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(54) **MULTI-LAYERED CHILD RESISTANT BLISTER PACKAGE AND METHOD OF ASSEMBLING SAME**

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(73) Assignee: **Howell Packaging division of FM Howell & Co.**, Elmira, NY (US)

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**Related U.S. Patent Documents**

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Issued: **Dec. 9, 2003**
Appl. No.: **10/061,154**
Filed: **Feb. 4, 2002**

(51) **Int. Cl.**
***B65D 83/04*** (2006.01)

(52) **U.S. Cl.** ..... **206/531**; 206/462; 206/469

(58) **Field of Classification Search** ..... 206/461, 206/462, 467, 468, 469, 531, 532, 534, 538, 206/539
See application file for complete search history.

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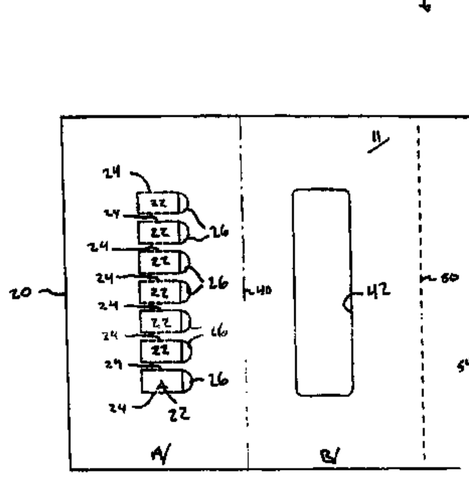
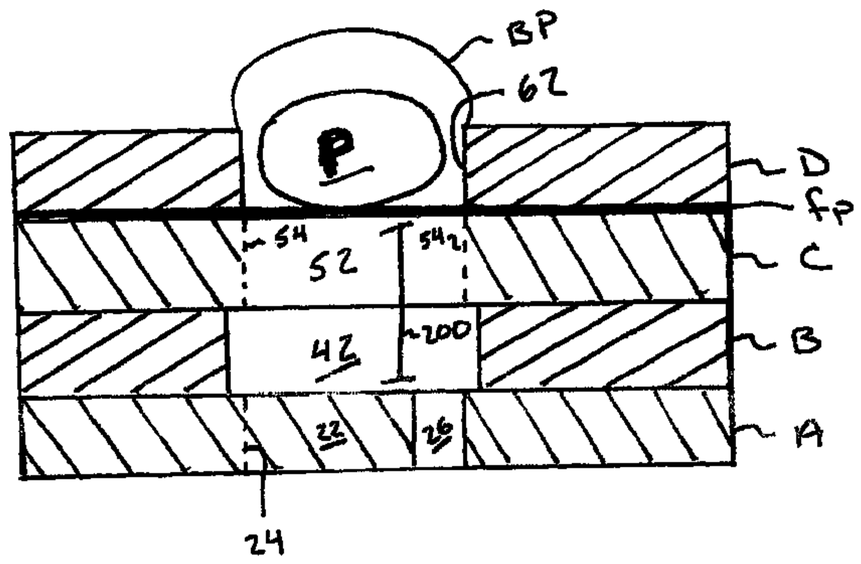
(57) **ABSTRACT**

A multi-layered child resistant blister package having blister packaging that retains an article. A single blank sheet has first and second opposing side edges and first, second, and third score lines that are parallel to the first and second opposing side edges. The opposing side edges and score lines delimit a back panel, first and second intermediate panels, and a top panel having at least one blister receiving pocket. The first intermediate panel is folded onto the back panel about the first score line. The second intermediate panel is folded onto the first intermediate panel about the second score line. The top panel is folded onto the second intermediate panel about the third score line. A cavity through which the article passes is defined at least by the first and second intermediate panels. The back panel includes a tear away panel positioned remote from an outer periphery of the package.

