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Siemonsen et al.

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[54] **EASY OPEN MEANS FOR BOTTLES AND THE LIKE**

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[73] Assignee: **Owens-Illinois, Inc.,** Toledo, Ohio

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[21] Appl. No.: **172,735**

Related U.S. Patent Documents

Reissue of:

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Issued: **Aug. 19, 1969**
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Filed: **Oct. 17, 1966**

[52] **U.S. Cl.** **215/255**
[51] **Int. Cl.²** **B65D 41/32**
[58] **Field of Search** 215/42, 46.5, 39, 255; 220/54

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Primary Examiner—George T. Hall
Attorney, Agent, or Firm—J. R. Nelson

[57] **ABSTRACT**

This disclosure relates to a bottle cap construction wherein a tear section is defined by score means in the bottle cap construction so that the tear section is initially integral with the remainder of the bottle cap throughout the entire juncture of the tear section with the remainder of the bottle cap. The tear section has at least one edge thereof extending from the top portion of the bottle cap to the free edge of the rim portion that is utilized to crimp the bottle cap to the open end of the bottle, a ring pull tab being secured to the tear section at the top portion of the bottle cap to facilitate the pulling of at least one edge of the tear section from the closure member to open the bottle.

29 Claims, 24 Drawing Figures

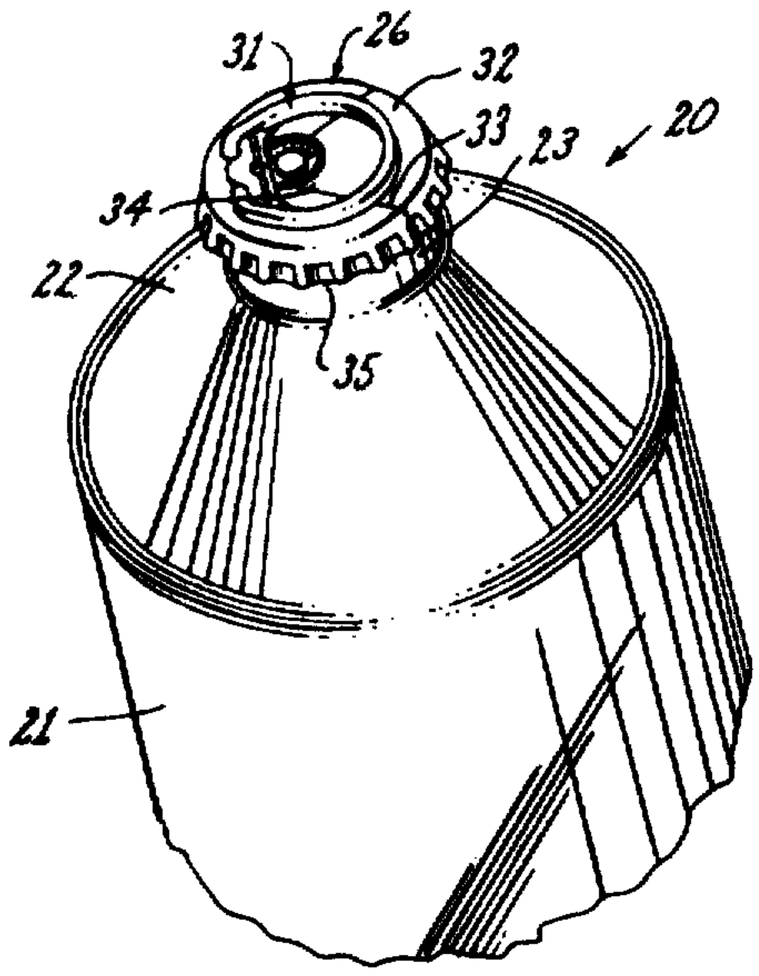


FIG.1

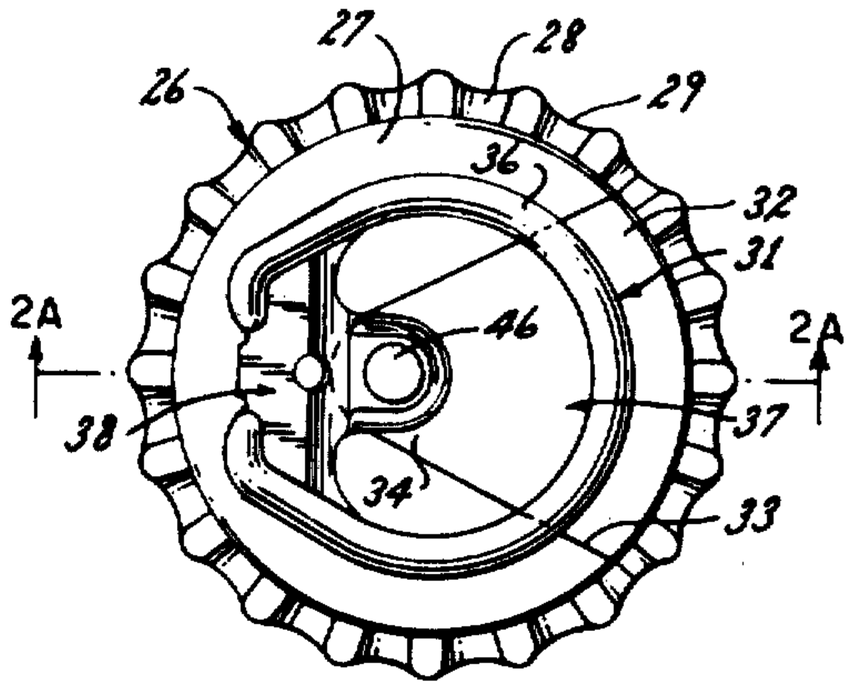


FIG.2

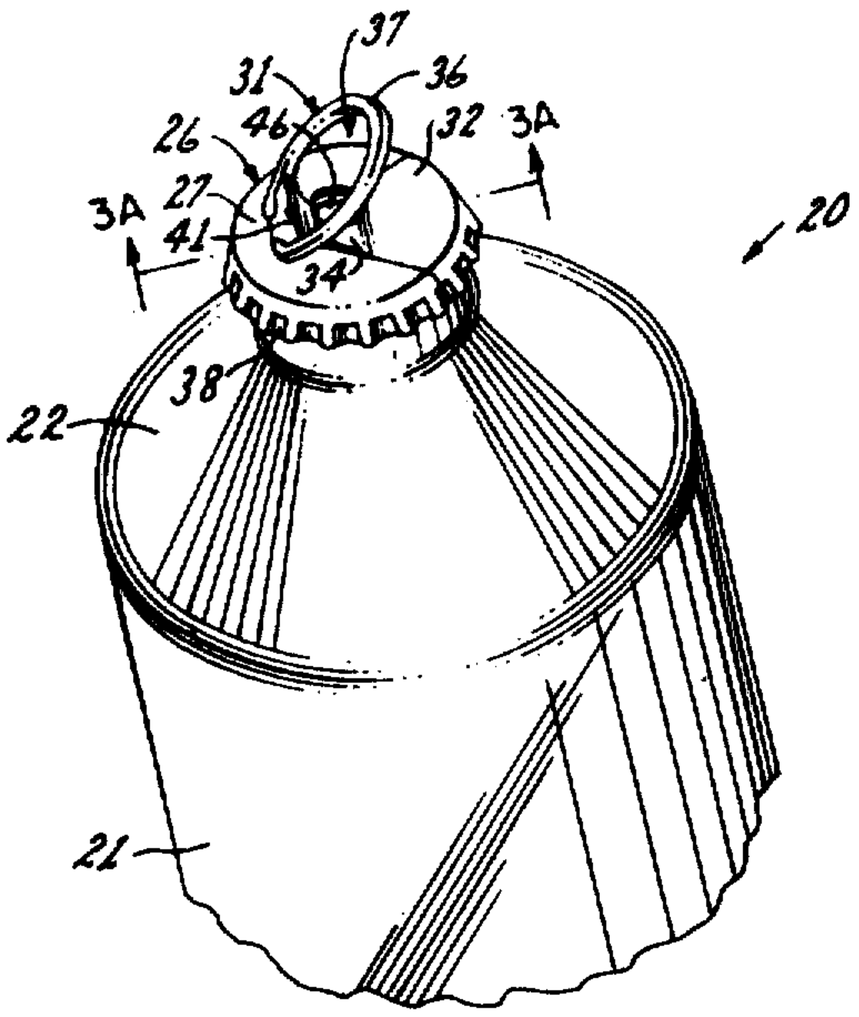


FIG.3

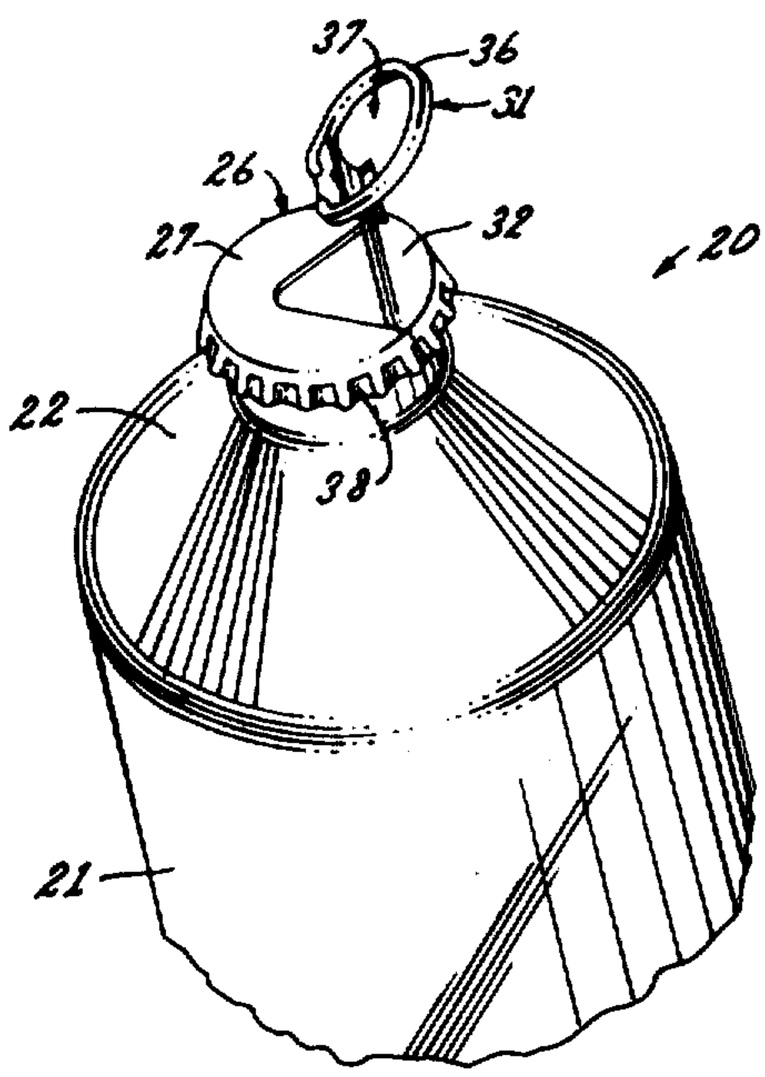


FIG.4

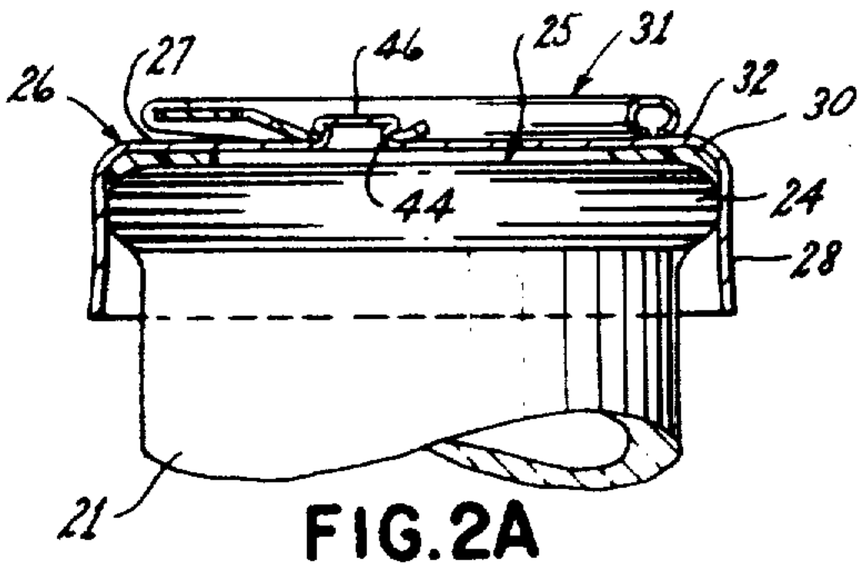


FIG.2A

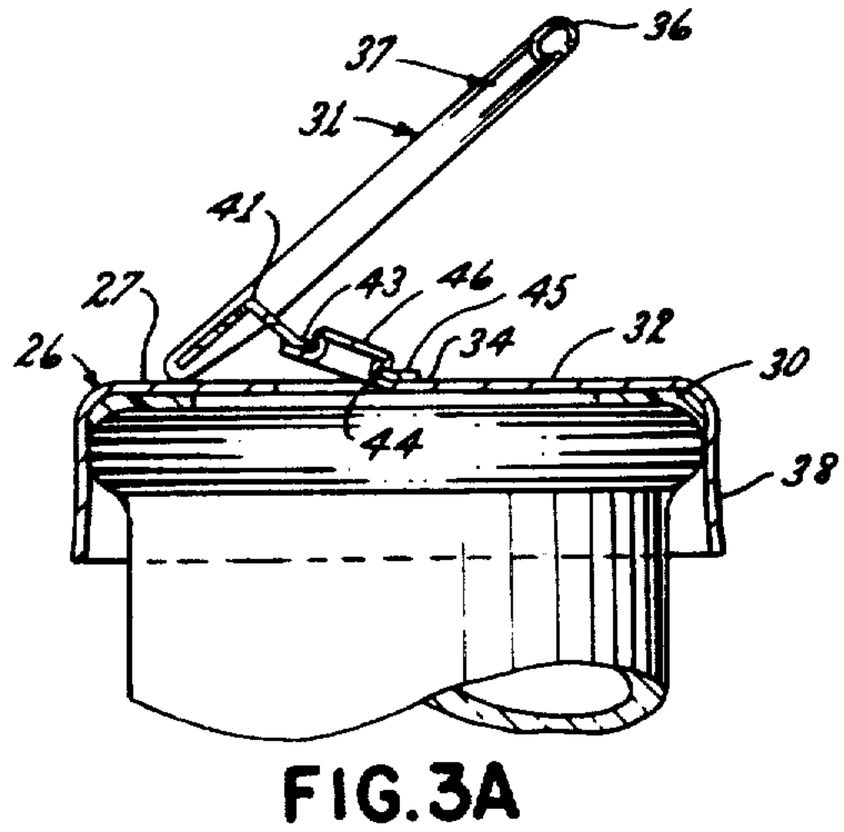
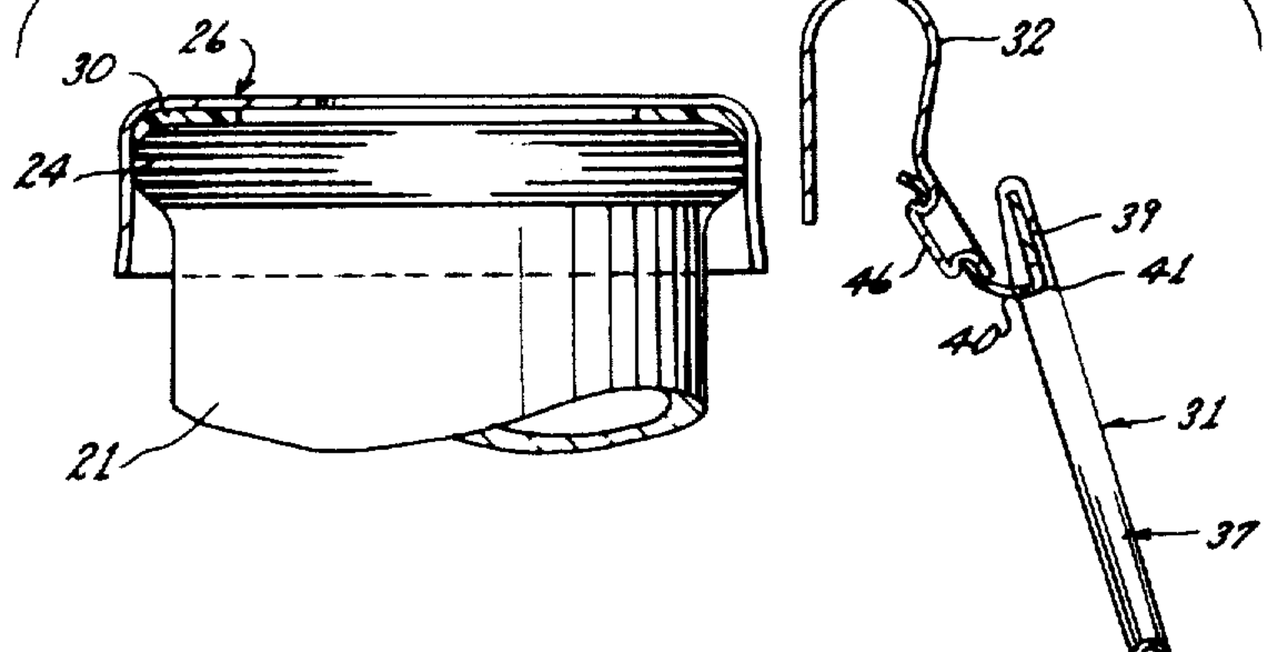


