Nov. 11, 1969 M. KISH, JR 3,477,553

LUGGAGE HAVING A ZIPPER CLOSURE

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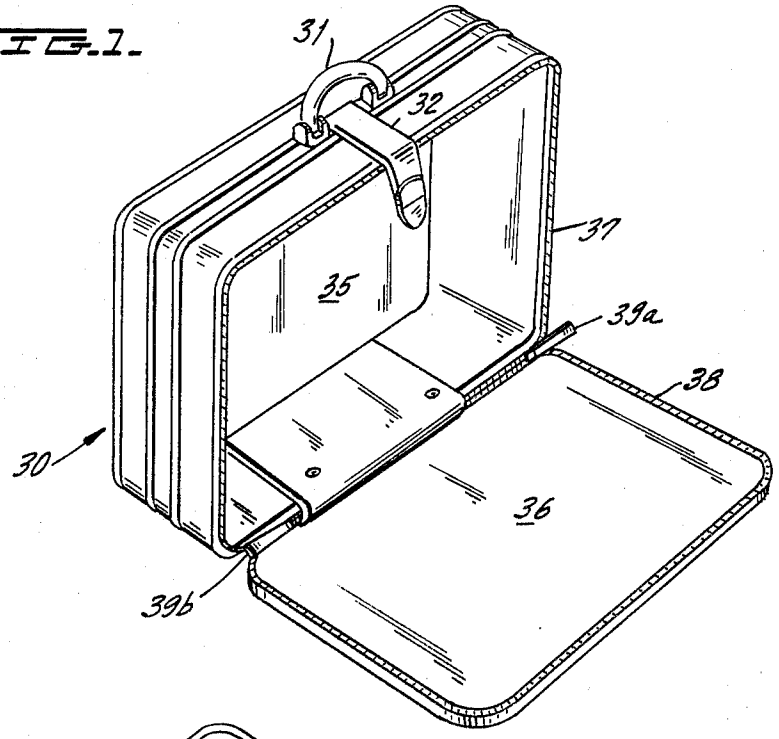
FIG. 1.



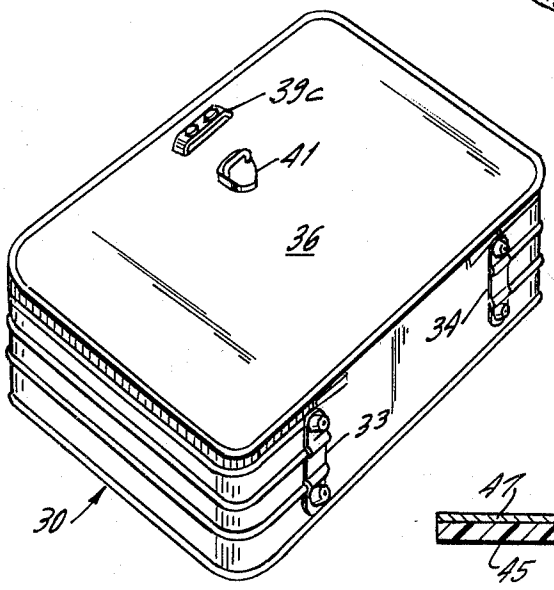




FIG. 2.

FIG. 4.

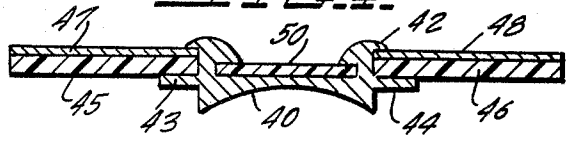
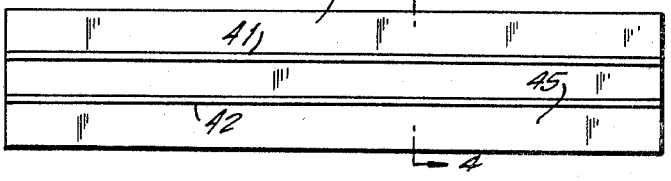



FIG. 3.

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LUGGAGE HAVING A ZIPPER CLOSURE

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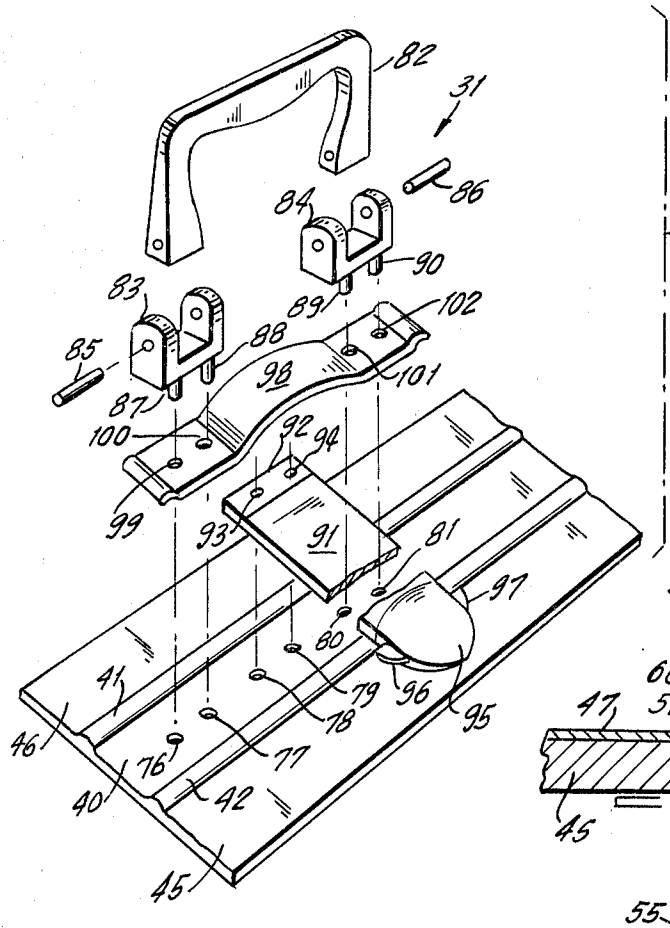


FIG. 8.

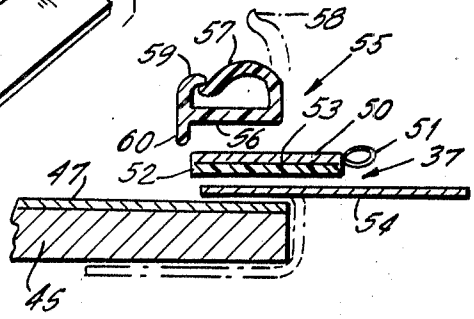


FIG. 5.

