US 20040173481A1

(19) **United States**

(12) **Patent Application Publication** (10) **Pub. No.: US 2004/0173481 A1**

Choi et al. (43) **Pub. Date: Sep. 9, 2004**

(54) **MEDIA STORAGE DISK BOX**

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(21) Appl. No.: **10/704,395**

(22) Filed: **Nov. 6, 2003**

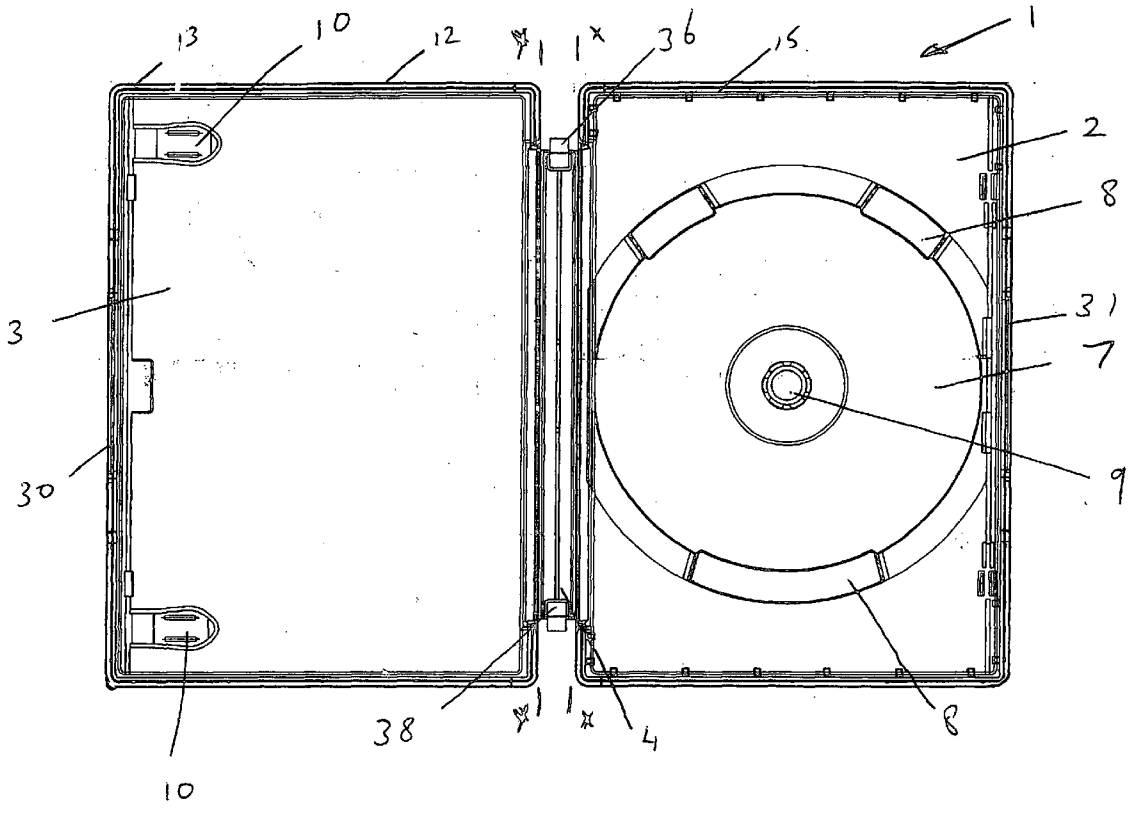
Publication Classification

(51) **Int. Cl.**[7] **B65D 85/57**

(52) **U.S. Cl.** **206/308.1**

(57) **ABSTRACT**

A media storage disk box comprising formed as a unitary plastic body, a first base panel, a second base panel and a spine panel intermediate of the first base panel and the second base panel, wherein formed intermediate of the first base panel and said second base panel is a hinge defining an axis of rotation the hinge allowing movement of the first base panel relative to the second base panel between a closed condition to and an open condition to provide to allow access to the enclosure of the box. The first base panel and second base panel are of a complementary size to, in the closed condition, provide perimeter to perimeter engagement of the first and second base panels. A sheet metal cover is affixed to and overlaying the first base panel to the non enclosure side of the first base panel.



