



(12) **EUROPEAN PATENT APPLICATION**

(43) Date of publication:
28.06.2006 Bulletin 2006/26

(51) Int Cl.:
B65B 55/24 (2006.01) **B65B 61/18** (2006.01)
B08B 5/02 (2006.01)

(21) Application number: **04425943.0**

(22) Date of filing: **23.12.2004**

(84) Designated Contracting States:
**AT BE BG CH CY CZ DE DK EE ES FI FR GB GR
HU IE IS IT LI LT LU MC NL PL PT RO SE SI SK TR**
Designated Extension States:
AL BA HR LV MK YU

(72) Inventor: **Viola, Massimo**
41058 Vignola (IT)

(74) Representative: **Franzolin, Luigi et al**
STUDIO TORTA S.r.l.,
Via Viotti, 9
10121 Torino (IT)

(71) Applicant: **Tetra Laval Holdings & Finance S.A.**
1009 Pully (CH)

(54) **Machine for packaging pourable food products**

(57) There is described a machine (1) for packaging pourable food products, having a feed station (4) for feeding a sheet packaging material (3) along a predetermined forming path (P), along which the packaging material (3)

is transformed into a succession of sealed packages (2); the machine has impurity removing means (15) for removing any impurities on the packaging material (3), and located downstream from the feed station (4) along the forming path (P).

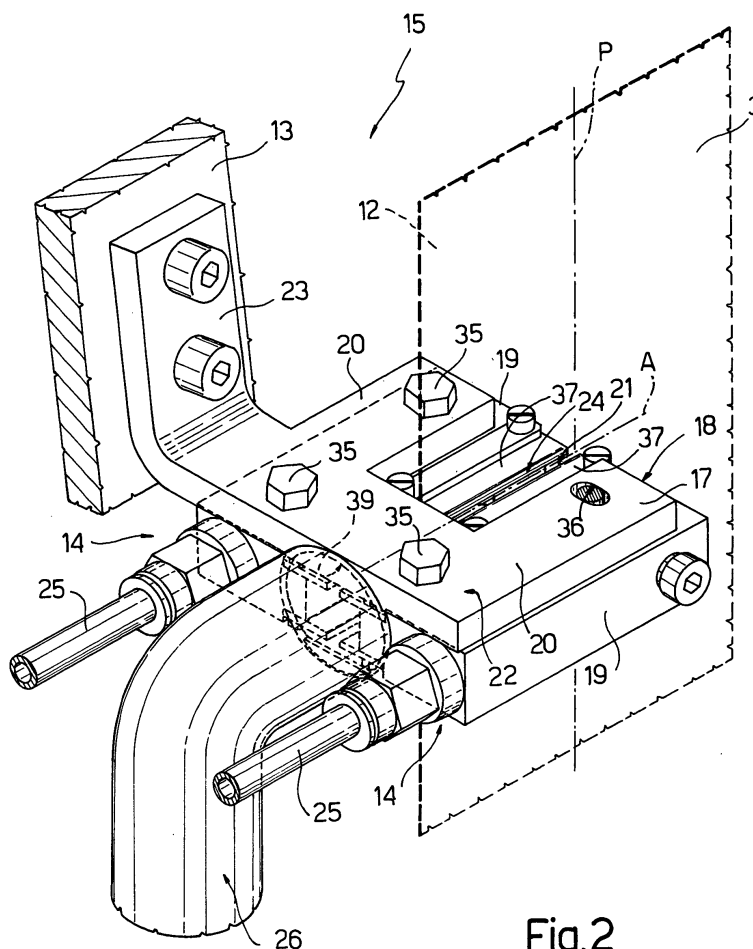


Fig.2

Description

[0001] The present invention relates to a machine for packaging pourable food products.

[0002] As is known, many pourable food products, such as fruit juice, pasteurized or UHT (ultra-high-temperature treated) milk, wine, tomato sauce, etc., are sold in packages made of sterilized packaging material.