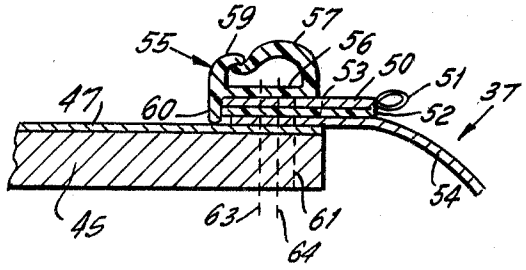


FIG. 6.

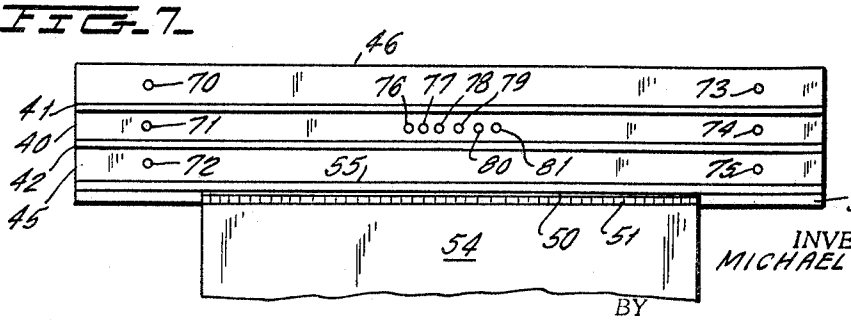


FIG. 7.

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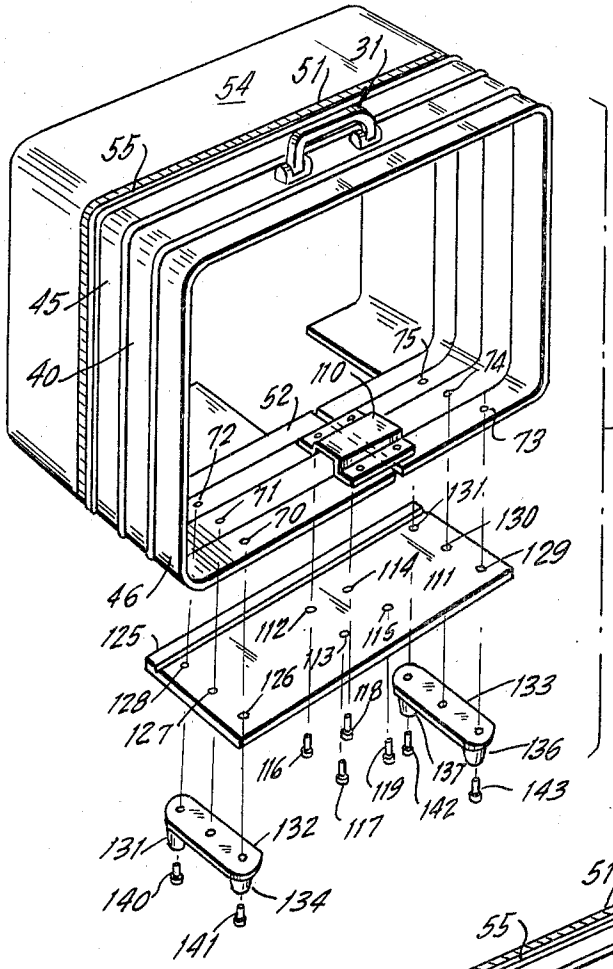


FIG. 9.

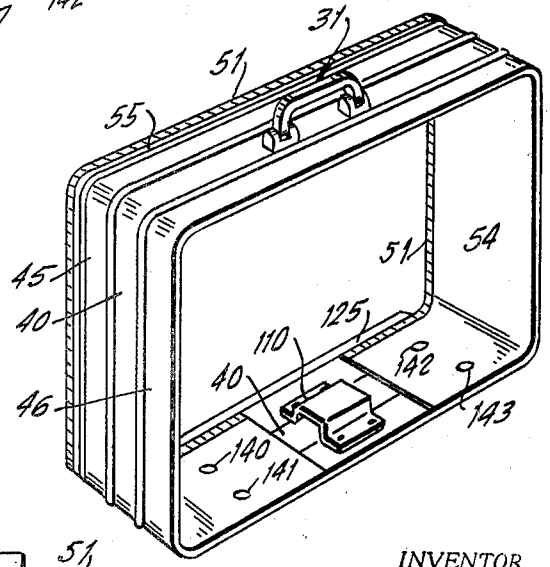


FIG. 10.

FIG. 11.

