

(19) **DANMARK**

(10) **DK/EP 2868593 T3**



(12)

## Oversættelse af europæisk patentskrift

Patent- og  
Varemærkestyrelsen

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- (51) Int.Cl.: **B 65 D 25/10 (2006.01)** **A 61 M 5/00 (2006.01)** **B 01 L 9/06 (2006.01)**  
**B 65 D 77/04 (2006.01)** **B 65 D 85/42 (2006.01)**
- (45) Oversættelsen bekendtgjort den: **2017-02-20**
- (80) Dato for Den Europæiske Patentmyndigheds bekendtgørelse om meddelelse af patentet: **2016-12-21**
- (86) Europæisk ansøgning nr.: **14189573.0**
- (86) Europæisk indleveringsdag: **2014-10-20**
- (87) Den europæiske ansøgnings publiceringsdag: **2015-05-06**
- (30) Prioritet: **2013-11-05 DE 102013112167**
- (84) Designerede stater: **AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR**
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- (54) Benævnelse: **Holdestruktur til samtidig fastholdelse af adskillige beholdere til substanser til medicinske, farmaceutiske eller kosmetiske anvendelser samt transport- og emballeringsbeholder med samme samt fremgangsmåde**
- (56) Fremdragne publikationer:  
**WO-A1-2009/015862**  
**WO-A1-2011/135085**  
**WO-A1-2012/143533**



**Field of the Invention**

The present invention relates to the simultaneous supporting (holding) of a plurality of containers for the storage of substances for medical, pharmaceutical or cosmetic applications, in particular of vials, ampoules, syringes or dual-chamber syringes, carpoules (cartridges), dual-chamber cartridges or vartridges, in a simple and reliable manner and in such a manner that the containers, while they are supported by the supporting structure, can be processed in a filling apparatus or in processing plants or can be processed further, particularly in a sterile tunnel, in a filling apparatus for liquid medical or pharmaceutical agents or in a freeze-dryer for this purpose. The present invention further relates to a transport and/or packaging container comprising at least one such supporting structure and to a process for the treatment or processing of such containers.

**Background of the Invention**

Medication containers, for example vials, ampoules or carpoules, are widely used as containers for preservation and storage of medical, pharmaceutical or cosmetic preparations to be administered in a liquid form, in particular in pre-dosed amounts. These generally have a cylindrical shape, can be made of plastic or glass and are available in large quantities at low costs. In order to fill the containers under sterile conditions as efficiently as possible concepts are increasingly used according to which the containers are already packaged in a transport or packaging container at the manufacturer of the containers under sterile conditions, which are then unpacked and further processed at a pharmaceutical company under sterile conditions, in particular in a so-called sterile tunnel.

For this purpose, various transport and packaging containers are known from the prior art, in which a plurality of medication containers are concurrently arranged in a regular. This has advantages in the automated further processing of the containers because the containers can be transferred to processing stations, for example to processing machines, robots or the like, at controlled positions and in a predetermined arrangement. For the transfer to a processing station it is just required to properly position and open the transport and packaging container. The downstream processing station will then know at what position and in what arrangement the containers to be processed further are arranged.

Such a transport and packaging container and a corresponding packaging concept is for example disclosed in US 8,118,167 B2. The further processing of the containers is, however, always performed in such a manner that the supporting structure will be removed from the transport and packaging container, that the containers will be  
5 removed from the supporting structure and isolated and then individually placed on a conveyor, in particular a conveyor belt, and passed to the processing stations individually for the further processing. This limits the speed of processing that can be achieved. Particularly in the isolation of the containers by means of cell wheels or the like, it always occurs that individual containers abut uncontrolled, which results in an  
10 undesired abrasion and subsequently in a contamination of the interior volume of the containers or of the processing station and in an impairment of the outer appearance of the containers which is undesirable.

US 8,100,263 B2 discloses a portable transport and packaging container that can be  
15 packaged in a sterile manner, in which a plate-shaped supporting structure can be inserted which supports a plurality of medication containers in a regular arrangement. However, the medication containers cannot be processed further while they are accommodated in the transport or packaging container or while they are supported in the supporting structure, but must be isolated first in the conventional manner and  
20 handed over to downstream processing stations.

A further similar transport and packaging container and supporting structures are disclosed in WO 2009/015862 A1. However, the carrier is formed in one part and does not comprise a frame, on which the carrier could be supported in two opposite  
25 orientations.

A further similar transport and packaging containers and supporting structures are disclosed in WO 2011/135085 A1. However, for the further processing the medication containers always need to be isolated. A further processing of batches of medication  
30 containers, while they are accommodated in a plate-shaped supporting structure as outlined above, is not possible.

### **Summary of the Invention**

35 The object of the present invention is to further enhance the supporting of containers used for the storage of substances for medical, pharmaceutical or cosmetic applications,

so that the containers can be supported easily and reliably in accordance with the specific conditions during their treatment or processing and can be packaged sterile, can be unpackaged and processed further. According to a further aspect of the present invention there is to be provided a corresponding transport and packaging container  
5 comprising at least one such supporting structure and a corresponding process for the treatment or processing of containers.

These problems are solved according to the present invention by a supporting structure with the feature of claim 1 and claim 2, respectively, by a transport and packaging  
10 container according to claim 9 and by a process according to claim 10 and claim 11, respectively. Further advantageous embodiments are the subject-matter of the dependent claims.

Thus, there is provided a supporting structure for concurrently supporting a plurality of  
15 containers of a predetermined length, which are used for the storage of substances for medical, pharmaceutical or cosmetic applications or contain such substances, comprising a carrier having a plurality of supporting means and being configured to support the containers in a first orientation (e.g. upright) or in a second orientation that is opposite to said first orientation (e.g. upside-down).

20

According to a first embodiment according to the present invention the supporting structure is formed in two parts and comprises the carrier and a frame, on which the carrier can be supported in a first predetermined orientation or in a second predetermined orientation, which is opposite to the first predetermined orientation,  
25 wherein the carrier is matched to the axial lengths of the containers in such a manner that the upper ends of the containers are arranged in said first position, in which the containers are supported in the first orientation at the carrier and the carrier is supported in the first predetermined orientation at the carrier, at the same distance to the upper rim of the frame used for supporting the carrier as the lower ends of the containers in the  
30 second position, in which the containers are supported in the second orientation at the carrier and the carrier is supported in the second predetermined orientation at the frame, and that the upper ends and/or lower ends of the containers are accessible for a further processing of the containers, while they are supported on the carrier.

35 According to a second embodiment according to the present invention the supporting structure is formed in two parts and comprises the carrier and a frame, on which the

carrier can be supported in a first orientation or in a second orientation, which is opposite to the first orientation, wherein the carrier is matched to the axial lengths of the containers in such a manner that the upper ends of the containers are arranged in a first position, in which the containers are supported in a predetermined orientation at the carrier and the carrier is supported in the first orientation at the carrier, at the same distance to the upper rim of the frame used for supporting the carrier as the lower ends of the containers in a second position, in which the containers are supported in the same predetermined orientation at the carrier and the carrier is supported in the second orientation at the frame, wherein the upper ends of the containers are accessible for a further processing of the containers, while the carrier is supported in the second orientation at the carrier and the containers are supported in the predetermined orientation on the carrier.

Thus, there is no need to adjust the heights of processing stations where the containers are treated or processed further, regardless of whether the containers are supported on the carrier in the first orientation (e.g. upright) or in the second orientation (e.g. upside-down), because the upper ends and lower ends of the containers are disposed on the same height level in both positions. According to the invention this facilitates the treatment and processing of containers considerably because the effort in terms of adjustment, control and automation can be considerably simplified.

The term "at the same distance" in the sense of the present application shall, of course, take into account unavoidable tolerances of the lengths of the containers. On the other hand, according to further embodiments also tolerances shall be taken into account that are caused by a different supporting of the upper ends and lower ends of the containers on the supporting structure and that are preferably at maximum of the order of the axial length of a constricted upper neck portion of the containers to be supported or that is slightly larger, in comparison to the total length of the containers to be supported, than this axial length, e.g. by less than 20%, preferably by less than 10% of the axial length of the constricted neck portion.

According to a further embodiment the carrier comprises a plurality of apertures, a plurality of supporting means, preferably two supporting means, being associated to said apertures, for supporting said containers, in particular by a positive-fit or by friction. Here, the containers are supported by the supporting means on the carrier preferably in such a manner that they extend through the apertures of the carrier, that the upper ends of

the containers protrude beyond an upper rim of the carrier and/or that the lower ends of the containers protrude beyond a lower rim of the carrier.

According to a further embodiment the containers are supported on the carrier or  
5 retained in axial direction on the carrier in the first orientation and in the second orientation so that they are reliably supported on the carrier if its orientation is reversed.

According to a further embodiment the carrier, which is preferably planar and in particular rectangular, comprises at least two supporting tongues as supporting means  
10 that are provided on the edge of a respective aperture and protrude from an upper surface of the carrier to support the respective container in said aperture. Here, the supporting tongues are configured such that they are elastically pivoted away or flapped away during insertion of the containers into the apertures, and further such that the supporting tongues are matched to the containers such that the containers are  
15 supported by the supporting tongues with a radial clearance. The radial clearance enables that containers with different radial tolerances and/or outer dimensions can be supported reliably by the same carrier. Conveniently, the radial clearance is designed and matched to the outer contour or to the outer dimension of the container in such a manner that all supporting tongues are never at the same in contact with the constricted  
20 neck portion at the upper end of the container, in particular of the vial. At the same time the radial clearance also prevents an undesired tension or even bulging of the carrier when supporting containers having different radial tolerances and/or different outer dimensions, which offers considerable advantages in particular in the case of the concurrent processing of a plurality of containers, while these are supported by the  
25 carrier, e.g. during freeze-drying and processing at very low temperatures.

According to a further embodiment the supporting tongues are formed sufficiently resilient or are supported resiliently, so that the containers can be inserted in axial direction, i.e. in the direction of the longitudinal axes of the containers and perpendicular  
30 to the plane of the carrier, from the upper side or underside of the carrier into the apertures or receptacles, in particular under elastic deformation of the supporting tongues, e.g. under bending of the same. Thus, loading the carrier with containers can be easily automated, which is further enhanced by a regular arrangement of the apertures or receptacles, preferably by a regular arrangement of the apertures or  
35 receptacles in a two-dimensional matrix.

The underside of an expanded upper rim of the container has turned out to be a preferred position where the containers are held or supported by the supporting tongues, such as the so-called rolled edge or shoulder that is usually provided in the case of vials. In this region a supporting area is available having a sufficient extent in the radial direction of the apertures or receptacles for holding or supporting the containers, in order to easily implement the afore-mentioned radial clearance when supporting the containers.

Because the containers can be lifted or displaced, e.g. rotated, with low efforts in the apertures or receptacles of the carrier, according to the invention the containers can be easily processed while they are within the carrier and are supported or at least guided by it. This kind of supporting turned out to be of particular advantage e.g. during sealing of the containers by crimping a metal lid. The processes required for this purpose can be performed on the metal lid while the containers are supported or at least guided in the apertures or receptacles of the carrier. This kind of supporting turned out to be of particular advantage for the processing of containers, while the containers are supported or accommodated in the carrier. E.g. the carrier together with the containers supported can be placed in a freeze-dryer or freeze-drying cabinet. Because of the supporting of the containers with a certain clearance in the carriers it can be ensured that the bottoms of all containers evenly rest on a cooling base, e.g. a cooling finger of the freeze-dryer or freeze-drying cabinet. Or the containers can be lifted and handled for the processing without much effort while being in the apertures or receptacles of the carrier.

According to a further preferred embodiment the supporting tongues are resilient supporting tongues, but have a sufficient elasticity to be pivoted away or folded away resiliently and to a sufficient extent upon insertion of the containers into the apertures or receptacles to give free the path into the apertures or receptacles. This can be accomplished easily by a suitable dimensioning, choice of materials and configuration of the strength of the material of the supporting tongues. Preferably, the supporting tongues are thus formed of a plastic material.

According to a further embodiment the supporting tongues are biased resiliently towards a retaining position, preferably by a resilient restoring member such as a restoring spring or a plastic plate or an elastic plastic structure, which cooperates with the associated supporting tongue suitably and is disposed or formed on the upper surface of the carrier.



According to a further embodiment the supporting tongues are matched to the containers such that the containers rest loosely with an expanded rim that is formed at an upper end of the container on the upper sides of the supporting tongues, in particular with the afore-mentioned rolled edge. Thus, the containers can be removed upward out  
5 of the apertures or receptacles without a significant resistance.

According to a further embodiment the supporting tongues embrace the expanded rim in such a manner that the containers are supported on the supporting tongues with a radial clearance or both with a radial clearance and an axial clearance. In this manner  
10 the containers can be retained in the apertures in axial direction and in a loose-proof manner so that the carrier can be turned over without problems. For removing the containers out of the apertures, the supporting tongues only need to be pivoted or flapped back again in the same manner as for inserting the containers.

15 According to a further embodiment the apertures are at least partially delimited by a sidewall or by one or more pins on one side of the carrier, namely on the upper side or the underside of the carrier, for preventing a collision of containers in directly adjacent apertures or receptacles. Here, most preferably the side walls or pins are formed in such a manner that the containers are freely accessible from this side of the carrier, i.e. from  
20 the upper side or from the lower side. Here, the side walls of adjacent apertures or receptacles of the carrier can also be connected with each other, which advantageously contributes to a further stiffening of the carrier. Preferably, the side walls are integral with the carrier, which can be implemented easily using a plastic injection molding technique.

25

The bottoms or lower ends of the containers accommodated in the apertures preferably protrude from the ends of the side walls so that the bottoms or lower ends of the containers are freely accessibly from the underside or upper side of the carrier. This makes it possible that the containers can be processed while they are supported on the  
30 carrier in the apertures or receptacles, as outlined below.

According to a further embodiment members that respectively interact with each other positively can be provided on the frame and on the carrier for defining a different height difference between the frame and the carrier in the respective orientation.

35

A further aspect of the present invention relates to a transport and packaging container comprising at least one supporting structure as outlined above and disclosed in more detail hereinafter.

- 5 Here, the containers respectively do not protrude beyond an upper rim and/or beyond a lower rim, respectively, of the transport and packaging container when the containers are supported on the carrier in the first position or in the second position so that the transport and packaging container can be sealed under sterile conditions for a transport of the containers, e.g. by means of a sealing foil which is bonded to the upper rim and/or  
10 lower rim of the transport and packaging container.

- A further aspect of the present invention as claimed in claim 10 and claim 11, respectively, relates to a process for the treatment or processing of containers used for the storage of substances for medical, pharmaceutical or cosmetic applications or  
15 containing such substances, wherein the containers are open at least at one end and wherein a supporting structure, as disclosed herein, and/or a transport and packaging container, as disclosed herein, is used.

- The treatment or processing of the containers can in particular be a cleaning of the  
20 containers and/or a weighing of the containers and/or a filling of the containers and/or a sealing of the containers with stoppers or caps and/or a crimping of metal caps onto the containers.

- According to a further embodiment of the process the treatment or processing of the  
25 containers can comprise a step for measuring filling capacities of the containers, where the containers are supported on the carrier in such a manner that a laser beam respectively propagates through a constricted neck portion of the containers and the laser beam is detected using a sensor, wherein the respective filling capacities of the containers, in particular a filling level of the containers, is determined on the basis of a  
30 measurement signal of the sensor.

- According to a further embodiment of the present invention in the process a container is sealed with a stopper, comprising the steps of: disposing a sealing member on an end of the container to seal said end of said container against the environment; inserting the  
35 stopper in a compressed state by means of a gripper into said end of the container; applying a vacuum to said end of the container via an annular gap between the gripper

and an inner surface of the container; and releasing the stopper until it rests against the inner surface of the container, to seal said end of the container against the environment. Because the stopper is inserted into the open end of the container in a compressed state and because the inner volume of the container is sealed by a sealing member against  
5 the environment, an appropriate vacuum can be applied easily to the inner volume of the container to withdraw air or gases out of the inner volume by suction, before the stopper seals the end.

According to a further embodiment of the process the gripper comprises a cylinder  
10 having an outer diameter that is smaller than the inner diameter at said end of the container, wherein said step of inserting the stopper in a compressed state by means of a gripper into said end of the container further comprises: compressing the stopper by inserting the stopper into said cylinder; displacing the cylinder together with the gripper for inserting the stopper into said end of the container; applying a pressure to the sealing  
15 member for sealing said end of the container against the environment; and pushing the stopper out of the cylinder further into said end of the container and towards the surface of the liquid that is stored in the container. Here, the cylinder serves as a means for delimiting and guiding the stopper and the gripper for reliably delimiting an annular gap between the outer wall of the cylinder and the inner wall of the container.

20

According to a further embodiment of the process the sealing member is a part of the bottom of a carrier or of a supporting structure as outlined above, wherein the containers are disposed on the bottom of the carrier or of the supporting structure such that the ends of the containers are aligned with the apertures formed in the bottom and that the  
25 stoppers are inserted into the ends of the containers via said apertures. Here, the stopper can be accommodated in a compressed state in the cylinder upon insertion into the apertures. Thus, the stoppers can be positioned in particular at times when the containers rest in their normal transport position in a carrier, as disclosed herein, e.g. when the carrier is removed out of a transport and packaging container, as disclosed  
30 herein. Thus, according to the invention the stoppers can be inserted into the upper ends of the containers, while they are supported in a carrier (nest). Particularly, the containers can be cylinder ampoules or cartridges (carpoules) that are supported in a carrier, which is accommodated under sterile conditions and transported in a transport and packaging container, wherein the transport and packaging container is opened at a pharmaceutical  
35 company and the cylinder ampoules or cartridges are then filled and sealed by placing

a stopper in the manner disclosed herein, while the cylinder ampoules or cartridges are supported in the carrier.

In this process the sealing member may also be fed as a separate member, in particular as a plate comprising a plurality of annular sealing members that are connected with  
5 each other via webs of the like.

### Overview on Drawings

The invention will now be described by way of example and with reference to the  
10 accompanying drawings, from which further features, advantages and problems to be solved will become apparent. In the drawings:

- |                    |                                                                                                                                                 |
|--------------------|-------------------------------------------------------------------------------------------------------------------------------------------------|
| Fig. 1             | shows a container for storing substances for medical, pharmaceutical or cosmetic applications, which is embodied as a vial;                     |
| 15 Figs. 2a to 2g  | show the basis components of a two-part supporting structure according to a first embodiment of the present invention;                          |
| Figs. 3a to 3g     | show the accommodation of such a supporting structure in a transport and packaging container according to the present invention;                |
| 20 Figs. 3h and 3i | show in comparative views the supporting structure according to Figs. 2a to 2g in a first position and a second position of the containers;     |
| Figs. 4a to 4j     | show a supporting structure and a transport and packaging container according to a further embodiment of the present invention;                 |
| 25 Fig. 4k         | shows in an exploded perspective view the transport and packaging container of Figs. 3a to 3g with a supporting structure of Figs. 2a to 2g;    |
| 30 Fig. 4l         | is a schematic diagram of a process for the concurrent treatment of processing of a plurality of containers according to the present invention; |
| Figs. 5a and 5b    | show further examples for the supporting of a container at a carrier of a supporting structure according to the present invention;              |
| 35 Figs. 6a to 6h  | show further examples for the supporting of a container at a carrier of a supporting structure according to the present invention;              |

- Fig. 6i shows a process step in a method according to the present invention for determining the filling level or filling level of a container using a laser;
- 5 Figs. 7a to 7e show a supporting structure according to a further embodiment, which serve for a better understanding of the present invention;
- Fig. 7f shows in an exploded perspective view a transport and packaging container with the supporting structure according to Figs. 7a to 7e;
- 10 Figs. 8a and 8b show in a plan view and in a greatly enlarged partial view a supporting structure according to a further embodiment of the present invention;
- Figs. 8c to 8e show in schematic partial sectional views different stages of a process step for setting stoppers (stoppering) in cartridges in a process according to the present invention; and
- 15 Figs. 9a is a perspective partial view of a transport and packaging container for use together with a supporting structure according to the present invention, wherein in Fig. 9a the supporting structure is formed in one part.

20 In the drawings, identical reference numerals designate identical or substantially equivalent elements or groups of elements.

### Detailed Description of Preferred Embodiments

25 According to the present invention, a supporting structure as well as a transport and packaging container accommodating such a supporting structure are used, as described below, for concurrently supporting a plurality of containers for storage of substances for medical, pharmaceutical or cosmetic applications in an array configuration, preferably in a matrix configuration with regular intervals between the containers along two different directions in space, preferably along two mutually orthogonal directions in space or in

30 regular rows that are offset relative to each other.

An example of such containers embodied as vials is schematically shown in Fig. 1 in a longitudinal sectional view. The vials have a cylindrical basic shape, having a cylindrical side wall 4 with - within tolerances - constant inner and outer diameters, which project

35 vertically from a flat vial bottom 3, which merges in a constricted neck portion 5 of a relatively short axial length near the upper open end of the vial and then merges in an

expanded upper rim 6 (also referred to as a rolled edge), which has a larger outer diameter than the associated neck portion 5 and is configured for connection to a closure member. As can be concluded from Fig. 1, the bottom edge of the rolled edge 6 can be slanted and may extend at an acute angle downward and toward the constricted neck portion 5. According to further embodiments, the bottom edge of the rolled edge 6 may also be flat and extend in radial direction substantially at a right angle relative to the constricted neck portion 5.

