

Description

This invention relates to a method of securing fastener elements to an underlying film web, and more particularly to flexible extruded rib male profile fastener elements for use on reclosable plastic bags.

Plastic containers or bags which feature reclosable fasteners are well known and widely used by consumers and industry. Typically, opposing rib and groove fastener elements (also called male and female profiles) on the container are pressed together or pulled apart to seal or open the container. Because of the popularity of such reclosable plastic containers, a number of different manufacturing processes and apparatuses have been developed to manufacture them. A major consideration in almost all of these prior art manufacturing processes has been the manner in which the fastener elements are formed and adhered or attached to the container walls. Problems have existed in manufacturing, such as twisting or distortion of the fastener elements when applied to a film substrate, obtaining secure adherence of the fastener elements to the film substrate, or other problems which reduce manufacturing speed and efficiency or otherwise increase manufacturing costs.

U.S. Patent 4,263,079 describes placing a fastener die in very close relationship to a film extrusion die and coextruding both the fastener and film. Adhesion of the fastener to the film occurs before any significant cooling of either the film or fastener.

FR-A-2 258 950 refers to the extrusion of a plastic profile having a square cross-section through an extruder die having concave shaped lines to compensate die swelling of the extruded profile.

In US-A-4,279,677, on which the preamble of claim 1 is based, a method and an apparatus for joining plastic fastener strips continuously to a film is described. Two separate parallel fastener strips provide a base for the male and female profiles and said base is adapted so that it can be fused to the plastic film. From Fig. 5 it is evident that the fastener strip is broad in relation to the width of the profiles.

Other prior processes have utilized the heat from hot, freshly-extruded, fastener elements in combination with a preheated traveling film web to fuse the elements to the film. Examples of such processes include Uramoto, US-A-3,780,781; Noguchi, US-A-3,945,872 and 3,784,432.

However, the joining together of separately formed film webs and fastener elements presents manufacturing problems in terms of maintaining the fastener elements in an upright position during the joinder with the web and obtaining secure joinder without entrapping air between the bases of the fastener elements and the film web. Entrapment of air may result in adhesive failure of the lamination of the fastener element to the film web.

In order to aid in maintaining fastener elements upright during joinder, many prior processes used elements with wide and/or extended bases. However, such wide and/or extended basis contributed to air entrapment problems during joinder of the fastener elements to the film web. In the context of the coextrusion process, the US-A-4,263,079 discussed above illustrates the adhesion and air entrapment problems which occur if the traveling film and/or extruded fasteners having extended bases are not carefully joined together.

Accordingly, the need exists in the art for fastener elements and which can be readily and reliably secured to an underlying traveling film web.

The present invention provides a method of forming a ribbed plastic fastener element for use on a reclosable plastic container including the steps of melt processing a thermoplastic resin to form molten plastic resin and extruding the molten plastic resin from a die to form a male profile having a base portion connected to a generally arrowhead-shaped tip by a stem and guiding the male profile into convergence with a travelling film web and joining the male profile to the film web together to secure the profile to the film web, characterized by extruding the male profile from the die in a form having a generally concave base portion.

The die orifice is shaped to provide some concavity to the tail or base portion of the male profile rib element. By concavity, it is meant that the lower surface of the tail traces generally the arc of a circle so that, as extruded, there is a space formed beneath opposite ends of the tail portion of the fastener element if it is placed on a flat surface. Surprisingly, however, it has been found that this as-extruded concavity is beneficial because post extrusion flow of the rib element prior to, and as it is being joined to, the underlying film web results in the lower surface of the tail portion of the element assuming a generally flat configuration which provides a good surface for effecting secure joinder of the element to the film web.

The fastener element, after being extruded from a respective rib die orifice, is then preferably secured to a film web or sheet while still hot. In a preferred method, a preformed continuous film web, which may also be polyethylene, is passed through a joining area where the freshly extruded hot fastener element is guided into convergence therewith. The heat from the fastener element has been found to be sufficient to fuse the element to the surface of the film web thereby securing the fastener element to the web. The male profile of the present invention is readily maintained in its correct, upright position during joinder to the web and is secured to the web without entrapment of air beneath its base.

The film web with fastener element secured

thereon may then be formed into a series of reclosable, flexible plastic containers as is conventional in the art. Typically, the container will have a bag body with flexible walls of plastic film which are sealed on all sides but one. The open side of the container will have the releasably interlocking rib and groove fastener elements secured to opposite facing inner surfaces of the bag walls adjacent the opening. To effect closure, the opposing rib and groove elements are pressed together so that the arrowhead-shaped tip portion of the rib element mates with the corresponding inwardly facing hook portions of the groove element to effect a seal. As is also conventional, the elements may be separated by pulling the opposing bag walls apart.

