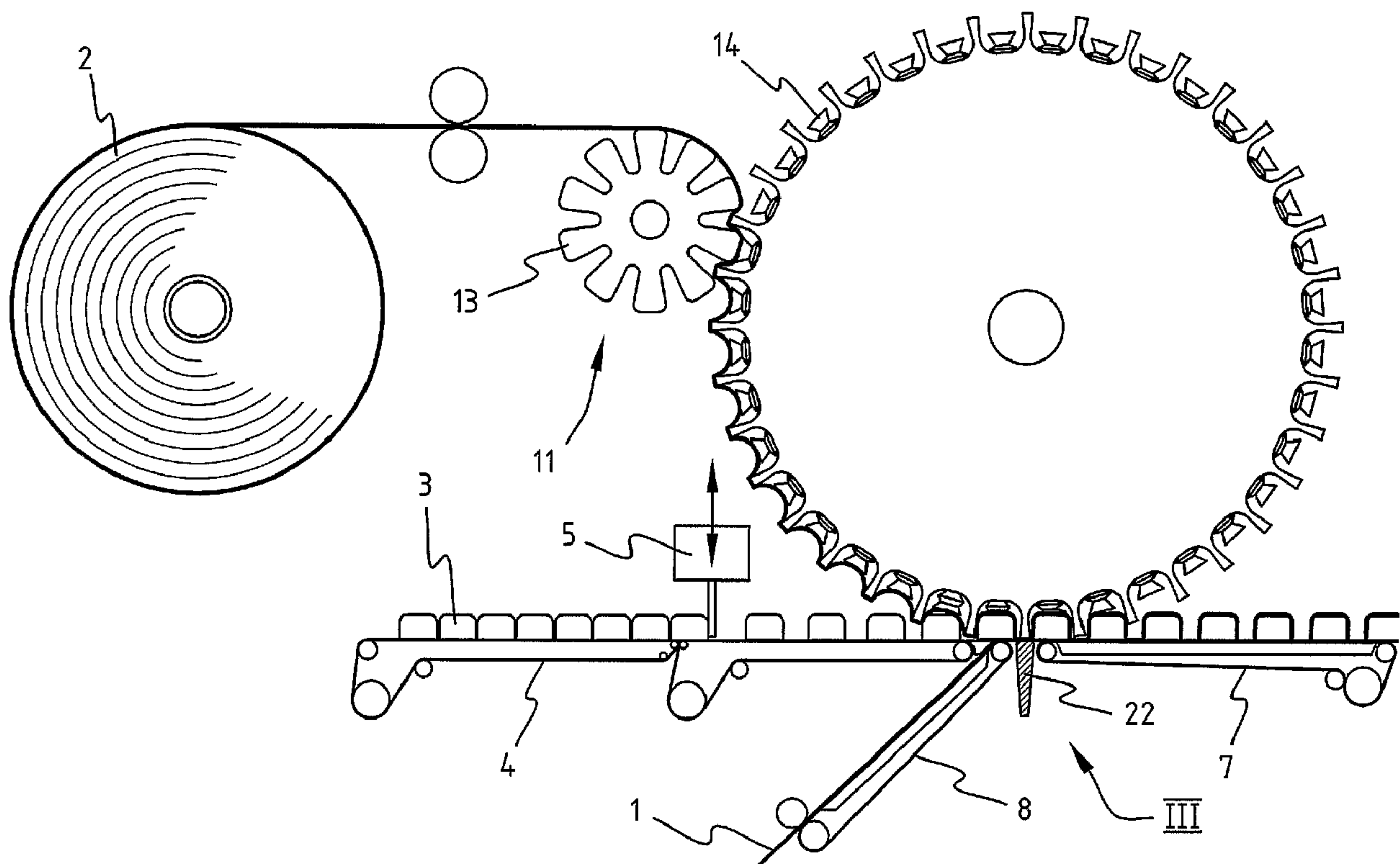




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A method for packaging products (3), such as candies, wherein the products are positioned on a first sheet (1) which is continuously moved in a transport direction, wherein the products are covered by a second sheet (2) which is continuously moved in the same transport direction and which is aligned substantially plane-parallel to the first sheet, and wherein the first and second sheets are sealed together near the outer edges of the individual products or grouped products by a sealing device (22), wherein the sealing device comprises sealing ribs (12) extending substantially transversely to the transport direction on one side of the moving sheets, wherein said sealing ribs (12) are being moved at the same speed as the sheets and the sealing ribs seal the first and second sheets together in between the moving products.



