March 2, 1937. A. I. RISSER 2,072,344

CONTAINER FILLING MACHINE

Filed Sept. 14, 1934 4 Sheets-Sheet 1

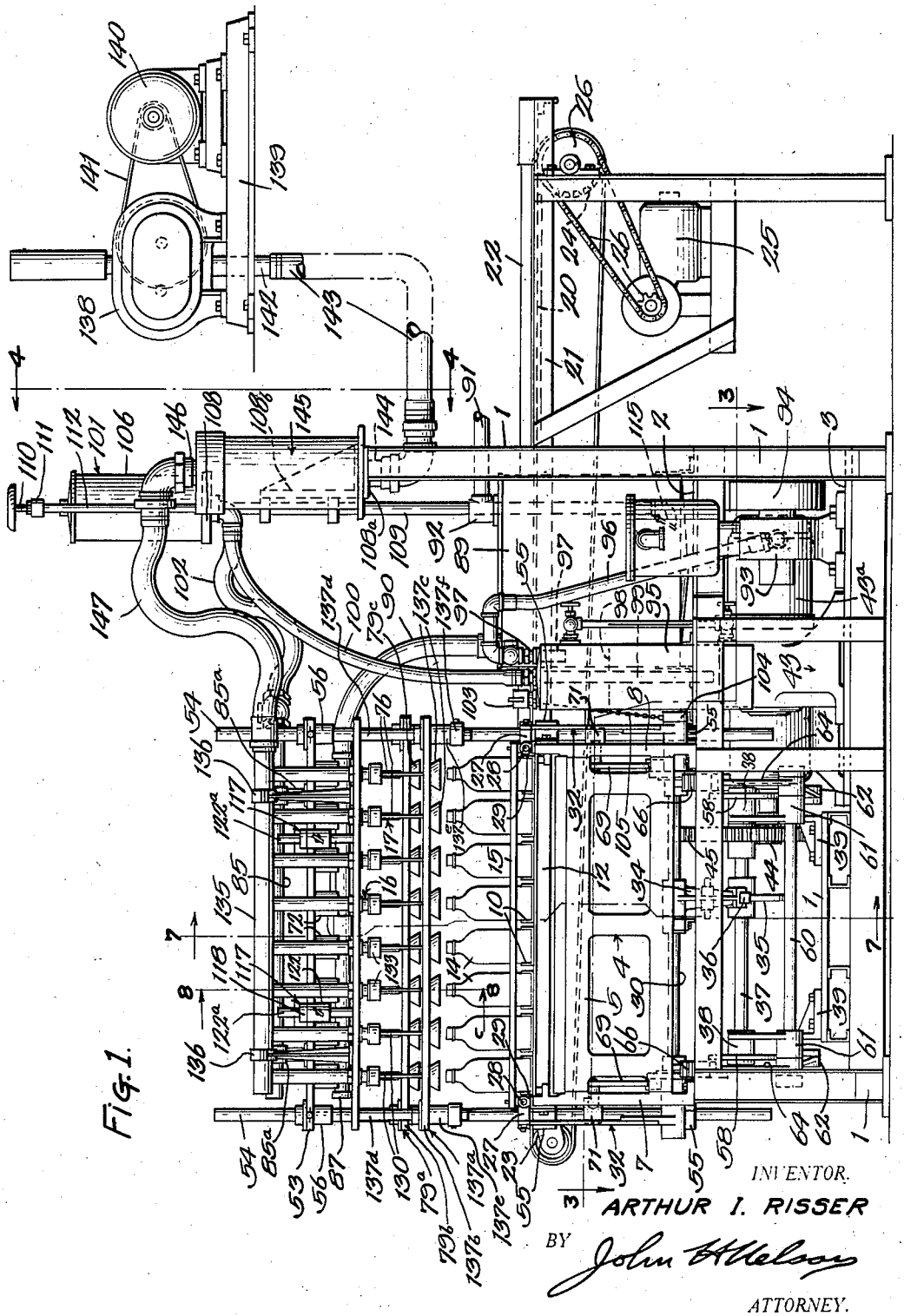


Fig. 1.

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Filed Sept. 14, 1934 4 Sheets-Sheet 2