FIG.3A

FIG.5



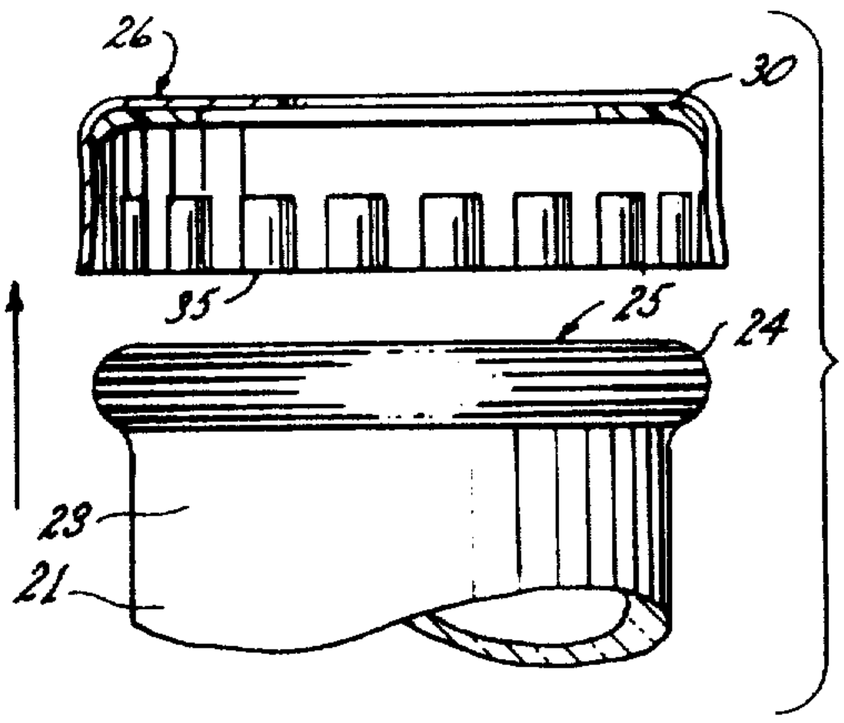


FIG.7

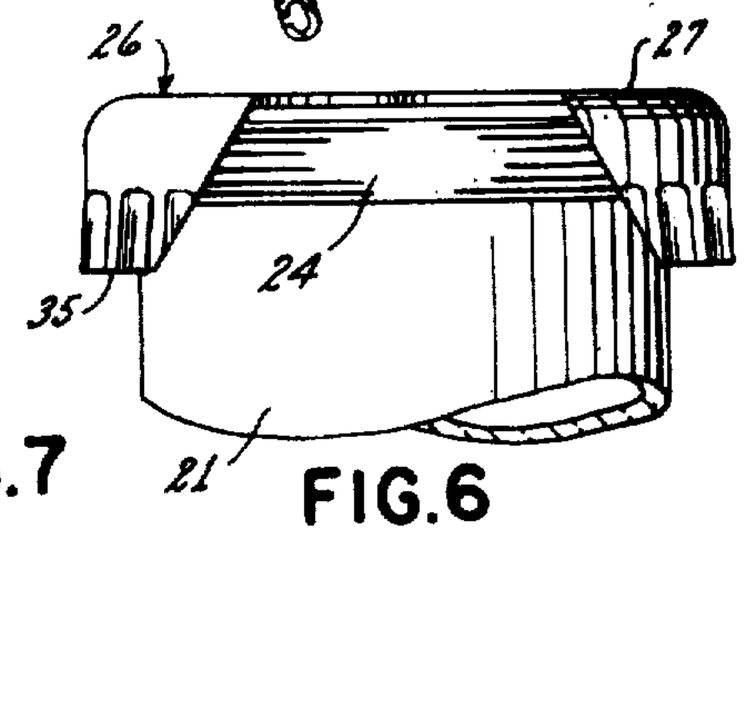


FIG.6

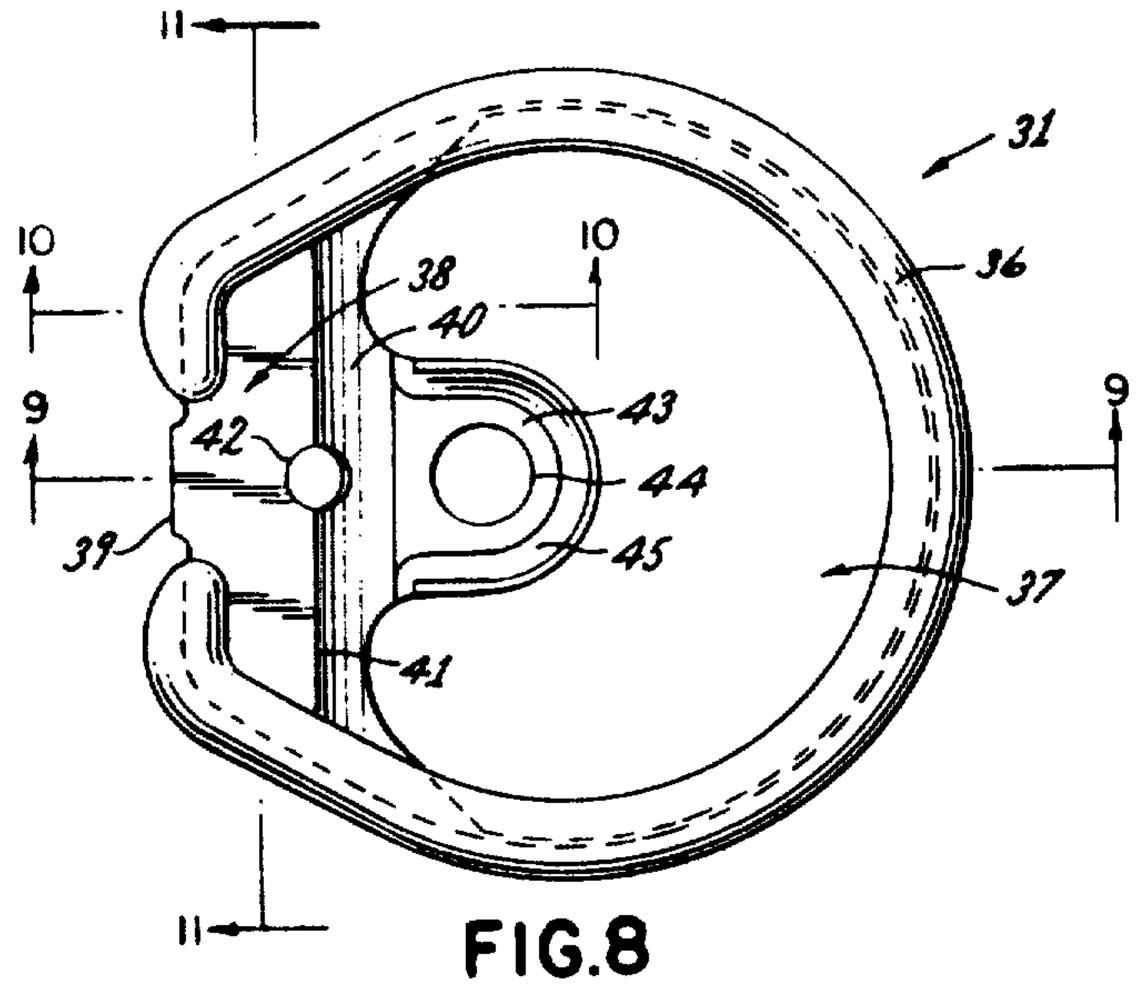


FIG.8

FIG.9

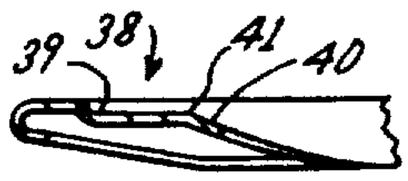


FIG.10

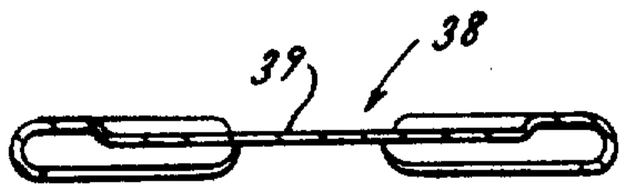


FIG.11

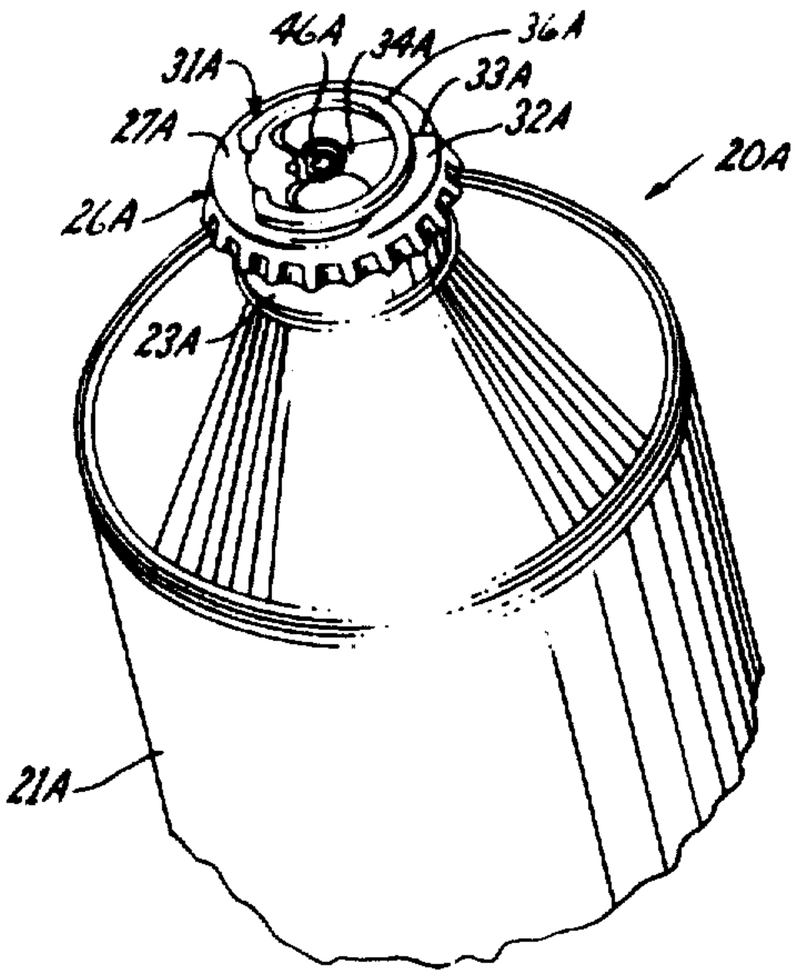


FIG. 12

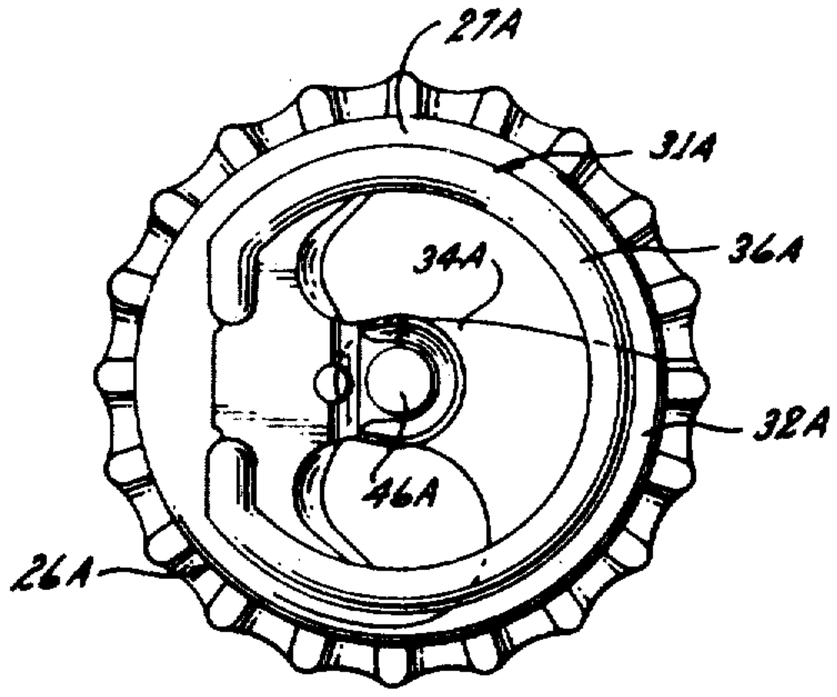


FIG. 13

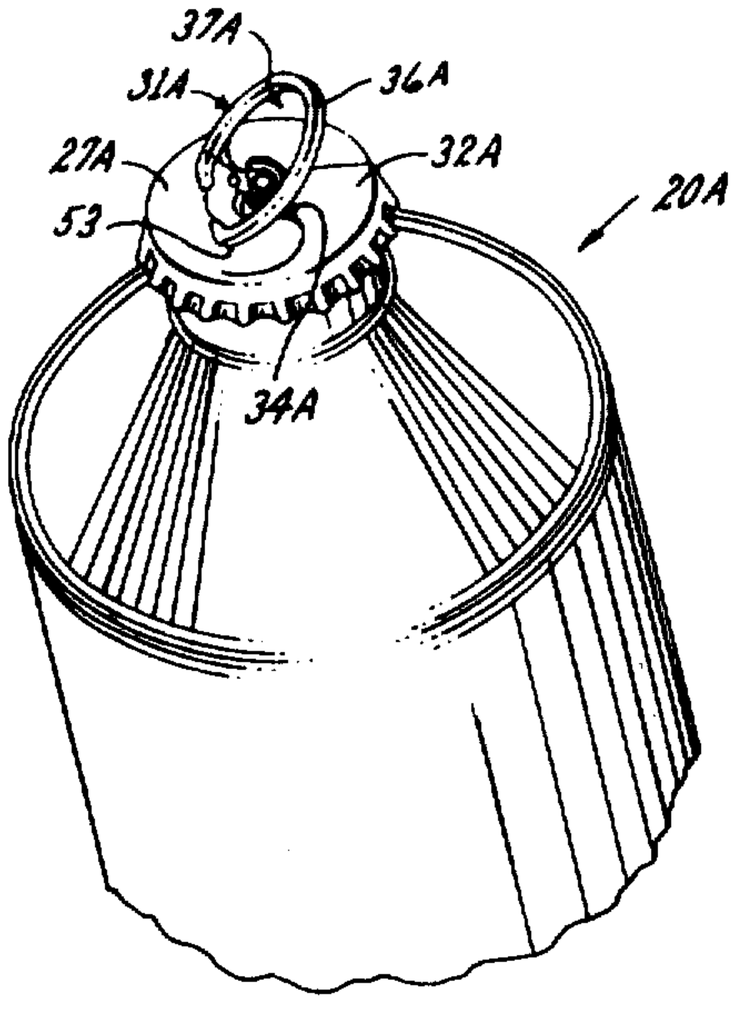


FIG. 14

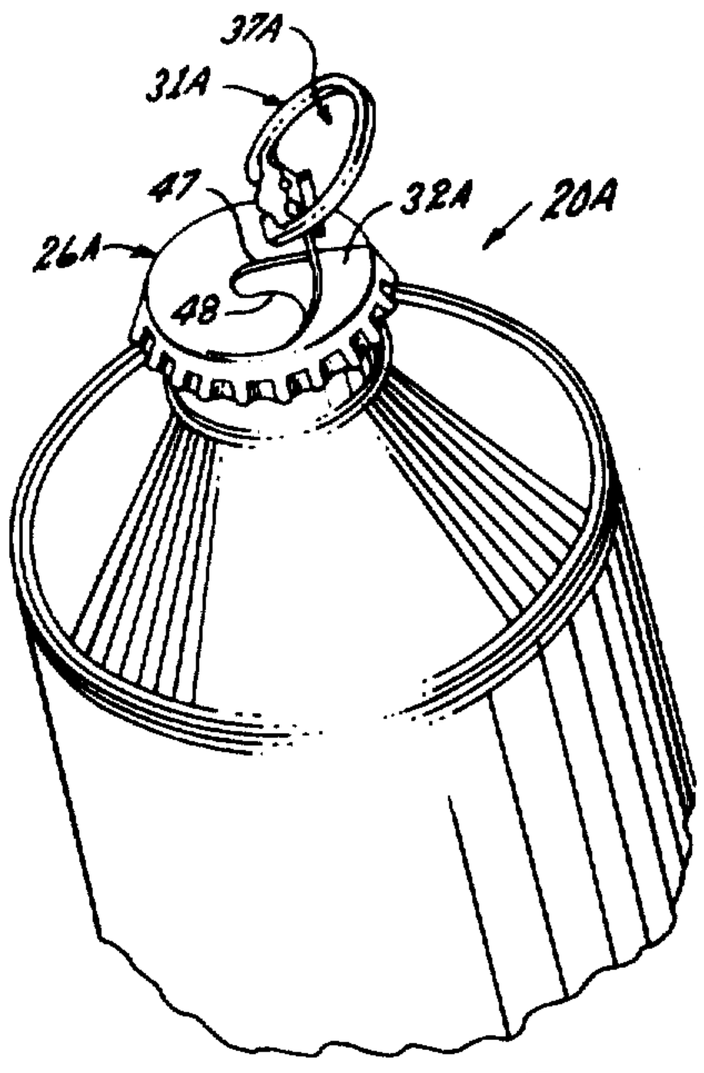


FIG. 15

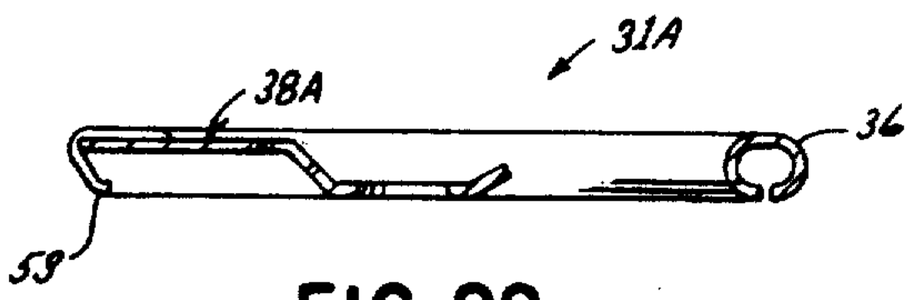


FIG. 22

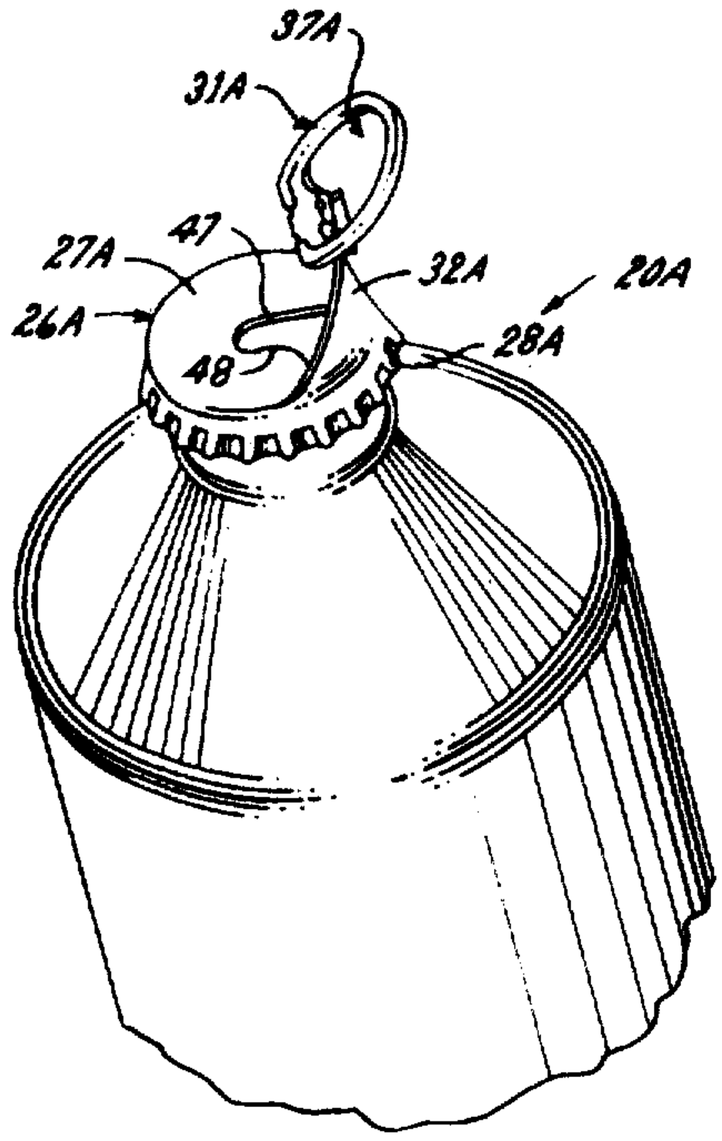


FIG. 16

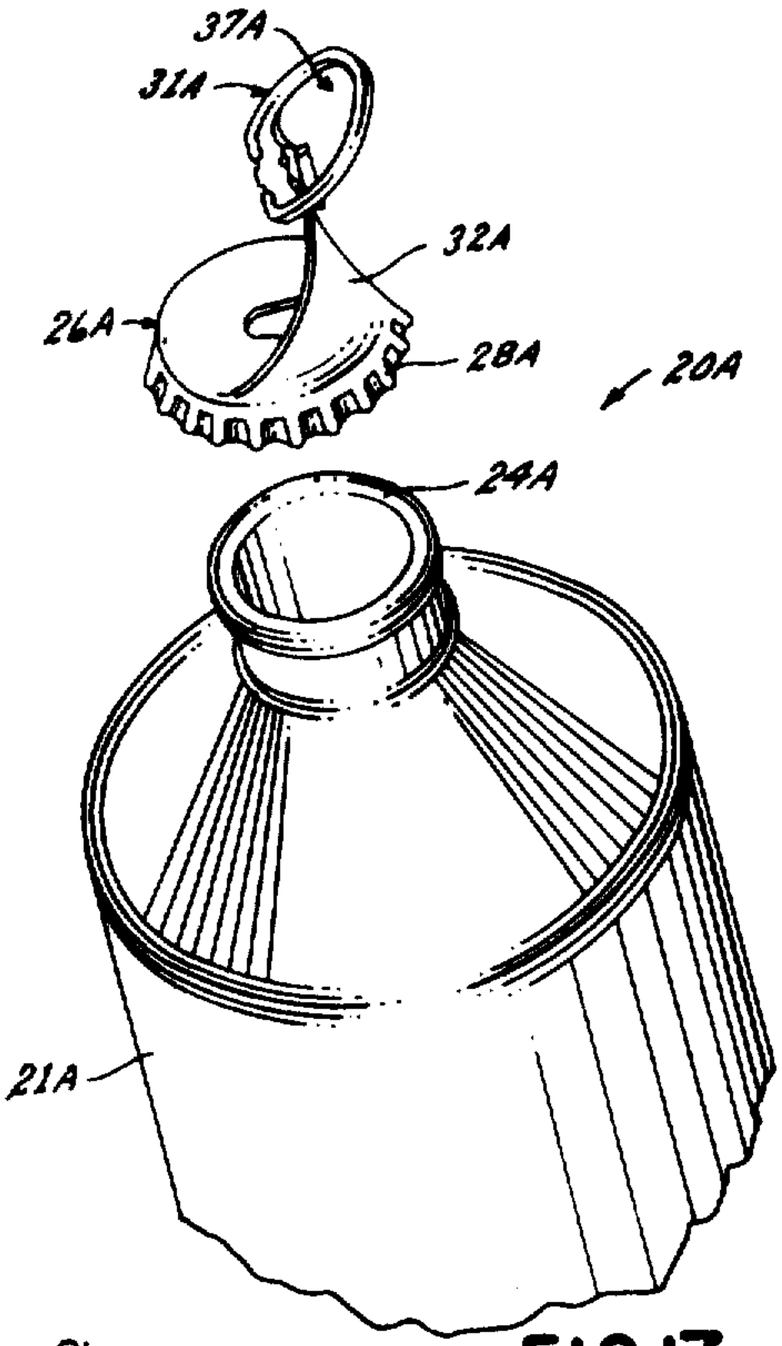


FIG. 17

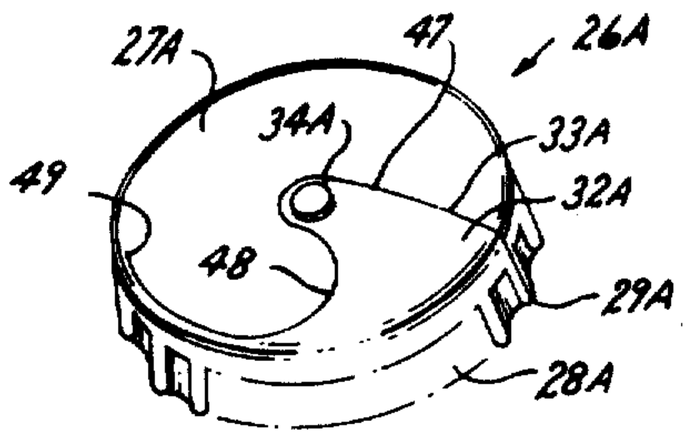


FIG. 18

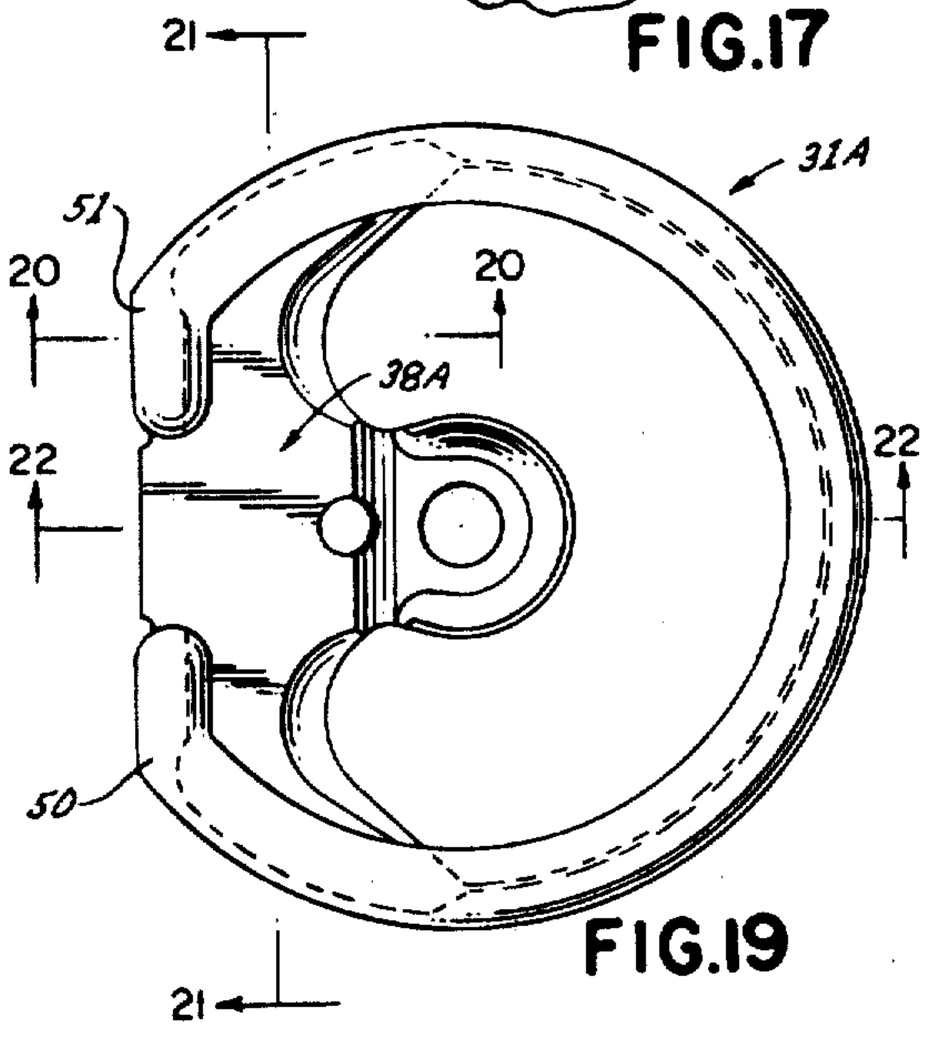


FIG. 19

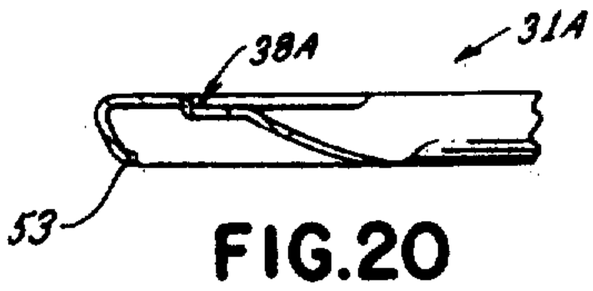


FIG. 20

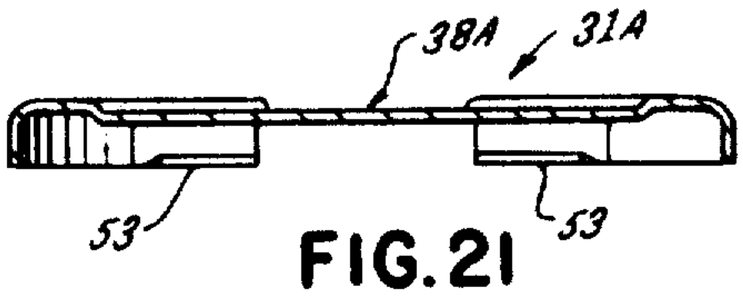


FIG. 21

EASY OPEN MEANS FOR BOTTLES AND THE LIKE

Matter enclosed in heavy brackets [ ] appears in the original patent but forms no part of this reissue specification; matter printed in italics indicates the additions made by reissue.

This invention relates to an improved easy open means for a closure member utilized to close the open end of a bottle-like container or the like.

It is well known that many beverage companies have been merchandising their product in aluminum containers or the like having the upper end closure thereof provided with a tear-out portion interconnected to a pull tab means so that the ultimate consumer can grasp the pull tab means and sever the tear-out portion from the end wall of the container to provide an opening therein for subsequent product dispensing purposes.

However, such cylindrical container end closure means and pull tab forming mechanism are not applicable for use on the relatively small crown type end closures or caps normally utilized with beverage bottles and the like so that no satisfactory easy open means have been provided for the conventional bottle type beverage container whereby auxiliary bottle cap openers must be utilized by the ultimate consumer to open such bottle-like beverage containers.