The neck portion 5 can be formed with smooth walls and without an external thread or may be provided with an external thread for screwing on a closure member. For example, a stopper (not shown) may be inserted in the inner bore of the neck portion 5 and the upper rim 6, whose upper end is connected with the upper rim 6 of the vial in a gas-tight manner and protected against the intrusion of contaminants into the vial, for example by crimping or beading a metal protective foil which is not shown. Such vials are radial symmetric and are made of a transparent or colored glass or of a suitable plastic material by blow molding or plastic injection molding techniques, and in general can be internally coated so that the material of the vial emits minimal impurities to the agent to be received.

Further examples of a medication container according to the present application are ampoules, carpoules (cartridges), syringes or injection containers.

In the sense of the present invention, such containers are used for the storage of substances or agents for cosmetic, medical or pharmaceutical applications, which are to be stored in one or several components in solid or liquid form in the container. While, in the following, cylindrical containers are disclosed, it should be noted that the containers, in the sense of the present invention, may also have a different profile, for example a square, rectangular or polygonal profile.

Inevitably such containers have tolerances due to the production which can be of the order of one or several tenths of a millimeter in particular for glass containers. To compensate for such manufacturing tolerances, while ensuring that all bottoms 3 or bottom ends of the containers can be disposed in a plane, according to the present invention the containers are fixed on a supporting structure as outlined in the following. This supporting of the containers is implemented either in the transition region between the constricted neck portion 5 and the expanded upper rim 6 or in the region of the

constricted neck 5. As described hereinafter, a supporting member is disposed in the region of the constricted neck portion 5, which engages with the constricted neck portion 5 in a positive-fit manner or preferably accommodates the latter with a certain radial clearance to compensate for tolerances and different outer diameters of different types of containers. This supporting member may be part of a supporting means or is formed by the latter that is clipped into a carrier in accordance with embodiments of the invention, as described below, to form a supporting structure for concurrently supporting a plurality of containers in apertures or receptacles.

For concurrently supporting a plurality of containers according to a first embodiment of the present invention, as shown in Figs. 2a to 2g, a planar rectangular carrier 20 (also referred to as a supporting structure in the present application) is provided, which is formed of a plastic, for example by punching or injection molding, and which comprises a plurality of apertures 22 for receiving the vials 2 (see Fig. 2c). The apertures 22 are arranged in a regular two-dimensional array, in the illustrated embodiment in a matrix array consisting of rows and columns extending perpendicularly thereto, which are offset from one another at equal distances and which are offset relative to each other in a periodic arrangement.

The apertures 22 are surrounded by cylindrical side walls 37 (see Fig. 2b) on the upper side of the carrier 20, which are preferably formed as circumferential side walls, but may also be formed as relatively short side wall portions for delimiting an associated aperture 22 only partially. In each case, a collision of containers, which are accommodated in directly adjacent apertures 22, is prevented by the side walls 37.

Fig. 2c shows a greatly enlarged detail from Fig. 2b. Four elastic supporting tongues 23 each protrude into the apertures 22, which are disposed along the edge of the apertures under equal angular distances from one another and which are separated from each other via a slot 24. The supporting tongues 23 are in particular formed integrally with the plate 21 of the carrier 20, which can be implemented easily using a conventional 1-component injection molding process or a 2-component injection molding process. Upon insertion of a container, the supporting tongues 23 are first pivoted elastically in order to snuggle to the constricted neck portion 5 of the container 2 after elastically pivoting back (see Fig. 3c) or to support the containers in this area, as described below. Because the resilient supporting tongues 23 project into the apertures 22 in an arrangement with a point symmetry of higher order, this results in a symmetrical force distribution when

supporting the containers by the supporting tongues 23, so that the containers are automatically centered with respect to a center line of a respective aperture 22.

As can be seen in Fig. 2c, a plurality of protrusions 40 protrude from the upright,  
5 circumferential side wall 35 of the carrier 20, which are interrupted in a predetermined geometry by slots 41, which is, however, not absolutely necessary.

Figs. 2d and 2e show a supporting frame for supporting a carrier 20 to form a supporting structure according to a first embodiment of the present invention. According to Fig. 2e  
10 the frame 50 is formed by a circumferential side wall 51 which merges into a flange-shaped circumferential upper rim 53. The frame is open on the upper side and bottom side so that the side wall 51 surrounds an aperture 55. According to Fig. 2e a plurality of ribs 52 are formed on the inner side of the side wall 51, which may serve, on the one hand, for stiffening of the frame 50 and which, on the other hand, may serve for a unique  
15 definition of the position of a carrier 20 due to their geometrical arrangement in a such a framework 50, as described above.

As shown in Fig. 2e, the ribs 52 do not necessarily have to extend over the entire height of the side walls 51 so that they together form a plurality of support points for supporting  
20 the carrier. According to Fig. 2e, a protrusion 54 is formed at the lower edge of the side wall 51 that is formed in this example circumferential (which is not essential) and which projects inward into the aperture 55.

According to the invention the frame 50 and the carrier 20 are adapted to one another  
25 in such a manner that the carrier 20 can be accommodated in the frame 50 and that the protrusions 40 on the side wall 35 of the carrier (cf. Fig. 2c) rest directly on the supporting points on the upper ends of the ribs 52 in a first orientation of the carrier. In contrast, when the carrier 20 is turned over and is inserted into the frame 50 in a second orientation (i.e. in the opposite orientation), the ribs 52 on the sidewall 51 of the frame  
30 50 are in engagement with the slots 41 between the protrusions of the carrier 20, so that the carrier 20 can slide down along the side wall 51, until finally the protrusions 40 rest on the bottom rim 54 of the frame 20.

According to the invention the supporting tongues 23 are configured for supporting the  
35 containers on the carrier 20 in both orientations of the carrier 20 (i.e. in the two positions of the containers, namely upright or upside down) so that they are retained in axial



direction. This is illustrated by way of example in the comparative view in Figs. 3h and 3i. According to Fig. 3h the containers are inserted into the apertures of the plate 21 of the carrier 20 upside down, i.e. with their expanded upper rim 6 facing downwards, such that the upper rim extends beyond the plate 21 and that the containers are supported  
 5 on the supporting tongues of the plate 21 in the region of the constricted neck portion, as described above with reference to Fig. 2c. The carrier 20 is inserted from above into the supporting frame 53 such that the protrusions 40 on the side wall of the carrier 20 (see Fig. 2c) rest on the protrusion 54 on the lower rim of the side wall 51 of the frame 50 (see Fig. 2e). As is indicated by the dashed line in Fig. 3h, in this position the lower  
 10 ends of the containers 2 (i.e., in Fig. 3h the filling apertures of the carpoules or cartridges 2) are arranged under a predetermined distance from the upper surface of the upper rim 53 of the supporting frame 50.

In the opposite orientation according to Fig. 3i, i.e. when the carrier 20 is turned over, which corresponds to the first position in the sense of claim 1, the carrier 20 is inserted  
 15 from above into the supporting frame 53 such that the protrusions 40 on the side wall of the carrier 20 (see Fig. 2c) rest on the protrusion 54 at the lower rim of the side wall 51 of the frame 50 (see Fig. 2e). In this orientation, the cartridges 2 are suspended in the plate 21 of the carrier 20. I.e., the cartridges 2 are suspended in the plate 21 of the  
 20 carrier 20 with their wider aperture at the upper rim 6, which is used for filling and subsequent inserting a stopper, directed upward and with their outlet aperture 8 directed downward. As indicated by the dashed line in Fig. 3i, in this position of the containers 2 the upper rims of the containers 2 (in Fig. 3i the wider apertures at the upper rim 6 of the cartridges 2) are arranged at the same predetermined distance to the upper surface  
 25 of the upper rim 53 of the supporting frame 50.

The same applies to the distance between the upper ends 6 of the cartridges 2 and the upper surface of the upper rim 53 of the supporting frame 50 as shown in Fig. 3h and for the distance between the lower ends of the cartridges 2 and the upper surface of the  
 30 upper rim 53 of the supporting frame 50 as shown in Fig. 3i.

Thus, the supporting structure formed jointly by the carrier 20 and the frame 50 is matched to the lengths of the containers 2 in such a manner that in the position shown in Fig. 3i the upper ends 6 of the containers 2 are disposed at the same distance to the  
 35 upper surface of the upper rim 53 of the supporting frame 50 as the lower ends 8 of the containers 2 in the position shown in Fig. 3h.

As can be concluded from Figs. 3h and 3i, in both orientations the two ends of the containers 2 are freely accessible for the treatment or processing of the containers 2, because in both positions the ends of the containers 2 project beyond the upper and lower rim, respectively, of the supporting structure formed by the carrier 20 and frame 50. Fig. 3h shows the frame 50 together with the carrier 20 supported thereon and with containers 2 supported by it in the second position in the sense of claim 1.

For the transport and packing of the afore-mentioned supporting structure together with the containers accommodated therein, a transport and packaging container 10 is used, which is shown schematically in Fig. 9a as a carrier formed as one part, which serves as a supporting structure, but which is not formed in two parts according to the present invention. According to Fig. 9a the transport and packaging container 10 is essentially box-shaped or trough-shaped and comprises a bottom 11, a circumferential side wall 12 protruding perpendicularly from this bottom 11, a step 13 substantially projecting perpendicularly from this and an upper rim 15, which is formed as a flange. The corners 16 of the transport and packaging container 10 are conveniently rounded. The upper side wall 14 may be slanted relative to a vertical onto the bottom 11 by a small angle of slope in order to facilitate the inserting of the supporting structure formed by a planar carrier 20. Such a transport and packaging container 10 is preferably formed from a plastics material, particularly by plastic injection molding, and is preferably formed of a clear transparent plastic to enable an optical visual inspection of the carrier 20 accommodated in the transport and packaging container 10 and of the containers 2 supported by the carrier 20.

For reliable positioning the carrier 20 in the transport and packaging container 10, the carrier and the transport and packaging container 10 comprise positioning structures which cooperate with each other, in particular in a form-fitting (positive-fit) manner. As an example, positioning structures may be formed at an appropriate position, particularly on the step 13 or on supporting surfaces 18 of the transport and packaging container 10, which are formed as protrusions or recesses or depressions, which interact in a form-fitting manner with correspondingly configured recesses or depressions or protrusions of the carrier 20 for positioning the carrier 20 precisely in the transport and packaging container 10. For this purpose a plurality of pin-like protrusions (not shown) may be formed particularly on the step 13 of the transport and packaging container 10, which engage in corresponding centering apertures 27 formed in the carrier 20.

According to Fig. 9a, the step 13 of the transport container 10 is formed as a circumferential, planar supporting surface on which the carrier 20 rests directly. According to further embodiments also additional supporting surfaces 18 or supporting members may be formed on the side walls 12 of the transport and packaging container 10. In this way, the carrier 20 can be positioned precisely in the transport and packaging container 10 and the plurality of containers 2 can be placed in this way in a regular array and at precisely defined positions in a transport and packaging container 10 having standard dimensions. In particular it can be ensured in this way that all bottoms of the containers 2 are arranged in a common plane and in parallel with the bottom 11 or upper rim 15 of the transport and packaging container 10.

Although the bottom 11 of the transport container 10 is shown in Fig. 9a to be closed and formed integrally with the side wall 12, the lower end of the transport container 10 may also be formed open in the manner of the upper end, in particular with a flange-like bottom rim in the manner of the upper rim 15 so that the bottoms of the containers 2 are freely accessible from the underside of the transport and packaging container 10, e.g. for processing steps in a sterile tunnel or in a freeze-dryer, as explained in detail below.

The accommodation of a supporting structure, which is formed in two parts and formed by a supporting frame 50 and a carrier 20 according to Figs. 2a to 2g, in a transport and packaging container 10, as described above, is shown in Figs. 3a to 3g. The supporting structure can be supported directly on the bottom 11 of the transport and packaging container 10 or may be supported on supporting surfaces of the transport and packaging container 10. For example, the upper rim 53 of the supporting frame 50 may be supported on the upper ends of protrusions provided on the side wall 12 or on the bottom 11 of the transport and packaging container 10. In this way, according to the invention also more than two height levels of the ends of the containers 2 supported on the carrier 20 can be implemented.

Fig. 3f shows the partial view encircled in Fig. 3c in a greatly enlarged view, namely in a position in which the carrier 20 is inserted into the frame 50 such that the cartridges 2 are suspended upright in the apertures 22 of the plate 21 of the carrier 20. In contrast, Fig. 3g, shows the partial view encircled in Fig. 3e in a greatly enlarged representation, namely in a position in which the carrier 20 is inserted into the frame 50 such that the cartridges 2 are inserted upside down into the apertures 22 of the plate 21 of the carrier 20 and that the cartridges 2 are arranged on the upper side of the carrier 20.

Figs. 4a to 4j show the accommodation of a supporting structure according to a further embodiment of a transport and packaging container 10, as described above and claimed by claim 2. As shown in Figs. 4c, 4d and 4f, the front ends of containers, which are designed as cartridges, can be inserted into the apertures of the plate 21 of the carrier 20 such that the expanded upper rims slightly projects beyond the plate 21 and that the supporting tongues 2 respectively support or hold the cartridges 2 in the region of the constricted neck portions. Here, the front ends of the cartridges extend through the receptacles formed by the cylindrical side walls 37. The side walls 37 are provided with slots 37a and hence can be expanded slightly, e.g. for guiding and clamping the front ends of the cartridges. The side walls 37 thereby prevent a collision between cartridges supported directly adjacent to each other on the carrier 20.

Figs. 4i shows the partial view encircled in Fig. 4f in a greatly enlarged view, namely in a position in which the carrier 20 is inserted into the frame 50 such that the cartridges 2 are suspended upright in the apertures 22 of the plate 21 of the carrier 20, which corresponds to the second position in the sense of claim 2. In the position shown in Fig. 4h, however, the lower ends of the cartridges 2 are inserted into the receptacles formed by the side walls 37, so that they rest directly on the plate 21 of the carrier 20, which corresponds to the first position in the sense of claim 2. Here, the side walls 37 can also clamp the lower ends of the cartridges 2 slightly.

Figs. 4j shows the partial view encircled in Fig. 4h in a greatly enlarged view, namely in a position in which the carrier 20 is inserted into the frame 50 such that the lower ends of the cartridges 2 are inserted into the receptacles formed by the side walls 37 and that the upper ends of the cartridges 2 with the expanded upper rims 6 provided there are also directed toward the upper aperture of the transport and packaging container 10, which corresponds to the first position in the sense of claim 2. Because in this position the front ends of the cartridges 2 are not inserted into the apertures of the plate 21 of the carrier 20, in the position shown in Fig. 4h the distance of the upper rims 6 of the cartridges 2 to the plate 21 of the carrier 20 is slightly larger than the distance of the lower edges 8 of the cartridges 2 to the plate 21 of the carrier 20 in the position according to Fig. 4f. This height difference substantially corresponds to the axial length of the constricted neck portion at the upper rim of the cartridges 2, and thus in the sense of the present application is negligible in comparison to the total length of the cartridges 2.

Figs. 4k shows the transport and packaging container described above in an exploded perspective view.

Figs. 4l shows a schematic diagram of a process for the concurrent treatment or processing of a plurality of containers according to the present invention. Here, a respective supporting structure is shown in the left-hand and right-hand part of the drawing, wherein in the left-hand part of the drawing the containers 2 are supported on the carrier 20 in the opposite orientation as in the right-hand part of the drawing. The supporting structures are conveyed by a conveying device 113, e.g. by means of conveying rollers or conveyor chains, in the direction of the arrow, i.e. in Fig. 4l from left to right. The conveying device 113 may act, for example on the upper rim 53 of the supporting frame 50. For reasons of simplicity, in Fig. 4l the associated transport and packaging container is not shown. However, as will be apparent to the person skilled in the art upon reading the above description the treatment or processing of the containers can be performed optionally either without such a transport and packaging container or while the supporting structure is accommodated in the transport and packaging container. If the bottom of the transport and packaging container is then designed to be closed, as shown for example in Fig. 9a, the treatment or processing of the containers may take place only from the upper insertion aperture of the transport and packaging container.

According to Fig. 4l, for the treatment or processing the containers supported on the supporting structure 2 are passed automated along processing stations 111, 112, which can be disposed above and/or below the conveying device 113. As can be seen in Fig. 4l, for the treatment or processing of the containers 2 there is no need to adjust the heights of the processing stations 111, 112 regardless of whether the containers 2 are supported on the supporting structure in the first position (namely, for example upright) or in the second position (namely, for example upside down), because, apart from the unavoidable tolerances as mentioned above, the upper and lower ends of the containers 2 are on the same height level in both positions (orientations). According to the invention this facilitates the treatment and processing of the containers considerably, because the effort regarding adjustment, control, and automation of the processing stations 111, 112 and of the conveying device 113 can be simplified substantially.

Fig. 5a shows a further embodiment of a supporting structure according to the present invention, wherein the supporting tongues 23 are formed as resilient supporting tongues

which project arcuately from the upper side of the plate 21 of the carrier and which extend radially inward into the associated apertures of the plate 21 of the carrier. In particular it can be seen that in the home position or supporting position, the cartridges are preferably supported in such a manner that a radial clearance is provided between

5 the front ends of the supporting tongues 23 and the constricted neck portions 5 of the cartridges and that therefore the bottoms of the expanded upper rims 6 of the cartridges rest on the front ends of the supporting tongues 23 in the position shown in the left-hand part of Fig. 5a, or that the transition regions between the constricted neck portions 5 and the cylindrical side walls 4 of the cartridges rest loosely on the rear sides of elastic

10 supporting tongues 23 in the position shown in the right-hand part of Fig. 5a. In this way, in both orientations the cartridges can be retained to the plate 21 in one axial direction. The dashed line in Fig. 5a indicates the same height level of the upper rims 6 of the cartridges and of the lower ends 8 of the cartridges when these are supported on the plate 21.

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Figs. 5b shows in a partial sectional view the supporting tongue of a supporting structure according to a further embodiment. As can be seen, the resilient supporting tongues 23 are flag-shaped and are formed with a supporting nose projecting radially inward. According to Fig. 5b, the resilient supporting tongues 23 are connected with the plate

20 21 via a resilient base 23a projecting perpendicularly from the upper side of the supporting plate 21. The base 23a merges into a portion 23b curved radially inward, which finally passes into the supporting nose 23c on which the expanded upper rim 6 of the container (see Fig. 1) rests. The supporting nose 23c protrudes into the aperture of the plate 21 of the carrier. The supporting nose 23c is followed by an insertion slope 23f

25 extending obliquely upward, which connects with the upper end of the supporting tongue 23. A recess 23d is formed between the upper insertion slope 23f and the lower insertion slope 23b, in which the upper rim 6 is retained in both axial directions (that is suitable for an upright orientation or for an upside-down orientation) and accommodated with a radial clearance. Due to the insertion slope 23f on the upper side of the supporting

30 tongue 23 and the curved portion 23b of the supporting tongue 23, which is open downward, the containers may be inserted into the apertures of the plate 21 of the carrier optionally either from above or from below and withdrawn again.

Upon insertion of the containers from above into the apertures of the carrier first the

35 bottoms or lower ends of the containers get in abutment with the insertion slopes 23f of the supporting tongues 23. When the containers are further inserted, the lower ends or

bottoms of the containers slide down along the insertion slopes 23f and resiliently spread the supporting tongues 23 progressively apart or fold and swivel them back. When the containers are further inserted, finally the cylindrical side walls 4 of the containers get in contact with the supporting noses 23e and slide therealong, until eventually the undersides of the expanded rims 6 of the containers rest loosely on the supporting noses 23c of the supporting tongues 23. The containers can be removed from the apertures of the plate 21 of the carrier either upward with the opposite movement of the supporting tongues 23 or downward with resilient bending of the supporting tongues 23.

Upon insertion of the containers from below into the apertures of the carrier, first the upper ends of the containers get in abutment with the curved portions 23b of the supporting tongues 23. Upon further introduction of the containers, the upper ends of the containers slide along the curved portions 23b upward and resiliently spread the supporting tongues 23 progressively apart or fold or swivel them back until finally the supporting noses 23c are reached. When further pushing up the containers, the bottoms of the expanded rims 6 of the containers slide over the supporting noses 23c of the supporting tongues 23 and finally rest loosely on the supporting noses 23c of the supporting tongues 23. The containers can be removed from the apertures of the plate 21 of the carrier either downward with the opposite movement of the supporting tongues 23 or upward with resilient bending of the supporting tongues 23.

In the embodiment of Fig. 5b thus the expanded upper rim portions 6 (rolled edge) of the containers are embraced clamp-like and in a positive-fit manner, while a sufficient radial clearance, as described above, is ensured, as indicated in Fig. 5b by the air gap in the radial direction. Furthermore, a sufficient axial clearance can also be ensured, as indicated in Fig. 5b by the air gap in the axial direction.

Figs. 6a to 6h show further variants for supporting the containers on a carrier, which can be provided additionally or alternatively to the supporting described above. Fig. 6a shows a side wall formed as a half-shell 37, which projects from the underside of the plate 21 of the carrier and comprises a protrusion 37b projecting at its lower end radially inward, in which a recess is formed. This protrusion 37b can be used as a stop for defining the axial position of the container 2 on the carrier, as shown in Fig. 6b, where the bottom of the expanded upper rim 6 of the container 2 rests loosely and preferably with radial clearance on the front ends 23g of the supporting tongues 23a. Fig. 6c shows a side view of the carrier of Fig. 6b. As can be seen in Fig. 6c, due to the design of the side wall 37 as a half-shell, the entire left-hand half of the container 2 is freely accessible

from the side of the supporting structure, for example for processing, handling or for an (optical) inspection of the container or of its content. Because only two supporting tongues 23a are respectively associated to the apertures of the carrier (on mutually diametrically opposite sides of the apertures), also the entire upper end of the container

5 2, including the constricted neck portion 5, is freely accessible from the side of the carrier, for example for a processing, handling or for an (optical) inspection of the container or of its content, as described below with reference to Fig. 6i. Figs. 6d and 6e show additional side views of this supporting structure.

