of the wrapper so as to leave the marginal portions 13 and 14 of the wrapper at each end of the cracker. The cracker is likewise arranged so that one longitudinal edge is located at $E^3$, spaced from the edge 7 so as to leave a marginal portion 15 of the blank projecting beyond the edge at $E^3$, the other longitudinal edge of the cracker then being at $E^4$. As a practical matter, the crackers 2 and 3 are assembled and placed as a unit on the blank. However, the crackers and blank may be otherwise associated so as to bring them in the relative position illustrated in Fig. 4. Before placing the crackers on the blank, the latter is placed upon a suitable support or abutment 16 (Figs. 5 and 8) which may, for example, be a rigid steel die block having a downwardly and outwardly sloping beveled face 18 over which the margin 15 of the blank projects in assembling the parts. After having assembled the parts in this way so that they rest on the abutment block 16, the edge 6 of the wrapper is carried upwardly and about the assembled crackers, the wrapper blank bending along the line $E^4$ so as to form the vertical edge wall 20 (Fig. 6). The wrapper also bends about the upper rear edge of the upper cracker 2 to form the horizontal top wall 21 of the wrapper, and again bends down about the forward upper edge of the upper cracker to form the front wall 22 of the package. The marginal portion 23 of the wrapper, adjacent to the edge 6, extends down substantially parallel to the projecting margin 15 which overlies the beveled face 18 of the abutment. A heated presser $16^a$, having a beveled lower corner parallel to the surface 18 of the die block 16, is now moved into contact with the margin 23 and is caused to press the margin 23 forcibly against the margin 15. Since the member $16^a$ is heated, this pressure causes the margins 23 and 15 to coalesce within a narrow transverse area of approximately the dimensions of the inclined beveled surface 18. Because the surface 18 slopes downwardly and away from the lower face of the bottom cracker, the pressure may be applied without injury to the crackers but the area of coalescence or heat seal extends very close to the edge of the cracker (Fig. 6) so that the crackers are closely embraced by the wrapper. However, the part $16^a$ exerts no direct pressure on the crackers, the seal 24 (Fig. 6) being formed directly between the parts 16 and $16^a$, and its location is not changed by any slight irregularities

which may exist in the size or shape of the crackers being wrapped.

After the first heat-sealing operation, the united marginal flaps 15 and 23 are turned upwardly so as to stand substantially vertical, as shown in Fig. 7, bending sharply along the lower forward edge of the lower cracker. As illustrated, the forward flap 15 is somewhat wider than the flap 23, so that the uppermost portion of the flap 15 extends beyond the edge of the flap 23. This upwardly projecting edge portion of the flap 15 is now pressed (preferably by means of a heated die 25, Fig. 7) against the body of the wrapper, near the upper front edge of the upper cracker, only slight pressure being employed so as to tack the flap 15 to the body of the wrapper along a second-sealing area 25a, thus producing a double seal and giving a neat appearance.