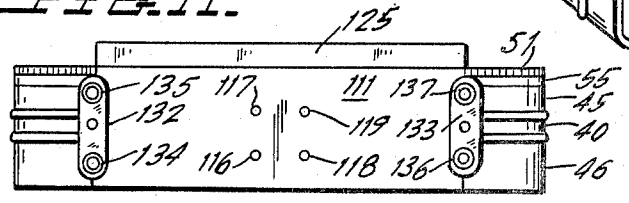


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FIG. 12

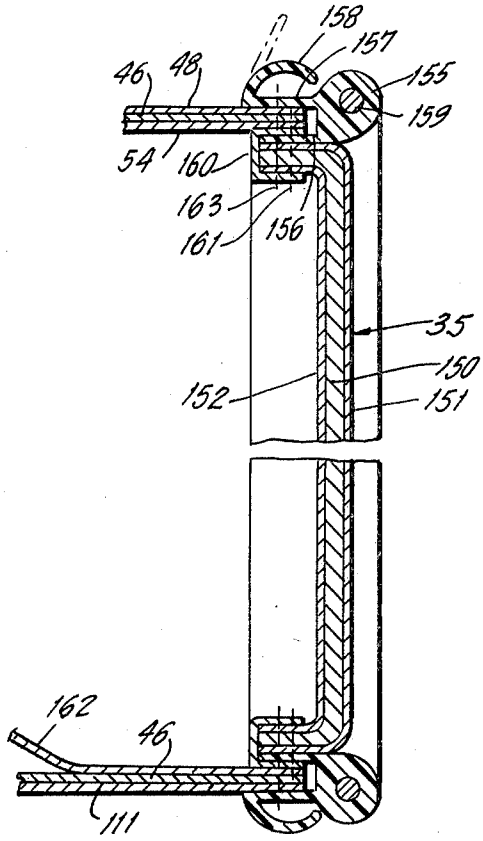
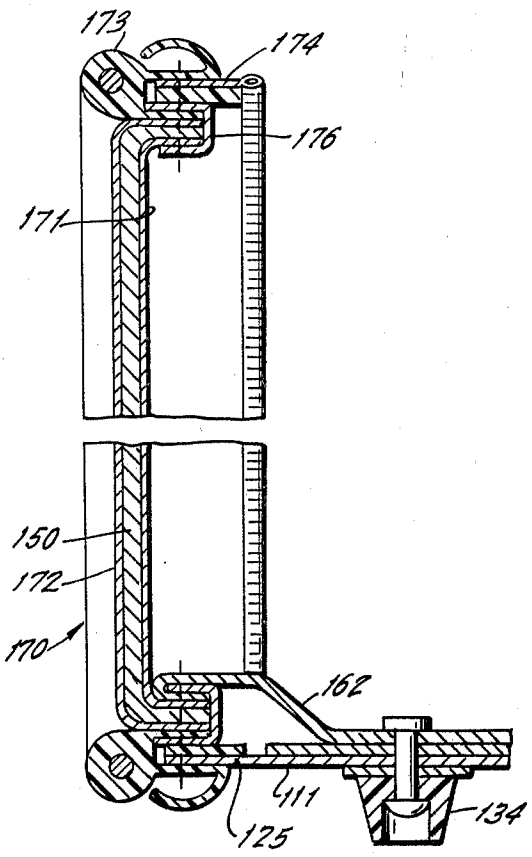



FIG. 14



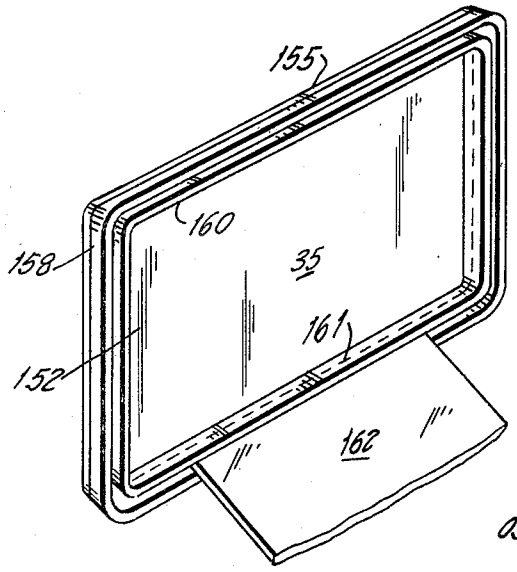




FIG. 13

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FIG. 16.

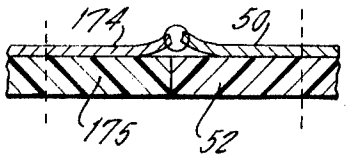



FIG. 17.

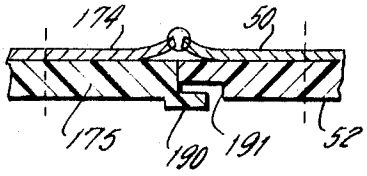



FIG. 15.

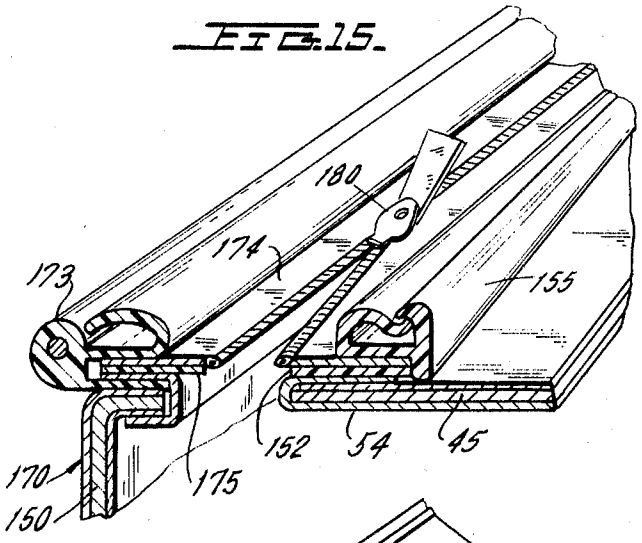



FIG. 20.

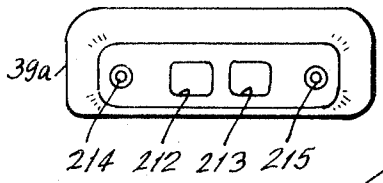



FIG. 21.

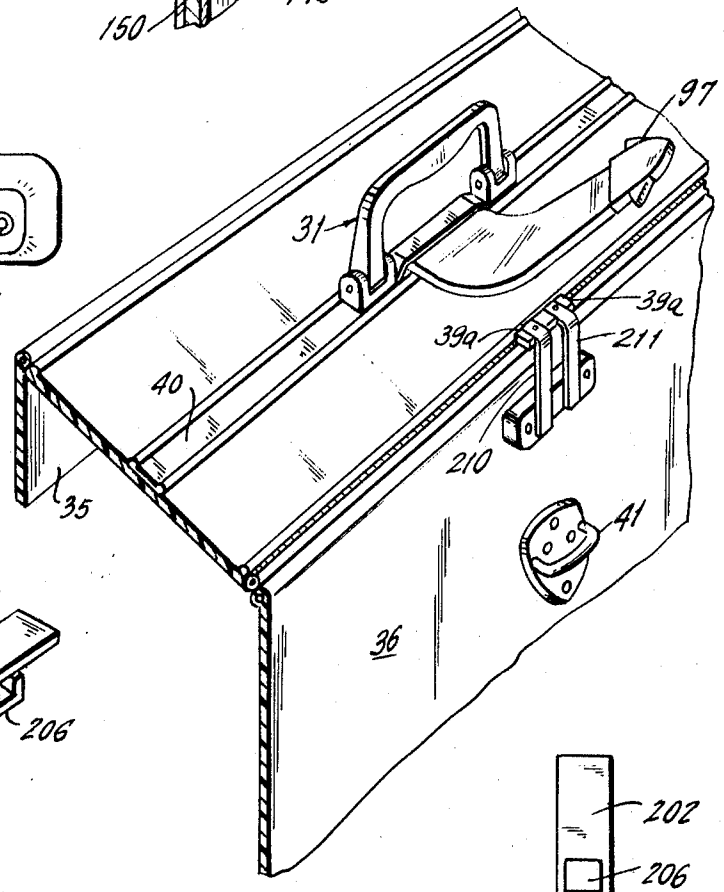



FIG. 18.