**23 Claims, 7 Drawing Sheets**



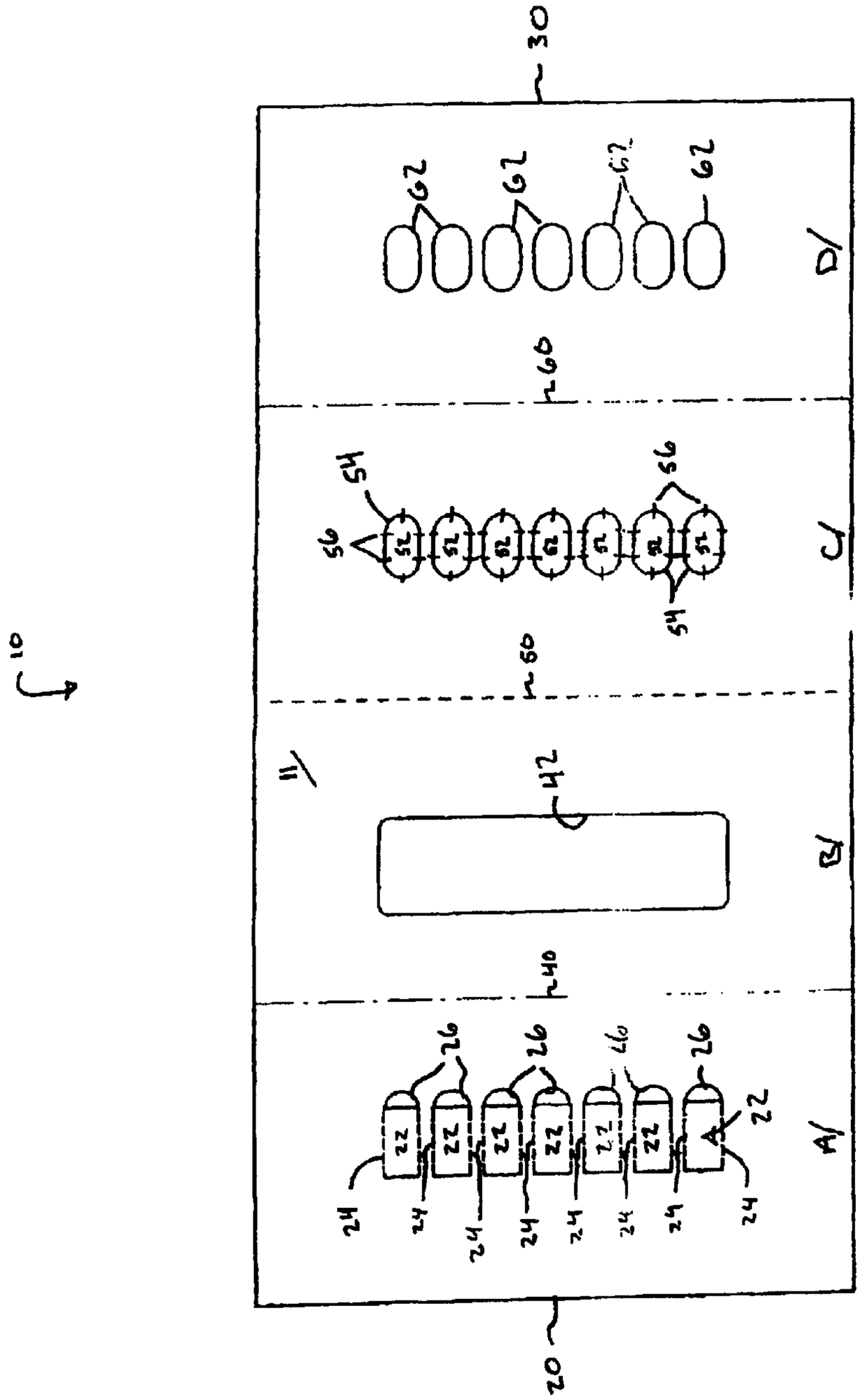



Fig. 1

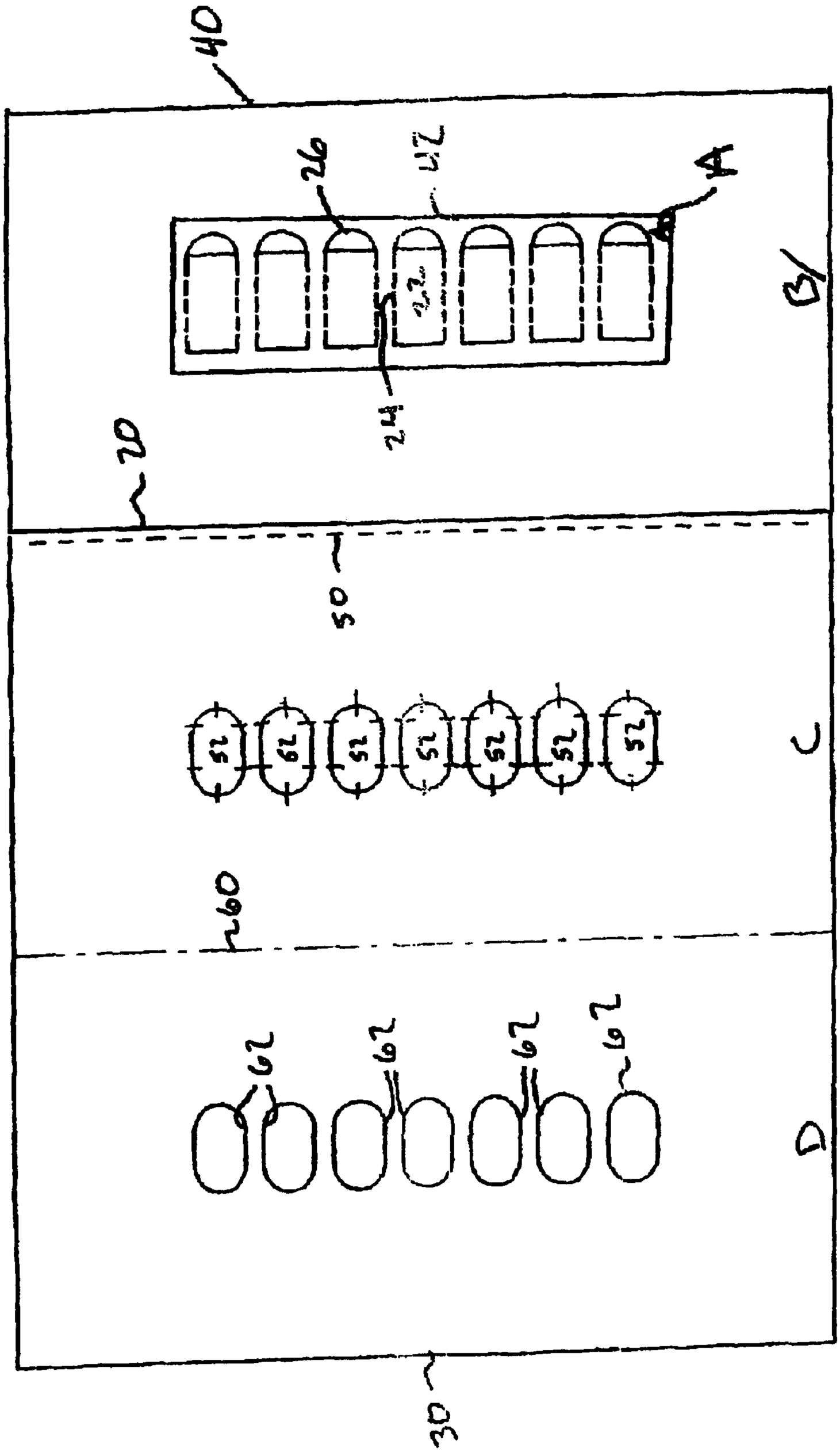



FIG. 2

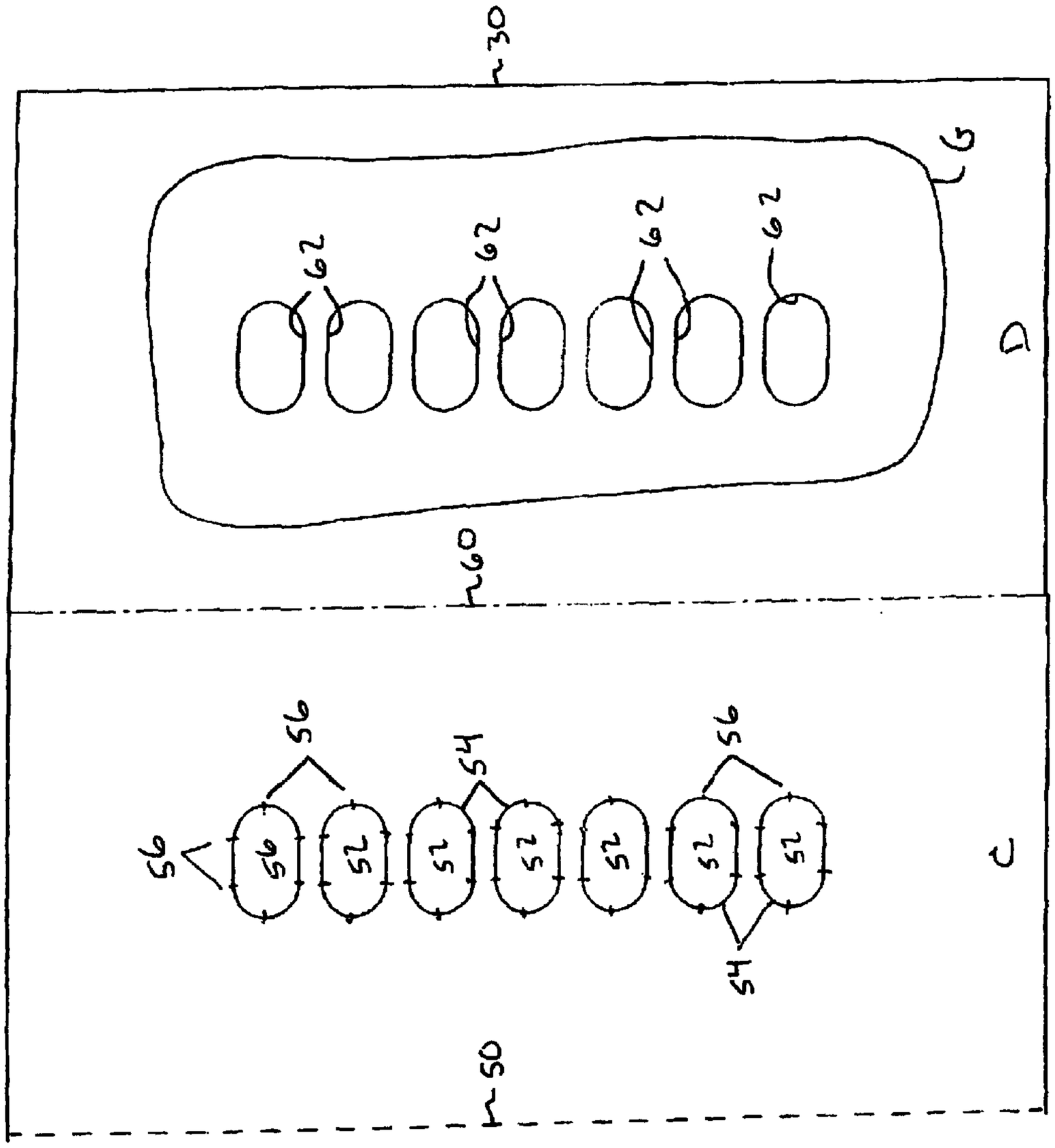



Fig. 3

