Feb. 27, 1962 I. POWERS 3,022,613

PACKAGING METHOD

Filed June 15, 1959 3 Sheets-Sheet 1

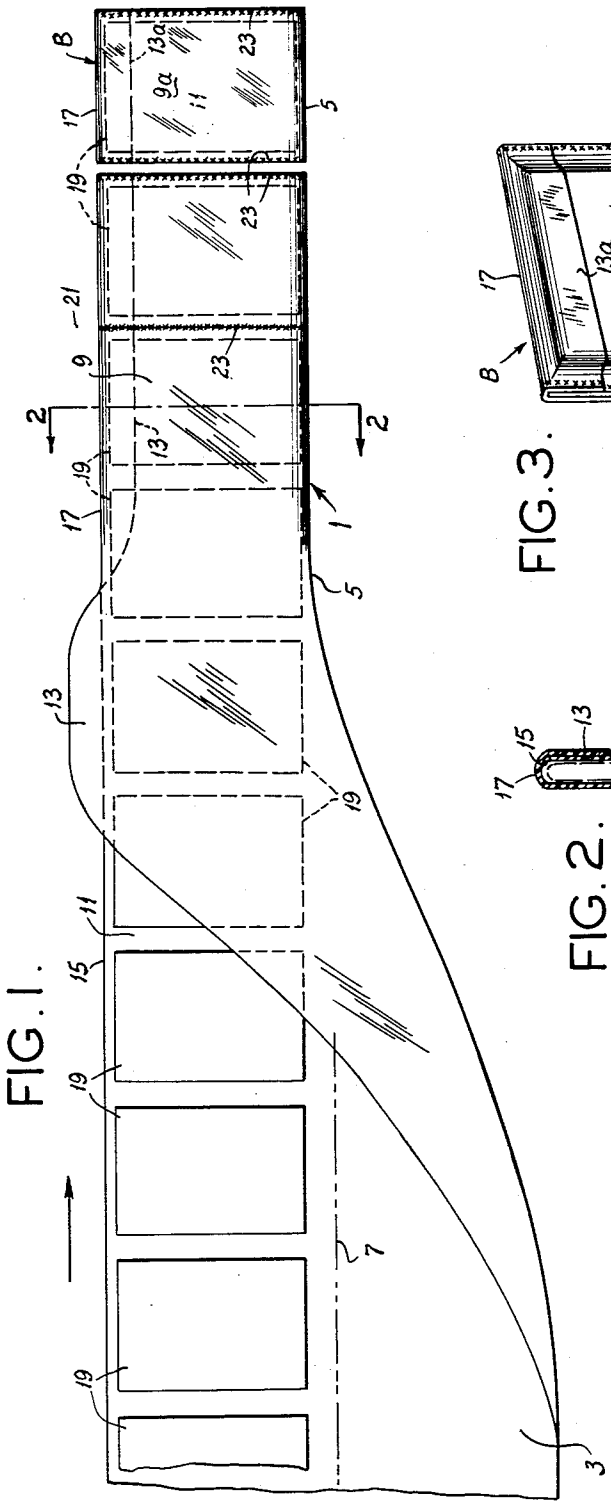



FIG. 1.

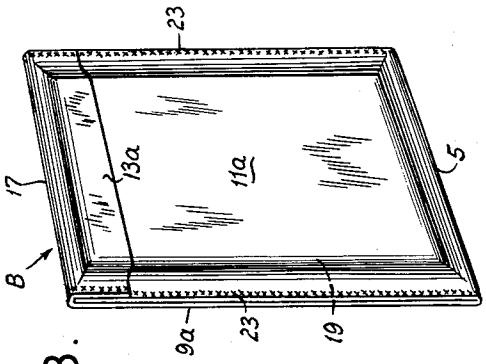



FIG. 3.

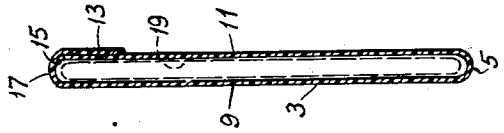



FIG. 2.

