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INSULATED SHIPPING CONTAINER AND METHOD OF MAKING

Abstract

An insulating shipping container includes an exterior box formed of paper defining a cavity and an interior box formed of paper and positioned within said cavity. The interior box defines a product cavity. A compressed mass of compostable insulating plant material is received in the cavity and around the interior box and covered by a collar.

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Background/Summary

CROSS-REFERENCE TO RELATED APPLICATION [0001] This application is a continuation application of 18/224,274 filed Jul. 20, 2023, which is a continuation of U.S. application Ser. No. 17/536,941, filed Nov. 29, 2021 (now abandoned), which is a continuation of U.S. application Ser. No. 16/795,022, filed Feb. 19, 2020 (now abandoned), which is a continuation of U.S. application Ser. No. 16/507,413, filed Jul. 10, 2019 (now U.S. Pat. No. 11,097,886), which is a continuation of U.S. application Ser. No. 14/756,163, filed Aug. 10, 2015 (now U.S. Pat. No. 10,392,177), the contents of which are incorporated by reference herein.

BACKGROUND OF THE INVENTION

Field of the Invention

[0002] The present invention relates to an improved insulated shipping container; with all or substantially all of the component parts of this container suitable for recycling (i.e., which are biodegradable, or can be composted). Thus, a shipping container according to this invention may be considered environmentally friendly, or “green.” More particularly, this invention relates to an insulated shipping container made essentially from selected biodegradable and compostable vegetable (i.e., plant based) materials. The most preferred insulating material being pelletized or granulated insulating material (i.e., vegetable starches); and which are also prevented from migration of the insulating material and shipped item during shipping.

[0003] In order to better protect item(s) being shipped, the present container is especially configured and constructed to provide both shock absorption; and to provide temperature regulation through the use of a combination of particulate insulation (i.e., insulation pellets or granules). In order to provide temperature regulation within the container, a cooling material, such as refrigerated gel packs or dry ice, for example, may also be employed.

Related Technology

[0004] Traditionally, containers for shipping temperature sensitive products have generally included conventional cardboard shipping containers (i.e., cardboard boxes, for example) having an insulating material therein. The insulating material may be simple loose-fill Styrofoam “peanuts,” for example, in which a chunk of dry ice is placed along with the material to be shipped. Another variety of conventional insulated shipping container utilized panels or containers made of an insulating material, such as expanded polystyrene (EPS). EPS is a relatively inexpensive insulating material, and it may be easily formed into a desired shape, has acceptable thermal insulating properties for many shipping needs (i.e., typical R value of about 3.6 to about 4.0 per inch), and may be encapsulated or faced with protective materials, such as plastic film or metal foil, or plastic film/metal foil laminates.

[0005] Containers including EPS are often provided in a multi-piece (i.e., usually six pieces) modular form. Individual panels of EPS insulation, possibly wrapped in foil or the like, are preformed using conventional methods, typically with beveled, mitered, or square (i.e., 90.degree.) edges. The panels are then inserted into a conventional cardboard box type of shipping container, one panel against the floor wall, and against each side wall, to create an insulated cavity within the container. In this arrangement, the beveled edges of adjacent panels form seams at the corners of the container. This configuration compromises insulation value by losses through the seams, called edge losses. A product is placed in the cavity and either a plug (such as a thick polyether or polyester foam pad), or an EPS lid is utilized, and is placed over the top of the product before the container is closed and prepared for shipping. In many cases, a coolant, such as packaged ice, gel packs, or loose dry ice, is placed around the product in the cavity to refrigerate the product during

shipping.

[0006] Alternatively, an insulated body may be injection molded from expanded polystyrene (EPS), forming a cavity therein and having an open top to access the cavity. A product is placed in the cavity, typically along with coolant, and a cover is placed over the open end, such as the foam plug described above or a cover is also formed from EPS. In some uses, the brittle and breakable nature of EPS makes is less than satisfactory because of the possibility of damage to the container during transport.

[0007] For shipping particularly sensitive products, such as certain medical or pharmaceutical products, expanded rigid polyurethane containers are often used, as expanded polyurethane has thermal properties generally superior to EPS. Typically, a cardboard container is provided having a box liner therein, defining a desired insulation space between the liner and the container.

Polyurethane foam is injected into the insulation space, substantially filling the space and generally adhering to the container and the liner. The interior of the box liner provides a cavity into which a product and coolant may be placed. A foam plug may be placed over the product, or a lid may be formed from expanded polyurethane, typically having a flat or possibly an inverted top-hat shape.

[0008] With all of the conventional shipping containers outlined above, many of the component parts of the container are not biodegradable, and recycling of the materials of the container is also problematic. Some countries, particularly the European countries, presently impose a tariff or tax on products that do not meet recycling guidelines. Many conventional insulated shipping containers do not meet these recycling guidelines, so that the costs of using such non-compliant containers is increased by the applied additional taxes. Particularly, insulated shipping containers of the type utilizing polyurethane foam injected into a space between an inner and an outer nested cardboard boxes create a particularly difficult disposal problem. When polyurethane is injected into such a container, it generally adheres substantially to the walls of both the inner and the outer cardboard box. Thus, the cardboard and insulation components may have to be disposed of together, entirely preventing recycling of the container.