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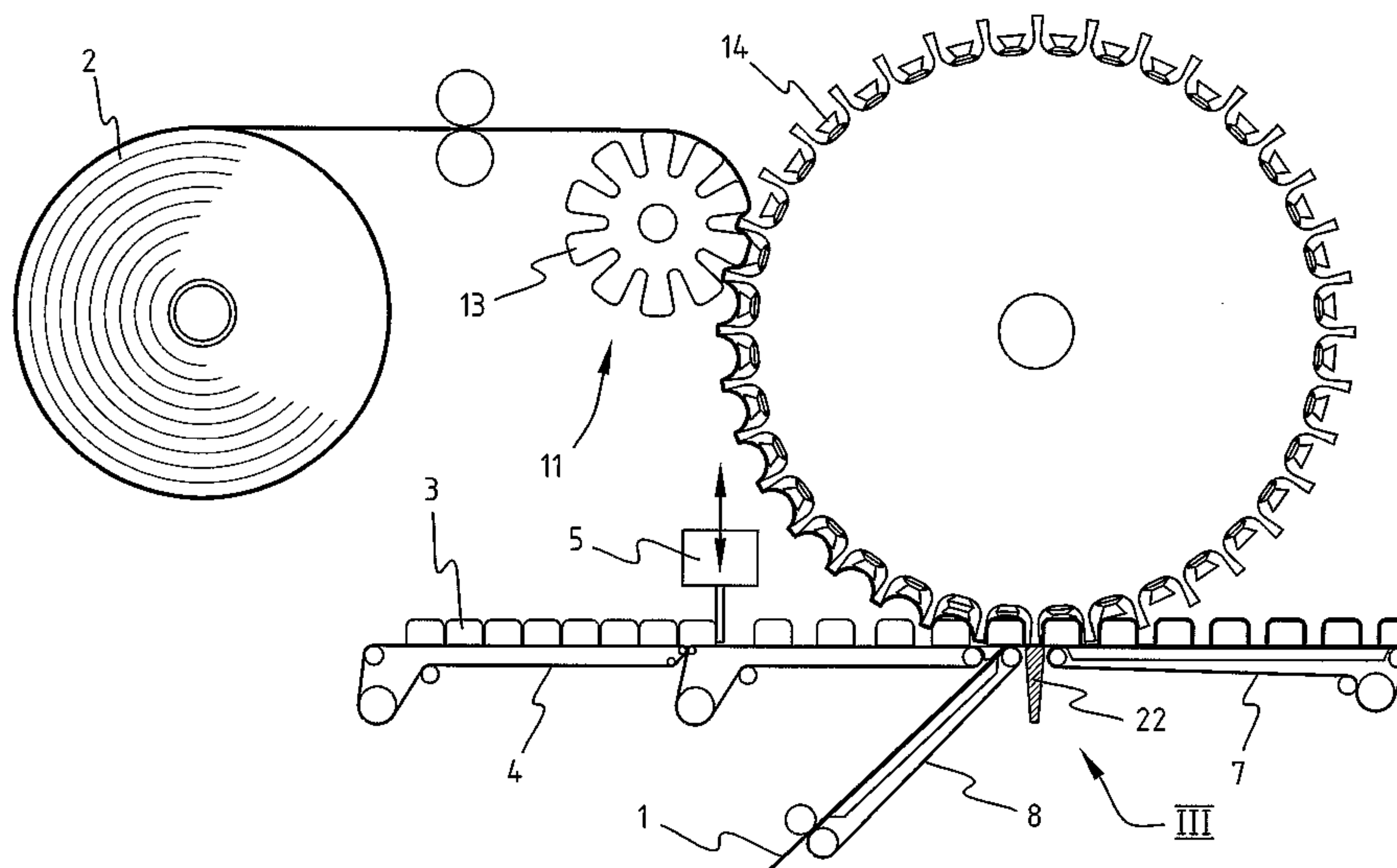
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(54) Title: METHOD AND DEVICE FOR PACKAGING PRODUCTS AND ARRAY OF PACKAGED PRODUCTS



(57) Abstract: A method for packaging products (3), such as candies, wherein the products are positioned on a first sheet (1) which is continuously moved in a transport direction, wherein the products are covered by a second sheet (2) which is continuously moved in the same transport direction and which is aligned substantially plane-parallel to the first sheet, and wherein the first and second sheets are sealed together near the outer edges of the individual products or grouped products by a sealing device (22), wherein the sealing device comprises sealing ribs (12) extending substantially transversely to the transport direction on one side of the moving sheets, wherein said sealing ribs (12) are being moved at the same speed as the sheets and the sealing ribs seal the first and second sheets together in between the moving products.

