

PACKAGE AND METHOD OF MANUFACTURE OF THE SAME

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates to a package capable of receiving therein wet or dry article such as tissue paper and more particularly to such type of package that is provided with an opening capable of being exposed and closed so as to allow the contained article to be taken out freely therefrom without the necessity of providing a separate unsealing cover which has conventionally been used. The present invention also relates to a method of manufacture of the package described above.

2. Prior Art

A conventional package of the above type is shown in Figs. 6(A) and 6(B) wherein Fig. 6(A) is a perspective view of the package for housing a wet tissue article consisting of a sheet-like fibrous material impregnated with a medicine especially in a state in which a cover is closed while Fig. 6(B) is a perspective view of the same especially in a state in which the cover is opened.

The package 1 is made of a laminated material consisting of (from on the upper surface side) a PET (polyethylene terephthalate) film, an aluminum foil and a sealant layer. The package 1 is vertically sealed at the bottom surface thereof and is horizontally sealed at both front and rear end portions 1b, 1b so that it is substantially cubic soft sealed body storing therein a plurality of sheets of wet tissue paper 3 in layers.

On the upper surface of the package 1, there is provided a

perforation line so as to allow an elliptical opening 1a to be formed thereon and a cover 2 having an adhesive layer thereon is adhesion-bonded to that surface. The cover 2 consists of a basic layer such as a polypropylene resin and surface layers such as polypropylene or polyethylene resin layers laminated on both surfaces of the basic layer with the addition of a print layer and a top coat layer, that is comparatively rigid and has an adhesive layer on the portion facing the package. When this cover 2 is peeled, the packaging material is cut along the perforation line to thereby provide the opening 1a.

When the opening 1a is closed by the cover 2 again after the wet tissue paper 3 has been taken out from the opening 1a, the adhesive layer of the cover 2 adheres to the package at the periphery of the opening 1a to thereby close the opening 1a. By sealing the opening 1a with the cover 2 while the package 1 is not in use, it is possible to prevent the wet tissue paper 3 in the package 1 from becoming dry.

In the case of the package 1 shown in Fig. 6, the cover 2 has its fixed end 2a at a portion little to the side of its base from notches 2c, 2c and the portion sandwiched between the notches 2c, 2c functions as a hinge. Further, an adhesive layer is formed over the entire rear surface of the cover 2 and is adhesion-bonded to the surface of the package 1. With this package 1, when the cover 2 is peeled up by holding the tab 2b to the hinge portion sandwiched between the notches 2c, 2c, the opening 1a is exposed in a state in which the cover 2 is held fixed to the surface of the package 1 at the fixed end 2a as shown in Fig. 6(B).

After the wet tissue paper 3 has been taken out from the opening 1a, the cover 2 is caused to fall down on the upper surface of the

package 1 and the cover 2 is adhered to the portion around the opening 1a. Thus, when the cover 2 is adhered to that portion again, since it is adhered to the surface of the package 1 in a state in which the cover 2 has returned to its original position, the positioning of the cover 2 with respect to the opening 1a is no more required so that the cover 2 is adhered to a predetermined position on the package 1.

However, when the cover 2 is made of a sheet material different from the material of which the package 1 is formed as has conventionally been practiced, a process becomes necessary in which the cover 2 is adhesion-bonded to the packaging material of the package 1 before forming the package 1. In this process, the step of supplying a number of covers 2 one by one and the step of adhesion-bonding each of the covers 2 to a portion for forming the opening 1a of the packaging material after positioning the covers 2 with respect to that portion one by one are required and the working facilities for performing such steps automatically become complicated.

Further, the conventional cover 2 is made of a comparatively expensive sheet material consisting of a basic layer of polypropylene and surface layers each consisting of polypropylene or polyethylene resin and laminated onto both surfaces of the basic layer with the addition of a print layer and a top coat layer, so that the material cost increases by the amount required for the provision of the cover 2.

In addition, in the case of such package 1, when the cover 2 is peeled in a direction in which it leaves away from the package 1 from the state shown in Fig. 6(A) by holding the tab 2b of the cover

2 by hand, it does not always follow that the peeling action is stopped at the notches 2c, 2c but there is sometimes a case where the fixed end 2a of the cover 2 comes off from the surface of the package 1 or the cover 2 is separated at the hinge portion sandwiched between the notches 2c, 2c, especially when the cover 2 is strongly pulled. Thus, in the event the cover 2 should be separated from the package 1, it becomes necessary to bond the cover to the package 1 by positioning it with respect to the opening 1a resulting in making it inconvenient in use.

SUMMARY OF THE INVENTION

The present invention has been made to solve the above-described problems involved in the conventional package and an object of the present invention is to provide a package which eliminates the necessity of attaching a separate cover thereto and which can reduce the material cost.

Another object of the present invention is to provide a package provided with an unsealing strip which is hardly separated from the packaging sheet forming part of the package and which is not required to be positioned and bonded during its use.

A further object of the present invention is to provide a method of manufacture of the above-described package, which method can eliminate the step of positioning a cover with respect to each of the packaging sheets forming the package to thereby simplify the manufacturing method.

The package according to the present invention is characterized in that it comprises a bag formed by laminating the outer peripheral

portions of an inner packaging sheet with an article takeout opening and an outer packaging sheet with an unsealing strip capable of exposing and closing the opening of the inner packaging sheet.

In the above structure, the outer packaging sheet may be provided with cutting lines for allowing a portion forming the above-mentioned unsealing strip to be separated from the remaining portion of the outer packaging sheet (see Fig. 1A). Alternatively, the outer packaging sheet may have a convex portion defined in advance for forming the unsealing strip. (see Fig. 2B).

Further, it is preferable that the edge of the inner packaging sheet be welded to the laminated section of the outer packaging sheet and the unsealing strip formed on said laminated section of the outer packaging sheet could be opened up to the welded portion.