According to the teachings of this invention, however, easy open means are provided for the conventional crown type end closures for bottle-like containers or the like wherein the ultimate consumer can open such end closure and remove the same from the bottle-like container in an easy and effective manner without requiring an auxiliary opening member.

Therefore, it is an object of this invention to provide an improved easy open means for a bottle-like container or the like, the easy open means of this invention having one or more of the novel features set forth above or hereinafter shown or described.

Another object of this invention is to provide an improved end closure having easy open means.

Other objects, uses and advantages of this invention are apparent from a reading of this description, which proceeds with reference to the accompanying drawings forming a part thereof and wherein:

FIG. **1** is a fragmentary, top perspective view of the improved bottle-like container means of this invention.

FIG. **2** is an enlarged top view of the end closure utilized with the bottle-like container of FIG. **1.**

FIG. **2A** is an enlarged, fragmentary, cross-sectional view taken substantially on line **2A—2A** of FIG. **2.**

FIG. **3** is a view similar to FIG. **1** and illustrates the initial step in opening the beverage container of FIG. **1.**

FIG. **3A** is a view similar to FIG. **2A** and is taken substantially on line **3A—3A** of FIG. **3.**

FIG. **4** is a view similar to FIG. **3** and illustrates another step in the end closure opening method of this invention.

FIG. **5** is a view similar to FIG. **2A** and illustrates the tear-out section being completely removed from the end closure of this invention.

FIG. **6** is a fragmentary, side view of the end closure and container of FIG. **5** after the tear-away section thereof has been removed.

FIG. **7** is a view similar to FIG. **5** and illustrates the last step in the method for completely opening the container of FIG. **1.**