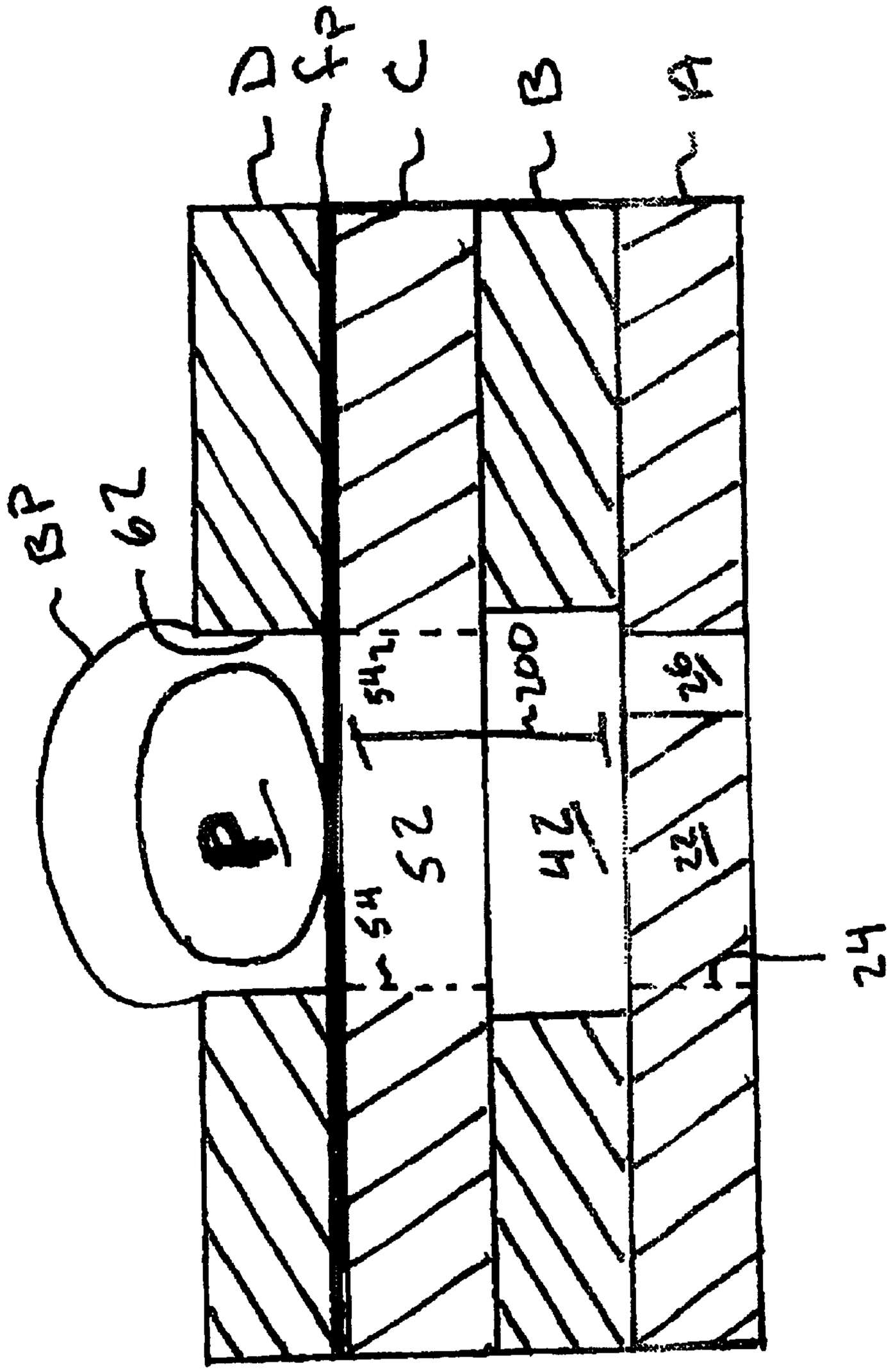



Fig. 4

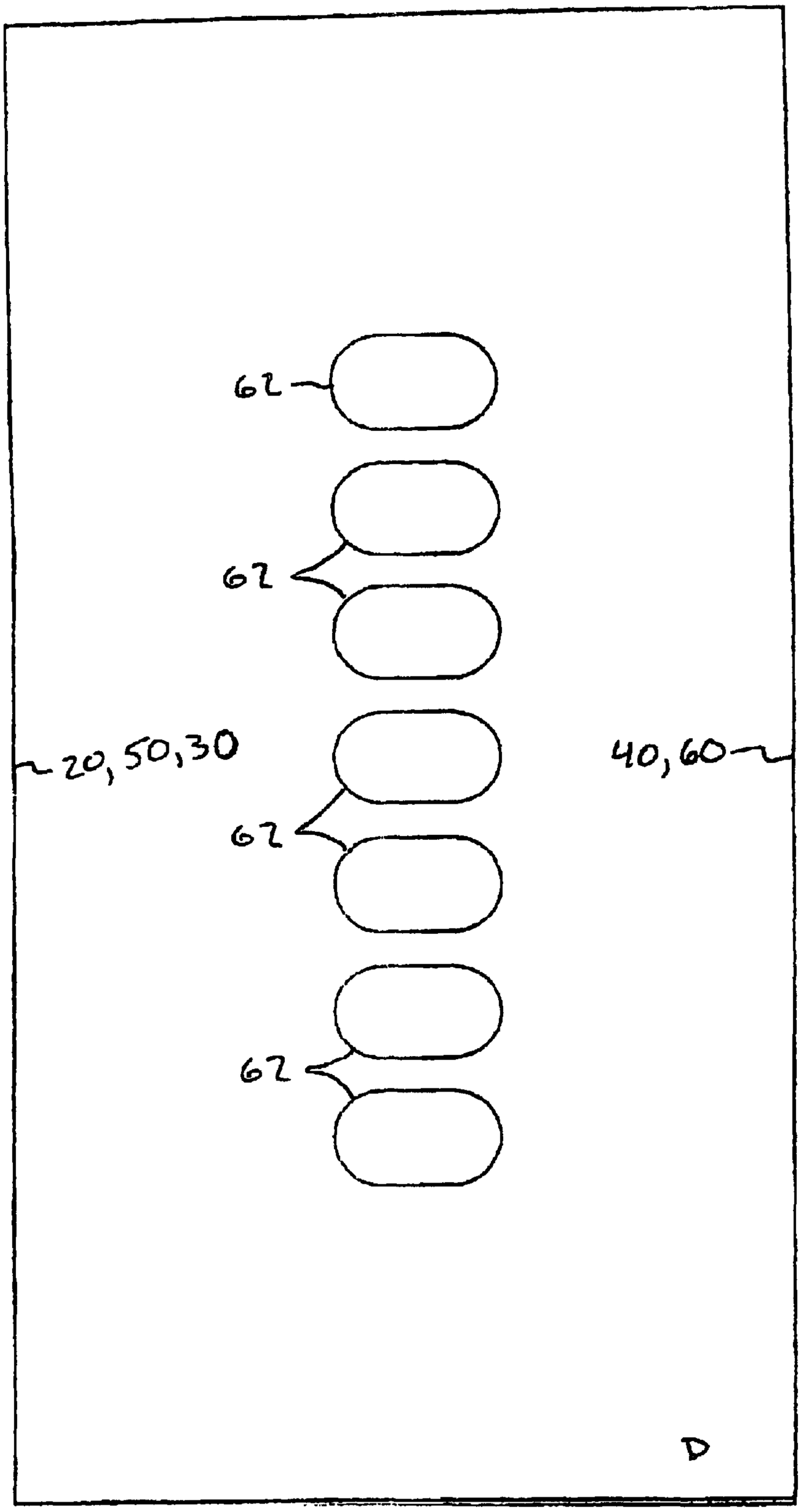
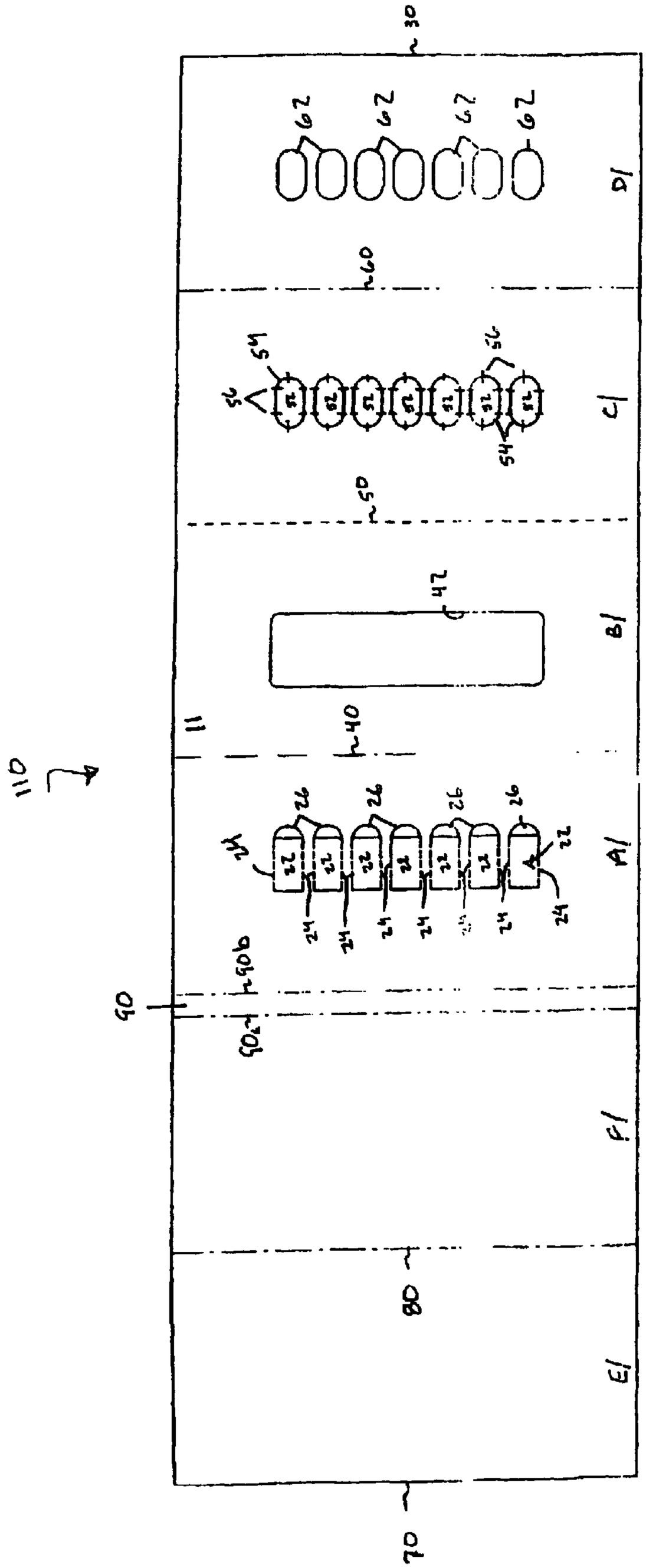



Fig. 5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42
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42
42
D1
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52
C1
50
46
B1
11
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60b
F1
80
E1
70