[0009] Accordingly, there is a need for an improved insulated shipping container which is “green” with substantially all of the components of the container being either biodegradable, or recyclable, or both.

SUMMARY OF THE INVENTION

[0010] The present invention is directed generally to an improved insulated shipping container for shipping a temperature sensitive product in a temperature regulated condition, which container is entirely recyclable or biodegradable. Further, the container is to provide physical protection from shocks and bumps as commonly occur during transport on common carriers, such as truck freight and air freight carriers. Further, the present invention is directed to such an insulated container that has insulating properties (i.e., R value) favorably comparable to EPS containers.

[0011] In one aspect, an insulating shipping container includes an exterior box formed of paper and defining a cavity, an interior box formed of paper and positioned within said cavity, said interior box defining a product cavity, a compressed mass of compostable insulating plant material of pellet/granular form received in said cavity and around said interior box, and said compressed mass of compostable insulating plant material has a compression ratio of at least 1.25:1 in comparison to a free-flowing loose-filled condition of the pellet/granular form sufficient to provide said compressed mass of compostable insulating plant material with a thermal insulating value (R value) substantially equal to or better than EPS.

[0012] Implementations can include one or more of the following.

[0013] The shipping container can be larger than 10 inches in at least one direction.

[0014] Said pellets/granules of said compressed mass of compostable insulating plant material can mutually engage and interlock with one another.

[0015] Said compressed mass of compostable insulating plant material can have a compression ratio of at least 1.35:1 in comparison to a free-flowing loose-filled condition of the pellets/granules

of mass of compostable insulating material.

[0016] The shipping container can include a film bag lining the exterior box and surrounding the interior box.

[0017] According to another aspect, a method of providing an insulating shipping container includes disposing an interior box formed of paper within a cavity in an exterior box formed of paper, said interior box defining a product cavity, disposing a first strata of starch in pellet/granular form in a volume between said interior box and said exterior box, compressing said first strata of starch, after compressing the first strata, disposing a second strata of starch in pellet/granular form in the volume over the first strata, and compressing the second strata of starch.

[0018] Implementations can include one or more of the following.

[0019] The shipping container can be larger than 10 inches in at least one direction.

[0020] Compressing the starch can cause said pellets/granules of said starch to mutually engage and interlock with one another.

[0021] The starch can be compressed to a compression ratio of at least 1.25:1 in comparison to a free-flowing loose-filled condition of the pellets/granules of starch.

[0022] A moisture resistant film can surround the interior cardboard box within the exterior box.

[0023] According to another aspect, an insulating shipping container includes an exterior paperboard box defining a cavity, an interior paperboard box within said cavity, said interior paperboard box defining a product cavity, a mass of compostable insulating material of pellet/granular form received in said cavity and around said inner paperboard box, and plural filamentary staples extending between and securing said exterior paperboard box and said interior paperboard box together.

[0024] Implementations can include one or more of the following.

[0025] The shipping container can be larger than 10 inches in at least one direction.

[0026] Said pellets/granules of said mass of compostable insulating material can mutually engage and interlock with one another.

[0027] Said mass of compostable insulating material can have a compression ratio of at least 1.25:1 in comparison to a free-flowing loose-filled condition of the pellets/granules of insulating material. The compression ratio can be sufficient to provide said compressed mass of compostable insulating material with a thermal insulating value (R value) substantially equal to or better than EPS.

[0028] A horizontal partition can cover and retain an upper layer of said mass of compostable insulating material.

[0029] The exterior paperboard box can be corrugated, and the interior paperboard box can be corrugated.

[0030] According to another aspect, a shipping container includes an exterior box defining a cavity, an interior box within said cavity, said interior box defining a product cavity, and a compressed mass of compostable insulating material of pellet/granular form received in said cavity and around said inner cardboard box, where the compressed mass of compostable insulating material is formed of one or more of corn husks, corn stalks, coffee husks, coconut husks, cotton fibers (wasted or recycled), or mushrooms.

[0031] Implementations can include one or more of the following.

[0032] The shipping container can be larger than 10 inches in at least one direction.

[0033] Said pellets/granules of said compressed mass of compostable insulating material can mutually engage and interlock with one another.

[0034] The compressed mass of compostable insulating material can have a compression ratio of at least 1.25:1 in comparison to a free-flowing loose-filled condition of the pellets/granules of insulating material. The compression ratio can be sufficient to provide said compressed mass of compostable insulating material with a thermal insulating value (R value) substantially equal to or better than EPS. The compressed mass of compostable insulating material can have a compression ratio of at least 1.35:1 in comparison to a free-flowing loose-filled condition of the pellets/granules

of insulating material.

[0035] Other objects and features of the present invention will become apparent from consideration of the following description taken in conjunction with the accompanying drawings.