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PACKAGING METHOD

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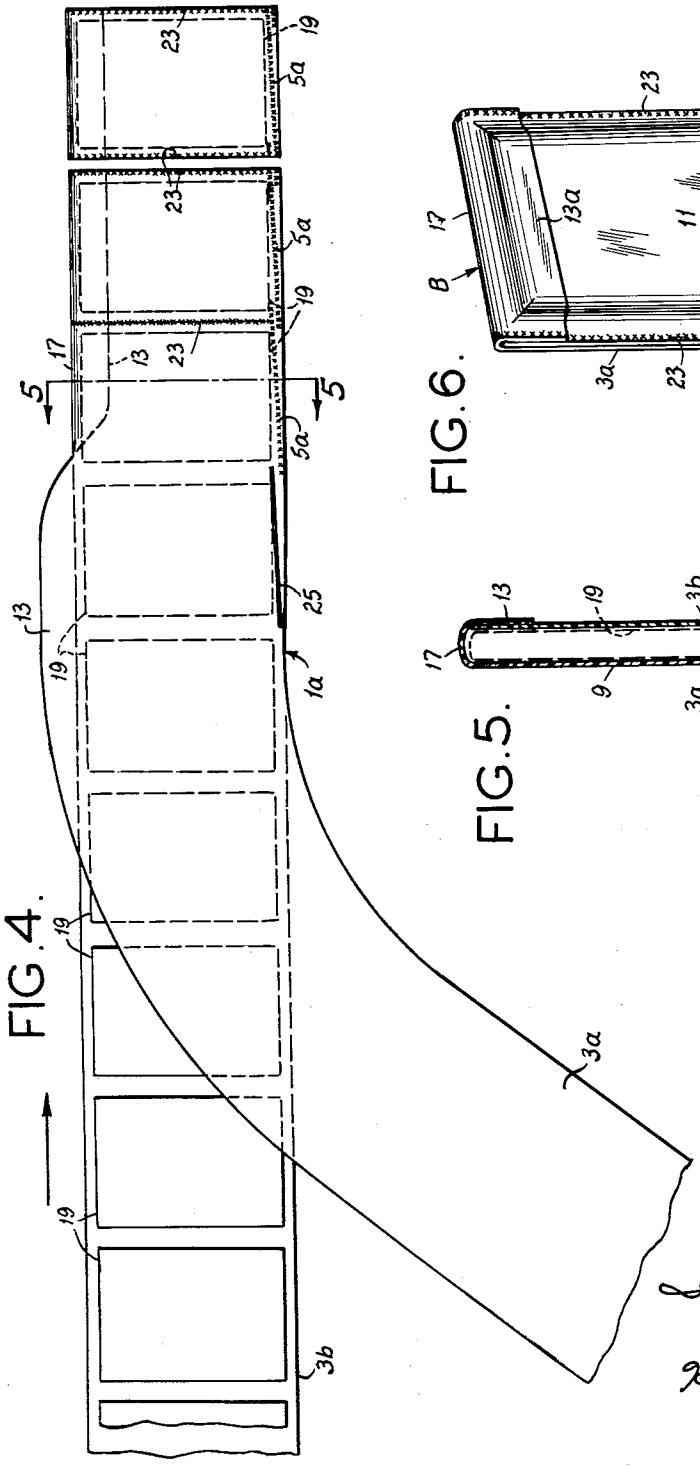



FIG. 4.




FIG. 6.




FIG. 5.