Fig. 6

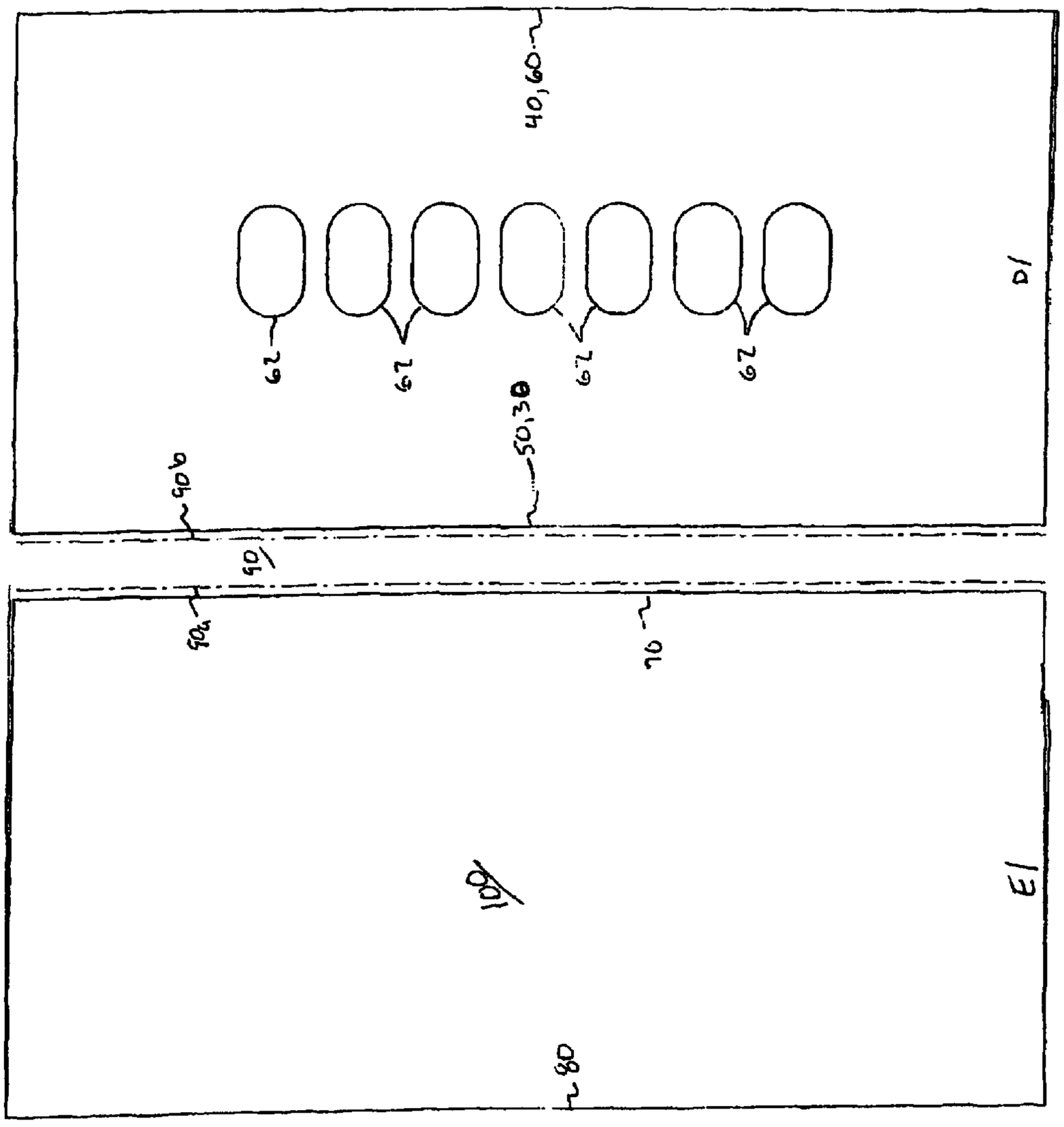


Fig 7

# MULTI-LAYERED CHILD RESISTANT BLISTER PACKAGE AND METHOD OF ASSEMBLING SAME

**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.**

## BACKGROUND OF THE INVENTION

1. Field of the Invention

This invention relates to a multi-layered blister package having a cavity with a depth that makes removal of articles contained within the package difficult for children.

2. Discussion of Related Art

It is common practice to use blister packages to package small solid articles or products which may be dispensed from the package by applying pressure to the blister to force the article or product from an individual blister or capsule through a rupturable membrane. Since this type of packaging is typically used for marketing medicines, the invention will be referred to herein with respect to a package particularly suitable for such use, but it should be understood that the package may be used for other products as well. Recently, a substantial effort has been directed toward providing packaging that contains sufficient impediments to prevent children from easily opening the package and gaining access to the package articles or products while still providing adults with easy access to the articles or products contained therein.

For example, U.S. Pat. No. 6,161,699 to Gartland discloses a conventional child-resistant package **10** having a blister containing laminate **12** with a plurality of cavity forming blisters **14** provided therein and projecting from a top of the laminate **12**. As illustrated in FIGS. **1**–**4** of Gartland, each blister **14** includes a tablet or pill **16**. A foil sheet **18** seals the blister **14** with the pill **16** therein. A card backing **20** is then laminated onto the other surface of the foil **18** and is formed with a series of punch-out sections **22** that are aligned with the blisters **14**. Each punch out section **22** has perforations **24**. A high strength adhesive film **26** is laminated onto the back of the card **20**. The adhesive film **26** is then removed to expose the punch-outs **22** formed by the perforations **24** in the card backing **20**. Then, in order to remove the pill **16** from the blister **14**, pressure is applied to the blister **14** so the pill punctures the foil **18**.

Gartland's package requires a rather undesirable level of dexterity on the part of a user attempting to gain access to the pill **16** in that the user must somehow peel the adhesive film **26** off the back of the card **20** before applying pressure to the blister **14**. Presumably, the user will have to slide a fingernail or other thin device, such as a knife, between the film **26** and card **20** so as to peel the film **26** off the card **20**. Adults, particularly the elderly, may not have the dexterity, hand eye coordination, or patience necessary to peel the film **26** off the back of the card **20**, especially those that suffer from arthritis, poor vision, and other such ailments.

U.S. Pat. No. 5,758,774 to LeBlong discloses another example of a conventional child resistant blister package. In particular, LeBlong discloses a convertible child-resistant blister package **10** that includes a first thermo-formable layer **11** bonded onto a second layer **12** formed from a rupturable material, such as, for example, foil. A blister **15** containing a tablet or pill **16** is provided in the first layer **11**. A third layer **17** is adhered to a bottom of the second layer **12** with a fourth layer **20** adhered to the back of the third layer **17**. A release



peel coating is provided between the third layer **17** and the second layer **12** so that the third layer **17** can be peeled off the second layer **12**.

Furthermore, the third and fourth layers **17** and **20** are integral so that when the third layer **17** is peeled off the second layer **12**, both the third and fourth layers **17** and **20** are removed together. Tear slits **21** extend through all four layers to provide access to the individual blisters **15**. Therefore, in order to gain access to the tablet or pill **16**, a detachable section **22** provided at the end of the package **10** is removed exposing the end **26** of a perforated strip **27** provided in the third and fourth layers **17** and **20**. See FIG. **2** of LeBlong. Then, the longitudinally extending perforated strip **27** is removed exposing the rupturable second layer **12** through which the row of tablets **16** can be pushed. See FIG. **4** of LeBlong.