The welded portion of the two packaging sheets is designated by the letter Sa in Fig. 4. That is, it is the portion where the outer packaging sheet is partially folded to cover (clamp) the edge of the inner packaging sheet, and the inner surface of the edge of the inner packaging sheet and the opposing inner surface of the folded portion of the outer packaging sheet are thermally welded. This structure has the advantage that even when the unsealing strip is peeled up to the boundary of the laminated section, that is, the welded portion between the edge of the inner packaging sheet and the outer packaging sheet, the edge of the inner packaging sheet is not separated from the outer packaging sheet to thereby prevent the formation of a gap between the two packaging sheets.

Further, the inner packaging sheet is provided with a separating line surrounding a portion of a predetermined area and this portion is adhesion-bonded to the outer packaging sheet whereby

when the unsealing strip is peeled, the portion surrounded by the separating line is separated from the remaining portion of the inner packaging sheet thereby exposing the above-mentioned opening. This structure has the advantage that when the opening is covered again by the peeled unsealing strip, the separated part of the inner packaging sheet that is adhered to the unsealing strip covers the opening thereby preventing the adhesive layer from coming into contact with the contained article through the opening.

Alternatively, it is also possible to so construct the package that an opening for taking out the contained article therefrom is formed in advance on the inner packaging sheet and a portion of the inner surface of the outer packaging sheet corresponding in position to the opening is made to have no adhesive layer. Further, although the opening in the shown example is elliptical, it may be in the form of a slit linearly cut in the inner packaging sheet.

Further, the method of manufacture of a package according to the present invention is characterized by comprising the steps of:

placing an outer packaging sheet having a portion becoming an unsealing strip over an inner packaging sheet having a contained article takeout opening and adhesion-bonding both of the sheets to thereby form a laminated section on one side of the sheets;

welding the edge of the inner packaging sheet and that of the outer packaging sheet on the side opposite to the laminated section before or after an article is received between the packaging sheets connected at the laminated section to thereby form a cylindrical body with a vertical seal ; and

dividing the cylindrical body into a plurality of sections of an equal length meeting the amount of an article to be contained

therein and welding the two packaging sheets forming the cylindrical body in a direction intersecting at right angles with the vertical seal to thereby form a horizontal seal.

The above-described method of manufacture may include the step of welding the edge of the inner packaging sheet to the outer packaging sheet before or after the cylindrical body is formed.

The article to be contained in the package according to the present invention is wet or dry tissue paper or the like.

Unlike the conventional package, the above-mentioned package has no separate cover for closing the opening but it is provided with an unsealing strip for closing the opening as a part of one of the packaging sheets forming the package. Consequently, it is not necessary to provide a cover separately from the packaging sheets so that the material cost can be reduced and the step of positioning and bonding the cover with respect to the corresponding packaging sheet can be curtailed.

The unsealing strip is formed integral with the outer packaging sheet but it is possible that no partial adhesive layer be provided at the laminated section between the top end of the unsealing strip and the inner packaging sheet and the top end of the unsealing strip be made to serve as a tab.

Further, where cutting lines for separating the unsealing strip are formed on the outer packaging sheet at the laminated section, such cutting lines may be provided only at the edge of the outer packaging sheet so that the unsealing strip can be separated from the outer packaging sheet through the cutting lines. Alternatively, the above-mentioned cutting lines for separating the portion for forming the unsealing strip may be made to be continuous lines

traversing the laminated section or intermittent perforation lines.

In the manufacturing process, two elongate packaging sheets are used in such a manner that separating lines such as perforation lines for separating an opening are formed on one of the packaging sheets or an opening is formed in advance and cutting lines for separating an unsealing strip are formed in advance on the other packaging sheet. Next, both of the packaging sheets are laminated so that the portion for becoming the unsealing strip overlaps the portion for forming the opening and an adhesive layer is formed on one of the two packaging sheets (preferably the outer packaging sheet). Then both of the sheets are bonded.

After that, an article is wrapped between the bonded packaging sheets and the bonded sheets are vertically sealed to become cylindrical. Alternatively, the article may be received in the vertically sealed cylindrical body. Then, the cylindrical body is divided into a plurality of units in proportion to the amount of the article contained and after being horizontally sealed, the units are separated from one another.

According to the manufacturing method for this package, since the body of the packaging sheets bonded at the laminated section may be subjected as it is to the conventional packaging process to form both vertical and horizontal seal sections to thereby complete packaging, the packaging process is quite simple. Especially, since the positioning and bonding of the cover with respect to the package which have hitherto been required are no more necessary, the manufacturing process is simplified.

In the case of the package and the method of manufacture of the same described above, the edges of the packaging sheets at a

position opposite to the laminated section are welded together to form a vertical seal to thereby allow the sheets to become a cylindrical body. However, according to the present invention, a single packaging sheet may be made cylindrical in such a manner that the mating edges of the sheet are laminated by a predetermined width through an adhesive layer, an opening is formed in the inner portion of the sheet while an unsealing strip is formed on the outer portion of the sheet and the cylindrical sheet is made to have only a horizontal seal.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1(A) is a perspective view of a package according to one embodiment of the present invention especially in a state in which an opening of the package is covered with an unsealing strip as a part of one of packaging sheets forming the package;

Fig. 1 (B) is a perspective view of the package shown in Fig. 1(A) especially in a state in which the opening of the package is exposed as a result of removing the unsealing strip;

Fig. 2(A) is a perspective view of a package according to another embodiment of the present invention with a short cutting line Ca;

Fig. 2(B) is a perspective view of the package according to another embodiment of the present invention with the outer packaging sheet Fa cut in a convex shape in advance;

Fig. 3 is a perspective view of a lamination of two packaging sheets forming the package shown in Fig. 1(A);

Fig. 4 is a vertical sectional view of a package according to the present invention;

Fig. 5 is an enlarged sectional view of packaging sheets to be laminated for forming a package according to the present invention;

Fig. 6 (A) is a perspective view of a conventional package especially in a state in which an opening of the package is closed with a cover; and

Fig. 6 (B) is a perspective view of the conventional package shown in Fig. 6 (A) especially in a state in which the opening is exposed as a result of opening the cover.