10 Finally Figs. 6f shows a further embodiment in which the side wall 37 is shorter than the side wall of the container 2 and thus the entire lower end of the container 2 is freely accessible from the underside of the carrier. In the case of the embodiment of Fig. 6a, however, if a cartridge is used, the lower edge of the cartridge is supported on the protrusion 37b, but the filling aperture of the cartridge at the lower end of the cartridge

15 is freely accessible, for example for filling the cartridge (carpule).

Figs. 6g and 6h show this supporting structure in a plan view and in a bottom view.

Figs. 6i shows as an example the measurement of the filling level or of the filling capacity of a container formed as a cartridge by means of a laser 100. It is assumed that the cartridge is filled via the filling aperture at the upper rim 6 by means of an injection needle 110. The hatched area 9a indicates the already-filled portion of the cartridge, whereas above this area an unfilled area 9b exists, which is, for example, filled with air or an inert gas. The laser beam 101 of the laser 100 propagates through the constricted neck

20 portion 5 of the cartridge. The laser beam 101 is detected on the opposite side of the cartridge by means of an optical sensor 102. When the cartridge is also filled in the area of the laser beam 101, a lateral displacement or deflection of the laser beam 101 occurs due to the different optical conditions along the beam path, which can be detected with the sensor 102. Because the laser beam 101 may be collimated to a relatively small

25 beam diameter, in this manner also the current filling capacity of the cartridge can be detected precisely and a treatment or processing of the cartridge such as a filling operation can be stopped, for example, upon reaching a predetermined filling level.

Figs. 7a to 7f show a supporting structure according to a further embodiment for a better

35 understanding of the present invention. Instead of the supporting tongues described above, in this embodiment cylindrical or hollow cylindrical pins 42 protrude from the plate



20 of the carrier substantially perpendicularly for preventing contact of containers supported directly adjacent to each other on the carrier 20.

In the plan view of Fig. 7b and in the greatly enlarged partial view of Fig. 7c it can be  
5 seen that the carrier 20 is substantially open and is spanned by intersecting supporting webs 43 which form a mesh-like bottom of the carrier on which the pins 42 are arranged. According to Fig. 7c six support pins 42 respectively form a receptacle in which the lower end or the upper end of the container is accommodated. Here, a radial clearance can be present between the supporting pin 42 and the side wall 4 of the container. Or the  
10 supporting pins 42 may abut tangentially to the side wall 4 of the container and possibly even clamp it slightly. Here, the intersecting support webs 43 support the respective ends of the containers.

As can be seen in Fig. 7d and the greatly enlarged partial view of Fig. 7e, the containers  
15 2 (in the drawings shown as cartridges) can be inserted upright or upside down into the receptacles formed by the pins 42. According to Fig. 7d such a carrier is accommodated directly in the transport and packaging container 10.

In such a supporting structure according to a further embodiment also an additional  
20 supporting frame (not shown) can be provided, in which the carrier is in turn accommodated, as described above with reference to Figures 2, for forming a two-part supporting structure. Fig. 7f shows a transport and packaging container 10 according to such a further embodiment in a perspective exploded view.

25 According to Fig. 7c, a recessed portion may be formed in the region of the crossing point 44 of the intersecting supporting webs 43 to form a receptacle for a constricted neck portion 5 of the container (see Fig. 1) to be supported, for preventing a tilting of the containers supported on the carrier. This results in a slight difference between the distance to the carrier 2 at which the upper ends 6 of the containers 2 are arranged in  
30 the first position, and the distance to the carrier 2 at which the lower ends 3, 8 of the containers 2 are arranged in the second position. However, this substantially corresponds to the axial length of the constricted neck portion 5 of the container to be supported, and is thus usually negligible compared with the total length of the containers.

In the plan view of Fig. 7b and in the greatly enlarged partial view of Fig. 7c it can be seen that the carrier 20 is formed substantially open and is spanned by intersecting supporting webs 43 which form a mesh-like bottom of the carrier on which the pins 42 are arranged. According to Fig. 7c six support pins 42 respectively form a receptacle in which the lower end or the upper end of the container is accommodated. Here, a radial clearance can be present between the supporting pin 42 and the side wall 4 of the container. Or the supporting pins 42 may abut tangentially on the side wall 4 of the containers and possibly even clamp them slightly. Here, the intersecting supporting webs 43 support the respective ends of the containers.

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Fig. 8a shows a supporting structure according to a further embodiment of the present invention in a plan view. Like in the embodiment of Fig. 7a, according to Fig. 8a cylindrical or hollow-cylindrical pins 42 project substantially perpendicularly from the bottom 21 of the carrier 20 for preventing a collision of directly adjacent containers supported on the carrier 20. The pins are connected with each other via webs 47 which serve for stiffening the bottom 21. Overall, six pins 42 are respectively arranged around the respective apertures 22 of the carrier 20 under equidistant angular distances to form a receptacle, in which a container is to be accommodated. Besides the apertures 22, the bottom 21 of the carrier 20 is closed and is preferably formed from a plastic material.

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An elastic material, such as rubber or a soft, resilient plastic, can be applied around the apertures 22 to form a ring-shaped structure serving as a sealing member, as described in the following with reference to Figs. 8c-8e. Particularly two-component injection molding techniques are suited for this purpose. Such a sealing member can also be positioned as a separate sealing gasket around the apertures 22 on the bottom 21 of carrier 20.

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According to Fig. 8a the carrier 20 is trough-shaped, with a relatively wide rim 40, which is connected with the bottom 21 via side walls that are slightly inclined inward. Ribs 46 are formed on the inner sides of the side walls 35, which serve as spacers when a plurality of such carriers 20 is stapled in a stack one above the other.

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Fig. 8b shows the portion encircled in Fig. 8a in a greatly enlarged view.

With reference to Figs. 8c-8e, in the following a process according to the present invention will be described, which is used to close the rear end of a cartridge (cylinder ampoule) with a rubber stopper. It is expressly noted that this process can be performed

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also outside of a carrier, as described above, and that this process represents an independent invention, which can be explicitly claimed by the present application independently to the above embodiments.

- 5 The filling and sealing of pre-sterilized cartridges is of particular interest because it must be ensured that the drug stored in the cartridge retains its properties for years. To prevent an interaction of the drug with air, according to the invention the cartridge is evacuated, and then a stopper is inserted into the rear end of the cartridge to close it.
- 10 According to Fig. 8c the stopper 80 is inserted by a vacuum gripper 70 in a compressed state inside a cylinder 71 and held compressed in the cylinder 71. The outer diameter of the cylinder 71 is smaller than the inner diameter of the cartridge 2. Furthermore, the inner diameter of the cylinder 71 is smaller than the outer diameter of the stopper 80 when it is not compressed. The vacuum gripper 70 can be displaced in axial direction
- 15 together with the cylinder 71, but can be displaced in axial direction relative to the cylinder 71.

A liquid 9a is filled into the cartridge 2, of which only the rear end is shown in Figs. 8c to 8e. Above the liquid level 9c of the liquid 9a, the inner volume 9b of cartridge 2 is not

- 20 filled. According to Fig. 8c an annular sealing member 77 is fitted onto the rear end of the cartridge 2, which is here flat (i.e. without a finger handle), to seal the rear end of the cartridge 2 against the environment. The cylinder 71 can be inserted by the vacuum gripper 70 into the aperture of the sealing member 77, because the outer diameter of the cylinder 71 is smaller than the diameter of the aperture.

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At the front end of the cylinder 71 there is a plunger 73, which is sealed against the cylinder 71 by a sealing ring 74. The cylinder 71 and vacuum gripper 70 can be displaced relative to the plunger 73 in axial direction. The plunger 73 serves as an abutment surface which abuts against the sealing member 77 and can exert a pressure on the

- 30 latter. According to Fig. 8c a radial suction channel 75 is formed inside of the plunger 77, through which the air or gas can be evacuated out of the annular gap 76 between the cylinder 71 and the cartridge 2 by a suction device (not shown). The sealing member 77 may consist of an elastic rubber material and can be positioned on the rear edge of the cartridge 2. However, the sealing element can also be the bottom 21 of a carrier 20
- 35 (see Fig. 8) or the sealing member can also be disposed or applied around the respective aperture 22 in the bottom 21 of the carrier 20. When the cartridges rest

upright on the bottom 21 of a carrier 20, which is closed as shown in Fig. 8a, the sealing arrangement shown in Fig. 8c can be implemented automatically when the cartridges 2 are inserted upright into a carrier. This position can in particular also be the transport position, in which the cartridges 2 are inserted into a carrier (nest) and in which the carrier is stored under sterile conditions and transported in a transport and packaging container such as shown, for example, in Fig. 7d.

The closing or sealing process starts with the setting of the stoppers: a sorting bowl (not shown) conveys stoppers 80 to the vacuum gripper 70 which is used to push then onto the cartridge afterwards. The vacuum gripper 70 pushes the stopper 80 into the cylinder 71 and the stopper 80 is thereby compressed, as shown in Fig. 8c. Subsequently, the vacuum gripper 70 is placed on the rear edge of the cartridge 2 together with the cylinder 71 and the plunger 73, whereby the sealing element 77 is pinched between the plunger 73 and the rear edge of the cartridge 2 to seal the inner volume 9b, which is not filled with liquid, and the annular gap 76 between the cylinder 71 and the cartridge 2 against the environment.

Air is then sucked out of the inner volume 9b that is not filled with liquid through the suction channel 75. Subsequently, the vacuum gripper 70 is displaced in axial direction relative to the cylinder 71 toward the liquid surface 9c. Here, the stopper 80 is first pushed out of the cylinder 71, so that it relaxes and bears sealingly on the inner wall of cartridge 2. Subsequently, the vacuum gripper 70 is further displaced in axial direction relative to the cylinder 71 towards the liquid surface 9c until the stopper 80 rests on the liquid surface 9c, as shown in Fig. 8d. After separation of the vacuum gripper 70 and the stopper 80, the sealing arrangement can be released, and the vacuum-gripper 70 and the cylinder 71 can be displaced again in axial direction out of the rear end of the cartridge 2, as shown in Fig. 8d.

Subsequently, the vacuum gripper 70 is further displaced relative to the cylinder 71 in axial direction, as shown in Fig. 8e, and the vacuum gripper 70 together with the cylinder 71 is displaced in axial direction out of the rear end of the cartridge 2 so that a new closing or sealing process can start.

During this closing or sealing process an optical inspection can check whether the stoppers are actually present. Furthermore, the positions of the cartridge, of the stopper and/or of the vacuum gripper can be determined and suitably adjusted. In a further part

of the closing or sealing process a towing train can put caps onto the stoppered cartridges. These caps can be in particular metal lids that are crimped onto the rims of the cartridges. These caps can be conveyed by a sorting bowl.

- 5 A filling of containers, especially of cartridges, under vacuum, which can prevent the formation of bubbles, is usually carried out with rotary piston pumps. The art of handling viscous liquids under vacuum is to find a balance of the various parameters. With conventional methods a too strong vacuum can cause that the product starts boiling. In the conventional setting of stoppers in turn there is the risk that the product is extracted  
10 out of the cartridge past the stopper. However, if the vacuum is too low, air pockets or bubbles do not occur.

By means of the width of the annular gap 76 (see Fig. 8c) and of the suction channel 75 and the vacuum used for suctioning, according to the present invention appropriate  
15 parameters can be determined easily, so that stoppers can be set without boiling of the liquid but also without air pockets or bubbles in the liquid. It is a positive side-effect that by means of the afore-mentioned closing or sealing process a higher sterile safety level can be attained with only a small amount of air present in the cartridge, that the dosing accuracy is usually higher and that a potential displacement of the stopper caused by  
20 changing climatic conditions (air pressure) during transport can be eliminated.

In particular, the above-mentioned closing or sealing process can be also carried out such that the containers, in particular cartridges, are supplied to a sealing station in a carrier, as described above, and in a predetermined geometric arrangement, wherein  
25 the open ends of the containers are positioned as close as possible to the bottom of carrier. For example, the open end of a container can be supported directly on the bottom of the carrier or the open ends, for example the necks of the containers, may extend to the other side of the carrier through the apertures formed in the bottom of the carrier. Thus, the bottom of the carrier can act directly as a counter member for the  
30 plunger of the sealing station. The containers are supported on the carrier in such a manner that the open ends thereof are disposed in alignment with the apertures in the bottom of the carrier. Subsequently, the plunger of the sealing station approaches the open end of the container, as described above, and the sealing or closing operation is performed, as described above, while the containers are supported on the carrier.

As will become apparent to the person skilled in the art upon reading the foregoing description, the containers may be supported on the supporting structure also by means of any other positive or frictional coupling.

- 5 The supporting force exerted by the supporting means on the containers is sufficient to support the containers reliably on the supporting structure. In particular, the supporting force exerted is greater than the weight of the containers, if necessary together with the content and a sealing stopper. Thus, a reliable supporting of the containers on the supporting structure is ensured. At the same time the containers can be displaced in the
- 10 apertures or receptacles of the supporting structure without any major effort, in particular displaced forward in axial direction or rotated,.

- Of course, in the sense of the present invention the supporting structure or the carrier can also be formed of a thermoplastic, thermosetting or elastomeric plastic, wherein at
- 15 least portions of the supporting structure or of the carrier are provided with a coating reducing friction, to facilitate insertion and removal of the containers.

P A T E N T K R A V

1. Holdestruktur til samtidig fastholdelse af adskillige beholdere (2) med en forudbestemt længde, som tjener til opbevaring af substanser til medicinske, farmaceutiske eller  
 5 kosmetiske anvendelser eller indeholder disse, og som har øvre ender (6) og nedre ender (8), med en bærer (20), som omfatter adskillige holdeorganer (23) og er indrettet til at fastholde beholderne valgfrit i en første orientering eller i en anden orientering, som er modsatrettet den første orientering, **kendetegnet ved, at** holdestrukturen er udformet todelt og omfatter bæreren (20) og en ramme (50), mod hvilken bæreren (20) kan hvile  
 10 i en første forudbestemt orientering eller i en anden forudbestemt orientering, som er modsatrettet den første forudbestemte orientering, idet bæreren (20) er afstemt til længden på beholderne (2) således, at

de øvre ender (6) på beholderne (2) i en første stilling (fig. 3i), i hvilken beholderne (2)  
 15 er fastholdt i den første orientering på bæreren (20), og bæreren (20) er understøttet i den første forudbestemte orientering på rammen (50), er anbragt med den samme afstand til den øvre kant af den til understøtning af bæreren (20) tjenende ramme (50), som de nedre ender (3; 8) på beholderne (2) i en anden stilling (fig. 3h), i hvilken beholderne (2) er fastholdt i den anden orientering i bæreren (20), og bæreren (20) er  
 20 understøttet i den anden forudbestemte orientering på rammen (50), og

de øvre ender (6) og/eller de nedre ender (8) på beholderne (2), medens disse er fastholdt i bæreren (20), er tilgængelige for en viderebearbejdning af beholderne.

25 2. Holdestruktur til samtidig fastholdelse af adskillige beholdere (2) med en forudbestemt længde, som tjener til opbevaring af substanser til medicinske, farmaceutiske eller kosmetiske anvendelser, eller indeholder disse, og som omfatter øvre ender (6) og nedre ender (8), med en bærer (20), som omfatter adskillige holdeorganer (23) og er indrettet til valgfrit at fastholde beholderne i en første eller anden orientering i bæreren  
 30 (20), **kendetegnet ved, at** holdestrukturen er udformet todelt og omfatter bæreren (20) og en ramme (50), mod hvilken bæreren (20) kan hvile i en første orientering eller en anden orientering, som er modsatrettet den første orientering, idet bæreren (20) er afstemt således til længden på beholderne (2), at

35 de øvre ender (6) på beholderne (2) i en første stilling (fig. 4h), i hvilken beholderne (2) er fastholdt i en forudbestemt orientering i bæreren (20), og bæreren (20) hviler i den

første orientering mod rammen (50), er beliggende i den samme afstand fra den øvre kant af den til understøtning af bæreren (20) tjenende ramme (50), som de øvre ender (6) på beholderne (2) i en anden stilling (fig. 4f), i hvilken beholderne (2) er fastholdt i den samme forudbestemte orientering i bæreren (20), og bæreren (20) hviler i den anden orientering mod rammen (50), idet

de øvre ender (6) på beholderne (2), medens bæreren (20) hviler i den første orientering mod rammen (50) og beholderne (2) er fastholdt i den forudbestemte orientering i rammen (20), er tilgængelige for en viderebearbejdning af beholderne, eller

de øvre ender (6) på beholderne (2), medens bæreren (20) hviler i den anden orientering mod rammen (50), og beholderne (2) fastholdt i den forudbestemte orientering i bæreren (20), er tilgængelige for en viderebearbejdning af beholderne.

3. Holdestruktur ifølge krav 1 eller 2, hvor bæreren omfatter adskillige åbninger (22), som hver især fortrinsvis er tilknyttet to holdeorganer (23), idet beholderne (2) fastholdes således, af holdeorganerne (23) i bæreren (20), at disse strækker sig igennem åbningerne i bæreren, at de øvre ender (6) på beholderne stikker frem over en øvre kant af bæreren, og/eller at de nedre ender (3; 8) på beholderne stikker frem over en nedre kant på bæreren.

4. Holdestruktur ifølge ethvert af de foregående krav, hvor beholderne i den første stilling og i den anden stilling er understøttet i bæreren eller er aksialt fastholdt i bæreren.

5. Holdestruktur ifølge ethvert af de foregående krav, hvor holdeorganerne er udformede som elastiske holdetunger (23), som er tilvejebragt ved kanten af en respektiv åbning og stikker ud fra en overside af bæreren (20), med henblik på at fastholde den respektive beholder, idet de elastiske holdetunger (23) er udformede således, at disse ved indføring af beholderne i åbningerne eller udsparingerne svinger elastisk væk eller bortvippes, idet de elastiske holdetunger fortrinsvis er afstemt således til beholderne, at disse med radial frigang fastholdes af de elastiske holdetunger.

6. Holdestruktur ifølge ethvert af de foregående krav, hvor sidevægge (37) eller tappe (42) stikker i det væsentlige vinkelret ud fra en underside af bæreren (20), med henblik på at forhindre en berøring af umiddelbart tilstødende i bæreren fastholdte beholdere, idet



sidevæggene (37) eller tappene (42) er udformede således, at beholderne fra undersiden af bæreren (20) er frit tilgængelige, eller

- 5 hvor sidevæggene (37) ikke er udformede rundtgående, således at et afsnit af de i bæreren fastholdte beholdere er sideværts tilgængeligt.

7. Holdestruktur ifølge ethvert af kravene 1-4, hvor tappe (42) stikker i det væsentlige vinkelret ud fra en underside af bæreren (20), med henblik på at forhindre en berøring af umiddelbart tilstødende i bæreren fastholdte beholdere, idet holdeorganerne (43) er udformede således, at de respektive ender på beholderne hviler imod holdeorganerne, idet holdeorganerne (43) er udformede som indbyrdes krydsende og indbyrdes forbundne holdetværstykker, hvor i det mindste to holdetværstykker (43) spænder over en i bæreren udformet åbning (22), og hvor der i området ved et krydsningspunkt (44) mellem de indbyrdes krydsende holdetværstykker (43) er udformet et nedsænket afsnit, med henblik på at danne en holder for et indsnævret halsafsnit (5, 6) på den beholder, som skal fastholdes, med henblik på at modvirke en vipning af de i bæreren fastholdte beholdere.

- 20 8. Holdestruktur ifølge ethvert af de foregående krav, hvor elementer (54; 40; 41) er tilvejebragt, især på rammen (50) og bæreren (20), med henblik på i den respektive orientering at fastlægge en forskellig højdedifferens imellem rammen (50) og bæreren (20), hvor elementerne (54; 40, 41) fortrinsvis samvirker formbetinget indbyrdes.

- 25 9. Transport- og emballeringsbeholder til adskillige beholdere (2) til substanser til medicinsk, farmaceutisk eller kosmetisk anvendelse, hvor transport- og emballeringsbeholderen (10) er udformet kasseformet, **kendetegnet ved** en holdestruktur ifølge ethvert af de foregående krav, som optages i den kasseformede transport- og emballeringsbeholder, med henblik på at fastholde de adskillige beholdere (2) i transport- og emballeringsbeholderen, idet beholderne (2) hver især ikke stikker ud over en øvre hhv. nedre kant af transport- og emballeringsbeholderen, når beholderne er fastholdt i bæreren i den første stilling eller i den anden stilling.