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PACKAGING METHOD

Filed June 15, 1959 3 Sheets-Sheet 3

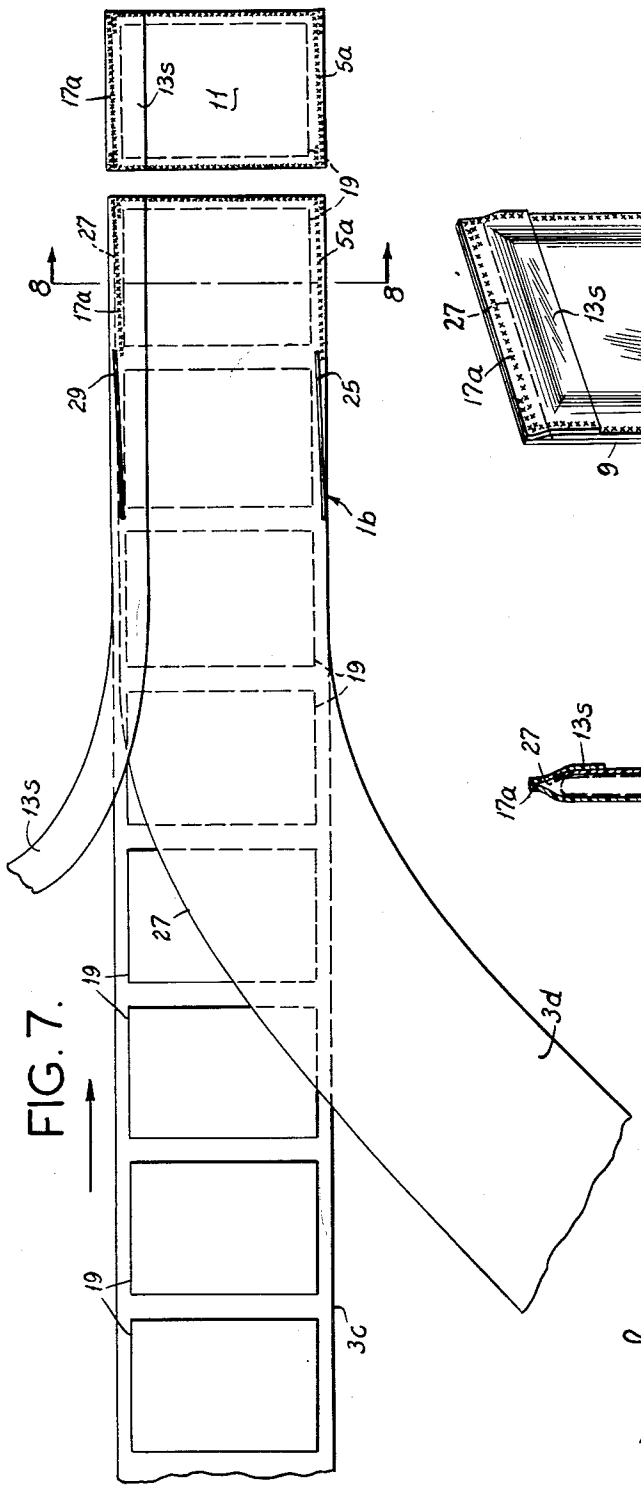



FIG. 7.

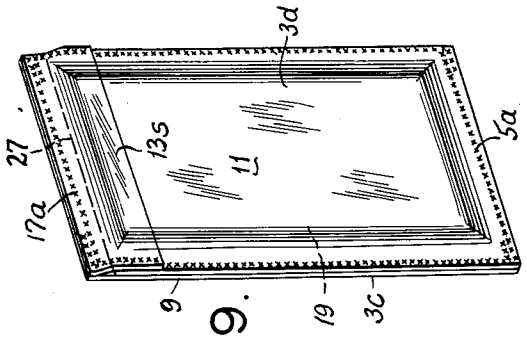



FIG. 9.

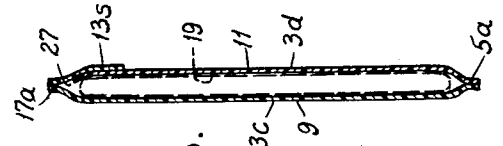



FIG. 8.

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United States Patent Office 3,022,613 Patented Feb. 27, 1962



# 3,022,613
# PACKAGING METHOD

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Filed June 15, 1959, Ser. No. 820,226
10 Claims. (Cl. 53—28)

This invention relates to packaging, and more particularly to methods of packing merchandise in plastic bags each having a closure flap adapted to be folded back away from closed position over the bag mouth to open the bag mouth for removal of the merchandise packed in the bag.

In the United States Patents 2,709,467 and 2,842,179 of Arthur D. Hoeppner, issued May 31, 1955, and July 8, 1958, respectively, there are shown bags made of flexible heat-sealable sheet plastic material, such as polyethylene, having a closure flap initially positioned exteriorly of one wall of the bag at the bag mouth. This flap is adapted to be folded over the mouth of the bag after the bag has been packed to close the bag, and adapted to be opened by reversely folding it to bring it back to its initial position. Such bags have come into widespread use for packaging a wide variety of merchandise, particularly soft goods such as shirts and other apparel, towels, etc. They are supplied by the bag manufacturer with the closure flap originally in open position. After the merchandise has been inserted in the bag through the mouth of the bag, the flap is folded over the mouth of the bag.

United States Patent 2,873,566 shows the formation of bags with a closure flap initially in the closed position over the mouth of the bag, the bottom end of the bag being left open. Merchandise is inserted in the bag through the open bottom, after which the bottom is sealed.

The packaging operations involved in each of the above instances involve the step of insertion of merchandise in a bag, and the step of closing the bag. The closing step in the case of United States Patents 2,709,467 and 2,842,179 involves the manipulation of the closure flap. The closing step in the case of United States Patent 2,873,566 involves the sealing of the bag bottom.

Among the several objects of this invention may be noted the provision of methods of packaging merchandise in bags in which the merchandise is associated with the material to be formed into bags prior to the formation of the bags, and in which packed bags issue from a packing line closed at both top and bottom, thereby accomplishing packaging without requiring insertion of merchandise through an open end of the bag and without requiring a bag-closing step as such; and the provision of a method such as described which is economical to carry out.