Having drawn the wrapper blank around the crackers and having provided a two-fold seal at one longitudinal edge wall of the package, the end margins of the resultant embryo package are next folded and sealed. As illustrated in Fig. 8, the abutment or die block 16 is provided along its right and left ends with upstanding ridges 26 having curved inner faces 27 and downwardly and outwardly sloping beveled faces 28. The lower cracker 3, with the portion 17 of the wrapper underlying it, extends from the inner surface 27 of one of the ridges 26 to the inner surface 27 of the corresponding ridge (not shown) at the opposite end of the block. The surfaces 27 and 28 meet at an upwardly acute edge 29. Initially the marginal portions 13 and 14 at opposite edges of the wrapper blank extend outwardly and upwardly over the edges 29, and the corresponding marginal portions 13a and 14a (which now form extensions of the upper wall 21 of the embryo wrapper) overlie the marginal portions 13 and 14 respectively. The superposed marginal portions are now bent downwardly onto the surface 28 (Fig. 8) thus drawing the wrapper in a transverse direction about the crackers. Preferably, before the heat sealing operation is performed, the corners 34 and 35 of the end margins (Fig. 10) are folded inwardly along diagonal lines. Heated presser members 32 (Fig. 8), one of which is arranged at each end of the stationary block or die 16, (these presser members 32 having beveled lower surfaces of the same slope as the surfaces 28) are moved into contact with the upper flaps 13a and 14a respectively, and force these flaps into contact with the flaps 13 and 14 respectively. Because the part 32 is heated, the pressure of the flaps between the rigid dies 16 and 32 causes the flaps to fuse at narrow transversely extending areas having substantially the dimensions of the surfaces 28. As shown in Fig. 8, the height of the ridge 26 is such that the edge 29 is about mid-way of the height of the lowermost cracker 3 and as the edge 29 is acute, the action of the dies is to form a sharp fold line at the edge, and the area of fusing extends substantially to the fold line. The pressure is exerted between the opposed dies, no substantial force being applied to the crackers such as might crumble them. A perfect heat seal is thus made possible since as much pressure as necessary may be applied without damage to the crackers.

After the heat seal 33 (Fig. 11) has been formed, the united flaps 13 and 13a and 14 and 14a are then turned upwardly, as illustrated in Fig. 11, and their upper margins are tacked to the body of the wrapper along lines such as the line



36 of Fig. 11, in the same way as illustrated in Fig. 7.

The formation of the heat seals at 33 and 36 provides a double seal at each end of the package. The wrapper embraces the crackers so that they cannot shift relatively to each other to any substantial extent, and thus crumbling is reduced to a minimum. Moreover, the side and end walls of the package are smooth and substantially perpendicular to the top and bottom surfaces so that the package is of neat appearance and capable of being packed with similar packages in a container without loss of space. Furthermore, the tough wrapper holds the crackers together so that they act as a unit, reinforcing each other against forces which tend to break them, and the packaged crackers are much less subject to breakage than though they were merely placed loosely in an envelope or similar container.

The above described operations may be performed by hand or by the use of such simple implements as above described, or may be carried out by properly organized machinery. It is further to be understood that while heat sealing is preferred, the double sealing at one longitudinal edge and at the ends may be provided in other ways, for example by the employment of adhesive or the like. However heat sealing is preferable because it may be performed very rapidly and the seal thus formed is not affected by atmospheric moisture.

While the wrapper has herein been referred to as of "moisture-impervious" material it is to be understood that this term is used in a relative sense and as suggestive of the moisture-resistant characteristic of such resinous materials as cellophane and the like which, although resistant to moisture for long periods, are not absolutely and completely impervious to the passage of moisture.

When the completed package is to be opened it is merely necessary to seize the wrapper material between the lines 11—11 or 12—12, whichever area of the wrapper is at the exterior, after the completion of the package, and to exert force tending to unwrap the rip cord 10 from around the package. The ripping of this cord from around the package removes a strip of the wrapper, thus leaving the wrapper open at one end so that the crackers are readily accessible.

It may again be noted that the heat seals formed at 24 and 33 between the opposed surfaces of the rigid dies are definitely located by the dimensions of the die 16, and that the formation of these heat seals is independent of the exact size or shape of the cracker, and that as much pressure as necessary to insure a good seal may be employed in forming these heat seals without any regard to the frangible character of the articles being wrapped. Furthermore, the novel method of wrapping is not limited to crackers or wafers of rectangular shape but is readily applicable to the wrapping of wafers of other shapes and dimensions, and whether one or a greater number of wafers are to be enclosed in the wrapper.

While for ease in description reference has been made to "bottom" and "top" wafers, and to folding or bending the wrapper upwardly or downwardly, etc., such terms are not to be regarded as limiting, since the package may be formed with the wafer disposed in any convenient position.

While certain dimensions have herein been suggested as illustrative and while a particular order of steps has been suggested as desirable,

it is to be understood that the invention is not thus to be limited but only as defined in the following claims.