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**METHOD AND DEVICE FOR PACKAGING PRODUCTS AND ARRAY OF  
PACKAGED PRODUCTS**

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The invention relates to a method for packaging products,  
such as candies, in a removable enclosure, wherein the  
products are positioned on a first sheet which is  
continuously moved in a transport direction, wherein the  
10 products are covered by a second sheet which is continuously  
moved in the same transport direction and which is aligned  
substantially plane-parallel to the first sheet, and wherein  
the first and second sheets are sealed together near the  
outer edges of the individual products or grouped products by  
15 a sealing device.

Such a method is used for providing a bandoleer of  
individually packaged products or of products that are  
grouped together in one sealed envelope, wherein the  
20 envelopes can be separated from each other at a later stage.  
The invention aims at an improved method, wherein products  
can be wrapped efficiently at a fast speed, wherein the  
packaging device can be easily adapted for differently sized  
products, wherein as little packaging material as possible is  
25 used, and/or wherein brittle products can be wrapped with as  
little damage possible.

To that end the sealing device comprises sealing ribs  
extending substantially transversely to the transport  
30 direction on one side of the moving sheets, wherein said  
sealing ribs are being moved at the same speed as the sheets  
and the sealing ribs seal the first and second sheets  
together in between the moving products. Thereby the sheets  
can move continuously, without the need to interrupt the

movement for sealing the sheets together. Preferably the sealing device comprises a rotating frame, the rotation axis of said frame extending transversely to the transport direction, wherein said sealing ribs extend from a coaxial  
5 cylindrical surface of said frame.

In order to prevent damage to the products, in particular if the products have a substantial height, at least one of said sheets is preferably pre-shaped to fit at least partially  
10 around the products before the film comes into contact with the products. Said pre-shaping action is preferably performed by a pre-shaping device comprising a first rotating shaping frame on one side of the moving sheet and a second rotating shaping shape on the opposite side of the moving sheet, the  
15 rotation axes of both frames extending transversely to the transport direction of the sheet, wherein said frames comprise co-operating protruding shaping ribs extending substantially transversely to the transport direction, wherein the shaping ribs of both frames move between each  
20 other, and wherein said shaping ribs are being moved at the same speed as the pre-shaped sheet. Preferably the first pre-shaping frame is positioned such that it guides the pre-shaped film towards the other moving sheet while including the products. Preferably the first pre-shaping frame is the  
25 same frame as the rotating frame of the sealing device, and the shaping ribs on said frame are said sealing ribs.

The described method is particularly advantageous when the products have an elongated form and are positioned  
30 transversely on the first moving sheet. Preferably the sealing ribs comprise ultrasonic welding means. Preferably the sealed areas between the products are perforated or



scored, such that the packaged products stay attached to each other, but can be easily separated.

The invention also relates to a device for packaging  
5 products, such as candies, comprising first transport means for continuously moving a first sheet in a transport direction, positioning means for positioning the products on the first sheet, second transport means for continuously moving a second sheet in the same transport direction in  
10 alignment substantially plane-parallel to the first sheet while covering the products, and a sealing device for sealing the first and second sheets together near the outer edges of the individual products, wherein the sealing device comprises protruding sealing ribs extending substantially transversely  
15 to the transport direction, and said sealing device further comprises synchronizing means for moving said sealing ribs at the same speed as the sheets while sealing the first and second sheets together in between the moving products.

20 Furthermore the invention relates to a method for packaging products, such as candies, wherein the products are positioned on a first sheet which is continuously moved in a transport direction, wherein the products are covered by a second sheet which is continuously moved in the same  
25 transport direction and which is aligned substantially plane-parallel to the first sheet, and wherein the first and second sheets are sealed together near the outer edges of the individual products by a sealing device, wherein at least one of said sheets is pre-shaped by a pre-shaping device to fit  
30 at least partially around the products before the sheet comes into contact with the products, wherein said pre-shaping device comprises a first rotating shaping frame on one side of the moving sheet and a second rotating shaping frame on

the opposite side of the moving sheet, the rotation axes of both drums extending transversely to the transport direction of the sheet, wherein said frames comprise co-operating protruding shaping ribs extending substantially transversely to the transport direction, wherein the shaping ribs of both frames move between each other, and wherein said shaping ribs are being moved at the same speed as the pre-shaped sheet.

