



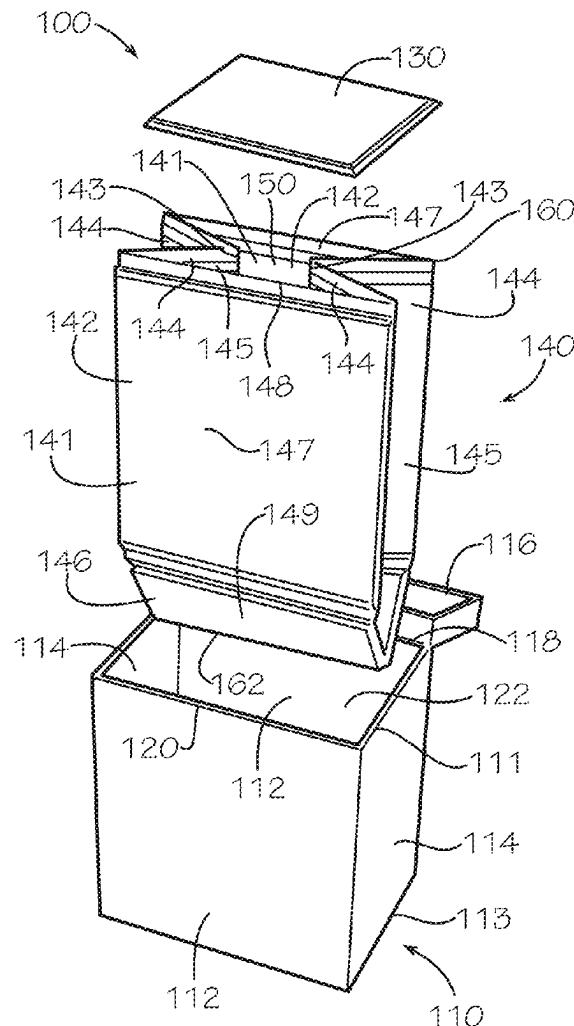
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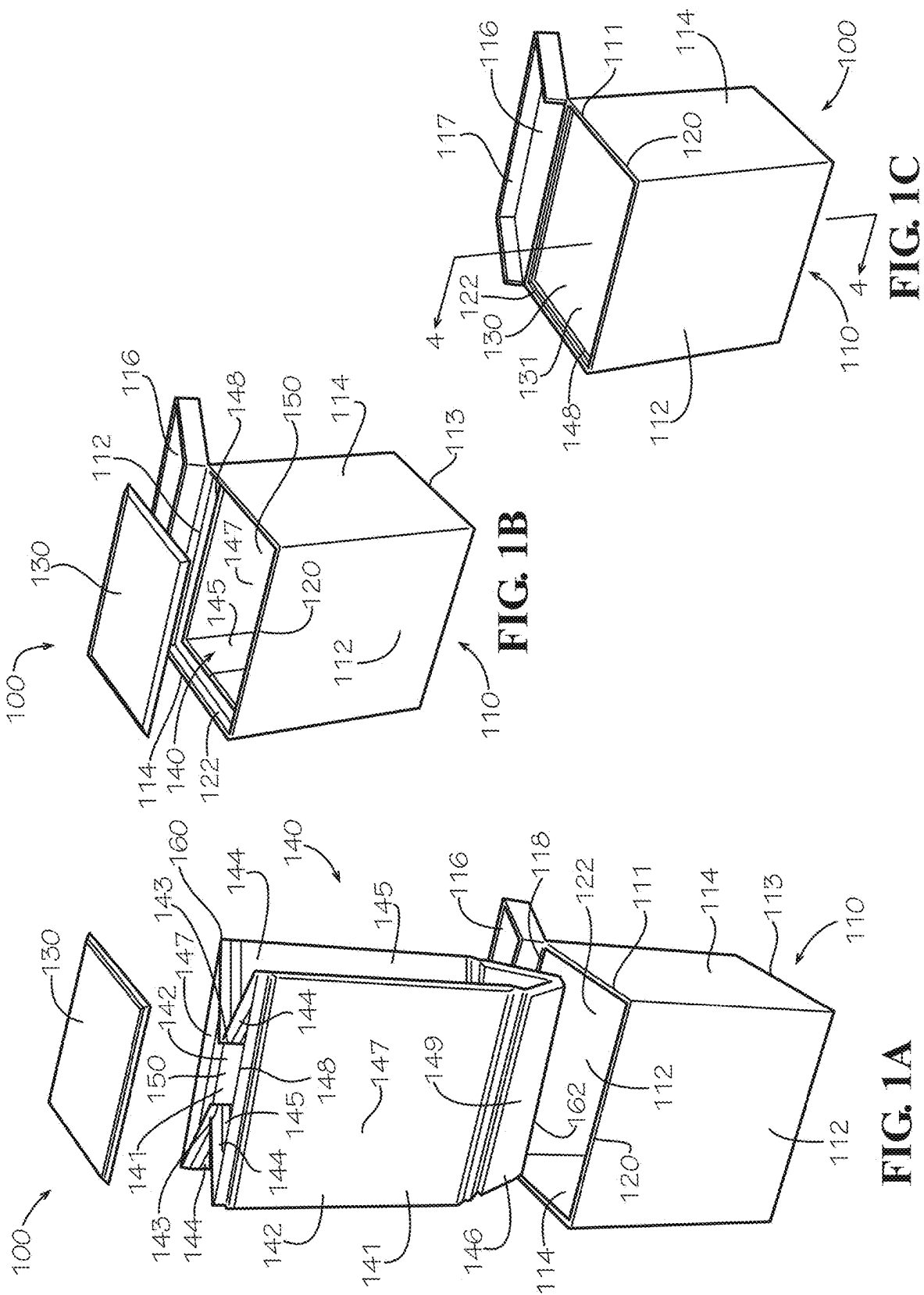
(19) **United States**(12) **Patent Application Publication**
Waltermire et al.(10) **Pub. No.: US 2025/0250095 A1**(43) **Pub. Date: Aug. 7, 2025**(54) **BOX LINER****Publication Classification**(71) Applicant: **Pratt Retail Specialties, LLC**,
Brookhaven, GA (US)(72) Inventors: **Jamie Waltermire**, Peachtree City, GA
(US); **Paul Ott**, Atlanta, GA (US)(21) Appl. No.: **19/190,395**(22) Filed: **Apr. 25, 2025**(51) **Int. Cl.**
B65D 81/38 (2006.01)
B65D 30/20 (2006.01)
B65D 43/16 (2006.01)
(52) **U.S. Cl.**
CPC **B65D 81/3813** (2013.01); **B65D 31/10**
(2013.01); **B65D 43/163** (2013.01); **B65D**
81/386 (2013.01); **B65D 81/3897** (2013.01)(57) **ABSTRACT**

An insulated box assembly can include an insulated liner defining a liner cavity, the liner including a pair of opposing main liner panels, a pair of opposing side liner panels, and a bottom liner panel, the main liner panels, the side liner panels, and the bottom liner panel each being defined by an insulation batt encapsulated in a panel cavity defined between a pair of blank sheets, each panel cavity of each main panel and each side panel being enclosed by a liner border, and the panel cavity of the bottom liner panel being enclosed by a bottom border, wherein the bottom border forms a bottom seam along a perimeter of the bottom liner panel with portions of the liner borders of the main liner panels and side liner panels.

Related U.S. Application Data

(60) Continuation of application No. 17/891,565, filed on Aug. 19, 2022, now Pat. No. 12,286,285, which is a continuation of application No. 17/079,437, filed on Oct. 24, 2020, now Pat. No. 11,485,566, which is a continuation of application No. 16/526,511, filed on Jul. 30, 2019, now Pat. No. 10,882,681, which is a division of application No. 15/482,186, filed on Apr. 7, 2017, now Pat. No. 10,800,595.





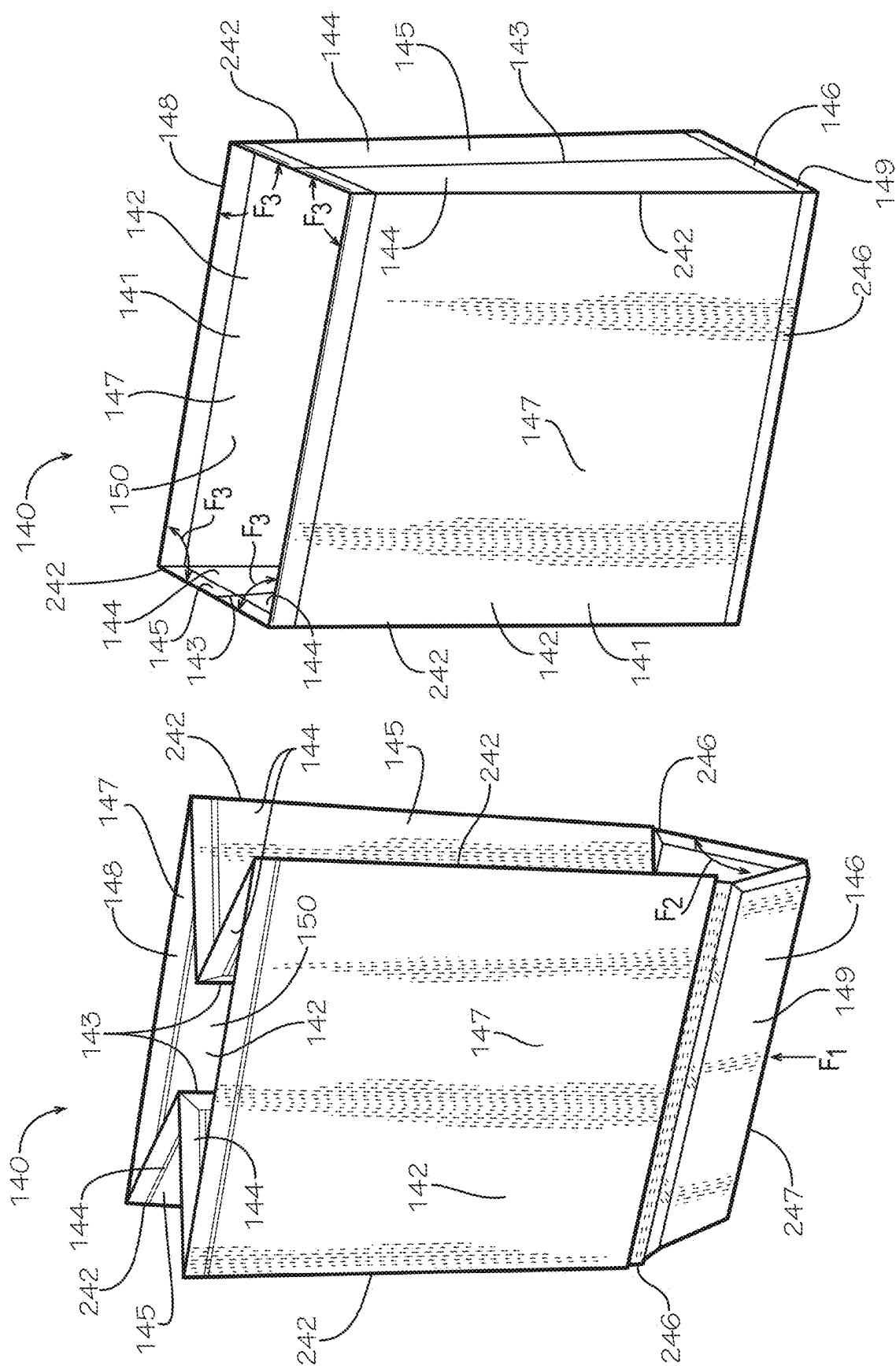
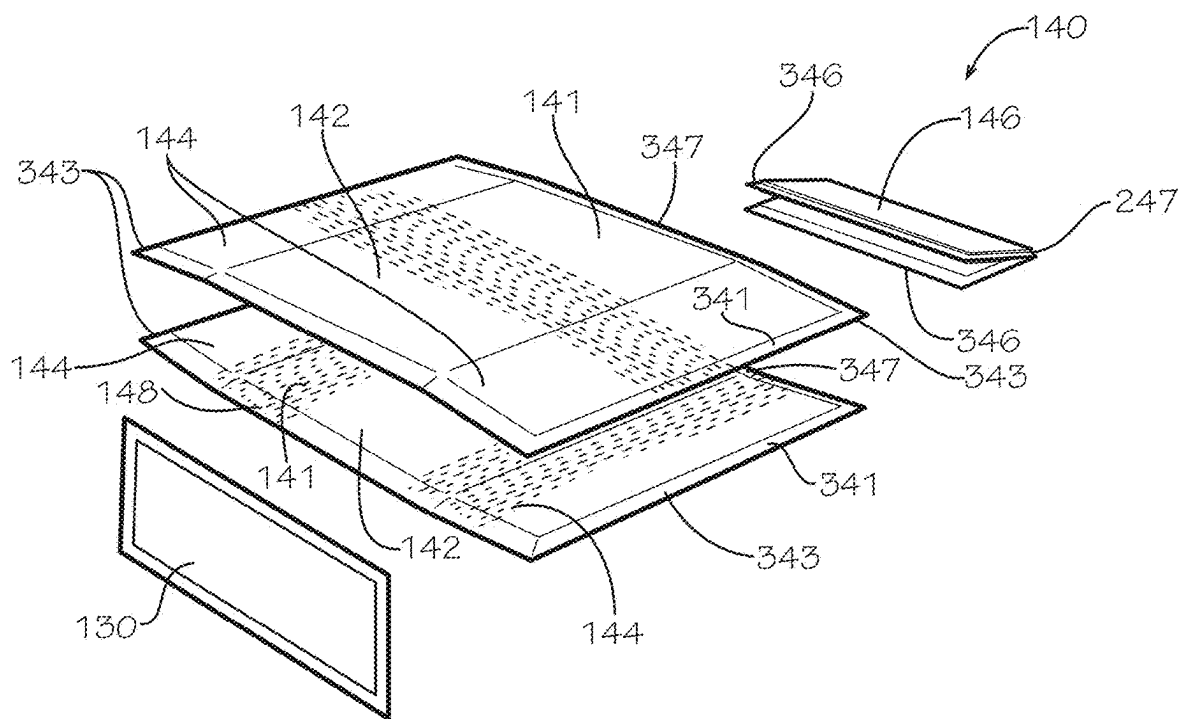
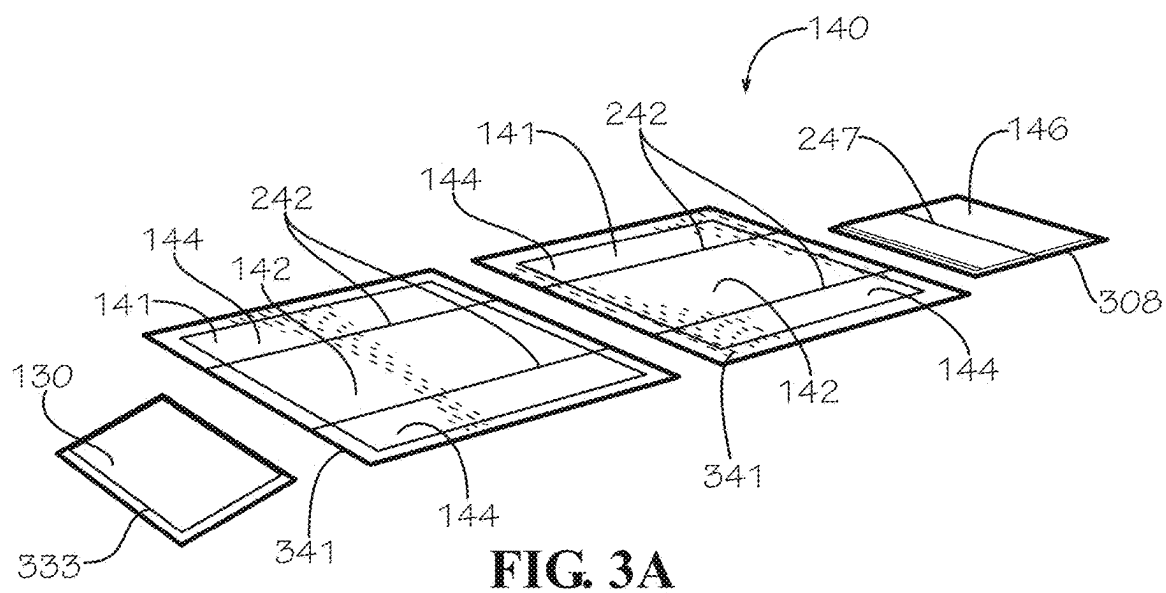