[0003] A typical example of this type of package is the parallelepiped-shaped package for liquid or pourable food products known as Tetra Brik Aseptic (registered trademark), which is made by folding and sealing normally laminated strip packaging material. The laminated packaging material comprises layers of fibrous material, e.g. paper, covered on both sides with heat-seal plastic material, e.g. polyethylene. In the case of aseptic packages, the side of the packaging material eventually contacting the food product in the package also has a layer of oxygen-barrier material, e.g. aluminium foil or a layer of EVOH, which in turn is covered with a layer of heat-seal plastic material.

[0004] Packaging machines for producing packages of the above type are known, in which the web of packaging material is unwound off a reel and fed along a predetermined path by rollers and guide members or similar.

[0005] Along the path, the web of packaging material is fed through an aseptic environment where it is sterilized by applying a liquid sterilizing agent such as hydrogen peroxide, which is subsequently evaporated by heating and/or by radiation of appropriate wavelength and intensity.

[0006] The web of packaging material is then fed through a sterile chamber, in which it is maintained in a sterile-air environment and fed vertically through a number of successive forming assemblies, which interact with the packaging material to fold it gradually from strip form into the form of a cylinder. The forming assemblies normally comprise respective roller folding members defining a number of compulsory passages for the packaging material varying gradually in section from an open C to a substantially circular section.

[0007] The folding members interact with the web of packaging material to superimpose opposite lateral portions of the web, which are then heat sealed to form a tube of packaging material.

[0008] Beforehand, a sealing strip of heat-seal plastic material is applied to a longitudinal edge of the inner plastic layer of the packaging material, and the packaging material is heat sealed along the strip to form said tube.

[0009] The tube is then filled with the sterilized or sterile-processed food product, and is sealed and subsequently cut along equally spaced cross sections to form pillow packs, which are folded mechanically to form respective finished packages of predetermined shape.

[0010] Alternatively, the packaging material may be cut into blanks, which are formed into packages on forming spindles, and the packages are filled with the food product and sealed. One example of this type of package

is the so-called "gable-top" package known by the trade name Tetra Rex (registered trademark).

[0011] Packages of the type briefly described above are normally fitted with opening devices by which to unseal the package and pour out the food product.

[0012] One known opening device comprises a "pull tab", which is applied over a hole in the packaging material, and is removable to open the package.

[0013] In one known production method, a succession of holes is formed in the strip packaging material, and, on the side eventually facing inwards of the package, the holes are sealed with respective "patches" defined by small sheets of heat-seal plastic material. The pull tabs are applied on the opposite side of the packaging material, and are heat sealed to the respective patches, so that respective free grip portions project from the packaging material.

[0014] The pull tabs comprise an aluminium oxygen-barrier layer; and a layer of heat-seal plastic material, normally polyethylene, which is sealed to the patch. Consequently, when the pull tab is pulled off, the part of the patch sealed to the tab is pulled off with it, thus exposing the hole.

[0015] Alternatively, the pull tabs may be applied directly to a so-called "prelaminated" hole in the packaging material, i.e. a hole formed in the layer of fibrous material, before this is covered with the other packaging material layers, which close the hole hermetically and aseptically, while at the same time being easily pierced.

[0016] In both cases, the pull tabs are normally applied flat to the packaging material, and are subsequently folded to superimpose the free grip portion on the portion sealed to the packaging material. The folding operation is performed in two steps: a first step, in which the grip end is raised with respect to the packaging material by an air jet directed parallel to the plane of the material and crosswise to its travelling direction; and a second step, in which the raised tab is folded mechanically by contact with appropriately shaped guide surfaces.

[0017] Though highly reliable and efficient, machines of the type described still leave room for further improvement.

[0018] In particular, the Applicant has observed that deposits of waste particles, such as polyethylene fibres and dust, on the packaging material may result in malfunctioning of the stations downstream from the reel, particularly those for applying the longitudinal sealing strip to the edge of the packaging material web, and for folding the pull tabs.

[0019] It is an object of the present invention to provide a machine for packaging pourable food products, designed to eliminate the aforementioned drawback.

[0020] According to the present invention, there is provided a machine for packaging pourable food products, as claimed in Claim 1.

