



US 20020142081A1

(19) **United States**

(12) **Patent Application Publication**

Ream et al.

(10) **Pub. No.: US 2002/0142081 A1**

(43) **Pub. Date: Oct. 3, 2002**

(54) **SHELF-STABLE COOKIE DOUGH
CONFECTION, PRODUCT, PACKAGING
APPARATUS AND PROCESS**

(75) Inventors: **Ronald L. Ream**, Plano, IL (US);
Christine L. Corriveau, Orland Park,
IL (US); **Gregory J. Milosch**, Oswego,
IL (US); **Timothy J. Guydan**,
Naperville, IL (US); **Michael P.
McHale**, Aurora, IL (US); **George M.
Nichtula**, Yorkville, IL (US)

Correspondence Address:

BRINKS HOFER GILSON & LIONE
P.O. BOX 10395
CHICAGO, IL 60610 (US)

(73) Assignee: **Wm. Wrigley Jr. Company.**

(21) Appl. No.: **09/757,281**

(22) Filed: **Jan. 8, 2001**

Related U.S. Application Data

(62) Division of application No. 09/314,715, filed on May 19, 1999, now Pat. No. 6,193,105.

(60) Provisional application No. 60/086,561, filed on May 21, 1998.

Publication Classification

(51) **Int. Cl.⁷** **A23G 3/00**; B65B 55/00

(52) **U.S. Cl.** **426/396**; 426/660; 426/564

(57) **ABSTRACT**

An apparatus for metering and dispensing a compressible confection comprises: at least one metering pump having an intake port and a discharge port; at least one internal bottom shutoff nozzle; at least one product line interconnecting the metering pump and the internal bottom shutoff nozzle; and a control mechanism for cyclically operating the at least one metering pump and operating the at least one internal bottom shutoff nozzle in synchronization with the metering pump such that generally constant pressure is maintained between the metering pump and the internal bottom shutoff nozzle.

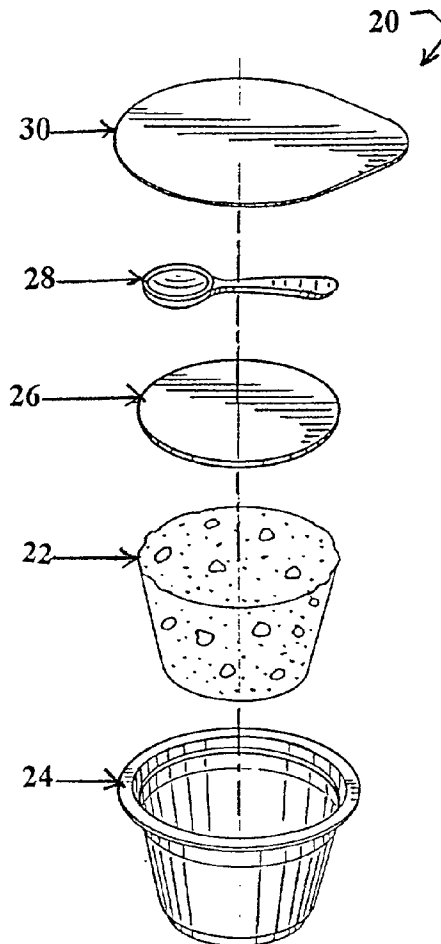
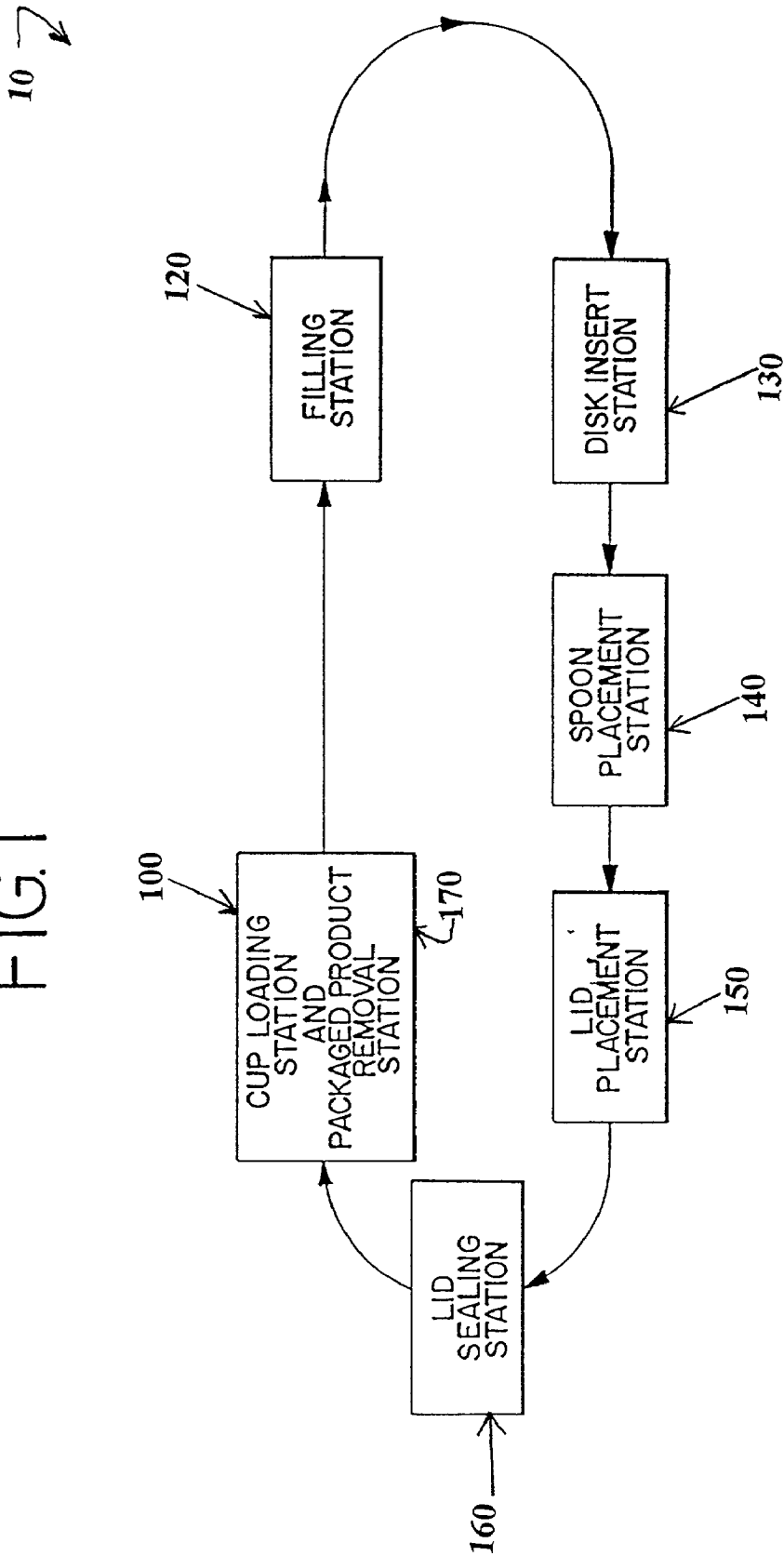
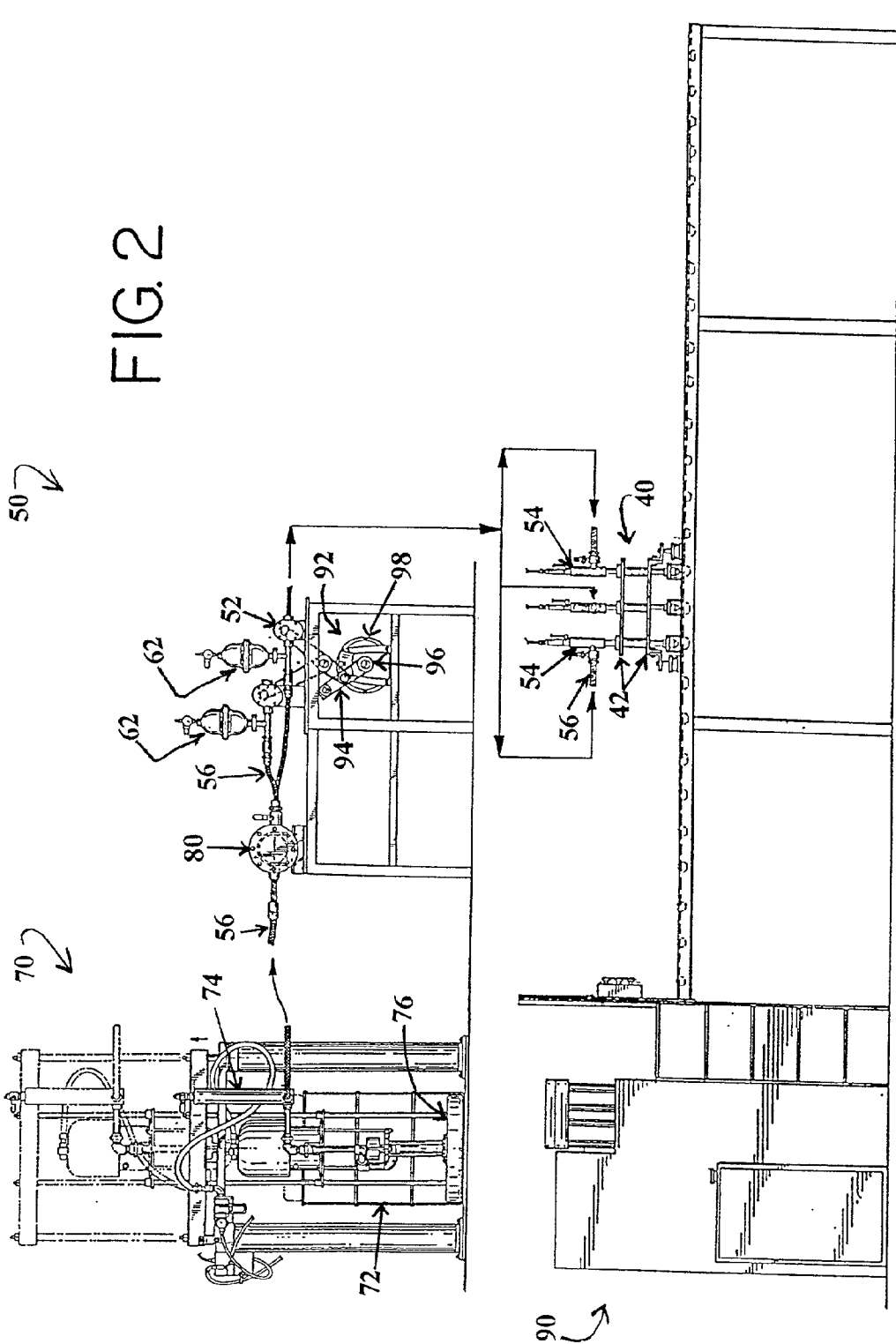