Description

BRIEF DESCRIPTION OF THE DRAWING FIGURES

[0036] FIG. 1 presents a perspective view of an insulated shipping container according to the invention, having a portion of the container sectioned or broken away for clarity of illustration;

[0037] FIG. 2 is a cross sectional view of the container seen in FIG. 1, with the cross section taken along a vertical plane 2-2 of FIG. 1, extending transversely through the container;

[0038] FIGS. 3-14 are diagrammatic cross sectional views somewhat similar to FIG. 2, and illustrating steps in the process of manufacturing an insulated shipping container embodying the present invention;

[0039] FIGS. 15, and 16 provide respective diagrammatic views of a conventional cushioning (i.e., packaging) or insulating “peanut” and of a pelletized or granular insulating element according to this present invention;

[0040] FIG. 17 is a graphical representation of the insulating performance of an insulated container embodying this invention in comparison to the performance of a conventional EPS container in an ISTA “summer” test cycle;

[0041] FIGS. 18 and 20, respectively, provide a sectioned perspective view, and a cross sectional view, each being similar to FIGS. 1 and 2, but showing an alternative embodiment of inventive shipping container; and

[0042] FIG. 19 is a perspective view of a component part of the shipping container shown in FIGS. 18 and 20.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0043] Turning now to the drawings, and considering FIGS. 1 and 2 in conjunction, these Figures show a perspective view of an insulated shipping container 10 according to the invention, with FIG. 1 having a portion of the container sectioned or broken away in the corner nearest the viewer for clarity of illustration. In FIG. 2, a cross sectional view of the insulated container 10 is presented, with the plane of the cross section indicated generally at the dashed line 2-2 of FIG. 1—extending transversely across the container—and looking in the direction of the arrows. In FIG. 2, an article 12 to be shipped is shown within an internal cavity 14 of the container (to be further described below), sandwiched between a pair of refrigerated gel packs 16. The gel packs 16 are provided to control the temperature of the item 12 to an acceptably low level during transport.

[0044] Still considering FIGS. 1 and 2, an insulated shipping container 10 in accordance with the present invention generally includes an exterior cardboard (i.e., corrugated cardboard or paper board) shipping container or box 18, including plural (in this case, four) side walls each indicated with the numeral 18a. A bottom wall 18b is cooperatively formed by plural lower flaps 18c each hingeably attaching at a lower marginal extent of the side walls 18a. A top wall 18t (best seen in FIG. 2) is similarly formed cooperatively by plural flaps 18u hingeably attaching at an upper marginal extent of the side walls 18a. It will be noted that in this instance, the upper flaps 18u are alike to the lower flaps 18c, although the invention is not so limited. In FIG. 1, the top wall of the box 18 is shown in its open configuration. The side wall 18a thus are seen to cooperatively define an upper opening 18d, leading to a rectangular prismatic cavity 17.

[0045] As is seen in both FIGS. 1 and 2, generally centrally received into the cavity 17 of container 10 (i.e., within outer box 18) is a dimensionally smaller inner box 20, preferably also formed of cardboard or paper board. The construction of the inner box 20 is substantially like that of the outer box 18. In both FIGS. 1 and 2, the upper flaps 20u of the inner box 20 are illustrated to be closed,

although those ordinarily skilled in the pertinent arts will understand that they can be opened as is shown for the outer box **18** in FIG. **1**.

[0046] Closely considering now FIGS. **1** and **2** together, it is seen that adjacent to both the bottom wall **18b** and side walls **18a** of the outer box **18** (and interposed between these walls of the outer box **18** and the walls of the inner box **20**) is a layer of insulation material (generally indicated with the numeral **22**). This insulating material is indicated on FIGS. **1** and **2** to consist of several layers or “strata,” indicated respectively with the numerals **22a**, **22b**, **22c**, and **22d**. These strata **22a-22d** of insulating material are each formed as will be explained further below. But, for the present, it is to be understood that each strata consists of granular or pelletized insulating material that has been compressed “in situ” by a determined degree or amount from an initial “loose fill” or free-flowing condition.

[0047] As a predicate to the following description of a method of making the container **10**, and in order to better appreciate and understand the significance of the selected or determined degree of compression of the granular insulating material **22** in the respective strata, attention may now be turned briefly to FIGS. **15** and **16**. Although not to scale or to be understood or taken as precise representations, the insulating pellets, granules, or “peanuts” shown in FIGS. **15** and **16** are approximately full size. In FIG. **15** is shown a conventional or prior-art foamed or “puffed” cylindrical plastic cushioning “peanut **24**” of the type generally used to cushion (and sometimes to insulate) items to be shipped. As is seen in FIG. **15**, this conventional foamed pellet is about one inch to about one and one-half inches in length and has a diameter about one-half its length (both indicated by respective arrows on FIG. **15**—with the length indicated in the vertical direction and the width or diameter dimension indicated in the horizontal direction). These conventional cushioning pellets have a bulk density of about 265.5 grams per cubic foot. When such conventional pellets are used to cushion or insulate an item to be shipped within a box the pellets are generally introduced or poured (i.e., free flowing condition) into the box around the item to be shipped in a “loose fill” condition, perhaps with a small excess of pellets to be pushed into the box when the flaps of the box are closed. This slight over filling of the box simply has the effect of somewhat resisting migration of the pellets around the item being shipped during the vibration of jostling of carriage. Consequently, settling or raising of the item being shipped within the bulk of the cushioning pellets is somewhat resisted. The over filling of the box with conventional cushioning pellets does not accomplish a consistent or uniform compressing of the conventional pellets. Further, a difficulty arises when the conventional pellets are used for insulation, in that their relatively large size and inconsistent pushing into the box as the box is closed (due to slight over filling) leaves a large interstitial or ullage volume inside the box. This large interstitial volume allows for air circulation around and among the conventional cushioning pellets and provides a very poor insulation value.