DESCRIPTION OF PREFERRED EMBODIMENTS OF THE INVENTION

The preferred embodiments of the present invention will now be described with reference to the accompanying drawings wherein Figs. 1 (A) and 1 (B) are perspective views of one mode of a package according to the present invention of which Fig. 1 (A) shows a state in which an opening 8 is covered by an unsealing strip 9 as a part of a packaging sheet Fa forming a part of the package H and Fig. 1 (B) shows a state in which the unsealing strip 9 is opened, Figs. 2 (A) and 2 (B) show another embodiment of the present invention, Fig. 3 is a perspective view illustrating a laminated section of packaging sheets forming a package, Fig. 4 is a sectional view of the package shown in Fig. 1 (A) and Fig. 5 is an enlarged sectional view of a packaging material F.

As shown in Fig. 3, a packaging material F for a package H of the present invention comprises a lamination of two packaging sheets Fa and Fb. As shown in Fig. 5, each of the packaging sheets Fa and Fb comprises a polyethylene terephthalate (PET) layer f1 as the outermost layer, an aluminum foil f2 as a core layer and a heat seal

layer f3 which is so called a sealant such as biaxial stretching polypropylene (OPP) as an inner layer and each of these layers is formed of a laminated film (a laminated sheet) bonded with a dry laminate. Alternatively, it may be a lamination of a heat seal layer laminated on a volume PET consisting of PET and an aluminum, silica or alumina layer deposited thereon. Further, in order to improve the heat sealing strength, a lamination of two layers of OPP and PE (polyethylene) may be used as the heat seal layer f3.

Since the aluminum foil f2 does not allow water or oxygen to permeate therethrough and has an excellent degree of air-tightness, when a wet tissue article 3 impregnated with cosmetics or a medicine is contained in the package, it is possible to prevent it from becoming dry. On the surface of the aluminum foil f2, there is printed a trademark or an instruction for handling and the PET layer f1 has also the function of protecting such printing serving as a protective layer.

As shown in Fig. 3, the packaging sheets Fa and Fb are overlapped each other by a width A which forms a laminated section. Further, on the rear (inner) surface of the packaging sheet Fa, that is, on the surface of the above-mentioned heat seal layer f3, there is formed an adhesive layer 6 over a width B and further, the edge of the packaging sheet Fa includes a portion 7 where there is no adhesive layer over a width of A minus B. At the laminated portion having the width A, the polyethylene terephthalate layer f1 as said outer layer of the packaging sheet Fb and the heat seal layer f3 as the inner layer of the packaging sheet Fa are adhesion-bonded in face to face relationship with each other.

Thus, a plurality of sheets of wet tissue article in a folded

and laminated state are wrapped as a content in the packaging material F comprising a lamination of the packaging sheets Fa and Fb. As shown in Fig. 4, edges 4a and 5a lying opposite to the laminated section of the packaging sheets Fa and Fb are joined together keeping the heat seal layers f3 as their inner layers face to face each other, pressed and thermally welded to thereby form a vertical seal section S1. When the package H is formed, the above-described laminated section becomes an upper surface and the vertical seal section S1 is directed to the bottom surface.

The packaging material F which has become cylindrical with the formation of the vertical seal section S1 has both longitudinal ends thereof, that is, both ends 4b, 4b of the packaging sheet Fa and both ends 5a, 5b of the packaging sheet Fb, pressed and thermally bonded while the heat seal layers f3 of the two packaging sheets are kept face to face according to the amount of its content, to thereby form a horizontal seal section S2.

As shown in Fig. 4, the sectional configuration of the package H is substantially in the form of a rectangle but at each of the corners of such rectangle, the packaging material F is folded by a small width W and thermally bonded to form small-width seal sections Sa, Sb, Sc and Sd.

At the small-width seal sections Sb and Sd, the heat seal layers f3 as the inner layer of the packaging sheet Fb are held opposite to each other, so that when the folded portions of the packaging sheet Fb are pressed and heated at the small-width section W, they can be thermally bonded together. Similarly, since the heat seal layers f3 of the packaging sheet Fa are held opposite to each other also at the small-width seal section Sc, when the folded portions of the

packaging sheet Fa are pressed and heated at the small-width section W, they can be thermally bonded.

However, at the small-width seal section Sa, the outer packaging sheet Fa is so folded as to cover (clamp) an edge 5c of the inner packaging sheet Fb at the laminated section so that the heat seal layer f3 at the edge 5c of the packaging sheet Fb and the facing heat seal layer f3 at the small-width section 4c of the packaging sheet Fa are thermally sealed and as shown in Fig. 4, the lower surface of the edge 5c becomes a thermally bonded seal section (i). However, the opposing surface portion (ii) between the upper surface of the edge 5c of the packaging sheet Fb and the packaging sheet Fa are not thermally bonded but are adhesion-bonded by the above-described adhesive layer 6.

As shown in Fig. 1(B), at the above-described laminated section having the width A, the inner packaging sheet Fb is provided with an opening 8 for taking out a content such as a wet tissue article 3. As shown in Fig. 3, the packaging sheet Fb has a separating line P enclosing a portion having a predetermined area. This separating line P is made up of a series of perforations or linear cuts formed at a predetermined pitch and the area surrounded by this line becomes a separating strip 5d. As shown in Fig. 1(B), when the separating strip 5d is separated along the separating line P, the opening 8 is exposed in the packaging sheet Fb.

Further, at the above-described laminated section, an unsealing strip 9 is formed integrally with the outer packaging sheet Fa so as to overlap a portion where the opening 8 is formed. The unsealing strip 9 can be so constructed that it can be separated from the remaining portion of the packaging sheet Fa through cutting lines

C formed on both sides thereof, respectively. Although the cutting line C is shown as a perforation line in the example shown in Fig. 1, it may be a continuous cutting line. Further, a short cutting or perforation line may be formed at the edge of the packaging sheet Fa such that when the unsealing strip 9 is pulled in the direction of the arrow α , a cutting line extends to the packaging sheet Fa from such short perforation line.