FIG. **8** is an enlarged top view of the ring pull tab means of this invention utilized with the container of FIG. **1.**

FIG. **9** is a cross-sectional view taken on line **9—9** of FIG. **8.**

FIG. **10** is a fragmentary, cross sectional view taken on line **10—10** of FIG. **8.**

FIG. **11** is a cross-sectional view taken on line **11—11** of FIG. **8.**

FIG. **12** is a view similar to FIG. **1** and illustrates another embodiment of this invention.

FIG. **13** is an enlarged top view of the container of FIG. **12.**

FIG. **14** is a view similar to FIG. **12** and illustrates the pull ring in its initially raised position.

FIGS. **15, 16** and **17** are views similar to FIG. **14** and illustrate other steps in the method for opening the container of FIG. **12.**

FIG. **18** is a perspective view of the closure member of FIG. **12** without the pull ring thereon.

FIG. **19** is an enlarged top view of the pull ring for the container of FIG. **12.**

FIG. **20** is a fragmentary cross-sectional view taken on line **20—20** of FIG. **19.**

FIG. **21** is a cross-sectional view taken on line **21—21** of FIG. **19.**

FIG. **22** is a cross-sectional view taken on line **22—22** of FIG. **19.**

While the various features of this invention are hereinafter described and illustrated as being particularly adaptable to provide easy open means for a beverage bottle or the like, it is to be understood that the various features of this invention can be utilized singly or in any combination thereof to provide easy open means for other types of products.

Therefore, this invention is not to be limited to only the embodiments illustrated in the drawings, because the drawings are merely utilized to illustrate one of the wide variety of uses of this invention.