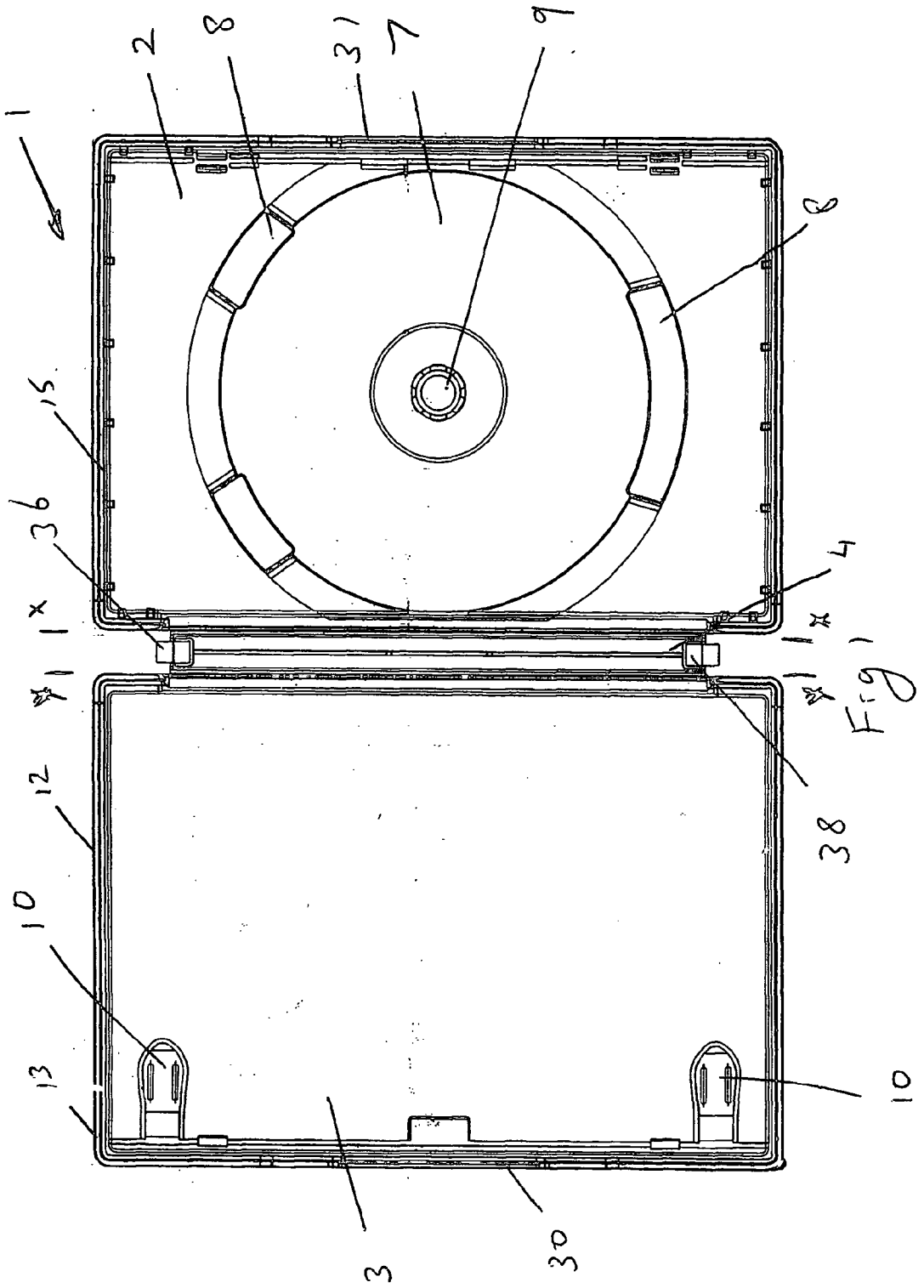


Fig 1

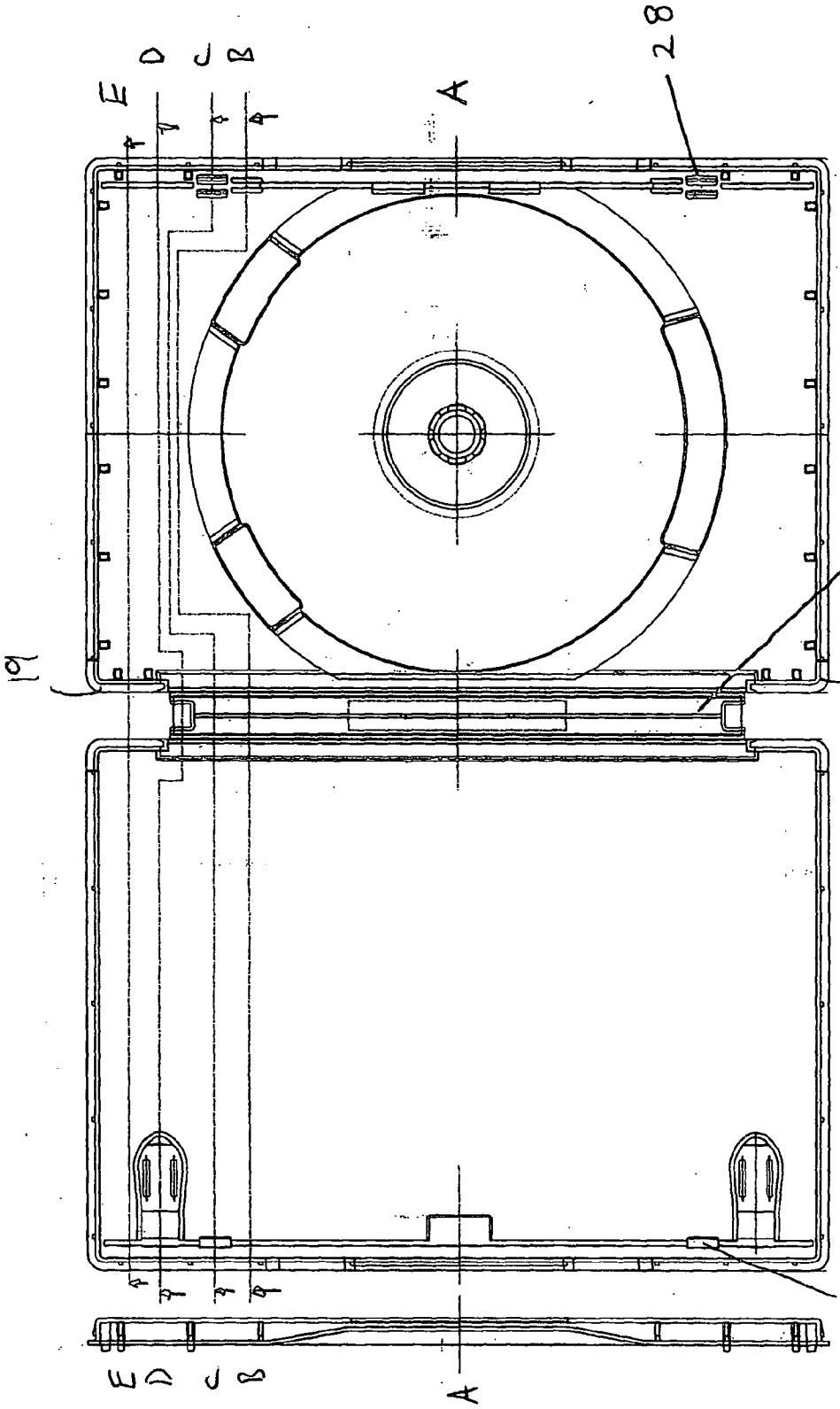


Fig 2 A

Fig 2 B

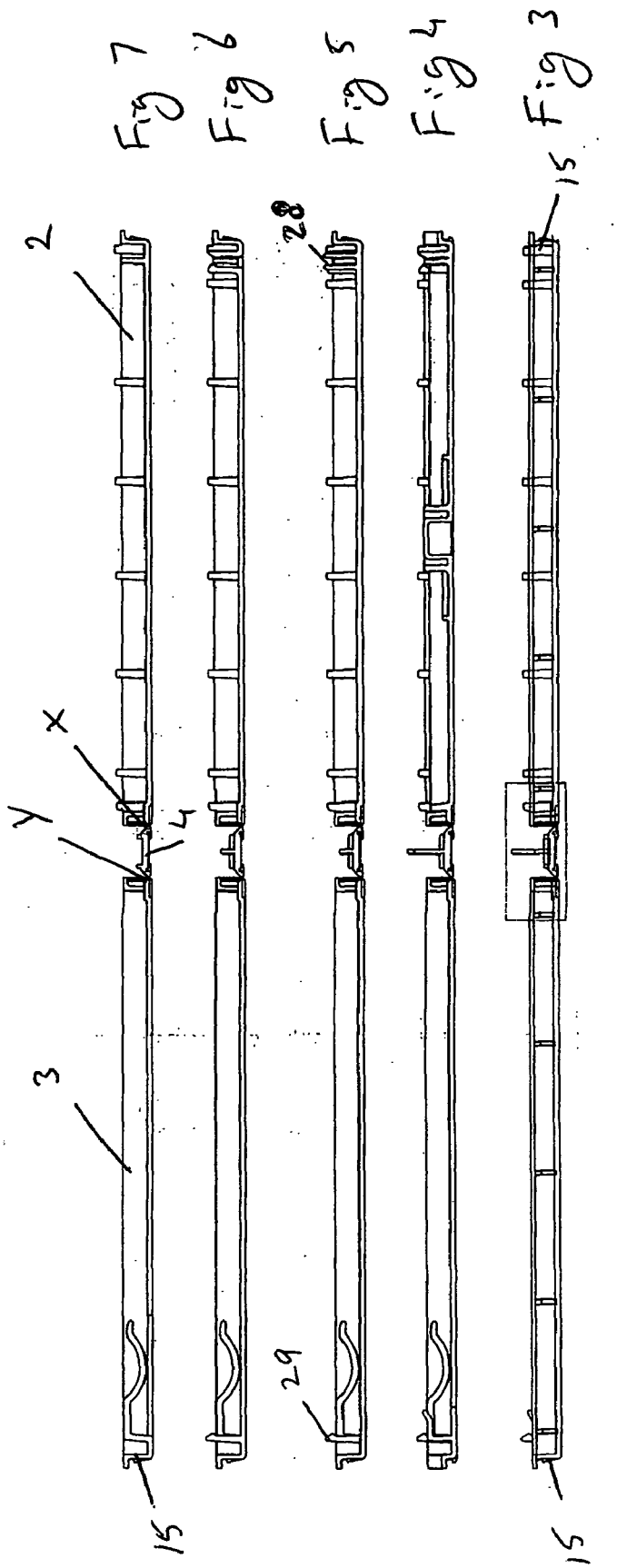


Fig 7
Fig 6
Fig 5
Fig 4
Fig 3
2
28
15
x
y
4
3
29
15
15

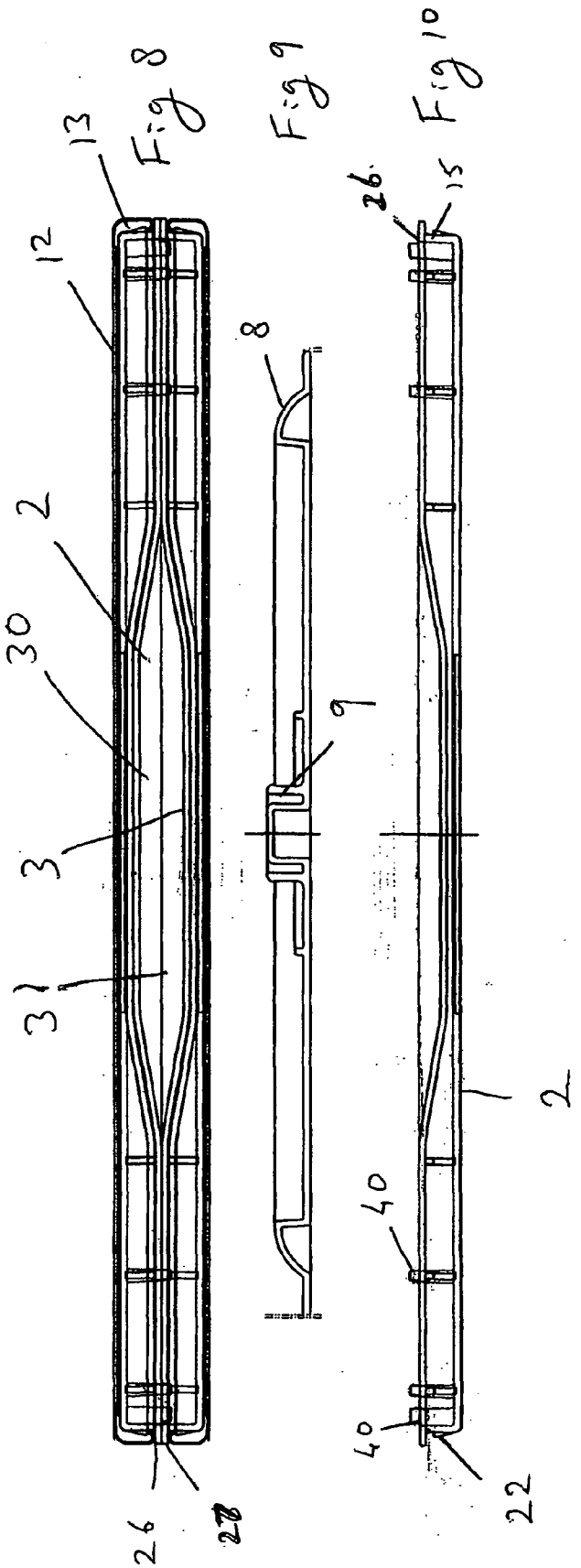


Fig 8
Fig 9
Fig 10
13
12
2
30
3
31
26
27
8
9
26
15
2
40
40
22

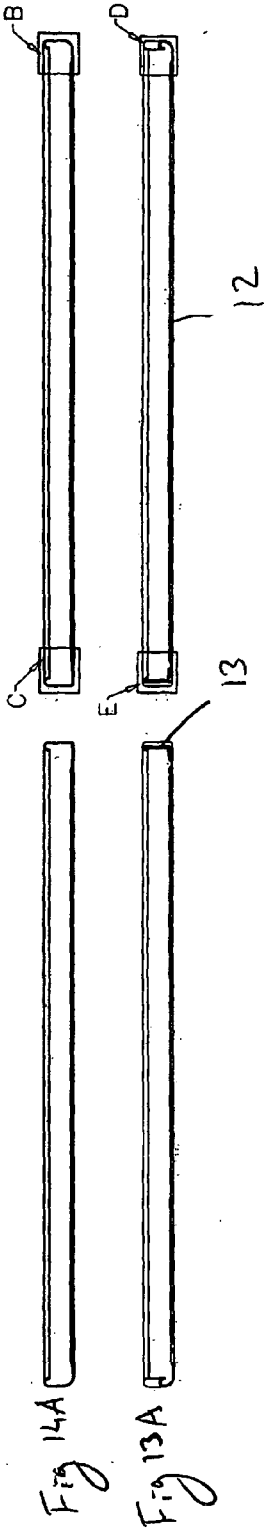


Fig 11
Fig 12
B
D
12
C
E
13
Fig 14A
Fig 13A

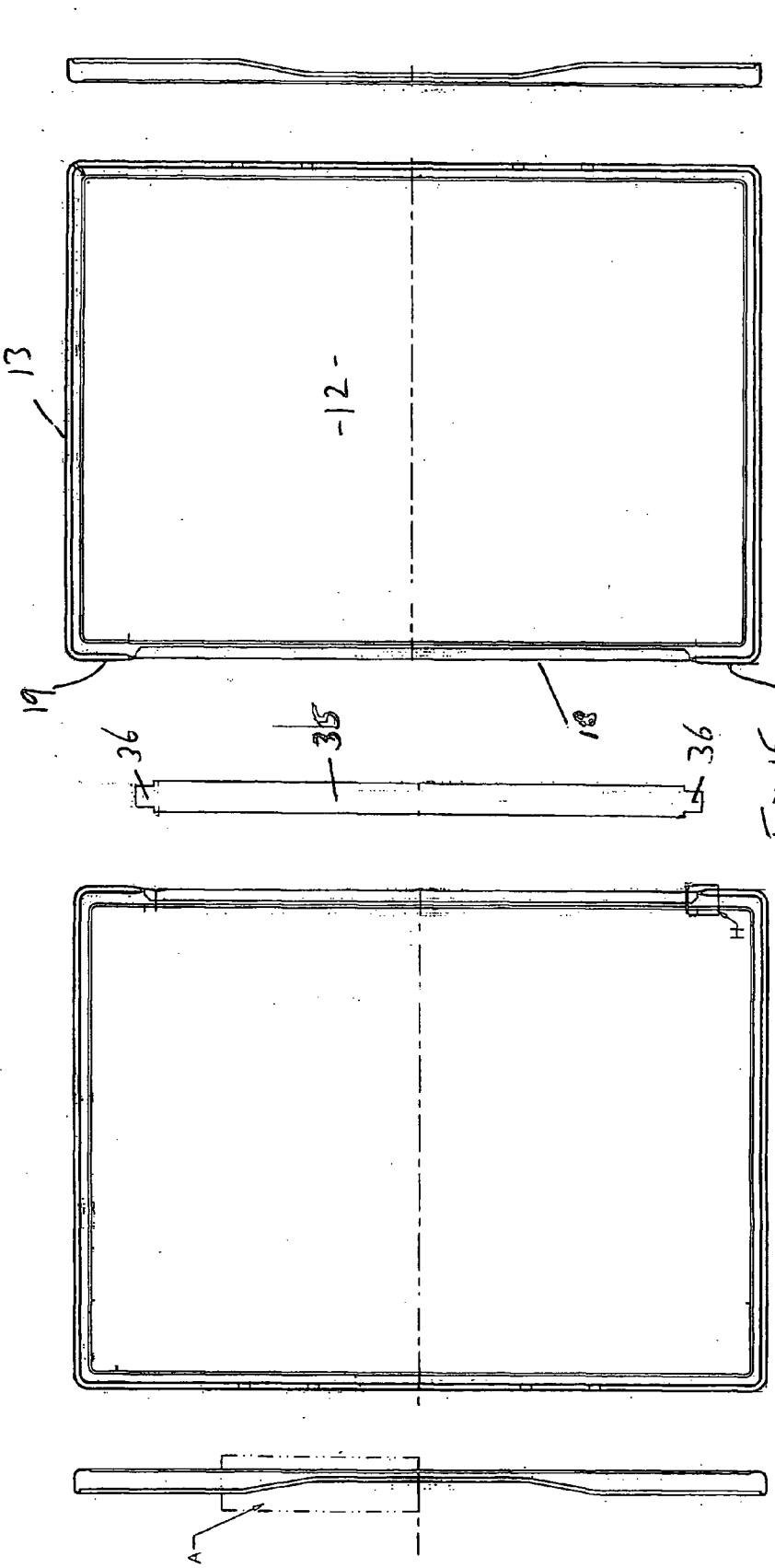


Fig 17
Fig 14B
13
-12-
19
18
19
Fig 15
36
35
36
Fig 13B
H
Fig 16
A

Fig 18

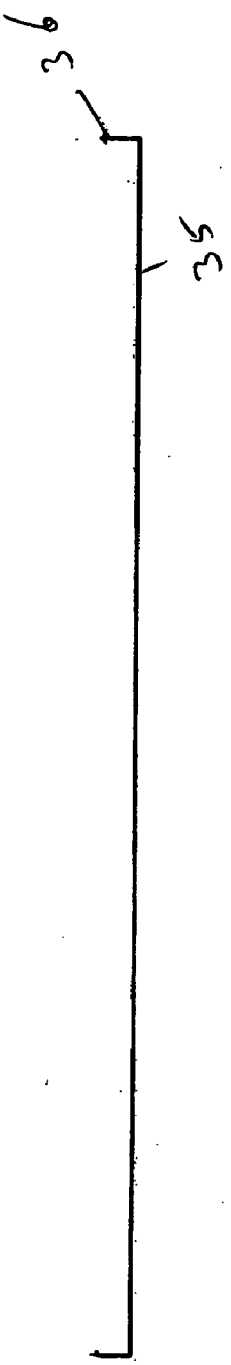
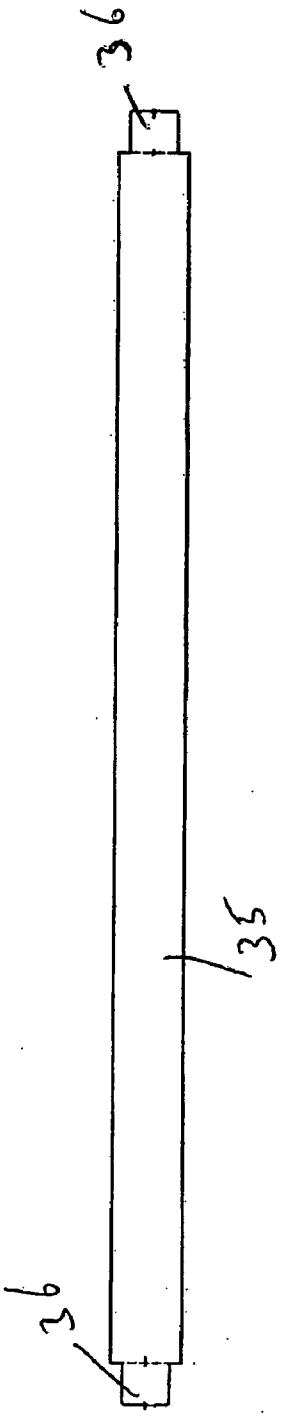


Fig 19



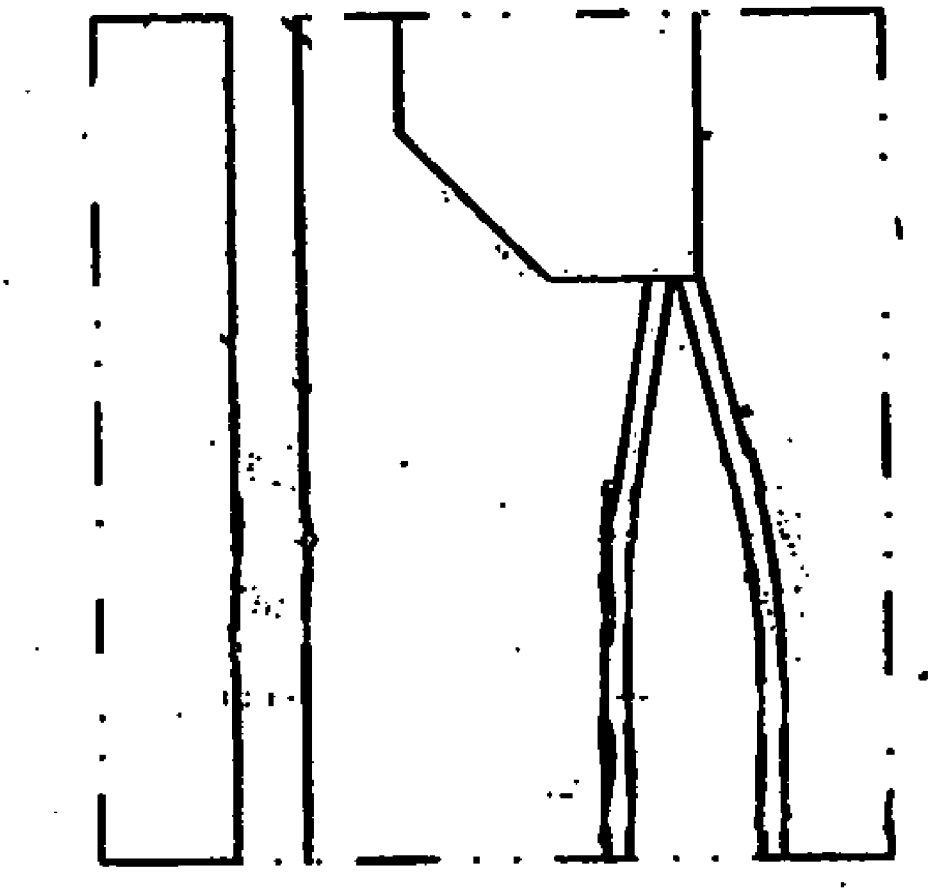
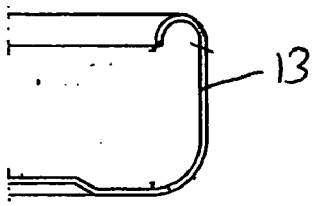
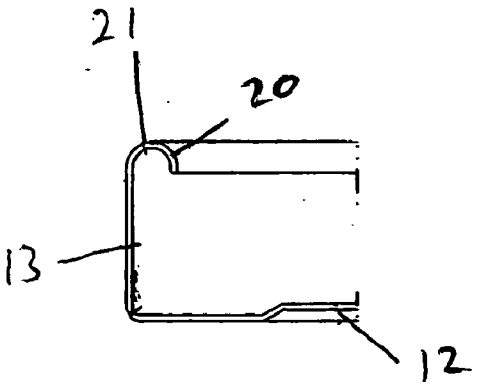


Fig 20



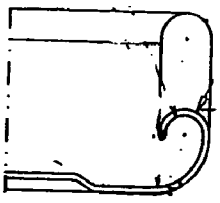
B

Fig 21



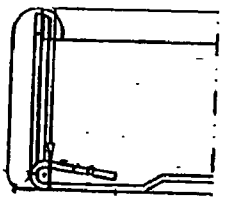
C

Fig 22



D

Fig 23



E

Fig 24

MEDIA STORAGE DISK BOX

FIELD OF THE INVENTION

[0001] The present invention relates to a media storage disk box such as for example those commonly used in the storage of CD Roms, DVDs, music CDs or similar.

BACKGROUND

[0002] A box or case to retain a CD or DVD are the common form by which such goods are normally sold. A box has the ability to carry product information and advertising whilst simultaneously providing protection to the disk. In a normal form of such a box the box consists of a base panel and a cover panel which are movable relative to each other. The configuration is of a