As described above, since the adhesive layer 6 is formed on the inner surface of the packaging sheet Fa at the laminated section, the unsealing strip 9 is adhered to the area of the packaging sheet Fb where the opening 8 is formed. Further, at the laminated section there is provided, on the side of the edge of the packaging sheet Fa, the above-mentioned portion 7 of a predetermined width where there is no adhesive layer. Therefore, the portion of the unsealing strip 9 corresponding to the portion 7 is not adhered to the packaging sheet Fb and the portion 7 serves as a tab 9a of the unsealing strip 9.

Next, a method of manufacture of the above-described package H will be described.

First, as shown in Fig. 3, two vertically elongated packaging sheets Fa and Fb each comprising a lamination of a PET layer f1, an aluminum foil f2 and a heat seal layer f3 are laminated with the packaging sheet Fb as an inner layer and the packaging sheet Fa as an outer layer. A plurality of separating lines P for removing separating strips 5d are formed in advance on the inner packaging sheet Fb at the laminated section and a plurality of cutting lines C for separating unsealing strips 9 are formed on the outer packaging sheet Fa at the laminated section.

An adhesive layer 6 having a width B is formed on the inner

surface (the surface of the heat seal layer f3) of the packaging sheet Fa. The adhesive layer 6 is formed by coating an adhesive agent on the inner surface of the packaging sheet Fa. The packaging sheets Fa and Fb are overlapped by a width A and adhesion-bonded by means of the adhesive layer 6. In this case, the packaging sheets Fa and Fb are adhesion-bonded after they are so aligned with each other that each of the portions of the packaging sheet Fa surrounded by the cutting lines C to become the unsealing strips 9 overlaps each of the separating strips 5d.

Further, small-width seal sections Sa, Sb, Sc and Sd shown in Fig. 4 are formed on the packaging material F formed by a lamination of the packaging sheets Fa and Fb. This step is performed by partially folding the packaging material F and thermally bonding the folded portions of the material F.

Next, a content such as a wet tissue article 3 is wrapped by the packaging material F, the edge 4a of the packaging sheet Fa and the edge 5a of the packaging sheet Fb are put together flat and thermally bonded to form a vertical seal section S1 thereby making the packaging material F cylindrical. Further, the packaging material F is pressed in a direction normal to the vertical seal section S1 in proportion to the amount of the content and thermally bonded thereby forming a horizontal sealing section S2. Then, the packaging material F is cut along the horizontal seal section S2 to separate each unit package thus formed.

In the case of the package H manufactured in the above manner, the unsealing strip 9 is a part of the packaging sheet Fa comprising the package H so that the material cost can be reduced when compared to the conventional package comprising a packaging material provided

with a separately attached cover. Further, since the content can be packaged as it is by the packaging material F formed of a lamination of the packaging sheets Fa and Fb by using a conventional packaging equipment, the packaging step is also performed with ease.

When the package H is first used, the tab 9a which is formed at the top of the unsealing strip 9 and which has no adhesive layer 6 is peeled toward the direction of the arrow α by fingers, the packaging sheet Fa is cut along the cutting lines C so that the unsealing strip 9 is separated from the remaining portion of the packaging sheet Fa. In this case, the separating strip 5d on the packaging sheet Fb is adhered to the unsealing strip 9 so that the separating strip 5d is separated from the packaging sheet Fb while it is kept adhered to the rear surface of the unsealing strip 9 and as a result, the opening 8 is formed in the packaging sheet Fb.

The content such as the wet tissue article 3 is taken out in sequence through the opening 8. When the unsealing strip 9 is made to fall down on the side of the packaging sheet Fb after the content has been taken out, the unsealing strip 9 is adhered to the packaging sheet Fb by means of the adhesive layer 6 so that the package H is sealed to prevent the content from becoming dry. Further, when the opening 8 is closed again by the unsealing strip 9, the separating strip 5a adhered to the unsealing strip 9 comes to lie at the opening 8 so that the opening 8 is covered with this separating strip 5d and the content such as the wet tissue article 3 does not become adhered to the adhesive layer 6 of the unsealing strip 9.

Thus, it is possible with this package H to peel the unsealing strip 9 repeatedly. Further, the unsealing strip 9 can be peeled by being pulled up to a small-width seal section Sa shown in Fig.

4. However, unlike the conventional cover shown in Fig. 6, since the unsealing strip 9 is a part of the packaging sheet Fa, it does not become completely separated from the package H. Further, at the small-width seal section Sa, the edge 5c of the packaging sheet Fb and the small-width section 4c of the packaging sheet Fa are thermally bonded at the thermally bonded seal section (i) so that when the unsealing strip 9 is peeled long in the direction in which it is opened, such peeling action can be securely stopped at the above-mentioned thermally bonded seal section (i). Further, since the packaging sheets Fa and Fb are thermally bonded at the thermally bonded seal section (i), when the unsealing strip 9 is peeled largely, it is possible to prevent the formation of a gap in the packaging material at the base portion of the unsealing strip 9.

Further, if a rigid reinforcing material such as a PET film is bonded to the peripheral portion of the opening 8 of the packaging sheet Fb for forming the package H so as to partially increase the thickness of the packaging sheet Fb at the peripheral portion of the opening 8, the packaging sheet Fb becomes hardly crumpled or bent at that peripheral portion of the opening 8 so that the unsealing strip 9 can be securely adhered around the opening 8 thereby increasing the sealing property of the opening 8.

Next, another embodiment of the present invention shown in Figs. 2(A) and 2(B) will be described.

In the case of the package H shown in Fig. 2(A), a short cutting line Ca extending from one of the cutting lines C in a direction normal to the latter is formed. In this embodiment, the unsealing strip 9 can be cut off from the short cutting line Ca after the unsealing strip 9 is peeled as shown in Fig. 1(B).

Accordingly, where this package H is used for its refilling into a container, it is possible to put the package in a state in which the unsealing strip 9 is removed by cutting. Further, where the package H is used as it is without putting it into the container, it is possible to use it in such a manner that as shown in Fig. 1(B), the unsealing strip 9 is repeatedly peeled without cutting off the unsealing strip 9 from the short cutting line Ca.