Essentially, the method comprises forming a continuous envelope having first and second superimposed walls joined along one edge thereof with the first wall having a flap-forming portion joined thereto along the other edge of the continuous envelope overlying the second wall on the outside thereof and free of the second wall, with a series of items of merchandise positioned within said continuous envelope between the walls thereof at spaced intervals along the length of the envelope. The envelope with the items therein is segmented on transverse lines between the items, and the segments are side-seamed throughout the width of the envelope, thereby to form individual bags each having merchandise therein with each bag having first and second walls joined at the bottom, seamed at the sides, and free of one another at the top, and having a closure flap derived from said flap-forming portion joined to the first wall at the upper



edge thereof overlying the upper portion of the second wall and having its ends seamed to the second wall at the bag side seams.

Other objects and features will be in part apparent and in part pointed out hereinafter.

The invention accordingly comprises the methods hereinafter described, the scope of the invention being indicated in the following claims.

In the accompanying drawings, in which several of various possible embodiments of the invention are illustrated,

FIG. 1 is a plan view illustrating a first method of this invention;

FIG. 2 is an enlarged section taken on line 2—2 of FIG. 1;

FIG. 3 is a perspective view of a completed package as made by the FIG. 1 method;

FIG. 4 is a plan view illustrating a second method of this invention;

FIG. 5 is an enlarged section taken on line 5—5 of FIG. 4;

FIG. 6 is a perspective view of a completed package as made by the FIG. 4 method;

FIG. 7 is a plan view illustrating a third method of this invention;

FIG. 8 is an enlarged section taken on line 8—8 of FIG. 7; and,

FIG. 9 is a perspective view of a completed package as made by the FIG. 7 method.

Corresponding reference characters indicate corresponding parts throughout the several views of the drawings.

Referring to FIG. 1 of the drawings, a continuous envelope 1 is shown as being formed from a continuous relatively wide web 3 of flexible heat-sealable sheet plastic material such as polyethylene. As shown, the envelope is formed by longitudinally folding the continuous web 3 on a longitudinal fold line 5 which is offset to one side of the longitudinal center line 7 of the web to provide first and second superimposed envelope walls 9 and 11 integrally joined along one longitudinal edge of the envelope by the fold at 5. Line 5 being offset from the longitudinal center line 7 of the web 3, the first wall 9 is wider than the second wall by the amount of the offset. This provides a marginal portion 13 of wall 9 which projects beyond the free edge 15 of wall 11, and which is folded over on a longitudinal fold line 17 substantially in register with edge 15 of wall 11 on the outside of wall 15 (lying underneath wall 11 as viewed in FIG. 1). This portion 13 (the width of which corresponds to the amount which line 5 is offset from center line 7) constitutes a flap-forming portion of the continuous envelope 1. This flap-forming portion 13 is joined to the first wall 9 along fold 17, which constitutes the other edge of the envelope from the fold or edge 5. It is free of the second wall 11.

The folding of the web 3 to form the envelope 1 is accomplished as the web (and envelope) are fed in the direction indicated by the arrow in FIG. 1 (toward the right). As the web 3 is fed toward the right, items of merchandise 19 (each of which may be a shirt, for examp'e) are placed on the web 3 at spaced intervals along the length of the web and on one side of the line 5 where the web is folded to form the envelope. As shown in FIG. 1, the items are placed on that portion of the web which becomes the wall 11 of the envelope. When the web is folded to form the envelope, wall 9 comes into position overlying the series of items on wall 11, and consequently the enve'ope 1 is made to contain a series of items 19 positioned between the envelope walls 9 and 11 at spaced intervals along the length of the

envelope. The spacing of the articles corresponds to the desired bag width, which is somewhat greater than the width of an item **19**.

The envelope **1** with the items **19** therein is then heat-sealed and segmented on transverse lines **21** at bag width intervals lying between the items **19**. This operation involves segmenting the envelope on lines **21**, and heat-sealing the walls **9** and **11** on both sides of each line of segmentation thereby to form heat-sealed side seams **23** for each segment extending throughout the width of the envelope. This operation may be carried out, for example, by feeding the envelope through a heat-sealing machine of a well-known type having a heated blade adapted to melt the plastic material to cut through the walls **9** and **11** and to fuse them together on opposite sides of the line on which the blade cuts through the walls. In this respect, it will be understood that the web **3** and envelope **1** may be intermittently fed forward a distance corresponding to the desired bag width, the blade operating during dwell intervals between successive feeding operations.