[0021] A preferred, non-limiting embodiment of the present invention will be described by way of example with reference to the accompanying drawings, in which:

Figure 1 shows a schematic view in perspective of a machine for packaging pourable food products in accordance with the present invention;

Figure 2 shows a larger-scale view in perspective of a detail in Figure 1;

Figure 3 shows a front view of the Figure 2 detail;

Figure 4 shows a section along line IV-IV in Figure 3;

Figure 5 shows a top plan view of the Figure 2 detail.

[0022] Number 1 in Figure 1 indicates as a whole a packaging machine for continuously producing sealed packages 2 of a pourable food product, such as pasteurized or UHT milk, fruit juice, wine, etc., from a web 3 of packaging material unwound off a reel 4 and fed along a forming path P.

[0023] More specifically, web 3 is guided along path P by guide members 5, e.g. rollers or similar, and is fed successively through a number of work stations, of which are shown schematically : a station 6 for applying a longitudinal sealing strip to web 3; a station 7 for folding removable opening devices (known in itself and not shown) applied beforehand to web 3; and a station 8 for forming packages 2 from web 3.

[0024] Stations 6, 7 and 8 are all known and are only described briefly below as required for a clear understanding of the present invention.

[0025] More specifically, station 6 applies a sealing strip of heat-seal plastic material (not shown) to a longitudinal edge 12 of web 3, which is then heat sealed along the sealing strip, inside station 8, to define a vertical tube 11.

[0026] Station 7 acts on the removable opening devices applied to web 3 to set them to the as-used configuration, i.e. to the configuration in which they can be pulled off by the user.

[0027] Station 8 comprises a fill device 9 for continuously pouring the sterilized or sterile-processed food product into tube 11 of packaging material; and a jaw-type forming assembly (not shown) for gripping, sealing, and cutting tube 11 along equally spaced cross sections to form a succession of packages 2.

[0028] According to an important aspect of the present invention, machine 1 also comprises a cleaning device 15 for removing any impurities from web 3, and located along path P, downstream from reel 4.

[0029] Device 15 is preferably interposed between reel 4 and station 6.

[0030] With particular reference to Figure 2, device 15 comprises a supporting bracket 18 fixed to a portion 13 of a supporting structure (not shown as a whole) of machine 1; and two fluid, preferably air, dispensing units 14 fitted to bracket 18 and acting on opposite sides of web 3 - in the example shown, at longitudinal edge 12 - to remove any impurities from web 3.

[0031] More specifically, bracket 18 comprises a first portion 23 substantially in the form of a rectangular plate and fixed to portion 13 of the supporting structure of machine 1; and a second portion 17 in the form of a C-shaped

plate, lying in a plane substantially perpendicular to that of portion 23, and integrally supporting units 14.

[0032] More specifically, portion 17 comprises two parallel arms 20 separated to permit passage of web 3; and a portion 22 connecting arms 20, and from which portion 23 projects in the form of an extension.

[0033] Each unit 14 comprises a plate 19 secured to a respective arm 20 of bracket 18; a conduit 16 formed inside plate 19 to create an air stream by which to remove any impurities from web 3; and a blower 25 communicating fluidically with conduit 16 and supplied with air in a manner not shown.

[0034] Plates 19 are substantially prismatic, are parallel to each other, and are symmetrical with respect to an axis A, which, in use, is perpendicular to path P and parallel to the plane of web 3.

[0035] Towards axis A, plates 19 have respective lateral walls 24 defining a substantially prismatic chamber 21 through which web 3 is fed in use.

[0036] More specifically, chamber 21 communicates along axis A, on one side, with the outside atmosphere to permit passage of web 3 along path P, and, on the opposite side, with a waste conduit 26 for collecting the impurities removed from web 3 by both assemblies 14.

[0037] Each blower 25 projects from respective plate 19 on the axially opposite side to web 3.