Next, in the case of the package H shown in Fig. 2(B), the outer packaging sheet Fa at the laminated section has no cutting line C but the outer packaging sheet Fa is cut in a convex shape in advance at the laminated section so that this convex portion serves as the unsealing strip 9. In the case of the package shown in Fig. 2(B), it is not necessary to separate the unsealing strip 9 along the above-mentioned cutting lines C and so, if the unsealing strip 9 is peeled directly from the tab 9a, the opening 8 can be exposed.

The package shown in Fig. 2(B) has the advantage that it is free of the problem that the edge (iii) of the packaging sheet Fa after removing the unsealing strip 9 shown in Fig. 1(B) gets turned up and therefore, the external appearance of the package in use is hardly impaired.

As described above, the package according to the present invention has various advantages that since the unsealing strip for closing the opening is formed of a portion of the cover, it is not necessary to provide a separate cover for closing the opening as has hitherto been practiced so that the material cost can be reduced. Further, no complicated step of positioning and then bonding the cover to the package is required in the manufacturing process thereof.

Further, the package according to the present invention has

an advantage in use to prevent the unsealing strip from coming off the package when being pulled up.



WHAT IS CLAIMED IS:

1. A package in the form of a bag for housing an article therein, said bag including a laminated section where an inner packaging sheet and an outer packaging sheet are laminated and adhesion-bonded to each other, said inner packaging sheet having an opening from which said article is taken out and said outer packaging sheet being provided with an unsealing strip capable of exposing and closing said opening of said inner packaging sheet.
2. A package according to Claim 1, wherein said outer packaging sheet at said laminated section is provided with cutting lines along which said unsealing strip can be separated from said outer packaging sheet.
3. A package according to Claim 1, wherein the edge of the inner packaging sheet at said laminated section is welded to the outer packaging sheet at said laminated section and said unsealing strip formed on said outer packaging sheet can be opened up to said welded edge of said inner packaging sheet.
4. A package according to Claims 1, wherein said inner packaging sheet at said laminated section includes a separating line surrounding a portion of a predetermined area which is adhesion-bonded to said outer packaging sheet such that when said unsealing strip is peeled, said portion surrounded by said separating line is separated from the inner packaging sheet thereby exposing said opening.
5. A method of manufacture of a package, which comprises the steps of:

forming a laminated section of an inner packaging sheet



THIS SHEET HAS BEEN
REPLACED

including a portion for forming an article takeout opening and an outer packaging sheet including a portion for forming an unsealing strip, by laminating and adhesion-bonding said inner and outer packaging sheets;

forming said inner and outer packaging sheets into a cylindrical body in such a manner that the edge of said inner packaging sheet and that of said outer packaging sheet on the side opposite to said laminated section are welded to form a vertical seal section before or after an article is received between said two laminated sheets; and

dividing said cylindrical body into a plurality of units of a length meeting the amount of said article and welding said inner and outer packaging sheets in a direction intersecting at right angles with said vertical seal section to thereby form horizontal seals.

6. A method of manufacture of a package according to Claim 5, which includes the step of welding the edge of said inner packaging sheet to said outer packaging sheet at said laminated section before or after said cylindrical body is formed.

This Sheet Has Been Replaced



ABSTRACT OF THE DISCLOSURE

TITLE OF THE INVENTION :

PACKAGE AND METHOD OF MANUFACTURE OF THE SAME

A package for receiving an article such as wet or dry tissue paper therein and a method of manufacture of such package. The package comprises an inner packaging sheet Fa and an outer packaging sheet Fb laminated to provide a laminated section having a width A by an adhesive layer 6. Further, an article takeout opening 8 is formed in the inner packaging sheet Fb at the laminated section and an unsealing strip 9 which is capable of being separated along cutting lines C is formed on the outer packaging sheet Fa. With such a structure, since the unsealing strip 9 is integral with the outer packaging sheet Fa, the material cost can be reduced as compared to the conventional package requiring a separate cover. Further, the package can be manufactured from two laminated packaging sheets by using an ordinary packaging process so that the manufacturing method can be simplified.

Figure 1(A) & (B)