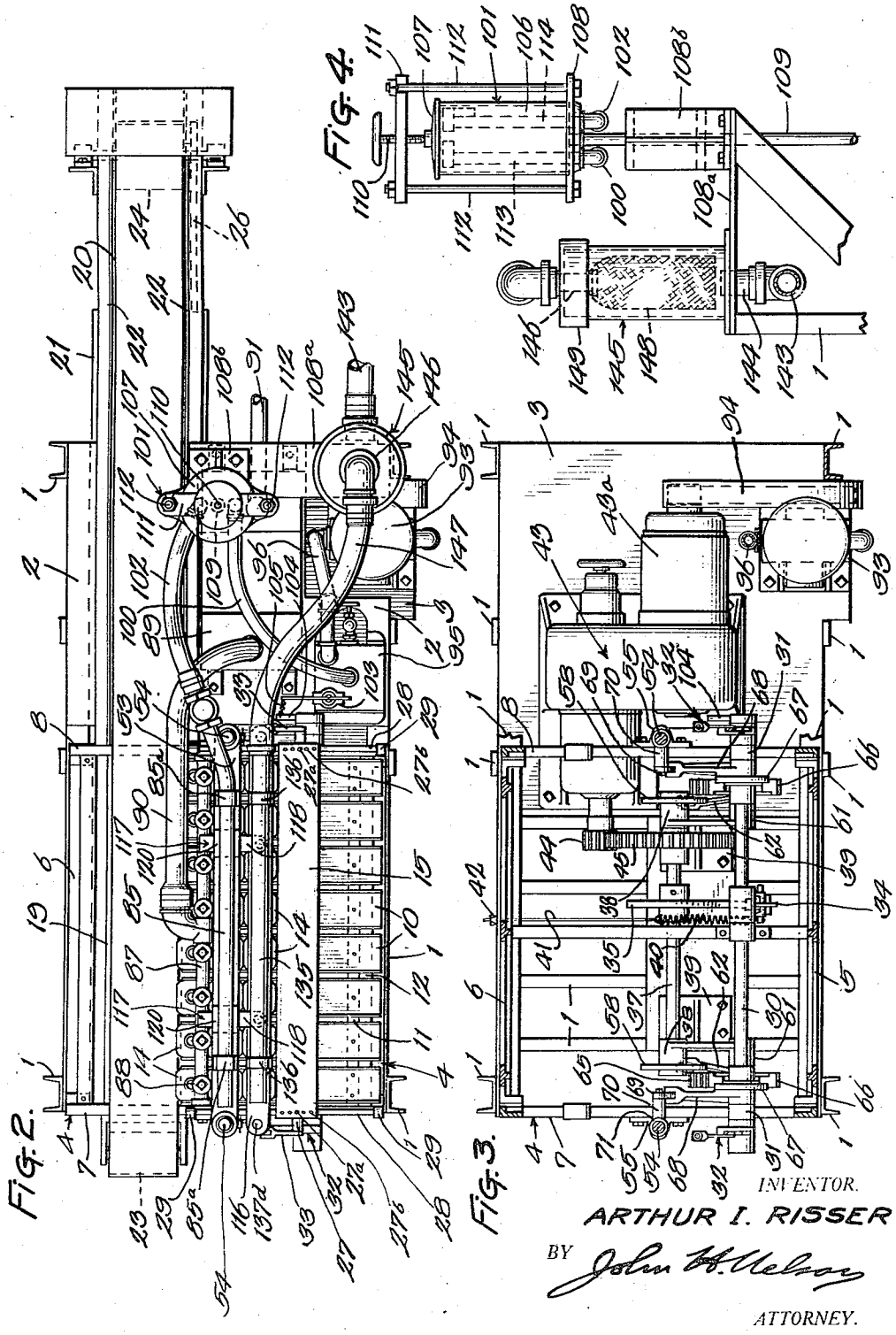


Fig. 2.

Fig. 3.

Fig. 4.

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CONTAINER FILLING MACHINE

Filed Sept. 14, 1934 4 Sheets-Sheet 3

FIG. 5.

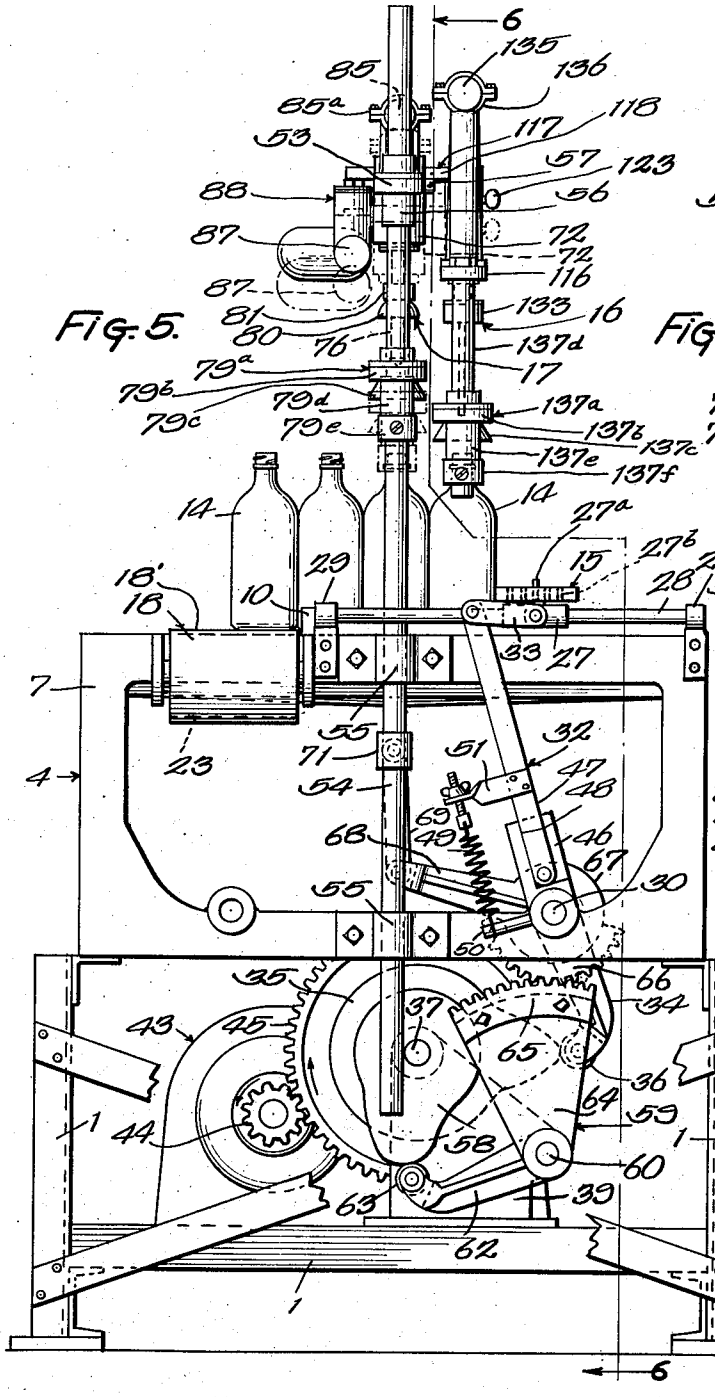
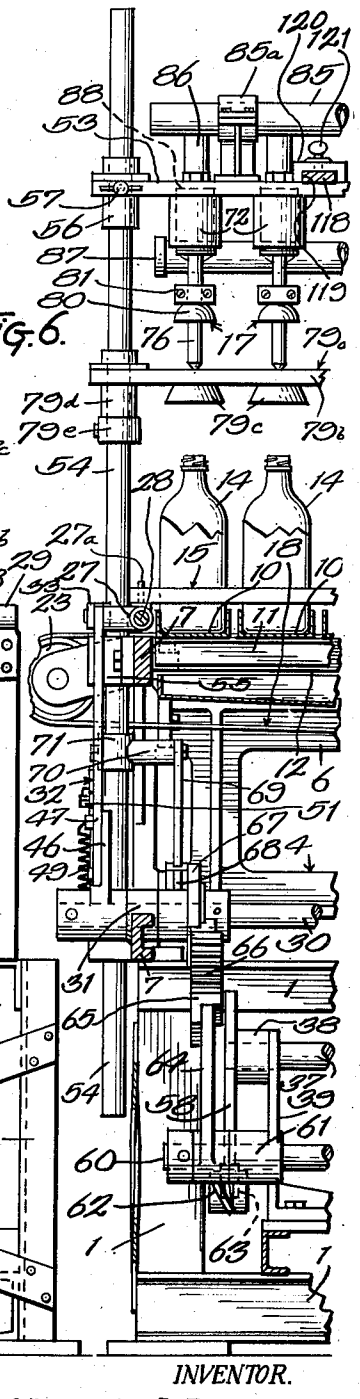