- 35 10. Fremgangsmåde til behandling eller bearbejdning af beholdere (2), som tjener til opbevaring af substanser til medicinske, farmaceutiske eller kosmetiske anvendelser eller indeholder disse, og som omfatter øvre ender (6) og nedre ender (8), idet

beholderne ved i det mindste én ende er udformede åbne, og hvor beholderne ved hjælp af en fremføringsindretning (113), med henblik på behandling eller bearbejdning, føres forbi processtationer (111, 112) eller gennemløber disse, ved hvilken

- 5 de adskillige beholdere (2) fremføres af fremføringsindretningen, medens disse fastholdes af en holdestruktur, og

beholderne, medens disse fastholdes af holdestrukturen, behandles eller bearbejdes,

10 **kendetegnet ved, at**

holdestrukturen er udformet todelt og omfatter en bærer (20) og en ramme (50), mod hvilken bæreren (20) valgfrit kan hvile i en første forudbestemt orientering eller i en anden forudbestemt orientering, som er modsatrettet den første forudbestemte

- 15 orientering, og

beholderne valgfrit kan være fastholdt i bæreren (20) i en første orientering og i en anden orientering, som er modsatrettet den første orientering,

- 20 ved hvilken fremgangsmåde

de øvre ender (6) på beholderne (2) i en første stilling (fig. 3i), i hvilken beholderne (2) er fastholdt i den første orientering i bæreren (20), og bæreren (20) hviler i rammen (50) i den første forudbestemte orientering, er anbragt med den samme afstand til den øvre kant af bæreren (20) eller den øvre kant (53) af den til understøtning af bæreren (20) tjenende ramme (50), som de nedre ender (3; 8) på beholderne (2) i en anden stilling (fig. 3h), i hvilken beholderne (2) er fastholdt i den anden orientering i bæreren (20), og bæreren (20) hviler i den anden forudbestemte orientering mod rammen (50), og

- 30 påvirkes ved behandling eller bearbejdning på beholderne (2) via disses øvre ender (6) og/eller via disse nedre ender (8) i den første eller anden stilling.

11. Fremgangsmåde til behandling eller bearbejdning af beholdere (2), som tjener til opbevaring af substanser til medicinske, farmaceutiske eller kosmetiske anvendelser, eller indeholder disse, og som omfatter øvre ender (6) og nedre ender (8), idet

35 beholderne ved i det mindste én ende er udformede åbne, og hvor beholderne ved hjælp

af en fremføringsindretning (113), med henblik på behandling eller bearbejdning, føres forbi eller gennemløber processtationer (111, 112), ved hvilken

adskillige beholdere (2) fremføres af fremføringsindretningen, medens disse fastholdes  
5 i en holdestruktur, og

beholderne, medens disse fastholdes af holdestrukturen, behandles eller bearbejdes,

**kendetegnet ved, at**

10

holdestrukturen er udformet todelt og omfatter en bærer (20) og en ramme (50), mod hvilken bæreren (20) valgfrit kan hvile i en første orientering eller i en anden orientering, som er modsatrettet den første orientering, og

15 bæreren (20) valgfrit kan fastholdes i en første orientering eller i en anden orientering i rammen (50),

ved hvilken fremgangsmåde

20 de øvre ender (6) på beholderne (2) i en første stilling (fig. 4h), i hvilken beholderne (2) er fastholdt i en forudbestemt orientering i bæreren (20), og bæreren (20) hviler i den første orientering i rammen (50), er beliggende i den samme afstand fra den øvre kant af den til understøtning af bæreren (20) tjenende ramme (50), som de øvre ender (6) på beholderne (2) i en anden stilling (fig. 4f), i hvilken beholderne (2) fastholdes i den  
25 samme forudbestemte orientering i bæreren (20), og bæreren (20) hviler i rammen (50) i den anden orientering, og

påvirkes til behandling eller bearbejdning på beholderne (2) via disses øvre ender (6), medens bæreren (20) hviler i den første orientering i rammen (50), og beholderne (2)  
30 fastholdes i den forudbestemte orientering i bæreren (20),

påvirkes til behandling eller bearbejdning på beholderne (2) via disses øvre ender (6) og/eller disses nedre ender (8), medens bæreren (20) hviler i den anden orientering i rammen (50), og beholderne (2) fastholdes i den forudbestemte orientering i bæreren  
35 (20).

12. Fremgangsmåde ifølge krav 10 eller 11, hvor behandlingen eller bearbejdningen af beholderne omfatter et trin til måling af en fyldningsmængde i beholderne (2), ved hvilken beholderne (2) fastholdes således i holdestrukturen, at en laserstråle (101) stråler igennem respektive indsnævrede halsafsnit (5) på beholderne (2) og laserstrålen

5 (101) ved hjælp af en føler (102) detekteres, idet der på basis af et målesignal fra føleren (102) sluttet til den respektive fyldningsmængde for beholderne, især til et fyldningsniveau for beholderne.

13. Fremgangsmåde ifølge ethvert af kravene 10-12, hvor behandlingen eller bearbejdningen af beholderne, medens disse fastholdes i bæreren (20), i det mindste omfatter et trin til rengøring af beholderne (2) og/eller til vejning af beholderne og/eller til fyldning af beholderne (2) og/eller lukning af beholderne med propper (80) eller hætter og/eller til bertling af metalkapper på beholderne.

15 14. Fremgangsmåde ifølge krav 13, hvor lukningen af en beholder med en prop (80) omfatter:

anbringelse af et tætningselement (77; 21) på én ende af beholderen (2), med henblik på at tætnen enden af beholderen imod omgivelserne; indføring af proppen

20 (20) i en komprimeret tilstand ved hjælp af en gribeindretning (70, 71) i enden af beholderen;

påføring af et undertryk ved enden af beholderen via en ringspalte (76) imellem gribeindretningen og en indvendig side i beholderen; og

25 frigivelse af proppen (80), indtil denne ligger an imod indersiden af beholderen med henblik på at tætnen enden af beholderen imod omgivelserne.

15. Fremgangsmåde ifølge krav 14, hvor gribeindretningen omfatter en cylinder (71),

30 hvis udvendige diameter er mindre end den indvendige diameter på enden af beholderne (2), idet indføringen af proppen (80) i den komprimerede tilstand ved hjælp af gribeindretningen (70, 71) i enden af beholderen yderligere omfatter:

komprimering af proppen (80) ved indføring af proppen i cylinderen (71);

forskydning af cylinderen (71) sammen med gribeindretningen (70), med henblik på at indføre proppen i enden af beholderen;

5 trykning af tætningselementet (77; 21), med henblik på at tætnes enden af beholderen i forhold til omgivelserne; og

udskydning af proppen (80) fra cylinderen (71) videre ind i enden af beholderen til overflade (9c) på væsken, som opbevares i beholderen (2).

10 16. Fremgangsmåde ifølge krav 14 eller 15, hvor tætningselementet er en bund (21) i bæreren (20), idet beholderne (2) anbringes således på bunden (21) af bæreren (20), at enderne på beholderne flugter med åbninger (22), som er udformede i bunden (21), og propperne (80) indføres igennem åbningerne (22) i enderne af beholderne.