We claim:

1. A package comprising a wafer and a protective casing for the wafer, the casing consisting of a single thin sheet of transparent moisture-impervious material, the sheet forming substantially parallel top and bottom walls, side walls and end walls, marginal portions of the sheet being overlapped along one side wall and at opposite ends of the package, respectively, overlapping portions of the material, at opposite ends of the package and adjacent to said side wall, being heat sealed together along each of two narrow, vertically spaced, horizontal areas one of which is adjacent to the top wall of the package.

2. A package comprising two substantially rectangular elongate wafers disposed one above the other in registering relation and a protective casing for the wafers, the casing consisting of a single thin sheet of transparent, moisture-impervious material, the sheet forming substantially parallel top and bottom walls, side walls and end walls, marginal portions of the sheet being overlapped along one transverse side wall, and other marginal portions being overlapped at opposite ends respectively of the package, the sheet material being tensioned snugly about the wafers and being of a type capable of being heat sealed, each set of overlapped margins being heat sealed together along a narrow area extending along one edge of the lowermost wafer and extending close to said edge, and each set of overlapping margins being also fused together along a second narrow area extending along an edge of the uppermost wafer and close to said edge.

3. A package comprising two substantially rectangular wafers disposed one above the other in registering relation and a protective casing for the wafers, the casing consisting of a sheet of thin, transparent, moisture-impervious material enveloping the wafers, the casing comprising top and bottom walls, side walls and end walls, the side and end walls being substantially perpendicular to the top and bottom walls, the marginal portions of the sheet being overlapped, said overlapping marginal portions being hermetically sealed together along a narrow area closely adjacent to the edge of one of said wafers, the same overlapping marginal portions being hermetically sealed together along a second narrow area adjacent to the corresponding edge of the other wafer thereby providing a double seal to prevent the entry of moisture.

4. A package comprising a plurality of wafers disposed one above the other in registering relation and a protective casing for the wafers, the casing consisting of a single sheet of thin, flexible, moisture-impervious, synthetic resin and comprising portions forming parallel top and bottom walls and other portions forming transverse side walls and end walls, the side and end walls being substantially perpendicular to the top and bottom walls, the bottom wall having a marginal flap at its free transverse edge, the lower edge of one transverse side wall also having a marginal flap, said flaps being heat sealed together along a narrow transversely extending area closely adjacent to the junction of the bottom wall and said latter transverse side wall, both flaps extending upwardly, from the area at which they are so sealed together, to the upper edge of the last-named transverse side wall, the same flaps being heat sealed together and to said last-named transverse side wall along a second narrow, transversely extending area adjacent to the junction of the latter side wall with the top wall.

5. A package comprising two substantially rectangular wafers disposed one above the other in registering relation and a protective casing for the wafers, the casing consisting of a single sheet of thin, flexible moisture-impervious, synthetic resin and comprising portions forming substantially parallel top and bottom walls and other portions forming transverse side walls and end walls, the side and end walls being substantially perpendicular to the bottom and top walls, the bottom wall having marginal flaps at the opposite ends of the package and each end wall having a marginal flap at its lower edge, the marginal flaps at each end of the bottom wall being hermetically sealed to the marginal flaps of the corresponding end walls, the sealing being along transversely extending lines closely adjacent to the junctions of the bottom and respective end walls, the corners of the flaps at each end being turned inwardly along diagonal lines, both marginal flaps at each end of the package extending upwardly from the aforesaid lines at which they are sealed together, the free edge portions of the marginal flaps at each end of the package being coalesced with the wrapping material adjacent to the junction of each end wall with the top wall.