As a result of the above-described operations, bags B such as illustrated at the extreme right end of FIG. 1 and one of which is illustrated per se in FIG. 3 are segmented from the envelope **1**. Each bag contains an item **19**. Each bag has first and second walls **9***a* and **11***a* (derived from walls **9** and **11** of the envelope **1**) seamed at the sides by the heat seals **23** and free of one another at the top, and is closed at the bottom at fold **5**. Each bag has a closure flap **13***a* derived from flap-forming portion **13** of the envelope **1** joined to the wall **9***a* at fold **17** at the upper edge of wall **9***a*. This flap **13***a* overlies the wall **11***a* on the outside thereof, thus occupying a position closing the upper end of the bag, and has its end seamed by heat seals to the wall **11***a* at the sides of the bag along the lines of heat-sealed side seams **23**. Thus, there are produced bags in which merchandise is prepacked, each bag, as produced, having closure flap **13***a* already in closed position. To remove the merchandise from a bag, flap **13***a* is folded back to open up the bag by inserting the fingers under it adjacent the sides, and turning it inside out.

It will be readily understood that the method above described is readily adaptable to the production of bags with gussets at top and bottom such as are shown in the Hoeppner United States Patent 2,842,179.

FIGS. 4–6 illustrate a variation of the above within the scope of the invention wherein the envelope **1***a*, instead of being formed from a single web **3** of flexible heat-sealable sheet plastic material is formed from two individual webs **3***a* and **3***b* of such material, web **3***a* being wider than web **3***b* by the amount desired for the flap-forming portion **13** of the envelope. The envelope **1***a* is then formed by feeding web **3***a* over the items **19** on web **3***b*, and heat-sealing the webs together along edge **5***a* of the envelope, the seam at **5***a* then corresponding to the fold at **5** in the FIG. 1 method. Web **3***a* then forms wall **11** of the envelope and web **3***b* forms wall **9**. The sealing at **5***a* may be effected as by means of a heated sealing bar **25** such as illustrated in FIG. 4, operable during the dwell intervals between successive feeding operations. As shown, the length of bar **25** is greater than the width of the bags to be formed, hence it is slightly angled relative to the direction of web feed so that, when it comes down, its leading end will miss the trailing end of the previously formed seal **5***a*. This avoids burning through at the trailing ends of seal **5***a*, as might occur if bar **25** were parallel to the direction of web feed. Flap-forming portion **13** is folded over the same as in FIG. 1. Envelope **1***a* shown in FIGS. 4 and 5 is then essentially the same as envelope **1** of FIGS. 1 and 2 except that walls **9** and **11** are joined at the heat-sealed seam **5***a* instead of fold **5**. Otherwise, the method of FIG. 4 is the same as that of FIG. 1. The bags (see FIG. 6) made by the FIG. 4 method differ from those made by the FIG. 1 method only in having a heat-sealed bottom seam **5***a* instead of a bottom fold.

FIGS. 1 and 4 show the flap-forming portion **13** of the envelope as being derived from the top wall of the envelope (which overlies the merchandise), but it will be apparent that it would be equally feasible to derive portion **13** from the bottom wall by making the latter the wider wall.

FIGS. 7–9 illustrate another variation within the scope of the invention wherein the envelope **1***b* is formed from two individual webs **3***c* and **3***d* and a relatively narrow strip or tape **13***s*, each of flexible heat-sealable sheet plastic material. Web **3***c* is the bottom web, and is somewhat wider than web **3***d*. The envelope **1***b* is formed by feeding web **3***d* over the items **19** on web **3***c*, heat-sealing the webs together along edge **5***a* of the envelope as by means of heated sealing bar **25** (the same as in FIG. 4), feeding strip **13***s* into position at the other margin of the envelope overlying the other edge **27** of web **3***d*, and heat-sealing strip **13***s* and web **3***c* together along edge **17***a* of the envelope outward of edge **27** of web **3***d*, as by means of a heated sealing bar **29** like bar **25**. Web **3***c* then forms wall **9** of the envelope, web **3***d* forms wall **11**, and strip **13***s* forms the flap-forming portion. Envelope **1***b* shown in FIGS. 7 and 8 is then essentially the same as envelope **1***a* of FIGS. 4 and 5 except that wall **9** and strips **13***s* are joined at the top by the heat-sealed seam at **17***a* instead of fold **17**. Otherwise, the method of FIG. 7 is the same as that of FIG. 4. The bags (see FIG. 9) made by the FIG. 7 method differ from those made by the FIG. 4 method only in that flap **13***a* is joined to wall **9***a* by a heat-sealed seam **17***a* instead of a fold.

In view of the above, it will be seen that the several objects of the invention are achieved and other advantageous results attained.