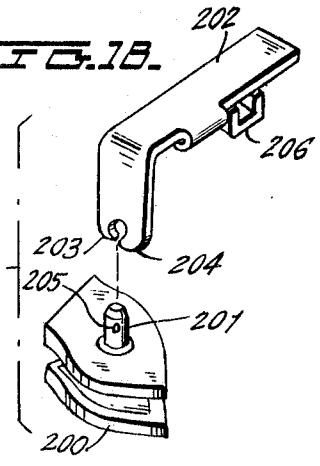
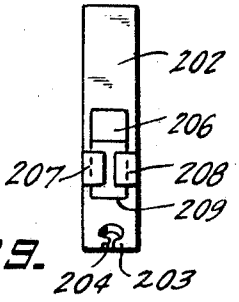



FIG. 19.



United States Patent Office 3,477,553 Patented Nov. 11, 1969



3,477,553

# LUGGAGE HAVING A ZIPPER CLOSURE

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Filed June 21, 1967, Ser. No. 647,841
Int. Cl. A45c 3/00; B23p 9/00; A44b 19/00
U.S. Cl. 190—41 9 Claims

## ABSTRACT OF THE DISCLOSURE

A zipper closure for luggage extends around one edge of the main frame to close a side panel of the luggage. The frame, including the zipper half extending along one side, is manufactured in the flat, and thereafter bent to tubular form. A lining tube extends from the zipper half in the flat, and is cuffed inwardly and over the frame interior after the frame is bent to the tubular form. An extruded plastic welt is used which has an inwardly curled top surface which curls over the stitch line otherwise visible from the exterior of the bag, with the outer edge of the inwardly curled section latching into a cooperating extension in the body portion of the welt to hold the flat in position. The cooperating zipper halves lie atop rigid plastic strips which generally abut one another when the zipper is closed and serve to reinforce the zipper fabric and to permit easier opening and closing of the zipper. A lock construction is formed with two zipper runners used for the zipper closure, each having L-shaped pulls which are pivotally mounted and swivelly extend from the runner. The two pulls are butted against one another with their L-shaped pulls wrapping over the edge of the bag and are received in spaced slots on the bag wall. A closure strap extending from the center of the frame overlies the zipper pulls and is locked into a receiving clamp to prevent access to the zipper pulls while the leather strap is in position.

This invention relates to luggage and a novel method of manufacture therefor.

In accordance with a first feature of the invention, a method of manufacture is used which is in part similar to the method disclosed in U. S. Patent 3,305,052 in the name of Michael Kish, Jr., entitled "Luggage and Method of Manufacture for Luggage," and assigned to the assignee of the present invention.

In the foregoing patent, the entire luggage frame is finished in the flat, and is thereafter bent to tubular form. Two sides are then secured to the frame where one of the sides has a zipper therein to provide access to the interior of the bag.

In accordance with an important feature of the present invention, a novel method of manufacture is used where the bag opening is formed of a zipper extending directly around the full side of the bag, as contrasted to a zipper flap used in the above noted patent. Substantially the entire frame is constructed in the flat, including securement of one of the zipper halves and a welt to the frame. At the same time and in the flat, the interior lining is secured to only one side of the frame with this lining being later "cuffed" over into the interior of the bag and secured in place when the opposite side wall is connected to the frame.



It is, therefore, an important object of the present invention to provide a novel method of manufacture for luggage having one side wall attached to the side edge of the bag frame by a zipper.

Yet another object of this invention is to provide a novel method of manufacture for the above type of luggage which substantially reduces manufacturing costs.

In the specific bag to which the application is directed, a zipper construction is used wherein each of the extending zipper fabrics have located directly beneath them a thin, a relatively rigid strip of material which may be of nylon or the like. The edge of the strip extends to about the mid-portion of the zipper teeth or zipper coil whereby the strips will serve as a support for the zipper fabrics with the strips of the two zipper halves substantially abutting one another when the zipper is closed. This then accomplishes several important effects. The first is that the zipper halves will not collapse inwardly as would occur in the prior art since they are supported by the relatively rigid strips beneath them whereby the zipper runner can run smoothly around the circular path including the corners of the bag when the bag is to be closed. As a second important feature, and since the relatively rigid strips abut one another, they impart a lateral stability to the closure area and prevent an inward motion of the zipper fabric halves beyond one another because of their abutting connection. As a third feature, and since the relative rigid strips abut one another, they aid in preventing seepage of water or moisture into the bag through the relatively open zipper teeth when the teeth are locked together. As a still further advantage of the placement of relatively rigid strips below the zipper fabric, it becomes more difficult to penetrate the zipper as with a sharp object to cause inadvertent zipper opening by laterally spreading the zipper teeth.

It is, therefore, a further important object of this invention to provide a novel zipper fabric mounting structure for luggage or other articles which are to be closed by a zipper which positively supports the zipper fabric; permits smooth movement of the zipper pulls around the zipper; permits an improved water sealing for the zipper; and supports the zipper fabric both laterally and transversely.

As a further feature of the invention, a novel welt is provided which has elongated overlying sections which will tend to curl over the lower welt body in order to cover any stitching extending through the main and lower welt body.

In accordance with another feature of the present invention, this welt is formed of an extruded plastic material where the free edge of the overlapping section is provided with an upwardly turned section which, when the overlapping section closes or is in overlapping relation with the main welt body, the upwardly extending projection can latch into a cooperating projection extending beyond the edge of the main welt body. Thus, the overlapping section will be securely held in position over the stitch line to provide a more positive protection for the stitch line and more attractive appearance for the bag.

Accordingly, another object of this invention is to provide an improved extruded plastic welt which has an overlapping section for covering external stitch lines which is locked in position after the overlapping section is closed.

In the bag of the present invention, the zipper closure may be accomplished by a pair of zipper pulls riding on the same zipper member and which abut one another at the top of the bag in order to close the zipper. In the past, such zippers have been provided with pivotally mounted pulls which can rotate in a plane parallel to the plane of the zipper closure. In order to lock such zippers in position, it has been the common practice to bring the zippers toward one another and then to lay the pulls flat in directions facing the opposing runner. A locking mechanism was then used to clamp the zipper runners in position. In this type structure, the zipper runners are necessarily separated from one another by a distance equal to the length of the two pulls since the ends of the two pulls abut one another in the locking position. Therefore, the zipper is necessarily open for this distance. This causes an unsightly appearance and makes it possible for moisture to enter the bag easily through this open zipper portion.