Fig. 1

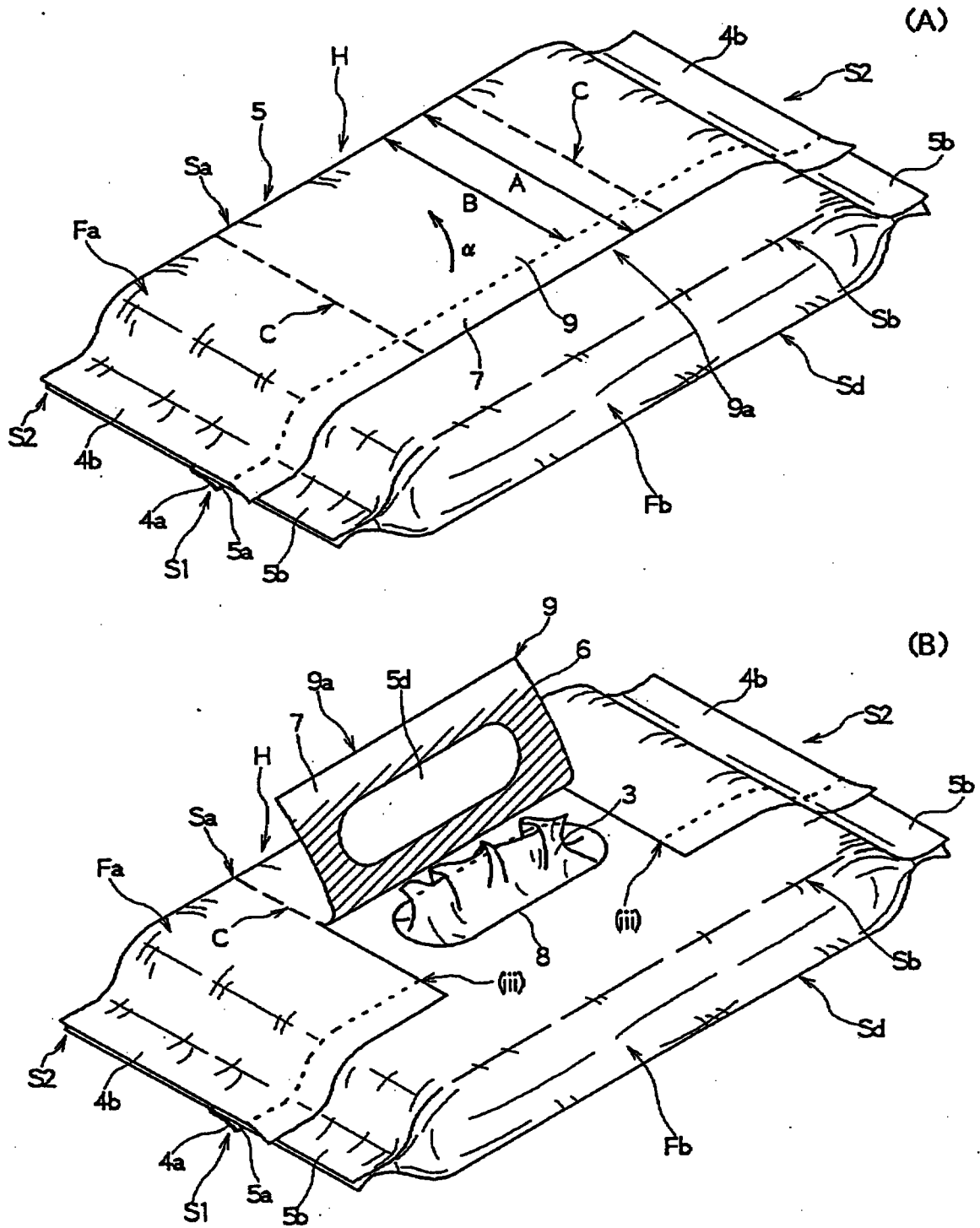


Fig. 2

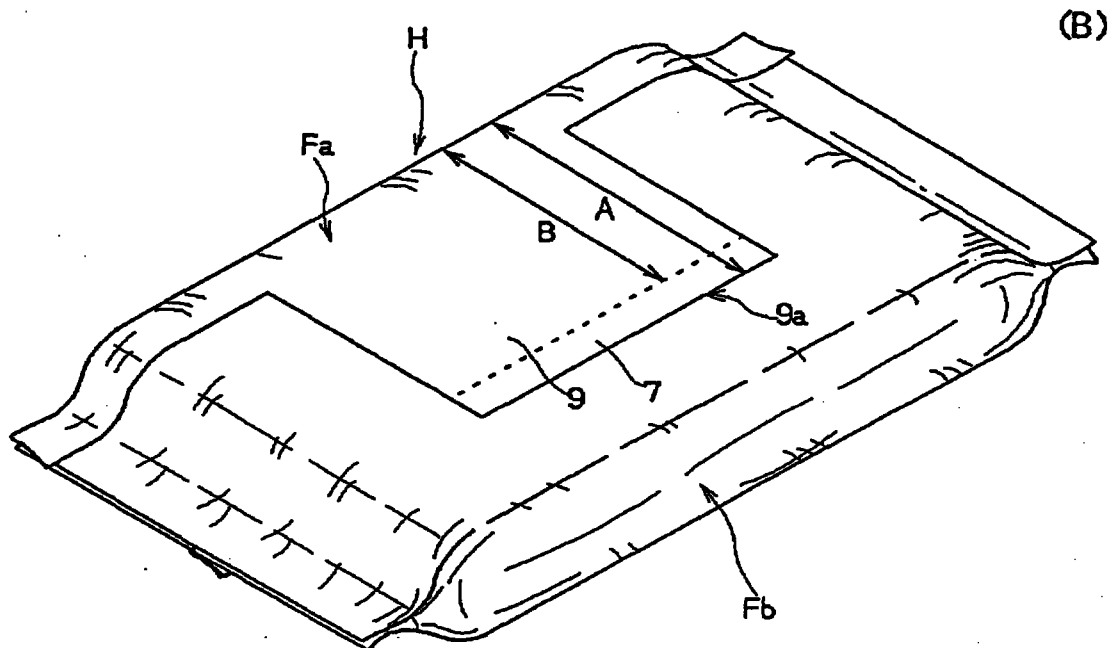
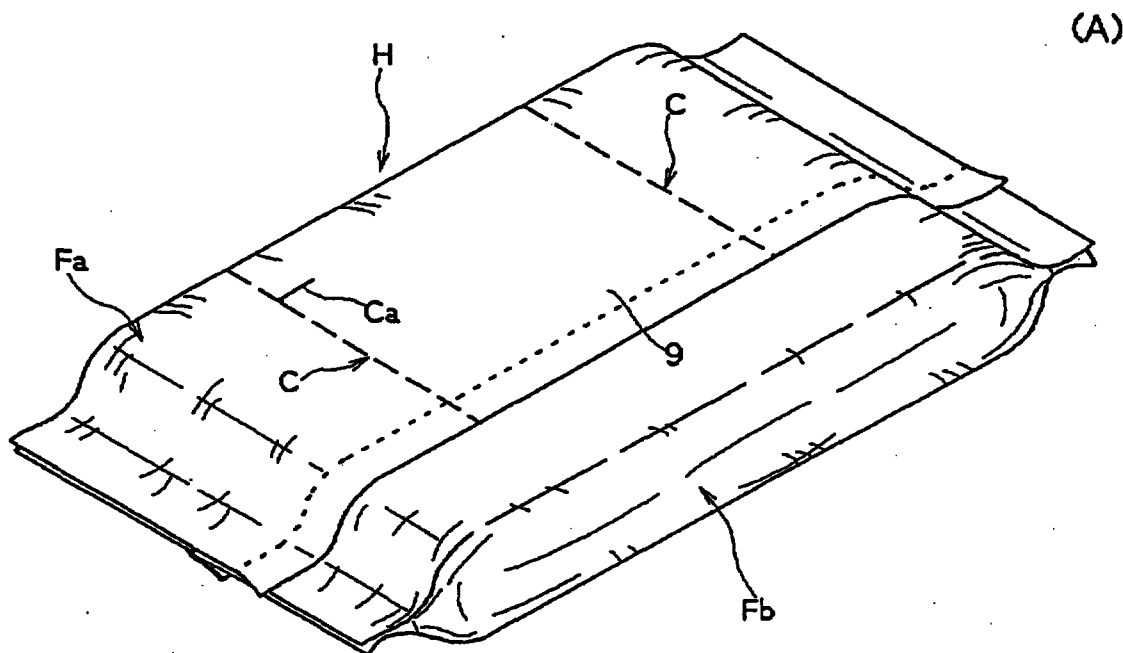