As various changes could be made in the above methods without departing from the scope of the invention, it is intended that all matter contained in the above description or shown in the accompanying drawings shall be interpreted as illustrative and not in a limiting sense.

I claim:

1. The method of packaging merchandise comprising forming a continuous envelope having first and second superimposed walls joined along one edge thereof with the first wall having a flap-forming portion joined thereto along the other edge of the continuous envelope overlying the second wall on the outside thereof and free of the second wall, with a series of items of merchandise positioned within said continuous envelope between the said walls thereof at spaced intervals along the length of the envelope, and segmenting the envelope with said items therein on transverse lines between said items and side-seaming said segments throughout the width of the envelope, thereby to form individual bags each having merchandise therein with each bag having first and second walls joined at the bottom, seamed at the sides, and free of one another at the top, and having a closure flap derived from said flap-forming portion joined to the first wall at the upper edge thereof overlying the upper portion of the second wall on the outside thereof and having its ends seamed to the second wall at the bag side seams but being otherwise wholly free of said second wall throughout its entire width, said closure flap being folded over the mouth of the bag without folding said upper portion of the second wall and being reversely foldable to overlie said first wall thereby exposing the mouth of the bag for removal of merchandise therefrom.

2. The method of packaging merchandise comprising forming a continuous envelope of flexible heat-sealable sheet material having first and second superimposed walls joined along one edge thereof with the first wall having a flap-forming portion joined thereto along the

other edge of the continuous envelope overlying the second wall on the outside thereof and free of the second wall, with a series of items of merchandise positioned within said continuous envelope between the said walls thereof at spaced intervals along the length of the envelope, and segmenting the envelope with said items therein on transverse lines between said items and side-seaming said segments by heat-sealing throughout the width of the envelope, thereby to form individual bags each having merchandise therein with each bag having first and second walls joined at the bottom, seamed by heat seals at the sides, and free of one another at the top, and having a closure flap derived from said flap-forming portion joined to the first wall at the upper edge thereof overlying the upper portion of the second wall on the outside thereof and having its ends heat-sealed to the second wall at the heat-sealed bag side seams but being otherwise wholly free of said second wall throughout its entire width, said closure flap being folded over the mouth of the bag without folding said upper portion of the second wall and being reversely foldable to overlie said first wall thereby exposing the mouth of the bag for removal of merchandise therefrom.

3. The method of packaging merchandise comprising placing items of merchandise on a continuous web at spaced intervals along the length of the web, folding the web to form it into a continuous envelope having first and second superimposed walls joined along one edge thereof at a fold with the first wall having a flap-forming portion joined thereto at a fold along the other edge of the continuous envelope overlying the second wall on the outside thereof and free of the second wall, and with the items of merchandise positioned within said continuous envelope between the said walls thereof at spaced intervals along the length of the envelope, and segmenting the envelope with said items therein on transverse lines between said items and side-seaming said segments throughout the width of the envelope, thereby to form individual bags each having merchandise therein with each bag having first and second walls joined at the bottom by a fold, seamed at the sides, and free of one another at the top, and having a closure flap derived from said flap-forming portion joined to the first wall by a fold at the upper edge thereof overlying the upper portion of the second wall on the outside thereof and having its ends seamed to the second wall at the bag side seams but being otherwise wholly free of said second wall throughout its entire width, said closure flap being folded over the mouth of the bag without folding said upper portion of the second wall and being reversely foldable to overlie said first wall thereby exposing the mouth of the bag for removal of merchandise therefrom.

4. The method of packaging merchandise comprising placing items of merchandise on a continuous web of flexible heat-sealable sheet material at spaced intervals along the length of the web, folding the web to form a continuous envelope having first and second superimposed walls joined along one edge thereof at a fold with the first wall having a flap-forming portion joined thereto at a fold along the other edge of the continuous envelope overlying the second wall on the outside thereof and free of the second wall, and with the items of merchandise positioned within said continuous envelope between the said walls thereof at spaced intervals along the length of the envelope, and segmenting the envelope with said items therein on transverse lines between said items and side-seaming said segments by heat-sealing throughout the width of the envelope, thereby to form individual bags each having merchandise therein with each bag having first and second walls joined at the bottom by a fold, seamed by heat seals at the sides, and free of one another at the top, and having a closure flap derived from said flap-forming portion joined to the first wall by a fold at the upper edge thereof overlying the upper portion of the second wall on the outside thereof and having its ends heat-sealed to the second wall at the heat-sealed bag side seams but being otherwise wholly free of said second wall throughout its entire width, said closure flap being folded over the mouth of the bag without folding said upper portion of the second wall and being reversely foldable to overlie said first wall thereby exposing the mouth of the bag for removal of merchandise therefrom.