FIG. 2B

FIG. 2A



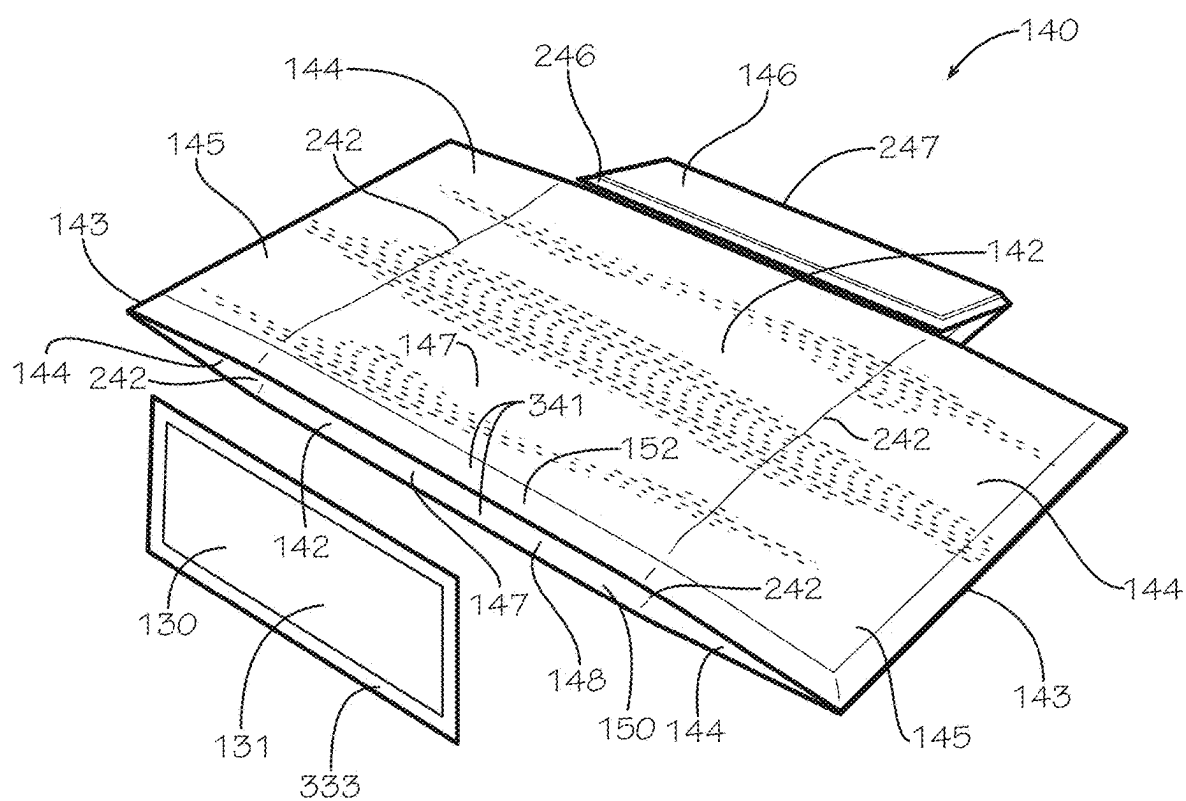
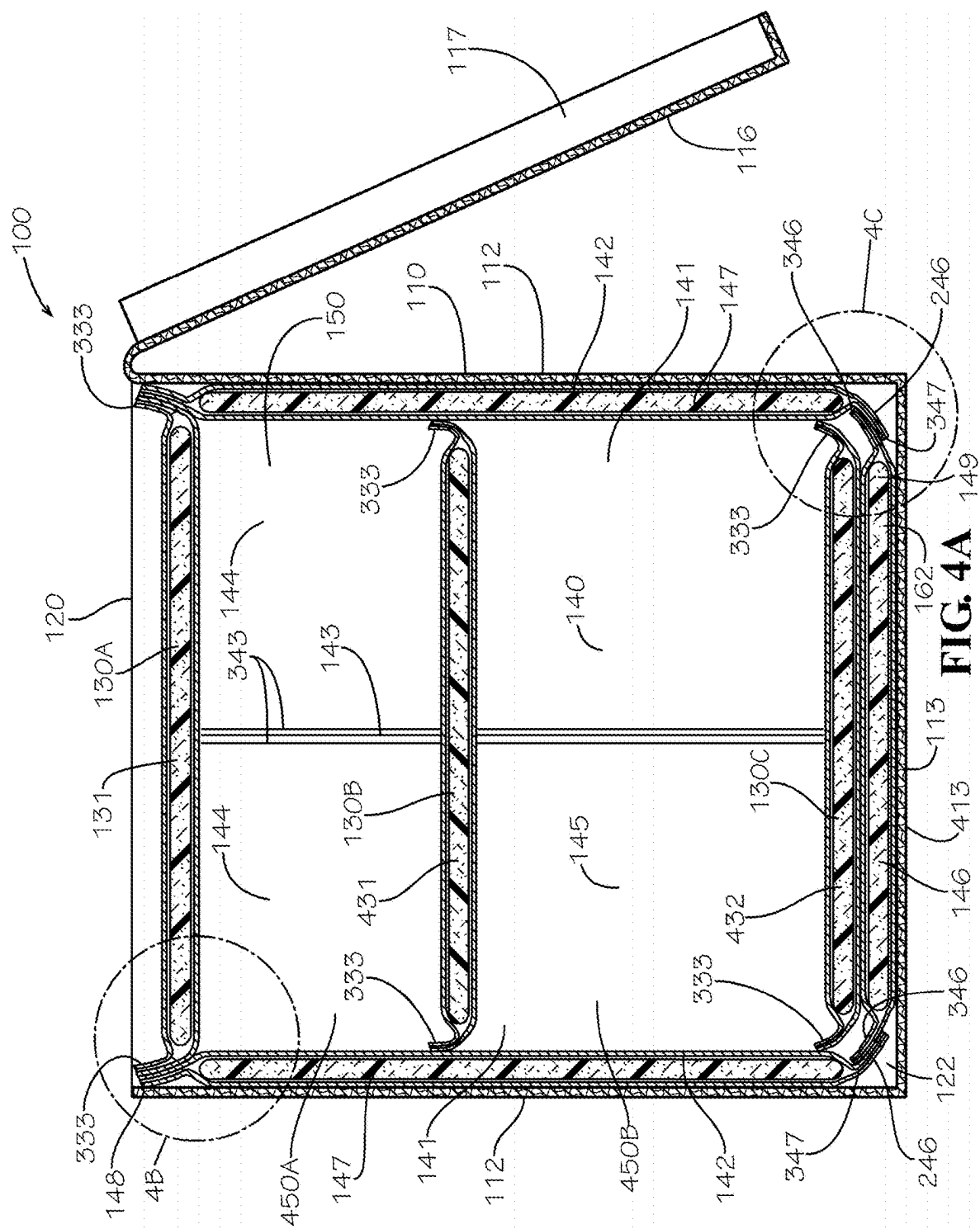