FIG. 1





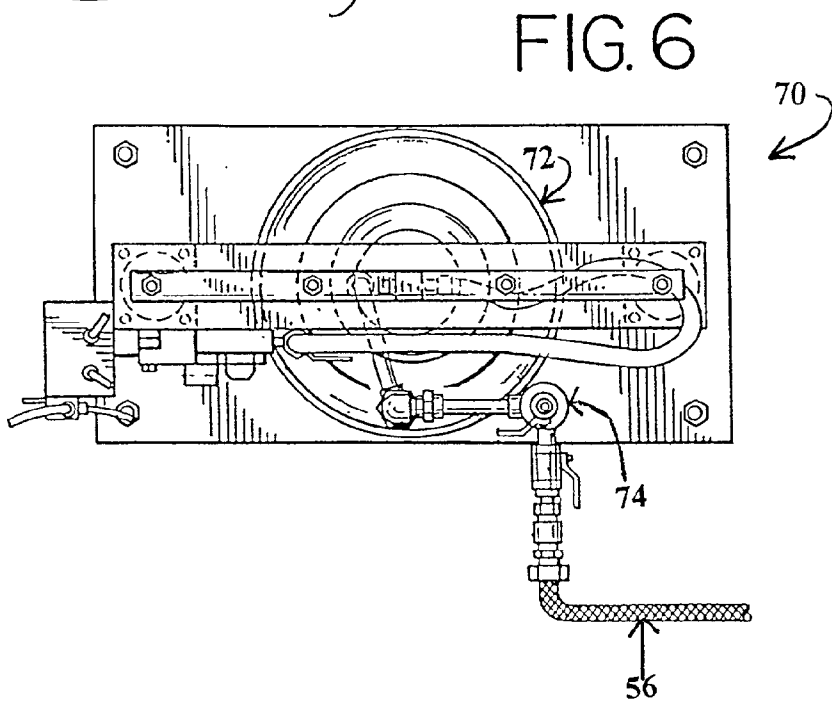
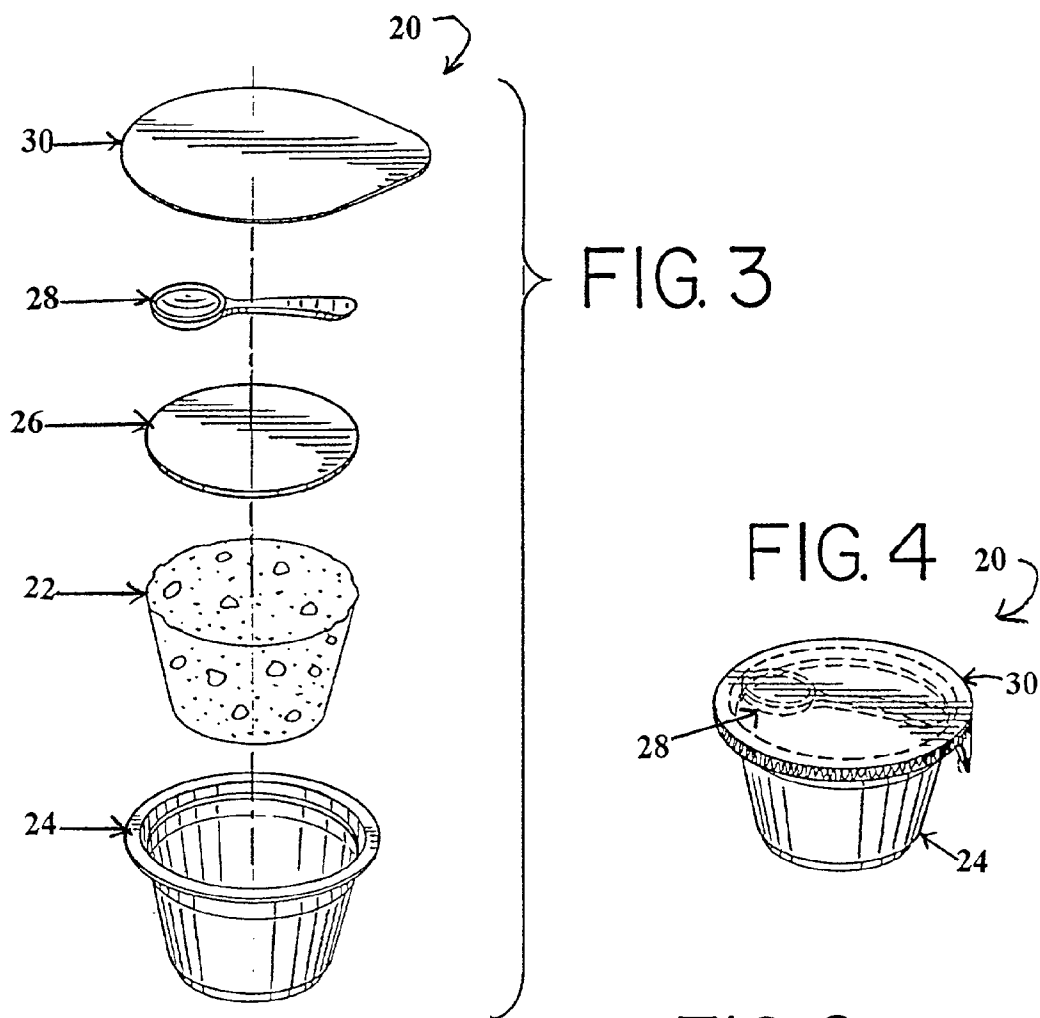
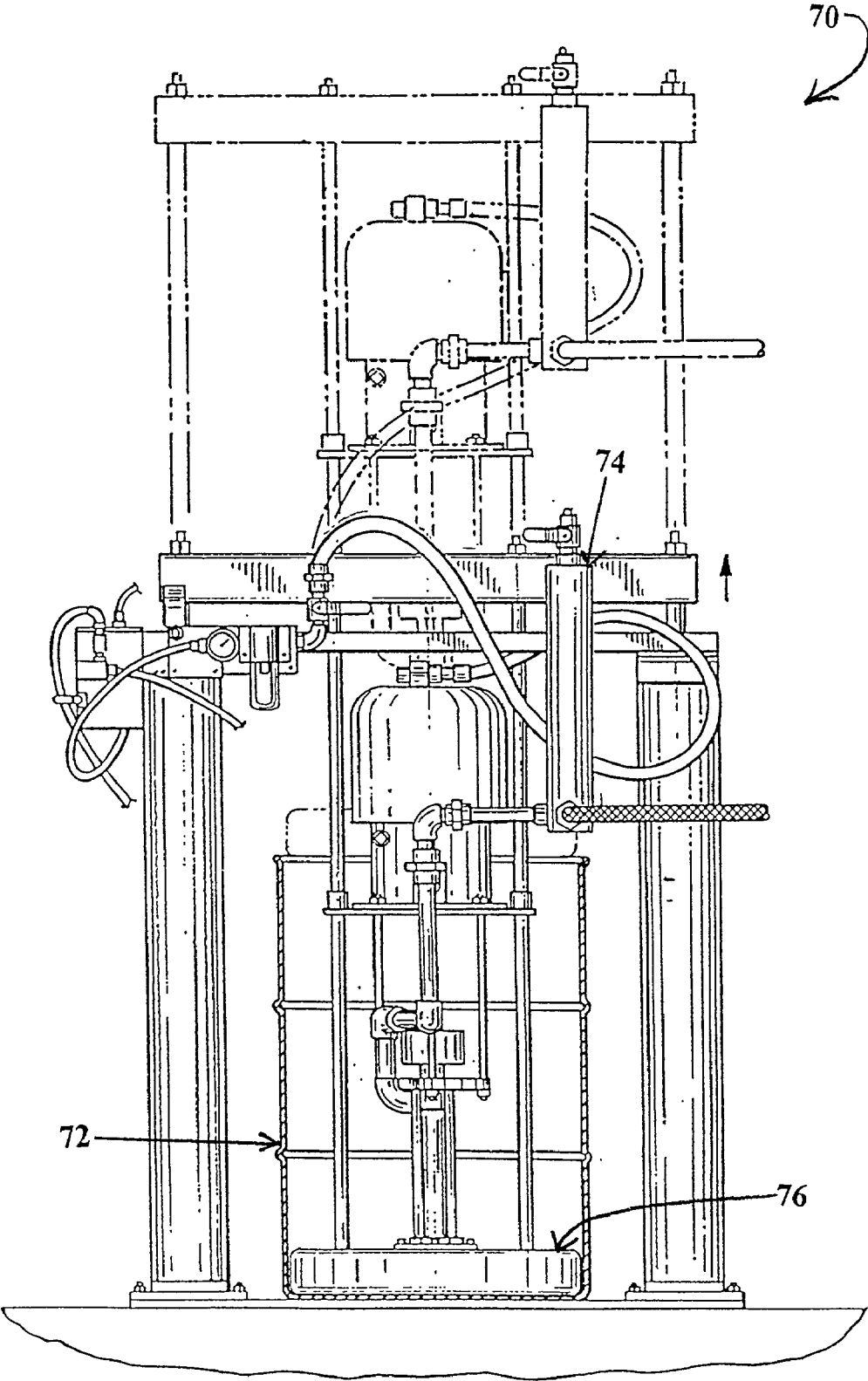
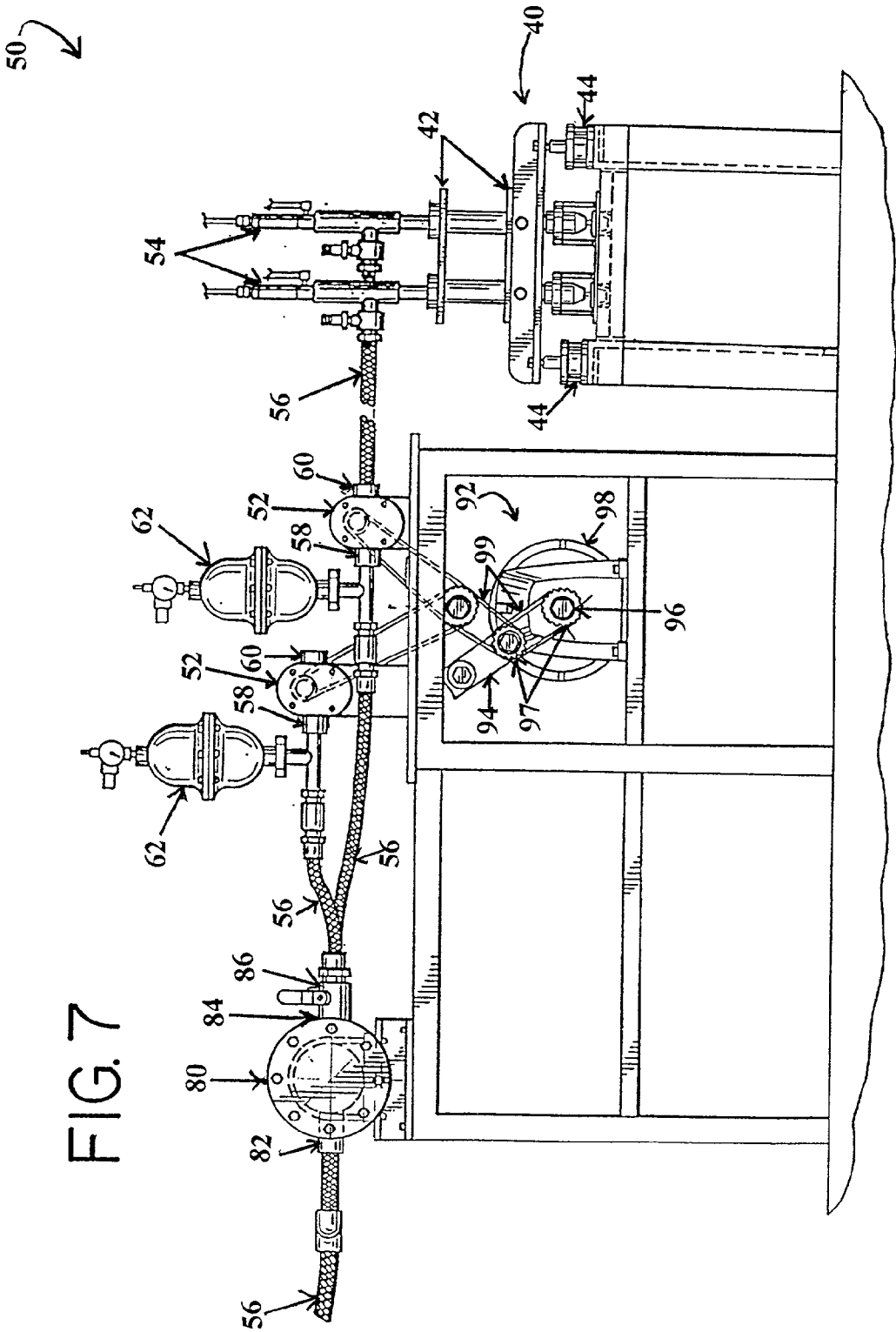