In the accompanying drawings, Figure 1 is a perspective view of an apparatus suitable for making the fastener elements of the present invention and for joining them to an underlying film web;

Figure 2 is an enlarged side elevational view of a rib fastener element secured to a film web;

Figure 3 is an enlarged cross-section of the die orifice through which the rib element of Figure 2 was extruded;

The apparatus illustrated in Figure 1 shows a preferred method of forming fastener elements in accordance with the present invention and, then, securing them to a film web or sheet. With reference to Figure 1, a preformed continuous film web 10 is taken off unwind roll 12. Unwind roll 12 has tension control which may be effected, for example, through drive means D connected to unwind roll 12 through belt 11 and shaft 13. This provides the proper tension for web 10 as it passes through the apparatus.

Web 10 is then directed around idler roll 14 and onto driven rolls 16 and 18. A conventional screw extruder 20 is fed thermoplastic resin through inlet 22. After melt processing occurs in extruder 20, the molten plastic resin is sent through pipe 24 to fastener element die block 26. Although only a single die block is illustrated, it will be appreciated that a plurality of die blocks may be utilized and spaced across the width of web 10 so that a plurality of fastener elements may be extruded simultaneously onto the web. Fastener element die block 26 may be configured to extrude either a rib element or a groove element from its outlet 28 onto web 10.

For simplicity and ease of understanding, the fastener element extruded from die block 26 will be referenced by drawing numeral 30, and it will be understood that fastener element 30 may be a rib element. As shown, fastener element 30 is guided into convergence with web 10 at a point where web 10 is just leaving the surface of roll 16. This joining area, which is generally indicated by reference numeral 32 is in the gap between rolls 16 and 18. The heat from fastener element 30 will fuse it to web 10. As shown, die block 28 may be offset from vertical by a small angle to better tension the extruded fastener element as it is brought into convergence with web 10.

Other specific forms of apparatus may be utilized to join the film web and fastener element including a coextrusion apparatus or an apparatus which utilize preheated, preformed film webs.

Referring back now to Figure 1, after joinder of fastener element 30 with web 10, the assembly travels over roll 18, around idler roll 34, and is passed between driven nip rolls 40, 42 to a tension controlled winder (not shown). Roll 18 may be chilled and/or water jets 44 may be positioned as needed to spray cooling water on the fastener element and web assembly. The assembly may then be further conventionally processed to form individual reclosable plastic containers.

As best illustrated in Figures 2 and 3, which are greatly enlarged for purposes of illustration, the rib element (R) is extruded from outlet 28 of die block 26 and has, upon exiting the die, a generally arrowhead-shaped tip 50 and a concave tail 52. The tip 50 and tail 52 are joined together by a generally upstanding stem 54. Tip 50 has asymmetrical sides 56, 58 which are designed to mate with corresponding asymmetrical hook elements on the groove fastener element as explained in further detail below. While tip 50 is preferably generally arrowhead-shaped, other shapes, as known in the art, may be used.

Figure 2 illustrates the shape of the rib element R after it has been secured to web 10. Post extrusion flow of the hot fastener element coupled with some shrinkage during cooling results in a rib element having a generally flat, rather than concave, base 52'. As shown, the thickness of upstanding stem 54 and tail 52 are approximately equal. Likewise, the ratio of the overall height of the fastener element to the overall length of the tail is also approximately 1:1. While the actual dimensions of the rib element will vary depending upon the desired end use and size of plastic container it is to be secured to, the proportions and ratios illustrated in the drawing figures and described above are maintained.

The tail 52 on the rib element of the present invention is quite short in relation to the extended bases utilized for prior art rib elements. It was found that such extended bases resulted in entrapment of air beneath the fastener element during joinder with the film web. Such air entrapment weakened the strength of the bond between fastener element and film web. Such an extended base was also believed to be necessary by the prior art to maintain the rib element upright during joinder to the film web. Surprisingly, it was found that by use of the rib design of the present invention such an extended base could be eliminated with concomitant elimination of the air entrapment problem and with no problem in maintaining the element upright during joinder.