[0048] On the other hand, consideration of FIG. **16** shows a preferred size for a cylindrical insulating pellet **26** to be used in the practice of this invention. This preferred insulating pellet is also made of foamed Material (as is to be further explained), and has a length of about five-eighth of an inch or less, and a diameter of about one-half of its length (both indicated by respective arrows on FIG. **16**). Significantly, this preferred insulating pellets have a bulk density in their “loose fill” free flowing condition from about 287.5 grams per cubic foot to over 400 grams per cubic foot. Accordingly, because the foam from which the pellets of FIGS. **15** and **16** are made is substantially the same, it is to be appreciated that the pellets of FIG. **16** appear to have a substantially smaller or decreased ullage volume (or interstitial volume) compared to the pellets of FIG. **15**. The bulk density, or weight per cubic foot, of the insulating pellets of FIG. **16** is from about 10% higher to about 150% higher than the cushioning pellets of FIG. **15**.

[0049] Even more significantly, a multitude of the preferred insulating pellets **26** as seen in FIG. **16** are disposed in the container **10** in a compressed bulk form in order to cooperatively form the strata **22a-22d**. These strata of compressed pellets each have a selected or desired degree of compressing

(or compression) from the “loose fill” condition of pellets **26**, and the compression of pellets **26** in the strata **22a-22d** is substantially uniform. As a result, the strata **22a-22d** exhibit a much lower interstitial volume than can be accomplished with conventional pellets or peanuts as seen in FIG. **15**. Further, because of the selected or desired degree of compression of the pellets **26** in the strata **22a-22d**, the pellets are effectively “locked” into engagement with one another, and migration of the pellets **26** comprising strata **22a-22d** is positively prevented.

[0050] Turning now to FIG. **3**, a tool **28** to be used in making the container **10** is diagrammatically illustrated. The tool **28** consists of a hollow base **30** carrying a plateau **32** penetrated by an array of vacuum holes **34**, circumscribing an upstanding mandrel **36**. Arrow **38** indicates communication of the hollow base **30** to a controllable vacuum source. FIG. **4** shows that the mandrel is sized to slip closely in supporting relationship within the inner box **20**. That is, the inner box **20** in inverted orientation is slipped over the upstanding mandrel **36**, as is indicated by the movement arrow on FIG. **4**. FIG. **5** illustrates in cross section the inner box **20** in place on mandrel **36**, and upon plateau **32** on base **30**. It will be noted that the plurality of vacuum holes **34** also circumscribe the inner box **20**.

[0051] FIG. **6** illustrates a subsequent step in the method of making container **10**, in which the outer box **18**, also in inverted orientation, is placed on the base **30**, with the plateau **32** fitting within the upper (now oriented downwardly) opening **18d**. The vacuum holes **34** are thus disposed within the outer box **18** (i.e., between the inner box **20** and outer box **18**). In this orientation of the outer box **18**, the bottom wall **18b** (i.e., formed by bottom flaps **18c**) is open upwardly, as is seen in FIG. **6**. A pliable bag **40** of film material is introduced over the inner box, spanning across the plateau **32** and vacuum holes **34**, and extending upwardly on the open bottom flaps **18c**, to embrace (i.e., be folded over) these bottom flaps **18c**.

[0052] Subsequently, as is seen in FIG. **7**, the bottom flaps **18c** are forming the upwardly oriented opening of the bag **40** into an entrance to the upwardly disposed bag **40** and bottom of the box **18**, as is best seen in FIG. **7**. At this time, structural support for the side walls **18a** of box **18** is provided, as is indicated on FIG. **7** by the plurality of arrows **42**. The arrows **42** do not indicate that inward force is applied to the side walls **18a**, but simply that these side walls **18a** are supported against outward movement or bulging.