FIG. 5





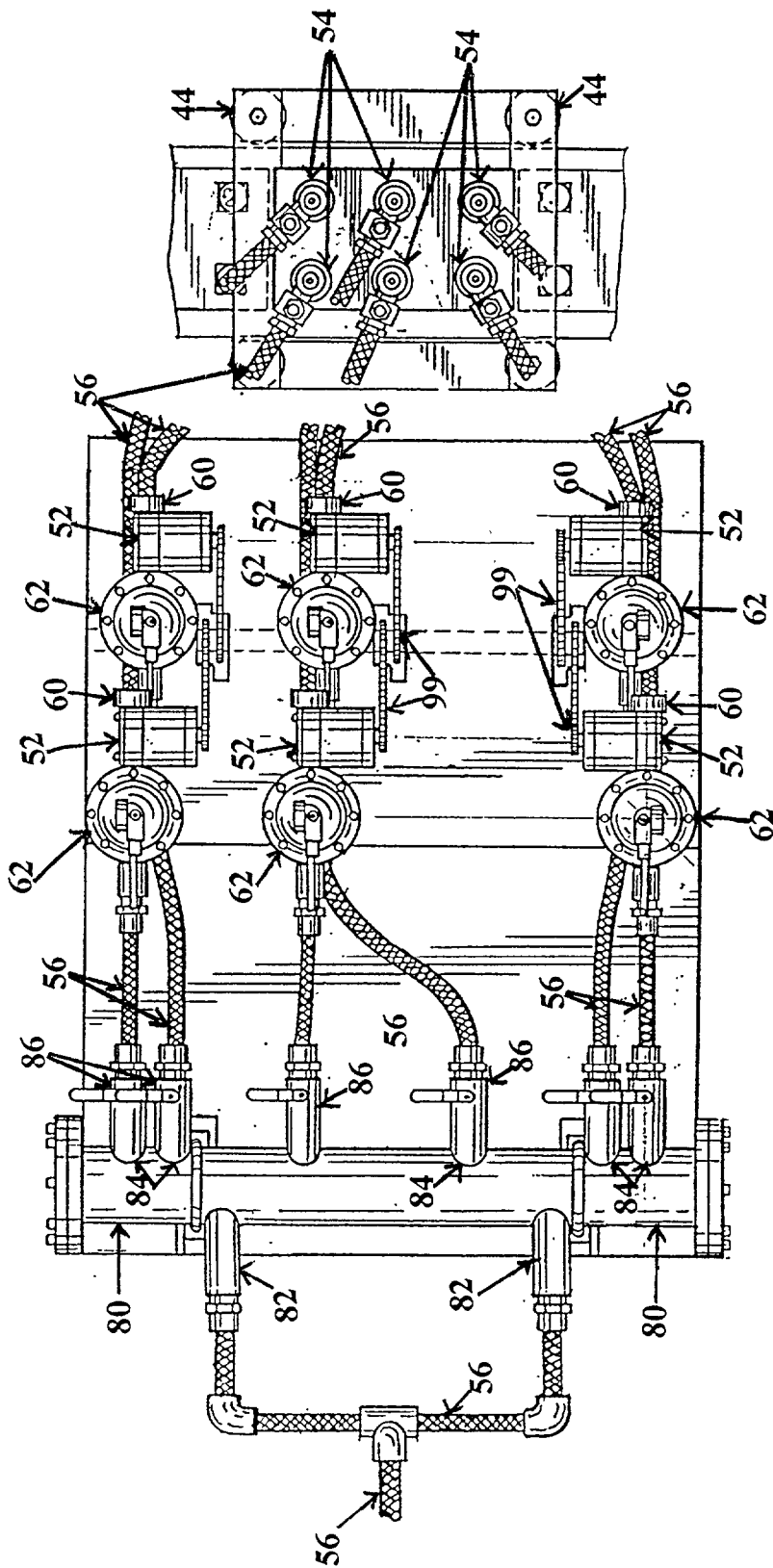
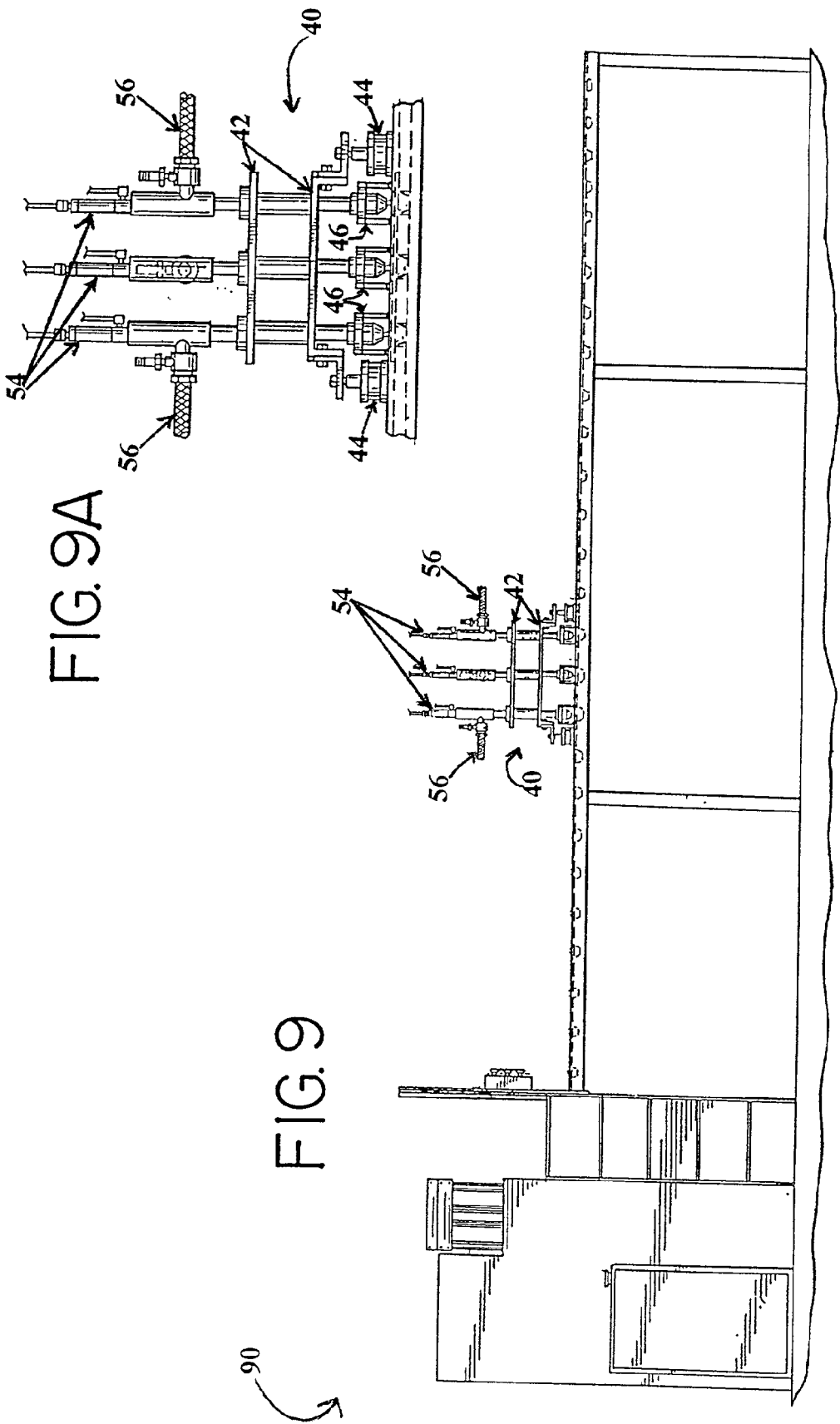
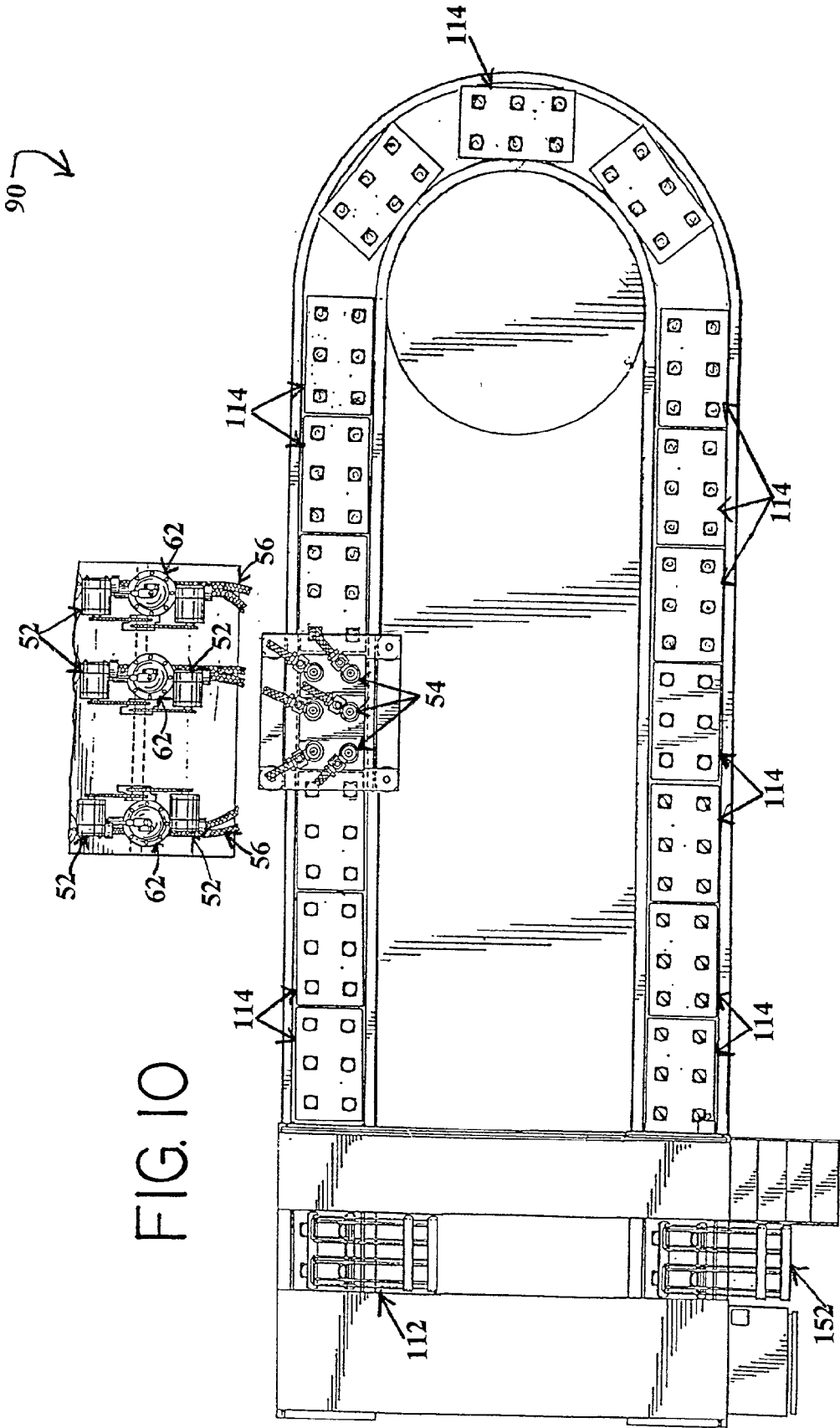


