

Title (en)
Manufacture of bulk bags

Title (de)
Herstellung eines flexiblen Schüttgutbehälters

Title (fr)
Fabrication de sacs de grande capacité

Publication
EP 0720956 B1 19980722 (EN)

Application
EP 95100063 A 19950103

Priority
EP 95100063 A 19950103

Abstract (en)
[origin: EP0720956A1] A method of manufacturing a bulk bag (10) having a side wall (11,12,13,14) height H of at least about twenty inches (51 cm) and a total circumferential length L of at least about ninety inches (228 cm) comprises fabricating a fabric side wall structure having a height H and a total circumferential length L, and providing a plurality of lift loops (61,62,63,64) each having a first (65) and second (66) leg portion. The legs (65,66) of each lift loop (61,62,63,64) are aligned at spaced locations around the top of the side wall (11,12,13,14) structure, in positions for ready penetration by the tines of a forklift truck, with both leg portions (65,66) of each lift loop (61,62,63,64) extending a given distance downwardly from the top edge of the side wall (11,12,13,14) structure. The leg portions (65,66) of each of the lift loops (61,62,63,64) are stitched to the top of the side wall structure by at least three parallel lines (81) of high-strength thread, preferably by chain stitching or lock stitching. The stitching lines (81) are all sewn in one or at most two passes; they extend horizontally across the lift loop legs (65,66) to anchor the lift loops (61,62,63,64) securely to the top of the side wall (11,12,13,14) structure. There is no horizontal fold of the top of the side wall (11,12,13,14) structure extending down to the anchor stitching (81). <IMAGE>

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