In accordance with an important feature of the present invention, the zipper pulls are formed with L-shapes with one of their ends being swivelly mounted to their corresponding runners. Clearly, such swivelly mounted pulls are old and well known even in luggage application, but such arrangements have never been used in combination with locks for two cooperating zipper runners. Each of the L-shaped runners are then provided with outwardly extending tangs on their outermost legs. The L-shaped pull is then arranged so that it can lie over the side edge of the bag. The side of the bag frame is then provided with a clamping plate having two spaced openings therein which receive the tangs of the two L-shaped zipper pulls. Thus, in order to close the zipper, the two pull sections are brought immediately next to one another so that the entire zipper is closed and the swivelly mounted L-shaped pulls are rotated and swivelled so that their tangs can be inserted into the openings in the clamping plate. Thereafter, a flexible strap having one end securely connected to the center of the frame overlies the L-shaped zipper pulls and is snapped into a conventional latch located beneath the clamping plate. This then makes it impossible for one to gain access to the zipper pulls until the strap is unlocked and moved upwardly.

Accordingly, it is another important object of this invention to provide a novel zipper locking arrangement for luggage.

Yet another object of this invention is to provide a novel zipper pull construction which adapts to a novel and inexpensive locking structure.

A further object of this invention is to provide a novel zipper pull structure for zipper closed luggage which permits complete closure of the bag by two closing zipper runners when the zipper runners are moved adjacent one another and locked in position.

These and other objects of this invention will become apparent from the following description when taken in connection with the drawings in which:

FIGURE 1 is a perspective view of luggage manufactured in accordance with the present invention with the zipper side open.

FIGURE 2 is a perspective view of the bag of FIGURE 1 as seen from the bottom and with the zipper flap closed.

FIGURE 3 is a top plan view of the three main frame sections assembled in the flat.

FIGURE 4 is a cross-sectional view of FIGURE 3 taken across the section line 4—4 in FIGURE 3.

FIGURE 5 illustrates an exploded cross-sectional view of the assembly of one of the zipper halves, its lower zipper guide, and its upper welt construction before connection to one edge of the frame of FIGURES 3 and 4.

FIGURE 6 illustrates the structure of FIGURE 5 after assembly thereof as by sewing.

FIGURE 7 is a plan view of the structure in the flat after the steps of FIGURES 5 and 6.



FIGURE 8 is an exploded perspective diagram illustrating the connection of the handle and closure flap applied to the flat assembly of FIGURE 7.

FIGURE 9 is an exploded perspective view illustrating the formation into a tube of the flat assembly of FIGURES 7 and 8 along with the means for securing the tube ends and for securing the bottom finishing panel of the bag and the bag legs.

FIGURE 10 is a bottom plan view of the bag in the stage of FIGURE 9 after assembly.

FIGURE 11 is a perspective view of the tube of FIGURES 9 and 10 after the finishing tube has been inwardly folded into the frame.

FIGURE 12 is a cross-sectional view of the fixed side panel secured to one side of the frame of FIGURE 11.

FIGURE 13 illustrates the side panel of FIGURE 12 prior to its assembly with the frame of FIGURE 11 and illustrates the securement of the bottom interior finishing strip which is previously connected to the side panel.

FIGURE 14 is a cross-sectional view of the zippered side panel which is connected to the opposite side of the frame of FIGURE 11 with the bottom portion of the frame of FIGURE 11 partially shown.

FIGURE 15 is a sectional perspective view illustrating the operation of the zipper closure with special reference to the lower zipper support strips.

FIGURE 16 is a sectional view of the zipper support strips and zipper fabrics alone.

FIGURE 17 illustrates a second embodiment for the construction of the abutting surfaces of the zipper support strips.

FIGURE 18 is an exploded perspective view of the novel zipper pull of the present invention in connection with a zipper runner having a rotatable pull connection rod.

FIGURE 19 is a bottom plan view of the runner of FIGURE 18.

FIGURE 20 is a front plan view of the clamping plate which receives the tangs of two zipper runners to perform the novel locking function of the invention.

FIGURE 21 is a perspective view of the top central portion of the bag, and illustrates the zipper runners in their latched position, and further illustrates the cooperation of the locking strap with the runners.

Referring first to FIGURES 1 and 2, there is generally illustrated the luggage constructed in accordance with the present invention. The luggage is comprised of a main central frame body **30** which has a carrying handle **31**, a locking strap **32**, and bottom support leg plates **33** and **34**. A fixed side panel **35** then extends across one side of frame **30** while a second and zippered side panel **36** extends across the opposite side of frame **30** and is secured to the frame **30** by cooperating zipper halves **37** and **38** connected to frame **30** and zipper panel **36**, respectively. Two zipper pulls **39***a* and **39***b* then cooperate with the zipper halves **37** and **38** to close zipper panel **36** across the open side of frame **30**. The front surface of zipper panel **36** then carries a locking plate **39***c* and a latch **41** where the locking plate **39***c*, as will be described hereinafter, receives the zipper pulls **39***a* and **39***b* which are subsequently covered by locking strap **32** which overlies the plate **39***c* and is locked into locking plate **41** in the usual manner.

The novel features and construction of the bag of FIGURES 1 and 2 may be best understood from the following description of the manufacturing steps of the bag.

Referring to FIGURES 3 and 4 which show the initial manufacturing process for the frame structure **30**, substantially all of the frame will be seen to be manufactured in the flat. Initially, a central metallic elongated extrusion **40**, shown in FIGURES 3 and 4, is provided wtih two extending abrasion surfaces **41** and **42** which, in combination with lower shelf sections **43** and **44**, define a channel for receiving frame strips **45** and **46**, respectively. The strips

45 and 46 may be composed of any suitable body material such as fiber or leather, or the like, and are covered with finishing strips 47 and 48 which will form the finished surface. The strips 45 and 46 are then securely locked between heads 41 and 42 and shelves 43 and 44 in any desired manner, which has been described in detail in above noted Patent 3,305,052. A decorative strip 50 may also be captured between heads 41 and 42, respectively, as illustrated in FIGURE 4 again as described in the above noted patent.

After the securement in the flat of members 40, 45 and 46, the next step in the manufacture is the connection of a zipper half to the edge of strip 45. This construction is best shown in FIGURES 5, 6 and 7 where a zipper half is composed of a fabric section 50 which may have a plastic coil 51 along the edge thereof. Note, however, that other zipper structures of the type using metallic teeth, as contrasted to the plastic coil variety, could be used in the bag of the present invention.