[0038] Each conduit 16 (Figure 4) is formed inside a respective plate 19, is connected fluidically to respective blower 25 by a respective inlet section 38, and comprises, from inlet section 38 to chamber 21, a first portion 32 parallel to axis A, a second portion 33 perpendicular to axis A, and a third portion 34 having a narrower air flow section than portions 32 and 33.

[0039] Each portion 34 is inclined with respect to axis A towards waste conduit 26, and feeds air directly into chamber 21 to remove and direct to waste conduit 26 any impurities on both faces of web 3 facing plates 19.

[0040] Each portion 34 communicates fluidically with chamber 21 by means of a respective recess 27 formed in wall 24 of respective plate 19 and for guiding the air to waste conduit 26. More specifically, proceeding along wall 24 of each plate 19 towards waste conduit 26, each recess 27 comprises a first edge 28 extending outwards of axis A and defining an outlet of portion 34 into chamber 21 and perpendicular to portion 34; and a second edge 29 perpendicular to first edge 28 and extending towards axis A.

[0041] Waste conduit 26 has an air outlet section 39 of device 15 facing chamber 21. The inlet sections 38 of blowers 25 and the outlet section 39 of waste conduit 26 are located on the opposite side of device 15 to web 3, and outlet section 39 is interposed between inlet sections 38 of the two units 14.

[0042] Each plate 19 is secured to bracket 18 in a direction perpendicular to axis A and parallel to path P.

[0043] With reference to Figures 2 to 5, each plate 19 is fixed to respective arm 20 of bracket 18 by bolts 35, which slide, perpendicularly to axis A and in the plane of

portion 17 of bracket 18, inside oval slots 36 in portion 17, to adjust the position of device 15 with respect to web 3.

[0044] Each plate 19 is fitted with two strips 37 of material suitable for defining a sliding contact with web 3, e.g. silicone or Teflon, etc., and which extend inside chamber 21, perpendicularly to axis A and parallel to plate 19, to guide web 3 along path P.

[0045] In actual use, by means of slots 36, the position of plates 19, and therefore of units 14, can be adjusted with respect to web 3 and perpendicularly to axis A, so that web 3 is centred inside chamber 21 and guided along path P by strips 37 with no undesired friction.

[0046] Each blower 25 supplies respective conduit 16 with air, which, after flowing successively along respective portions 32 and 33, is accelerated sharply at respective narrow-section portion 34.

[0047] By virtue of the shape of edges 28 and 29 of each recess 27, the air is directed from portions 34 to waste conduit 26.

[0048] According to a known fluid-dynamic effect, acceleration of the air at each narrow-section portion 34 produces a fall in air pressure in portion 34.

[0049] A pressure difference is thus produced between the air in each portion 34 and the air about web 3 in chamber 21, and such as to detach any impurities from web 3 and feed them, together with the air, to waste conduit 26.

[0050] The advantages of machine 1 according to the present invention will be clear from the foregoing description.

[0051] In particular, device 15 is easy to fit to machine 1, is cheap and compact, and provides for effectively and continuously removing any waste particles on web 3, to prevent malfunctioning of machine 1 and production stoppages.

[0052] Clearly, changes may be made to machine 1 as described and illustrated herein without, however, departing from the scope of the accompanying Claims.

[0053] In particular, device 15 may be designed otherwise than as described and shown, so as to interact with areas of web 3 other than longitudinal edge 12. For example, to operate directly on the area to which the removable opening devices are applied - usually along the centerline - plates 19 and conduits 16 may be appropriately sized, parallel to axis A, to permit air flow from the centerline to the edge of web 3 adjacent to waste conduit 26.

[0054] In an alternative not shown, as opposed to fluid dispensing units 14, cleaning device 15 may comprise respective suction units for removing waste particles on web 3 of packaging material.

Claims

1. A machine (1) for packaging pourable food products, comprising a feed station (4) for feeding a sheet

packaging material (3) along a predetermined forming path (P), along which said packaging material (3) is transformed into a succession of sealed packages (2);

characterized by comprising impurity removing means (15) for removing any impurities on said packaging material (3), and located downstream from said feed station (4) along said forming path (P).