kind to provide a wallet like enclosure within which a disk can be stored. Such a box or case will also normally include a mounting region with which a disk can be mounted. The movement of the base and cover panels can be such as to provide an enclosure to securely locate the disk within the enclosure yet allow for the cover to move relative to the base and allow for access to be gained to the enclosure to allow for the removal of the disk from the box. In the most common form the box itself does not present the product branding, advertising and product information. Normally a paper sleeve is engaged with the box, the paper sleeve providing such indicia. Accordingly the boxes which are manufactured to carry the disks are normally of a generic kind and the boxes are customised by the engagement of a paper sleeve carrying the graphics and indicia corresponding to the disk which is to be retained within the box. Besides appropriate selection of the indicia or graphics provided by a paper sleeve, no real significant other ways of distinguishing the box from other boxes is able to be achieved. The paper sleeve is normally that portion which is the most obvious means of drawing attention to the box but beyond the selection of colours and graphic styles, no other differentiating features are conveniently incorporated with known boxes. In a consumer market to which DVDs and CDs are directed, it is important to allow for distinguishing features to be provided by the box to attract a consumer and encourage them to purchase that particular product. There has accordingly been a need to provide different forms of visual appeal for DVD or CD to be boxed for such purposes.

[0003] Accordingly the present invention is directed to a media storage disk box which provides a different visual appeal visible from exterior of the box to those boxes as hereinbefore described or to at least provide the public with a useful choice

BRIEF DESCRIPTION OF THE INVENTION

[0004] Accordingly it is an object of the present invention to provide a media storage disk box comprising:

[0005] a first metal cover pivotally engaged to a second metal cover to be movable between

[0006] i. a closed condition to provide an enclosure within which a mounting region to support a media storage disk is located

[0007] ii. an open condition to provide access to said enclosure, and

[0008] a hinge of a plastic material affixed to said first metal cover and to said second metal cover, said hinge including at least one flexible region defining an axis of rotation for pivotal movement of said first metal cover with said second metal cover between said open and closed condition

[0009] an extension panel integrally formed with said hinge, said extension panel affixed to said first metal cover and disposed to the enclosure side thereof, said extension panel including and presented to the enclosure side thereof a means to releasably affix a media storage disk.