Fig. 4

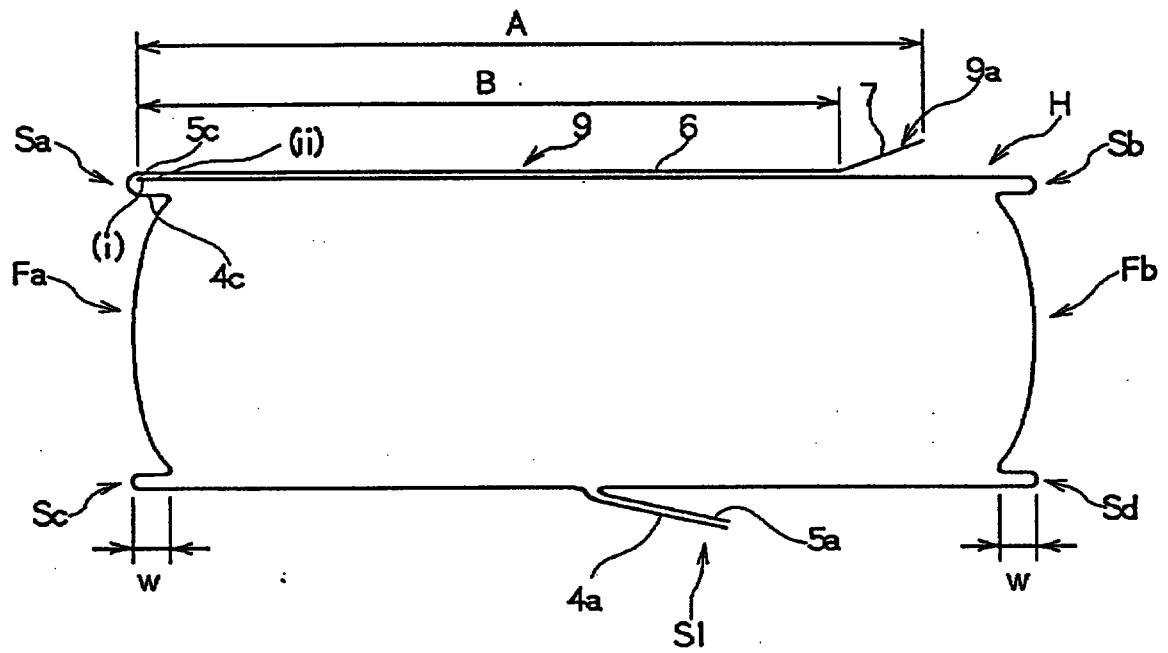


Fig. 5

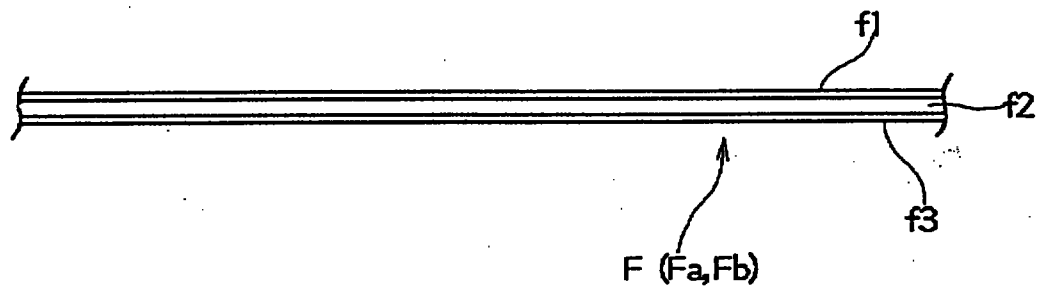
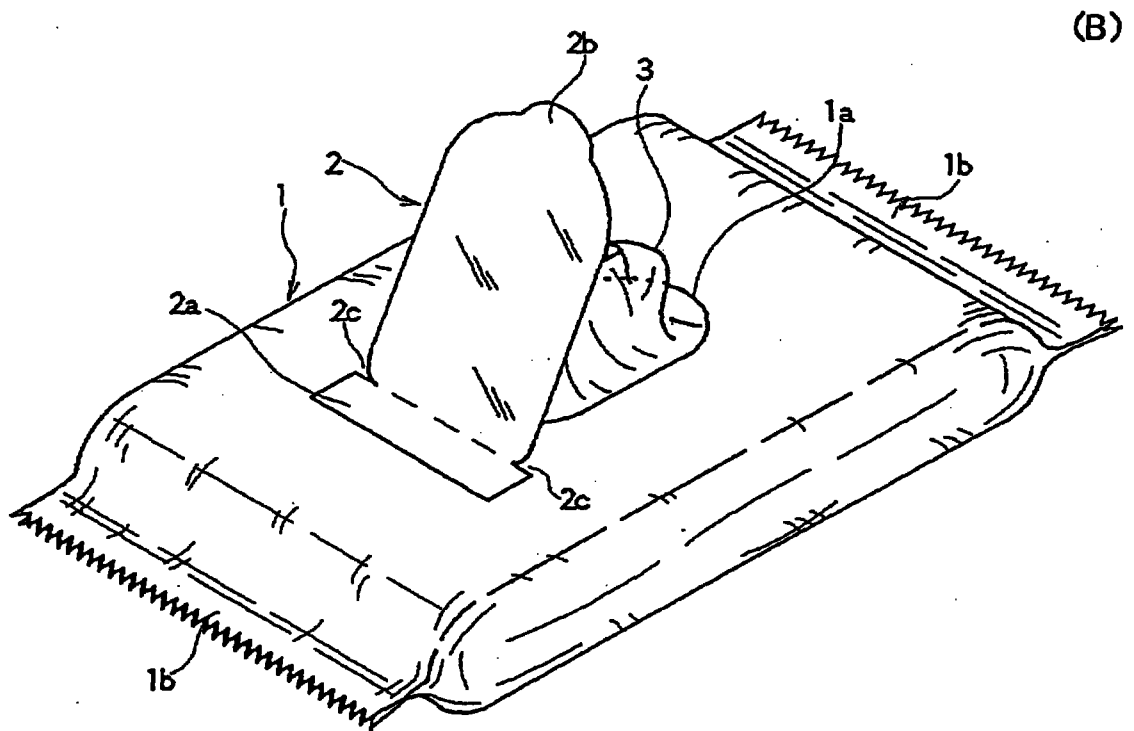
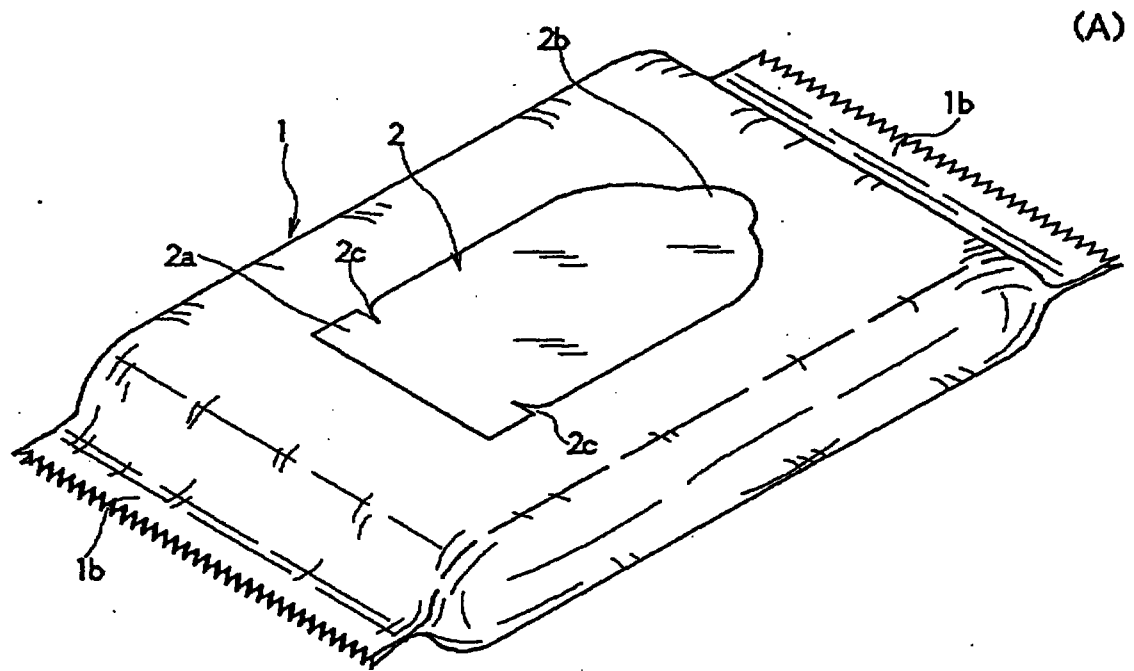
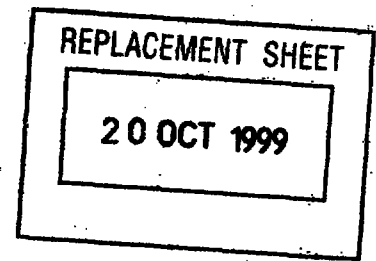


Fig.6



**WHAT IS CLAIMED IS:**

1. A package in the form of a bag for housing an article therein, said package comprising a packaging material composed of first and second packaging sheets, said packaging material including a laminated section where one side portion of said first packaging sheet is laminated and adhesion-bonded to one side portion of said second packaging sheet, wherein

said packaging material is formed into the bag to have a seal section extending parallel to said laminated section and other seal sections extending perpendicular to said laminated section, said seal section extending parallel to the laminated section is formed by welding one edge of said first packaging sheet opposite to the other edge included in said side portion thereof to one edge of said second packaging sheet opposite to the other edge included in said side portion thereof, said side portion of the first packaging sheet has an opening from which said article can be taken out, and said side portion of the second packaging sheet has an unsealing strip capable of exposing and closing said opening.

2. A package according to Claim 1, wherein said side portion of the second packaging sheet is provided with cutting lines along which said unsealing strip can be separated from portions other than said unsealing strip.

3. A package according to Claim 1, wherein the edge of the first packaging sheet included in said side portion thereof is welded to the second packaging sheet, so that said unsealing strip can be opened up to said welded edge of the first packaging sheet.

4. A package according to Claim 1, wherein said side portion of the first packaging sheet includes a separating line surrounding a portion of a predetermined area which is adhesion-bonded to said side portion of the second packaging sheet such that when said unsealing strip is peeled, said portion surrounded by said separating line is separated from the first packaging sheet thereby exposing said opening.



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5. A method of manufacture of a package, which comprises the steps of:

forming a laminated section of a first packaging sheet and a second packaging sheet, by laminating and adhesion-bonding a portion of said first packaging sheet including an article takeout opening to a portion of said second packaging sheet including an unsealing strip;

forming said first and second packaging sheets into a cylindrical body in such a manner that an edge of said first packaging sheet and an edge of said second packaging sheet on the side opposite to said laminated section are welded to form a seal section extending parallel to said laminated section before or after an article is received in said first and second packaging sheets;

welding and closing said cylindrical body in proportion to the amount of said article to form other seal sections extending perpendicular to said laminated section; and

cutting said seal sections extending perpendicular to said laminated section to obtain individual packages.

6. A method of manufacture of a package according to Claim 5, which includes the step of welding an edge of said first packaging sheet included in said laminated section to said second packaging sheet before or after said cylindrical body is formed.