[0053] FIG. **8** diagrammatically illustrates that the vacuum source **38** has been turned on, at least momentarily, in order to pull the film bag **40** into embrace with the inner box **20**, the plateau **32**, and the outer box **18**. The timing of this application of vacuum is not critical, and can be performed as part of the steps illustrated in any one or all of FIGS. **6** through **8**. As seen in FIG. **8**, a first (i.e., upper) strata **44** of loose-filled granular or pelletized insulating material (i.e., plural pellets **26** as seen in FIG. **16**) are being filled into the space between the inner box **20** and outer box **18** within the film bag **40**. As is indicated by the depth of this strata **44** in comparison with the strata **22d** seen best in FIG. **2**, it is to be appreciated that in the loose-filled condition of the strata **44**, the depth is considerably greater than the depth of corresponding strata **22d**. However, as FIG. **9** illustrates, the strata **44** of loose-filled pellets **26** is compressed by substantially uniform application of downwardly directed force (indicated on FIG. **8** with the arrows **46**). It is to be noted that the compression force and movement indicated by arrows **46** is applied substantially uniformly across the upwardly exposed surface of the strata **44** and around the circumference of the strata **44** between the inner box **20** and outer box **18**. That is, the pellets **26** are substantially uniformly compressed in strata **44** from their loose-filled, free-flowing condition to a compressed or compacted condition, producing the strata **22d**. As will be further explained, the strata **44** of loose-filled pellets or granules **26** is thus compressed to a sufficient degree (to be further explained below) that the upper strata **22d** is produced. The strata **22a-22d** of multiple pellets **26** thus compressed or compacted will be recognized as effective thermal insulation (i.e., inhibiting heat transfer) disposed between the inner box **20** and outer box **18**.

[0054] FIG. **10** illustrates that by subsequent repeated application of the method steps indicated in

FIGS. 8 and 9, the subsequent strata 22c and 22b are produced in the volume (i.e., in that circumferential space) surrounding inner box 20 and within outer box 18. During the compression of these strata 22, the support (arrows 42) prevent the compression force (arrows 46) from resulting in the side walls 18a of box 18 being pushed or bulged outwardly by transferred compression force. [0055] Turning to FIG. 11, the provision of the strata 22a within box 18 is illustrated. Again, loose-filled pellets 26 are provided to a depth greater than the desired thickness of strata 22a, in order to accomplish substantially the same compression of the pellets 26 as has been done for strata 22d, 22c, and 22b (in the order of the creation of these strata). However, as FIG. 11 illustrates, in order to create the strata 22a, the loose filled pellets 26 are captured inside of the material of the film bag 40, which is gathered and folded over these loose-filled pellets 26 of strata 22a. The bottom flaps 18b of box 18 are then forcefully closed (refer to FIG. 12) on the loose-filled pellets 26 of the strata 22a, and force is applied (indicated by arrows 48) in order to bring the bottom flaps 18b of box 18 into position as seen in FIG. 12. In this way, the strata 22 is subjected to substantially the same degree or amount of compression of the pellets 26 as are the other strata 22d, 22c, and 22b.

[0056] Finally (as is indicated by the action arrows 50 on FIG. 13), a plurality of conventional plastic filament securing devices (or staples) 52 is inserted downwardly from the outside of box 18. These staples are inserted through the folded-closed bottom flaps 18a of box 20, through the strata 22a of compressed pellets 26, and through the bottom of box 20. Each of the plastic filament devices 52 have a spaced apart end pair of integral cross bars or tie bar portions, which respectively engage the bottom flaps of outer box 18 and the bottom of inner box 20. Thus, maintaining the position of inner box 20 within the outer box 18, and within the plural strata 22a-22d of compressed pellets 26 is assured. An advantage of this “stapling” of the inner box 20 into position within outer box 20 is that in the event that the shipping container is jostled during handling, or a worker were to tug on the flaps of inner box 20 during filling of this box, for example, the inner box 20 is not easily dislodged from its proper position within the strata of pellets 22a-22d.

[0057] Turning now to FIG. 14, it is seen that the container 10 has been removed from the tool 8, and has been turned over to its normal or upright orientation. In this orientation, the item 12 to be shipped, as well as any temperature control packs 16 to be utilized can be placed into the inner box 20 (recalling FIG. 2). The upper flaps of the inner box 20 are then closed (or alternatively, in the event an inner box 20 without top flaps has been used, a closure piece of flat cardboard (not seen in the drawing Figures) is employed to span and close the opening of inner box 20). Subsequently, a generally flat and correspondingly sized film bag 54 having an outer film layer 56 (i.e., like the film of bag 40) and an inner filling (not visible in the drawing Figures) of loose-filled insulating pellets 26 is provided. This generally flat bag 54 is placed in the top of box 18 atop of the upper strata 22d of compressed pellets, and atop of the closed inner box 20. Desirably, this bag 54 has a volume greater than the remaining space within outer box 18, generally according to the desired compression to be accomplished for the insulating pellets 26—recalling the description of compressed strata 22a-22d provided above. Once the bag 54 is placed into the opening of box 18, the upper flaps 18u are folded over the bag 54, and vertically downwardly directed force (arrows 58 of FIG. 2) is applied both to compress the pellets 26 of insulating material within bag 54, and to conform the shape of bag 54 to the shape of the remaining space within box 18 (i.e., atop of strata 22d and atop of the closed inner box 20), viewing FIG. 2). Further, it is to be noted that the bag 54 has provisions for allowing air trapped therein to escape during the compression of this bag and the pellets therein to the desired shape. Expedients that have been used are to have a few needle punches or slits formed in the film 56 from which the bag 54 is made.