As also shown in Figure 2, the tail 52 of the rib element is designed to be somewhat concave as the rib element leaves the die. Preferably, the lower surface of the tail is defined by the arc of a circle having a radius of between (0.15 and 0.20

inches) 0.38 to 0.51 cm, and most preferably of approximately (0.175 inches) 0.44 cm. In other words, the degree of concavity of the tail, which for purposes of the present invention is defined as the ratio of the vertical distance from the highest point on the lower surface of the tail to the lowest point on the lower surface of the tail (shown as distance C in Figure 3), to the length of the tail (shown as distance D in Figure 3), should be approximately 0.1.

This degree of concavity has been found, as a result of post extrusion flow of the hot fastener element, to result in a rib element having a generally flat base 52', as shown in Figure 2. Rib elements extruded with lesser degrees of concavity result in elements having rounded (convex) bases which cause problems in maintaining the element upright during joiner. On the other hand, extruding a rib element with greater concavity results in an element which is still somewhat concave and which may entrap air beneath the element during joiner with a film web.

Preferably, the rib element of the present invention is made of a melt processable thermoplastic resin such as polyethylene. Additionally, it may be desirable to utilize the same thermoplastic resin for both the fastener elements and the film web. Once the respective rib and groove elements have been secured to the film web, the web assembly may be further processed as is conventional in the art to form individual reclosable, flexible plastic containers. Such containers typically comprise a bag body having flexible walls of a plastic film and an opening therein. The releasably interlocking rib and groove fastener elements are secured to respective opposing facing inner surfaces of the bag walls. The container is sealed by applying pressure to the opposing rib and groove elements causing them to interlock. The container may be opened by applying pressure to pull the releasably interlocked element apart.

Claims

1. A method of forming a ribbed plastic fastener element (30) secured to an underlying film web of a reclosable plastic container including the steps of melt processing a thermoplastic resin to form molten plastic resin and extruding the molten plastic resin from a die (26) to form a male profile having a base portion (52) connected to a generally arrowhead-shaped tip (50) by a stem (54) and guiding the male profile into convergence with a travelling film web (10) and joining the male profile to the film web (10) together to secure the profile to the film web (10), characterized by, extruding the male profile from the die (26) in a form having a generally concave base portion.

2. The method of claim 1 characterized in that the ratio of the thickness of the stem (54) to the thickness of the base (52) is approximately 1 : 1.

3. The method of claim 1 characterized in that the ratio of the overall height of the male profile to

the length of the base is approximately 1 : 1.

4. The method of claim 1 characterized in that, the lower surface of the base is defined by the arc of a circle having a radius of from (0.15 to 0.20 inches) 0.38 to 0.51 cm.

5. The method of claim 1 characterized in that, the degree of concavity of the base portion (52) is approximately 0.1.

Patentansprüche

1. Verfahren zum Herstellen eines mit Rippen versehenen Kunststoffverschlußelementes (30), das an einer darunterliegenden Folienbahn befestigt ist, für einen wiederverschließbaren Kunststoffbehälter durch Schmelzverarbeiten eines thermoplastischen Harzes und Ausbilden geschmolzenen Kunststoffharzes und Extrudieren des geschmolzenen Kunststoffharzes durch eine Düse (26), um ein Patrizienprofil mit einem Basisteil (52) auszubilden, das über einen Stiel (54) mit einer im allgemeinen pfeilförmigen Spitze (50) verbunden ist, und Zusammenführen des Patrizienprofils mit einer sich bewegendenden Folienbahn (10) und Verbinden des Patrizienprofils mit der Folienbahn (10), um das Profil an der Folienbahn (10) zu befestigen, gekennzeichnet durch Extrudieren des Patrizienprofils aus einer Düse (26) mit einem im allgemeinen konkaven Basisteil.

2. Verfahren nach Anspruch 1 dadurch gekennzeichnet, daß das Verhältnis der Dicke des Stiels (54) zur Dicke des Basisteils (52) etwa 1 : 1 ist.

3. Verfahren nach Anspruch 1, dadurch gekennzeichnet, daß das Verhältnis der Gesamthöhe des Patrizienprofils zur Länge des Basisteils etwa 1 : 1 ist.

4. Verfahren nach Anspruch 1, dadurch gekennzeichnet, daß die untere Oberfläche des Basisteils ein Bogen eines Kreises ist, mit einem Radius von 0,38 bis 0,51 cm (0,15 bis 0,20 Inch).

5. Verfahren nach Anspruch 1, dadurch gekennzeichnet, daß der Grad der Hohlrundung des Basisteils (52) annähernd 0,1 ist.