2. A machine as claimed in Claim 1, **characterized by** comprising an application station (6) for applying a sealing strip to a longitudinal edge (12) of said packaging material (3); and in that said impurity removing means (15) are located upstream from said application station (6) for applying said sealing strip.

3. A machine as claimed in Claim 1 or 2, **characterized by** comprising a folding station (7) for folding removable opening devices fitted to said packaging material (3); and in that said impurity removing means (15) are located upstream from said folding station (7).

4. A machine as claimed in any one of Claims 1 to 3, **characterized in that** said impurity removing means (15) comprise flow generating means (14) for generating, on at least one surface (12) of said packaging material (3), a flow of fluid adapted to remove said impurities.

5. A machine as claimed in Claim 4, **characterized in that** said flow generating means comprise dispensing means (14) for dispensing fluid at a pressure differing from the pressure about said packaging material (3), so as to remove said impurities from the packaging material (3).

6. A machine as claimed in Claim 5, **characterized in that** said dispensing means (14) comprise at least one conduit (16) for said fluid and defining a narrow section (34) communicating fluidically with said packaging material (3).

7. A machine as claimed in Claim 5 or 6, **characterized in that** said impurity removing means (15) define a chamber (21), through which said packaging material (3) is fed in use, and which communicates fluidically with said conduit (16) and with a catch vessel (26) for collecting said impurities.

8. A machine as claimed in Claim 7, **characterized in that** said narrow section (34) is oriented towards said catch vessel (26).

9. A machine as claimed in Claim 8, **characterized in that** said narrow section (34) communicates fluidically with said chamber (21) by means of guide surfaces (28, 29) for guiding said fluid and which direct

the fluid towards said catch vessel (26).

10. A machine as claimed in any one of Claims 6 to 9, **characterized in that** said dispensing means (14) comprise at least two said conduits (16) for dispensing fluid on opposite sides of said packaging material (3) with respect to said forming path (P). 5
11. A machine as claimed in any one of the foregoing Claims, **characterized by** comprising adjusting means (35, 36) for adjusting the position of said impurity removing means (15) with respect to said packaging material (3). 10
12. A machine as claimed in any one of the foregoing Claims, **characterized by** comprising guide means (37) for guiding said packaging material (3) and located along said forming path (P), close to the operating area of said impurity removing means (15). 15
13. A machine as claimed in Claim 12, **characterized in that** said guide means (37) are carried by said impurity removing means (15). 20