[0058] It will be noted in FIG. 2, that as compressed into place, the bag 54 takes on a stepped or rabbeted shape, with an upper peripheral portion 54a which is highly compressed atop of strata 22d, and an inner portion 54b which is not so highly compressed atop of the closed inner box 20. Thus, a desirable air or respiration sealing engagement of bag 54 is accomplished with the strata 22d of compressed pellet insulation within the box 18. Once the flaps 18u have been closed,

adhesive tape may be employed to retain these flaps in their closed positions. It is to be noted that although the film bags **40** and **54** are not impermeable, they do provide a barrier against moisture migration into the container **10**, thus minimizing condensation of liquid water within the cavity **14**. The bags **40** and **54** also are believed to contribute to retention of sublimation gas within the container **10** when dry ice is utilized as a cooling agent, further contributing to a desirable increase in the R value of the container **10**. Also, it is to be noted that a variety of bags **40**, **54**, made of a variety of film materials, may be utilized in making the insulated container **10** according to this invention, and indeed, a container according to this invention may be made without using a bag **40** at all, as will be further explained.

[0059] Recalling the disclosure above of the foamed nature of the pellets **26**, it is to be noted that most preferably, the insulating pellets **26** are formed of foamed or “puffed” vegetable starch. A most preferred material for making the insulating pellets **22** is corn starch. In the event the pellets **26** are made of corn starch, then a desired compression for these pellets is at least 1.125:1. A higher compression ratio may be employed as is explained below. On the other hand, alternative vegetable and natural materials may be employed to make the pellets **26**, or to make a granular or pellet form of insulating material for use in container **10**. One material that has been employed successfully to make pellets **26** is sorghum starch. In the event that sorghum is utilized to make the pellets **26**, then a desired compression for these pellets is substantially at least 1.125:1. Experimentation has shown that for relatively small containers **10**, a compression ratio for sorghum based pellets is 1.25:1 is particularly satisfactory in providing an insulation value as good as or better than EPS. For larger containers **10** (i.e., larger than about 10 inches in any direction), a compression ratio of 1.35:1 provides the desired insulation value (i.e., equal to or better than EPS). Similarly, while the film for bags **40** and **54** (i.e., film **56**) may be made of a variety of materials, the most preferred material for making this casing is also a flexible corn starch film, which is biodegradable. Alternatively, the film for bags **40** and **54** may be made of a commercially available polyethylene sheeting having an ingredient added so that it biodegrades quickly.

[0060] Further considering the compression of pellets **26**, and the substantial reduction in interstitial volume or space achieved, it will be understood that when such insulating pellets are loose-filled together into a space or volume, they define considerable interstitial spaces, and these interstitial spaces communicate with one another. Moreover, although the communicating interstitial spaces define tortuous communication pathways through a layer of such pellets, a considerable air circulation can take place, and the insulating value of loose-filled pellets is not satisfactory. Testing has confirmed this assertion. On the other hand, FIG. **17** graphically illustrates a performance comparison for a container made according to this present invention versus a conventional EPS container. Both containers were cooled by a matching quantity of dry ice. The test protocol, generally, is the 24 hour ISTA Summer test, which has been made more severe for test purposes by extending the test beyond 24 hours (i.e., by more than an additional 6 hours), and by keeping the temperature of the test chamber at its highest level in the interval beyond 24 hours. Considering FIG. **15**, it is seen that throughout the entire 24 hour ISTA Summer test, the temperature within a container **10** according to this invention remains desirably lower than the temperature within a comparable insulated container made of EPS. As the ISTA Summer test is drawing to a close, near the last 5 hours of this standard test cycle, the container embodying this invention maintains a considerably lower internal temperature. In fact, at least for an additional 6 hours (until the test was terminated), the insulated container according to this present invention maintained a significant advantage over the conventional EPS container.

[0061] Further to the above, it has been discovered in the course of making and testing containers according to this invention that the compressed or compacted nature of the natural vegetable insulating materials utilized appears to result in a favorable retention of the sublimation gas (i.e., carbon dioxide) released when dry ice is utilized in the container for cooling purposes. That is, the cool carbon dioxide resulting from sublimation of the dry ice is not allowed to easily escape from

the container because of respiration or free-flowing circulation or permeation of the container is inhibited. Thus, the cool carbon dioxide is retained more effectively in the container **10** (i.e., in the insulation of the container as well), and warm outside air is apparently inhibited from respiration into the container **10**. The result is an increase or improvement in the insulating value (i.e., “R” value) of the container. Still further, it has been determined that materials other than the mentioned corn or sorghum materials may be utilized to form a granular or pellet form of insulating material for this present invention. That is, materials such as corn husks, corn stalks, coffee husks, coconut husks, cotton fibers (waste or recycled), and mushrooms could be used to make insulation material according to this invention. All of these alternative insulating materials are also biodegradable/compostable.