FIG. 8





SHELF-STABLE COOKIE DOUGH CONFECTION, PRODUCT, PACKAGING APPARATUS AND PROCESS

[0001] This application claims the benefit of the filing date under 35 U.S.C. § 119(e) of U.S. Provisional Application No. 60/086,561, filed May 21, 1998 which is hereby incorporated by reference.

BACKGROUND OF THE INVENTION

[0002] The present invention is directed to a shelf-stable cookie dough confection, a product comprising the shelf-stable cookie dough confection packaged in a sanitary package, an apparatus for metering and dispensing a compressible confection, and a process for packaging the compressible confection.

[0003] Traditionally, raw cookie dough was merely the intermediate product of the desired product, the baked cookie. Cookies were either made at home, or were baked and packaged for distribution. In recent years, raw cookie dough has been packaged and distributed as such, to be formed into cookies and baked at home. The cookie itself has somewhat bowed in popularity to the rich, sweet and creamy texture of conventional raw cookie dough. Conventional raw cookie dough and products containing raw cookie dough, such as cookie dough ice-cream, have become increasingly popular. Typically, these products include real eggs and flour. To decrease the danger in eating these products, egg substitutes often replace eggs. However, even with the omission of real eggs, a danger remains under moist conditions as the flour and the proteins therein provide a harbor for bacteria. To prevent microbial growth, conventional raw cookie dough and products containing raw cookie dough require refrigeration and, as such, are not shelf-stable. A shelf-stable cookie dough would therefore be of great importance.

[0004] Conventional raw cookie-dough has traditionally been packaged in what is known in the art as a chub-pack. The chub-pack, typically, comprises a thin plastic casing in the form of a tube encasing the cookie dough. Each end of the plastic casing is clinched with a metal band. Despite the bands, when not refrigerated the fat in the product can wick out of the clinched ends, resulting in exposure to air, moisture and contamination. A shelf-stable cookie dough product comprising a shelf-stable cookie dough confection packaged in a sanitary package would therefore be a great improvement.

[0005] Once a shelf-stable cookie dough confection was invented in accordance with the present invention, it was found to be compressible. In packaging processes, a compressible confection exhibits compression and relaxation phenomena. More specifically, the compression and relaxation phenomena occur when a compressible confection is initially forced to move through a process line. For example, because air cells are incorporated in an aerated fat used in the confection, the material initially does not move when pressure is applied. In fact, movement only occurs once the confection builds up a head pressure sufficient to overcome the flexing, or compressing, air cells. This is known as the compression phenomenon. Once the confection is moving, the majority of the pressure is stored in the furthest back portion of the confection in the line where pressure originated. Upon relieving the pressure to stop the flow, the

partially compressed confection returns to its original form and the confection springs forward to equalize the pressure. This is known as the relaxation phenomenon. Thus, if the product is packaged using an intermittent flow system and a finite number of units per minute to fill the packaged product, the confection will not fill on immediate command due to the compression phenomenon, nor will the flow of the confection shut off on immediate command due to the relaxation phenomenon. These phenomena lead to inconsistent flow, or weight control, of the compressible confection in the final packaged product. Thus, a compressible confection requires unconventional pumping equipment for even flow, or weight control, of the final product. An apparatus and process for metering and dispensing a compressible confection capable of overcoming the compression and relaxation phenomena would be a significant contribution to the art of confection packaging.

SUMMARY OF THE INVENTION

[0006] As noted above, a confection has been invented which has a taste and texture of raw cookie dough, but which is shelf-stable. In one aspect, the present invention is such a shelf-stable confection itself

[0007] In another aspect, the invention is a product comprising a shelf-stable confection having the taste and texture of raw cookie dough in a package, preferably a sanitary package of an individual portion of the confection.

[0008] In yet another aspect, the invention is an apparatus for metering and dispensing a compressible confection comprising at least one metering pump, the metering pump comprising an intake port and a discharge port, at least one internal bottom shutoff nozzle, at least one product line interconnecting the metering pump and the internal bottom shutoff nozzle, and a control mechanism for cyclically operating the at least one metering pump and operating the at least one internal bottom shutoff nozzle in synchronization with the metering pump such that generally constant pressure is maintained between the metering pump and the internal bottom shutoff nozzle.