5. The method of packaging merchandise comprising feeding a continuous web lengthwise and, as it is being fed, folding it on a longitudinal fold line which is offset to one side of the longitudinal center line of the web, thereby to provide superimposed envelope walls one of which is wider than the other, placing items of merchandise on the web prior to the completion of the folding thereof at spaced intervals along the length of the web and on one side of the line where the web is longitudinally folded, folding over the marginal portion of the wider wall at the edge thereof opposite said longitudinal fold line to overlie the other wall on the outside thereof, thereby to provide a continuous envelope having first and second superimposed walls joined along one edge thereof at a fold with the first wall having a flap-forming portion joined thereto at a fold along the other edge of the continuous envelope overlying the second wall on the outside thereof and free of the second wall, and with the items of merchandise positioned within said continuous envelope between the said walls thereof at spaced intervals along the length of the envelope, and segmenting the envelope with said items therein on transverse lines between said items and side-seaming said segments throughout the width of the envelope, thereby to form individual bags each having merchandise therein with each bag having first and second walls joined at the bottom by a fold, seamed at the sides, and free of one another at the top, and having a closure flap derived from said flap-forming portion joined to the first wall by a fold at the upper edge thereof and overlying the upper portion of the second wall on the outside thereof and having its ends seamed to the second wall at the bag side seams but being otherwise wholly free of said second wall throughout its entire width, said closure flap being folded over the mouth of the bag without folding said upper portion of the second wall and being reversely foldable to overlie said first wall thereby exposing the mouth of the bag for removal of merchandise therefrom.

6. The method of packaging merchandise comprising feeding a continuous web of flexible heat-sealable sheet material lengthwise and, as it is being fed, folding it on a longitudinal fold line which is offset to one side of the longitudinal center line of the web, thereby to provide superimposed envelope walls one of which is wider than the other, placing items of merchandise on the web prior to the completion of the folding thereof at spaced intervals along the length of the web and on one side of the line where the web is longitudinally folded, folding over the marginal portion of the wider wall at the edge thereof opposite said longitudinal fold line to overlie the other wall on the outside thereof, thereby to provide a continuous envelope having first and second superimposed walls joined along one edge thereof at a fold with the first wall having a flap-forming portion joined thereto at a fold along the other edge of the continuous envelope overlying the second wall on the outside thereof and free of the second wall, and with the items of merchandise positioned within said continuous envelope between the said walls thereof at spaced intervals along the length of the envelope, and segmenting the envelope with said items therein on transverse lines between said items and side-seaming said segments by heat-sealing throughout the width of the envelope, thereby to form individual bags each having merchandise therein with each bag having first and second walls joined at the bottom by a fold, seamed by heat seals at the sides, and free of one

another at the top, and having a closure flap derived from said flap-forming portion joined to the first wall by a fold at the upper edge thereof overlying the upper portion of the second wall on the outside thereof and having its ends heat-sealed to the second wall at the heat-sealed bag side seams but being otherwise wholly free of said second wall throughout its entire width, said closure flap being folded over the mouth of the bag without folding said upper portion of the second wall and being reversely foldable to overlie said first wall thereby exposing the mouth of the bag for removal of merchandise therefrom.

7. The method of packaging merchandise comprising placing items of merchandise on a continuous web at spaced intervals along the length of the web, applying a second web of a different width from the first web overlying the items of merchandise and longitudinally seaming said webs together along one edge thereof, folding the marginal portion of the wider of the two webs at the other edge thereof to overlie the narrower web on the outside thereof, thereby to form a continuous envelope having first and second walls joined along one edge thereof at a longitudinal seam with the first wall having a flap-forming portion joined thereto at a fold along the other edge of the continuous envelope overlying the second wall on the outside thereof and free of the second wall, and with the items of merchandise positioned within said continuous envelope between the said walls thereof at spaced intervals along the length of the envelope, and segmenting the envelope with said items therein on transverse lines between said items and side-seaming said segments throughout the width of the envelope, thereby to form individual bags each having merchandise therein with each bag having first and second walls seamed at the bottom and at the sides, and free of one another at the top, and having a closure flap derived from said flap-forming portion joined to the first wall by a fold at the upper edge thereof overlying the upper portion of the second wall on the outside thereof and having its ends seamed to the second wall at the bag side seams but being otherwise wholly free of said second wall throughout its entire width, said closure flap being folded over the mouth of the bag without folding said upper portion of the second wall and being reversely foldable to overlie said first wall thereby exposing the mouth of the bag for removal of merchandise therefrom.