[0062] Turning now to FIGS. **18**, **19**, and **20** in conjunction, these Figures show a sectioned perspective view, and a cross sectional view of an alternative embodiment of insulated shipping container **10'** according to the invention. FIG. **19** illustrates a component part of the insulated container **10'**. Viewing FIGS. **18** and **20** in comparison with FIGS. **1** and **2**, it is immediately seen that the two embodiments of the invention thus illustrated are very similar. Because of the similarity of the two embodiments of inventive shipping container, the same reference numerals employed earlier to indicate features of the first embodiment are utilized for the embodiment of FIGS. **18** and **20**, but with a prime (') added. However, the embodiment of FIGS. **18** and **20** does not employ a bag **40** to contain the pellets **26**. Instead, the embodiment of FIGS. **18** and **20** does utilize a cardboard partition member **60**, as is best seen in FIG. **19**. This cardboard partition member **60** is sized and shaped to span and substantially close the circumferential, peripheral space between inner box **20'** and outer box **18'** (viewing FIG. **18**).

[0063] Turning to FIG. **19**, it is seen that the partition member **60** includes a central opening **62** sized and shaped to receive the inner box **20'**. As FIG. **18** shows, the cardboard partition member **60** is disposed substantially co-extensively with or co-planar with the top of box **20'**. Into this central opening **62** projects a plurality of integral tabs **64**, which can be seen in FIG. **18** (i.e., in dashed lines) folded downwardly so that they, enter matchingly positioned slots formed in the top of inner box **20'**. These tabs **64** may alternatively or additionally be glued to the box **20'**. Also viewing FIG. **19**, it is seen that the partition member includes outwardly projecting integral tab portions **66**, which in FIGS. **18** and **20** can be seen to engage into matchingly positioned slots defined by the outer box **18'**. Again, the partition member **60** may alternatively or additionally be glued to the inside of outer box **18'**. Thus, the upper extent of the compressed or compacted strata **22b'** of pellets **26** is protected by the cardboard partition member **60**. The partition member **60** assists in retaining the inner box **20'** within the outer box **18'**. So, the box **10'** may or may not utilize staples **52**, like were utilized by the first embodiment. Experience has shown that the cardboard partition member **60** by itself is sufficient in many uses of the container **10'** to secure the inner box **20'** during handling and preparations of the container **10'** for use and during shipping.

[0064] While the invention is susceptible to various modifications, and alternative forms, a specific example thereof has been shown in the drawings and is herein described in detail. It should be understood, however, that the invention is not to be limited to the particular forms disclosed, but to the contrary, the invention is to cover all modifications, equivalents and alternatives falling within the spirit and scope of the appended claims.

Claims

1-20. (canceled)

21. A thermally insulating container, comprising: an outer container that is a box formed of a paper and having an outer floor and a plurality of outer walls; an inner container that is a box formed of a paper and having an inner floor and a plurality of inner walls, a space interior to the plurality of inner walls defining an inner cavity to hold a product for shipping in the container; a recyclable or

compostable thermal insulation material formed primarily of plant fiber disposed between the inner walls and the outer walls; and a barrier formed of paper positioned to cover the thermal insulation material between the inner walls and the outer walls, the barrier comprising a plurality of collar section arranged in a horizontal rectangular ring substantially co-planar with a top of the inner container and below an upper rim of the plurality of outer walls of the outer container, the barrier further comprising a flap extending downwardly from an inner edge of a collar section from one of the plurality of collar sections and along a corresponding inner wall from the plurality of inner walls.

22. The container of claim 21, wherein the barrier comprises a plurality of flaps, each respective flap of the plurality of flaps extending downwardly from a respective outer edge of a respective collar section and along a respective corresponding inner wall from the plurality of inner walls.

23. The container of claim 22, wherein each flap extends partially but not entirely along a height of the corresponding inner wall.

24. The container of claim 23, wherein the barrier is a separate piece from the inner container and the outer container.

25. The container of claim 21, wherein the flap extends partially but not entirely along the inner wall

26. The container of claim 21, wherein the barrier is a separate piece from the inner container.

27. The container of claim 21, wherein the barrier is a separate piece from the outer container.

28. The container of claim 21, wherein the barrier is formed of cardboard.

29. The container of claim 28, wherein the inner container and outer container are cardboard or paperboard.

30. The container of claim 21, wherein the flap extends along an inner surface of the corresponding inner wall.

31. The container of claim 21, wherein the flap is secured to the inner wall.

32. The container of claim 21, wherein the plant fiber is formed from cotton fiber, corn stalks, or coconut husk.

33. A thermally insulating container, comprising: an outer container that is a box formed of a paper and having an outer floor, and a plurality of outer walls; a sheet formed of paper and folded to form a plurality of inner walls and located within the outer container, a space interior to the plurality of inner walls defining an inner cavity to hold a product for shipping in the container; a recyclable or compostable thermal insulation material formed primarily of plant fiber disposed between the plurality of inner walls and the plurality of outer walls; a barrier formed of paper to cover a top surface of the thermal insulation material in the outer cavity between the plurality of inner walls and the plurality of outer walls, the barrier comprising a plurality of collar sections arranged in a horizontal rectangular ring substantially co-planar with a top edge of the inner walls and below an upper rim of the plurality of outer walls of the outer container, one or more of the plurality of collar sections joined to and extending outwardly from one or more upper edges of one or more corresponding inner walls of the plurality of inner walls of the inner container; and a plurality of projections formed of paper, each projection of the plurality of projections extending from an outer edge of a collar section and contacting the outer wall of the outer container.