25

30

35

40

45

50

55

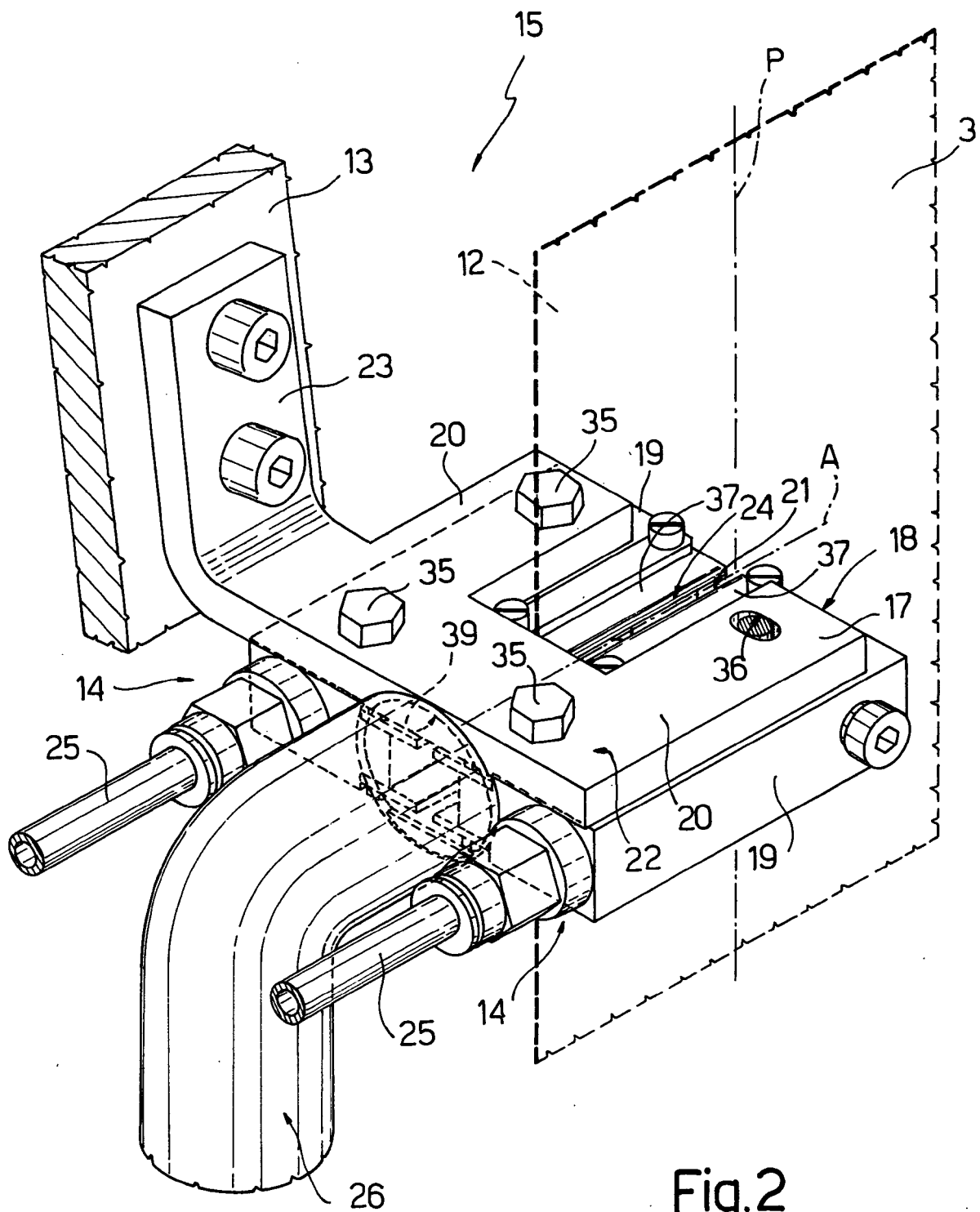


Fig.2

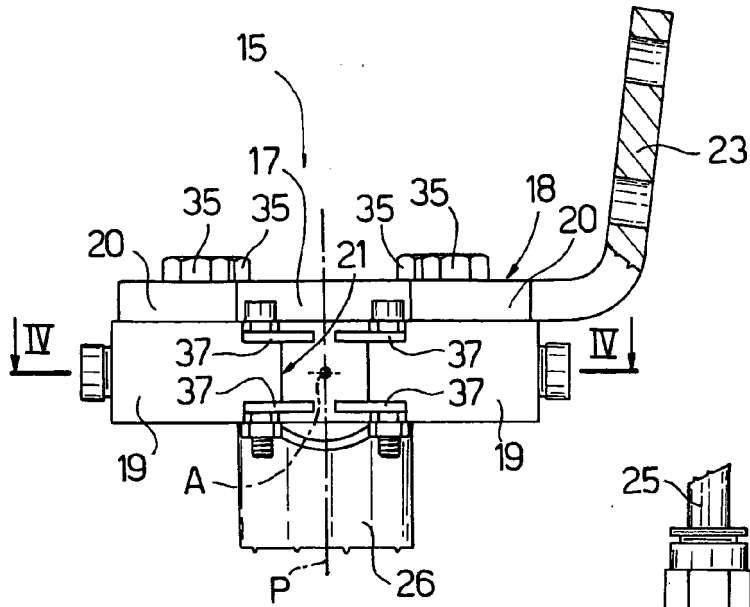


Fig.3

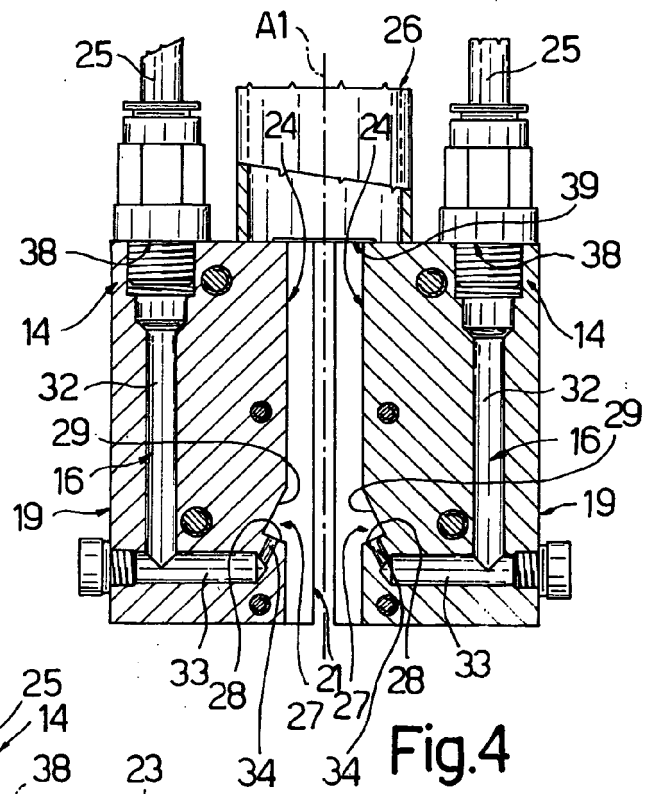


Fig.4

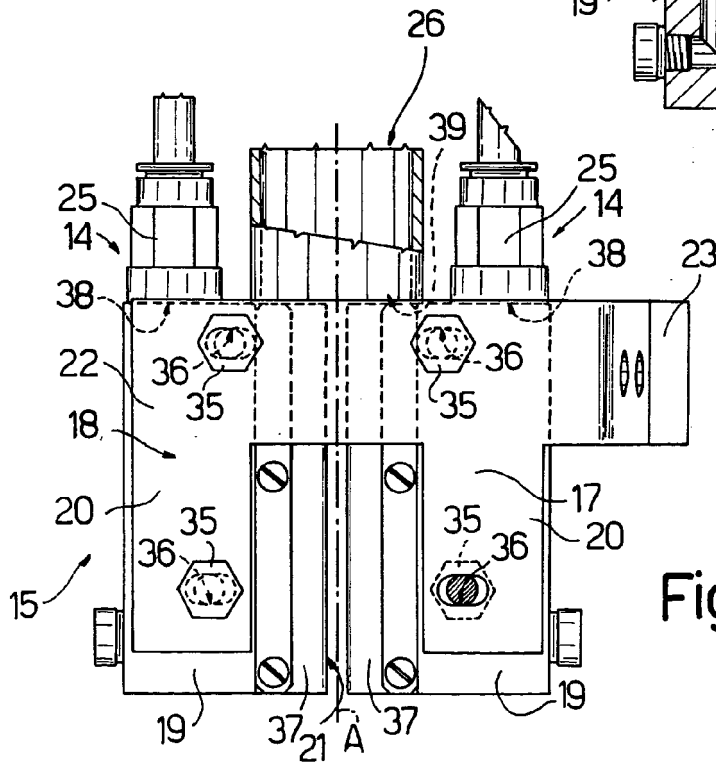


Fig.5



European Patent
Office

EUROPEAN SEARCH REPORT

Application Number
EP 04 42 5943

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.7)
X	WO 2004/041697 A (TETRA LAVAL HOLDINGS & FINANCE S.A; LAGERROTH, PER; TURESSON, MATS) 21 May 2004 (2004-05-21) * claim 1; figures 1-6 *	1,11-13	B65B55/24 B65B61/18 B08B5/02
Y	-----	2-10	
Y	US 4 538 396 A (NAKAMURA ET AL) 3 September 1985 (1985-09-03) * abstract; figures 15,16 *	2,3	
Y	----- US 5 916 373 A (SCHNEIDER ET AL) 29 June 1999 (1999-06-29) * column 4, line 7 - column 6, line 11; figure 3 *	4-10	
A	----- US 6 666 002 B1 (OTSUKA YUZO ET AL) 23 December 2003 (2003-12-23) * column 3, lines 40-50; figure 2 *	1	
A	----- US 6 148 831 A (LINDSTROM ET AL) 21 November 2000 (2000-11-21)		TECHNICAL FIELDS SEARCHED (Int.Cl.7)
A	----- DE 296 18 023 U1 (STRAUCH, HELMUT, 97483 ELTMANN, DE) 16 January 1997 (1997-01-16) -----		B65B
The present search report has been drawn up for all claims			
Place of search Munich		Date of completion of the search 15 July 2005	Examiner Schelle, J
