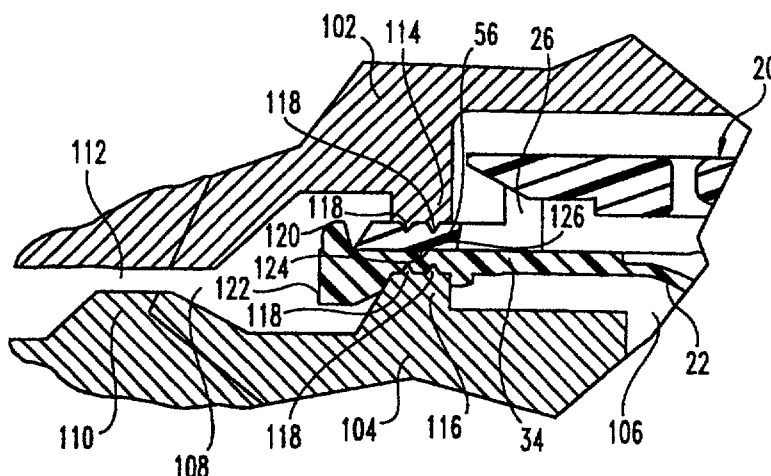


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(54) Title: INSERT MOLDED TAMPER EVIDENT POURING SPOUT



(57) Abstract

A flexible pouring spout (22) for material containers incorporating a tamper evident ring (26) having the container cover (12) molded around the peripheral edge (34, 56) of the spout and ring to integrally bond both the spout and its tamper evident ring within the cover; the closure spout generally includes a dispensing orifice and a cap member (24) for selectively closing the spout. A tamper evident ring is connected to the cap member by a series of frangible elements (52). Both the spout and the tamper evident ring include peripheral flanges (34, 56) which are molded directly within the container cover upon formation of the cover. The spout and cap with its tamper evident ring are inserted into the mold (100) for the container cover with the peripheral flanges extending pivotally into the mold for the cover. Upon molding the cover, the molten plastic will envelope the flanges creating an integral bond with both the spout and tamper evident, creating dual tamper evidence for the container closure. Both the mold and the preferred closure include structural features which prevent molten plastic from flowing between the flanges of the spout and tamper ring thereby eliminating deformation of the closure during molding of the container cover by reducing the force of the molten plastic directly on the closure.