[0009] In a further aspect, the invention is a process for packaging a shelf-stable confection having the taste and texture of raw cookie dough comprising the steps of loading at least one empty cup onto a packaging conveyor, conveying the at least one empty cup to a filling station, filling the at least one empty cup with the confection to form at least one filled cup, conveying the filled cup to a lid placement station, placing a lid on top of the filled cup, conveying the filled cup to a lid sealing station, and sealing the lid to the filled cup to form a packaged product.

[0010] The shelf-stable cookie dough confection itself confers an improvement over the prior art in that it requires no refrigeration. In addition, the shelf-stable cookie dough product satisfies a need unmet by the prior art for a sanitary package containing a shelf-stable cookie dough confection that protects the confection from exposure to air, moisture and contamination at room temperature. Yet another improvement over the prior art conferred by the present invention is an apparatus and process for metering and dispensing a compressible confection which is capable of overcoming the compression and relaxation phenomena exhibited in conventional processes for packaging compressible confections. These and other advantages of the

invention, as well as the invention itself, will be best understood in view of the attached drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

[0011] FIG. 1 is a block diagram of the process of packaging the shelf-stable cookie dough confection of the present invention.

[0012] FIG. 2 is a side elevational view of the apparatus for metering and dispensing the shelf-stable cookie dough confection located parallel to the filling station used with the packaging conveyor identified in FIG. 1.

[0013] FIG. 3 is an exploded view of a preferred shelf-stable cookie dough confection product produced by the process of FIG. 1.

[0014] FIG. 4 is a perspective view of the shelf-stable cookie dough confection product of FIG. 3.

[0015] FIG. 5 is a side elevational view of the displacement drum pump depicted in FIG. 2.

[0016] FIG. 6 is a top plan view of the displacement drum pump of FIG. 5.

[0017] FIG. 7 is a side elevational view of the apparatus for metering and dispensing the shelf-stable cookie dough confection depicted in FIG. 2.

[0018] FIG. 8 is a top plan view of the apparatus for metering and dispensing the shelf-stable cookie dough confection of FIG. 7.

[0019] FIG. 9 is a side elevational view of the packaging conveyor depicted in FIG. 2.

[0020] FIG. 10 is a top plan view of the packaging conveyor of FIG. 9.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0021] The present invention includes aspects drawn to a shelf-stable cookie dough product 20, as depicted in FIGS. 3 and 4, an apparatus for metering and dispensing a compressible confection 22, as depicted in FIGS. 1, 2, 5, 6, 7, 8, 9 and 10, and a process of packaging the compressible confection 10 as depicted in FIG. 1.

[0022] The shelf-stable cookie dough product 20 includes a shelf-stable cookie dough confection 22. The shelf-stable cookie dough confection 22 has a taste and texture of raw cookie dough. The confection can be made using an aerated fat, a food grade glycerine, a food grade starch and sugar.

[0023] The taste and texture of the confection is selected from, but not limited to, the group consisting of chocolate chip cookie dough flavor, peanut butter cookie dough flavor, chocolate peanut butter cookie dough flavor, sugar cookie dough flavor, chocolate cream sandwich cookie flavor, cookie and cream flavor, chocolate mint chip flavor and chocolate brownie flavor.

[0024] The aerated fat provides a light, fluffy, or doughy, texture to the confection. The aerated fat is selected from the group consisting of, but is not limited to, shortening-type fats. The preferred confection has an aerated fat composition between about 10 and 45 weight percent.

[0025] The food grade glycerine provides plasticity to the confection. Preferably, the glycerine has a percent solids level of between about 96 to about 99 percent solids. The preferred composition comprises between about 0.5 and about 10 weight percent of a food grade glycerine having a solids level of about 96 weight percent solids.

[0026] The food grade starch acts both as a drying agent and a bulking agent. As a desiccant, starch provides additional moisture protection. As a bulking agent, starch eliminates the need to use flour, a bulking agent used in conventional cookie dough confections. Flour, and the proteins found therein, typically provide a harbor for bacteria. Thus, the use of starch as a bulking agent and the attendant reduced risk of bacterial contamination confers an advantage to the relevant art. The preferred composition comprises between about 5 and about 30 weight percent of a food grade starch.

[0027] The sugar is selected from the group consisting of brown sugar, brown sugar powder, granular sugar, powder sugar and mixtures thereof. The preferred composition comprises between about 5 and about 45 weight percent sugar. More preferably, the confection comprise between about 5 and about 30 weight percent brown sugar powder, between about 5 and about 30 weight percent granular sugar, and between about 5 and about 30 weight percent powder sugar.

[0028] The preferred confection includes a food grade emulsifier. The emulsifier acts as a binding agent and is added in either a dry or a melted form. As a binding agent, the food grade emulsifier brings together the fat portions of the confection with any available moisture and provides stability to the overall confection. More specifically, the food grade emulsifier provides a dough-like texture and prevents the confection from crumbling and falling apart over time. Preferably the food grade emulsifier is selected from a group consisting of mono- and di-glycerides and propylene glycol. Most preferably the food grade emulsifier is MIVATEX 3-50. The preferred composition comprises between about 0.1 and 2 weight percent of a food grade emulsifier.

[0029] The preferred confection includes a food grade antioxidant. The antioxidant is added to prevent oxidative rancidity and to improve the shelf life. Typically, a shelf life of about nine to 12 months can be achieved. The antioxidant is added in compliance of governmental regulations as a percentage of the fat. The preferred composition comprises a food grade antioxidant at a level of about 0.02 percent by weight of the fat.

[0030] The preferred confection includes corn syrup solids. The preferred composition comprises between about 5 and about 30 weight percent corn syrup solids.

[0031] The preferred confection includes a flavoring. The flavoring is selected from, but not limited to, the group consisting of vanilla, almond, peanut butter, chocolate, mint and combinations thereof. The preferred composition comprises between about 0.05 and about 3.5 weight percent of a flavoring.

[0032] The preferred confection includes a flavored chip. The flavored chip is selected from, but not limited to, the group consisting of chocolate, peanut butter, mint, chocolate cookie, vanilla cookie, mint cookie, and brownie. Preferably, the flavored chips are fat-based. Most preferably, the fat-based flavored chips are coated. The coating prevents the

fat-based flavored chips from dissolving in the confection. The preferred composition comprises a flavored chip content of between about 0.1 and about 20 weight percent.

[0033] The preferred confection includes a stabilizer such as a cellulose-based gum. The stabilizer is added to create a creamy, doughy texture. Most preferably, the cellulose-based gum comprises hydroxypropyl methylcellulose. The preferred composition comprises between about 0.5 and about 4 weight percent of a cellulose-based gum.

[0034] The preferred confection includes a food grade salt. The preferred composition comprises between about 0.1 and 4 weight percent of a food grade salt.

[0035] The confection of the present invention is virtually moisture-free. As such, microbial growth is inhibited. The preferred confection has a water activity (A_w) level of 0.6 or less.

[0036] An example of a cookie dough confection of the preferred invention has a water activity (A_w) level of 0.6 or less and comprises about 28 weight percent of an aerated fat, about 1 weight percent of a food grade glycerine, about 0.5 weight percent of a food grade emulsifier, about 0.25 weight percent flavoring, about 0.0056 weight percent of a food grade antioxidant, about 14.75 weight percent of a food grade starch, about 13 weight percent brown sugar powder, about 12.64 weight percent granular sugar, about 10 weight percent corn syrup solids, about 9.0 weight percent powder sugar, about 7.75 weight percent chocolate flavored chips, and about 2 weight percent cellulose-based gum.

[0037] FIGS. 3 and 4 illustrate another aspect of the invention. The shelf-stable cookie dough confection product 20 comprises a shelf-stable cookie dough confection 22 in a package, preferably a sanitary package of an individual portion of the confection. The sanitary package provides a barrier to oxygen and moisture and preferably includes a cup 24, a sanitary disk 26, an eating implement 28, and a lid 30.

[0038] Most preferably the cup 24 comprises a multi-layer laminate of polystyrene, ethylvinyl alcohol and polyethylene. The eating implement 28 is choke resistant and is preferably a spoon. Most preferably the spoon has a 2½ inch length. The ideal length of 2½ inches makes the spoon small enough to fit within the cup but large enough to avoid the danger of becoming lodged in the throat of a small child. Thus, the incorporation of an eating element 28 within the packaging of the shelf-stable cookie dough confection product 20 represents a unique aspect of the present invention.

[0039] The sanitary disk 26 is placed between the shelf-stable cookie dough confection 22 and the eating implement 28. Most preferably the sanitary disk 26 is impervious to fat and comprises a foam material.

[0040] The lid 30 preferably comprises a multi-layer laminate of clay-coated paper, foil and a sealant layer. Preferably, the sealant layer (not shown) comprises high density polyethylene, ethyl acrylic acid and surlyn polymer.

[0041] FIGS. 2, 5, 6, 7, 8, 9, and 10 depict yet another aspect of the present invention. The apparatus for metering and dispensing a compressible confection 50 comprises at least one metering pump 52, at least one internal bottom shutoff nozzle 54, at least one product line 56 interconnecting the metering pump 52 and the internal bottom shutoff nozzle 54, a diving mechanism 40 for lowering and elevat-

ing the internal bottom shutoff nozzle 54, and a control mechanism (not shown) for cyclically operating the metering pump 52 and operating the internal bottom shutoff nozzle 54 and the diving mechanism 40 in synchronization with the metering pump 52. By operating the internal bottom shutoff nozzle 54 in synchronization with the metering pump 52, generally constant pressure is maintained between the metering pump 52 and the internal bottom shutoff nozzle 54. Ultimately, the compression and relaxation phenomenon of the compressible confection is minimized by maintaining a generally constant pressure between the metering pump 52 and the internal bottom shutoff nozzle 54 and a more even flow, or the weight control, of the final product is achieved.

[0042] Preferably the apparatus for metering and dispensing the compressible confection 50 includes a displacement drum pump 70 for transporting the compressible confection from a 55 gallon drum 72. The product line 56 interconnects the displacement pump 70 and the metering pump 52.