[0010] Preferably said hinge has disposed therefrom extension panels from each side to the axis of rotation, each extension panel being affixed to a respective first and second metal covers.

[0011] Preferably said hinge includes a spine intermediate of said first metal cover and said second metal cover, said spine providing two flexible regions each defining an axis of rotation extending parallel with the spine.

[0012] Preferably said hinge includes a spine intermediate of said first metal cover and said second metal cover, said spine providing two flexible regions each defining an axis of rotation extending parallel with the spine wherein said extension panel is disposed from said spine extending from one of said axis of rotation.

[0013] Preferably said hinge includes a spine intermediate of said first metal cover and said second metal cover, said spine providing two flexible regions each defining an axis of rotation extending parallel with the spine wherein two extension panels are disposed from said spine, each extending from a respective said axis of rotation.

[0014] Preferably said extension panel is affixed to said first metal cover in an interlocking relationship defined by a folded region of said first metal cover.

[0015] Preferably each said extension panel is affixed with a respective metal cover by an interlocking relationship defined by a folded region of said respective metal cover.

[0016] Preferably said extension panel is substantially co-extensive with said first metal cover.

[0017] Preferably both said extension panels are substantially co-extensive with its respective metal cover.

[0018] Preferably said extension panel is substantially co-extensive with said first metal cover, wherein said means to releasably affix includes a rosette to locate at a central aperture of said media storage disk.

[0019] Preferably both said extension panels are substantially co-extensive with its respective metal cover and each present at their distal most from said hinge edge, means to mutually interlock to allow said box to be releasably retained in said closed condition.

[0020] Preferably said extension panel includes perimeter wall upstands projecting from a base to the enclosure disposed side of said base and at perimeter sides of said extension panel save for where said extension panel is connected to said hinge.

[0021] Preferably said first metal cover includes perimeter flanges projecting from at least part of the perimeter of said

first metal cover and locating with the outward to said enclosure facing perimeter walls of said extension panel.

[0022] Preferably each said extension panels include perimeter wall upstands projecting from a base to the enclosure disposed side of said base and at perimeter sides of said extension panel save for where said extension panel is connected to said hinge.

[0023] Preferably said second metal cover includes perimeter flanges projecting from at least part of the perimeter of said second metal cover and locating with the outward to said enclosure facing perimeter walls of said second mentioned extension panel.

[0024] Preferably said spine has affixed to be disposed from a non enclosure disposed side thereof a metal spine panel.

[0025] Preferably said metal spine panel is substantially coextensive with said spine.

[0026] Preferably said metal panel is clipped to said spine at the longitudinally disposed ends of said spine.

[0027] In a second aspect the present invention consists in a media storage disk box comprising:

[0028] a first metal cover pivotally engaged to a second cover to be movable between

[0029] a. an open condition to provide access to a media storage disk mounting region disposed from one of said first metal cover and second cover, and

[0030] b. a closed condition to provide an enclosure within which said mounting region is located

[0031] a hinge of a plastic material affixed to said first metal cover and to said second cover, said hinge defining an axis of rotation for pivotal movement of said first metal cover with said second cover.

[0032] In a further aspect the present invention consists in a media storage disk box comprising:

[0033] a first metal cover pivotally engaged by a hinge to a second cover to be movable between

[0034] i. a closed condition to provide an enclosure within which a mounting region to support a media storage disk is located, and

[0035] ii. an open condition to provide access to said enclosure,

[0036] said hinge forming part of a unitary moulded plastic base structure which includes a first extension panel affixed to the enclosure side of said first metal cover, said hinge defining at least one axis of rotation for pivotal movement of said first metal cover with said second cover and wherein said extension panel is disposed to one of said at least one axis of rotation

[0037] said first said extension panel being substantially coextensive with said first metal cover.

[0038] Preferably said second cover is part of said unitary moulded plastic base structure.

[0039] Preferably said second cover defines to the enclosure side thereof said mounting region including a rosette to realisably affix to the central aperture of a said disk.

[0040] Preferably said second cover is a second metal cover and wherein a second extension panel formed part of said unitary moulded plastic base structure, is disposed from the other side of said hinge and affixed to the enclosure side of said second metal cover.

[0041] Preferably said second extension panel defines to the enclosure side thereof said mounting region including a rosette to releasably affix to the central aperture of a said disk.

[0042] Preferably said first metal cover and said extension panel are of a quadrilateral perimeter, said first metal cover folded to affix to at least part of the perimeter of all of the four sides of said first extension panel.

[0043] Preferably said second metal cover and said second extension panel are of a quadrilateral perimeter, said second metal cover folded to affix to at least part of the perimeter of all of the four sides of said second extension panel.

[0044] Preferably said first extension panel includes a base panel having perimeter walls upstanding from the enclosure disposed side of said base panel, said perimeter walls in said closed condition locating with said second cover.

[0045] Preferably said first extension panel includes a base panel having perimeter walls upstanding from the enclosure disposed side of said base panel and to the exterior to the enclosure side of at least part of said perimeter walls, is affixed said first metal cover.

[0046] Preferably said second extension panel includes a base panel having perimeter walls upstanding from the enclosure disposed side of said base panel and to the exterior to the enclosure side of at least part of said perimeter walls, is affixed said second metal cover.

[0047] Preferably said second extension panel includes a base panel having perimeter walls upstanding from the enclosure disposed side of said base panel and to the exterior to the enclosure side of at least part of said perimeter walls, is affixed said second metal cover and wherein first extension panel includes a base panel having perimeter walls upstanding from the enclosure disposed side of said base panel and to the exterior to the enclosure side of at least part of said perimeter walls, is affixed said first metal cover and wherein in said closed condition, the free edges of at least some of said perimeter wall of said first extension panel and the free edge of at least some of said perimeter wall of said second extension panel abut each other.

[0048] In a further aspect the present invention consists in a media storage disk box comprising:

[0049] formed as a unitary plastic body, a first base panel, a second base panel and a spine panel intermediate of said first base panel and said second base panel, wherein formed intermediate of said first base panel and said spine panel is a first hinge defining a first axis of rotation and between said second base panel and said spine panel is a second hinge defining a second axis of rotation parallel to said first axis of rotation, said hinges allowing movement of said first base panel relative to said second base panel between

[0050] i. a closed condition to provide an enclosure within which a mounting region to support a media storage disk is located

[0051] ii. an open condition to provide to allow access to said enclosure,

[0052] said first base panel and second base panel are of a complementary size to, in said closed condition, provide perimeter to perimeter engagement of said first and second base panels

[0053] a first sheet metal cover is affixed to and overlaying the first base panel to the non enclosure side of said first base panel.

[0054] Preferably a second sheet metal cover is affixed to and overlaying the second base panel to the non enclosure side of said second base panel.

[0055] Preferably a third sheet metal cover is affixed to and overlaying the hinge panel to the non enclosure side of said hinge panel.

[0056] Preferably said first base panel presents to the enclosure side thereof said mounting region.

[0057] Preferably said second base panel presents to the enclosure side thereof said mounting region.

[0058] Preferably said first base panel includes a planar base panel from which and to the enclosure side thereof is provided perimeter walls upstanding from said planar base panel to, in said closed condition engage with the second base panels and clipped about, and to the outwardly directed surfaces of at least part of said perimeter walls of, said first base panel are complementary upstanding perimeter walls.

[0059] Preferably wherein,

[0060] a. a second sheet metal cover is affixed to and overlaying the second base panel to the non enclosure side of said second base panel and wherein

[0061] b. said first base panel includes a planar base panel from which and to the enclosure side thereof is provided perimeter walls upstanding from said planar base panel and clipped about, and to the outwardly directed surfaces of at least part of said perimeter walls of, said first base panel are complementary upstanding perimeter walls and wherein

[0062] c. said second base panel includes a planar base panel from which and to the enclosure side thereof is provided perimeter walls upstanding from said planar base panel to in said closed condition engage with the upstanding walls of said first base panels and clipped about, and to the outwardly directed surfaces of at least part of said perimeter walls of, said second base panel are complementary upstanding perimeter walls of said second sheet metal cover.

[0063] Preferably said complementary upstanding perimeter walls of said first sheet metal panel are provided to at least part of diametrically opposed perimeter regions of said first sheet metal panel.