FIG. 6.



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CONTAINER FILLING MACHINE

Filed Sept. 14, 1934 4 Sheets-Sheet 4

FIG. 7.

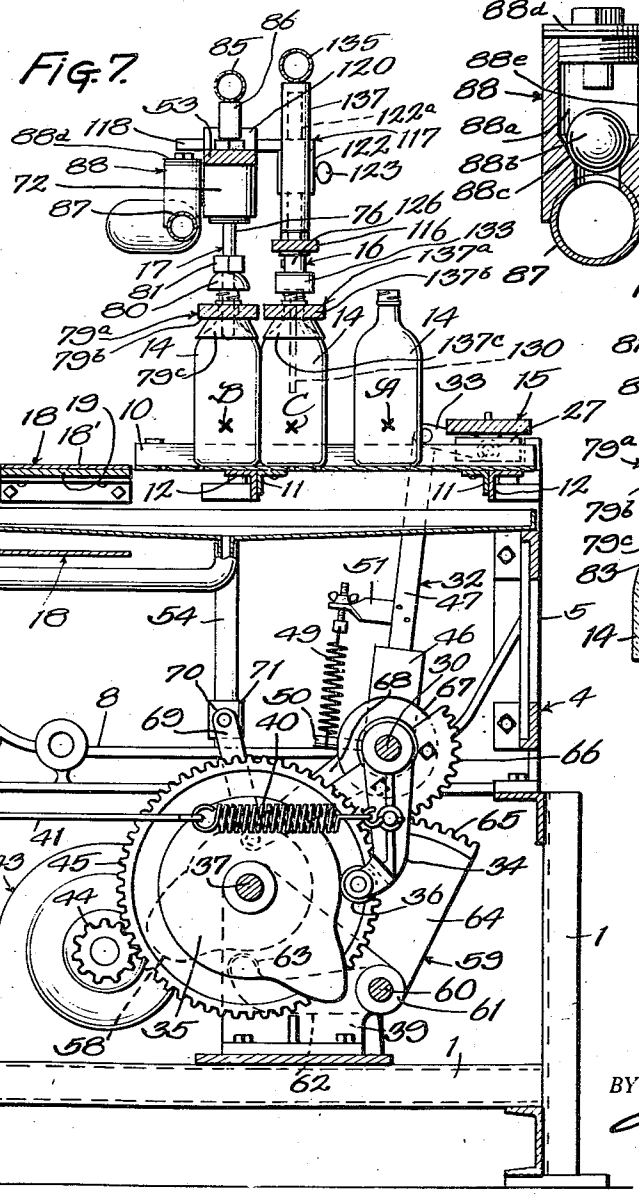
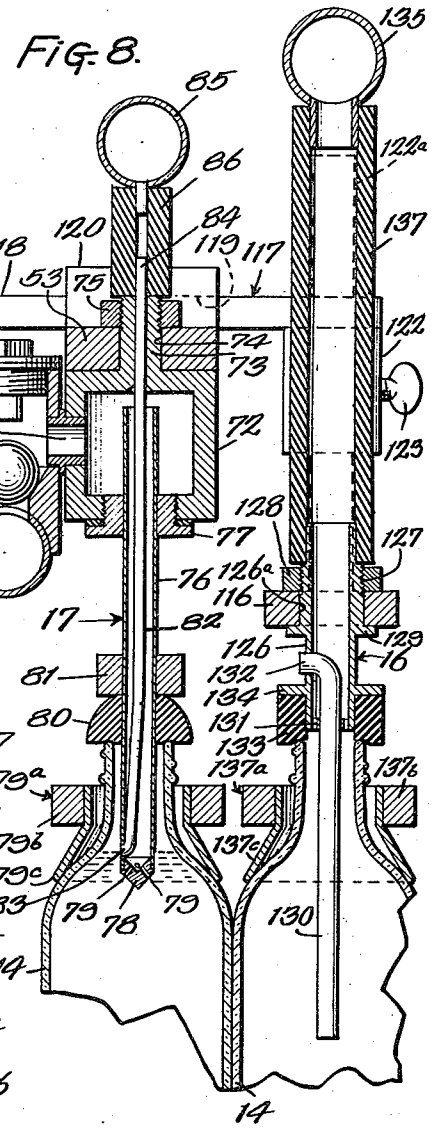