FIG. 3C



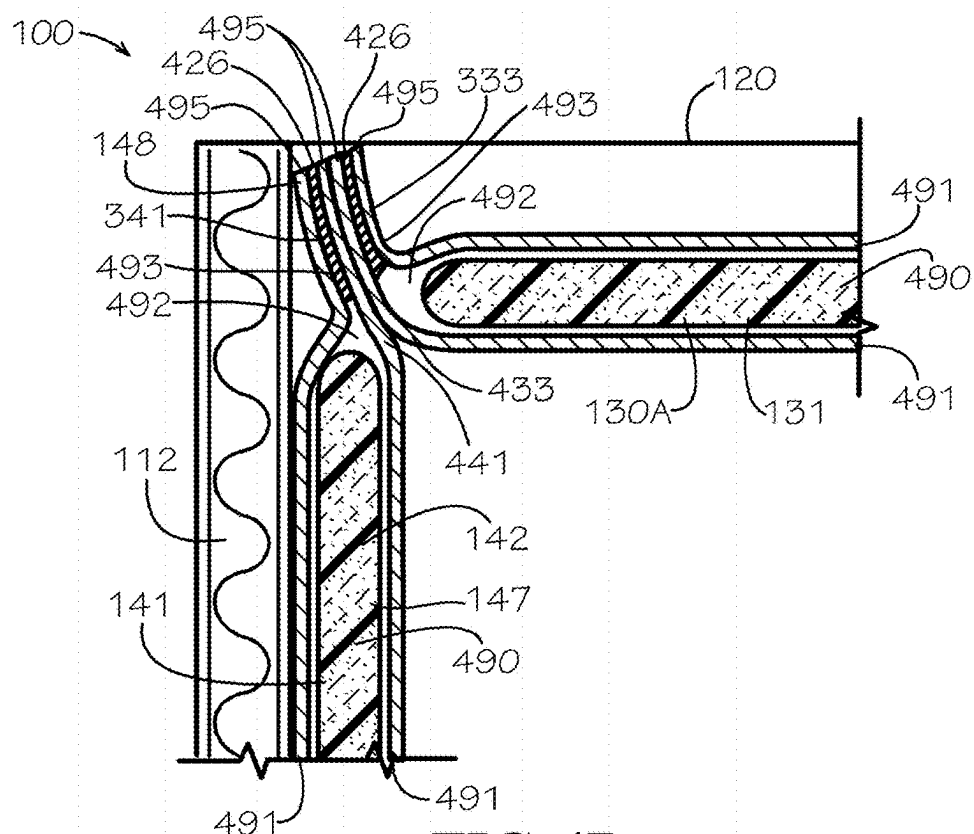


FIG. 4B

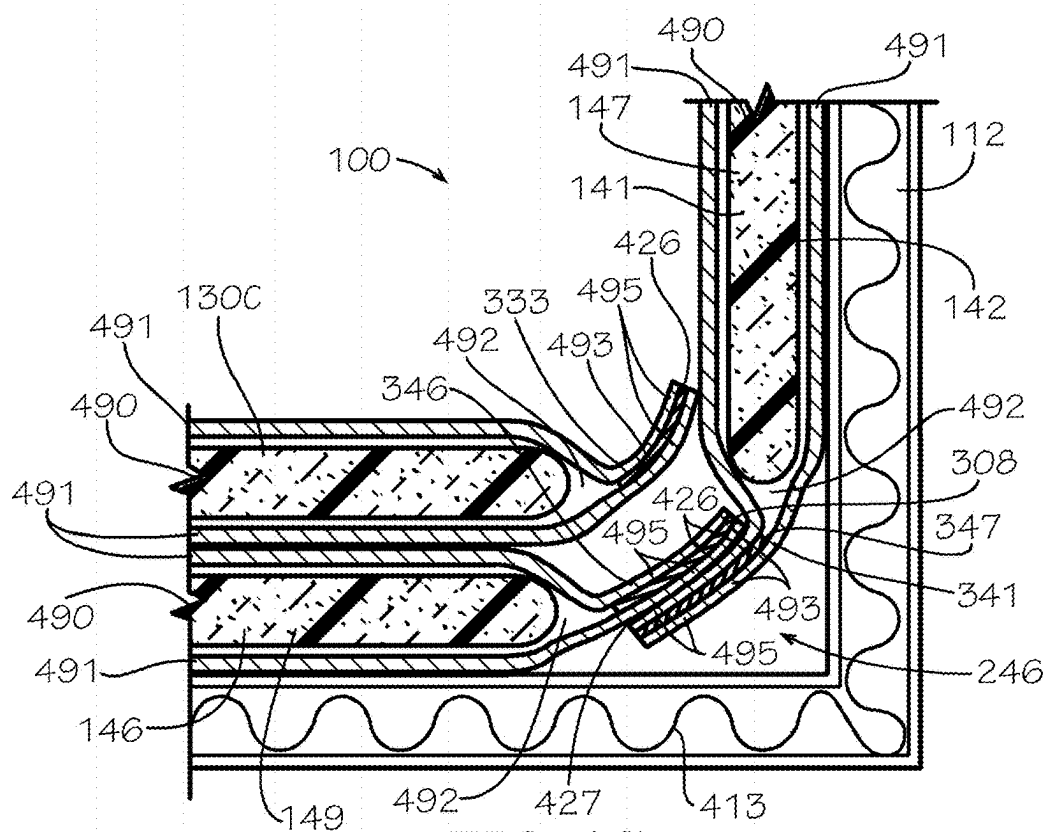
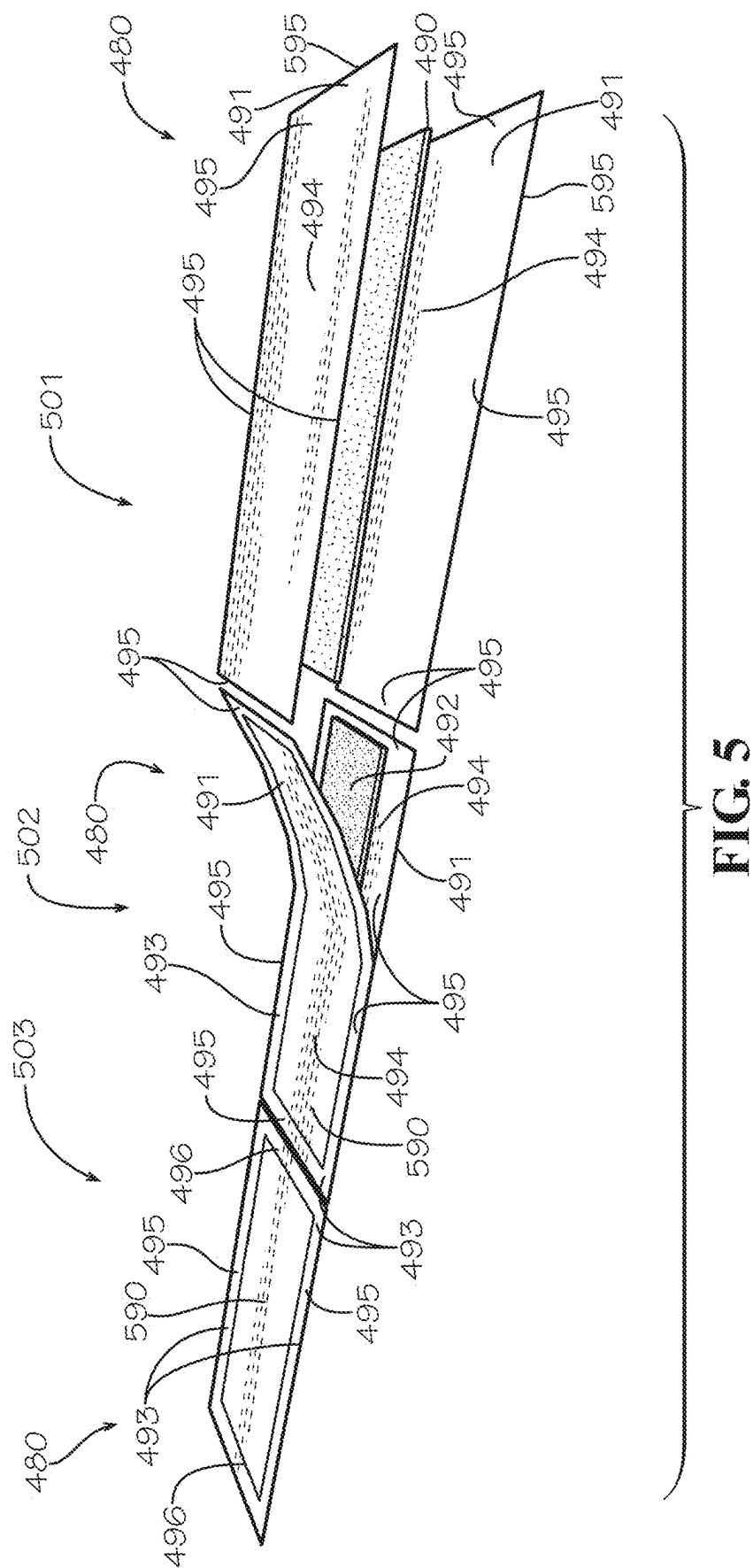


FIG. 4C



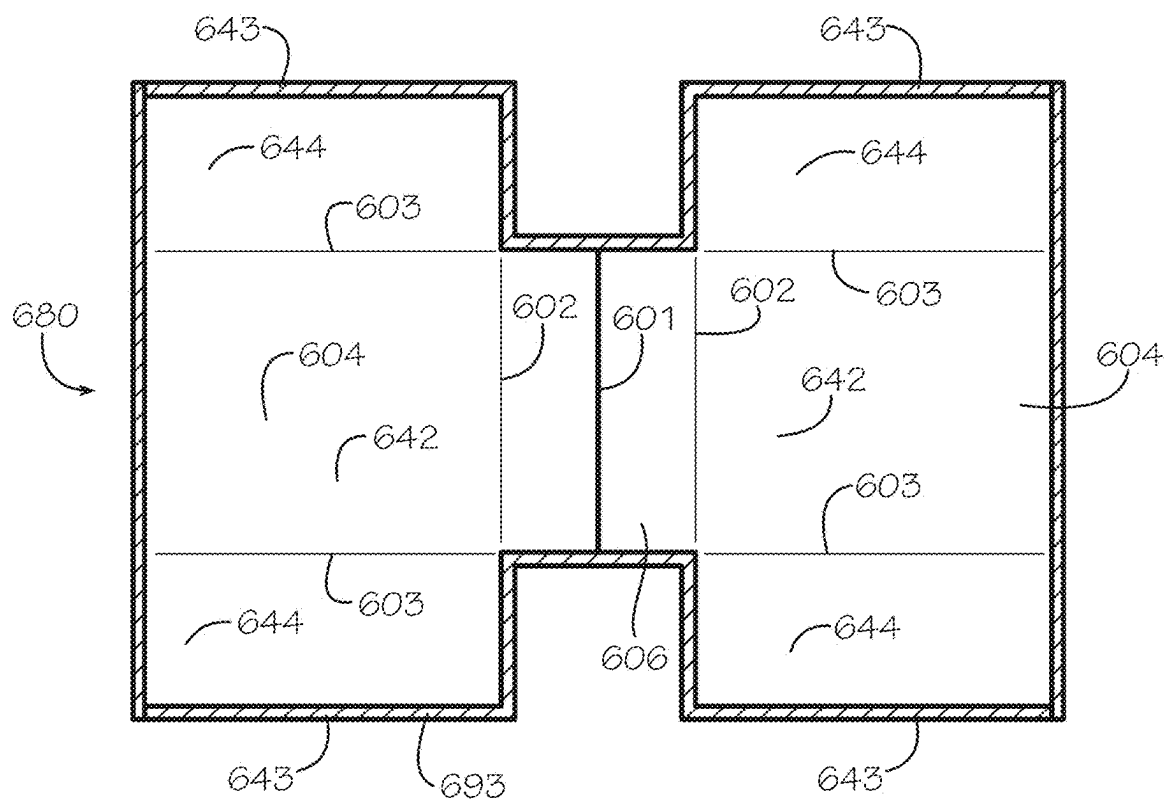


FIG. 6A

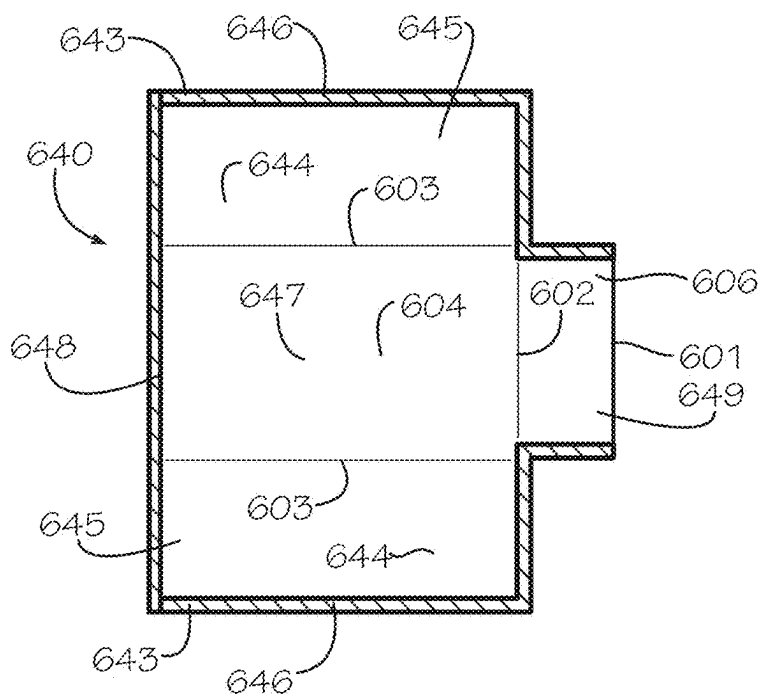
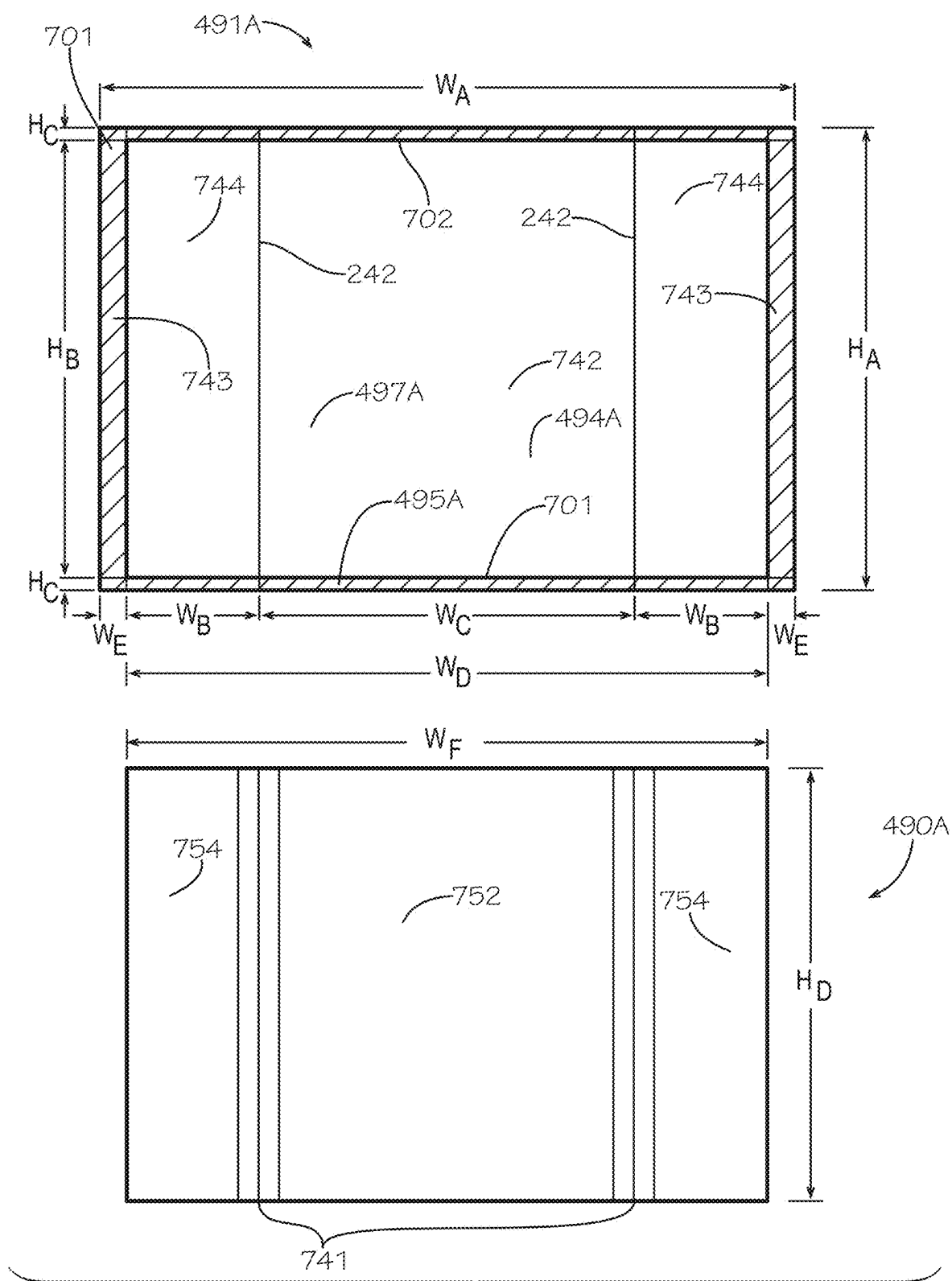