In accordance with an important feature of the invention, the fabric section 50 is laid atop an extruded plastic strip 52 which is relatively rigid, although it is capable of being bent into the shape of the tube when the bag frame is subsequently formed. Strip 52, however, is sufficiently rigid to provide a strong platform for the fabric 50. A typical strip 52 has been formed of nylon having a thickness of about 1/32 of an inch and a width of about ½ an inch. Similarly, the zipper fabric may have a width of about ½ inch with the right-hand edge of strip 52 lying under the zipper structure, running along a central portion of the zipper tooth or coil. It should be further noted that the zipper fabric 50 and strip 52 are sewn together as by stitch line 53 so that they form a subassembly.

A sheet of finishing lining 54 has one edge thereof placed atop the outer edge of strip 47, as illustrated in FIGURE 5, and the combined zipper fabric and strips 50 and 52 are laid atop the left-hand edge of lining 54. Thereafter, an extruded plastic welt 55 is laid atop fabric 50. Welt 55 has a main body portion 56 and a covering flap 57 which can be spread upwardly to the dotted line position. Flap 57 has an upwardly projecting tip 58 (indicated in the dotted line portion) which can latch under the hook-shaped cooperating section 59, extending from the main body 56. Thus, when the flap 57 is placed in its latched position, it cannot be unintentionally raised to expose the interior of body 56 which will carry a line of stitching. It will be further observed that body 56 has a downwardly projecting leg 60 which snugly fits over the stacked edges of members 50, 52 and 54 during the connection of these members to member 45.

The assembled structure is illustrated in FIGURE 6 where during the assembly zipper fabric 50, strip 52 and lining 54 are initially sewn to strip 45 as by the stitch line 61. Thereafter, the welt 55 is laid atop these members, as shown in FIGURE 6, the flap 57 is raised to its dotted line position and two stitch lines 63 and 64 pass through the body 56 of the welt 55 and through the stacked members thereby to securely connect them together.

In a subsequent operation, the fabric lining 54, which now extends outwardly from the flat frame assembly, as shown in FIGURE 7, will be tucked around or cuffed around the bottom of the frame, as illustrated in dotted lines in FIGURE 5. Note that the width of lining 54 is approximately equal to the full width of the frame. It should be further noted that the lining 54 has a length which falls short of the ends of strips 40, 45 and 46. In addition, while guide strip 52 extends for the full length of strips 40, 45 and 46, the zipper fabric and zipper need extend only as far as illustrated, since the portions uncovered by lining 54 will be at the bottom interior of the bag which is to be covered by other lining means, as will be illustrated.

With the frame structure still in the flat, as illustrated in FIGURE 7, a plurality of openings may be formed through the frame which subsequently receive hardware. For example, openings 70, 71, 72, 73, 74 and 75 are formed in what will become the bottom of the bag for subsequently receiving the support legs. Similarly, a series of five openings 76 through 81 are formed in the central portion of the frame which is to become the top of the bag for receiviig the carrying handle and locking strap.

The carrying handle and locking strap are shown in exploded view in FIGURE 8 with this structure connected to the frame of FIGURE 7 while the frame is still in the flat. The carrying handle may typically be comprised of a handle member 82 which is pivotally carried in brackets 83 and 84 by pins 85 and 86, respectively. Each of brackets 83 and 84 have downwardly extending legs 87–88 and 89–90 which are respectively received by openings 76, 77, 80 and 81 in the frame structure of FIGURE 6.

A locking strap 91 is then provided which has a metallic mounting member 92 integrally connected thereto which has openings 93 and 94 therein. Suitable rivets (not shown) passing through openings 93 and 94 and through openings 79 and 80 in the frame connect the end of strap 9 to the frame. Note that the opposite end of strap 91 has a suitable typical locking head 95 which has spring biased areas 96 and 97 extending from the sides thereof which can be received, for example, in locking hook 41 of FIGURE 2. A decorative plate 98 overlies the metallic end of strap 91 and is interposed between brackets 83 and 84 and the strip 40 which receives the hardware. Strap 98 has openings 99, 100, 101 and 102 for receiving members 87–88 and 89–90, respectively, so that strap 98 can be rigidly held in place beneath brackets 83 and 84.

After the handle assembly 31 is completed, as illustrated in FIGURE 8, the flat subassembly is then formed into a tube, as shown in FIGURE 9. Thus, as shown in FIGURE 9, the two opposite ends of the end of FIGURE 7 are butted together and are held in place by a metallic bracket 110. The metallic bracket 110 also receives a bottom finishing fiber sheet 111, the bottom of which is covered with a suitable finishing layer. Sheet 111 has openings 112, 113, 114 and 115 therein which cooperate with rivets 116 through 119, respectively, which enter respective openings in plate 110 whereby the finishing layer 111, plate 110 and the adjacent ends of the frame are connected together in a single operation. Note that the plate 110 has a shallow inverted U-shape to fit across the bottom of extrusion 40 shown in FIGURE 4. The bottom finishing strip 110 has a width greater than the frame width and includes a flexible or hinged end section 125 which will serve to carry the zipper panel 36, as will be described hereinafter. In addition, openings 126 through 131 are formed at the ends of member 111 and are in alignment with openings 70 through 75, respectively, in the frame bottom.

Leg hardware members 132 and 133 which have downwardly projecting legs, best seen in FIGURE 9, which carry legs 134–135 and 136–137, respectively, have suitable openings in alignment with openings 127–128 and openings 129–130 and 131, respectively, so that rivets or other suitable securing means can pass directly through these aligned openings 70–71–72 and openings 73–74–75, respectively, in the frame. It is to be noted, however, that at this point of manufacture of the bag the securing rivets, which are to be secured by openings 70 and 73, are not yet placed in position, this being done at a later stage of the manufacture.

After the securement of the bottom finishing member 111, plate 110 and leg hardware 132 and 133, the lining fabric 54 is cuffed inwardly to overlie the interior of the tubular frame so that the bag will now have the appearance shown in FIGURES 10 and 11. It is to be noted that this cuffing operation is performed before the rivets 140–141 and 142–143 are placed in position within openings 70–71 and 73–74, respectively, so that the rivet heads can be seen in FIGURE 11 and assist in holding the lining 54 in position.

The main frame of the bag is now substantially complete in its manufacture with the exception of a bottom

covering finishing strip which will extend across the exposed rivet heads **40** through **43**, the ends of finishing strip **54**, and the plate **110**. This lower finishing strip is connected to the frame at the same time that the sides are connected thereto.