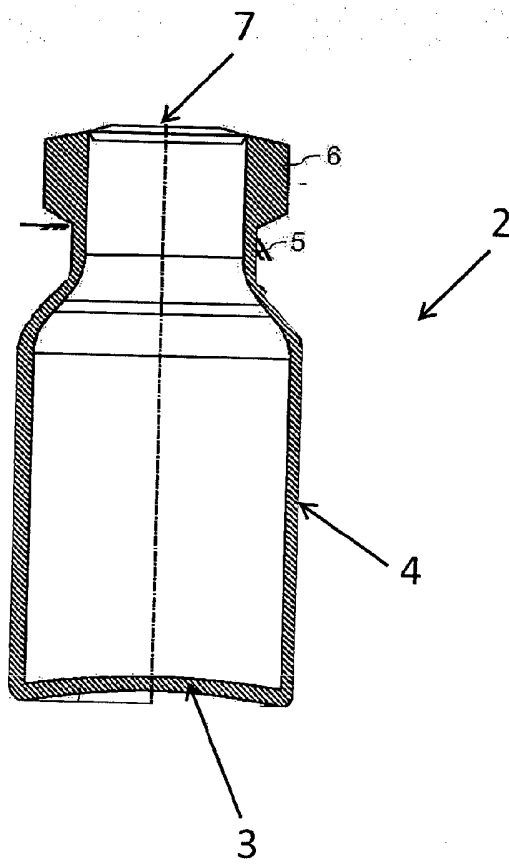


Fig. 1

20

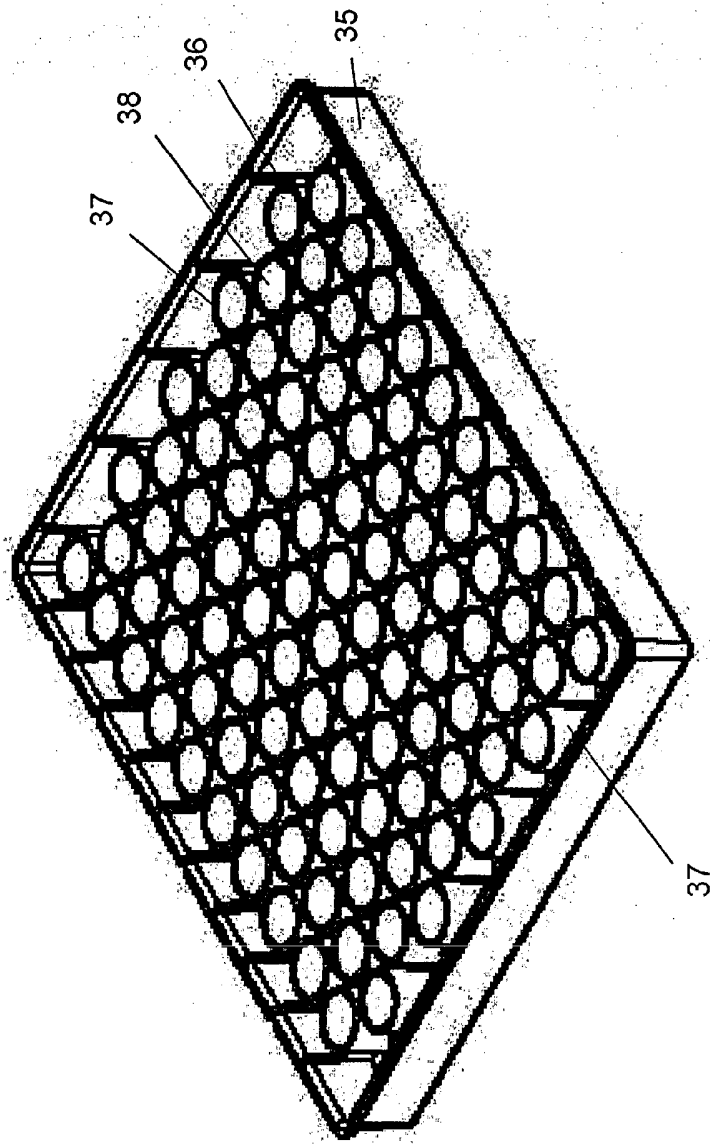


Fig. 2a

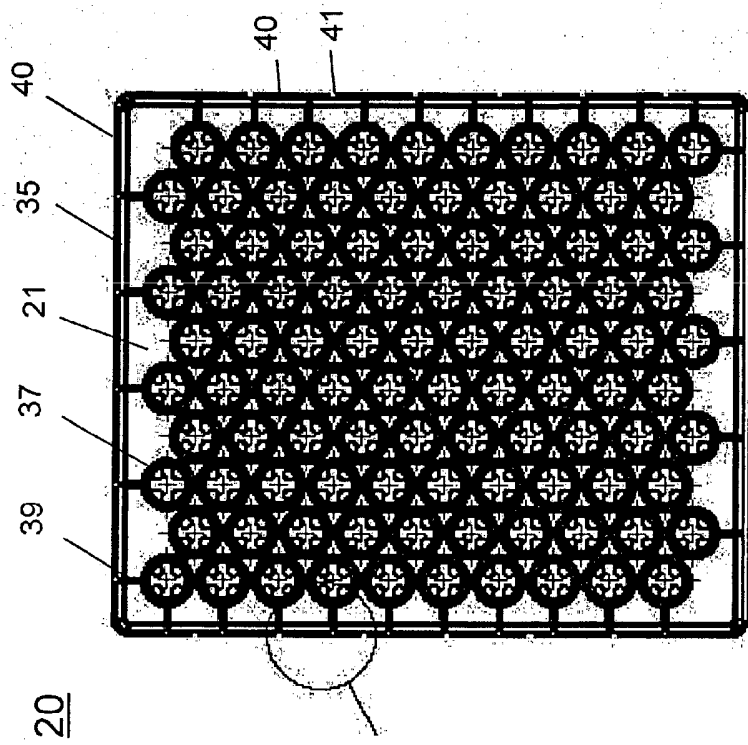


Fig. 2b

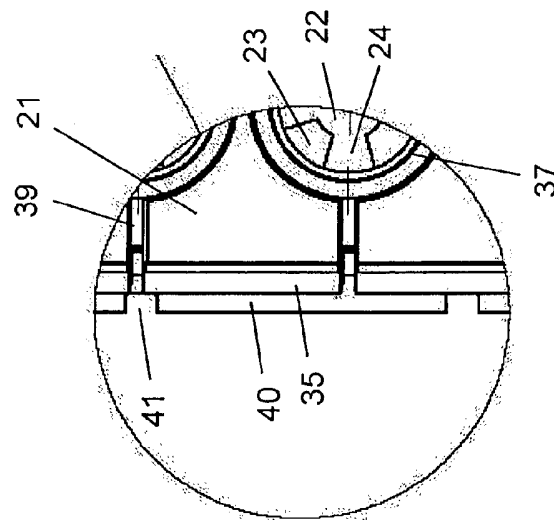


Fig. 2c



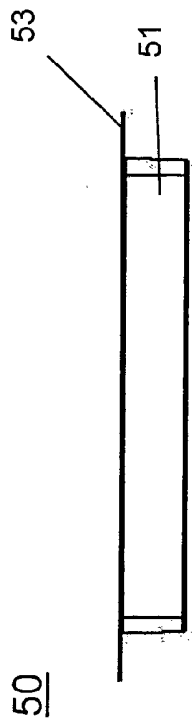


Fig. 2d

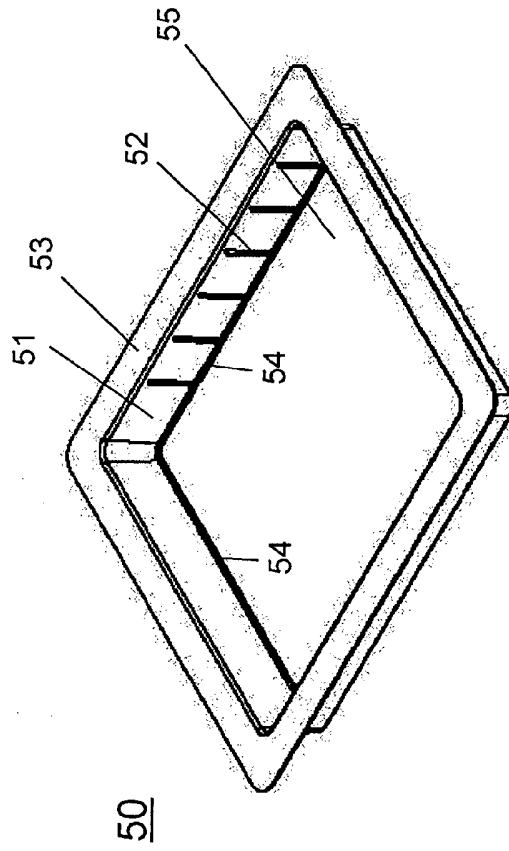


Fig. 2e

50

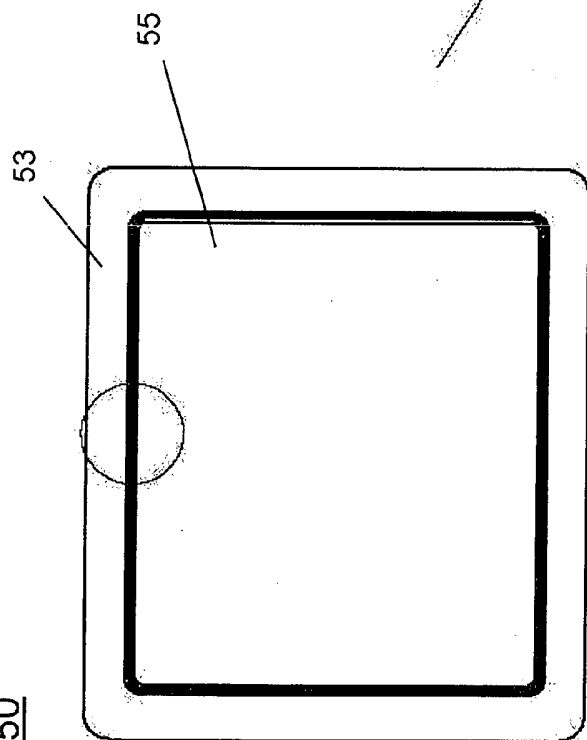


Fig. 2f

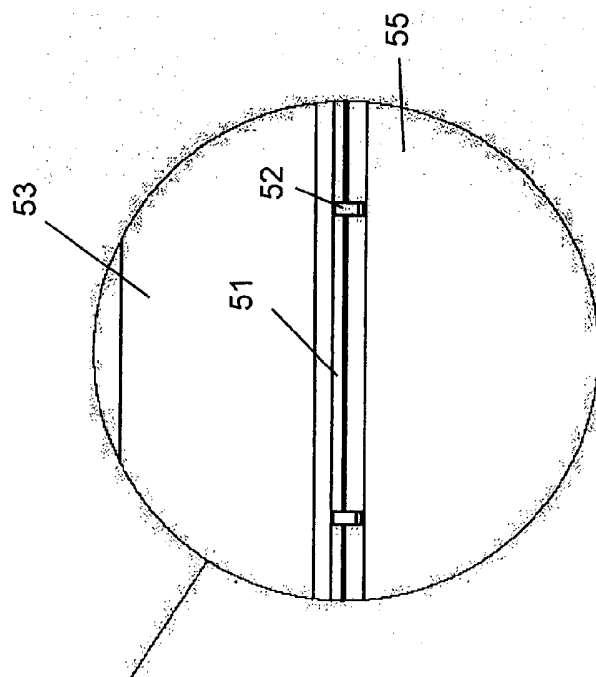


Fig. 2g

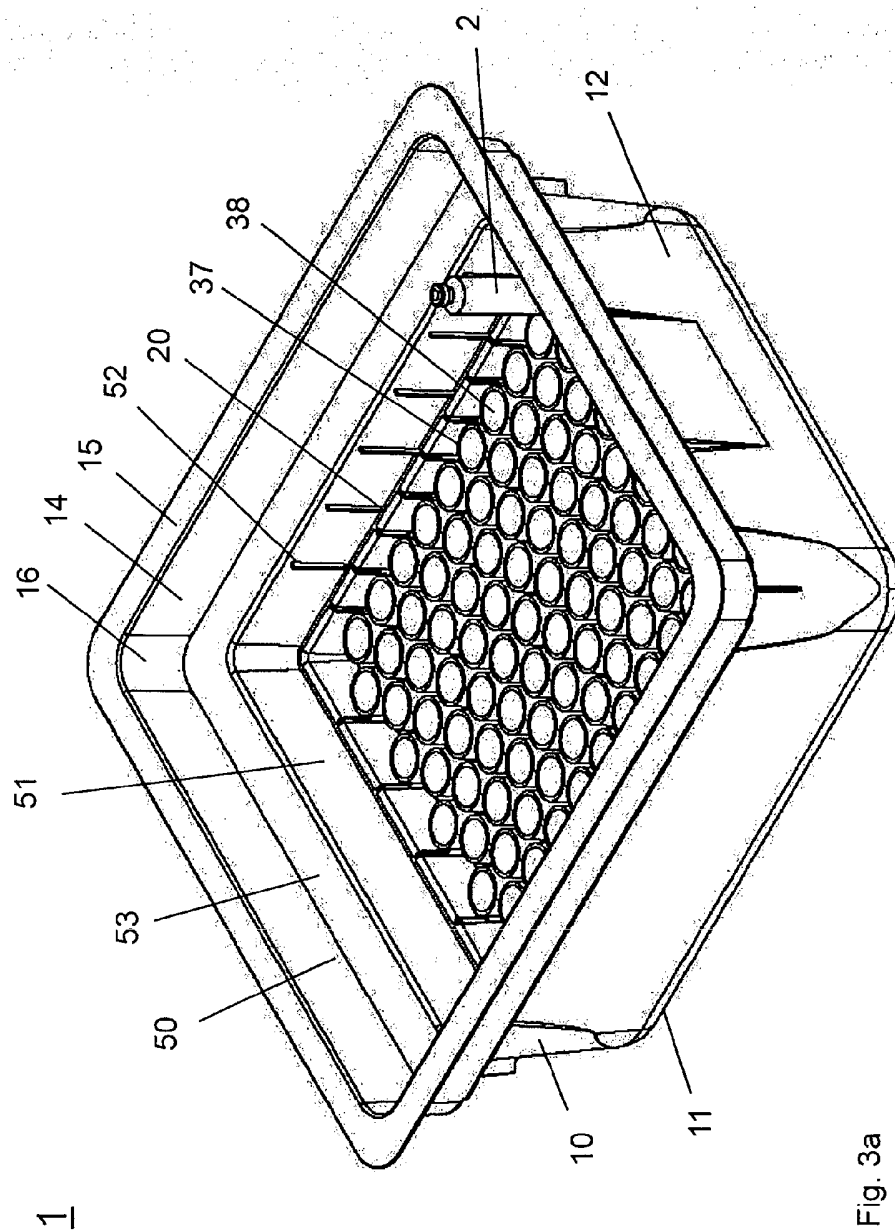


Fig. 3a

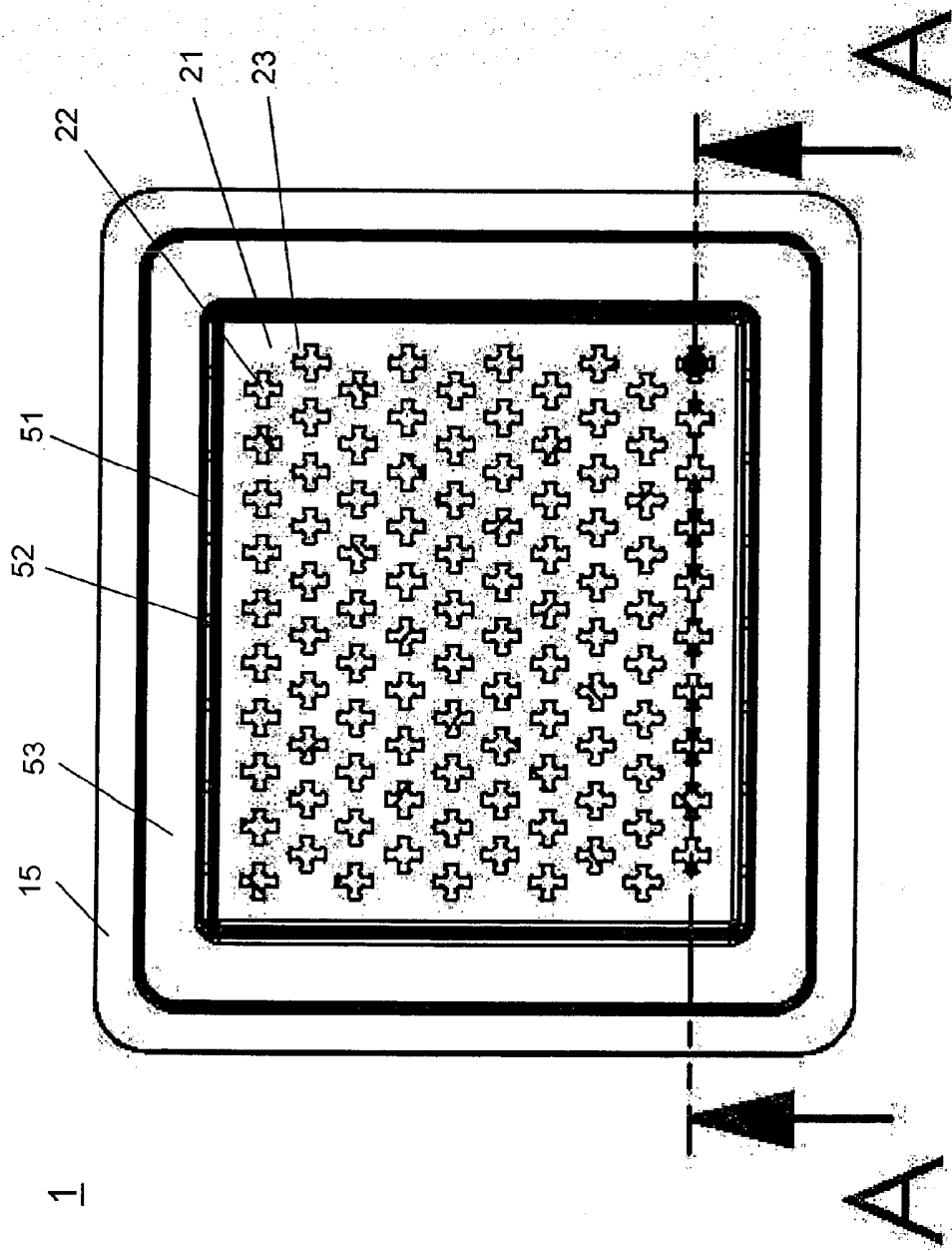


Fig. 3b

1

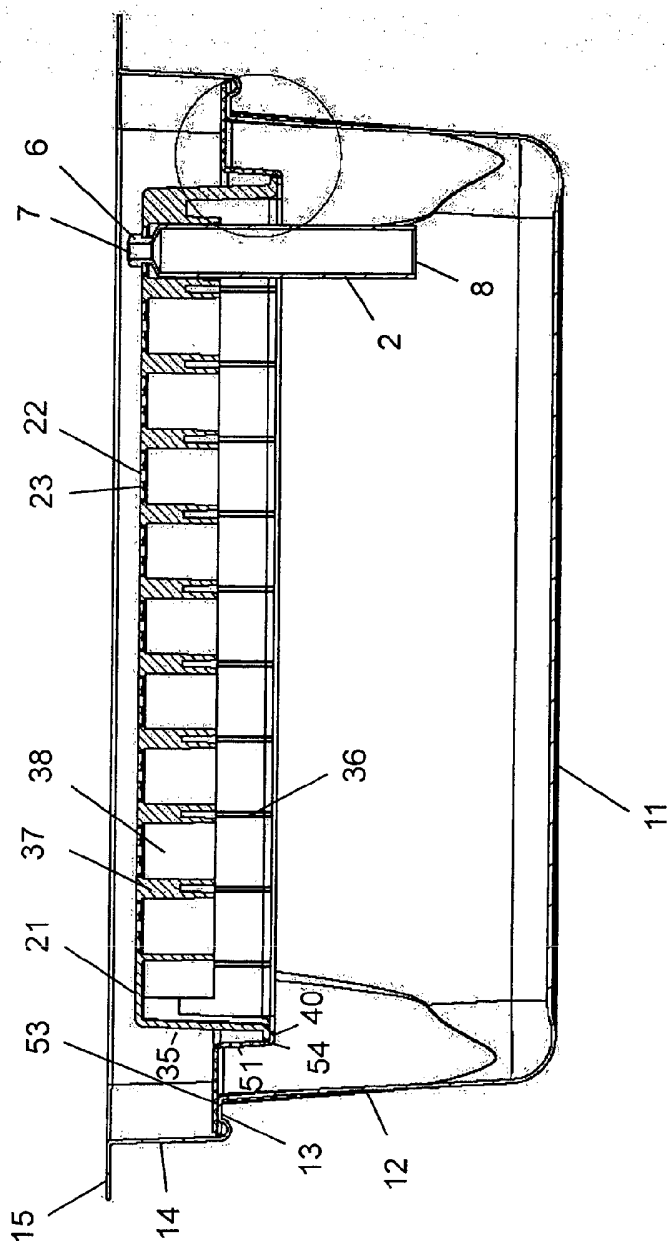


Fig. 3c

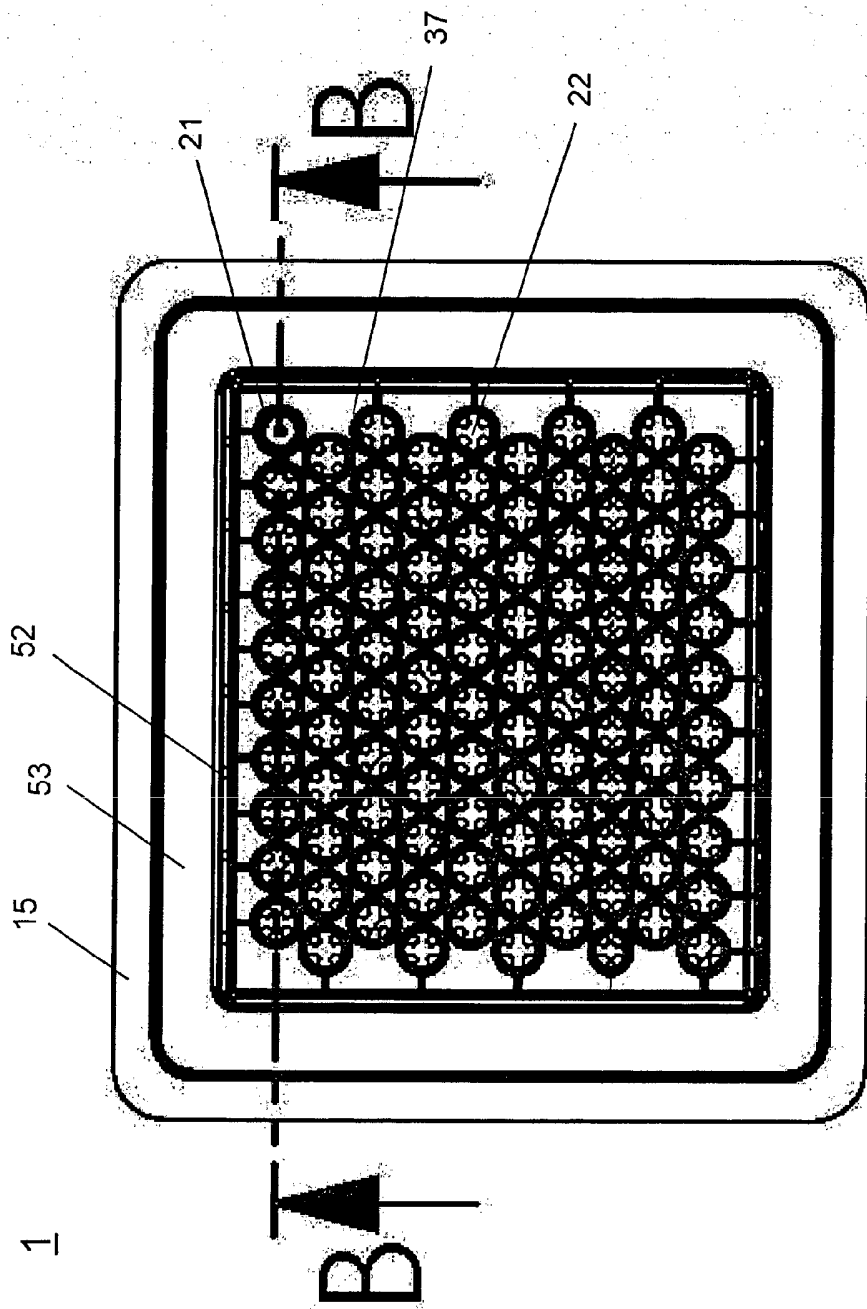


Fig. 3d

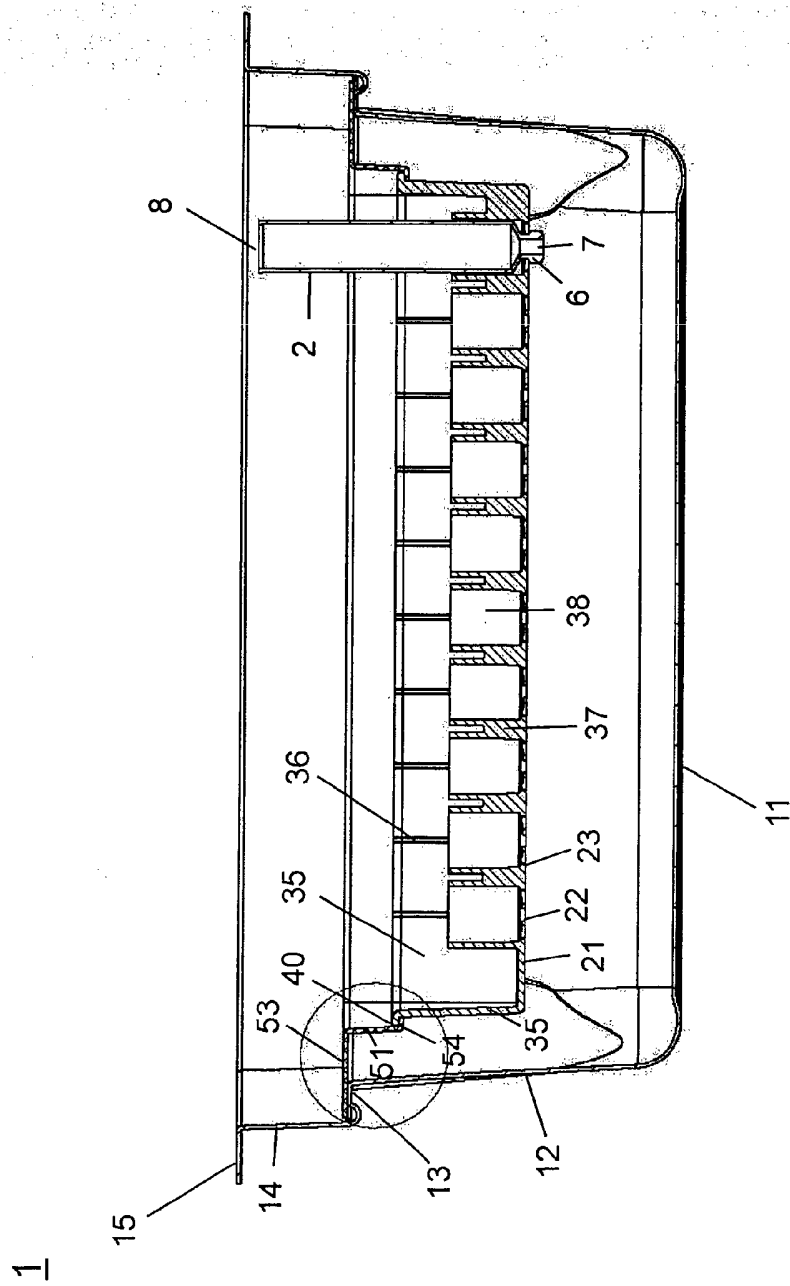


Fig. 3e

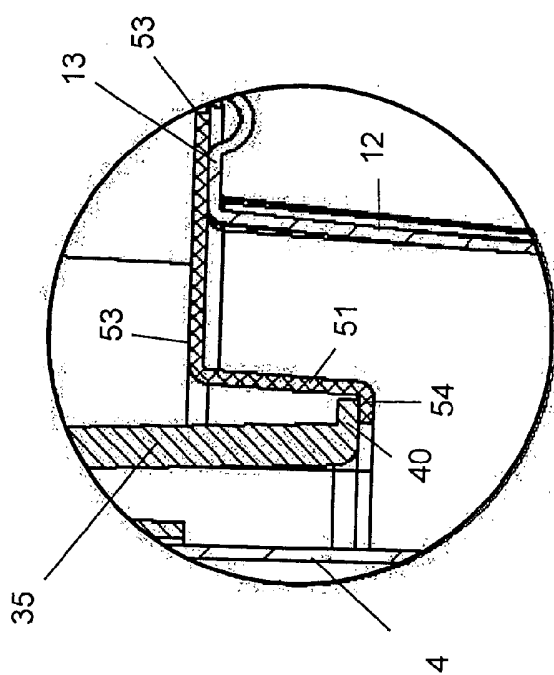


Fig. 3f

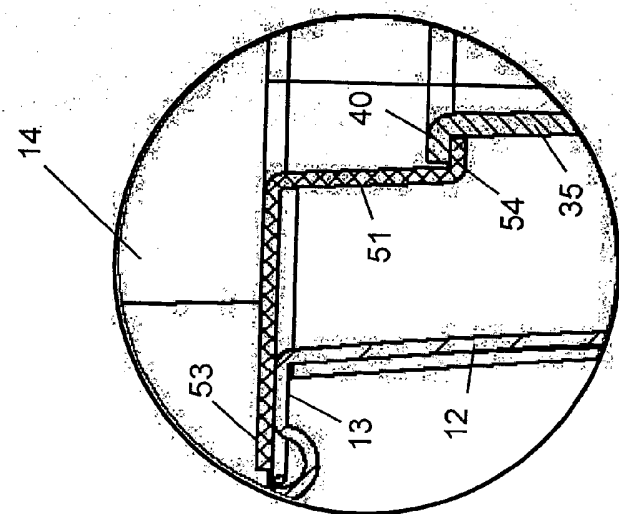


Fig. 3g



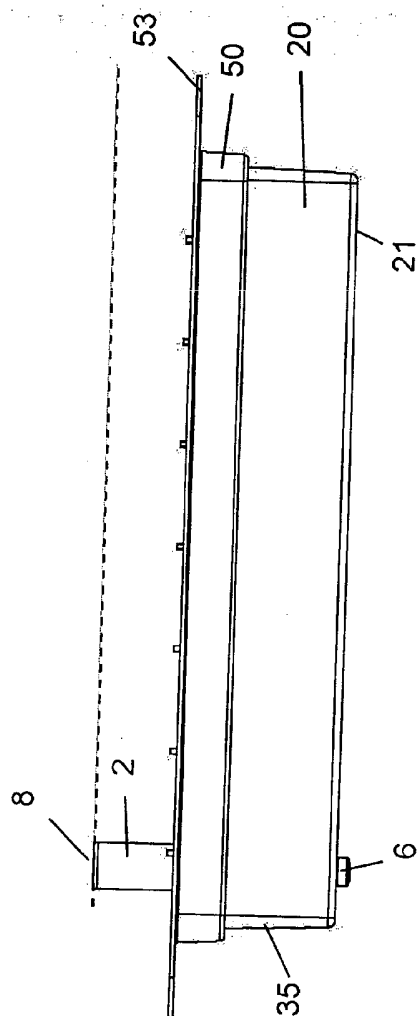


Fig. 3h

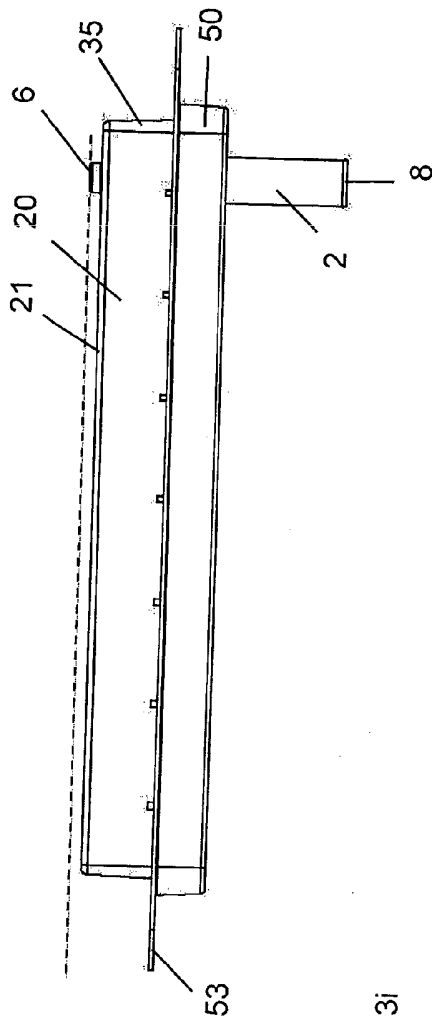


Fig. 3i

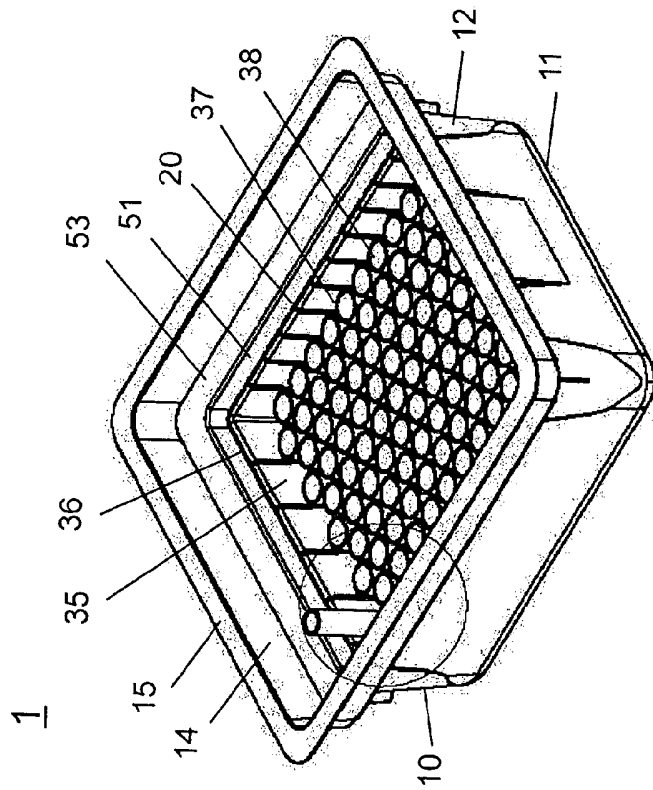


Fig. 4a

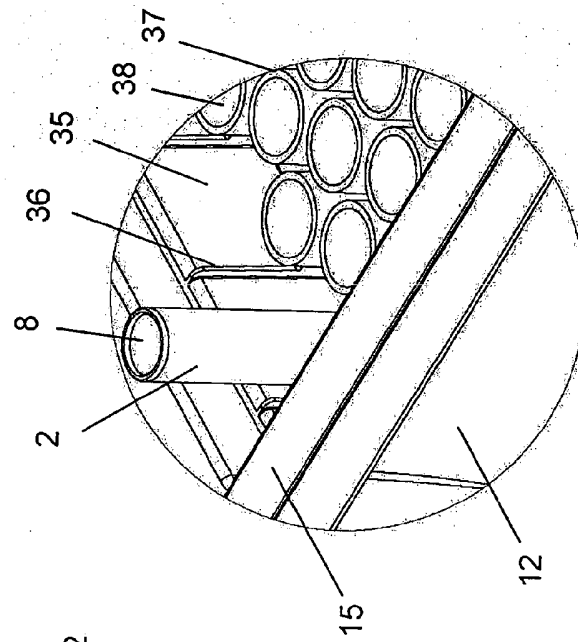
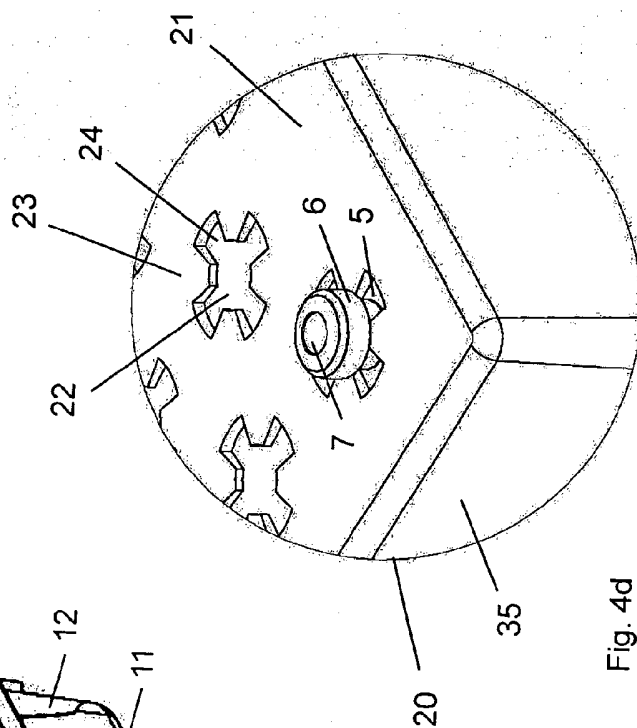
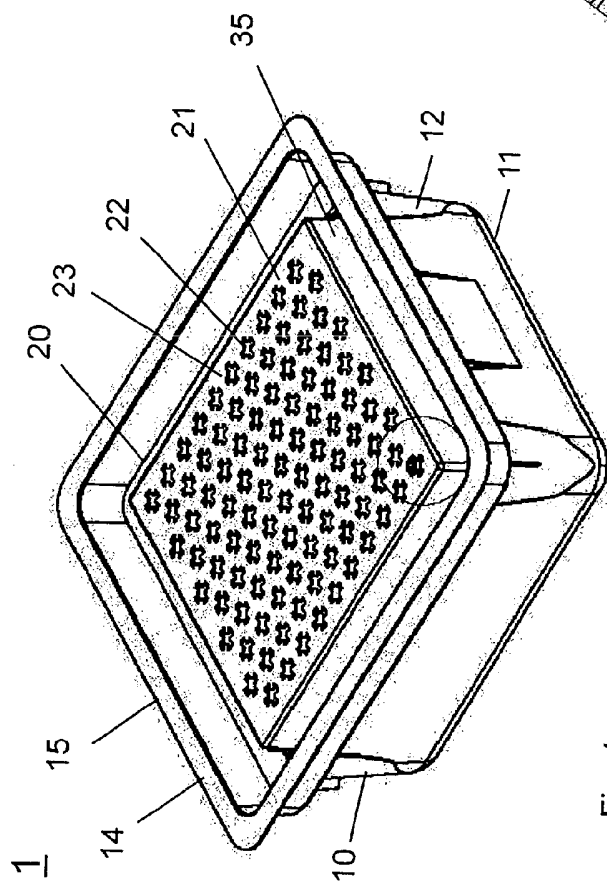