FIG. 6B



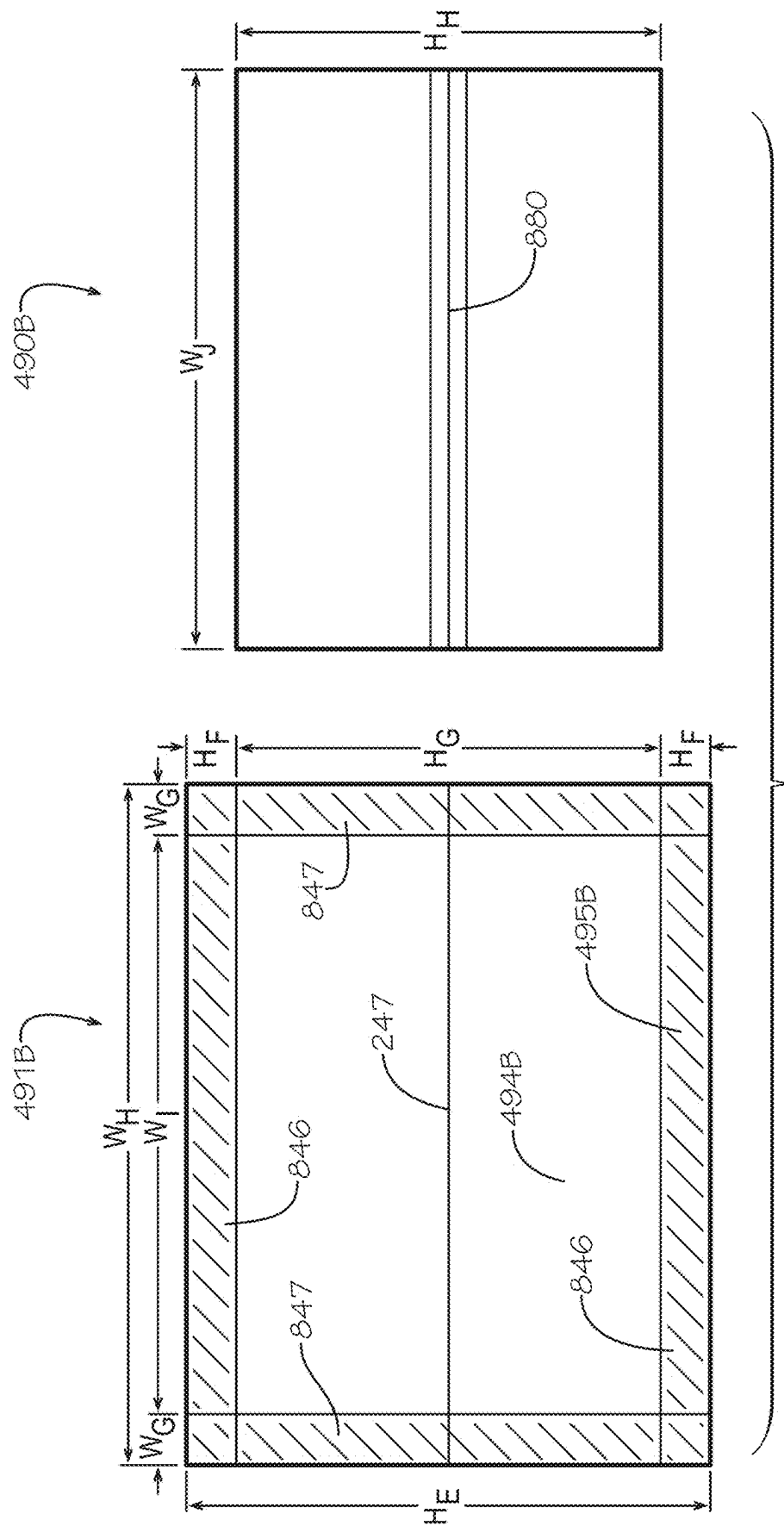
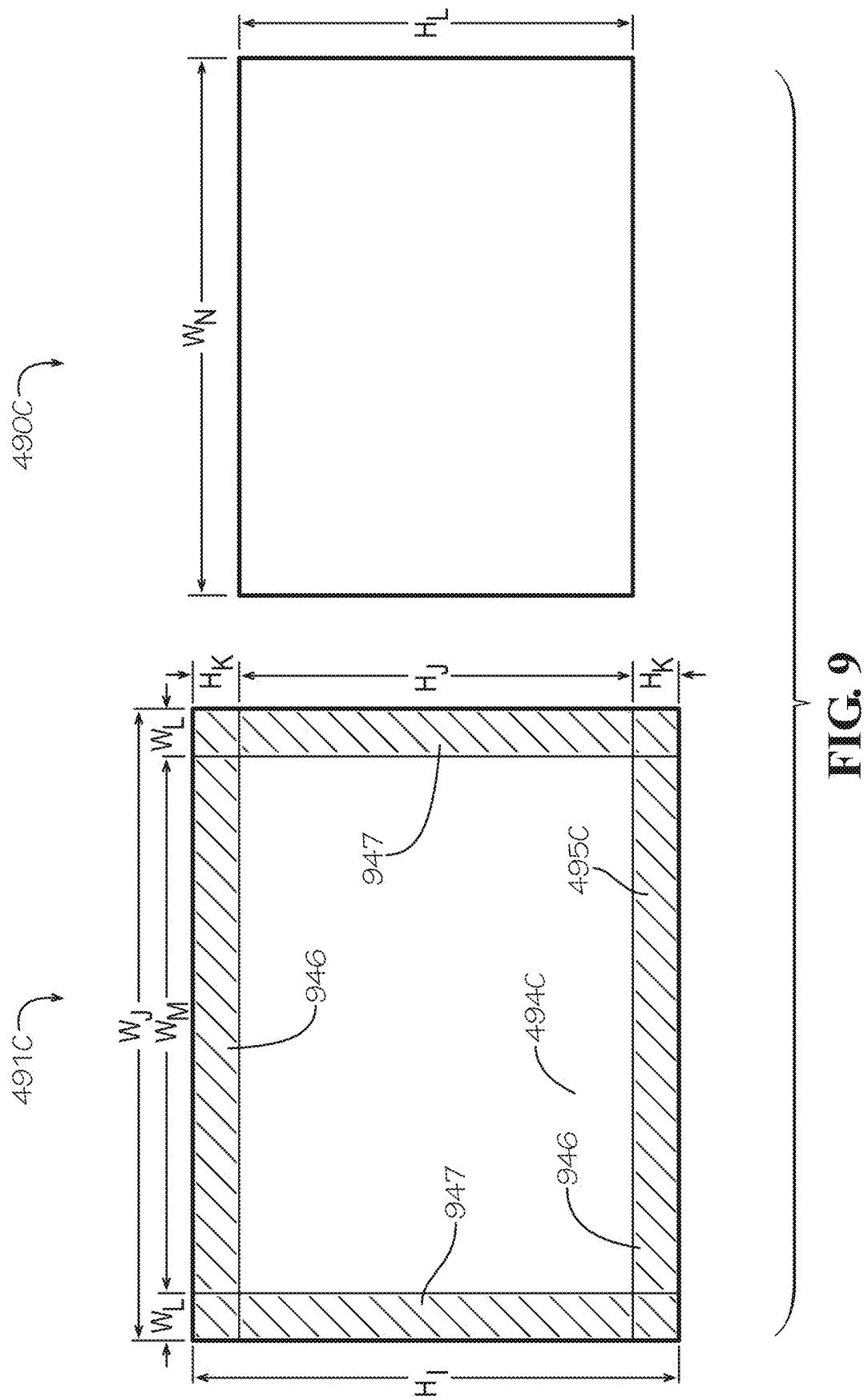


FIG. 8



BOX LINER

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application is a continuation of U.S. application Ser. No. 17/891,565, filed Aug. 19, 2022, which is a continuation of U.S. application Ser. No. 17/079,437, filed Oct. 24, 2020, which issued into U.S. Pat. No. 11,485,566 on Nov. 1, 2022, which is a continuation of U.S. application Ser. No. 16/526,511, filed Jul. 30, 2019, which issued into U.S. Pat. No. 10,882,681 on Jan. 5, 2021, which is a divisional of U.S. application Ser. No. 15/482,186, filed Apr. 7, 2017, which issued into U.S. Pat. No. 10,800,595 on Oct. 13, 2020, each of which is hereby incorporated by reference herein in its respective entirety.

JOINT RESEARCH AGREEMENT

[0002] The subject matter disclosed herein was developed and the claimed invention was made by, or on behalf of, one or more parties to a joint research agreement between MP Global Products LLC of Norfolk, NE and Pratt Retail Specialties, LLC of Conyers, GA, that was in effect on or before the effective filing date of the claimed invention, and the claimed invention was made as a result of activities undertaken within the scope of the joint research agreement.

TECHNICAL FIELD

[0003] This disclosure relates to packaging. More specifically, this disclosure relates to an insulated liner for box.

BACKGROUND

[0004] Packaging perishable or temperature sensitive contents for storage or shipping can pose challenges. The contents can spoil, destabilize, freeze, melt, or evaporate during storage or shipping if the temperature of the contents is not maintained or the packaging is not protected from hot or cold environmental conditions. Contents such as food, pharmaceuticals, electronics, or other temperature sensitive items can be damaged if exposed to temperature extremes. Many insulated packages are bulky and difficult to store prior to use. Many insulated packages cannot be recycled and are often disposed of in landfills.

SUMMARY

[0005] It is to be understood that this summary is not an extensive overview of the disclosure. This summary is exemplary and not restrictive, and it is intended to neither identify key or critical elements of the disclosure nor delineate the scope thereof. The sole purpose of this summary is to explain and exemplify certain concepts of the disclosure as an introduction to the following complete and extensive detailed description.

[0006] Disclosed is an insulated box assembly including an insulated liner defining a liner cavity, the liner including a pair of opposing main liner panels, a pair of opposing side liner panels, and a bottom liner panel, the main liner panels, the side liner panels, and the bottom liner panel each being defined by an insulation batt encapsulated in a panel cavity defined between a pair of blank sheets, each panel cavity of each main panel and each side panel being enclosed by a liner border, and the panel cavity of the bottom liner panel being enclosed by a bottom border, wherein the bottom

border forms a bottom seam along a perimeter of the bottom liner panel with portions of the liner borders of the main liner panels and side liner panels.

[0007] Various implementations described in the present disclosure may include additional systems, methods, features, and advantages, which may not necessarily be expressly disclosed herein but will be apparent to one of ordinary skill in the art upon examination of the following detailed description and accompanying drawings. It is intended that all such systems, methods, features, and advantages be included within the present disclosure and protected by the accompanying claims. The features and advantages of such implementations may be realized and obtained by means of the systems, methods, features particularly pointed out in the appended claims. These and other features will become more fully apparent from the following description and appended claims, or may be learned by the practice of such exemplary implementations as set forth hereinafter.

BRIEF DESCRIPTION OF THE DRAWINGS

[0008] The features and components of the following figures are illustrated to emphasize the general principles of the present disclosure. The drawings are not necessarily drawn to scale. Corresponding features and components throughout the figures may be designated by matching reference characters for the sake of consistency and clarity.

[0009] FIG. 1A is an exploded view of an insulated box assembly comprising a box, an insulated liner, and an insulated panel in accordance with one aspect of the disclosure.

[0010] FIG. 1B is a perspective view of the insulated box assembly of FIG. 1A.

[0011] FIG. 1C is a perspective view of the insulated box assembly of FIG. 1A.

[0012] FIG. 2A is a perspective view of the insulated liner of FIG. 1A in a collapsed insertion configuration.

[0013] FIG. 2B is a perspective view of the insulated liner of FIG. 1A in an expanded configuration.

[0014] FIG. 3A is an exploded view of the insulated liner comprising two blank liner panels and a bottom panel and the insulated panel of FIG. 1A.

[0015] FIG. 3B is an exploded view of the insulated liner and the insulated panel of FIG. 1A in an aligned configuration.