Referring now to FIG. **1,** one embodiment of the improved container means of this invention is generally indicated by the reference numeral **20** and comprises a conventional glass-type bottle **21** of the returnable or non-returnable type having an upper end **22** provided with a conventional neck **23** terminating at its upper end in an annular bead **24** surrounding the open end **25** thereof and through which the desired product, such as a beverage or the like, is disposed within the bottle **21** and through which the product is subsequently dispensed by the ultimate consumer.

A substantially conventional crown type end closure or bottle cap **26** of this invention is adapted to be disposed over the neck portion **23** of the bottle **22** to seal the product means therein by conventional bottle closing mechanism.

In particular, the conventional end closure **26** includes a substantially flat top portion **27** having a depending peripheral flange means or rim means **28** adapted to depend below the annular bead **24** of the bottle **21** and through the corrugation means **29** and be inwardly bent or crimped to hold the end closure **26** to the annular bead **24** of the bottle **21** so that the product means will be completely hermetically sealed in the bottle **21.**

In order to perfect the hermetic seal between the end closure **26** and the open end **25** of the bottle **21,** a suitable sealing gasket means **30** is carried by the end closure **26** and is adapted to be compressed against the annular bead **24** of the bottle **21** in a conventional manner.

In order to convert the conventional end closure **26** to the easy open means of this invention, a ring-like pull tab means **31** is provided and is interconnected to a tear section **32** of the end closure **26** in a manner hereinafter set forth so that when the pull tab means **31** is utilized in a manner hereinafter described to completely separate the tear section **32** from the end closure **26,** the remaining portion of the end closure **26** on the bottle **21** can be readily removed therefrom by hand in the manner illustrated in FIG. **7** to fully open the bottle **21** without requiring a conventional bottle opener or the like.