34. The container of claim 33, wherein each collar section of the plurality of collar sections is joined to a corresponding projection of the plurality of projections.

35. The container of claim 33, wherein the plurality of collar sections and plurality of projections are provided by a unitary body.

36. The container of claim 33, wherein the sheet and the barrier are cardboard.

37. The container of claim 36, wherein the outer container is cardboard or paperboard.

38. The container of claim 33, wherein the a plurality of collar sections completely cover a top surface of the thermal insulation material.

39. The container of claim 33, wherein outer edges of the barrier are vertically stabilized relative to

the outer container.

40. The container of claim 39, wherein the plurality of projections extend into a plurality of slots in the outer container.

41. The container of claim 33, wherein the outer container comprises a plurality of flaps extending from upper edges of the plurality of outer wall and foldable to close the box.

42. The container of claim 33, wherein the plurality of collar sections are attached to the plurality of inner walls by adhesive.

43. A thermally insulating container, comprising: a floor section including an upper layer formed of paper, a lower layer formed of paper, and a recyclable or compostable thermal insulation material formed primarily of plant fiber disposed between the upper layer and the lower layer; an outer rectangular shell supported on to the floor section, the outer rectangular shell formed of paper and having a plurality of outer walls with each outer wall joined to both adjacent outer walls to form the outer rectangular shell and; an inner rectangular shell formed of paper and having a plurality of inner walls and located within the outer container with each inner wall joined to both adjacent inner walls to form the inner rectangular shell, a space between the plurality of inner walls and plurality of outer walls defining an outer cavity, and a space interior to the plurality of inner walls defining an inner cavity to hold a product for shipping in the container; a recyclable or compostable thermal insulation material formed primarily of plant fiber disposed in the outer cavity and around the inner container; four collar sections arranged in a rectangular ring with each collar section joined to and extending outwardly from an upper edge of a corresponding inner wall of the plurality of inner walls of the inner container so as to be substantially co-planar with a top of the inner container and vertically spaced below an upper edge of the outer rectangular shell, each collar section extending to a corresponding outer wall of the plurality of outer walls and covering the thermal insulation material between the inner container and outer container; a plurality of first projections, each first projection integrally joined to and extending from an outer edge of a collar section past an exterior side of the thermal insulation material; and a cover to extend over the inner cavity and the collar section.

44. The container of claim 43, wherein outer edges of the collar sections are vertically stabilized relative to the outer container.

45. The container of claim 44, wherein the plurality of projections extend into a plurality of slots in the outer container.

46. The container of claim 43, comprising a plurality of second projections, each second projection integrally joined to and extending downward from an inner edge of a collar section on an interior side of the thermal insulation material.

47. The container of claim 46, wherein each second projection is adhesively attached to the inner container.

48. The container of claim 47, wherein each first projection is adhesively attached to the outer container.

49. The container of claim 43, wherein the four collar sections are provided by a unitary planar body.

50. The container of claim 43, wherein the four collar sections are cardboard.

51. The container of claim 43, wherein the outer container and inner container are cardboard.

52. The container of claim 43, wherein the plant fiber is formed from cotton fiber, corn stalks, or coconut husk.

53. The container of claim 43, wherein the thermal insulation material formed primarily of plant fiber directly contacts the inner walls and outer walls.

54. The container of claim 43, comprising a rectangular insert that fits inside the outer container above the collar.

55. The container of claim 43, wherein the cover is provided by a plurality of flaps that extend from the outer rectangular shell.

56. The container of claim 43, wherein the plurality of inner walls are provided by an unitary planar body.

57. The container of claim 43, wherein the plurality of outer walls are provided by an unitary planar body.

58. A thermally insulating container, comprising: an outer container that is a box formed of a paper and having an outer floor, a plurality of outer walls; an inner container formed of a paper and having a plurality of inner walls and located within the outer container, a space between the plurality of inner walls and plurality of outer walls defining an outer cavity, and a space interior to the plurality of inner walls defining an inner cavity to hold a product for shipping in the container; a recyclable or compostable thermal insulation material formed primarily of plant fiber disposed in the outer cavity and around the inner container; a collar removably fit between the inner container and the outer container to cover the thermal insulation material between the inner container and outer container, the collar forming a rectangular ring extending between the plurality of inner walls and the plurality of outer walls and positioned to so as to be substantially co-planar with a top edge of the inner container.

59. The container of claim 21, comprising a rectangular insert that fits inside the plurality of outer walls and above the inner cavity and the plurality of collar sections, wherein the rectangular insert comprises a plant fiber filler surrounded by sheets formed of a compostable or recyclable plant material.

60. The container of claim 33, comprising a rectangular insert that fits inside the plurality of outer walls and above the inner cavity and the plurality of collar sections, wherein the rectangular insert comprises a plant fiber filler surrounded by sheets formed of a compostable or recyclable plant material.

61. The container of claim 43, comprising a rectangular insert that fits inside the plurality of outer walls and above the inner cavity and the four collar sections, wherein the rectangular insert comprises a plant fiber filler surrounded by sheets formed of a compostable or recyclable plant material.