[0043] Most preferably, the apparatus comprises a manifold 80, multiple metering pumps 52, multiple internal bottom shutoff nozzles 54, a bracket 42 for supporting and spacing the multiple internal bottom shutoff nozzles 54, and multiple product lines 56 interconnecting the multiple metering pumps 52 and the multiple internal bottom shutoff nozzles 54. The manifold 80 interconnects the multiple metering pumps 52 and the displacement drum pump 70.

[0044] The metering pumps 52 of the present invention are rotary metering pumps. The rotary metering pumps 52 meter as well as transport the compressible confection to be dispensed. The rotary metering pumps 52 are electrically operated and comprise an intake port 58 and a discharge port 60. Preferably a sanitary pulse regulator 62 is attached to the intake port 58 of each rotary metering pump 52. By protecting against air pockets in the compressible confection, the pulse regulator 62 enhances the metering capability of the pump 52. Generally, the selection of lobe-type positive displacement pumps 52 achieves greater metering precision. Most preferably the lobe-type positive displacement pump is a Tri-Clover® PR3 Series Positive Rotary Pump having an intake and discharge port size of about 1 inch and having a maximum flow rate of about 2.8 GPM at 20 PSI. The PR3 pumps 52 are driven by a motor 98 driving a drive shaft 96 having multiple sprockets 97 thereon and chain drives 99 between the drive shaft sprockets 97 and the PR3 pumps 52.

[0045] The internal bottom shutoff nozzle 54 of the present invention are pneumatically operated and controlled by at least one electrical solenoid (not shown). The pneumatically operated internal bottom shutoff nozzles 54 prevent the confection from flowing out of the bottom of the nozzle as the confection relaxes. Most preferably the pneumatically operated internal bottom shutoff nozzles 54 are KALISH brand Kalishtronic Giant Internal Bottom Shutoff Nozzles comprising a nozzle size of about 1½ inches and an outlet having an inner diameter of about 1 inch. The Kalishtronic Giant Internal Bottom Shutoff Nozzles generally deliver a precise amount of the confection. By preference, a nozzle-tip collar 46 is attached to each internal bottom shutoff nozzle 54 for holding a cup 24 in place as the cup 24 is filled with a compressible confection 22. Most preferably, the nozzle-tip collar 46 comprises a collar and at least one spring attached to the collar.

[0046] The product line 56 interconnecting the metering pump 52 and the internal bottom shutoff nozzle 54 is

sanitary and flexible. Preferably, the product line **56** interconnecting the metering pump **52** and the internal bottom shutoff nozzle **54** comprises 1 inch, stainless steel braided pipe. Also by preference, the apparatus of the present invention comprises an accumulator **74** for surge protection from air pockets in the compressible confection **22**. The accumulator **74** is attached to the product line **56** between the displacement drum pump **70** and the manifold **80**. Most preferably, the product line **56** interconnecting the displacement drum pump **70** and the manifold **80** comprises 1½ inch, stainless steel braided pipe.

[0047] The manifold **80** comprises at least one inlet port **82** and preferably two inlet ports, multiple outlet ports **84** and multiple ball valves **86**. Each ball valve **86** is attached to at least one outlet port **84**. The output rate of product in finite number of units per minute can be adjusted by opening and closing the ball valves **86** and thereby operating either a single pump, product line, and shutoff nozzle or multiple metering pumps, product lines, and shutoff nozzles. Preferably, the manifold **80** includes a supplemental surge accumulator (not shown) for additional surge protection from air pockets in the compressible confection **22**. The supplemental surge accumulator (not shown) is attached at the top of the manifold **80**.

[0048] The displacement drum pump **70** is pneumatically operated, controlled by an electrical solenoid (not shown), and comprises a ram **76** and a relief spout (not shown). Most preferably the pneumatically operated displacement drum pump **70** is a Graco® King Pump with priming piston, Model 207-568 Series D, and comprises a Graco® 55 Gallon Ram, Model 207-279, and a Graco® King Air Motor, Model 207-647 Series L.

[0049] The diving mechanism **40** for lowering and elevating the multiple shutoff nozzles **54** comprises at least one pneumatically operated air cylinder **44** controlled by at least one electrical solenoid (not shown). By lowering and elevating the shutoff nozzles **54**, the diving mechanism **40** facilitates the dispensing of the compressible confection **22**. Preferably the diving mechanism **40** comprises multiple air cylinders **44** controlled by multiple electrical solenoids (not shown) wherein each air cylinder **44** is controlled by a separate electrical solenoid (not shown). Most preferably, the diving mechanism **40** is attached to the bracket **42** for supporting and spacing the internal bottom shutoff nozzles **54**.

[0050] Preferably the control mechanism (not shown) is capable of cyclically operating the metering pumps **52** and operating the shutoff nozzles **54**, the diving mechanism **40** and the displacement drum pump **70** in synchronization with the metering pumps **52**. By preference, the control mechanism (not shown) comprises a signal generating device (not shown) controlled by a packaging conveyor **90** and an electrically operated clutch breaking system **92** comprising a clutch break **94** engaging the drive shaft **96**. The clutch breaking system **92** accommodates the intermittent operation of the packaging conveyor **90** and enables the motor **98** driving the metering pumps **52** to run continuously.

[0051] Most preferably, the control mechanism (not shown) is capable of simultaneously sending a signal to the electrical solenoids controlling the bottom shutoff nozzles **54**, air cylinder **44** and displacement drum pump **70**, as well as to the clutch breaking system **92**. Upon receiving a signal

from the packaging conveyor **90**, the first electrical solenoids open the internal bottom shutoff nozzles **54**, the second electrical solenoids cause the air cylinder **44** to lower the internal bottom shutoff nozzles **54** to a fully lowered position, and the third electrical solenoid starts the displacement drum pump **70**. Meanwhile, the clutch break **94** disengages the drive shaft **96** to start the metering pumps. As the metering pumps **52** operate, the diving mechanism **40** gradually elevates the internal bottom shutoff nozzles **54**. Similarly, upon receiving a signal from the packaging conveyor **90**, the first electrical solenoids close the internal bottom shutoff nozzles **54**, the second electrical solenoids cause the air cylinder **44** to elevate the internal bottom shutoff nozzles **54** to a fully elevated position, the third electrical solenoid stops the displacement drum pump **70**. Also, the clutch break **94** engages the drive shaft **96** to stop the metering pumps **52**.

[0052] FIGS. 1, 9 and 10 depict a further aspect of the present invention. The invention is a process for packaging a shelf-stable cookie dough confection comprising the steps of loading an empty cup **24** onto a packaging conveyor **90**, conveying the empty cup **24** to a filling station **120**, filling the empty cup **24** with the shelf-stable cookie dough confection **22** to form a filled cup, conveying the filled cup to a lid placement station **150**, placing a lid **30** on top of the filled cup, conveying the filled cup to a lid sealing station **160**, and sealing the lid to the filled cup to form a packaged product **20**.

[0053] Preferably, the filling is performed using a lobe-type positive displacement pump **52** feeding the confection to an internal bottom shutoff nozzle **54**. Also by preference, the process includes the steps of conveying the filled cup to a disk insert station **130** and inserting a disk **26** before the filled cup is conveyed to the lid placement station **150**. The disk is tapped to settle the shelf-stable cookie dough confection **22** within the filled cup. By preference a pick and place machine (not shown) is used to insert and tap the disk **26**. Next, the filled cup is conveyed to an eating implement placement station **140** and an eating implement **28** is placed in the filled cup. After the lid **30** is sealed to the filled cup, the process includes the steps of conveying the packaged product **20** to a packaged product removal station **170** and removing the packaged product **20** from the packaging conveyor **90**.

[0054] Most preferably the packaging conveyor **90** of the present invention is an Alloyd brand Blister Pack Machine, Model 18SC1216 Carousel and comprises a cup loading station **100**, nesting trays **114**, a filling station **120**, a disk insert station **130**, a spoon placement station **140**, a lid placement station **150**, a lid sealing station **160**, and a packaged product removal station **170**.

[0055] More specifically, the cup loading station **100** comprises a first magazine **112**, or cup feeder magazine, (FIG. 10), an adjustable cup suction assembly (not shown) to pull the cups from the cup feeder magazine **112** and place them on the nesting trays **114**. The cup feeder magazine **112** and the adjustable cup suction assembly are mounted on the packaging conveyor **90** at the cup loading station **100**.

[0056] In the preferred invention the packaging conveyor comprises multiple nesting trays **114**. The nesting tray **114** comprises an aperture into which the cup is loaded. Preferably each nesting tray comprises multiple apertures into

which multiple cups are loaded. Most preferably the multiple apertures comprise a configuration having two rows of three apertures.

[0057] In the preferred invention the filling station 120 comprises the apparatus for metering and dispensing a compressible confection 50. The disk insert station 130 preferably includes a pick and place machine (not shown). Also by preference, a spoon 28 is manually placed in the filled cup at the spoon placement station 140.

[0058] In the preferred invention the lid placement station 150 comprises a second magazine 152, or lid feeder magazine, an adjustable lid suction assembly (not shown) to pull the lids from the lid feeder magazine 152 and place them on the filled cups. The lid feeder magazine 152 and the adjustable lid suction assembly are mounted on the packaging conveyor 90 at the lid placement station 150.

[0059] In the preferred invention the lid sealing station 160 comprises a heat plate (not shown) and a pressure anvil (not shown) for heat sealing the lid 30 to the filled cup. Preferably, the packaged product removal station 170 comprises an adjustable eject station assembly (not shown) to lift the sealed packages off of the nesting trays 114 and place them onto the discharge chute (not shown) to exit away from the packaging conveyor 90.

[0060] In the process of the preferred invention, the packaging conveyor 90 operates intermittently and in synchronization with the apparatus for metering and dispensing a compressible confection 50. Most preferably, the packaging conveyor 90 conveys for about 1 second and stops for about 3 seconds. Meanwhile, the apparatus for metering and dispensing a compressible confection 50 fills at least one empty cup at the cup filling station within about 3 seconds.