6. That method of packaging wafers which comprises as steps providing a thin, flexible wrapper sheet of moisture-impervious thermoplastically adhesive material, disposing at least one wafer upon the wrapper sheet adjacent to but spaced from one transverse edge of the latter, thereby leaving a transverse marginal flap of the sheet projecting beyond the wafer, drawing the sheet up and about the wafer and disposing its free transverse margin in overlapping relation to the aforenamed marginal flap and so that said overlapped margins extend beyond the edge of the wafer, and while rigidly supporting said projecting flaps applying heat and pressure to the overlapping margins along a line closely adjacent to the edge of the wafer but without applying substantial pressure to the wafer, thereby heat-sealing the overlapped margins along a line close to the lower longitudinal edge of the wafer, turning the overlapping margins up and uniting the upturned marginal flap to the wrapping material adjacent to the upper longitudinal edge of the wafer.

7. That method of packaging wafers which comprises as steps providing a thin, flexible wrapper sheet of moisture-impervious thermoplastically adhesive material, disposing a plurality of superposed registering wafers upon the wrapper sheet adjacent to but spaced from one transverse edge of the latter, thereby leaving a transverse marginal flap of the sheet projecting beyond the lowermost wafer, drawing the sheet up and about the wafers and disposing its free transverse margin in overlapping relation to the aforenamed marginal flap and so that said overlapped marigns project beyond the edge of the lowermost wafer and while rigidly supporting said projecting margins applying heat and pressure to the overlapping margins along a line closely adjacent to the edge of the lowermost wafer thereby hermetically to seal said margins together, and then turning said margins up and hermetically sealing the marginal flaps together and to the wrapper sheet along a line close to the longitudinal edge of the uppermost wafer.

8. That method of packaging wafers which comprises as steps providing a thin, flexible

wrapper sheet of moisture-impervious thermoplastically adhesive material, disposing a plurality of superposed registering wafers upon the wrapper sheet adjacent to but spaced from one transverse edge of the latter, thereby leaving a transverse marginal flap of the sheet projecting beyond the lowermost wafer, drawing the sheet up and about the wafers and disposing its free transverse margin in overlapping relation to the aforenamed marginal flaps and so that the overlapping flaps project diagonally downward from the edge of the lowermost wafer and, while rigidly supporting said diagonally disposed overlapping flaps, subjecting them to heat and pressure along a transversely extending area close to the transverse edge of the lowermost wafer thereby to fuse said margins together.

9. That method of packaging wafers which comprises as steps providing a thin, flexible wrapper sheet of moisture-impervious thermoplastically adhesive material, disposing at least one wafer upon the wrapper sheet with the opposite edges of the wafer spaced substantially equally from the lateral edges of the sheet, thereby leaving an end margin of the wrapper sheet projecting at each end of the wafer, drawing the wrapper about the wafer and rigidly supporting the transverse margins of the wrapper in overlapping relation and so that they slope downwardly and outwardly from the lower edge of the wafer while subjecting said margins to heat and pressure to unite them, thereby forming an embryo package, overlapping the projecting upper and lower portions of the end margins of the wrapper at each end of the package, rigidly supporting said overlapped margins at each end so that they slope downwardly and outwardly from the lower lateral edge respectively of the wafer, subjecting the overlapped end margins along a line close to the edge of the lowermost wafer to heat and pressure to unite them, turning up the overlapped and united marginal portions at each end of the package and fusing the overlapped end marginal portions to the wrapper along lines closely adjacent to the upper lateral edge of the wafer respectively.

10. That method of packaging wafers which comprises as steps providing a thin, flexible wrapper sheet of moisture-impervious thermoplastic material, disposing a plurality of superposed registering wafers upon the wrapper sheet so as to leave margins of the wrapper projecting beyond a transverse edge and both end edges of the lowermost wafer, tensioning the wrapper sheet about the wafers and placing the transverse marginal portions of the wrapper in overlapping relation, thereby holding the wafers tightly together, rigidly supporting said overlapped transverse marginal portions so that they project beyond the edge of the lowermost wafer and applying heat and pressure to heat-seal the overlapped transverse marginal portions of the wrapper to form an embryo package, sealing together the upper and lower end marginal portions of the wrapper at the opposite ends, respectively, of the package, and thereafter up-turning the overlapped united marginal portions at the side and each end of the package to lie against the side and against the ends, respectively, of the package, and sticking said up-turned marginal portions at the side and each end of the package to the body of the wrapper proper, adjacent to the upper edges of the uppermost wafer.

