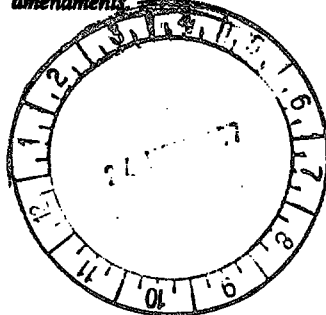
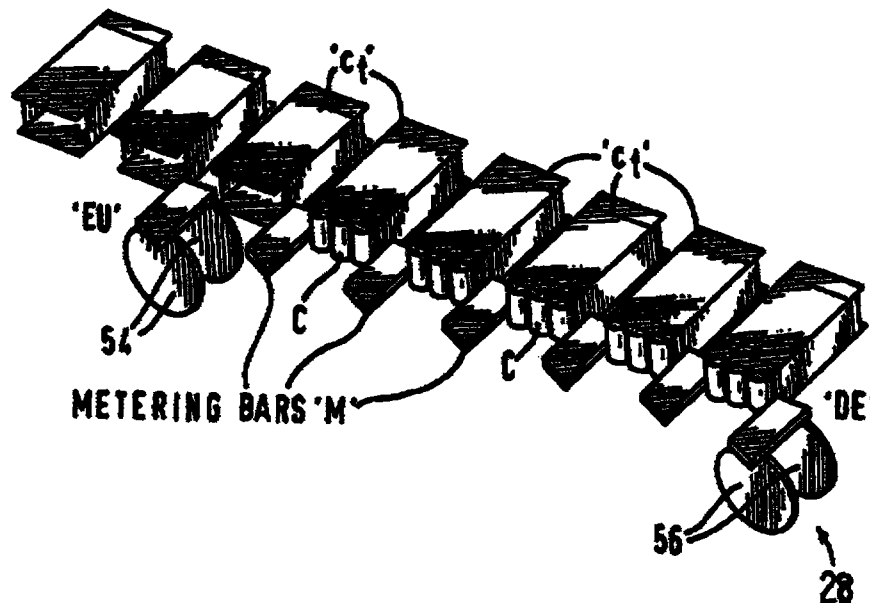


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(54) Title: PACKAGING MACHINE FOR MULTI-PACKS**(57) Abstract**

A packaging machine for packaging articles into cartons has a carton conveyor for conveying an open-ended carton (ct) through the machine, an article infeed for directing articles along an infeed path toward the carton conveyor, and an article group-forming conveyor comprising a plurality of spaced metering bars (m) moving along the conveyor for intersecting the infeed path to separate articles into groups of predetermined pattern. The metering bars at a first end of the group-forming conveyor are disposed away from cartons on the carton conveyor and, during movement along the group-forming conveyor, are moved laterally to extend at least partially between adjacent ones of the cartons. The group-forming conveyor further includes a series of carriers, the metering bars being detachably mounted to selected ones of the carriers in a predetermined pattern.