FIGURES 12 and 13 show the construction of the fixed side panel which is to be connected across the end of the frame of FIGURE 11 which is opposite the end carrying the zipper half.

Referring now to FIGURES 12 and 13, the fixed panel **35** is comprised of a main body section **150** which has an outer finishing layer **151** and inner lining layer **152** which are integral with the body **150**. In assembling the fixed side, an extruded welt **155** is utilized which has a lower leg **156** and an upper shelf **157** which has a covering flap **158** extending therefrom. A metallic wire **159** is extruded into welt **155** to impart rigidity to the welt. In assembling the fixed panel, the outer edges of the panel are inwardly dished with the inwardly dished section sewn to the bottom of welt portion **156**. Note that a short finishing strip **160**, which wraps around the edge of the panel **150** and the edge of member **155**, is also sewn to the subassembly with a single stitch line.

During this sewing operation and along the bottom of the fixed panel, an additional finishing sheet **162** is secured adjacent the outside of finishing strip **160**, as best shown, for example, in FIGURE 13. FIGURE 13 represents the side panel at this stage of manufacture and prior to the assembly of the panel to the frame. FIGURE 12 illustrates further the frame of FIGURE 11 being inserted into the region between upper member **157** and welt **155** and the top of the finishing strip **160** or, at the bottom of the panel, the bottom of finishing strip **162**. The flap **158** is then raised, as indicated in the dotted lines of FIGURE 12. A single line of stitching **163** is passed through the edge of the frame, the welt member **157** finishing strip **160**, welt member **156**, and the inwardly turned edge of body **150** in order to secure the fixed panel to the frame. Note that the top portion of the frame of FIGURE 12 includes the frame body **46** which has an integral outer finishing layer **48** along with the lining **54** which is sewn into place with the common stitch line **163**. Since the section of FIGURE 12 is taken through the bag, at the bottom, the section does not show finishing layer **54**. However, the bottom portion of the frame includes the bottom finishing layer **111**, strip **46**, and the additional finishing strip **162** which subsequently covers the bottom of the frame.

It now remains to secure the zipper panel to the other side of the frame and to connect finishing strip **162** over the bottom of the frame.

FIGURE 14 illustrates the construction of the zipper panel **36** in cross-section. The zipper panel **36** is composed of a panel body similar in construction to that shown in FIGURE 12 having a central body portion **170**, an interior lining **171** and an exterior lining surface **172**. A welt construction **173**, similar to welt **155** of FIGURE 12, is used to connect the inwardly dished periphery of the panel body to zipper half **174**, having a guide strip **175** therebeneath, and to the main panel body in a stitching process similar to that described for FIGURE 12. Note that a covering strip **176** wraps around the lower extending member and welt **173** and the inwardly bent portion of the panel in the manner described in FIGURE 12. Obviously, the zipper fabric **174** shall serve the function of zipper **38**, shown in FIGURE 1, and is intended to cooperate with zipper **51** of FIGURE 11.

At the bottom of the bag, it will be recalled from FIGURES 9 and 11, that the bottom finishing layer has an extending portion **125**. The portion **125** is inserted into the welt **173** and is sewn in position thereby to rigidly connect the bottom of the zipper panel **170** to the frame independently of the zipper. Note that extending portion **125** is capable of bending so that it acts as a pivot for opening and closing panel **170**.

During the operation in which stitch portion **125** of bottom finishing layer **111** is secured to welt **173**, the finishing strip **162** of FIGURE 13 is wrapped under finishing strip **176** and is thus sewn into position. Note that strip **162** is somewhat bellied outwardly to permit rotation of panel **170** with strip portion **125** as the panel is opened and closed. Moreover, before the securement of the end of finishing strip **162** to the panel **170**, the zipper runners are connected to the cooperating zipper halves **174** for the zipper panel **51** for the frame.

After this, the sewing operation is performed to connect the upper half of finishing strip **176** and the end of finishing strip **162** to the bottom of welt **173**. Thereafter, the third rivets for the bottom legs, such as the rivet extending through legs **134** of FIGURE 9, are placed in position and capture finishing strip **162** so that it will be held snugly against the bottom of the bag in covering relation with plate **110** of FIGURE 11 and the rivet heads **140** through **143** in FIGURE 11.

FIGURES 15, 16 and 17 illustrate the method in which the relatively rigid strips act during the zipper operation.

Referring first to FIGURES 15 and 16, it is seen that when a zipper runner **180** closes the zipper halves, the relatively rigid strips **175** for the zipper panel **170** and **145** for the side of the frame will prevent the downward collapse of the zipper halves thereby to prevent the catching of the zipper which would make it difficult to continue to run the zipper and requiring the backing off of the zipper. In addition, as shown in FIGURE 16, the adjacent edges of strips **52** and **175** are in substantial abutment, thereby preventing lateral or inward movement of the zipper halves **50** and **174** toward one another, thus making the bag more rigid even though it has a flexible fabric zipper closure.

The guide strips **52** and **175** not only serve to improve the operation of the zipper, but they further operate to prevent entrance of moisture into the bag through the relatively open zipper loops and also make it more difficult to pry the zipper loops apart by forcing a sharp object into the zipper loops.

In FIGURE 16, the adjacent or abutting sides of strips **52** and **175** are flat sections. Improved guiding operation can be obtained, as illustrated in FIGURE 17, as by providing an extending flange **190** on strip **175** and a cooperating shoulder **191** on the strip **52**. This type of configuration would improve the abutment action of the two strips to prevent their misalignment and the slipping of one under the other under lateral forces.

FIGURES 18 through 21 illustrate the novel locking structure which is used in the bag. As shown in FIGURE 2, a locking plate **39***c* and locking hook **41** are connected to panel **36**. Clearly, this connection can be made, as by riveting, after the completion of the panel construction in FIGURE 13. A novel zipper pull construction is used, as illustrated in FIGURES 18 and 19, for cooperating with plate **39***c* of FIGURE 2 for securely locking the two zippers **39***a* and **39***b*. More particularly, a zipper pull **200** is used, which is of a standard variety, and has a swivel post **201** extending therefrom. The zipper pull is comprised of an L-shaped member **202** which has opposing prongs **203** and **204** in the end of one leg thereof which snap into opening **205** of the swivel post **201**. Thus the pull **202** can be rotated about the axis of opening **205** and can revolve around the rotational axis of post **201**. The L-shaped pull **202** then has a tang **206** extending therefrom which can be secured to the pull **202** by inwardly bent tabs **207** and **208** which are bent inwardly to be connected to a rearwardly extending platform **209** of tang **206**.