[0064] Preferably said complementary upstanding perimeter walls of said first sheet metal panel are provided to at least part of diametrically opposed perimeter regions of said first sheet metal panel and wherein said complementary upstanding perimeter walls of said second sheet metal panel are provided to at least part of diametrically opposed perimeter regions of said second sheet metal panel.

[0065] Preferably said first base panel is quadrilateral in plan shape and said second base panel is quadrilateral in plan shape said hinge panel being provided intermediate of complementary perimeter edges of said first and second base panels, and wherein said hinge panel is of a length shorter than said complementary perimeter edges of said first and second base panels.

[0066] In a further aspect the present invention consists in a media storage disk box comprising:

[0067] formed as a unitary plastic body, a first base panel, a second base panel and a hinge formed intermediate of said first base panel and said second base panel, said hinge allowing movement of said first base panel relative to said second base panel between

[0068] i. a closed condition to provide an enclosure within which a mounting region to support a media storage disk is located

[0069] ii. an open condition to provide to allow access to said enclosure,

[0070] said first base panel and second base panel are of a complementary size to, in said closed condition, provide perimeter to perimeter engagement of said first and second base panels

[0071] a first sheet metal cover is affixed to and overlaying the first base panel to the non enclosure side of said first base panel.

[0072] This invention may also be said broadly to consist in the parts, elements and features referred to or indicated in the specification of the application, individually or collectively, and any or all combinations of any two or more of said parts, elements or features, and where specific integers are mentioned herein which have known equivalents in the art to which this invention relates, such known equivalents are deemed to be incorporated herein as if individually set forth.

BRIEF DESCRIPTION OF THE DRAWINGS

[0073] A preferred form of the present invention will now be described with reference to the accompanying drawings in which:

[0074] **FIG. 1** is a plan view of a media storage disk box showing the enclosure side of the two panels of the box,

[0075] **FIG. 2A** is a view of the same storage box as per **FIG. 1** but wherein the sheet metal tabs of the spine panel have been folded over to be captured with the spine,

[0076] **FIG. 2B** is a side view of the box of **FIG. 2**A,

[0077] **FIG. 3** is an end view of the box of **FIG. 2**A,

[0078] **FIG. 4** is a sectional view through section AA of **FIG. 2**A,

[0079] **FIG. 5** is a sectional view in direction BB of **FIG. 2**A,

[0080] **FIG. 6** is a sectional view through section CC of **FIG. 2**A,

[0081] **FIG. 7** is a sectional view through section DD of **FIG. 2**A,

[0082] **FIG. 8** is a side view of the box of **FIG. 1** but wherein the box is in a closed condition,

[0083] **FIG. 9** is a close up sectional view of the mounting region of a panel of the box of **FIG. 1**,

[0084] **FIG. 10** is an enlarged drawing of **FIG. 2**B,

[0085] **FIG. 11** is an end view of the sheet metal cover for one of the panels of the box,

[0086] **FIG. 12** is a sectional view of the panel of **FIG. 11**,

[0087] **FIG. 13A** is a sectional view of the other of the sheet metal covers of the other panel of the box,

[0088] **FIG. 13B** is a plan view of one of the sheet metal covers,

[0089] **FIG. 14A** is an end view of such panel,

[0090] **FIG. 14B** is a plan view of the other of the sheet metal covers,

[0091] **FIG. 15** is a plan view of the sheet metal spine cover,

[0092] **FIG. 16** is an end view of **FIG. 13**B,

[0093] **FIG. 17** is an end view of **FIG. 14**B,

[0094] **FIG. 18** is a side view of **FIG. 15**,

[0095] **FIG. 19** is an enlarged view of **FIG. 15**,

[0096] **FIG. 20** is an enlarged view of region H of **FIG. 13**B,

[0097] **FIG. 21** is a close up view of region B of **FIG. 11**,

[0098] **FIG. 22** is a close up view of region C of **FIG. 11**,

[0099] **FIG. 23** is a close up view of region D of **FIG. 12**, and

[0100] **FIG. 24** is a close up view of region E of **FIG. 12**.

DETAILED DESCRIPTION OF THE INVENTION

[0101] With reference to **FIG. 1**, the box may generally be defined by a unitarily formed plastic body **1** which consists of first panel **2** and a second panel **3**. The first and second panels are generally planar panels however relief details are or can be provided thereto. The first and second panels are preferably of a complimentary size and shape such that when they are in an overlapping condition (a box closed condition) the perimeter of the first and second panels are commensurate with each other. The first and second panels are connected to each other via a hinge **4**. The hinge **4** is for example a hinge panel which (being integrally formed with the first and second panels **2, 3**) is positioned intermediate of the first and second panels **2, 3**. The hinge **4** may define axes of rotation XX and YY which allows for each of the first and second panels **2, 3** to move relative to the hinge panel **4** and relative to each other. In the most preferred form and with reference to **FIG. 1**, the unitary plastic body **1** provides the two hinges intermediate of the hinge panel **4** and a respective first and second panel **2, 3**. The axes of rotation XX and YY are provided as a consequence of a change in the wall thickness of the unitary plastic body **1**. Such a change in the wall thickness where the thickness is reduced, provides a region about which the components of the unitary plastic body can rotate relative to each other. In an alternative form of the present invention it may be that the hinge **4** defines merely one axis of rotation being an axis of rotation to allow for mutual rotation of the first and second panels **2, 3** relative to each other. The hinge itself may in such a configuration form part of the first and second panels of the unitary plastic body **1**. However in the most preferred form the hinge **4** is a separate panel to the first and second panels **2, 3** and as such provides a spine or at least part of a spine to the box. The first and second panels **2, 3** are each independently movable relative to the spine provided by the hinge according to the configuration of **FIG. 1**.

[0102] In the most preferred form the first and second panels are in plan shape of a quadrilateral perimeter. As can be seen in **FIG. 1** the box is in a substantial part defined by the first and second panels which are of a rectangular perimeter shape. The spine is provided intermediate of the first and second panels juxtaposed to two major sides of the rectangular form of each of the panels **2, 3**. However in an alternative condition the spine may be provided along two of the minor sides of the rectangular perimeter form of each of the panels **2, 3**. The relationship of the two panels **2, 3** is such that by rotation about the pivot axis or axes XX, YY, the perimeter regions of each of the two panels **2, 3** become engaged with each other to define within the perimeter and within the major surfaces of the panels **2, 3** and enclosure. With reference to **FIG. 8**, the box is shown in a closed condition.

[0103] The first panel **2** has provided on the enclosure facing side thereof a disk mounting region **7**. The disk mounting region **7** may include disk peripheral relief **8** and also include a mounting means **9** which is for example a rosette style mounting to engage with the central aperture of a disk in a manner to be releasable therefrom. The enclosure side of the second panel **3** may include relief details such as clips **10** which may be provided for the purposes of releasably affixing to the enclosure side surface of the second panel, an information booklet.

[0104] Provided to at least one of the first and second panels **2, 3** and to the side thereof (opposite to the enclosure facing side), is a sheet metal cover **12**. The sheet metal cover **12** is preferably co-extensive with the non enclosure facing side of the plastic panel. The sheet metal cover as for example shown in **FIG. 14B** is also of a rectangular form and is affixed to one of the plastic panels **2** or **3**. In the most preferred form both plastic panels **2, 3** have engaged to the non enclosure facing side thereof such as sheet metal cover. The sheet metal cover is affixed with the plastic panel in a manner to be permanently retained therewith. In the most preferred form the sheet metal cover also locates over at least a substantial part of the perimeter of each of the panels **2, 3**. The sheet metal cover is preferably substantially planar as far as its location adjacent the major surface of the plastic panel **2** or **3**, but includes perimeter upstanding wall sections **13** which locate about corresponding upstanding walls **15** of the perimeter of the plastic panel **2, 3**. As such, the perimeter upstanding wall sections **13** of the sheet metal covers enclose about a substantial part of the exterior to the enclosure directed surfaces of each of the plastic panels **2, 3**.