FIG. 8.



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UNITED STATES PATENT OFFICE

2,072,344

CONTAINER FILLING MACHINE

Arthur I. Risser, Chicago, Ill., assignor to U. S. Bottlers Machinery Co., Chicago, Ill., a corporation of Illinois

Application September 14, 1934, Serial No. 743,937

6 Claims. (Cl. 226—68)

This invention relates to container filling machines and also to a machine or apparatus for cleaning containers or bottles, and has for one of its objects, the provision of means for removing dust, foul air or other foreign matter or bodies from the containers preparatory to their being filled.

Another object of the invention is to provide such apparatus whereby the containers or bottles are pneumatically cleaned. A further object of the invention is to provide such a cleaning and filling organization whereby the cleaning means cooperates to prevent the contamination of the filling means, or operation by foreign matter, removed by the cleaning means.

Another object of the invention is to provide such a machine of the simplest construction having two operably connected devices, such as a filler head and a cleaner head, and means for positioning a container into cooperative relation with a device whereby said container cooperates to position another container into cooperative relation with the other device, and wherein the machine is capable of handling containers of various sizes with a minimum amount of adjustment of the operating parts.

Other objects and advantages will become apparent by reference to the specification and accompanying drawings, in which:

Fig. 1 is a front view of the machine with certain cooperating parts shown diagrammatically.

Fig. 2 is a plan view of the machine.

Fig. 3 is a plan sectional view of the machine, as taken substantially on the section line 3—3 of Fig. 1, with certain parts shown in full and other parts being omitted.

Fig. 4 is a detail vertical section taken on the section line 4—4 of Fig. 1.

Fig. 5 is an end view of the machine as viewed from its left hand side as appearing in Fig. 1.

Fig. 6 is a vertical section of the machine as taken substantially on the section line 6—6 of Fig. 5.

Fig. 7 is a vertical section of the machine as taken substantially on the section line 7—7 of Fig. 1, with certain operating parts in changed position and other parts omitted.

Fig. 8 is a vertical detail section of the filler and cleaner devices, as taken substantially on the section line 8—8 of Fig. 1, with the parts shown in their position as seen in Fig. 7.

As seen in Figs. 1, 2 and 3, the machine comprises an elongated rectangular base frame 1, made up of structural forms, and having at its right hand portion upper and lower mounting or base plates 2 and 3 respectively, on which plates are mounted mechanism later described. On the frame 1 at its left hand portion is mounted a rectangular upper supporting frame 4, forming an upward extension of the frame 1 and comprising similar front and rear frame panel sections 5 and 6, respectively, and end panel sections 7 and 8, respectively, connecting the panels 5 and 6. Upon the frame 4 is mounted the container positioning, cleaning and filling means or apparatus later described.

Arranged longitudinally across the top of the frame 4 is container supporting means such as a group of container guiding members 10 in the form of troughs closely arranged side by side and extending from the front of the frame to about two thirds its depth. The troughs are connected into a group by means of two spaced bars or angle irons 11 mounted thereunder longitudinally, which angle irons are received between two spaced bars or angle irons 12 mounted on and extending between the end panels 7 and 8 of the frame 4, and upon which angles 12 the group of troughs are removably supported so that groups for various sizes may be easily assembled with the machine.

The containers or bottles 14 to be cleaned and filled are placed by hand or other means in the troughs 10, which position or station of the bottles is indicated by the cross A, Fig. 7, whereupon the containers are arranged in cooperative relation with conveying or feeder mechanism such as a container pusher member 15 in the form of a flat bar of wood extending across over the front portion of the troughs. The pusher 15 is mounted movable back and forth, or reciprocable, lengthwise of the troughs to feed the containers placed at the station A in an aligned group into position under a group of aligned vertically reciprocable cleaner heads 16 of the suction type, later described. The cleaner heads are then lowered onto the containers thereunder upon the return stroke of the pusher 15 to effect the cleaning of the containers internally, the cleaner heads remaining in their lowered position and the pusher remaining in its retracted position for a given length of time.

Upon the feeding of a succeeding container, or bottle, on the advance stroke of the pusher, the cleaner heads are raised out of cooperative relation or off of the bottles thereunder, which cleaned bottles, upon the positioning of the succeeding bottles under the cleaner heads, are advanced by

the succeeding bottles into position under an aligned group of filler heads 17, which position or station of the cleaned bottles is indicated by the cross B, Fig. 7. The position or station of the bottles placed under the cleaner heads, as indicated by the cross C, Fig. 7, is determined by the diameter of the bottles because the station of the bottles under the filler heads is fixed. The groups of filler and cleaner heads are mounted to reciprocate together, whereupon on being lowered they are caused to operate simultaneously on the bottles thereunder.