[0016] FIG. 3C is a perspective view of the insulated liner and the insulated panel of FIG. 1A in an assembled configuration.

[0017] FIG. 4A is a cross-sectional view of the insulated box assembly of FIG. 1A taken along line 4-4 of FIG. 1C.

[0018] FIG. 4B is a detail view of the insulated box assembly taken from Detail 4B of FIG. 4A.

[0019] FIG. 4C is a detail view of the insulated box assembly taken from Detail 4C of FIG. 4A.

[0020] FIG. 5 is a perspective view of a method of manufacturing for an insulated panel.

[0021] FIG. 6A is a top view of another aspect of a liner panel.

[0022] FIG. 6B is a top view of another aspect of an insulated liner.

[0023] FIG. 7 is a top view of an aspect of a blank sheet and an aspect of an insulation batt for the liner panel of FIG. 3A.

[0024] FIG. 8 is a top view of another aspect of the blank sheet and another aspect of the insulation batt for the bottom panel of FIG. 3A.

[0025] FIG. 9 is a top view of another aspect of the blank sheet and another aspect of the insulation batt for the insulated panel of FIG. 3A.

DETAILED DESCRIPTION

[0026] The present disclosure can be understood more readily by reference to the following detailed description, examples, drawings, and claims, and the previous and following description. However, before the present devices, systems, and/or methods are disclosed and described, it is to be understood that this disclosure is not limited to the specific devices, systems, and/or methods disclosed unless otherwise specified, and, as such, can, of course, vary. It is also to be understood that the terminology used herein is for the purpose of describing particular aspects only and is not intended to be limiting.

[0027] The following description is provided as an enabling teaching of the present devices, systems, and/or methods in its best, currently known aspect. To this end, those skilled in the relevant art will recognize and appreciate that many changes can be made to the various aspects of the present devices, systems, and/or methods described herein, while still obtaining the beneficial results of the present disclosure. It will also be apparent that some of the desired benefits of the present disclosure can be obtained by selecting some of the features of the present disclosure without utilizing other features. Accordingly, those who work in the art will recognize that many modifications and adaptations to the present disclosure are possible and can even be desirable in certain circumstances and are a part of the present disclosure. Thus, the following description is provided as illustrative of the principles of the present disclosure and not in limitation thereof.

[0028] As used throughout, the singular forms “a,” “an” and “the” include plural referents unless the context clearly dictates otherwise. Thus, for example, reference to “an element” can include two or more such elements unless the context indicates otherwise.

[0029] Ranges can be expressed herein as from “about” one particular value, and/or to “about” another particular value. When such a range is expressed, another aspect includes from the one particular value and/or to the other particular value. Similarly, when values are expressed as approximations, by use of the antecedent “about,” it will be understood that the particular value forms another aspect. It will be further understood that the endpoints of each of the ranges are significant both in relation to the other endpoint, and independently of the other endpoint.

[0030] For purposes of the current disclosure, a material property or dimension measuring about X or substantially X on a particular measurement scale measures within a range between X plus an industry-standard upper tolerance for the specified measurement and X minus an industry-standard lower tolerance for the specified measurement. Because tolerances can vary between different materials, processes and between different models, the tolerance for a particular measurement of a particular component can fall within a range of tolerances.

[0031] As used herein, the terms “optional” or “optionally” mean that the subsequently described event or circum-

stance can or cannot occur, and that the description includes instances where said event or circumstance occurs and instances where it does not.

[0032] The word “or” as used herein means any one member of a particular list and also includes any combination of members of that list. Further, one should note that conditional language, such as, among others, “can,” “could,” “might,” or “may,” unless specifically stated otherwise, or otherwise understood within the context as used, is generally intended to convey that certain aspects include, while other aspects do not include, certain features, elements and/or steps. Thus, such conditional language is not generally intended to imply that features, elements and/or steps are in any way required for one or more particular aspects or that one or more particular aspects necessarily include logic for deciding, with or without user input or prompting, whether these features, elements and/or steps are included or are to be performed in any particular aspect.

[0033] Disclosed are components that can be used to perform the disclosed methods and systems. These and other components are disclosed herein, and it is understood that when combinations, subsets, interactions, groups, etc. of these components are disclosed that while specific reference of each various individual and collective combinations and permutation of these may not be explicitly disclosed, each is specifically contemplated and described herein, for all methods and systems. This applies to all aspects of this application including, but not limited to, steps in disclosed methods. Thus, if there are a variety of additional steps that can be performed it is understood that each of these additional steps can be performed with any specific aspect or combination of aspects of the disclosed methods.

[0034] In one aspect, disclosed is an insulated box assembly and associated methods, systems, devices, and various apparatus. The insulated box assembly can comprise a box, an insulated panel, and an insulated liner. It would be understood by one of skill in the art that the disclosed valve body is described in but a few exemplary aspects among many. No particular terminology or description should be considered limiting on the disclosure or the scope of any claims issuing therefrom.

[0035] FIGS. 1A-C disclose and describe an insulated box assembly **100** in one aspect of the present disclosure. FIG. 1A is an exploded view of an insulated box assembly **100** comprising a box **110**, an insulated liner **140**, and an insulated panel **130**. In the present aspect, the box **110** can be a chute box; however, in other aspects, the box **110** can be any suitable type of box. The box **110** can comprise a pair of opposing main box panels **112**, a pair of opposing side box panels **114**, a box bottom panel **413** (shown in FIG. 4A), and a lid **116**. The box **110** can define a top box end **111** and a bottom box end **113**, and the top box end **111** can be disposed opposite from the bottom box end **113**. The opposing main box panels **112**, the opposing side box panels **114**, and the box bottom panel **413** of the box **110** can define an internal box cavity **122**, and the internal box cavity **122** can define a box opening **120** positioned at the top box end **111** of the box **110**. The lid **116** can be attached to the box **110** at the top box end **111** by a lid hinge **118**, and the lid **116** can be configured to selectively move about and between an open position and a closed position. In the closed position, the lid **116** can be configured to cover the box opening **120** and seal the internal box cavity **122**. In the open position shown in FIGS. 1A-C, the lid **116** can be configured to

uncover the box opening 120, and a user can add or withdraw contents from the internal box cavity 122. The internal box cavity 122 can be configured to receive the insulated liner 140 and the insulated panel 130.

[0036] The insulated liner 140 can be configured to line the internal box cavity 122. In the present aspect, the insulated liner 140 can comprise a liner bottom 149, an opposing pair of main liner panels 147, and an opposing pair of side liner panels 145. The liner bottom 149, the opposing pair of main liner panels 147, and the opposing pair of side liner panels 145 can define a liner cavity 150. The insulated liner 140 can comprise and be assembled from a bottom panel 146 and an opposing pair of blank liner panels 141. The blank liner panels 141 can be attached in an opposing configuration by a pair of side seams 143. Each blank liner panel 141 can define a main subpanel 142 positioned between a pair of side subpanels 144. In the opposing configuration, the blank liner panels 141 are aligned and facing each other such that the main subpanels 142 of the respective blank liner panels 141 can be aligned and each of the side subpanels 144 of a one of the blank liner panels 141 is aligned with a different one of the side subpanels 144 of another of the blank liner panels 141. Each of the main subpanels 142 of the blank liner panels 141 can define a one of the main liner panels 147 of the insulated liner 140. Each of the side seams 143 can attach together a one of the side subpanels 144 from each of the blank liner panels 141, thereby defining a one of the side liner panels 145.

[0037] The bottom panel 146 can be positioned at a bottom liner end 162 of the insulated liner 140. A liner opening 148 of the liner cavity 150 can be defined at a top liner end 160 opposite from the bottom liner end 162. The bottom panel 146 can define the liner bottom 149 of the insulated liner 140. In other aspects, the insulated liner 140 can be a one-piece insulated liner 640, as shown in FIG. 6B, which can comprise a one-piece blank liner panel 680, as shown in FIG. 6A. In such aspects, the liner bottom 149, the opposing pair of main liner panels 147, and the opposing pair of side liner panels 145 can be defined by the one-piece blank liner panel 680.

[0038] As shown in FIG. 1A, the insulated liner 140 can be collapsed into a collapsed insertion configuration in which the side liner panels 145 can be folded inwards towards the liner cavity 150, the main liner panels 147 can collapse inwards towards the liner cavity 150, and the liner bottom 149 of the insulated liner 140 can be in a folded position. In this configuration, the side liner panels 145 do not interfere with the opposing side box panels 114 of the box 110, and the collapsed main liner panels 147 provide a clearance between the insulated liner 140 and the opposing main box panels 112. The clearance can facilitate insertion of the insulated liner 140 into the box 110. In the collapsed insertion position, the insulated liner 140 can be inserted into the internal box cavity 122 through the box opening 120. Inserting the insulated liner 140 fully into the internal box cavity 122 can assist in expanding the insulated liner 140 into an expanded configuration. This effect is further described below with respect to FIG. 2A.

[0039] FIG. 1B is a perspective view of the insulated box assembly 100 of FIG. 1A. As shown, the insulated liner 140 can be configured to fit within the internal box cavity 122 of the box 110. In the expanded configuration, the insulated liner 140 can be sized and shaped complimentary to the internal box cavity 122. The insulated liner 140 can conform

to a shape defined by the internal box cavity 122. The liner opening 148 can be positioned adjacent to the box opening 120. The liner opening 148 can define a substantially rectangular shape complimentary in a size and a shape to the box opening 120. In the present aspect, the main liner panels 147 can be in facing engagement with the main box panels 112, the side liner panels 145 can be in facing engagement with the side box panels 114, and the liner bottom 149 can be in facing engagement with the box bottom panel 413 (shown in FIG. 4A) of the box 110.

[0040] FIG. 1C is a perspective view of the insulated box assembly 100 of FIG. 1A. As shown, the insulated panel 130 can be a top panel 131 configured to cover the liner opening 148. The insulated panel 130 can comprise insulation, and a seal formed between the insulated panel 130 and the insulated liner 140 can increase an insulation value of the liner cavity 150 as shown in FIG. 4A. The lid 116 can be placed in the closed position (not shown) to enclose the insulated liner 140 and the insulated panel 130 within the internal box cavity 122. The lid 116 can comprise a lip 117 which can be shaped complimentary to the box opening 120. The lip 117 can form a box seal by overlapping a portion of the main box panel 112, and the side box panels 114 at the top box end 111 of the box 110.

[0041] FIG. 2A is a perspective view of the insulated liner 140 of FIG. 1A in the collapsed insertion configuration. When the side liner panels 145 are folded inwards towards the liner cavity 150, each pair of side subpanels 144 of the side liner panels 145 can fold relative to each other about the respective side seam 143. Each side subpanel 144 can fold relative to a one of the main subpanels 142 about a side crease line 242. Each of the side subpanels 144 can define an acute angle with an adjacent one of the main subpanels 142.

[0042] In the present aspect, the insulated panel 130, blank liner panel 141, and bottom panel 146 can each demonstrate a positional memory which biases the panel 130, 141, 146 towards a flat, substantially planar configuration. When the panels 130, 141, 146 are subjected to a bending moment or force, the panels 130, 141, 146 can elastically deform; however when the bending moment or force is removed, the panels 130, 141, 146 can return to the substantially planar configuration. When the panels 130, 141, 146 are elastically deformed, internal stresses can produce a force which resists the deflection. As the degree of deflection increases, the internal stresses can increase, and the resisting force can increase as well. When the panels 130, 141, 146 are returned to the substantially planar configuration, the force can be minimized or eliminated. The force can be maximized when the panels 130, 141, 146 are folded in half.

[0043] When the main liner panels 147 are collapsed inwards towards the liner cavity 150, the liner bottom 149 folds about a bottom crease line 247. The bottom crease line 247 can substantially bisect the liner bottom 149. The liner bottom 149 can fold downwards away from the side liner panels 145 exposing openings between the liner bottom 149 and the side liner panels 145. The liner bottom 149 can demonstrate the positional memory which can exert a force F_2 biasing the liner bottom 149 towards the expanded configuration from the collapsed insertion configuration. The force F_2 can resist folding of the liner bottom 149 about the bottom crease line 247. In the present aspect, the force F_2 can be exerted by the bottom panel 146 of the liner bottom 149; however in other aspects in which the liner

bottom 149 is defined by a blank liner panel, the force F_2 can be exerted by the blank liner panel. Once in the expanded configuration, a value of the force F_2 is minimized.

[0044] In the present aspect, the bottom panel 146 can be attached to the main subpanels 142 by a pair of bottoms seams 246. In the present aspect, the bottom seams 246 can be flexible and do not demonstrate positional memory or a biasing force; however, in other aspects, the bottom seams 246 can be crease lines defined by a blank liner panel which can demonstrate positional memory and a biasing force.

[0045] The force F_2 can cooperate with a force F_1 to expand the insulated liner 140 from the collapsed insertion configuration to the expanded configuration. When the insulated liner 140 is inserted into the box 110, interference between the box bottom panel 413 (shown in FIG. 4A) of the box 110 and the liner bottom 149 of the insulated liner 140 can urge the liner bottom 149 to unfold. As shown, the force F_1 can act on the liner bottom 149 proximate the bottom crease line 247. The force F_1 can produce a moment about the bottom seams 246 which can bias the liner bottom 149 to unfold and flatten into a substantially planar configuration. The flattening of the liner bottom 149 can expand the opposing main liner panels 147 away from the liner cavity 150.