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

1
EPO FORM 1503 03.82 (P04C01)

**ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.**

EP 04 42 5943

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP file on
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

15-07-2005

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
WO 2004041697 A	21-05-2004	SE 523995 C2	15-06-2004
		AU 2003265203 A1	07-06-2004
		SE 0203283 A	08-05-2004
		WO 2004041697 A1	21-05-2004

US 4538396 A	03-09-1985	JP 56173109 U	21-12-1981
		JP 58030495 Y2	05-07-1983
		AU 555436 B2	25-09-1986
		AU 2688984 A	02-08-1984
		AU 536262 B2	03-05-1984
		AU 6473480 A	11-06-1981
		DE 3069237 D1	25-10-1984
		DE 3072193 D1	25-07-1991
		DE 3072208 D1	18-11-1993
		DE 3072208 T2	19-05-1994
		EP 0030348 A1	17-06-1981
		EP 0119314 A2	26-09-1984
		EP 0420301 A1	03-04-1991
		GR 72501 A1	15-11-1983
		HK 60485 A	23-08-1985
		MY 102185 A	31-12-1985
		SG 79684 G	26-04-1985
		US 4420080 A	13-12-1983
		US 4616470 A	14-10-1986
		US 4651874 A	24-03-1987
		US 4739879 A	26-04-1988

US 5916373 A	29-06-1999	CH 687957 A5	15-04-1997
		AT 183117 T	15-08-1999
		AU 686897 B2	12-02-1998
		AU 3764995 A	27-03-1996
		BR 9508885 A	30-12-1997
		CA 2199151 A1	14-03-1996
		WO 9607490 A1	14-03-1996
		CN 1167451 A ,C	10-12-1997