The invention also relates to a device for packaging products, such as candies, comprising first transport means for continuously moving a first sheet in a transport direction, positioning means for positioning the products on the first sheet, second transport means for continuously moving a second sheet in the same transport direction in alignment substantially plane-parallel to the first sheet while covering the products, a sealing device for sealing the first and second sheets together near the outer edges of the individual products, and a pre-shaping device for pre-shaping at least one of said sheets to fit at least partially around the products before the sheet comes into contact with the products, wherein said pre-shaping device comprises co-operating protruding shaping ribs extending substantially transversely to the transport direction, wherein the shaping ribs of both drums are movable between each other, and said pre-shaping device further comprises synchronizing means for moving said shaping ribs at the same speed as the pre-shaped sheet.

Further the invention relates to an array of packaged products, such as candies, comprising two sheets which are sealed together and enclose said products or groups of products, wherein the sealed areas between the products are weakened, for instance by scores or perforations, such that



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the packaged products can be easily separated, wherein one of said sheets is a substantially flat relatively rigid board or film and the other sheet is a relatively flexible foil shaped to fit at least partially around the products. Preferably the sides of the sealed sheets extending from the outer ends of the products are bend,  
5 upwards or downwards, in order to give the array rigidity in its longitudinal direction. In this manner a very efficiently packaged product is obtained. The extending sides of the sealed sheets can be given such a length that they can be bend further, over the packaged products and be sealed together, such that the rigid board forms a protective tubular box.

10 According to one aspect of the present invention, there is provided a method of packaging elongate products in removable packaging comprising: placing elongate products on a conveyor so that they are positioned transversely to the transport direction of the conveyor; spacing the elongate products on the conveyor at a pre-defined distance apart; continuously moving a flat first sheet in the said  
15 transport direction; pre-shaping a second sheet to fit partially around the spaced apart elongate products before the second sheet comes into contact with the elongate products; continuously moving the pre-shaped second sheet to cover the spaced apart elongate products with the pre-shaped second sheet; positioning the spaced apart elongate products on the flat first sheet; and sealing the flat first  
20 sheet and the second sheet together between the elongate products using sealing ribs extending substantially transversely to the said transport direction on one side of the moving sheets and moving at the same speed as the sheets.

According to another aspect of the present invention, there is provided use of a device in a method as described above, the device comprising: a conveyor for  
25 moving elongate products in the transport direction of the conveyor; a separation device for spacing the elongate products on the conveyor at a pre-defined distance apart; first transport means for continuously moving a flat first sheet in the said transport direction; means for pre-shaping a second sheet to fit partially around the spaced apart elongate products before the second sheet comes into  
30 contact with the elongate products; second transport means for continuously moving the pre-shaped second sheet to cover the spaced apart elongate

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products; positioning means for positioning the spaced apart elongate products on the flat first sheet; sealing ribs extending substantially transversely to the said transport direction for sealing the flat first sheet and the second sheet together between the elongate products; and synchronising means for moving the said  
5 sealing ribs at the same speed as the sheets while sealing the flat first sheet and the second sheet together.

The invention will be illustrated with reference to the drawings, wherein:

Fig. 1 shows a schematic perspective view of a packaging device;

Fig. 2 shows a schematic side view of a detail of the packaging device of Fig. 1;

10 Fig. 3 shows a further schematic side view of a detail of the packaging device of Fig. 1;

Fig. 4 shows a perspective view of an array of packaged products.

With reference to Figures 1, 2 and 3 the packaging device has a first roll of cardboard 1 having a plastic coating on at least one side and a second roll of  
15 plastic film 2. The elongated candy bars 3 are placed transversely on a first endless conveyor 4. A separation device 5 has a barrier which



moves up and down at regular intervals for spacing the candy bars 3 a pre-defined distance apart.

The second conveyor 6, the third conveyor 7, the fourth  
5 conveyor 8, the fifth conveyor 9, as well as the card board 1 all move at the same speed, which is larger than the speed of conveyor 4 in order to accommodate the larger mutual distance of the candy bars.

10 The plastic film 2 is led between a co-operating rotating shaping drums 10, 11. Both drums 10, 11 have protruding shaping ribs 12, 13 which during rotation are moved between each other like a gear unit, thereby corrugating the plastic film 2 into the desired shape. The drum 10 has flexible  
15 suction cups 14 between its ribs 12 which hold the pre-shaped film by a vacuum action force.