It is well known in the industry that child resistant features in such packaging is most effective when provided toward a center of the package away from the edge of the package as such placement restricts children from biting through the edge of the package to gain access to the article or product provided therein. In other words, when removable portions of the child resistant feature are provided along the outer edge of the package, it has been found that children are able to access the articles or products simply by biting through the outer edge of the package. Leblong's package enables children to access any unused pills **16** provided beneath the perforated strip **27** as the end **26** of the strip becomes the edge of the package **10** after the detachable portion **22** is removed.

U.S. Pat. No. 5,339,960 to Price discloses yet another example of a conventional child resistant blister package. It should be noted that the Price package positions the child resistant feature at the outer edge of the package. Specifically, Price discloses a child resistant package **10** having a body **11** that contains a plurality of blister chambers **12** with a pill **13** provided therein. The package **10** includes panels A, B, and C. Panel C is folded over panel B and then panel A is folded over panel C. See FIG. **3** of Price. Panel B includes oval cutouts **36** through which the blister **12** extends. Panel C includes score lines **48** and **50** that align with the oval cutouts **36** in panel B. Likewise, panel A includes score lines **18** that align with the score lines **48** of panel C and oval cutouts **36** of panel B. Panel A also includes a tab **15** with a peel away access panel **17** formed by the score lines **18** and **45**.

To gain access to the pill **13**, the tab **15** and peel away access panel **17** on the outer edge of the package are removed to expose a bendable breakaway panel **21**. The bendable breakaway panel **21** is then removed exposing a rupturable foil barrier **19**. Then, pressure is applied to the blister chamber **12** such that the pill **13** can penetrate through the foil barrier **19**. See FIG. **2** of Price.

## SUMMARY OF THE INVENTION

An object of this invention is to at least overcome the above-discussed drawbacks of the conventional child resistant packages and dispensers.

Another object of this invention is to provide a multi-layered child resistant blister package having blister packaging with at least one blister that retains an article therein. A single blank sheet has parallel first and second opposing side edges and first, second, and third score lines that are substantially parallel to the first and second opposing side edges. The opposing side edges and score lines delimit a back panel, first and second intermediate panels, and a top panel having at least one blister receiving pocket, respectively.

To assemble the package, the first intermediate panel is folded onto the back panel about the first score line. Then, the second intermediate panel is folded onto the first intermediate panel about the second score line. The top panel is then folded onto the second intermediate panel about the third score line. The blister packaging is attached to the top panel so that the blister receiving pocket receives the blister of the blister packaging. A cavity through which the article passes is defined at least by the folded first and second intermediate panels. The back panel includes at least one tear away panel positioned remote from an outer periphery of the package. The tear away panels are aligned with a corresponding blister.

## BRIEF DESCRIPTION OF THE DRAWINGS

Other objects and features of this invention will be better understood from the following description, with reference to the accompanying drawings, wherein:

FIG. **1** is a top view of the disassembled package, according to a preferred embodiment of this invention;

FIG. **2** is a partial, top view of the package of FIG. **1** with panel B folded onto panel C;

FIG. **3** is a partial, top view of the package of FIG. **1** with panel C folded onto panels A and B;

FIG. **4** is a schematic diagram illustrating a partial sectional view of the assembled package of FIG. **1** with an article being retained by blister packaging;

FIG. **5** is a top view of the assembled package of FIG. **1** with panel D folded onto panels A, B, and C;

FIG. **6** is a top view of the disassembled package, according to an alternate embodiment of this invention; and

FIG. **7** is a top view of the package shown in FIG. **6** with panel E folded onto panel F and panel D folded onto panels A, B and C.

## DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

Referring to FIG. **1**, the package **10** is formed from a flat, substantially rectangular shaped single blank **11**, ideally made from paperboard. However, it is within the scope of this invention to use any suitable material well known or later developed in the art, such as, for example, paper, plastic, and the like.

Parallel to opposing edges **20** and **30**, there are defined non-conventional and mutually parallel score lines **40**, **50**, and **60**, which delimit generally identically sized, substantially rectangular, panels A, B, C, and D. Score line **40** enables panel B to be folded about score line **40** onto panel A. Similarly, score line **60** enables panel D to be folded about score line **60** onto panel C. Finally, score line **50** enable panels C and D, with panel D already folded onto panel C, to be folded about score line **50** onto panels A and B, with panel B already folded onto panel A.

It should be noted that the scope of this invention is not limited to the order of the above-described sequence of steps for folding the respective panels onto each other. For example, panel B can be folded onto panel A about score line **40**. Then, panel C can be folded onto panel B about score line **50**. Finally, panel D can be folded onto panel C about score line **60**. As stated above, the scope of this invention is not limited to the sequence of the above-described example of folding steps. In fact, every permutation of possible folding sequences regarding panels A, B, C, and D about score lines **40**, **50**, and **60** is considered to be within the scope of this invention.



Panel A includes a plurality of individual tear away panels **22** that are each defined by non-continuous score lines **24**. FIG. **1** illustrates a total of seven tear away panels **22** that are substantially rectangular in shape and disposed approximately in the center of panel A. It should be noted the number of tear away panels **22** illustrated is strictly exemplary in nature and is in no way intended to limit the number of tear away panels **22** that can be included in the package **10**. Furthermore, each tear away panel **22** stands alone and is not connected with another tear away panel.

Furthermore, the shape of each tear away panel **22** being rectangular is merely exemplary and it is within the scope of this invention to use any known shape to define the panels **22**, such as, but not limited to, circular, oval, square, triangular, trapezoidal, and the like. Although in the exemplary preferred embodiment the tear way panels **22** are shown as being positioned relatively in the center of panel A, it is within the scope of this invention to place the tear away panels **22** anywhere on the panel A that is remote from the outer periphery of the assembled package **10** such that the articles P contained in the package cannot be accessed simply by biting through the outer edge of the package. Each tear away panel **22** is abuttingly adjacent a corresponding access aperture **26**.

Although the access apertures **26** are illustrated as being semi-circular in shape, it is within the scope of this invention to provide each access aperture **26** to be of any known shape, such as, for example, rectangular, square, triangular, trapezoidal, and the like. The shape of the access aperture **26** should be chosen so as to define an opening that is easily accessible by, such as, for example only, a finger of a user, a fingernail of a user, a pencil, a pen, a tip of a key, and the like, so that the tear away panel **22** can be removed from the panel A along score lines **24**. Panel A forms the back surface of the assembled package **10** when the panels A, B, C, and D are folded onto each other.