		DE 59506604 D1	16-09-1999
		EP 0789635 A1	20-08-1997
		ES 2137536 T3	16-12-1999
		FI 970940 A	05-03-1997
		HU 76873 A2	29-12-1997
		JP 10505276 T	26-05-1998
		LV 11854 A	20-10-1997
		LV 11854 B	20-12-1997
		NO 971002 A	05-05-1997
		NZ 300045 A	26-08-1998
		-----	-----

EPO FORM P0459

For more details about this annex : see Official Journal of the European Patent Office, No. 12/82

**ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.**

EP 04 42 5943

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
The members are as contained in the European Patent Office EDP file on
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

15-07-2005

Patent document cited in search report		Publication date		Patent family member(s)	Publication date
US 6666002	B1	23-12-2003	JP	2001018909 A	23-01-2001
			AU	6802900 A	22-01-2001
			CN	1373723 A ,C	09-10-2002
			EP	1200309 A1	02-05-2002
			WO	0102249 A1	11-01-2001

US 6148831	A	21-11-2000	FI	964297 A	26-04-1998
			AT	215637 T	15-04-2002
			CA	2269790 A1	07-05-1998
			DE	69620479 D1	08-05-2002
			DE	69620479 T2	10-10-2002
			EP	0937178 A1	25-08-1999
			WO	9819009 A1	07-05-1998
			JP	2001501680 T	06-02-2001
			KR	2000052824 A	25-08-2000
			NO	991861 A	19-04-1999
			US	5800679 A	01-09-1998

DE 29618023	U1	16-01-1997	NONE		