Upstanding walls **15** are however preferably not provided by the plastic panels **2, 3** at the region where the plastic panels are juxtaposed with the spine or hinge **4**. As a consequence and likewise, no upstanding perimeter wall sections **13** of the sheet metal panels are provided in regions corresponding to such juxtaposed to the spine regions of the plastic panels. It is indeed as a consequence of the upstanding wall sections **13** of the sheet metal panels by which the sheet metal panels become engaged and affixed to a respective plastic panel **2, 3**. With reference to **FIG. 14B** the upstanding peripheral wall upstands **13** of a sheet metal panel extend at least in part about the perimeter of the sheet metal panel at each of the four sides thereof. As can be seen in **FIG. 14B** such peripheral upstanding wall sections **13** are not provided to the sheet metal panel at region **18** being the region corresponding to where the sheet metal cover is provided adjacent the spine **4**. However short sections at the end of each of the ends of that edge at where the spine is provided (e.g. the ends **19**) such upstanding wall sections are provided. As can be seen in **FIG. 2**, the spine **4** is not of a length equal to the major side length of the rectangular shaped plastic panels **2, 3**. Indeed the spine **4** is of a length shorter than the major sides of the panel such as to allow for the end regions **19** of such a major side to be free from engagement with the spine **4**.

[0105] Each of the sheet metal covers at its upstanding peripheral wall includes a flange downturn **20**. The flange downturn is an extension from the upstanding peripheral wall **13** which is directed both inwardly and downwardly back towards the major panel of the metal cover **12**. As a result a radiused surface **21** is presented defining the distal edge of the upstanding wall **13**. Such a downturn is provided for both providing a safe and non-dangerous finish to the sheet metal panel but also to provide a clipping feature to allow for the sheet metal cover to clip with a respective plastic panel. With reference to **FIG. 10**, corresponding clipping relief **22** is provided to the exterior side of the upstanding wall **15** of the panel **2**. Such clipping relief **22** presents a surface with which the downturn **20** can engage. In a most preferred form a plurality of such clipping relief features **22** are provided about the perimeter of the upstanding wall **15** of the panel **2** and also for example from the panel **3**. Adhesive may in addition or alternatively be used.

[0106] As can be seen with reference to **FIG. 10**, such clipping relief **22** is provided below the free edge **26** of the upstanding walls **15** of the panel **2**. With reference to **FIG. 8**, the complimentary free edges **26** and **27** of the first and second panels **2, 3** are capable of engaging with each other when the box is in the closed condition. Accordingly there is no contact that occurs between the sheet metal covers of the first and second panels when the box is in the closed condition and it is the free edges of the upstanding walls **15** of the plastic panels **2, 3** which engage with each other. Provided to the plastic covers may be detailing **28** and **29** provided for the purposes of allowing for the box in the closed condition to be locked in the closed condition. The closure features **28** and **29** are preferably locking components which interact with each other to hold the box in the closed condition yet allow for the box to be opened when desired. A tongue and groove-like arrangement for the closure features **28** and **29** as for example shown in **FIG. 5** may be utilised. A handled or handle region **30** and **31** may be provided to each of the first and second plastic panels **2, 3**. Such a handle region **30, 31** is preferably provided to allow for the box to be grasped by a person and to allow for the first and second panels to be moved from the closed condition to the locked condition. The handled region may provide surface indents within which fingers can be positioned to allow for the box to be opened.

[0107] In the configuration of the box where a separate spine panel **4** is provided a sheet metal spine cover **35** may be located. With reference to **FIG. 15** such a sheet metal spine cover **35** is preferably of a length to cover the entire length of the spine panel **4**. It is preferably also of a width covering a substantial portion of the spine panel. The sheet metal spine cover **35** is engaged with the spine **4** to the non enclosure facing side thereof. Clipping tabs **36** are provided at each end of the sheet metal spine cover **35** and such tabs can be folded to locate the sheet metal spine cover to the spine **4**. With reference to **FIG. 1**, the tabs **36** are shown in an unfolded state. The enclosure facing side of the spine may include regions **38** which provide relief into which the tab **36** can be folded. Such relief may be a surface indent to the interior facing surface of the spine such that when the tab is folded over, it is located within the rebate or receptacle region defined on the interior surface of the spine **4**. The tab **36** do not protrude out from such a receptacle region **38**. As a consequence of such, the possibility of a snagging or catching of the tab **36** with a foreign body can be avoided.

[0108] The plastic panel may also include and presented beyond the free edge **26** and/or **27** of at least the first panel **2** and possibly also the second panel **3**, upstands **40**. The upstands **40** are provided to locate to the interior side of the upstanding wall **15** of the other panel and to locate against the inwardly directed surface of such upstanding wall **15** of the other panel to thereby provide resistance to the sliding movement of the two panels relative to each other. Whilst resistance to such sliding movement is provided as a result of the integral formation of the two panels incorporating the hinge, because the plastic material is of a flexible nature the upstands **40** (in a direction parallel to the substantially planar configuration of the box in its closed condition) will resist the sliding movement. In a preferred form of the invention it is only one of the panels **2, 3** which provide such upstands and these may be provided in a form where there are a plurality of such upstands provided about the perimeter of the first or second panels **2, 3** or may alternatively be a continuous or semi-continuous edge or lip presented from the free edge **26** of the panel **2** or the free edge **27** of the panel **3**.

[0109] The metal covers are made form a metal which can provide high gloss characteristics. The metal covers may be printed with a printing ink to provide graphics and product information to the exterior side of the box. The fact that such printing inks are provided to the exterior of the metal covers can allow for the high gloss character to be taken advantage of. A metallic finish can be obtained. Furthermore, the sheet metal may, during its forming procedure, have provided regions of embossing to the major panel regions thereof. The embossing can provide further enhancement especially where such is provided to define an outline enhancement to graphics subsequently printed there on.

1. A media storage disk box comprising:

a first metal cover pivotally engaged to a second metal cover to be movable between

i. a closed condition to provide an enclosure within which a mounting region to support a media storage disk is located

ii. an open condition to provide access to said enclosure, and

a hinge of a plastic material affixed to said first metal cover and to said second metal cover, said hinge including at least one flexible region defining an axis of rotation for pivotal movement of said first metal cover with said second metal cover between said open and closed condition

an extension panel integrally formed with said hinge, said extension panel affixed to said first metal cover and disposed to the enclosure side thereof, said extension panel including and presented to the enclosure side thereof a means to releasably affix a media storage disk.

2. A media storage disk box as claimed in claim 1 wherein said hinge has disposed therefrom extension panels from each side to the axis of rotation, each extension panel being affixed to a respective first and second metal covers.

3. A media storage disk box as claimed in claim 1 wherein said hinge includes a spine intermediate of said first metal cover and said second metal cover, said spine providing two flexible regions each defining an axis of rotation extending parallel with the spine.

4. A media storage disk box as claimed in claim 1 wherein said hinge includes a spine intermediate of said first metal cover and said second metal cover, said spine providing two flexible regions each defining an axis of rotation extending parallel with the spine wherein said extension panel is disposed from said spine extending from one of said axis of rotation.

5. A media storage disk box as claimed in claim 1 wherein said hinge includes a spine intermediate of said first metal cover and said second metal cover, said spine providing two flexible regions each defining an axis of rotation extending parallel with the spine wherein two extension panels are disposed from said spine, each extending from a respective said axis of rotation.

6. A media storage disk box as claimed in claim 1 wherein said extension panel is affixed to said first metal cover in an interlocking relationship defined by a folded region of said first metal cover.

7. A media storage disk box as claimed in claim 5 wherein each said extension panel is affixed with a respective metal cover by an interlocking relationship defined by a folded region of said respective metal cover.

8. A media storage disk box as claimed claim 1 wherein said extension panel is substantially co-extensive with said first metal cover.

9. A media storage disk box as claimed in claim 5 wherein both said extension panels are substantially co-extensive with its respective metal cover.

10. A media storage disk box as claimed in claim 1 wherein said extension panel is substantially co-extensive with said first metal cover, wherein said means to releasably affix includes a rosette to locate at a central aperture of said media storage disk.

11. A media storage disk box as claimed in claim 6 wherein both said extension panels are substantially co-extensive with its respective metal cover and each present at their distal most from said hinge edge, means to mutually interlock to allow said box to be releasably retained in said closed condition.

12. A media storage disk box as claimed in claim 1 wherein said extension panel includes perimeter wall upstands projecting from a base to the enclosure disposed side of said base and at perimeter sides of said extension panel save for where said extension panel is connected to said hinge.