Fig. 4b



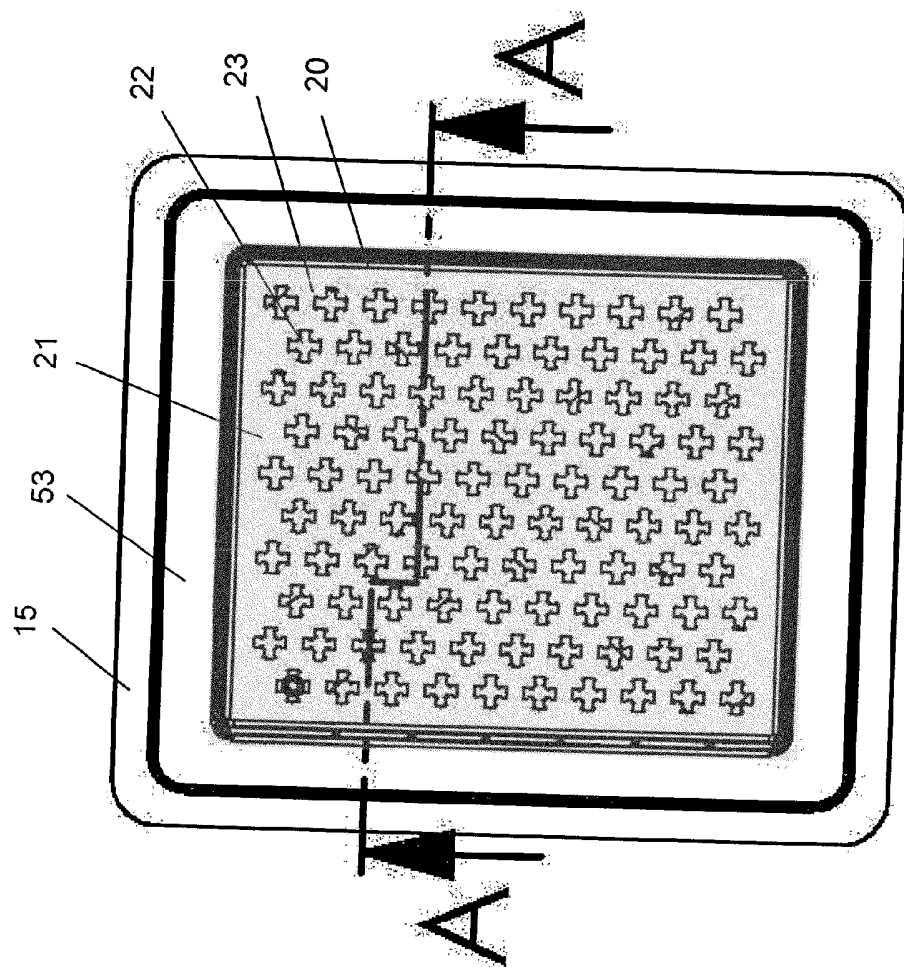


Fig. 4e

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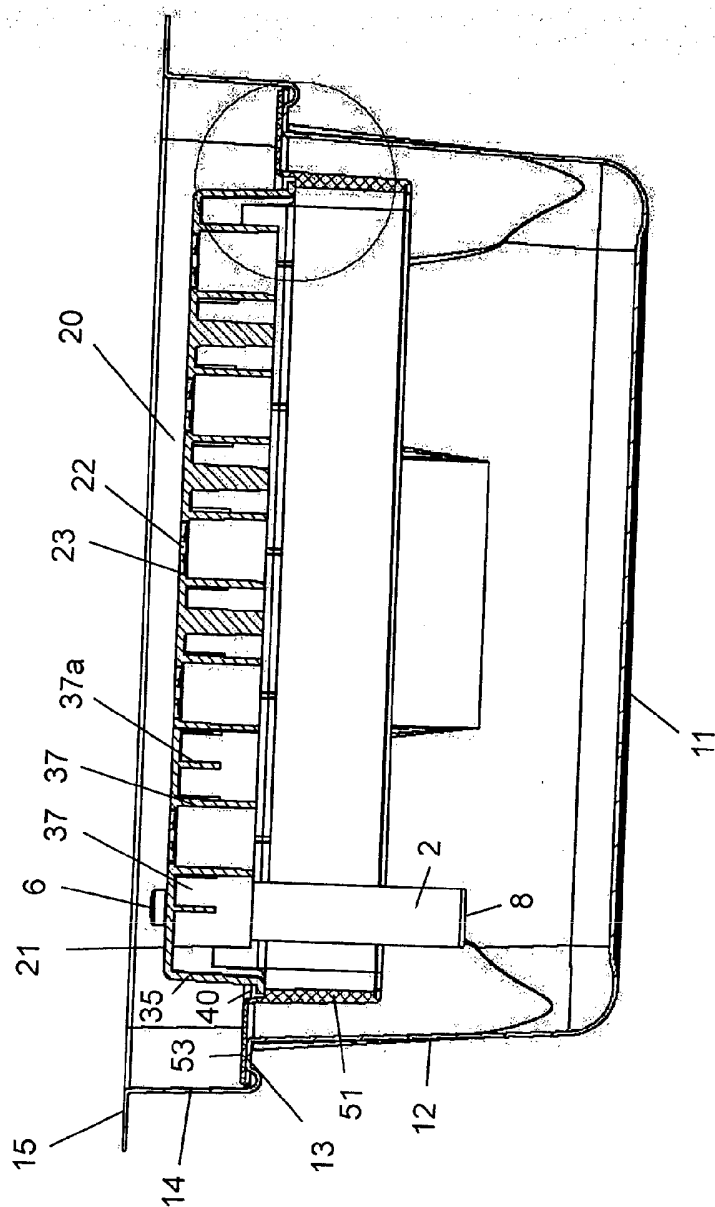


Fig. 4f

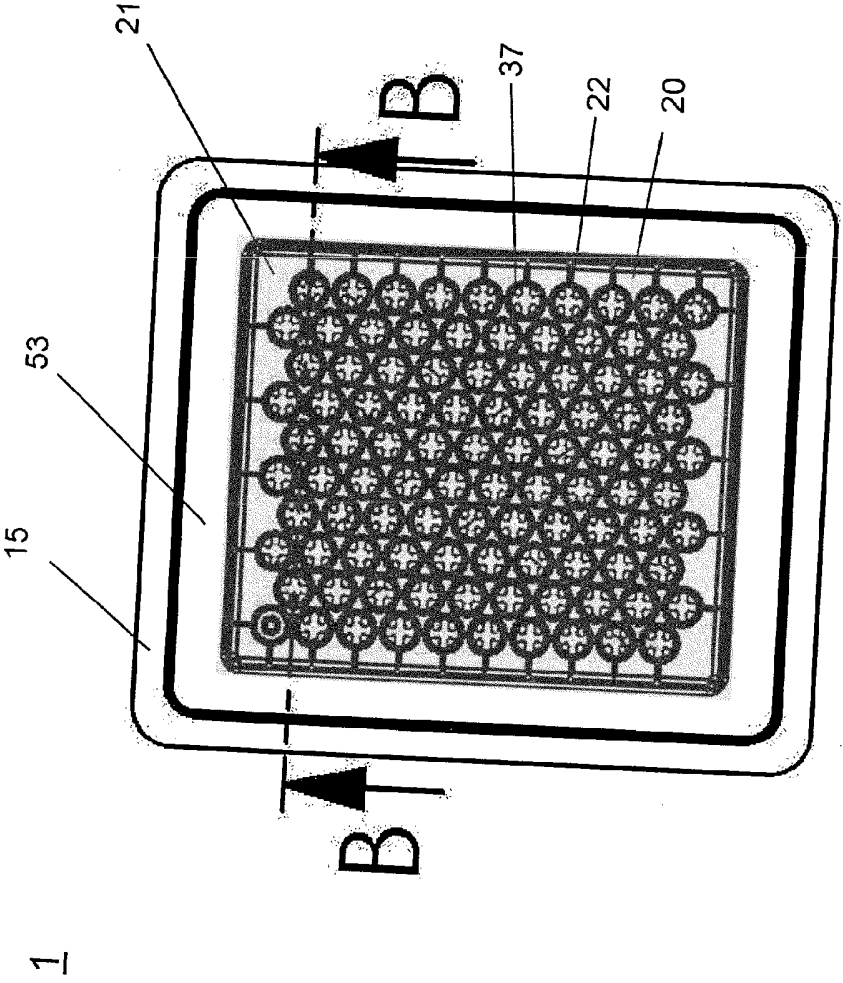


Fig. 4g



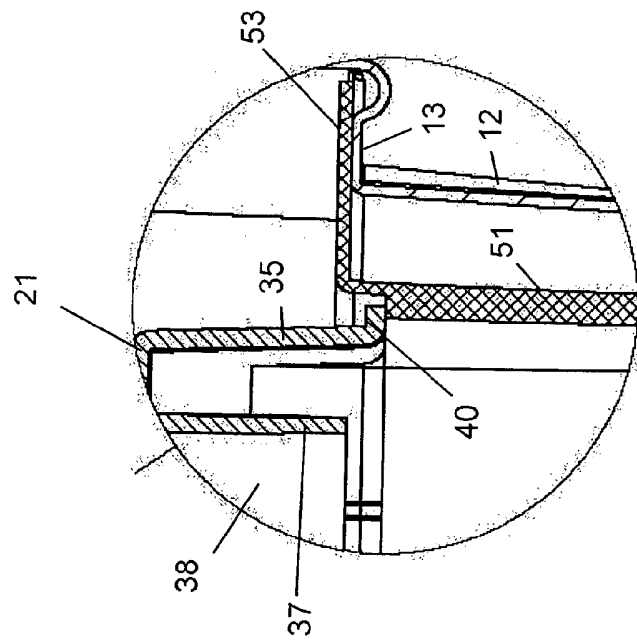


Fig. 4i

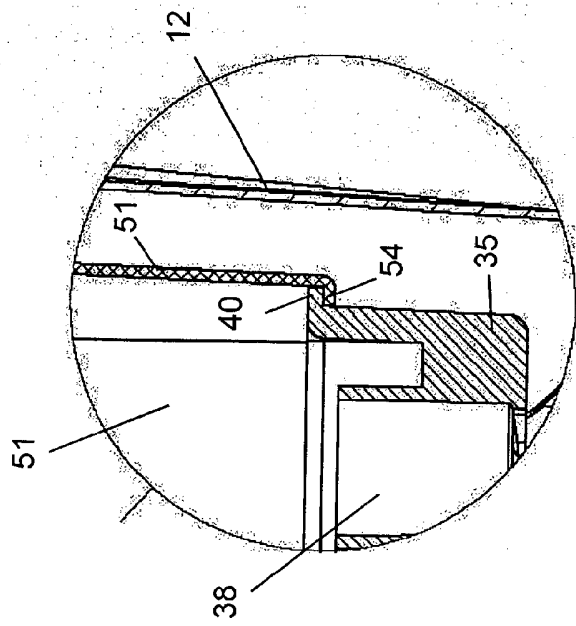


Fig. 4j



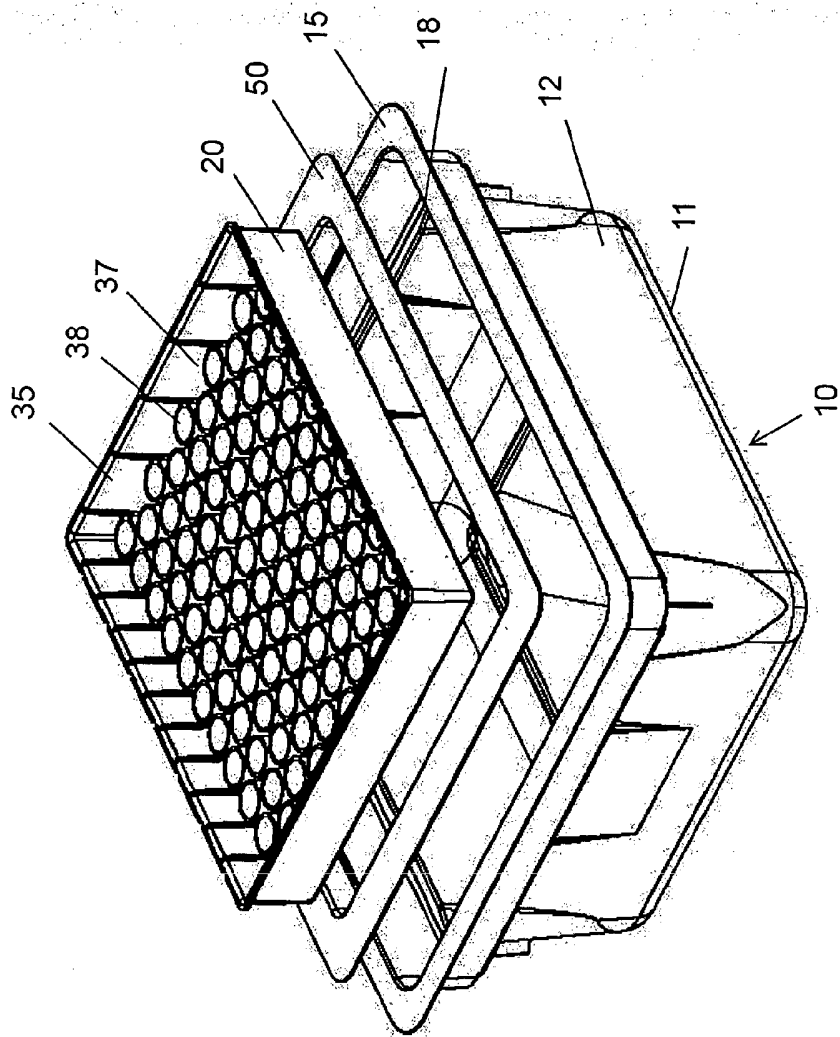


Fig. 4k

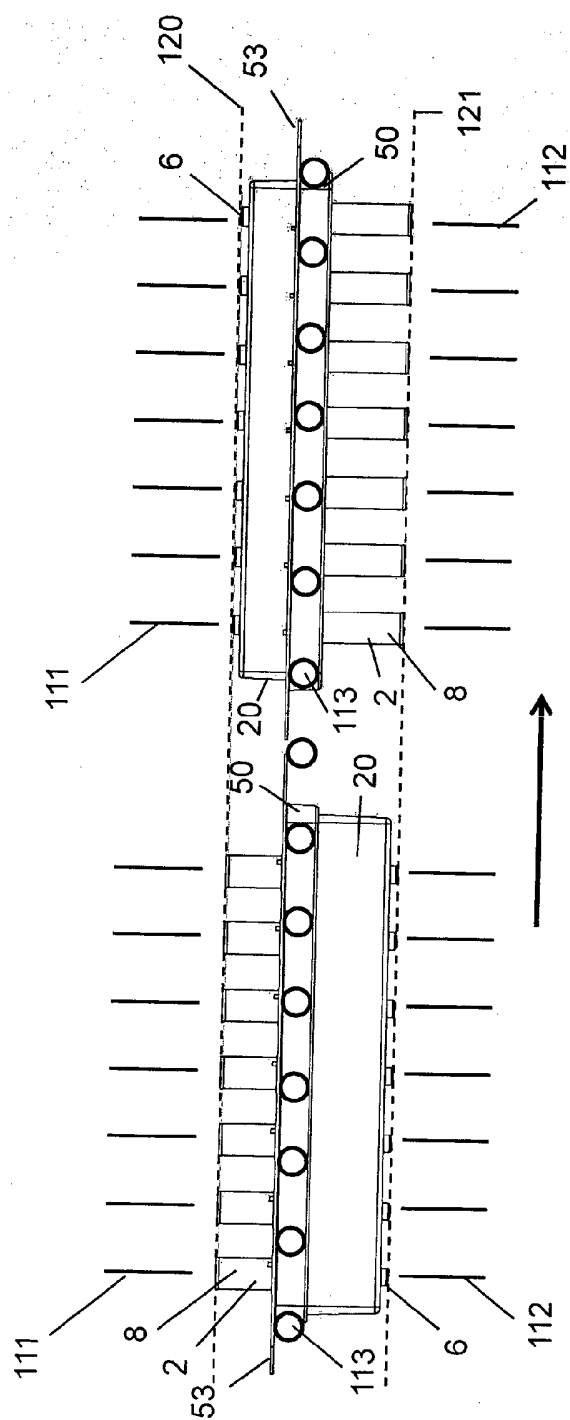
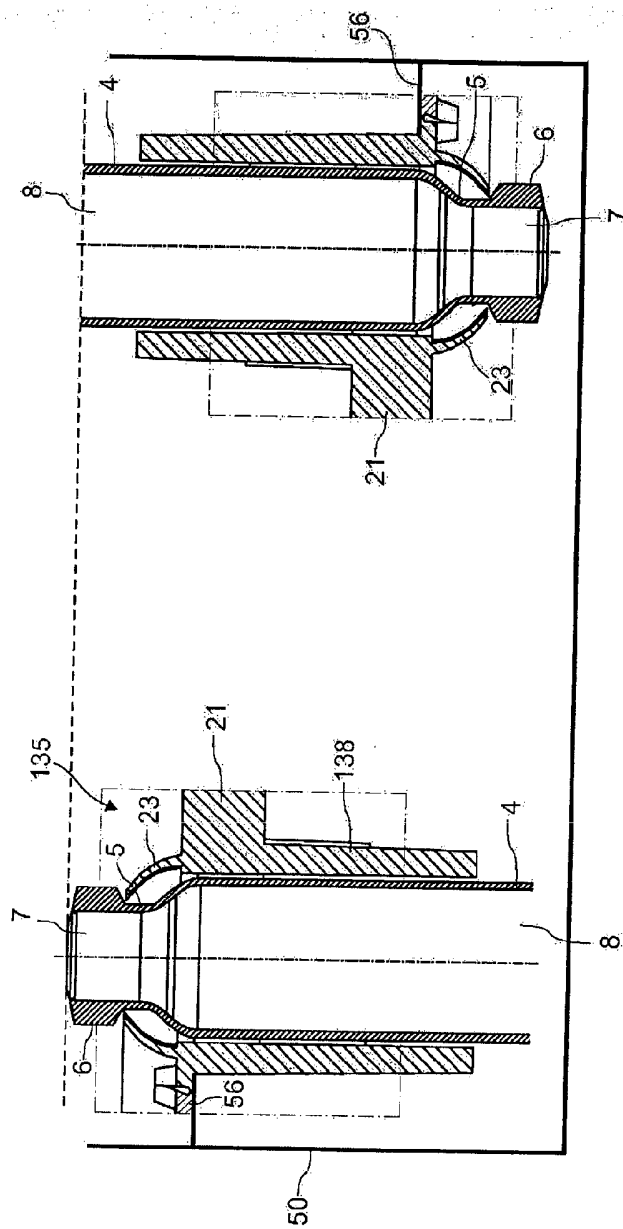