As the succeeding bottles are fed under the cleaner heads, the filled bottles are advanced by the cleaned bottles and off the ends of the guide troughs onto a conveyor 18 in the form of an endless belt whose upper stretch 18' passes across the ends of the troughs toward the right, (see Fig. 1) over a support plate 19 mounted on the upper frame 4, then continues on over a support plate 20 mounted on the frame extension 21 of the frame 4, the plate 20 having bottle guard rails 22 between which the bottles pass to be removed by hand or other means. The belt 18 is supported on an idler pulley 23 mounted on the outer face of the frame panel section 7 and a drive pulley 24 mounted on the outer end of the frame extension 21, the drive pulley being suitably driven by a combined motor and speed reducer 25, mounted on the frame extension, through the sprocket and chain drive connection 26.

The pusher 15 is reciprocably mounted by means of two slides 27 secured adjustably at opposite ends of the pusher, wherein each slide has an upstanding pin 27*a* received in one of a row of apertures 27*b* extending across each end of the pusher bar. Thus the pusher bar may be adjusted to advanced or retracted positions with respect to the slides, which have a fixed zone of reciprocation, to compensate for various sizes of bottles in feeding same to their fixed filling station B on the bottles guides. The slides are in the form of tubular sections reciprocably mounted on horizontal guide rods 28 mounted to extend over and along the end panel sections 7 and 8 of the frame 4, the rods being secured to the panels by means of bracket 29 at their ends.

The slides are reciprocated in unison on the rods 28 by means of a horizontal rock shaft 30 disposed longitudinally of the frame portion 4 and mounted at its ends in bearings 31 on the end panels 7 and 8 of frame 4, the shaft having arms 32 secured at opposite ends whose free ends are pivotally connected through links 33 to the slides. The rock shaft 30 is oscillated by means of an operator arm 34 secured centrally on the shaft and being operated by a cam 35 engaging a roller 36 on the arm. The cam is centrally mounted on a drive shaft 37 disposed parallel with the shaft 30 and rotatably mounted at its ends in bearings 38 of spaced brackets 39 mounted on the frame 1. The operator arm 34 is maintained engaged with the cam 35 by means of a tension spring 40 connected at one end with the arm and connected at its other end with a rod 41 anchored adjustably to the rear of the frame 1 by the thumb screw connection 42. The drive shaft is driven by means of a well known slow speed power unit 43 mounted on the base plate 3 on the frame 1, the unit comprising a motor 43*a* driving a power spur gear 44 through cased in reducing gearing (not shown), which gear 44 meshes with a larger spur gear 45 secured on the drive shaft 37.

To prevent breakage of the bottles in the event they become jammed under the heads 16 or 17, due to faulty adjustment of the mechanism, the rocker shaft arms 32 are constructed to be resilient on the feed stroke of the pusher 15 to provide an impositive drive therefor. To this end each arm 32 comprises an operating arm portion 46 secured to the rocker shaft 30 and on which is pivotally mounted an operated arm extension portion 47 resiliently held in alignment with the operating arm portion, in the direction of its feed stroke, against a shoulder 48 of said operating arm portion by means of a tension spring 49 connected between a lateral pin 50 on the arm portion 46 and a lateral extension 51 of the arm portion 47.

The groups of cleaner and filler heads 16 and 17, later described in detail, are mounted to be raised and lowered in unison and arranged whereby, on the feed stroke of the pusher bar 15, the heads are in raised position, and on the return stroke of the bar the heads are lowered into cooperative relation with the bottles positioned thereunder. Generally, the groups of cleaner and filler heads are mounted on a carrier 53 in the form of a horizontal bar spaced above the bottle guides 10 and extending directly over the bottle stations B thereof. For raising and lowering the carrier bar 53, it is mounted to extend between two vertically reciprocating uprights or rods 54 arranged at opposite ends of the upper frame 4, each rod being reciprocably mounted in spaced bearings 55 on said frame, and the carrier bar having a bearing 56 at each end receiving an upright on which it is adjustably secured by a set screw 57, for adjusting the heads with respect to bottles of various height.

The uprights 54 are reciprocated in unison by two similar cams 58 secured at opposite ends of the drive shaft 37 in close proximity to the uprights. Each cam 58 is connected to operate its respective upright through a bell crank lever 59, the levers being oscillatably mounted on opposite ends of a shaft 60 fixed in bearings 61 of the brackets 39. Each bell crank lever has an arm portion 62 having a roller 63 engaging its cam, and having an upstanding arm portion 64 on which is removably secured a gear segment 65 meshing with a smaller gear segment 66 secured removably on the enlarged hub portion 67 of a horizontally arranged lever 68 loosely mounted on the shaft 30. The free end of each lever is in pivotal connection with an upright 54 through a connecting link 69 connected with an inward extension 70 of a collar 71 secured on the upright.

The cleaner and filler heads will now be described. Referring to Fig. 8, each filler head includes a hollow cylindrical nozzle head 72 arranged centrally or in alignment over the bottle station B of each guide 10. Each nozzle head is secured under the carrier bar 53 by having an upward hollow reduced stem portion 73 passing through an aperture 74 in the bar, which portion is threaded to receive a nut 75 for securing the nozzle head to the carrier bar. Centrally disposed and depending from the nozzle head 72 is a filler nozzle 76 in the form of a small tube on which is a threaded collar 77 threaded into the bottom of the head for securing the nozzle with the head. The nozzle projects upward into the nozzle head to form a trap for dirt or other foreign matter upon liquid being supplied to the nozzle by way of the head. The nozzle has an outlet end including a conical cap 78 having a plurality of small outlet apertur- 79.