The two zipper runners and pulls **39***a* and **39***b* of FIGURE 1 are constructed in a manner identical to that shown in FIGURES 18 and 19 and are illustrated in place in FIGURE 21 on the completed bag with runners abutting one another so that the bag is completely closed. The L-shaped pulls **210** and **211** of FIGURE 21, which

are identical to pulls **200** of FIGURES 18 and 19, are then bent over the edge of the bag with their tangs registering and entering into openings **212** and **213** of the plate member **39***a*. Note that the plate **39***a* is provided with openings **214** and **125** which serve to receive suitable rivets for connecting the plate to the panel **36**. With the tangs of pulls **210** and **211** fitted or snapped into openings **212** and **213**, the strap **91** is thereafter laid over pulls **210** and **211** and is snapped into the locking ring member **41** which is also riveted to panel **36**. The side ears **96** and **97** then lock into the locking ring **41** so that access to pulls **210** and **211** is prevented, thereby preventing the opening of the zipper without the unlocking of strap **91**. Thus, a simple locking structure is formed with the present invention using the zipper pulls **210** and **211** as instrumental elements in the locking structure where, however, their respective pulls **39***a* and **39***b* are directly abutted against one another so that an unsightly gap is not formed before locking.

Although this invention has been described with respect to its preferred embodiments, it should be understood that many variations and modifications will now be obvious to those skilled in the art.

The embodiments of the invention in which an exclusive privilege or property is claimed are defined as follows:

**1.** In combination; a first extending member, a second extending member, and an elongated welt for connecting said first and second members by sewing; said elongated welt formed of a flexible material, and having a main body portion, an outwardly extending side portion extending from one edge of said main body portion, and a flap portion extending from the opposite edge of said main body portion; said main body portion positioned above overlapped end portions of said first and second extending members; a line of sewing extending through said main body portion, and said overlapped end portions of said first and second extending members; said flap portion flexibly movable from an open position exposing said main body portion to a closed position overlying and enclosing said main body portion; the outer edge of said side portion including engagement means releasably engaging the outer edge of said flap portion to retain said flap portion in said closed position.

**2.** The combination of claim **1** wherein said welt is an extruded plastic member.

**3.** The combination as set forth in claim **1** wherein said first and second extending members comprise at least portions of an enclosure.

**4.** In combination, luggage having a zipper opening and a zipper lock; said luggage comprising a main frame, a side panel extending across an open end of said main frame, cooperating zipper halves extending around the adjacent peripheries of said side panel and said open end of said main panel, a zipper runner extending between said zipper halves, and a zipper pull for said zipper runner; said zipper runner lying in a plane parallel to the plane of one of said side panel or said main frame; means connecting one end of said zipper pull to said zipper runner permitting universal swivelling and pivoting of said zipper pull with respect to said zipper runner; said zipper pull having a generally L-shape; a projection extending from the interior surface of one of the legs of said L-shaped zipper pull; means secured to one of said main frame or side panel having an opening therein for receiving said projection, said means laterally disposed from the path of movement of said zipper runner and receiving said projection when said pull is at right angles to said path of movement of said runner and said L-shaped pull extends around the edge of said luggage defined by the junction of said main frame and said side panel; and a strap closure perpendicular to said zipper halves and having one end secured to one of said main frame or side panel and an opposite end removably connected to the other of said main frame or side panel; said strap closure overlying said means for receiving said projection.

**5.** The combination as set forth in claim **4** wherein said means for receiving said projection is secured to said side panel; said zipper runner moving in a plane parallel to said main frame.

**6.** The combination as set forth in claim **5** which includes a second zipper runner and zipper pull identical to said zipper runner and pull; said means for receiving said projection having two spaced openings therein for receiving the projections of said zipper pull and said second zipper pull, with said zipper pulls parallel to one another.

**7.** The combination as set forth in claim **4** which includes a second zipper runner having a zipper pull identical to said zipper runner and pull; said means for receiving said projection having two spaced openings therein for receiving the projections of said zipper pull and said second zipper pull, with said zipper pulls parallel to one another.

**8.** In combination, luggage having a zipper opening and a zipper lock; said luggage comprising a main frame, a side panel extending across an open end of said main frame, cooperating zipper halves extending around the adjacent peripheries of said side panel and said open end of said main frame, a zipper runner extending between said zipper halves, and a zipper pull for said zipper runner; said zipper runner lying in a plane parallel to the plane of one of said side panel or said main frame; means connecting one end of said zipper pull to said zipper runner permitting universal swivelling and pivoting of said zipper pull with respect to said zipper runner; said zipper pull having a projection extending from the interior surface of said zipper pull; means secured to one of said main frame or side panel having an opening therein for receiving said projection, said means laterally disposed from the path of movement of said zipper runner; and a strap closure perpendicular to said zipper halves and having one end secured to one of said main frame or side panel and an opposite end removably connected to the other of said main frame or side panel; said strap closure overlying said means for receiving said projection.

**9.** In combination; first and second extending members having spaced apart edges to be connected and disconnected by a zipper; said first and second members comprising cooperating portions of an enclosure, a zipper comprising first and second elongated zipper halves each having fabric portions and cooperating engagement portions on outer edges thereof; said first and second elongated zipper halves extending around a major portion of the full periphery of said enclosure; and first and second elongated narrow sheets which are relatively stiff compared to said fabric portions and having a width approximately equal to the width of said first and second zipper halves, respectively; said first zipper fabric portion and said first elongated narrow sheet sewn adjacent to one another and sewn to the outwardly facing surface of said first extending member and adjacent the outer edge thereof with said cooperating engagement portion of said first zipper portion extending beyond the said outer edge of said first extending member; said first elongated narrow sheet underlying said zipper fabric portion with the outer edge thereof extending under at least a portion of said cooperating engagement portion of said first zipper fabric portion; said second zipper fabric portion and said second elongated narrow sheet sewn adjacent one another and sewn to one surface of said second extending member adjacent the outer edge thereof with said cooperating engagement portion of said second zipper portion extending beyond the said outer edge of said second extending member; said second elongated narrow sheet underlying said zipper fabric portion with the outer edge thereof extending under at least a portion of said cooperating engagement portion of said second zipper fabric portion; the opposing edges of said first and second elongated narrow sheets generally abutting one another when said zipper

is closed; said first and second narrow sheets comprising plastic sheets having low surface friction; said first and second zipper fabric portions facing outwardly of said enclosure and being freely supported atop said first and second narrow sheets for a major portion of the widths of said first and second zipper fabric portions.


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