Fig. 4I



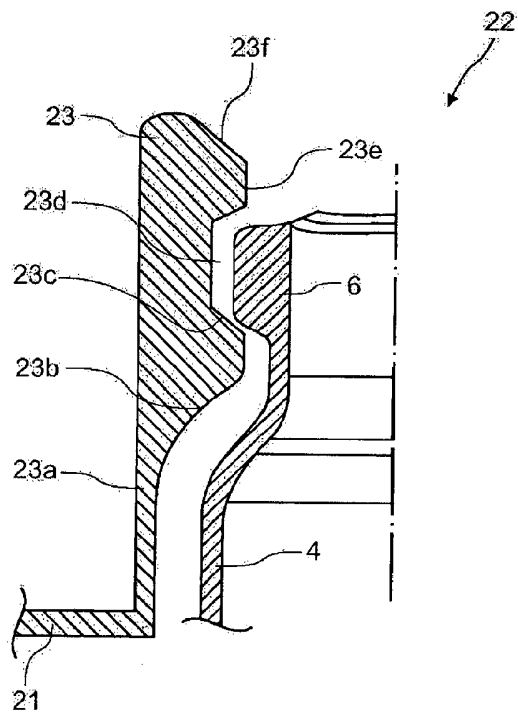


Fig. 5b

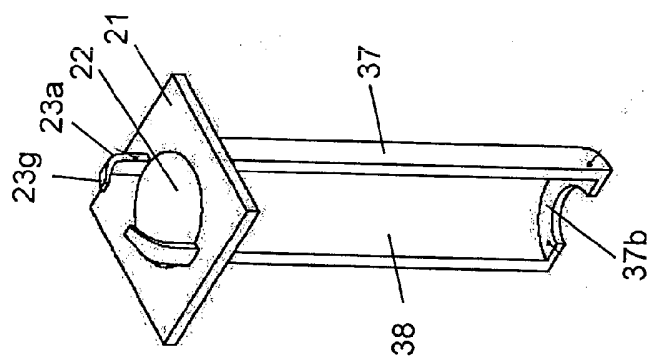


Fig. 6a

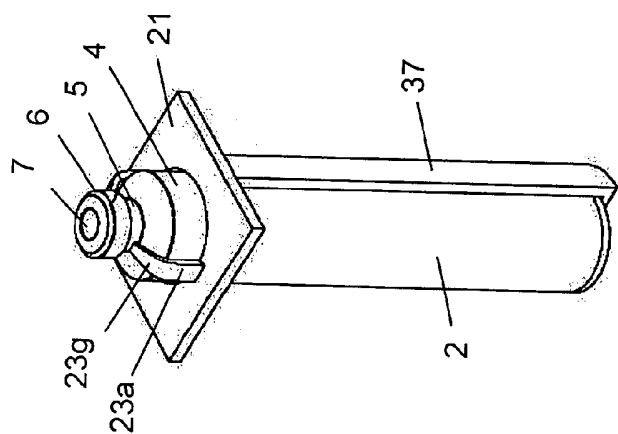


Fig. 6b

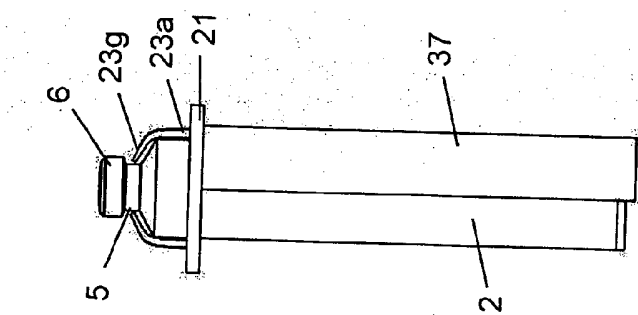


Fig. 6c

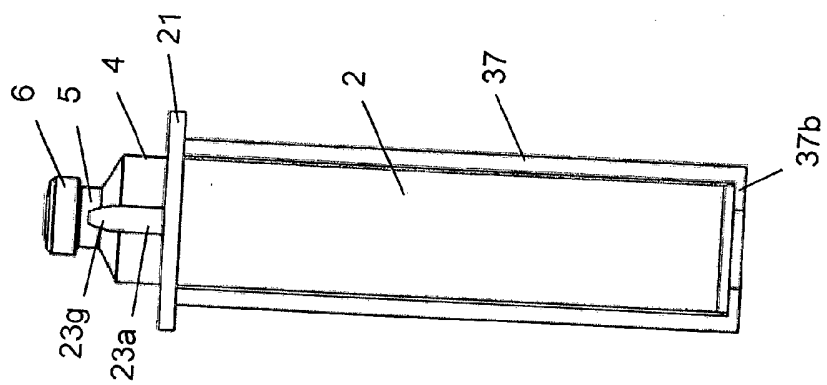


Fig. 6d

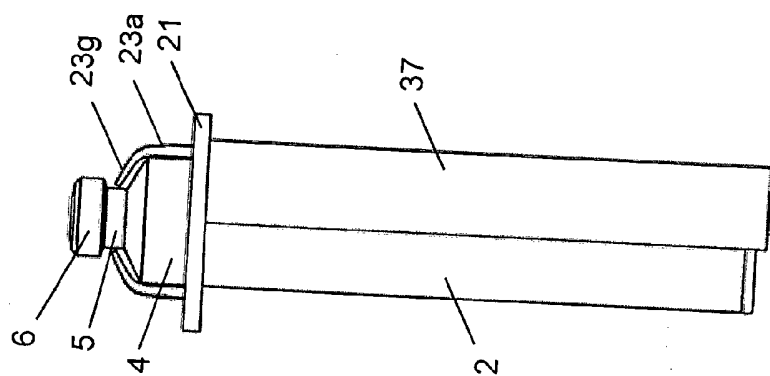


Fig. 6e

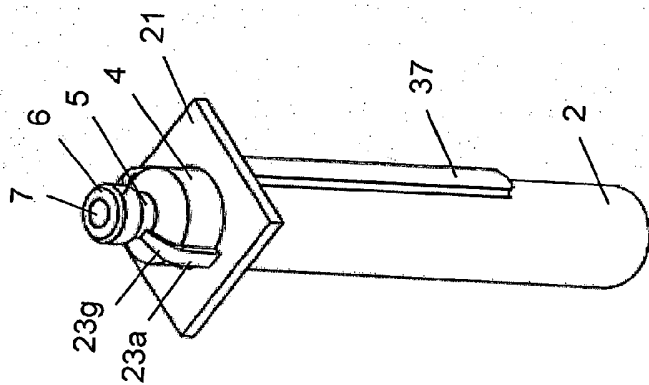


Fig. 6f

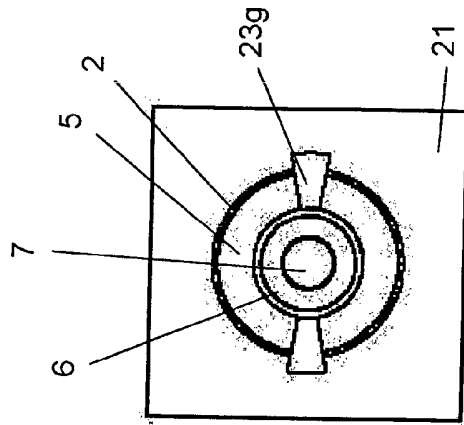


Fig. 6g

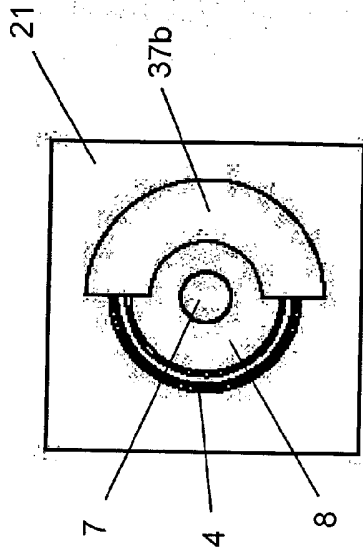


Fig. 6h

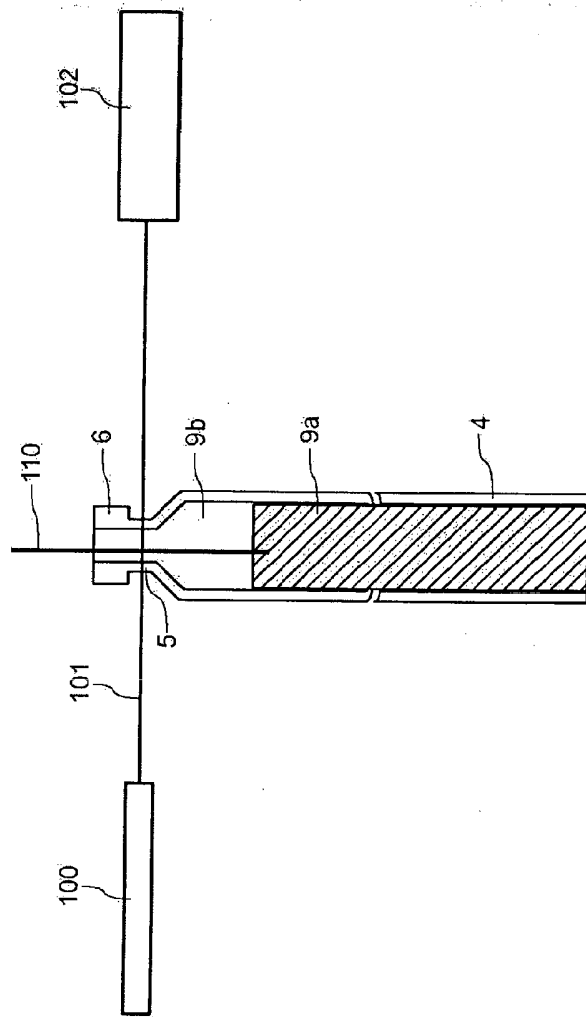


Fig. 6i



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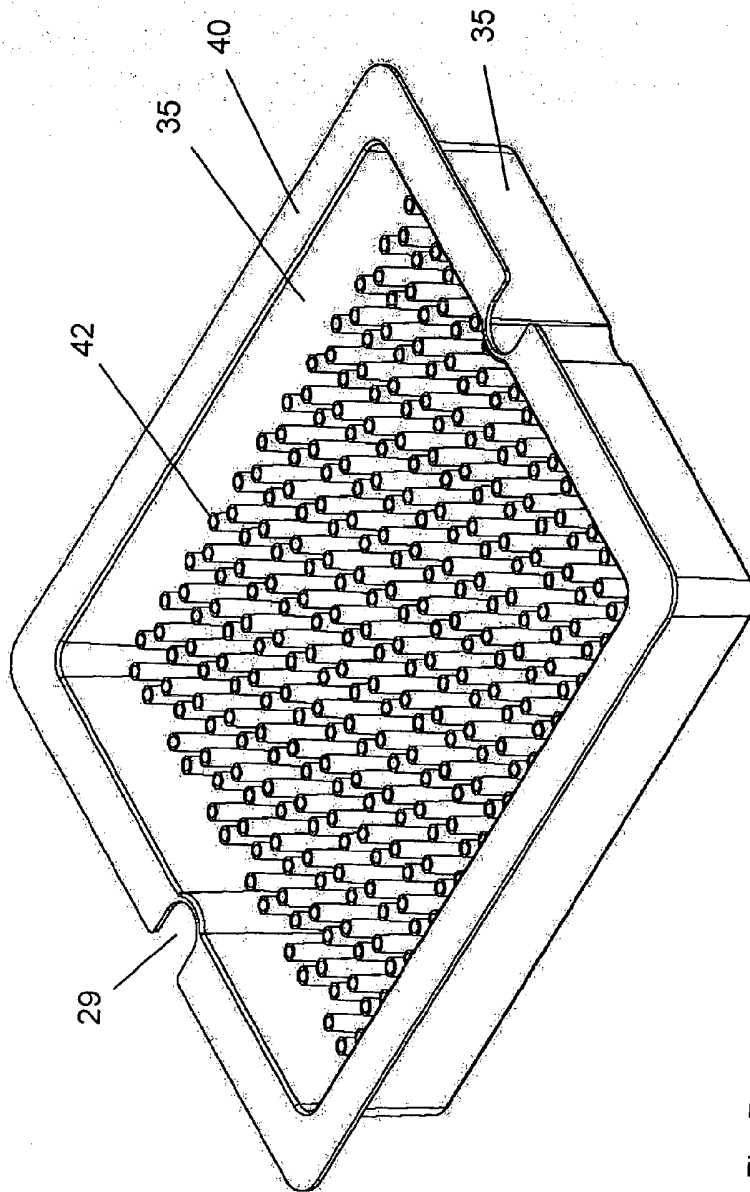