Panel B includes an aperture **42** positioned therein so as to encompass all of the tear away panels **22** when panel B is folded onto panel A about score line **40**, as shown in FIG. **2**. Although the aperture **42** is illustrated as being substantially rectangular, it should be noted that it is within the scope of the invention to have the aperture **42** be any known shape, such as, for example, but not limited to, circular, trapezoidal, oval, triangular, and the like, so long as the tear away panels **22** and access apertures **26** are encompassed by the apertures **42** when the panel B is folded onto panel A about score line **40**. Furthermore, panel B is an intermediate layer when the package **10** is assembled and provides the package **10** with an additional layer that adds depth to a cavity **200** formed in the fully assembled package **10** (FIG. **4**), which restricts children from picking at the contents of the package as the package is thicker and more difficult to bite through.

Returning to FIG. **1**, it can be seen that panel C includes a plurality of punch outs **52** that correspond to the number of tear away panels **22**. Each punch out **52** is aligned with a corresponding tear away panel **22** and is defined by a non-continuous score line **54** that is interrupted by securing nicks **56** that hold the punch out **52** in place. Although the punch outs **52** are illustrated as being oval, it should be noted that it is within the scope of this invention to provide punch outs **52** of any known shape, such as, for example, but not limited to, rectangular, circular, triangular, trapezoidal, square, and the like, so that they may facilitate an article P passing therethrough when forced from the blister as will be explained in further detail below. It should be noted that the panel C is another intermediate layer of the package **10** when fully assembled that also adds depth to the cavity **200** formed in

the fully assembled package **10** (FIG. **4**). Because panel C does not have any openings therein until an article P is passed through one of the punch outs **52**, panels A and B are obscured from view when panel C is folded onto panels A and B about score line **50**, as shown in FIG. **3**.

Moreover, as shown in FIG. **1**, panel D includes a plurality of blister receiving pockets **62** that correspond to the number of tear away panels **22** in panel A and punch outs **52** in panel C. The pockets **62** typically will contain blister packaging BP (FIG. **4**) that is well known in the art and is made from such materials as, for example only, a clear plastic, foil, or the like. It should be noted that blister packaging BP is well known in the art and includes a backing that includes a foil portion fp through which each article P must pass when being removed from the package **10**. As shown in FIG. **3**, the blister packaging BP is adhered onto a back surface of the panel D within an adhering region G. To affix the blister packaging BP to the panel D, an adhesive material, such as, but not limited to, glue, is placed on the adhering region G. Then, a top surface of the blister packaging BP, which is not visible when the package **10** is fully assembled, is attached to the panel D in the adhering region G so that the blisters are received and held by corresponding pockets **62** in the panel D. It should be noted that it is also within the scope of this invention to position the blister packaging BP without the use of an adhesive material in a manner that is well known in the art.

Each pocket **62** is aligned with a corresponding tear away panel **22** and punch out **52** when the package **10** is assembled, as shown in FIG. **4**. Although the pockets **62** are illustrated as being oval, it should be noted that it is within the scope of this invention to provide pockets **62** of any known shape, such as, for example, but not limited to, rectangular, circular, triangular, trapezoidal, square, and the like, so that they may facilitate the article P passing therethrough When forced from the blister packaging BP, as will be explained in further detail below. It should be noted that the panel D is the top layer of the fully assembled multi-layered package **10**, as shown in FIG. **5**.

To assemble the package **10**, a bonding agent (not shown) is placed on a top surface of panel A. Panel B is then folded onto panel A about score line **40** so that the aperture **42** fully encompasses each and every tear away panel **22** and access aperture **26** provided on panel A. The bonding agent (not shown) is placed on a bottom surface of either one of panel B or C. Panel C is then folded onto panel B about score line **50** so that the bottom surfaces of panels B and C are bonded together and the punch outs **52** in panel C are aligned with the tear away panels **22** in panel A. The blister packaging BP is then affixed to panel D as described above. A bonding agent (not shown) is placed on a top surface of either one of panel C or panel D and panel D is then folded onto panel C about score line **60**, to fully assemble the package **10**.

To remove the article P held b the blister packaging BP in a blister pocket **62** of panel D, a user first turns the package **10** over so the tear away panels **22** are visible. Then, by placing a fingertip or fingernail or other such object into the access panel **26** corresponding to the desired article P, the user lifts up and removes the tear away panel **22** by breaking the non-continuous score lines **24** to expose a corresponding punch out **52** on panel C. The user then pushes downward on the blister packaging BP, forcing the article P contained in the pocket **62** from the blister pocket, through the foil portion fp and punch out **52** in panel C. The article P then passes through the opening formed by the removed tear away panel **22** into the hands of the user.

As such, the above-described invention provides a child resistant multilayered package that restricts articles contained within the package from being removed by children while simultaneously providing a package that is simple to manufacture, easy to use by adults, and cost efficient.

An alternate embodiment of the package **110** according to the invention is discussed below with regards to FIGS. **6**–**7**.

The package **110** is substantially similar to the package **10** of the exemplary preferred embodiment described above with regards to FIGS. **1**–**5**. In particular, the package **110** includes panels A, B, C, and D, which are nearly identical to those of package **10**. As such, a detailed discussion of panels A, B, C, and D will be omitted to avoid redundancy. However, it should be noted that panel A is not delimited by edge **20** that opposes edge **30** of panel D. Rather, as shown in FIG. **6**, panel A is delimited by hinge **90** and score line **40**.

As shown in FIG. **6**, the package **110** includes panels E and F that are adjacent to panel A and on an opposite side of hinge **90**, which is located between panel F and panel A. Furthermore, edge **70** of panel E is parallel to and opposite edge **30** of panel D.

Panel E is delimited by edge **70** and score line **80**, which is parallel to the edge **70**. Panel F is delimited by score line **80** and hinge **90**. Panel E is foldable onto panel F about score line **80** to form a cover **100** for the package **110**. The hinge **90** is formed by scoring the blank **11** at hinge folds **90**a and **90**b. As such, the package **110** can take the form of a book when panels A, B, C, and D are folded over each other as explained above in the preferred embodiment. Then, panel E is folded over panel F about score line **80** to form the cover **100**. The cover **100** is then folded over the panels A, B, C, and D, which form the other half of the book shaped multi-layered package **110**, about the hinge **90**.

The article P is removed from the package **110** similar to the exemplary preferred embodiment, with the additional step of opening the package **110** by turning the cover **100** away from the panels A, B, C, and D. It should be noted that the cover **100** may include indicia, such as, for example only, the name of article P manufacturer, the dosage of the article P, when the article P should be taken by the user, and other such information.

As such, the above-described invention provides a child resistant package using panels that fold onto each other about non-continuous score lines provided between neighboring panels. The folded panels provide a package with a cavity having a depth that discourages children from biting through the package and generally obstruct articles contained within the package from being removed by children. Simultaneously, the packaging is simple to manufacture, easy to use by adults, and is cost efficient.