In particular, the end closure or bottle cap **26** is formed from metallic material, such as aluminum-containing metallic material or the like and the tear section **32** thereof is defined by score means **33** so constructed and arranged that the same defines a substantially triangular tear section **32** having its apex **34** disposed substantially centrally in the flat top wall **27** of the end closure **26** with the score means **33** diverging away from each other as they extend toward the depending side wall means or peripheral flange **28** of the end closure **26** and extend downwardly along the side wall or flange **28** of the end closure **26** to the free end **35** thereof.

The ring-like pull tab means **31** of this invention is fully illustrated in FIGS. **8–11** and comprises metallic material, such as aluminum-containing metallic material or the like, suitably formed to defined an annular portion **36** having a substantially circular cross-sectional configuration and providing a finger-receiving opening **37** for a purpose hereinafter described, the annular portion **36** being defined in part by a stepped flange means **38** having a front portion **39** interconnected to an angularly disposed portion **40** at an edge or fold line **41** suitably weakened by an aperture **42** passing therethrough for a purpose hereinafter described. The angular portion **40** is interconnected to an inwardly directed fastening tab **43** having an opening **44** passing therethrough and being substantially surrounded by an upwardly flared peripheral section **45** to strengthen the section **43** for a purpose hereinafter described.

In order to secure the ring-like pull tab means **31** of this invention to the tear section **32** of the end closure **26,** the tear section **32** has an integral rivet-like portion **46** upwardly formed therefrom and passing through the opening **44** of the pull tab means **31** in the manner illustrated in FIG. **2A** to be subsequently flattened so tha the rivet portion **46** holds the pull tab means **31** thereto as fully illustrated in FIG. **2A.**

When the pull tab means **31** is secured to the end closure **26** in the manner previously described, it can be seen that the pull tab means **31** is disposed flush against the flat portion **27** of the end closure **26** to provide a compact arrangement so that the assembled pull tab means **31** and end closure **26** can be utilized with existing bottle cap facilities at breweries or other bottling plants and can be used at the same high speed requiring only minor modifications thereof.

After the assembled ring-like pull the tab means **31** and end closure **26** of this invention have been assembled together in the manner previously described, the same can be utilized to seal closed the open end **25** of the product filled bottle **21** in the manner previously described whereby the depending flange **28** of the end closure **26** is crimped around the annular bead **24** of the bottle **21** in the previously described conventional manner to hermetically seal the product means within the bottle **21.**

When the ultimate consumer desires to open the container means **20** of this invention, the ultimate consumer inserts a finger nail or the like under the right-hand portion of the pull tab means **31** and lifts upwardly on the same in the manner illustrated in FIGS. **3** and **3A** whereby the left-hand portion of the annular means **36** of the pull tab means **31** begins to fulcrum against the top wall **27** of the end closure **26** outboard of the apex **34** of the tear section **32** to pull upwardly on the rivet means **46** of the tear section **32** and cause the apex **34** thereof to completely separate from the end closure **26** in the manner illustrated in FIGS. **3** and **3A.**

Thus, it can be seen that a relatively small force is required to lift upwardly on the pull tab means **31** to dispose the same in the position illustrated in FIGS. **3** and **3A** because of the lever-like arrangement of the pull tab means **31** and because the flange means **38** of the pull tab means **31** readily bends at the line **41** thereof to cause an upward lifting force on the rivet means **46** to separate the apex part **34** of the tear section **32** from the wall **27** of the end closure **26,** the flared annular surrounding means **45** of the securing part **43** of the pull tab means **31** fully reinforcing the opening **44** thereof to prevent the section **43** from being torn from the rivet means **46** in a premature manner.

With the pull tab means **31** now disposed in the position illustrated in FIGS. **3** and **3A,** the ultimate consumer can now insert a finger through the finger-receiving opening **37** thereof and pull the pull tab means **31** to the right in FIGS. **3** and **3A** and then downwardly in a simple motion in the manner illustrated in FIG. **5** whereby the tear section **32** will completely separate from the end closure **26** as illustrated in FIGS. **5** and **6.** The holding force of the inwardly crimped side wall or flange **28** of the end closure **26** around the annular bead **24** of the bottle **21** is now substantially relieved by the removed tear section **32** in a manner to permit the ultimate consumer to merely push upwardly on the remaining portion of the end closure **26** at the free edge **35** thereof in the manner illustrated in FIG. **7** so that the end closure **26** will be readily separated from the bottle **21** in any easy finger removing manner.

Thus, it can be seen that the pull tab means **31** and tear section **32** of this invention readily converts the conventional crown type end closure or bottle cap **26** to an easy open means in a simple and effective manner so that the ultimate consumer can readily open the container means **20** of this invention with a simple finger operation without requiring a conventional bottle cap opener or the like. However, it can further be seen that if the ultimate consumer does not utilize the easy open means **31, 32** of this invention, the bottle cap **26** can be opened in the conventional manner by a bottle cap opener because the pull tab means **31** is disposed snugly against the flat top wall **27** of the end closure **26** and will not interfere with the conventional opening means for the container **20,** if desired.

Further, it can readily be seen that in initially lifting the pull tab means **31** from the position illustrated in FIG. **2A** to the position illustrated in FIG. **3A** in the manner previously described, the apex means **34** of the tear section **32** is completely severed from the flat wall **27** of the end closure **26** by an effective lever-like arrangement so that the subsequent pulling of the tear section **32** from the end closure **26** in the manner illustrated in FIG. **5** requires relatively little force because it is well known that in tear sections the greatest force is required in initially forming a separation between the tear section and the remainder of the wall thereof.

For example, in the past, such initial separation of an end portion of the tear section from the remaining wall of the end closure carrying the same required a pulling action by the ultimate consumer, whereas in this invention, the initial separation is easily provided by a simple lever-like arrangement so that the fulcruming action of the pull tab means **31** relative to the end closure **26** effects the initial separation of the tear section **32** from the end closure **26** without requiring a pulling action as in the past.

While the tear section **32** for the container construction **20** has been previously described as being completely removable from the closure member **26** during the bottle opening operation, it is to be understood that such tear section could remain secured to the closure member while still effecting easy opening thereof in combination with the ring-like pull tab means.

For example, another embodiment of this invention is illustrated in FIGS. **12–22** wherein the various parts of the container construction or means **20A** that are substantially identical to like parts of the container means **20** are indicated by the reference numerals followed by the reference letter A.

As illustrated in FIG. **12**, the container means **20A** comprises the conventional glass type bottle **21A** having the end closure or cap **26A** of this invention secured to the neck porition **23A** in the manner previously described to substantially hermetically seal a desired product within the bottle **21A.**

The end closure member **26A** includes a tear section **32A** defined therein by score means **33A** with one end **34A** of the tear section **32A** being secured to the ring pull tab means **31A** by the integral rivet means **46A** previously described.

However, it can readily be seen in FIG. **18** that the closure member or cap **26A** has the tear section **32A** defined by the score means **33A** in such a manner that one edge means **47** of the tear section **32A** extends from the end **34A** of the tear section **32A** across the top portion **27A** and down the rim portion **28A** to the free end **29A** thereof in substantially the same manner as one of the opposed edge of the previously described tear section **32.** However, the other edge means **48** of the tear section **32A** extends from the end **34A** thereof toward the rim portion **28A** and then loops back or reversely turns to run substantially concentric with the outer periphery of the top portion **27A** to terminate at a point **49** as illustrated in FIG. **18** for a purpose hereinafter described.

The ring pull tab means **31A** for the container means **20A** is substantially indentical to the ring pull tab means **31** previously except that the stepped flange portion **38A** thereof has the opposed ends **50** and **51** curled thereunder to respectively define fulcrum point means **53** as illustrated in FIGS. **20** and **22** to fulcrum on the top portion **27A** of the end closure **26A** during

the opening operation of the container means **20A** now to be described.

As illustrated in FIGS. **12** and **13,** the ring pull tab means **31A** is disposed substantially concentrically upon the top portion **27A** of the end closure **26A** and is firmly attached to the end **34A** of the tear section **32A** by the previously described integral rivet means **46A.** However, when the ultimate consumer desires to open the container means **20A** with the ring pull tab means **31A,** the ultimate consumer lifts upwardly on the right-hand end of the annular portion **36A** of the ring pull tab means **31A** in the manner illustrated in FIG. **14** to cause the fulcrum points **53** of the ring pull tab means **31A** to fulcrum against the top portion **27A** of the end closure **26A** and raise and separate the inner end **34A** of the tear section **32A** in the manner previously described.