[0046] FIG. 2B is a perspective view of the insulated liner 140 of FIG. 1A in the expanded configuration. In the expanded configuration, a one of the main liner panels 147 can be parallel to another of the main liner panels 147, and a one of the side liner panels 145 can be parallel to another of the side liner panels 145. The liner bottom 149 can be substantially perpendicular to each of the main liner panels 147 and each of the side liner panels 145. The side liner panels 145, and the liner bottom 149 can be unfolded and substantially planar. The liner bottom 149 can be in non-sealing, connectionless contact with each of the side liner panels 145. The main liner panels 147 can be expanded away from the liner cavity 150.

[0047] In the present aspect, the blank liner panels 141 can also demonstrate the positional memory and exert a force F_3 biasing the side subpanels 144 to rotate about the side crease lines 242 away from the main subpanels 142 and towards the expanded configuration. In the expanded configuration, each of the side subpanels 144 can define a substantially right angle with the adjacent one of the main subpanels 142. If the insulated liner 140 is not restrained by the box 110, the side subpanels 144 can be biased to further unfold away from the main subpanels 142 to a collapsed storage position shown in FIG. 3C. In the present aspect, the side seams 143 can be flexible and do not demonstrate positional memory or a biasing force; however, in other aspects, the side seams 143 can be crease lines which can demonstrate positional memory and a biasing force.

[0048] The forces F_1, F_2, F_3 can cooperate to produce a self-expanding effect biasing the insulated liner 140 from the collapsed insertion configuration to the expanded configuration. The insulated liner 140 can be configured to self-expand from the collapsed insertion configuration to the expanded configuration when the insulated liner 140 is inserted or dropped into the internal box cavity 122 of the box 110. The self-expanding effect can be desirable in order to reduce or eliminate manual manipulation of the insulated liner 140 when inserting the insulated liner 140 into the box 110, such as in a manufacturing operation. The self-expanding effect can reduce the time required to assemble each

insulated box assembly 100 or can facilitate automated assembly of the insulated box assemblies 100 such as by robotic or mechanized equipment.

[0049] FIGS. 3A-C show a perspective view of the assembly of the insulated liner 140. FIG. 3A is an exploded view of the insulated liner 140 comprising two blank liner panels 141 and a bottom panel 146 and the insulated panel 130 of FIG. 1A. In the present aspect, panels 130, 141, 146 can each define a border which can each be a two-ply seam. The blank liner panels 141 can each define a liner border 341 extending around a perimeter of the respective blank liner panel 141. The bottom panel 146 can define a bottom border 308 extending around a perimeter of the bottom panel 146. The insulated panel 130 can define a panel border 333 extending around a perimeter of the insulated panel 130. The liner border 341 can extend from the liner opening 148 to the bottom panel 146.

[0050] FIG. 3B is an exploded view of the insulated liner 140 and the insulated panel 130 of FIG. 1A in an aligned configuration. The two blank liner panels 141 are shown aligned in an opposing configuration, and the bottom panel 146 is folded about the bottom crease line 247 and aligned with each of the main subpanels 142 of the pair of blank liner panels 141. At opposing ends of each blank liner panel 141, a portion of each liner border 341 adjacent to a one of the side subpanels 144 can define a side border portion 343. The side border portions 343 of a one of the blank liner panels 141 can be aligned and adjacent to the side border portions 343 of a second of the blank liner panels 141.

[0051] Similarly, at opposing ends of the bottom panel 146 distal from the bottom crease line 247, the bottom border 308 can define a pair of first bottom border portions 346. A portion of each liner border 341 adjacent to the main subpanel 142 and distal from the liner opening 148 can define a second bottom border portion 347. Each of the first bottom border portions 346 of the bottom panel 146 can be aligned with a different one of the second bottom border portions of the pair of blank liner panels 141. In the position shown, the panels 141, 146 are prepared to be attached to form the seams 143, 246. The aligned side border portions 343 of the opposing blank liner panels 141 can be attached in facing engagement to form the side seams 143. Each of the side seams 143 can be formed as a plain seam; however in other aspects, each of the side seams 143 can be a lap seam or any other type of seam. Each of the bottom seams 246 can be formed by attaching a one of the first bottom border portions 346 to a one of the second bottom border portions 347 in facing engagement. Each of the bottom seams 246 can be formed as a lap seam; however in other aspects, each of the bottom seams 246 can be a plain seam or any other type of seam. In other aspects, each of the bottom seams 246 can be formed by attaching a one of the first bottom border portions 346 directly to a one of the main subpanels 142 rather than to a portion of the liner border 341.

[0052] FIG. 3C is a perspective view of the assembled insulated liner 140 and the insulated panel 130 of FIG. 1A in an assembled configuration. In the present aspect, the bottoms seams 246 and the side seams 143 can be flexible and function as living hinges. Each of the side seams 143 can extend from the liner opening 148 to the bottom border portion 347. The border portions 343, 346, 347 can be

attached in facing engagement using a glue, adhesive, tape, cement, or any other method of attachment such as stitching or stapling.

[0053] In the embodiment shown in FIGS. 3C, the insulated panel 130 can be the top panel 131. In the present aspect, the top panel 131 can be separate and disconnected from the insulated liner 140. In other aspects, the top panel 131 can be attached to the insulated liner 140 by a top seam (not shown) formed by attaching a portion of the panel border 333 to a portion of the liner border 341 proximate the liner opening 148. The top seam (not shown) can also function as a living hinge allowing the top panel 131 to rotate about the top seam relative to the insulated liner 140.

[0054] FIG. 3C depicts the insulated liner 140 in the collapsed storage configuration. In the collapsed storage configuration, the side liner panels 145 extend outwards and away from the liner cavity 150, and the main liner panels 147 are collapsed together in facing engagement. Each of the side subpanels 144 can define an obtuse angle with an adjacent one of the main subpanels 142. In this configuration, the force F_3 exerted about the side crease lines 242 by the positional memory of the blank liner panels 141 is minimized. Conversely, when the insulated liner 140 is in the collapsed insertion configuration shown in FIGS. 1A and 2A, the force F_3 is maximized as each of the blank liner panels 141 can be nearly folded in half about each of the side crease lines 242. The collapsed storage configuration can be used for stacking, storing, or packaging the insulated liners 140 in bulk.

[0055] FIG. 4A is a cross-sectional view of the insulated box assembly 100 of FIG. 1A viewed from line 4-4 of FIG. 1C. In the aspect shown, the insulated box assembly 100 can optionally comprise three insulated panels 130A,B,C. In other aspects, the insulated box assembly 100 can comprise greater or fewer than three insulated panels 130. In the present aspects, the insulated panels 130B and 130C can be sized smaller than the insulated panel 130A in order to facilitate insertion into the liner cavity 150. In other aspects, the insulated panels 130A,B,C can all be sized and shaped similarly. The insulated panel 130A can be the top panel 131 positioned over the liner opening 148.

[0056] The insulated panel 130B can be a divider panel 431 which can partition the liner cavity 150 into a first insulated compartment 450A and a second insulated compartment 450B. This configuration can be desirable in order to maintain the first insulated compartment 450A and the second insulated compartment 450B at separate temperatures. In other aspects, the insulated box assembly 100 can comprise a plurality of divider panels 431 which can divide the liner cavity 150 into more than two insulated compartments 450. In the present aspect, the divider panel 431 can be in a horizontal orientation configured to partition the liner cavity 150 top-to-bottom. In other aspects, the divider panel 431 can be in a vertical orientation configured to partition the liner cavity 150 side-to-side, front-to-back, or diagonally. In some aspects, the insulated box assembly 100 can comprise a plurality of divider panels 431 in both horizontal orientations and vertical orientations. In the present aspect, the panel border 333 of the divider panel 431 can form a seal with the main liner panels 147 and the side liner panels 145 of the insulated liner 140. In some aspects, the divider panel 431 can rest upon contents of the second insulated compartment 450B.

[0057] Insulated panel 130C can be a floor panel 432 positioned on top of the bottom panel 146. In some embodiments, the bottom panel 146 may not comprise insulation (not shown), and the floor panel 432 can be placed atop the bottom panel 146 of the liner bottom 149 to insulate the bottom liner end 162. Such a configuration can be desirable in order to simplify manufacturing or reduce manufacturing steps. In the aspect shown, the bottom panel 146 comprises insulation, and the floor panel 432 can be positioned on top of the bottom panel 146 to provide increased insulation to the bottom liner end 162. This configuration can be desirable when the contents of the liner cavity 150 are heavy and can compress the insulation at the bottom liner end 162, thereby possibly rendering the insulation less effective. This configuration can also be desirable to provide increased insulation against conduction of heat through the bottom liner end 162 of the insulated liner 140 when the insulated box assembly 100 is resting upon a hot or cold environmental surface. As shown, each of the panels 130,141,146 can each be insulated.

[0058] FIG. 4B is a detail view of the insulated box assembly 100 taken from detail 4B of FIG. 4A. As shown in FIGS. 4B and 4C and described in further detail with regard to FIG. 5, the panels 130,141,146 can each comprise an insulation batt 490 encapsulated between a pair of blank sheets 491. The insulation batt 490 can be positioned in a panel cavity 492 defined between the blank sheets 491. The panel cavity 492 can be enclosed by a border 493, which can be the panel border 333, the liner border 341, or the bottom border 308. The border 493 can be formed by attaching together in facing engagement a perimeter portion 495 of each of the blank sheets 491. In the present aspect, the perimeter portions 495 of the blank sheets 491 can be attached together by a first adhesive 426 which can be a glue, cohesive, cement, epoxy, or tape strip. In other aspects, the blank sheets 491 can be attached by another suitable method such as stitching or stapling.

[0059] FIG. 4B shows the construction of the top panel 131 and the blank liner panel 141. The top panel 131 can taper towards the panel border 333 which can define a beveled panel edge 433. Similarly, the blank liner panel 141 can taper towards the liner border 341 which can define a beveled liner edge 441 proximate the liner opening 148. When the top panel 131 is positioned to cover the liner opening 148, the panel border 333 and the beveled panel edge 433 can cooperate with the liner border 341 and the beveled liner edge 441 to form a seal between the top panel 131 and the insulated liner 140. The seal can improve an insulation value of the liner cavity 150.

[0060] FIG. 4C is a detail view of the insulated box assembly 100 taken from detail 4C of FIG. 4A. FIG. 4C shows a one of the bottom seams 246 formed between the bottom panel 146 and the blank liner panel 141. In the present aspect, each of the bottom seams 246 can be formed by attaching a one of the first bottom border portions 346 of the bottom panel 146 to a one of the second bottom border portions 347 of the blank liner panels 141, as described relative to FIG. 3C, which can define a four-ply seam comprised of four overlapping perimeter portions 495. Each of the side seams 143 can be a similarly constructed four-ply seam. The first bottom border portion 346 can be attached to the second bottom border portion 347 in facing engagement with a second adhesive 427. The second adhesive 427 can be the same as the first adhesive 426, or in other aspects, the

second adhesive 427 can be a different type of adhesive such as a glue, cement, epoxy, or tape strip. As shown, the panel border 333 of insulated panel 130C can cooperate with the insulated liner 140 to form a seal within the liner cavity 150.

[0061] FIG. 5 is a perspective view of a method of manufacturing for an insulated panel 480. The insulated panel 480 can be representative of the insulated panels 130, the blank liner panels 141, the bottom panel 146, or the blank liner panel 680 (shown in FIG. 6).

[0062] In a step 501, an insulation batt 490 can be positioned between a pair of blank sheets 491. The blank sheets 491 can be sized and shaped complimentary to each other; however in some aspects, the blank sheets 491 can differ in size and shape. Each sheet can define an outer edge 595 and a perimeter portion 495 proximate the outer edge 595. The perimeter portions 495 can extend around the outer edge 595 of each of the respective blank sheets 491. The insulation batt 490, blank sheets 491, and the insulated panel 480 can each be substantially flat and planar prior to assembly.

[0063] The blank sheets 491 can be sized to overhang the insulation batt 490 on all sides with the perimeter portions 495 extending beyond the insulation batt 490. The perimeter portions 495 can each encompass an interior portion 494 of a different one of the blank sheets 491. The interior portions 494 can be sized and shaped complimentary to the insulation batt 490.

[0064] Surfaces of the blank sheets 491 facing the insulation batt 490 can be treated with an adhesive, such as the first adhesive 426. In the present aspect, only the perimeter portions 495 of the blank sheets 491 can be selectively treated with the first adhesive. In some aspects, the first adhesive 426 can be a cohesive which is configured to selectively adhere only to other cohesive treated areas. In some aspects, the insulation batt 490 can also be adhered to the interior portions 494 of the blank sheets 491.

[0065] In a step 502, the blank sheets 491 can be aligned and positioned in facing engagement wherein the perimeter portions 495 can be attached by the first adhesive 426 (not shown). The insulation batt 490 can be aligned between the interior portions 494. Attaching the perimeter portions 495 can form the border 493 of the insulated panel 480. The border 493 can be a two-ply seam formed by two overlapping perimeter portions 495. The border 493 can seal and enclose the insulation batt 490 within the panel cavity 492, defined between the interior portions 494 of the blank sheets 491. Portions of the insulated panel 480 containing the insulation batt 490 can define insulated portions 590. In some aspects, the insulation batt 490 can be aligned off-center from the blank sheets 491 wherein the border 493 can extend outwards from the insulated portions 590 further in some areas than others.