13. A media storage disk box as claimed in claim 12 wherein said first metal cover includes perimeter flanges projecting from at least part of the perimeter of said first metal cover and locating with the outward to said enclosure facing perimeter walls of said extension panel.

14. A media storage disk box as claimed in claim 6 wherein each said extension panels include perimeter wall upstands projecting from a base to the enclosure disposed side of said base and at perimeter sides of said extension panel save for where said extension panel is connected to said hinge.

15. A media storage disk box as claimed in claim 14 wherein said second metal cover includes perimeter flanges projecting from at least part of the perimeter of said second metal cover and locating with the outward to said enclosure facing perimeter walls of said second mentioned extension panel.

16. A media storage disk box as claimed in claim 3 wherein said spine has affixed to be disposed from a non enclosure disposed side thereof a metal spine panel.

17. A media storage disk box as claimed in claim 16 wherein said metal spine panel is substantially coextensive with said spine.

18. A media storage disk box as claimed in claim 16 wherein said metal panel is clipped to said spine at the longitudinally disposed ends of said spine.

19. A media storage disk box comprising:

a first metal cover pivotally engaged to a second cover to be movable between

a. an open condition to provide access to a media storage disk mounting region disposed from one of said first metal cover and second cover, and

b. a closed condition to provide an enclosure within which said mounting region is located

a hinge of a plastic material affixed to said first metal cover and to said second cover, said hinge defining an axis of rotation for pivotal movement of said first metal cover with said second cover.

20. A media storage disk box comprising:

a first metal cover pivotally engaged by a hinge to a second cover to be movable between

i. a closed condition to provide an enclosure within which a mounting region to support a media storage disk is located, and

ii. an open condition to provide access to said enclosure,

said hinge forming part of a unitary moulded plastic base structure which includes a first extension panel affixed

to the enclosure side of said first metal cover, said hinge defining at least one axis of rotation for pivotal movement of said first metal cover with said second cover and wherein said extension panel is disposed to one of said at least one axis of rotation

said first said extension panel being substantially coextensive with said first metal cover.

21. A media storage disk box as claimed in claim 20 wherein said second cover is part of said unitary moulded plastic base structure.

22. A media storage disk box as claimed in claim 21 wherein said second cover defines to the enclosure side thereof said mounting region including a rosette to realisably affix to the central aperture of a said disk.

23. A media storage disk box as claimed in claim 20 wherein said second cover is a second metal cover and wherein a second extension panel formed part of said unitary moulded plastic base structure, is disposed from the other side of said hinge and affixed to the enclosure side of said second-metal cover.

24. A media storage disk box as claimed in claim 23 wherein said second extension panel defines to the enclosure side thereof said mounting region including a rosette to releasably affix to the central aperture of a said disk.

25. A media storage disk box as claimed in claim 20 wherein said first metal cover and said extension panel are of a quadrilateral perimeter, said first metal cover folded to affix to at least part of the perimeter of all of the four sides of said first extension panel.

26. A media storage disk box as claimed in claim 23 wherein said second metal cover and said second extension panel are of a quadrilateral perimeter, said second metal cover folded to affix to at least part of the perimeter of all of the four sides of said second extension panel.

27. A media storage disk box as claimed in claim 20 wherein first extension panel includes a base panel having perimeter walls upstanding from the enclosure disposed side of said base panel, said perimeter walls in said closed condition locating with said second cover.

28. A media storage disk box as claimed in claim 20 wherein first extension panel includes a base panel having perimeter walls upstanding from the enclosure disposed side of said base panel and to the exterior to the enclosure side of at least part of said perimeter walls, is affixed said first metal cover.

29. A media storage disk box as claimed in claim 23 wherein second extension panel includes a base panel having perimeter walls upstanding from the enclosure disposed side of said base panel and to the exterior to the enclosure side of at least part of said perimeter walls, is affixed said second metal cover.

30. A media storage disk box as claimed in claim 23 wherein second extension panel includes a base panel having perimeter walls upstanding from the enclosure disposed side of said base panel and to the exterior to the enclosure side of at least part of said perimeter walls, is affixed said second metal cover and wherein first extension panel includes a base panel having perimeter walls upstanding from the enclosure disposed side of said base panel and to the exterior to the enclosure side of at least part of said perimeter walls, is affixed said first metal cover and wherein in said closed condition, the free edges of at least some of said perimeter wall of said first extension panel and the free edge of at least some of said perimeter wall of said second extension panel abut each other.

31. A media storage disk box comprising:

formed as a unitary plastic body, a first base panel, a second base panel and a spine panel intermediate of said first base panel and said second base panel, wherein formed intermediate of said first base panel and said spine panel is a first hinge defining a first axis of rotation and between said second base panel and said spine panel is a second hinge defining a second axis of rotation parallel to said first axis of rotation, said hinges allowing movement of said first base panel relative to said second base panel between

i. a closed condition to provide an enclosure within which a mounting region to support a media storage disk is located

ii. an open condition to provide to allow access to said enclosure,

said first base panel and second base panel are of a complementary size to, in said closed condition, provide perimeter to perimeter engagement of said first and second base panels

a first sheet metal cover is affixed to and overlaying the first base panel to the non enclosure side of said first base panel.

32. A media storage disk box as claimed in claim 31 wherein a second sheet metal cover is affixed to and overlaying the second base panel to the non enclosure side of said second base panel.

33. A media storage disk box as claimed in claim 31 wherein a third sheet metal cover is affixed to and overlaying the hinge panel to the non enclosure side of said hinge panel.

34. A media storage disk box as claimed in claim 32 wherein said first base panel presents to the enclosure side thereof said mounting region.

35. A media storage disk box as claimed in claim 32 wherein said second base panel presents to the enclosure side thereof said mounting region.

36. A media storage disk box as claimed in claim 31 wherein said first base panel includes a planar base panel from which and to the enclosure side thereof is provided perimeter walls upstanding from said planar base panel to, in said closed condition engage with the second base panels and clipped about, and to the outwardly directed surfaces of at least part of said perimeter walls of, said first base panel are complementary upstanding perimeter walls.

37. A media storage disk box as claimed in claim 31 wherein

a. a second sheet metal cover is affixed to and overlaying the second base panel to the non enclosure side of said second base panel and wherein

b. said first base panel includes a planar base panel from which and to the enclosure side thereof is provided perimeter walls upstanding from said planar base panel and clipped about, and to the outwardly directed surfaces of at least part of said perimeter walls of, said first base panel are complementary upstanding perimeter walls and wherein

c. said second base panel includes a planar base panel from which and to the enclosure side thereof is pro-

vided perimeter walls upstanding from said planar base panel to in said closed condition engage with the upstanding walls of said first base panels and clipped about, and to the outwardly directed surfaces of at least part of said perimeter walls of, said second base panel are complementary upstanding perimeter walls of said second sheet metal cover.

38. A media storage disk box as claimed in claim 36 wherein said complementary upstanding perimeter walls of said first sheet metal panel are provided to at least part of diametrically opposed perimeter regions of said first sheet metal panel.

39. A media storage disk box as claimed in claim 37 wherein said complementary upstanding perimeter walls of said first sheet metal panel are provided to at least part of diametrically opposed perimeter regions of said first sheet metal panel and wherein said complementary upstanding perimeter walls of said second sheet metal panel are provided to at least part of diametrically opposed perimeter regions of said second sheet metal panel.

40. A media storage disk box as claimed in claim 31 wherein said first base panel is quadrilateral in plan shape and said second base panel is quadrilateral in plan shape said hinge panel being provided intermediate of complementary perimeter edges of said first and second base panels, and wherein said hinge panel is of a length shorter than said complementary perimeter edges of said first and second base panels.

41. A media storage disk box comprising:

formed as a unitary plastic body, a first base panel, a second base panel and a hinge formed intermediate of said first base panel and said second base panel, said hinge allowing movement of said first base panel relative to said second base panel between

i. a closed condition to provide an enclosure within which a mounting region to support a media storage disk is located

ii. an open condition to provide to allow access to said enclosure,

said first base panel and second base panel are of a complementary size to, in said closed condition, provide perimeter to perimeter engagement of said first and second base panels

a first sheet metal cover is affixed to and overlaying the first base panel to the non enclosure side of said first base panel.

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