11. That method of packaging wafers which comprises as steps providing a thin, flexible wrapper sheet of moisture-impervious thermoplastic material, disposing two rectangular wafers in superposed registering relation upon the wrapper sheet so that marginal portions of the wrapper sheet project beyond the ends and a transverse edge, respectively, of the lowermost wafer, drawing the wrapper sheet up and about the wafers and rigidly supporting its transverse and end marginal portions, respectively, in overlapping relation and so that they incline downwardly from the edges of the lower wafer, subjecting said overlapping margins to heat and pressure, thereby uniting the marigns, at each end and along said transverse edge respectively, along narrow, transversely extending areas which extend close to the edges of the lowermost wafer, and turning the overlapped and united marginal portions at each end and at said transverse edge respectively, vertically up and sticking said upturned marginal portions to the body of the wrapper at narrow areas extending along the upper transverse and end edges of the upper wafer.

12. That method of packaging wafers which comprises as steps providing a thin, flexible wrapper sheet of thermoplastic material, disposing a plurality of rectangular wafers in superposed registering relation upon the wrapper sheet so that the end margins of the wrapper sheet project beyond the respective ends of the lower wafer, drawing the wrapper sheet about the wafers and uniting its transverse marginal portions, thereby forming an embryo package wherein the respective end margins of the wrapper sheet comprise upper and lower overlapped portions, folding in the corners of the united margins along diagonal lines at each end of the package, bending said upper and lower overlapped margins at each end of the package along lines approximately midway the height of the lowermost wafer so that they project downwardly and rigidly, supporting said downwardly projecting margins while subjecting said overlapping margins to heat and pressure along lines closely adjacent to the edges of the lowermost wafer, thereby fusing said overlapping portions together at a narrow area which extends close to the edge of the lowermost wafer, turning the united marginal portions vertically up at each end of the package, and fusing said upturned marginal portions at each end of the package to the body of the wrapper at narrow areas extending along the upper lateral edges of the upper wafer.

13. That method of packaging wafers which comprises as steps providing a thin, flexible wrapper sheet of thermoplastic material, disposing a plurality of superposed registering wafers upon the wrapper sheet with the opposite ends of the lowermost wafer spaced substantially equally from the end edges of the sheet, thereby leaving an end margin of the wrapper exposed at each end of the lowermost wafer, drawing the wrapper about the wafers and heat-sealing the transverse marginal portions of the wrapper to each other along a line adjacent to the transverse lower edge of the lowermost wafer, thereby forming overlapping upper and lower portions of the end margins of the wrapper, which project beyond the end edges of the wafer, rigidly supporting said projecting margins while applying heat and pressure thereto along lines closely adjacent to each lateral edge, respectively, of the lowermost wafer, thereby uniting the overlapping margins at each end, and then turning said overlapping united margins at each end upwardly and sticking them to the wrapper along lines adjacent to the

upper lateral edges, respectively, of the uppermost wafer.

14. That method of packaging wafers which comprises as steps providing a thin, flexible wrapper sheet of thermoplastic synthetic resin, disposing a plurality of superposed registering wafers upon the wrapper sheet with the opposite edges of the lowermost wafer spaced substantially equally from the respective end edges of the sheet, thereby leaving an end margin of the wrapper exposed at each end edge of the lowermost wafer, drawing the wrapper about the wafers so that its transverse marginal portions overlap while concomitantly causing upper and lower portions of the respective end margins to overlap, rigidly supporting the overlapping portions of the wrapper which project outwardly beyond each end edge of the lowermost wafer, drawing the overlapping end portions downwardly so that they lie in planes making acute angles



with the plane of the under surface of the lowermost wafer, and applying pressure and heat thereto to fuse the overlapping lateral marginal portions together along lines closely adjacent to the edge of the lowermost wafer.

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