[0066] In a step 503, the perimeter portions 495 can be fully attached, thereby forming the completed border 493. A taper from the insulated portion 590 to the border 493 can define a beveled edge 496 which can be similar to the beveled panel edge 433 of the insulated panel 130 and the beveled liner edge 441 of the blank liner panel 141. The border 493 can extend outwards from the insulated portion 590.

[0067] In other aspects, the insulated panel 480 may not comprise the border 493 fully encompassing the insulated panel 480. In some aspects, some portions of the perimeter may expose an unfinished edge in which the insulation batt 490 is exposed. In some aspects, the insulated panel 480 may

not define the border 493 on any portion of the perimeter of the insulated panel 480, and the entire perimeter can define an unfinished edge. In such aspects, the insulated panel 480 can comprise pre-laminated paper and each of the blank sheets 491 can be attached in facing contact with the insulation batt 490 with, for example and without limitation, an adhesive. In some aspects in which the insulated panel 480 defines the border 493, the insulation batt 490 can also be attached in facing contact with one or both of the blank sheets 491. In some aspects, the pre-laminated paper can be provided in a roll, and the insulated panels 480 can be cut to size from the roll.

[0068] In different aspects, the insulation batt 490 can define different thickness from less than $\frac{1}{16}$ " to over 2"; however, this range should not be viewed as limiting. In various aspects, the different panels 130, 141, 146 can each comprise insulation batts 490 of either different thicknesses or the same thickness. For example and without limitation, the bottom panel 146 can comprise an insulation batt 490 defining a thickness greater than that of an insulation batt 490 comprised by the blank liner panel 141. In other aspects, each insulation batt 490 can vary in thickness and define contours between areas of greater thickness and areas of lesser thickness.

[0069] In some aspects, the thickness defined by the insulation batt 490 can affect a strength of the force exerted by the positional memory, such as forces F_2 and F_3 , and increasing the thickness of the insulation batt 490 can increase the force exerted by the positional memory. Conversely, decreasing the thickness of the insulation batt 490 can decrease the force exerted by the positional memory of the insulation batt 490. One method of reducing the thickness of the insulation batt 490 can be to define a groove 741, 880 into the insulation batt 490 as shown in FIG. 7 and FIG. 8. In the present aspect, each groove can be a V-shaped groove defined into the insulation batt 490 to facilitate folding of the insulation batt 490 about the groove. In other aspects, the grooves can define a different shape, such as semicircular. In some aspects, the groove can be aligned with a crease line of the panel 130, 141, 146, such as crease lines 242, 247, in order to allow the panel 130, 141, 146 to bend more easily about the respective crease lines 242, 247. Grooves can be desirable, for instance, for insulation batts 490 defining large thickness values which can be difficult to bend. Cutting grooves can also be desirable to concurrently optimize both the manufacturing process and the assembly process in which it can be desirable to use a single section of insulation batt 490 that does not exhibit positional memory at specific locations.

[0070] Additionally, a density defined by each of the insulation batts 490 can be varied in different aspects or between different insulation batts 490 comprised by a single insulated liner 140. In some aspects, increasing the density of the insulation batt 490 can increase an insulation value of the insulation batt 490. Increasing the density of the insulation batt 490 can also increase resistance to compression of the insulation batt 490. Compression of the insulation batt 490 can be undesirable as compression can degrade the insulation value of the insulation batt 490.

[0071] In some aspects, a plurality of insulation batts 490 can be encapsulated between the pair of blank sheets 491. In these aspects, the plurality of insulation batts 490 can overlap one another or alternatively, can be positioned separate from one another. Separated insulation batts 490

can be encapsulated in separate, isolated panel cavities 492 divided by a portion of the border 493 extending across the insulated panel 480 (not shown). Separately encapsulating the plurality of insulation batts 490 into a single insulated panel 480 can be an alternative to attaching together separate insulated panels 480 with seams or other attachment methods. In some aspects, the insulated panels 480 can define shapes other than rectangular. The insulation batt 490 and the blank sheets 491 can be cut or shaped, such as by die cutting, in order to define different shapes for the insulated panels 480.

[0072] FIG. 6A is a top view of another aspect of the blank liner panel 680. The blank liner panel 680 can be a one-piece blank liner panel 680 configured to form the one-piece insulated liner 640 of FIG. 6B without additional panels 130, 146, 141, 480. The blank liner panel 680 can be manufactured through the method shown in FIG. 5, and the blank liner panel 680 can be constructed similar to the insulated panel 480. In the present aspect, the blank liner panel 680 can comprise a single, continuous insulation batt 490; however, in other aspects, the blank liner panel 680 can comprise a plurality of insulation batts 490. The blank liner panel 680 can define a pair of liner subpanels 604 connected by a bottom subpanel 606. The blank liner panel 680 can define a border 693 extending around a perimeter of the blank liner panel 680. Each liner subpanel 604 can define a pair of side border portions 643 of the border 693 positioned at opposite ends of the respective liner subpanel 604. The blank liner panel 680 can be folded in half about a bottom crease line 601 to bring the liner subpanels 604 into facing engagement and to align the respective side border portions 643 of each of the liner subpanels 604 with one another. The bottom crease line 601 can correspond to and function similarly to the bottom crease line 247 of the insulated liner 140.

[0073] The blank liner panel 680 can define a pair of liner crease lines 602, each positioned at an intersection between a one of the liner subpanels 604 and the bottom subpanel 606. The liner subpanels 604 can fold relative to the adjacent bottom subpanel 606 about the liner crease lines 602. The liner subpanels 604 can each define a pair of side crease lines 603. Each liner subpanel 604 can define a main subpanel 642 positioned between a pair of side subpanels 644. For each liner subpanel 604, the side crease lines 603 can extend between the main subpanel 642 and a different one of the side subpanels 644. Each of the side subpanels 644 can fold about a one of the side crease lines 603 relative to the adjacent main subpanel 642. In the present embodiment, the side crease lines 603 can be structurally and functionally similar to the side crease lines 242. In some aspects, the insulation batt 490 underlying each liner crease line 602 can be cut to define a groove which can facilitate bending of the blank liner panel 680 about any of the crease lines 601, 602, 603.

[0074] FIG. 6B is a top view of another aspect of the insulated liner 640. The insulated liner 640 can be formed by folding the blank liner panel 680 in half about the bottom crease line 601 and attaching each pair of aligned side border portions 643 in facing engagement in order to form a pair of side seams 646. At each side seam 646, a pair of side subpanels 644, each defined by a different opposing liner subpanel 604, can be attached by the respective side seam 646. Similar to the insulated liner 140, the insulated liner 640 can comprise a liner bottom 649, an opposing pair of main liner panels 647, and an opposing pair of side liner

panels 645. Each of the main liner panels 647 can be defined by a one of the main subpanels 642 of the liner subpanel 604 extending between the side crease lines 603. Each of the side liner panels 645 can be defined by a one of the pairs of side subpanels 644 attached by a one of the side seams 646. The liner bottom 649 can be defined by the bottom subpanel 606 extending between the liner crease lines 602. The main liner panels 647 and the side liner panels 645 can define a liner opening 648 defined distal from the bottom crease line 601.

[0075] FIG. 7 is a top view of another aspect of a blank sheet 491A and another aspect of an insulation batt 490A for the blank liner panels 141 of FIG. 3A. Each of the blank liner panels 141 can be formed by encapsulating the insulation batt 490A between two blank sheets 491A. The blank sheet 491A can define a height H_A and a width W_A . The blank sheet 491A can define the interior portion 494A and the perimeter portion 495A which can surround the interior portion 494A. The interior portion 494A can define a height H_B and a width W_B . The perimeter portion 495A can define a top portion 702 and a bottom portion 701 opposite from the top portion 702. Attaching two bottom portions 701 of two blank sheets 491A together can form the second bottom border portion 347. The perimeter portion 495A can also define a pair of side portions 743 opposite from one another. Attaching two side portions 743 of two blank sheets 491A together can form the side border portion 343. The top portion 702 and the bottom portion 701 can each define a height H_C , and the side portions 743 can each define a width W_E . In the aspect shown, the width W_E can define a value greater than a value of height H_C . In some aspects, the side portions 743 may extend further outwards than the top portion 702 or the bottom portion 701. This configuration can be desirable to provide increased surface area for attaching the side border portions 343 of two separate blank liner panels 141 to form one of the side seams 143. In some aspects in which the second bottom border portion 347 is configured to attach to one of the first bottom border portions 346, the bottom portion 701 may extend further than the top portion 702.

[0076] The blank sheet 491A can define the side crease lines 242. The side crease lines 242 can divide the interior portion 494A into a main subpanel portion 742 and a pair of side subpanel portions 744. The main subpanel portion 742 can correspond to the main subpanel 142 of the blank liner panel 141, and the side subpanel portions 744 can correspond to the side subpanels 144 of the blank liner panel 141. The main subpanel portion 742 can define a width W_C , and the side subpanel portions 744 can each define a width W_B .

[0077] In some aspects, the insulation batt 490A can optionally define a pair of side grooves 741 which can be positioned to align with the side crease lines 242 when the insulation batt 490A is aligned with the interior portion 494A. However, in other aspects, the insulation batt 490A may not define the side grooves 741. The side grooves 741 can be defined into the insulation batt 490A, such as by die cutting the side grooves 741 into the insulation batt 490A. In the present aspect, the side grooves 741 can be V-shaped. The side grooves 741 can be configured to increase flexibility of the insulation batt 490A which can be desirable, particularly in aspects in which the insulation batt 490A is relatively thick, for example and without limitation when the insulation batt 490A is greater than $\frac{1}{2}$ " in thickness. The insulation batt 490A can range in thickness from less than $\frac{1}{16}$ " to over 2". In some aspects, the preferred thickness

range can be from less than 1" to over 1.5". The side grooves 741 can define a main insulation portion 752 and two side insulation portions 754 which can be sized and shaped substantially similar to the main subpanel portions 742 and the side subpanel portions 744, respectively. The side grooves 741 can be defined on either one or both sides of the insulation batt 490A. In some aspects, the side grooves 741 can extend completely through the insulation batt 490A dividing the insulation batt 490A into separate subpanels.

[0078] The insulation batt 490A can define a width W_F and a height H_D which can each define a value substantially the same or slightly less, for example and without limitation 1" less, than the width W_D and height H_B , respectively. This sizing allows the insulation batt 490A to fit within the panel cavity (not shown) defined between the interior portions 494A of two blank sheets 491A when the perimeter portions 495A are attached in facing engagement. Sizing the insulation batt 490A slightly smaller than the interior portion 494A can provide clearance for the thickness of the insulation batt 490A, particularly in embodiments in which the insulation batt 490A defines a large thickness such as $\frac{1}{2}$ " or greater.

[0079] FIG. 8 is a top view of another aspect of a blank sheet 491B and another aspect of an insulation batt 490B for the bottom panel 146 of FIG. 3A. In this aspect, the blank sheet 491B can define a width W_H and a height H_E . In the present aspect, the width W_H of the blank sheet 491B, which can correspond to a width of the bottom panel 146, can have substantially the same value as the width W_C of the main subpanel portion 742, which can correspond to a width of the main subpanel 142 of the liner panel 141. The blank sheet 491B can define the interior portion 494B and the perimeter portion 495B which can extend around a perimeter of the blank sheet 491B. The bottom border 308 of the bottom panel 146 can be formed by attaching two perimeter portions 495B of two separate blank sheets 491B together in facing engagement.

[0080] The interior portion 494B can define a width W_I and a height H_G . In some aspects in which the side seam 143 is a lap seam, the height H_G can have substantially the same value as the combination of the width W_E of the side portion 743 and the widths W_B of the two side subpanel portions 744. The combination of width W_E of the side portion 743 and the widths W_B of the two side subpanel portions 744 can be approximately equal to a combined width of one of the side seams 143 and a pair of side subpanels 144 which can together define one of the side liner panels 145. In other aspects in which the side seam 143 is a plain seam, the height H_G can have substantially the same value as twice the widths W_B of the two side subpanel portions 744. With two blank sheets 491B aligned and attached in facing engagement, the interior portions 494B can define the panel cavity (not shown) which can contain the insulation batt 490B.

[0081] The blank sheet 491B can define the bottom crease line 247 which can bisect the blank sheet 491B. The perimeter portion 495B can define a pair of first bottom border portions 846 which can correspond to the first bottom border portions 346 of the bottom panel 146. Portions of the perimeter portion 495B at opposite ends of the bottom crease line 247 can define a pair of side border portions 847. The side border portions 847 can each define a width W_G and the first bottom border portions 846 can each define a height H_F . In the present aspect, the width W_G and the height H_F can define values which can be substantially the same; however, in other aspects the height H_F can define a value

greater than the value of the width W_G . This configuration can be desirable to provide additional surface area for attaching the first bottom border portions 346 to the second bottom border portions 347 or to the main subpanels 142.