For positively centering the bottles at the stations B of the guides under the nozzles 76, to insure entry of the nozzles into the bottles on being lowered, a bottle centering device 79a is provided under the heads. The device includes a horizontal flat bar 79b arranged to extend under the nozzles in their raised position, and mounted on the bar to extend therethrough is a group of centering members 79c in the form of downwardly and outwardly flaring bell shaped sleeves, each of which being coaxial with a nozzle to permit its passage therethrough. The bar 79b is mounted for limited reciprocable movement upon the uprights 54, each of which passes through a bearing 79d at each end of the bar, and on each upright is an adjustably mounted collar 79e for limiting downward movement of the bar with respect to the nozzles. Upon lowering of the carrier bar 53, the centering sleeves 79c engage about the shoulders of the necks of the bottles thereunder, thus causing same to be centered with the nozzles 76. On continued downward movement of the carrier bar, the nozzles are projected into the necks of the bottles until each bottle mouth is engaged by a sealing member or gasket 80 mounted on each nozzle. The gaskets are composed of resilient material, such as rubber, and are held on the nozzles by frictional engagement and being limited from upward movement thereon by engagement with an adjusting collar 81 clamped on the nozzles.

The filler heads are lowered by force of gravity controlled by the action of the cams 58, whereupon the amount of pressure exerted on the bottles by the nozzle gaskets 80 is determined by the weight of the filler heads, carrier bar and the operating uprights.

With the filler nozzles projected into the bottles sealed by the gaskets 80, in which lowered position of the nozzles they remain for a given length of time, determined by the cams 58, liquid is caused to flow from the nozzles into the containers by the action of vacuum being created in the bottles. Vacuum is created in the bottles by means of a vacuum nozzle 82 in the form of a small tube disposed in each filler nozzle with its bottom open end 83 extending through the side wall of the filler nozzle slightly above its outlet end, and having its top end 84 projecting through the reduced portion 73 of the nozzle head. Each vacuum nozzle is in communication with a vacuum supply manifold 85 extending over the filler heads and mounted on upright brackets 85a on the carrier bar 53, the manifold being in communication with each vacuum nozzle through a flexible rubber conduit 86. As vacuum is created in the bottles, liquid is drawn into the nozzle heads, from a source later described, then passes into the bottles until it reaches a level even with the bottom open end 83 of the vacuum nozzle of each filler head. Thus any surplus or overflow liquid is drawn into the vacuum manifold 85, through the vacuum nozzles, to be disposed of in a manner later described.

The filler heads are so operated that they remain in lowered position long enough to complete filling the bottles with a small amount of overflow permitted so as to insure a uniform supply for each bottle.

Liquid is supplied to the filler heads through a liquid supply manifold 87 extending alongside the heads and being in communication with each head through a ball check valve 88 in the form of a hollow upstanding manifold outlet portion 88a, within which is disposed a ball 88b resting on a valve seat 88c and confined loosely for upward displacement by the cap 88d threaded into the top of the portion 88a. The valve outlets 88a are connected with the nozzle heads 72 by short pipe connections 88e whereby the manifold is also carried by the heads.

The supply manifold 87 is in communication with a supply tank 89, mounted on the base plate 2, through a flexible rubber conduit 90 permitting raising and lowering of the manifold with the filler heads. The tank 89 may be supplied from any suitable source through the supply pipe 91 connecting with the tank through any type of float controlled valve 92, generally shown in Figs. 1 and 2.

For creating a vacuum in the manifold 85 and for disposing of the overflow liquid from the filled bottles, the structure includes a vacuum pump 93 mounted on the base plate 3 and being driven by the motor 43 through a suitable cased-in belt and pulley drive connection 94. The air intake port of the pump is in communication with the top end of a closed air purifying tank 95, mounted on the base plate 2, through a pipe connection 96 having its end 97 depending slightly into the top of the tank. The tank is filled with water 98 to a level below the pipe end 97, and depending into the tank from its top is a pipe 99 extending into the water. Continuing from the top end of the pipe 99 is a flexible conduit 100 which communicates at its other end with a liquid supply overflow trap 101 which in turn communicates with the manifold 85 through a flexible rubber conduit 102.

As a vacuum is created in the tank 95 above the water therein, by action of the pump 93, air is withdrawn from the manifold 85 to pass through conduit 102, trap 101, conduit 100, and then through pipe 99 to be drawn into the tank above the water by passing through the water, whereupon in the handling of fumy liquids, the fumes will be taken up in the water.

The filler heads are so regulated that vacuum is created in their nozzles just before they reach the lowered position and broken shortly upon being raised. To this end, a vent valve 103 is provided in the top of the air purifying tank 95 and being operated by a lever 104 mounted on the inner end of the rocker shaft 30 and connected with the valve through a chain 105. The lever 104 is so arranged that when the shaft 30 is operated to feed the feeder bar 15, the valve 103 is opened to break the vacuum in the air purifying tank 95, and closed to establish vacuum in the tank upon the return movement of the shaft.