Additionally, many modifications may be made to adapt the teachings of the child resistant package of this invention to particular situations or materials without departing from the scope thereof. Therefore, this invention should not be limited to the particular embodiments disclosed herein, but includes all embodiments within the spirit and scope of the disclosure.

We claim:

**1**. A multi-layered child resistant package, comprising:

blister packaging having at least one blister that retains an article therein;

a single blank sheet having parallel first and second opposing side edges and first, second, and third score lines substantially parallel to said first and second opposing side edges that delimit a back panel, first and second intermediate panels, and a top panel having at least one blister receiving pocket, respectively,

wherein said first intermediate panel is folded onto said back panel about said first score line, said second inter-

mediate panel is folded onto said first intermediate panel about said second score line, and said top panel is folded onto said second intermediate panel about said third score line,

wherein said blister packaging is attached to said top panel and said at least one blister receiving pocket receives said at least one blister of said blister packaging, *and*

a cavity through which said article passes, said cavity is aligned with a corresponding said at least one blister and is defined in at least in said first and second intermediate panels**[**; and

at least one tear away panel located on said back panel remote from an outer periphery of said package, said at least one tear away panel being aligned with a corresponding said at least one blister**]**.

**2**. The child resistant package according to claim **[1]** *21*, wherein said **[**a**]** *at* least one tear away panel is defined by a non-continuous score line.

**3**. The child resistant package according to claim **2**, wherein each said at least one tear away panel further comprises an access aperture abuttingly adjacent a side of said at least one tear away panel not having said non-continuous score line.

**4**. The child resistant package according to claim **[1]** *21*, wherein said first intermediate panel includes an aperture that encompasses said at least one tear away panel and access aperture when said first intermediate panel is folded onto said back panel about said first score line.

**5**. The child resistant package according to claim **[1]** *21*, wherein said second intermediate panel includes at least one punch out aligned with a corresponding said at least one tear away panel and said at least one blister, said at least one punch out defined by a non-continuous score line interrupted by a plurality of securing nicks.

**6**. The child resistant package according to claim **1**, wherein said first side edge is a hinge formed by parallel first and second opposing hinge folds.

**7**. The child resistant package according to claim **6**, further comprising fifth and sixth panels separated by a fourth score line, wherein said sixth panel is adjacent said hinge.

**8**. The child resistant package according to claim **7**, wherein said fifth panel is folded onto said sixth panel about said fourth score line to form a cover for said package.

**9**. A multi-layered child resistant package, comprising:

blister packaging having at least one blister that retains an article therein;

a single blank sheet having parallel first and second opposing side edges and first, second, and third score lines substantially parallel to said first and second opposing side edges that delimit a back panel, first and second intermediate panels, and a top panel having at least one blister receiving pocket, respectively, wherein said first side edge is a hinge formed by parallel first and second opposing hinge folds,

wherein said first intermediate panel is folded onto said back panel about said first score line, said second intermediate panel is folded onto said first intermediate panel about said second score line, and said top panel is folded onto said second intermediate panel about said third score line,

wherein said blister packaging is attached to said top panel and said at least one blister receiving pocket receives said at least one blister of said blister packaging, *and*

a cavity through which said article passes, said cavity is aligned with a corresponding said at least one blister and is defined in at least said first and second intermediate panels**[**; and

at least one tear away panel located on said back panel remote from an outer periphery of said package, said at least one tear away panel being aligned with a corresponding said at least one blister**]**.

**10**. The child resistant package according to claim **[9]** *22*, wherein said **[**a**]** *at* least one tear away panel is defined by a non-continuous score line.

**11**. The child resistant package according to claim **10**, wherein each said at least one tear away panel further comprises an access aperture abuttingly adjacent a side of said at least one tear away panel not having said non-continuous score line.

**12**. The child resistant package according to claim **[9]** *22*, wherein said first intermediate panel includes an aperture that encompasses said at least one tear away panel and access aperture when said first intermediate panel is folded onto said back panel about said first score line.

**13**. The child resistant package according to claim **[9]** *22*, wherein said second intermediate panel includes at least one punch out aligned with a corresponding said at least one tear away panel and said at least one blister, said at least one punch out defined by a non-continuous score line interrupted by a plurality of securing nicks.

**14**. The child resistant package according to claim **9**, further comprising fifth and sixth panels separated by a fourth score line, wherein said sixth panel is adjacent said hinge.

**15**. The child resistant package according to claim **14**, wherein said fifth panel is folded onto said sixth panel about said fourth score line to form a cover for said package.

**16**. A method of assembling a multi-layered child resistant package having blister packaging with at least one blister that retains an article therein, a single blank sheet including parallel first and second opposing side edges and first, second, and third score lines substantially parallel to the first and second opposing side edges that delimit a back panel, first and second intermediate panels, and a top panel having at least one blister receiving pocket, respectively, said method comprising the steps of:

folding the first intermediate panel onto the back panel about the first score line;

folding the second intermediate panel onto the first intermediate panel about the second score line, wherein at least the folded first and second intermediate panels form a cavity through which the article passes;

affixing the blister packaging to the top panel; *and*

folding the top panel onto the second intermediate panel about the third score line**[**;

positioning at least one tear away panel on the back panel remote from an outer periphery of the package; and

aligning the at least one tear away panel with a corresponding blister**]**.

**17**. The method according to claim **16**, wherein the first opposing side edge is a hinge formed by parallel first and second opposing hinge folds and the package further includes fifth and sixth panels separated by a fourth score line, the sixth panel being adjacent the hinge, said method comprising the additional step of:

folding the fifth panel onto the sixth panel about the fourth score line to form a cover for the assembled package.

**18**. The method according to claim **[16]** *23*, further comprising the step of forming an aperture on the first intermediate panel before the step of folding the first intermediate panel, wherein the aperture on the first intermediate panel encompasses the at least one tear away panel on the back panel when the first intermediate panel is folded onto the back panel.

**19**. The method according to claim **[16]** *23*, further comprising the step of forming at least one punch out on the second intermediate panel before the second intermediate panel is folded onto the first intermediate panel, wherein the at least one punch out is aligned with the at least one tear away panel.

**20**. The method according to claim **16**, further comprising the step of forming at least one blister receiving pocket on the top panel to receive the blister therein before the step of folding the first intermediate panel onto the back panel.

*21. The child resistant packaging according to claim 1, further comprising at least one tear away panel located on said back panel remote from an outer periphery of said package, said at least one tear away panel being aligned with a corresponding said at least one blister.*

*22. The child resistant package according to claim 9, further comprising at least one tear away panel located on said back panel remote from an outer periphery of said package, said at least one tear away panel being aligned with a corresponding said at least one blister.*

*23. The method according to claim 16, further comprising the steps of positioning at least one tear away panel on the back panel remote from an outer periphery of the package; and aligning the at least one tear away panel with a corresponding blister.*

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