8. The method of packaging merchandise comprising placing items of merchandise on a continuous web of flexible heat-sealable sheet material at spaced intervals along the length of the web, applying a second web of flexible heat-sealable sheet material and of a different width from the first web overlying the items of merchandise and longitudinally seaming said webs together along one edge thereof by heat-sealing, folding the marginal portion of the wider of the two webs at the other edge thereof to overlie the narrower web on the outside thereof, thereby to form a continuous envelope having first and second walls joined along one edge thereof at a heat-sealed longitudinal seam with the first wall having a flap-forming portion joined thereto at a fold along the other edge of the continuous envelope overlying the second wall on the outside thereof and free of the second wall, and with the items of merchandise positioned within said continuous envelope between the said walls thereof at spaced intervals along the length of the envelope, and segmenting the envelope with said items therein on transverse lines between said items and side-seaming said segments by heat-sealing throughout the width of the envelope, thereby to form individual bags each having merchandise therein with each bag having first and second walls heat-sealed at the bottom and at the sides, and free of one another at the top, and having a closure flap derived from said flap-forming portion joined to the first wall by a fold at the upper edge thereof overlying the upper portion of the second wall on the outside thereof and having its ends heat-sealed to the second wall at the heat-sealed bag side seams but being otherwise wholly free of said second wall throughout its entire width, said closure flap being folded over the mouth of the bag without folding said upper portion of the second wall and being reversely foldable to overlie said first wall thereby exposing the mouth of the bag for removal of merchandise therefrom.

9. The method of packaging merchandise comprising placing items of merchandise on a continuous web at spaced intervals along the length of the web, applying a second web of a different width from the first web overlying the items of merchandise and longitudinally seaming said webs together along one edge thereof, applying a continuous strip overlying the other edge of the narrower web and longitudinally seaming said strip and the wider web together outward of said other edge of the narrower web, thereby to form a continuous envelope having first and second walls joined along one edge thereof at a longitudinal seam with the first wall having a flap-forming portion constituted by said strip joined thereto along the other edge of the continuous envelope by a longitudinal seam and overlying the second wall on the outside thereof and free of the second wall, and with the items of merchandise positioned within said continuous envelope between the said walls thereof at spaced intervals along the length of the envelope, and segmenting the envelope with said items therein on transverse lines between said items and side-seaming said segments throughout the width of the envelope, thereby to form individual bags each having merchandise therein with each bag having first and second walls seamed at the bottom and at the sides, and free of one another at the top, and having a closure flap derived from said strip joined to the first wall at the upper edge thereof by a seam and overlying the upper portion of the second wall on the outside thereof and having its ends seamed to the second wall at the bag side seams but being otherwise wholly free of said second wall throughout its entire width, said closure flap being folded over the mouth of the bag without folding said upper portion of the second wall and being reversely foldable to overlie said first wall thereby exposing the mouth of the bag for removal of merchandise therefrom.

10. The method of packaging merchandise comprising placing items of merchandise on a continuous web of flexible heat-sealable sheet material at spaced intervals along the length of the web, applying a second web of flexible heat-sealable sheet material of a different width from the first web overlying the items of merchandise and longitudinally seaming said webs together along one edge thereof by heat-sealing, applying a continuous strip of flexible heat-sealable sheet material overlying the other edge of the narrower web and longitudinally seaming said strip and the wider web together by heat-sealing outward of said other edge of the narrower web, thereby to form a continuous envelope having first and second walls joined along one edge thereof at a heat-sealed longitudinal seam with the first wall having a flap-forming portion constituted by said strip joined thereto along the other edge of the continuous envelope by a heat-sealed longitudinal seam and overlying the second wall on the outside thereof and free of the second wall, and with the items of merchandise positioned within said continuous envelope between the said walls thereof at spaced intervals along the length of the envelope, and segmenting the envelope with said items therein on transverse lines between said items and side-seaming said segments by heat-sealing throughout the width of the envelope, thereby to form individual bags each having merchandise therein with each bag having first and second walls heat-sealed at the bottom and at the sides, and free of one another at the top, and having a closure flap derived from said strip joined to the first wall at the

upper edge thereof by a heat-sealed seam and overlying the upper portion of the second wall on the outside thereof and having its ends heat-sealed to the second wall at the heat-sealed bag side seams but being otherwise wholly free of said second wall throughout its entire width, said closure flap being folded over the mouth of the bag without folding said upper portion of the second wall and being reversely foldable to overlie said first wall thereby exposing the mouth of the bag for removal of merchandise therefrom.

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