[0061] It should be appreciated that the compositions, apparatus and methods of the present invention are capable of being incorporated in the form of a variety of embodiments, only a few of which have been illustrated and described above. The invention may be embodied in other forms without departing from its spirit or essential characteristics. It will be appreciated that the addition of some other ingredients, process steps, materials or components not specifically included may have an adverse impact on the present invention. The best mode of the invention may therefore exclude ingredients, process steps, materials or components other than those listed above for inclusion or use in the invention. However, the described embodiments are to be considered in all respects only as illustrative and not restrictive, and the scope of the invention is, therefore, indicated by the appended claims rather than by the foregoing description. All changes that come within the meaning and range of equivalency of the claims are to be embraced within their scope.

What is claimed is:

1. A shelf-stable confection having a taste and a texture of raw cookie dough.
2. The confection of claim 1 having a water activity (A_w) level of 0.6 or less.
3. The confection of claim 1 comprising between about 10 and about 45 weight percent of an aerated fat.
4. The confection of claim 1 comprising between about 0.5 and about 10 weight percent of a food grade glycerine.

5. The confection of claim 4 wherein the glycerine has a percent solids level of between about 96 and about 99 percent solids.

6. The confection of claim 1 comprising between about 0.1 and about 2 weight percent of a food grade emulsifier.

7. The confection of claim 6 wherein the emulsifier is selected from the group consisting of mono- and di-glycerides and propylene glycol.

8. The confection of claim 1 comprising a fat and a food grade antioxidant at a level of about 0.02 percent by weight of the fat.

9. The confection of claim 1 comprising between about 0.05 and about 3.5 weight percent of a flavoring.

10. The confection of claim 1 comprising between about 5 and about 30 weight percent of a food grade starch.

11. The confection of claim 1 comprising between about 5 and about 30 weight percent corn syrup solids.

12. The confection of claim 1 comprising between about 5 and about 45 weight percent sugar.

13. The confection of claim 11 wherein the sugar is selected from the group consisting of brown sugar, brown sugar powder, granular sugar, powder sugar and mixtures thereof.

14. The confection of claim 12 comprising between about 5 and about 30 weight percent brown sugar powder.

15. The confection of claim 12 comprising between about 5 and about 30 weight percent granular sugar.

16. The confection of claim 12 comprising between about 5 and about 30 weight percent powder sugar.

17. The confection of claim 1 comprising a flavored chip content of between about 0.1 and about 20 weight percent.

18. The confection of claim 17 wherein the flavored chips are fat-based.

19. The confection of claim 18 wherein the flavored chips are coated.

20. The confection of claim 17 wherein the flavored chips are chocolate flavored.

21. The confection of claim 1 comprising between about 0.5 and about 4 weight percent of a cellulose-based gum.

22. The confection of claim 21 wherein the cellulose based gum comprises hydroxypropyl methylcellulose.

23. The confection of claim 1 comprising between about 0.1 and about 4 weight percent of a food grade salt.

24. The confection of claim 1 comprising:

- a) between about 10 and about 45 weight percent of an aerated fat;
- b) between about 0.5 and about 10 weight percent of a food grade glycerine;
- c) between about 5 and about 30 weight percent of a food grade starch; and

d) between about 5 and about 45 weight percent sugar.

25. The confection of claim 1 having a water activity (A_w) level of 0.6 or less and comprising:

- a) about 28 weight percent of an aerated fat,
- b) about 1 weight percent of a food grade glycerine,
- c) about 0.5 weight percent of a food grade emulsifier,
- d) about 0.25 weight percent flavor,
- e) about 0.0056 weight percent of a food grade antioxidant,

- f) about 14.75 weight percent of a food grade starch,
- g) about 13 weight percent brown sugar powder,
- h) about 12.64 weight percent granular sugar,
- i) about 10 weight percent corn syrup solids,
- j) about 9.0 weight percent powder sugar,
- k) about 7.75 weight percent chocolate chips,
- l) about 2 weight percent cellulose-based gum and
- m) about 1.1 weight percent of a food grade salt.
- 26. The confection of claim 1 wherein the confection is chocolate chip cookie dough flavor.
- 27. The confection of claim 1 wherein the confection is peanut butter cookie dough flavor.
- 28. The confection of claim 1 wherein the confection is sugar cookie dough flavor.
- 29. The confection of claim 1 wherein the confection is chocolate cream sandwich cookie flavor.
- 30. The confection of claim 1 wherein the confection is cookie and cream flavor.
- 31. The confection of claim 1 wherein the confection is chocolate mint chip flavor.
- 32. The confection of claim 1 wherein the confection is brownie flavor.
- 33. A product comprising the confection of claim 1 in a package.
- 34. The product of claim 33 wherein the package is resistant to oxygen and moisture.
- 35. The product of claim 34 wherein the package comprises a multi-layer laminate of polystyrene, ethylvinyl alcohol and polyethylene.
- 36. The product of claim 33 wherein the package comprises a cup.
- 37. The product of claim 36 wherein the package further comprises a lid.
- 38. The product of claim 37 wherein the lid comprises a multi-layer laminate of clay-coated paper, foil and a sealant layer, the sealant layer comprising high density polyethylene, ethyl acrylic acid and surlyn polymer.
- 39. The product of claim 33 wherein the package contains an eating implement.
- 40. The product of claim 39 wherein the package comprises a sanitary disk placed between the confection and the eating implement.
- 41. The product of claim 40 wherein the sanitary disk comprises a foam material; the foam material being impervious to fat.
- 42. The product of claim 39 wherein the eating implement is choke resistant.
- 43. The product of claim 42 wherein the eating implement is a spoon.
- 44. The product of claim 43 wherein the spoon has a 2½ inch length.
- 45. An apparatus for metering and dispensing a compressible confection comprising:
 - a) at least one metering pump; the metering pump comprising an intake port and a discharge port;
 - b) at least one internal bottom shutoff nozzle;
 - c) at least one product line interconnecting the metering pump and the internal bottom shutoff nozzle; and

- d) a control mechanism for cyclically operating the at least one metering pump and operating and the at least one internal bottom shutoff nozzle in synchronization with the metering pump such that generally constant pressure is maintained between the metering pump and the internal bottom shutoff nozzle.
- 46. The apparatus of claim 45 comprising at least one pulse regulator attached to the intake port of the metering pump.
- 47. The apparatus of claim 46 wherein the pulse regulator is sanitary.
- 48. The apparatus of claim 45 comprising a diving mechanism for lowering and elevating the at least one internal bottom shutoff nozzle, the control mechanism is capable of operating the diving mechanism in synchronization with the metering pump.
- 49. The apparatus of claim 48 comprising a bracket for supporting the at least one internal bottom shutoff nozzle and interconnecting the diving mechanism and the at least one internal bottom shutoff nozzle.
- 50. The apparatus of claim 48 wherein the diving mechanism comprises at least one air cylinder.
- 51. The apparatus of claim 45 wherein the control mechanism comprises a clutch breaking system.
- 52. The apparatus of claim 45 wherein the metering pump comprises a lobe-type positive displacement pump.
- 53. The apparatus of claim 52 wherein the lobe-type positive displacement pump has a maximum flow rate of 2.8 GPM at 20 PSI.
- 54. The apparatus of claim 45 comprising a motor to drive the metering pump.
- 55. The apparatus of claim 45 wherein the internal bottom shutoff nozzle comprises a nozzle tip collar for holding a cup in place as the cup is filled with the compressible confection.
- 56. The apparatus of claim 55 wherein the nozzle tip collar comprises a collar and at least one spring.
- 57. The apparatus of claim 45 wherein the internal bottom shutoff nozzle has an outlet with an inner diameter of about 1 inch.
- 58. The apparatus of claim 45 wherein the product line is sanitary.
- 59. The apparatus of claim 58 wherein the product line is flexible.
- 60. The apparatus of claim 59 wherein the product line is stainless steel braided pipe.
- 61. The apparatus of claim 45 comprising multiple metering pumps.
- 62. The apparatus of claim 61 comprising multiple internal bottom shutoff nozzles.
- 63. The apparatus of claim 61 comprising multiple product lines.
- 64. The apparatus of claim 45 wherein the control mechanism is capable of cyclically operating multiple metering pumps and operating multiple internal bottom shutoff nozzles in synchronization with the multiple metering pumps.
- 65. The apparatus of claim 45 comprising multiple pulse regulators.
- 66. The apparatus of claim 63 further comprising a manifold comprising at least one inlet port and multiple outlet ports, the manifold interconnecting the multiple outlet ports to the multiple product lines.

67. The apparatus of claim 66 wherein the manifold comprises multiple ball valves wherein each ball valve is attached to at least one outlet port of the manifold.

68. The apparatus of claim 67 wherein the multiple product lines interconnect the ball valves and the intake ports of the multiple metering pumps.

69. The apparatus of claim 66 comprising a supplemental surge accumulator.

70. The apparatus of claim 69 wherein the supplemental surge accumulator is attached adjacent the manifold inlet port for additional surge protection from air pockets in the compressible confection.

71. An apparatus for metering and dispensing a compressible confection comprising:

- a) at least one electrically operated rotary metering pump comprising:
 - i) an intake port,
 - ii) a discharge port, and
 - iii) a chain drive;
- b) at least one pneumatically operated internal bottom shutoff nozzle controlled by at least one first electrical solenoid and supported by a bracket;
- c) at least one nozzle tip collar comprising a collar and at least one spring for holding a cup in place as the cup is filled with the compressible confection dispensed from the internal bottom shutoff nozzle;
- d) a diving mechanism comprising at least one pneumatically operated air cylinder controlled by at least one second electrical solenoid and attached to the bracket for lowering and elevating the at least one pneumatically operated internal bottom shutoff nozzle;
- e) a product line interconnecting the electrically operated rotary metering pump and the pneumatically operated internal bottom shutoff nozzle;
- f) a control mechanism for cyclically operating the at least one electrically operated rotary metering pump and operating the at least one pneumatically operated internal bottom shutoff nozzle in synchronization with the rotary metering pump such that constant pressure is maintained between the electrically operated rotary metering pump and the pneumatically operated internal bottom shutoff nozzle, the control mechanism being capable of operating the diving mechanism in synchronization with the electrically operated rotary metering pump;
- g) a drive shaft comprising at least one sprocket engaging the chain drive of the electrically operated rotary metering pump; and
- h) a motor driving the drive shaft.