The liquid overflow trap 101 comprises a closed tank including a glass cylinder 106 clamped between a lid 107 and a base 108 mounted on the raised horizontal bracket portion 108a of the frame 1, on which bracket is an upstanding bracket 108b supporting a vertical overflow pipe 109 connecting with the base 108 and in communication with the tank. The lid 107 of the tank is clamped thereon by a screw 110 threaded into a bar 111 extending over the tank and connected to the tank base 108 by the rods 112 on opposite sides of the tank. Extending upward into the tank 101, through its base 108, are two pipes 113 and 114 on opposite sides of the overflow pipe 109, which pipes respectively communicate at their bottom ends with the conduits 100 and 102. Thus as vacuum is created in the tank 101 through pipe 113, vacuum is established in the manifold 85 by way of the pipe 114, whereupon any surplus liquid from the filled bottles

is drawn into the tank 101. Upon release of the vacuum in the trap 101, controlled by the valve 103, the liquid contained therein will drain into the overflow pipe 109 which projects down into the supply tank 89 with a check valve 115 for admitting the overflow liquid into the tank upon release of the vacuum.

The cleaner heads 16 and means controlling same will now be described. A cleaner head carrier 116 in the form of a flat bar is provided, located parallel to and in advance of the filler head carrier bar 53, with respect to the direction of feed of the bottles thereunder. The carrier bar 116 is situated slightly below the plane of the carrier bar 53 and mounted thereon for vertical and lateral adjustment by means of two adjustable brackets 117. Each bracket comprises a bracket member 118 in the form of a horizontal bar portion extending transversely over the bar 53 and received in a guide groove 119 of a guide block 120 mounted on the carrier bar 53 and having a set screw 121 for holding the bracket portion 118 in adjusted position in the groove. The bracket bar portions 118 terminate in end portions over the carrier bar 116, each of which has a vertical bearing portion 122 at said end in which is adjustably received a vertical upright or rod 122a secured on the bar and being held in adjusted positions in the bearing, for raising or lowering the cleaner heads with respect to the filler heads, by means of a set screw 123 threaded into the bearing.

Each cleaner head comprises an air suction nozzle 126, of cylindrical form, depending from the carrier bar 116, and extending upward through an opening 126a in the bar into an externally threaded portion 127 receiving a nut 128 cooperating with the shoulder 129 of the nozzle for clamping same on the bar. The cleaner nozzles are arranged centrally over the bottle guides and positioned in advance of the filler heads to be in coaxial alignment with bottles succeeding those under the filler heads. Centrally supported in each suction nozzle 126, so as to depend therefrom, is an air admitting member or intake nozzle 130 in the form of a small tube supported in a spider formation 131 at the bottom end of the suction nozzle, and having its top end bent, as at 132, to extend through the side wall of the suction nozzle to be open to the atmosphere. About the bottom end of the suction nozzle 126, is a bottle sealing member or gasket 133 of flexible material such as rubber, which is frictionally held on the end of the nozzle, so as to project slightly therebeyond, and being supported under a shoulder 134 on the nozzle.

Extending over the carrier bar 116 in spaced relation thereover, is an air suction or vacuum manifold 135 mounted on two spaced brackets 136 on the bar, which manifold has communication with each suction nozzle through a flexible rubber air suction conduit 137.

For positively centering the bottles under the cleaner nozzles, as same are lowered, a bottle centering device 137a is provided similar to the centering device for the filler heads. The device 137a includes a horizontal flat bar 137b arranged to extend under the nozzles 126, in their raised position, and mounted on the bar to extend therethrough, is a group of centering members 137c in the form of downwardly and outwardly flaring bell shaped sleeves, similar to the sleeves 79c, each of which is coaxial with a nozzle 126 to permit its passage therethrough.

The bar 137b is mounted for limited reciprocable movement vertically upon two guide rods 137d depending from the opposite ends of the carrier bar 116, which rods pass through two bearings 137e on opposite ends of the bar 137b. On each guide rod 137d is a stop collar 137f for limiting downward movement of the centering device with respect to the cleaner nozzles.

Upon lowering of the cleaner heads with the filler heads, the centering sleeves 137 engage over the shoulders about the necks of the bottles thereunder, causing the bottles to be centered with the nozzles of the heads. On continued downward movement of the cleaner heads, the air intake nozzles enter the necks of the bottles to project therein considerably, upon the engagement of the suction nozzle gaskets with the necks of mouths of the bottles to effect the sealing of same. Suction is then created in the bottles by way of the nozzles 126 which causes admittance of an air stream into the bottom portion of the bottles by way of the air intake nozzles 130 whereupon air is caused to circulate through the bottles to carry dust and other foreign matter therefrom up into the vacuum manifold 135 to be disposed of in a manner outlined in the following.

For creating a suction, or vacuum, in the cleaner head manifold 135, a vacuum pump 138 is provided, which is mounted on a base 139 on which is supported a motor 140 for driving the pump through a suitable pulley and belt drive connection 141, said parts being arranged as a separate unit as shown in Fig. 1. The intake port 142 of the pump 138 is in communication, by way of a flexible conduit 143, to the bottom outlet connection 144 of a dust collector or trap 145 in the form of a closed cylindrical storage tank mounted on the bracket 108a, and the top intake connection 146 of the tank is in communication, by way of a flexible suction conduit 147, with the intake end of the cleaner manifold 135. The air intake connection 146 extends part-way into the tank 145 and has secured thereon a dust collector bag 148 of metallic or cloth screening, within which dust or other foreign matter drawn from the bottles is gathered. The tank 145 may be provided with any type of removable cover 149 to enable removal of the dust collector bag for cleaning.