With the ring pull tab means **31A** disposed in the raised position illustrated in FIG. **14,** the ultimate consumer can now fully insert a finger into the finger receiving opening **37A** of the ring pull tab means **31A** and pull outwardly and upwardly on the same in the manner illustrated in FIG. **15** to cause the tear section **32A** to begin to separate from the remainder of the end closure **26A** along the opposed edges **47** and **48** thereof in the manner illustrated in FIG. **15.**

Further outward movement of the ring pull tab means **31A** causes the edge means **47** of the tear section **32A** to tear or separate completely from the end closure **26A** along the top portion **27A** and rim portion **28A** thereof in the manner illustrated in FIG. **16** and to begin to tear along the reversely turned part of the edge means **48** until a particular position is reached to completely relieve the holding tension of the rim portion **28A** of the end closure **26A** around the beaded upper end **24A** of the bottle **21A** so that the entire end closure **26A** is completely pulled therefrom in the manner illustrated in FIG. **17.**

Thus, it can be seen that the tear section **32A** in the embodiment of FIGS. **12–22** remains secured to the end closure **26A** after the tear section **32A** has been partially separated from the remainder of the end closure **26A** in an amount sufficient to completely relieve the holding tension of the crimped rim portion **28A** around the bead **24A** of the bottle **21A** so that the entire end closure **26A** and attached tear section **32A** can be removed as a unit from the bottle **21A** in substantially one simple pulling motion by the ultimate consumer.

This simply pulling motion is effected by the ultimate consumer merely placing one finger in the finger receiving opening **37A** of the ring pull tab means **31A** in the manner previously described whereby no sharp or ragged edges on the end closure **26A** will be engaged by the hands of the ultimate consumer during the previously described easy opening of the container means **20A.**

Therefore, it can be seen that the end closure **26** in the embodiment of FIG. **1** has the tear section **32** thereof completely removed during the easy opening thereof whereas the tear section **32A** in the end closure **26A** of the embodiment of FIG. **12** remains secured to the remainder of the end closure **26A** during the easy opening of the container means **20A.**

Therefore, it can be seen that this invention not only provides an improved easy open means for bottle-like container means or the like, but also this invention

provides an improved end closure means for such a container means or the like.

While the form of the invention now preferred has been disclosed as required by the statutes, other forms may be used, all coming within the scope of the claims which follow.

What is claimed is:

1. In combination, a container having an open end for dispensing product means disposed in said container, and a [one-piece] closure member secured to said open end of said container to close said open end, said closure member having a top portion disposed over said open end and a depending peripheral rim portion disposed around said container at said open end thereof to secure said closure member to said container, said closure member having a tear section integral therewith throughout the entire juncture of said tear section with the remainder of said closure member and provided with two edges that join together at adjacent ends thereof to define one end of said tear section substantially at the central part of said top portion with at least one edge thereof extending from said top portion to the free edge of said rim portion and with the other edge always [progressively] diverging away from said one edge from said adjacent ends thereof to the other ends thereof, and a ring pull tab means secured to said tear section at said top portion of said closure member and having a finger-receiving opening passing therethrough to facilitate the pulling of at least said one edge of said tear section from said closure member.

2. A combination as set forth in claim **1** wherein said juncture between said tear section and said remainder of said closure member is defined by score line means in said closure member.

3. A combination as set forth in claim **1** wherein said other edge of said tear section extends from said top portion of said closure member and terminates short of said free edge of said rim portion whereby said tear section remains integral with said closure member even though said edges have been separated from said closure member to permit pulling of said closure member from said container by said ring pull tab means.

4. A combination as set forth in claim **3** wherein said other edge of said tear section extends toward said rim portion from said one end of said tear section and reversely turns adjacent thereto along said top portion of said closure member.

5. A combination as set forth in claim **1** wherein said tear section has a substantially triangular configuration.

6. A combination as set forth in claim **5** wherein said tear section has its apex secured to said pull tab means with its base being defined at said free edge of said rim portion whereby said tear section can be completely separated from said closure member by said ring pull tab means.

7. A combination as set forth in claim **1** wherein said ring pull tab means is initially disposed against and within the outer periphery of said top portion of said closure member.

8. A [one-piece] closure member for a container having an open end for dispensing product means disposed in said container, said closure member having a top portion adapted to be disposed over said open end and a depending peripheral rim portion adapted to be disposed around said container at said open end thereof to secure said closure member to said container, said closure member having a tear section integral therewith throughout the entire juncture of said tear section with the remainder of said closure member and provided with two edges that join together at adjacent ends thereof to define one end of said tear section substantially at the central part of said top portion with at least one edge thereof extending from said top portion to the free edge of said rim portion and with the other edge always [progressively] diverging away from said one edge from said adjacent ends thereof to the other ends thereof, and a ring pull tab means secured to said tear section at said top portion of said closure member and having a finger-receiving opening passing therethrough to facilitate the pulling of at least said one edge of said tear section from said closure member.

9. A closure member as set forth in claim **8** wherein said juncture between said tear section and said remainder of said closure member is defined by score line means in said closure member.

10. A combination as set forth in claim **8** wherein said other edge of said tear section extends from said top portion of said closure member and terminates short of said free edge of said rim portion whereby said tear section remains integral with said closure member even though said edges have been separated from said closure member to permit pulling of said closure member from said container by said ring pull tab means.

11. A combination as set forth in claim **10** wherein said other edge of said tear section extends toward said rim portion from said one end of said tear section and reversely turns adjacent thereto along said top portion of said closure member.

12. A closure member as set forth in claim **8** wherein said tear section has a substantially triangular configuration.

13. A closure member as set forth in claim **12** wherein said tear section has its apex secured to said pull tab means with its base being defined at said free edge of said rim portion whereby said tear section can be completely separated from said closure member by said ring pull tab means.

14. A closure member as set forth in claim **8** wherein said ring pull tab means is initially disposed against and within the outer periphery of said top portion of said closure member.

15. A [one-piece] closure member for a container having an open end for dispensing product means disposed in said container, said closure member having a top portion adapted to be disposed over said open end and a depending peripheral rim portion adapted to be disposed around said container at said open end thereof to secure said closure member to said container, said closure member having a tear section integral therewith throughout the entire juncture of said tear section with the remainder of said closure member and provided with two edges that join together at adjacent ends thereof to define one end of said tear section [substantially at the central part of said top portion] with at least one edge thereof extending from said top portion to the free edge of said rim portion and with the other edge always [progressively] diverging away from said one edge from said adjacent ends thereof to the other ends thereof.

16. A closure member as set forth in claim **15** wherein said juncture between said tear section and said remainder of said closure member is defined by score line means in said closure member.

17. A closure member as set forth in claim 15 wherein said other edge of said tear section extends from said top portion of said closure member and terminates short of said free edge of said rim portion whereby said tear section remains integral with said closure member even though said edges have been separated from said closure member.

18. A closure member as set forth in claim 17 wherein said other edge of said tear section extends toward said rim portion from said one end of said tear section and reversely turns adjacent thereto along said top portion of said closure member.

19. A closure member as set forth in claim 15 wherein said tear section has a substantially triangular configuration.

20. A closure member as set forth in claim 19 wherein said tear section has its apex defined at said top portion with its base being defined at said free edge of said rim portion whereby said tear section can be completely separated from said closure member.

21. In combination a container having an open end for dispensing product means disposed in said container, and a closure member secured to said open end of said container to close said open end, said closure member having a top portion disposed over said open end and a depending peripheral rim portion disposed around said container at said open end thereof to secure said closure member to said container, said closure member having a tear section integral therewith throughout the entire juncture of said tear section with the remainder of said closure member and provided with two edges that join together at adjacent ends thereof to define one end of said tear section with at least one edge thereof extending from said top portion to the free edge of said rim portion and with the other edge always diverging away from said one edge from said adjacent ends thereof to the other ends thereof, and a ring pull tab means secured to said tear section at said top portion of said closure member and having a finger receiving opening passing therethrough to facilitate the pulling of at least said one edge of said tear section from said closure member.

22. A combination as set forth in claim 21 wherein said other edge of said tear section extends from said top portion of said closure member and terminates short of said free edge of said rim portion whereby said tear section remains integral with said closure member even though said edges have been separated from said closure member to permit pulling of said closure member from said container by said ring pull tab means.

23. A closure member for a container having an open end for dispensing product means disposed in said container, said closure member having a top portion adapted to be disposed over said open end and a depending peripheral rim portion adapted to be disposed around said container at said open end thereof to secure said closure member to said container, said closure member having a tear section integral therewith throughout the entire juncture of said tear section with the remainder of said closure member and provided with two edges that join together at adjacent ends thereof to define one end of said tear section with at least one edge thereof extending from said top portion to the free edge of said rim portion and with the other edge always diverging away from said one edge from said adjacent ends thereof to the other ends thereof, and a ring pull tab means secured to said tear section at said top portion of said closure member and having a finger-receiving opening passing therethrough to facilitate the pulling of at least said one edge of said tear section from said closure member.

24. A combination as set forth in claim 23 wherein said other edge of said tear section extends from said top portion of said closure member and terminates short of said free edge of said rim portion whereby said tear section remains integral with said closure member even though said edges have been separated from said closure member to permit pulling of said closure member from said container by said ring pull tab means.

25. A combination as set forth in claim 21 in which said closure member has a sealing gasket.

26. A closure member as set forth in claim 17 which further has a sealing gasket.

27. A closure member as set forth in claim 17 made of metal containing aluminum.

28. A closure member as set forth in claim 24 which further has a sealing gasket.

29. A closure member as set forth in claim 24 made of metal containing aluminum.

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