Fig. 7a

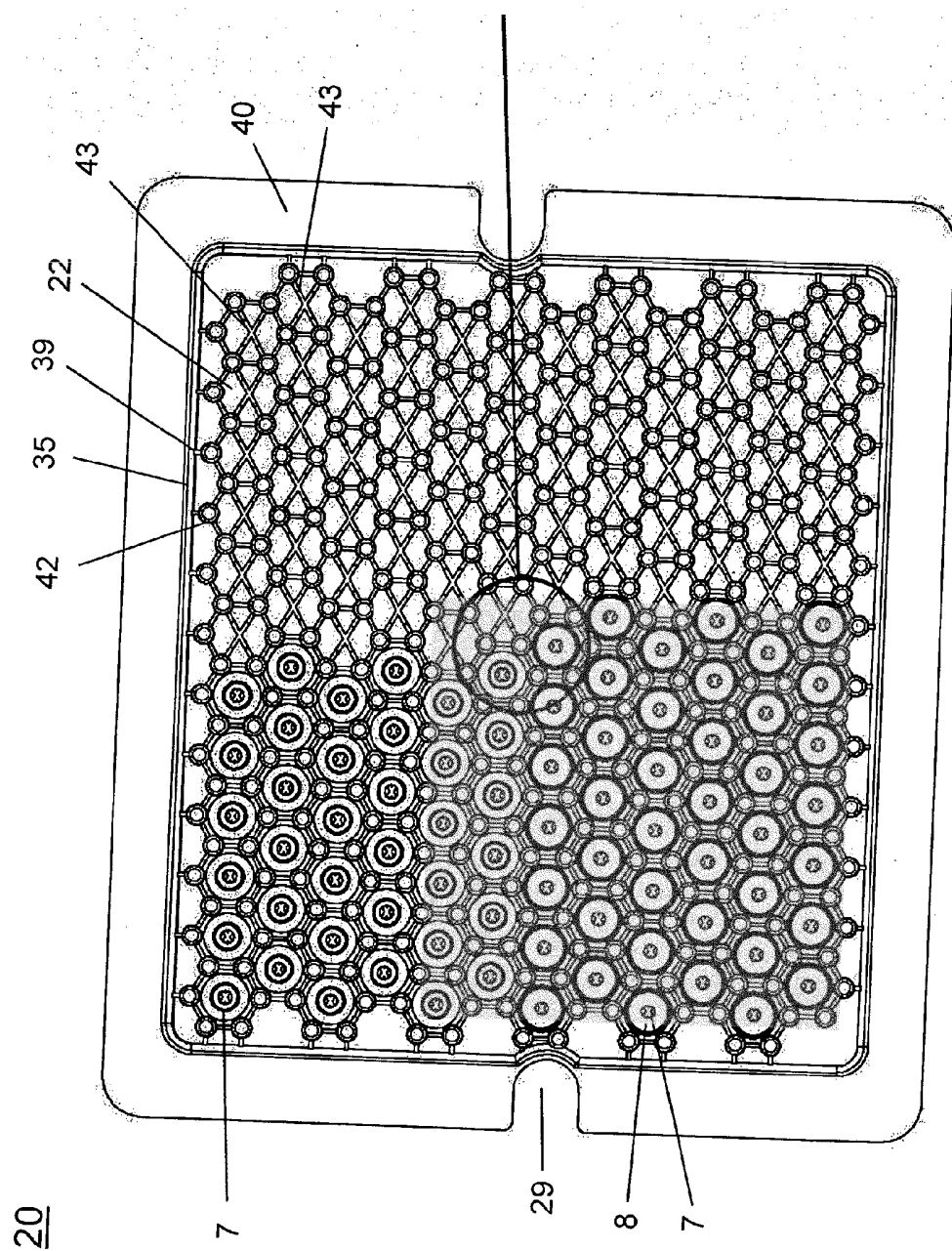


Fig. 7b

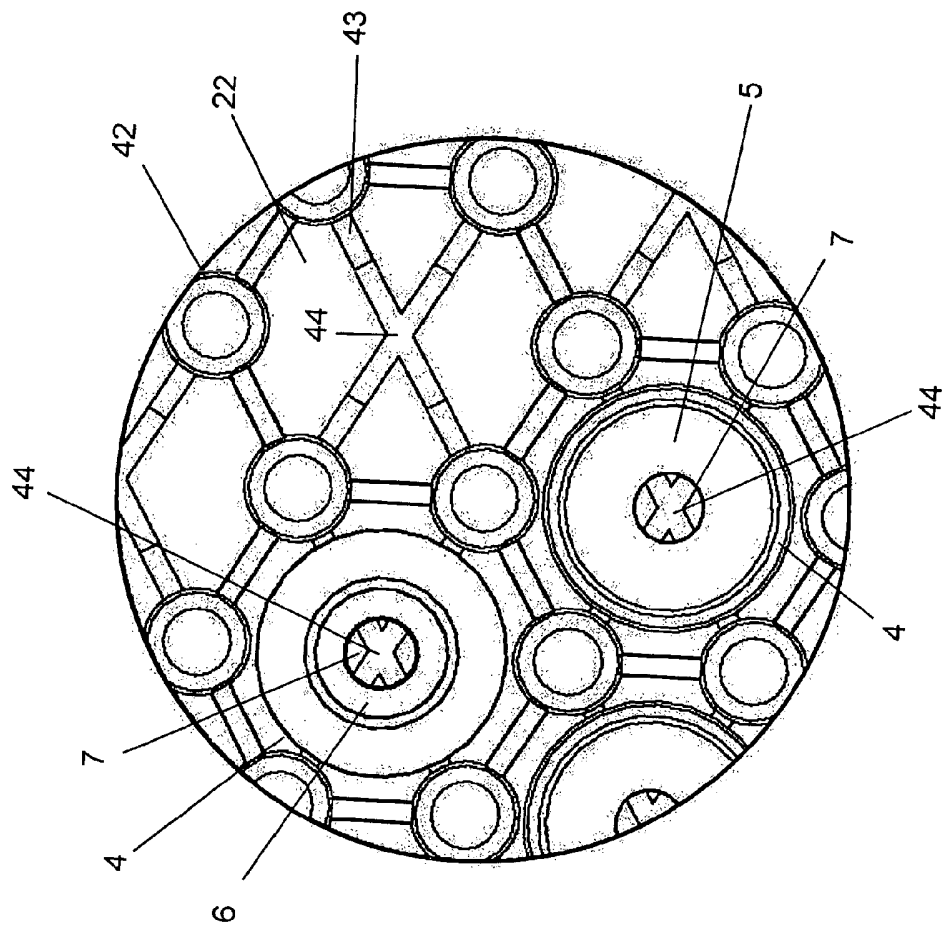


Fig. 7c

10

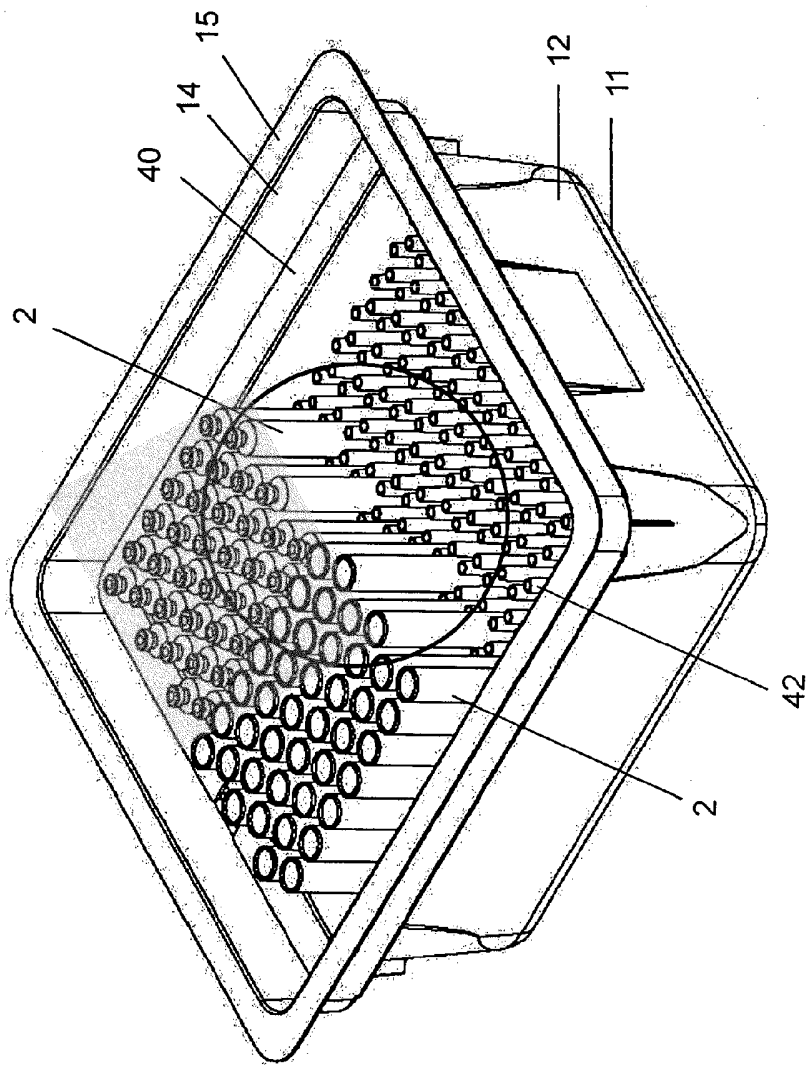


Fig. 7d

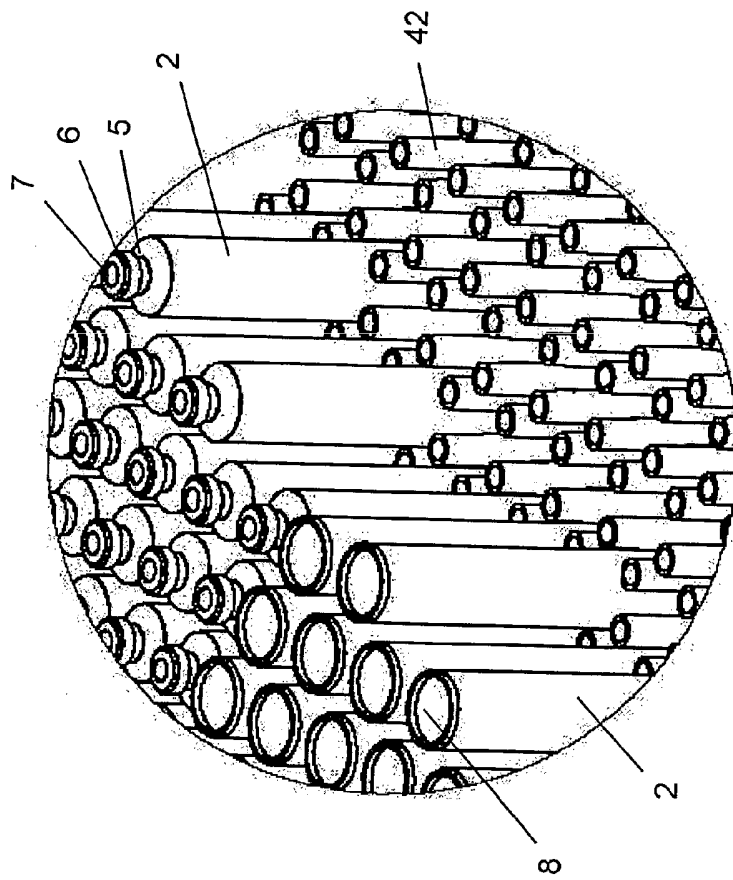


Fig. 7e

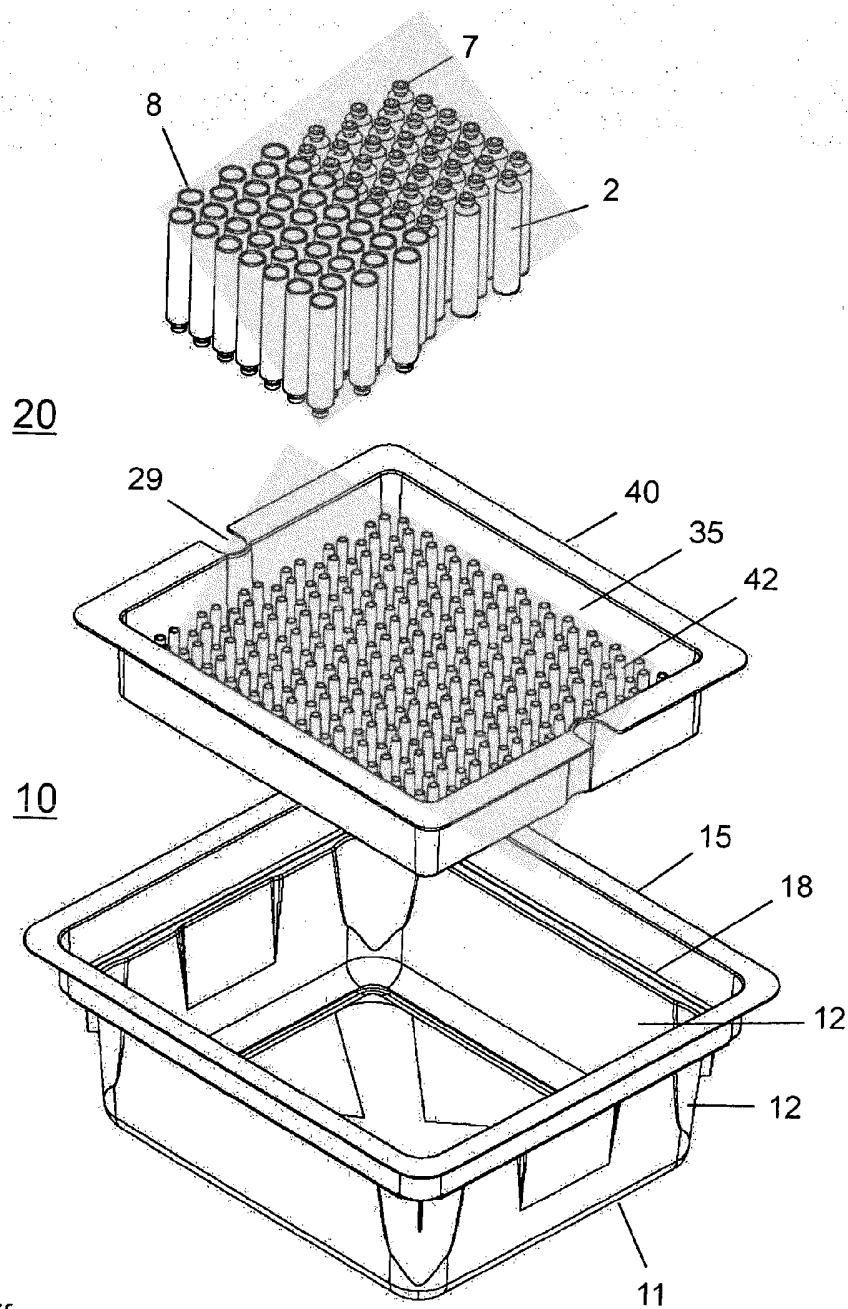


Fig. 7f

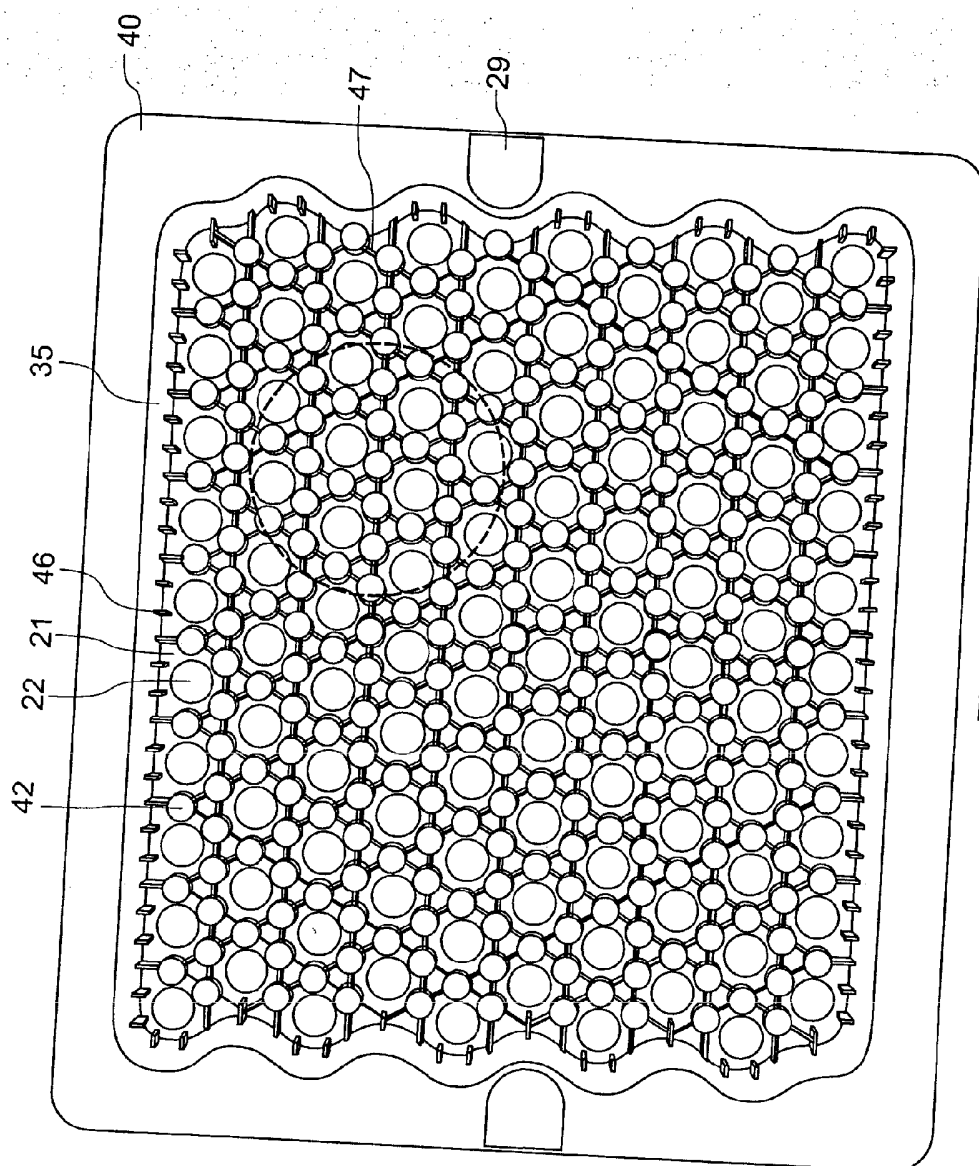


Fig. 8a

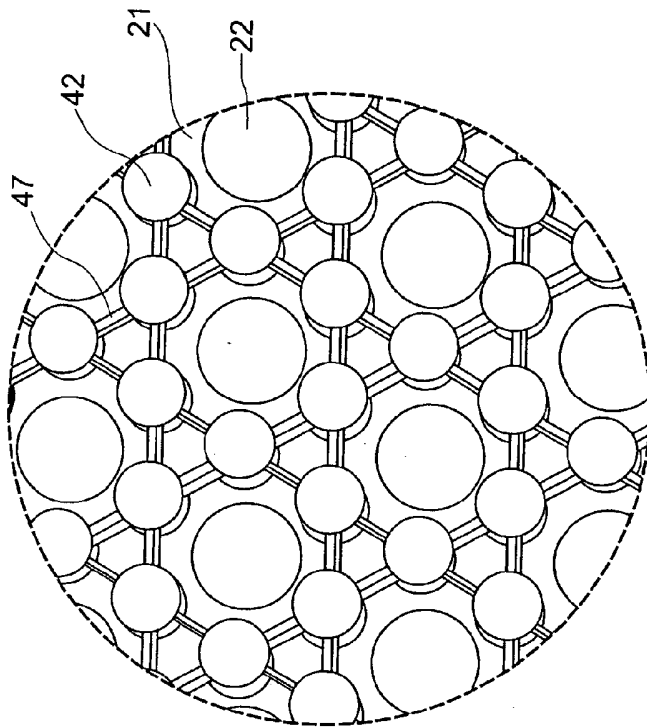


Fig. 8b



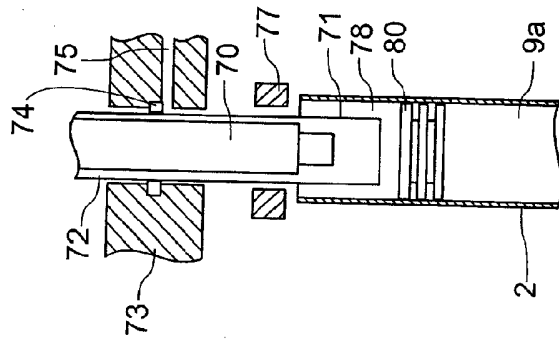


Fig. 8e

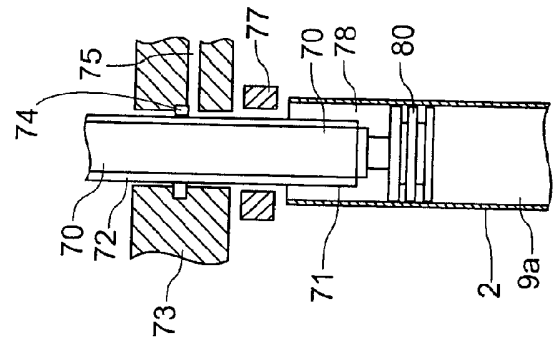


Fig. 8d

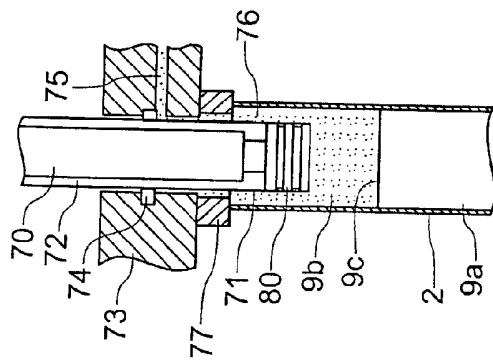


Fig. 8c

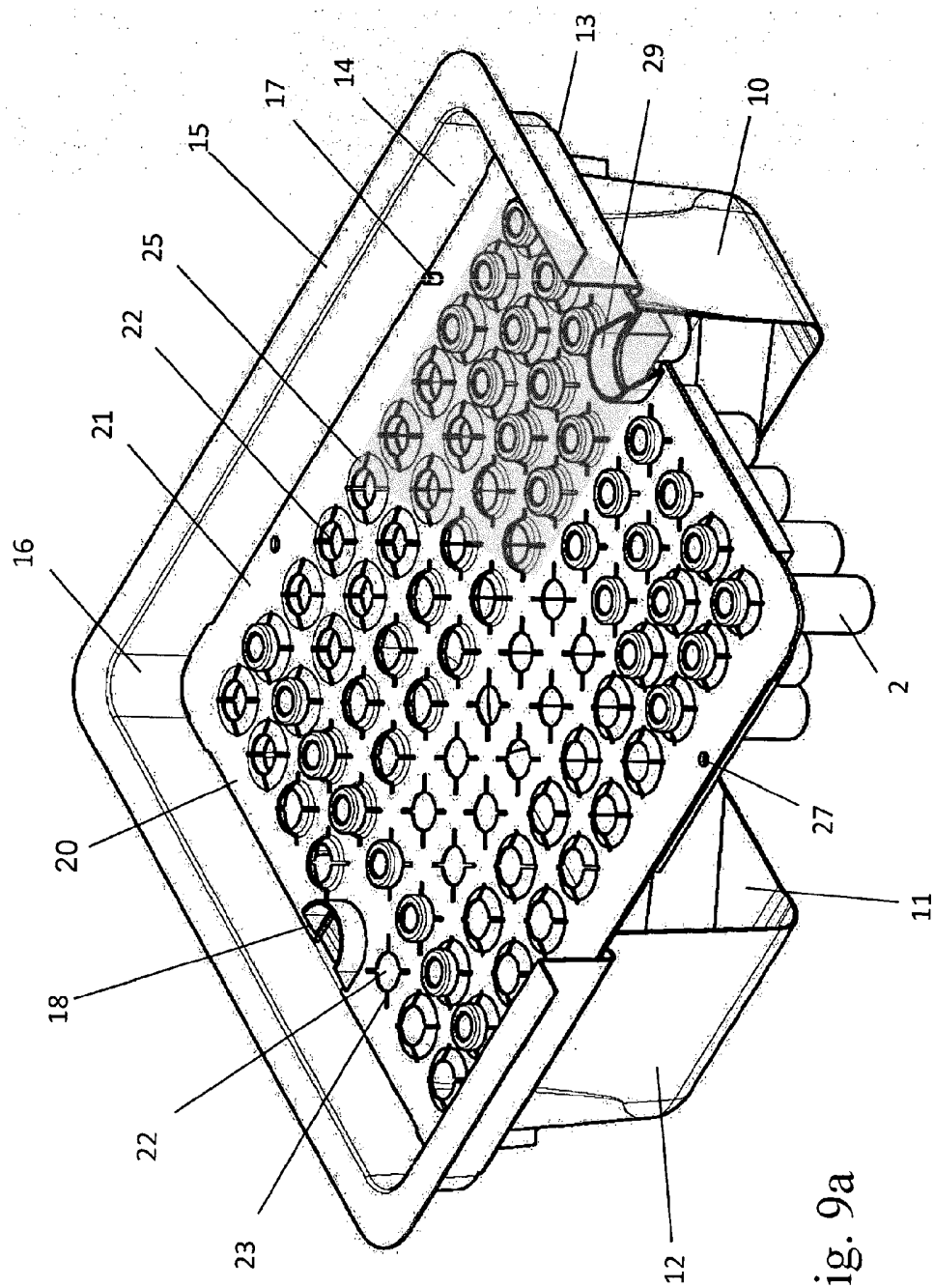


Fig. 9a

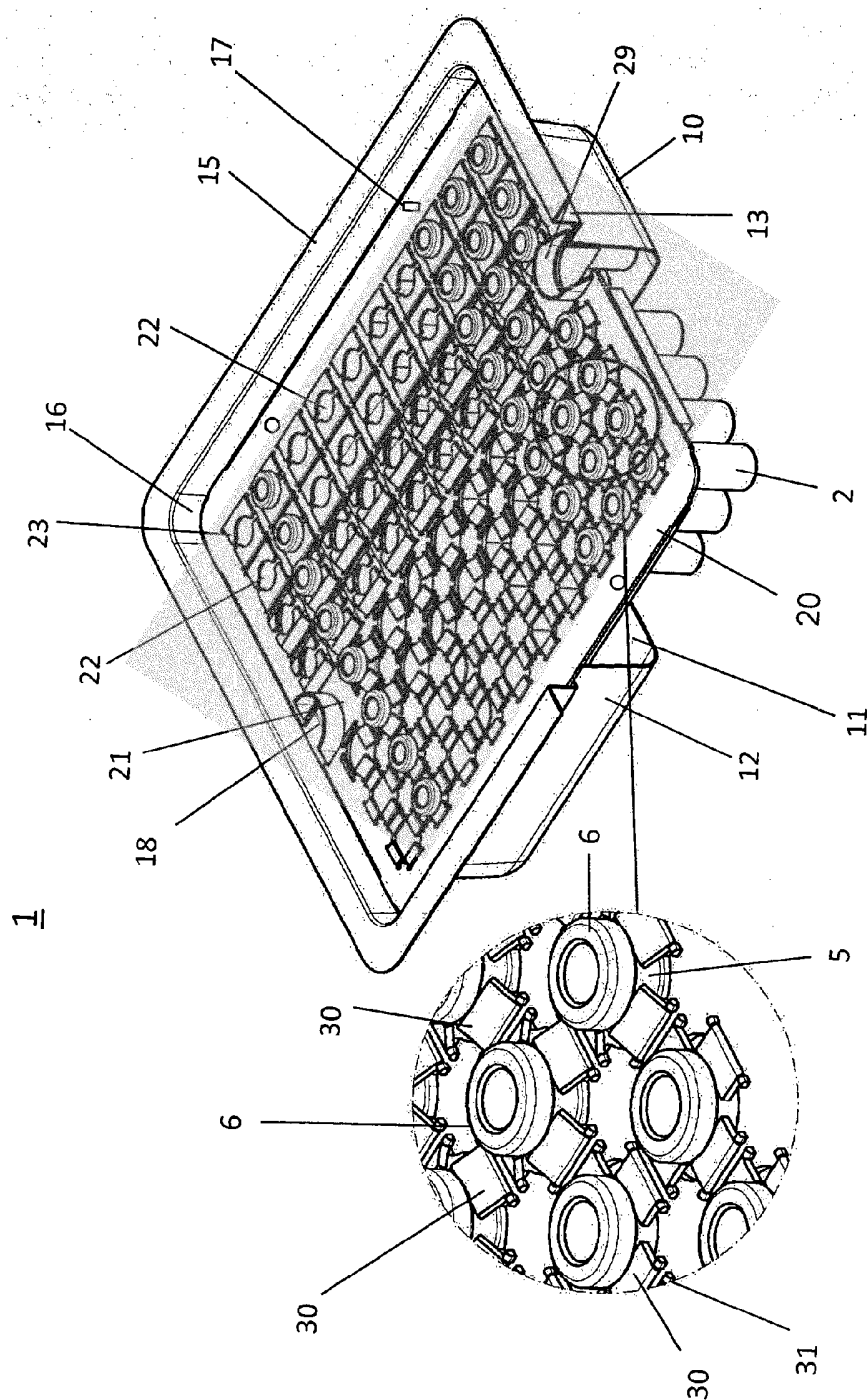


Fig. 9b