By reason of the structure described, regarding the filler and cleaner heads, the filler heads are easily adjusted to determine the amount of liquid to be supplied to the bottles. For one example, if the amount of liquid supplied to the bottles is to be decreased, and assuming the filler and cleaner heads are positioned as shown in Fig. 5, the gaskets 80 are adjusted upward on the filler nozzles 76 with their stop collars 81 until the proper depth of entry of the nozzles in the bottles is attained. Then the filler heads and bar 53 with the centering means 79a are adjusted downward on the uprights 54 until the gaskets 80 are located in their normal position prior to the adjustment of same on the nozzles. The cleaner heads 16 with their carrier bar 116 are then adjusted upward on the brackets 117 until the heads again are located in their normal position, above the bottle guides, attained prior to the downward adjustment of the filler heads. The filler heads are shown in their adjusted positions in dot and dash lines in Fig. 5.

In that all sizes of bottles are fed to the fixed station B on the guides 10, the cleaner heads with their carrier bar 116 are adjusted laterally of the

filler heads, by means of the adjustment of the bracket portion 118, with respect to the carrier bar 53, so that the cleaner head nozzles will be in coaxial alignment with bottles of various diameters located thereunder by contact with the bottles at the station B of the guides.

The gaskets 80 of the filler heads are composed of less resilient rubber than the gaskets 133 of the cleaner heads, and the gaskets 133 project slightly below the plane of the bottoms of the gaskets 80 in the normal or raised position of the heads. Thus as the filler and cleaner heads are lowered by force of their weight, controlled by the action of the cams 58, the gaskets 80 of the filler heads will engage the bottles thereunder under a greater pressure than that taken up by the gaskets 133 of the cleaner heads on engagement with their respective bottles. Therefore, the upward pressure exerted against the overhanging bracket members 118 of the brackets 117, upon engagement of the cleaner heads with the bottles thereunder, is reduced to a minimum to prevent canting or tilting of the cleaner heads out of alignment with the bottles. Also, by virtue of the arrangement and construction of the gaskets, any reasonable variation in the height of bottles will be mainly taken up in the more resilient gasket 133, thereby preventing the possibility of one gasket being in sealing engagement with a container or bottle, and the other being held out of engagement over its respective bottle.

Having thus described my invention, I claim:

1. In a machine of the class described, means for positioning two containers, a vacuum filler nozzle, said means and nozzle being arranged for relative movement whereby to cause entry of the nozzle in a container, a container sealing member adjustably mounted on the nozzle for regulating depth of entry of the nozzle in a container, a suction cleaner nozzle connected operably with the filler nozzle whereby its entry is established in the other container upon said entry of the filler nozzle, a container sealing member mounted on the cleaner nozzle for engaging a container upon said entry of the filler nozzle, and means providing an adjustable operable connection between the nozzles in compensating for the adjustment of the filler nozzle sealing member.

2. In a machine of the class described, means for positioning two containers, a filler nozzle having means regulated by its depth of entry in a container for controlling the amount supplied, said positioning means and nozzle being arranged for relative movement whereby to cause entry of the nozzle in a container, a container sealing gasket adjustably mounted on the nozzle in controlling depth of entry of same in the container, a suction cleaner nozzle operably connected with the filler nozzle to establish its entry in the other container upon said relative movement, a container sealing gasket mounted on the cleaner nozzle for engaging a container upon said entry of the filler nozzle, and means providing adjustment of the cleaner nozzle gasket with respect to the filler nozzle gasket in compensating for the adjustment of same.

3. In a machine of the class described, means for positioning two containers, a filler nozzle mounted to be lowered into a container and having means controlled by its depth of entry for regulating amount supplied to the container, a container sealing gasket adjustably mounted on the nozzle for controlling its said depth of entry, a suction cleaner nozzle operably connected with the filler nozzle to cause its entry in the other container upon said entry of the filler nozzle, a container sealing gasket fixedly mounted on the cleaner nozzle for engaging a container upon said entry of the filler nozzle, and means providing adjustment of the cleaner nozzle with respect to the filler nozzle in compensating for the adjustment of the filler nozzle gasket.

4. In a machine of the class described, a carrier member movable to raised and lowered positions, a filler nozzle mounted on the carrier to depend therefrom, a depending suction cleaner nozzle disposed laterally of the filler nozzle, means connecting the cleaner nozzle with the filler nozzle to operate therewith and provide its adjustment laterally thereof, means for positioning a container in alignment under each nozzle whereby one cooperates to position the other, and a gasket of resilient material mounted on each nozzle for engaging a container when lowered, wherein one gasket is composed of more resilient material than the other.

5. In a machine of the class described, a driving carrier member mounted movable to raised and lowered positions, a filler nozzle mounted on the carrier to depend therefrom, a driven carrier member spaced laterally of the driving carrier and mounted thereon for lateral adjustment, a suction cleaner nozzle mounted on the driven carrier to depend therefrom, means for positioning a container in alignment under each nozzle whereby one container controls the position of the other, and a gasket of resilient material on each nozzle for engaging a container when lowered, wherein the gasket on the cleaner nozzle is composed of more resilient material than the other gasket.

6. In a machine of the class described, a driving carrier member mounted movable to raised and lowered positions, a filler nozzle mounted on the carrier to depend therefrom, a bracket member extending laterally of the carrier and mounted thereon for adjustment laterally thereof, a driven carrier member mounted on the bracket and spaced laterally of the first carrier, a suction cleaner nozzle mounted on the driven carrier to depend therefrom, means for positioning a container in alignment under each nozzle whereby one controls the position of the other, and a rubber gasket on each nozzle for engaging a container when lowered, wherein the gasket on the suction cleaner nozzle is composed of more resilient rubber than the other.

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