72. The apparatus of claim 71 comprising at least one pulse regulator attached to the intake port of the rotary metering pump.

73. The apparatus of claim 71 wherein the pulse regulator is sanitary.

74. The apparatus of claim 71 wherein the control mechanism comprises:

- a) a signal generating device controlled by a packaging conveyor; and

b) an electrically operated clutch breaking system comprising a clutch break engaging the drive shaft.

75. The apparatus of claim 74 wherein the control mechanism is capable of simultaneously sending a signal to at least one first electrical solenoid, at least one second electrical solenoid and the clutch breaking system.

76. The apparatus of claim 75 wherein the first electrical solenoid is capable of receiving the signal and opening the internal bottom shutoff nozzle.

77. The apparatus of claim 76 wherein the second electrical solenoid is capable of receiving the signal and lowering the at least one internal bottom shutoff nozzle to a fully lowered position.

78. The apparatus of claim 77 wherein the clutch breaking system is capable of receiving the signal and starting the rotary metering pump.

79. The apparatus of claim 78 wherein the clutch break is capable of disengaging the drive shaft to start the rotary metering pump.

80. The apparatus of claim 78 wherein the diving mechanism is capable of gradually elevating the at least one internal bottom shutoff nozzle as the rotary metering pump operates.

81. The apparatus of claim 75 wherein the first electrical solenoid is capable of receiving the signal and closing the internal bottom shutoff nozzle.

82. The apparatus of claim 81 wherein the second electrical solenoid is capable of receiving the signal and elevating the internal bottom shutoff nozzle to a fully upright position.

83. The apparatus of claim 81 wherein the clutch breaking system is capable of receiving the signal and stopping the rotary metering pump.

84. The apparatus of claim 82 wherein the clutch break is capable of engaging the drive shaft to stop the rotary metering pump.

85. The apparatus of claim 71 wherein the rotary metering pump comprises a lobe-type positive displacement pump.

86. An apparatus for metering and dispensing a compressible confection comprising:

- a) a pneumatically operated displacement drum pump which comprises a ram and a relief spout and is controlled by a third electrical solenoid;
- b) a manifold which comprises:
 - i) at least one inlet port,
 - ii) multiple outlet ports,
 - iii) multiple ball valves wherein each ball valve is attached to at least one outlet port, and
 - iv) a supplemental surge accumulator for additional surge protection from air pockets in the compressible confection;
- c) a product line connected at one end to the displacement drum pump and at the other end to the at least one manifold inlet port;
- d) an accumulator attached to the product line between the displacement drum pump and the manifold;
- e) multiple lobe-type positive displacement pumps each comprising an intake port and a discharge port, the pumps being driven by a motor driving a drive shaft

having multiple sprockets thereon and chain drives between the drive shaft sprockets and the pumps;

- f) multiple sanitary pulse regulators wherein each sanitary pulse regulator is attached to the intake port of at least one lobe-type positive displacement pump;
- g) multiple first flex-lines wherein each first flex-line is connected at one end to one of said ball valves and at the other end to one of said pump intake ports;
- h) multiple pneumatically operated internal bottom shutoff nozzles;
- i) multiple nozzle-tip collars wherein each nozzle-tip collar comprises a collar and at least one spring mounted to the collar for holding a cup in place as the cup is filled with the compressible confection, the nozzle tip collar being attached to the pneumatically operated internal bottom shutoff nozzle;
- j) multiple first electrical solenoids wherein each first electrical solenoid controls at least one pneumatically operated internal bottom shutoff nozzle;
- k) a bracket for supporting and spacing the multiple pneumatically operated internal bottom shutoff nozzles;
- l) a diving mechanism for lowering and elevating the multiple internal bottom shutoff nozzles comprising at least one pneumatically operated air cylinder controlled by at least one second electrical solenoid and is attached beneath the bracket;
- m) multiple second flex-lines wherein each second flex-line is connected at one end to one of said pump discharge ports and at the other end to one of said internal bottom shutoff nozzles; and
- n) a control mechanism for synchronously operating the displacement drum pump, the multiple lobe-type positive displacement pumps and the multiple internal bottom shutoff nozzles such that generally constant pressure is maintained between each multiple lobe-type positive displacement pump and shutoff nozzle, the control mechanism also being capable of operating the diving mechanism in synchronization with they rotary metering pump.

87. The apparatus of claim 86 wherein the control mechanism comprises:

- a) a signal generating device controlled by a packaging conveyor; and
- b) an electrically operated clutch breaking system comprising a clutch break engaging the drive shaft.

88. The apparatus of claim 87 wherein the control mechanism is capable of simultaneously sending a signal to the first electrical solenoids, the second electrical solenoids, the third electrical solenoid and the clutch breaking system.

89. The apparatus of claim 88 wherein the first electrical solenoid is capable of receiving the signal and opening the internal bottom shutoff nozzle.

90. The apparatus of claim 89 wherein the second electrical solenoid is capable of receiving the signal and lowering the at least one internal bottom shutoff nozzle to a fully lowered position.

91. The apparatus of claim 90 wherein third electrical solenoid is capable of receiving the signal and starting the pneumatically operated displacement drum pump.

92. The apparatus of claim 91 wherein the clutch breaking system is capable of receiving the signal and starting the rotary metering pump.

93. The apparatus of claim 92 wherein the clutch break is capable of disengaging the drive shaft to start the rotary metering pump.

94. The apparatus of claim 93 wherein the diving mechanism is capable of gradually elevating the at least one internal bottom shutoff nozzle as the rotary metering pump operates.

95. The apparatus of claim 88 wherein the first electrical solenoid is capable of receiving the signal and closing the internal bottom shutoff nozzle.

96. The apparatus of claim 95 wherein the second electrical solenoid is capable of receiving the signal and elevating the internal bottom shutoff nozzle to a fully upright position.

97. The apparatus of claim 96 wherein the third electrical solenoid is capable of receiving the signal and stopping the pneumatically operated displacement drum pump.

98. The apparatus of claim 97 wherein the clutch breaking system is capable of receiving the signal and stopping the rotary metering pump.

99. The apparatus of claim 98 wherein the clutch break is capable of engaging the drive shaft to stop the rotary metering pump.

100. The apparatus of claim 86 wherein the product line comprises 1 inch stainless steel pipe.

101. The apparatus of claim 86 wherein the manifold comprises 4 inch stainless steel pipe.

102. The apparatus of claim 86 wherein the first and second flex-lines comprise 1 inch stainless steel braided pipe.

103. The apparatus of claim 86 wherein the internal bottom shutoff nozzles comprise a 1 inch inner diameter outlet.

104. The apparatus of claim 86 wherein each of the lobe-type positive displacement pumps has a maximum output rate of 2.8 GPM at 20 PSI.

105. The apparatus of claim 86 wherein the motor comprises an electrical motor.

106. A process for packaging the product of claim 1 comprising the steps of:

- a) loading at least one empty cup onto a packaging conveyor;
- b) conveying the at least one empty cup to a filling station;
- c) filling the at least one empty cup with the product of claim 1 to form at least one filled cup;
- d) conveying the filled cup to a lid placement station;
- e) placing a lid on top of the filled cup;
- f) conveying the filled cup to a lid sealing station; and
- g) sealing the lid to the filled cup to form a packaged product.

107. The process of claim 106 further comprising between steps c) and d) the steps of:

- a) conveying the filled cup to a disk insert station; and
- b) inserting a disk.

108. The process of claim 107 further comprising the step of tapping the disk to settle the product of claim 1 within the filled cup.

109. The process of claim 106 further comprising before steps d, the steps of:

- a) conveying the filled cup to an eating implement placement station; and
- b) placing an eating implement in the filled cup.

110. The process of claim 106 further comprising the steps of:

- a) conveying the packaged product to a packaged product removal station; and
- b) removing the packaged product from the packaging conveyor.

111. The process of claim 106 wherein the filling is performed using a lobe-type positive displacement pump feeding product to an internal bottom shutoff nozzle.

112. The process of claim 109 wherein the lid placement is performed by a pick and place machine inserting and tapping the disk.

113. The process of claim 106 wherein the lids are heat sealed at the lid sealing station.

114. The process of claim 106 wherein the packaging conveyor comprises at least one nesting tray; the nesting tray having an aperture into which the cup is loaded.

115. The process of claim 114 wherein the packaging conveyor comprises multiple nesting trays.

116. The process of claim 115 wherein the nesting tray comprises multiple apertures into which multiple cups are loaded.

117. The process of claim 116 wherein the multiple apertures comprise a configuration having two rows of three apertures.

118. The process of claim 106 wherein the packaging conveyor comprises a first magazine and a second magazine.

119. The process of claim 118 wherein the first magazine hold the cups to be loaded onto the packaging conveyor.

120. The process of claim 119 wherein the second magazine hold the lids to be placed on top of the filled cup.

121. The process of claim 120 wherein the packaging conveyor comprises a blister pack machine.

122. The process of claim 106 wherein the packaging conveyor operates intermittently.

123. The process of claim 122 wherein the packaging conveyor operates in synchronization with the apparatus of claim 45.

124. The process of claim 123 wherein the packaging conveyor conveys for about 1 second and stops for about 3 seconds.

125. The process of claim 124 wherein the apparatus of claim 45 fills at least one empty cup at the cup filling station within about 3 seconds.

* * * * *