Revendications

1. Procédé de formation d'un élément d'agrafe plastique nervuré (30) fixé à une bande de film sous-jacent pour un récipient plastique pouvant se refermer, comportant les étapes consistant à faire fondre une résine thermoplastique pour former une résine plastique fondue et à extruder la résine plastique fondue hors d'une filière (26) pour former un profil mâle présentant une portion de base (52) reliée à une pointe (50), ayant la forme générale d'une tête de flèche, par une tige (54) et à guider le profil mâle pour qu'il vienne converger avec une bande de film en déplacement (10) et à joindre ensemble le profil mâle à la bande de film (10) pour fixer le profil à la bande de film (10), caractérisé en ce que l'on extrude le profil mâle hors de la filière (26) sous une forme présentant une portion de base de

inches) 0.38 to 0.51 cm, and most preferably of approximately (0.175 inches) 0.44 cm. In other words, the degree of concavity of the tail, which for purposes of the present invention is defined as the ratio of the vertical distance from the highest point on the lower surface of the tail to the lowest point on the lower surface of the tail (shown as distance C in Figure 3), to the length of the tail (shown as distance D in Figure 3), should be approximately 0.1.

This degree of concavity has been found, as a result of post extrusion flow of the hot fastener element, to result in a rib element having a generally flat base 52', as shown in Figure 2. Rib elements extruded with lesser degrees of concavity result in elements having rounded (convex) bases which cause problems in maintaining the element upright during joinder. On the other hand, extruding a rib element with greater concavity results in an element which is still somewhat concave and which may entrap air beneath the element during joinder with a film web.

Preferably, the rib element of the present invention is made of a melt processable thermoplastic resin such as polyethylene. Additionally, it may be desirable to utilize the same thermoplastic resin for both the fastener elements and the film web. Once the respective rib and groove elements have been secured to the film web, the web assembly may be further processed as is conventional in the art to form individual reclosable, flexible plastic containers. Such containers typically comprise a bag body having flexible walls of a plastic film and an opening therein. The releasably interlocking rib and groove fastener elements are secured to respective opposing facing inner surfaces of the bag walls. The container is sealed by applying pressure to the opposing rib and groove elements causing them to interlock. The container may be opened by applying pressure to pull the releasably interlocked element apart.

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1. A method of forming a ribbed plastic fastener element (30) secured to an underlying film web a reclosable plastic container including the steps of melt processing a thermoplastic resin to form molten plastic resin and extruding the molten plastic resin from a die (26) to form a male profile having a base portion (52) connected to a generally arrowhead-shaped tip (50) by a stem (54) and guiding the male profile into convergence with a travelling film web (10) and joining the male profile to the film web (10) together to secure the profile to the film web (10), characterized by, extruding the male profile from the die (26) in a form having a generally concave base portion.

2. The method of claim 1 characterized in that the ratio of the thickness of the stem (54) to the thickness of the base (52) is approximately 1 : 1.

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Revendications

1. Procédé de formation d'un élément d'agrafage plastique nervuré (30) fixé à une bande de film sous-jacent pour un récipient plastique pouvant se refermer, comportant les étapes consistant à faire fondre une résine thermoplastique pour former une résine plastique fondue et à extruder la résine plastique fondue hors d'une filière (26) pour former un profil mâle présentant une portion de base (52) reliée à une pointe (50), ayant la forme générale d'une tête de flèche, par une tige (54) et à guider le profil mâle pour qu'il vienne converger avec une bande de film en déplacement (10) et à joindre ensemble le profil mâle à la bande de film (10) pour fixer le profil à la bande de film (10), caractérisé en ce que l'on extrude le profil mâle hors de la filière (26) sous une forme présentant une portion de base de



me générale concave.

2. Procédé selon la revendication 1, caractérisé en ce que le rapport de l'épaisseur de la tige (54) à l'épaisseur de la base (52) est approximativement 1:1.

3. Procédé selon la revendication 1, caractérisé en ce que le rapport de la hauteur hors-tout du profil mâle à la longueur de la base est approxima-

tivement 1:1.

4. Procédé selon la revendication 1, caractérisé en ce que la surface inférieure de la base est définie par l'arc d'un cercle ayant un rayon allant de 0,38 à 0,51 cm (0,15 à 0,20 pouce).

5. Procédé selon la revendication 1, caractérisé en ce que le degré de concavité de la portion de base (52) est environ 0,1.

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