[0082] The insulation batt 490B can define a width W_J and a height H_H which can each define a value substantially the same or slightly less, for example and without limitation 1" less, than the width W_I and height H_G , respectively. Similar to FIG. 7, this sizing allows the insulation batt 490B to fit within the panel cavity (not shown) defined between two blank sheets 491B. Sizing the insulation batt 490B slightly smaller than the interior portion 494B can provide clearance for the thickness of the insulation batt 490B, particularly in embodiments in which the insulation batt 490B defines a large thickness such as $\frac{1}{2}$ " or greater.

[0083] In some aspects, the insulation batt 490B can optionally define a bottom groove 880 which can be similar in shape, form, and function to the side grooves 741. The bottom groove 880 can be positioned to align with the bottom crease line 247 when the insulation batt 490B is aligned on top of the interior portion 494B. However, in other aspects, the insulation batt 490B may not define the bottom groove 880.

[0084] FIG. 9 is a top view of another aspect of a blank sheet 491C and another aspect of an insulation batt 490C for the insulated panels 130 of FIG. 3A. The blank sheet 491C can define a width W_J and a height H_I . The panel border 333 of the insulated panels 130 can be formed by attaching two perimeter portions 495C of two separate blank sheets 491C together in facing engagement. The interior portion 494C can define a width W_M and a height H_J . With two blank sheets 491C aligned and attached in facing engagement, the interior portions 494C can define the panel cavity (not shown) which can contain the insulation batt 490C.

[0085] The perimeter portion 495C can define a pair of first panel border portions 946 and a pair of second panel border portions 947. The second panel border portions 947 can each define a width W_L , and the first panel border portions 946 can each define a height H_K . In the present aspect, the width W_G and the height H_F can define values which can be substantially the same.

[0086] The insulation batt 490C can define a width W_N and a height H_L which can each define a value substantially the same or slightly less, for example and without limitation 1" less, than the width W_M and height H_J , respectively. This sizing allows the insulation batt 490C to fit within the panel cavity (not shown) defined between two blank sheets 491C. Sizing the insulation batt 490C slightly smaller than the interior portion 494C can provide clearance for the thickness of the insulation batt 490C, particularly in embodiments in which the insulation batt 490C defines a large thickness such as $\frac{1}{2}$ " or greater.

[0087] In some aspects, such as when the insulated panel 130 corresponding to the blank sheet 491C is the top panel 131, the width W_J and the height H_I can be sized complementary to the size and shape of the liner opening 148. In this aspect, the width W_J can define a value substantially the same as the width W_C of the main subpanel portion 742 of blank sheet 491A. In aspects in which the side seam 143 is a lap seam, the height H_I can define a value substantially the same as the combination of the width W_E of the side portion 743 and the widths W_B of the two side subpanel portions 744. These widths can correspond to a combined width of the two side subpanels 144 and the side seam 143 which can

together define a one of the side liner panels **145** as shown in FIG. 2B. In other aspects in which the side seam **143** is a plain seam, the height H_j can have substantially the same value as twice the widths W_b of the two side subpanel portions **744**. In aspects in which the insulated panel **130** is the divider panel **431** or the floor panel **432** as shown in FIG. 4A, the width W_j and the height H_j can be sized slightly smaller than the liner opening **148** to accommodate the thickness of the insulation batt **490A** of the blank liner panels **141**.

[0088] A method of assembling the insulated box assembly **100** can comprise configuring the insulated liner **140** in the collapsed installation configuration, aligning the insulated liner **140** with the box opening **120** of the box **110**, inserting the insulated liner **140** into the internal box cavity **122**, and configuring the insulated liner **140** to the expanded configuration. Configuring the insulated liner **140** in the collapsed insertion configuration can comprise folding the side liner panels **145** inwards towards the liner cavity **150**, collapsing the main liner panels **147** inwards towards the liner cavity **150**, and folding the liner bottom **149**. Configuring the insulated liner **140** to the expanded configuration can comprise expanding the main liner panels **147** away from the liner cavity **150**, unfolding the side liner panels **145** outwards from the liner cavity **150**, and unfolding the liner bottom **149**. Configuring the insulated liner **140** to the expanded configuration can further comprise self-expanding the insulated liner **140** with the force F_2, F_3 exerted by the positional memory of the insulated liner. Configuring the insulated liner **140** to the expanded configuration can further comprise positioning a one of the main liner panels **147**, the side liner panels **145**, and the liner bottom **149** in facing engagement with a one of the main box panels **112**, the side box panels **114**, and the box bottom panel **413**. The method can further comprise covering the liner opening **148** with the insulated panel **130** and forming the seal between the insulated panel **130** and the insulated liner **140**.

[0089] In the present aspect, the blank sheets **491** can comprise paper, such as kraft paper; however, in other embodiments, the blank sheets **491** can comprise poster-board, cardboard, plastic sheeting, cloth, or any other suitable material. In some aspects, the pair of blank sheets **491** can each comprise a different material. In some aspects, the blank sheets **491** can be a water-proof or water-resistant material, such as water-resistant kraft paper. The insulation batt **490** can comprise paper or other paper fiber materials; however, in other aspects, the insulation batt **490** can comprise cotton, foam, rubber, plastics, fiberglass, mineral wool, or any other flexible insulation material. In the present application, the insulation batt **490** can be repulpable. In the present aspect, the insulated box assembly **100** can be 100% recyclable. In the present aspect, the insulated box assembly **100** can be single-stream recyclable wherein all materials comprised by the insulated box assembly can be recycled by a single processing train without requiring separation of any materials. In some aspects, only the insulated liner **140** can be single-stream recyclable. In the present aspect, the insulated box assembly **100** can be compostable. In the present aspect, the insulated box assembly **100** can be repulpable. In the present aspect, insulated box assembly **100** and each of the box **110**, the insulated liner **140**, and the insulated panel **130** can be repulpable in accordance with the requirements of the Aug. 16, 2013, revision of the “Voluntary Standard For Repulping and Recycling Corrugated Fiberboard

Treated to Improve Its Performance in the Presence of Water and Water Vapor” provided by the Fibre Box Association of Elk Grove Village, IL, which is hereby incorporated by reference in its entirety. In the present aspect, insulated box assembly **100** and each of the box **110**, the insulated liner **140**, and the insulated panel **130** can be recyclable in accordance with the requirements of the Aug. 16, 2013, revision of the “Voluntary Standard For Repulping and Recycling Corrugated Fiberboard Treated to Improve Its Performance in the Presence of Water and Water Vapor” provided by the Fibre Box Association of Elk Grove Village, IL. In some aspects, the insulated box assembly **100** can be biodegradable.

[0090] Recyclable and repulpable insulation materials are further described in U.S. Patent Application No. 62/375,555, filed Aug. 16, 2016, U.S. Patent Application No. 62/419,894, filed Nov. 9, 2016, and U.S. Patent Application No. 62/437,365, filed Dec. 21, 2016, which are each incorporated by reference in their entirety herein.

[0091] The insulated box assembly **100** can be used in applications in which a user or mail carrier transports perishable or temperature-sensitive goods or contents. For example and without limitation, the insulated box assembly **100** can be used to transport groceries or medications. In some applications, a material such as ice, dry ice, or a freeze pack can be placed in the liner cavity **150** to maintain a temperature of goods for longer durations. Alternatively, the insulated box assembly **100** can be used to transport warm contents, such as takeout delivery of freshly-prepared food. In such applications, a heat pack or other heat source can be placed within the liner cavity to keep contents of the insulated box assembly **100** warm.

[0092] Many forms of packaging and insulation are not accepted by many recycling facilities or curb-side recycling programs in which a waste management service collects recyclables at a user's home. Examples such as bubble wrap or plastic-wrapped insulations may not be accepted. In some aspects, the insulated box assembly **100** can reduce waste and pollution by comprising materials which are recyclable or biodegradable. In aspects in which the insulated box assembly **100** is curb-side or single-stream recyclable, the user may be more likely to recycle the insulated box assembly **100** due to the ease of curb-side collection.

[0093] One should note that conditional language, such as, among others, “can,” “could,” “might,” or “may,” unless specifically stated otherwise, or otherwise understood within the context as used, is generally intended to convey that certain embodiments include, while other embodiments do not include, certain features, elements and/or steps. Thus, such conditional language is not generally intended to imply that features, elements and/or steps are in any way required for one or more particular embodiments or that one or more particular embodiments necessarily include logic for deciding, with or without user input or prompting, whether these features, elements and/or steps are included or are to be performed in any particular embodiment.

[0094] It should be emphasized that the above-described embodiments are merely possible examples of implementations, merely set forth for a clear understanding of the principles of the present disclosure. Any process descriptions or blocks in flow diagrams should be understood as representing modules, segments, or portions of code which include one or more executable instructions for implementing specific logical functions or steps in the process, and

alternate implementations are included in which functions may not be included or executed at all, may be executed out of order from that shown or discussed, including substantially concurrently or in reverse order, depending on the functionality involved, as would be understood by those reasonably skilled in the art of the present disclosure. Many variations and modifications may be made to the above-described embodiment(s) without departing substantially from the spirit and principles of the present disclosure. Further, the scope of the present disclosure is intended to cover any and all combinations and sub-combinations of all elements, features, and aspects discussed above. All such modifications and variations are intended to be included herein within the scope of the present disclosure, and all possible claims to individual aspects or combinations of elements or steps are intended to be supported by the present disclosure.

That which is claimed is:

1. An insulated box assembly comprising:
 - an insulated liner, the insulated liner defining a top liner end and a bottom liner end, the top liner end disposed opposite from the bottom liner end, the insulated liner defining a liner cavity, the liner cavity defining a liner opening disposed at the top liner end of the insulated liner, the insulated liner comprising:
 - a pair of opposing main liner panels,
 - a pair of opposing side liner panels, each side liner panel of the pair of side liner panels attached to both main liner panels of the pair of main liner panels, and
 - a bottom liner panel, the bottom liner panel disposed at the bottom liner end, the main liner panels, the side liner panels, and the bottom liner panel further defining the liner cavity;
 - wherein the main liner panels, the side liner panels, and the bottom liner panel are each defined by an insulation batt and a pair of blank sheets, the insulation batt encapsulated in a panel cavity defined between the pair of blank sheets, the panel cavity of each main liner panel and each side liner panel being enclosed by a liner border defined by a perimeter portion of each blank sheet thereof being positioned in facing engagement, and the panel cavity of the bottom liner panel being enclosed by a bottom border defined by a perimeter portion of each blank sheet thereof being positioned in facing engagement, and
 - wherein the bottom border is disposed in a facing relationship with a portion of the liner border of each main liner panel and each side liner panel, thereby forming a bottom seam along a perimeter of the bottom liner panel.
2. The insulated box assembly of claim 1, wherein the bottom border is secured to the corresponding portions of the main liner panels and side liner panels by an adhesive.
3. The insulated box assembly of claim 2, wherein the adhesive comprises one of glue, cohesive, cement, epoxy, and tape strip.
4. The insulated box assembly of claim 1, wherein the perimeter portions of each blank sheet of each main liner panel and each side liner panel that define the liner borders are secured together by an adhesive.

5. The insulated box assembly of claim 1, further comprising a floor panel positioned on top of the bottom liner panel.

6. The insulated box assembly of claim 5, wherein the floor panel is defined by an insulation batt and a pair of blank sheets, the insulation batt encapsulated in a panel cavity defined between the pair of blank sheets.

7. The insulated box assembly of claim 6, the panel cavity of the floor panel being enclosed by a panel border defined by a perimeter portion of the blank sheets thereof being positioned in facing engagement.

8. The insulated box assembly of claim 7, wherein the perimeter portions of each blank sheet of the floor panel that define the panel border are secured together by an adhesive.

9. The insulated box assembly of claim 7, wherein the panel border of the floor panel is disposed adjacent the bottom seam of the insulated liner.

10. The insulated box assembly of claim 1, further comprising:

- a box, the box defining a top box end and a bottom box end, the top box end disposed opposite from the bottom box end, the box defining an internal box cavity, the internal box cavity defining a box opening disposed at the top box end of the box, the box comprising:

- a pair of opposing main box panels,

- a pair of opposing side box panels, each side box panel of the pair of side box panels attached to both main box panels of the pair of main box panels, and

- a bottom box panel, the bottom box panel positioned at the bottom box end of the box, the bottom box panel attached to the main box panels and the side box panels, the main box panels, side box panels, and bottom box panel further defining the internal box cavity,

- wherein the insulated liner is disposed within the internal box cavity of the box.

11. The insulated box assembly of claim 10, wherein the insulated liner is positioned within the internal box cavity, each main liner panel of the pair of main liner panels is positioned in facing engagement with a different main box panel of the main box panels, each side liner panel of the side liner panels positioned in facing engagement with a different side box panel of the side box panels, and the bottom liner end is positioned adjacent to the bottom box end.

12. The insulated box assembly of claim 1, wherein each side liner panel of the pair of side liner panels is defined by a pair of side subpanels attached together by a side seam.

13. The insulated box assembly of claim 12, wherein each side seam extends from the top liner end to the bottom liner end when the insulated liner is in an expanded configuration.

14. The insulated box assembly of claim 1, wherein the insulated box assembly further comprises an insulated panel covering the liner opening of the insulated liner.

15. The insulated box assembly of claim 14, wherein:

- the insulated liner defines a beveled liner edge proximate the liner opening;

- the insulated panel defines a beveled panel edge; and
- the beveled liner edge and the beveled panel edge cooperate to form a seal at the liner opening.

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