The pre-shaped film 2 is placed on top of the moving candy bars 3 by the drum 10 while they are at the same time being  
20 transferred by the conveyor 6 onto the coated side of moving cardboard 1. In this manner the candy bars 3 are enclosed in the cardboard 1 and the pre-shaped plastic film 2. When the ribs 12 are at their lowest point 2 they push the plastic film 2 onto the cardboard 1, where the plastic film 2 is  
25 welded on the coated side of cardboard 1 by a first ultrasonic welding device 22, which co-operate with ultrasonic welding means present in the sealing ribs 12. In this manner a series of interconnected tubes is formed, each tube comprising a candy bar. By changing the opening time of  
30 the separation device 5 also two or more candy bars 3 can be grouped together and enclosed in a single tube thereby.

Subsequently the transverse seals between the candy bars 3 are perforated or scored by a rotating drum 24 having scoring or perforating ribs 15. Then the ends of the film 1 which extend from the sides of the candy bars 3 are pushed down by two further ultrasonic sealing devices 16 and sealed to the cardboard 1, whereby the candy bars 3 are enclosed inside the cardboard and plastic film in an airtight manner. At this stage the candy bars 3 form an endless array of interconnected packaged products. The separation drum 17 separates the products into arrays 19 of for instance six candy bars each by means of cutting ribs 18.

The array 19 of candy bars 3 as shown in Figure 4 thereby has a cardboard layer 1 on the bottom side and a shaped plastic film layer 2 on the top side which is sealed onto the cardboard layer 1 in between the candy bars 3. These transverse seals have scores or perforations 20 so that individual products can be easily torn off, without breaking the seal. Both sealed longitudinal sides 21 of the package are folded upwards, giving the array 19 such rigidity that it can subsequently be treated as a box. The array 19 can be shipped to and exposed in shops, and sold to the public, without the need to enclose it in a further layer of plastic, as is the case with prior art packaging methods of candy bars.



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CLAIMS:

1. A method of packaging elongate products in removable packaging comprising:

5 placing elongate products on a conveyor so that they are positioned transversely to the transport direction of the conveyor;

spacing the elongate products on the conveyor at a pre-defined distance apart;

continuously moving a flat first sheet in the said transport direction;

10 pre-shaping a second sheet to fit partially around the spaced apart elongate products before the second sheet comes into contact with the elongate products;

continuously moving the pre-shaped second sheet to cover the spaced apart elongate products with the pre-shaped second sheet;

15 positioning the spaced apart elongate products on the flat first sheet; and

sealing the flat first sheet and the second sheet together between the elongate products using sealing ribs extending substantially transversely to the said transport direction on one side of the moving sheets and moving at the same speed as the sheets.

20 2. A method according to claim 1 wherein the elongate products are positioned on a relatively rigid flat first sheet.

3. A method according to claim 1 or 2 wherein the flat first sheet and the second sheet are sealed together between each pair of adjacent elongate products.

25 4. A method according to any one of claims 1 to 3 in which the sealing ribs protrude from the cylindrical surface of a rotating drum.

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5. A method according to any one of claims 1 to 4 wherein the said pre-shaping of the second sheet is performed by a rotating first shaping drum on one side of the moving second sheet and a rotating second shaping drum on the opposite side of the moving second sheet, the rotation axes of both drums
- 5 extending transversely to the transport direction, wherein the said drums comprise co-operating protruding shaping ribs extending substantially transversely to the transport direction, wherein the shaping ribs of both drums move between each other and wherein the said shaping ribs are moved at the same speed as the second sheet.
- 10 6. A method according to claim 5 wherein the first shaping drum is positioned such that it guides the second sheet towards the moving flat first sheet to cover the elongate products on the flat first sheet.
7. A method according to any one of claims 1 to 6 wherein the sealing ribs comprise ultrasonic welding means.
- 15 8. A method according to any one of claims 1 to 7 further comprising perforating or scoring the sealed areas between elongate products such that the elongate products stay attached to each other but can be easily separated.
9. Use of a device in a method according to any one of claims 1 to 8, the device comprising:
- 20 a conveyor for moving elongate products in the transport direction of the conveyor;
- a separation device for spacing the elongate products on the conveyor at a pre-defined distance apart;
- first transport means for continuously moving a flat first sheet in the
- 25 said transport direction;
- means for pre-shaping a second sheet to fit partially around the spaced apart elongate products before the second sheet comes into contact with the elongate products;



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second transport means for continuously moving the pre-shaped second sheet to cover the spaced apart elongate products;

positioning means for positioning the spaced apart elongate products on the flat first sheet;

5                    sealing ribs extending substantially transversely to the said transport direction for sealing the flat first sheet and the second sheet together between the elongate products; and

                    synchronising means for moving the said sealing ribs at the same speed as the sheets while sealing the flat first sheet and the second sheet  
10 together.

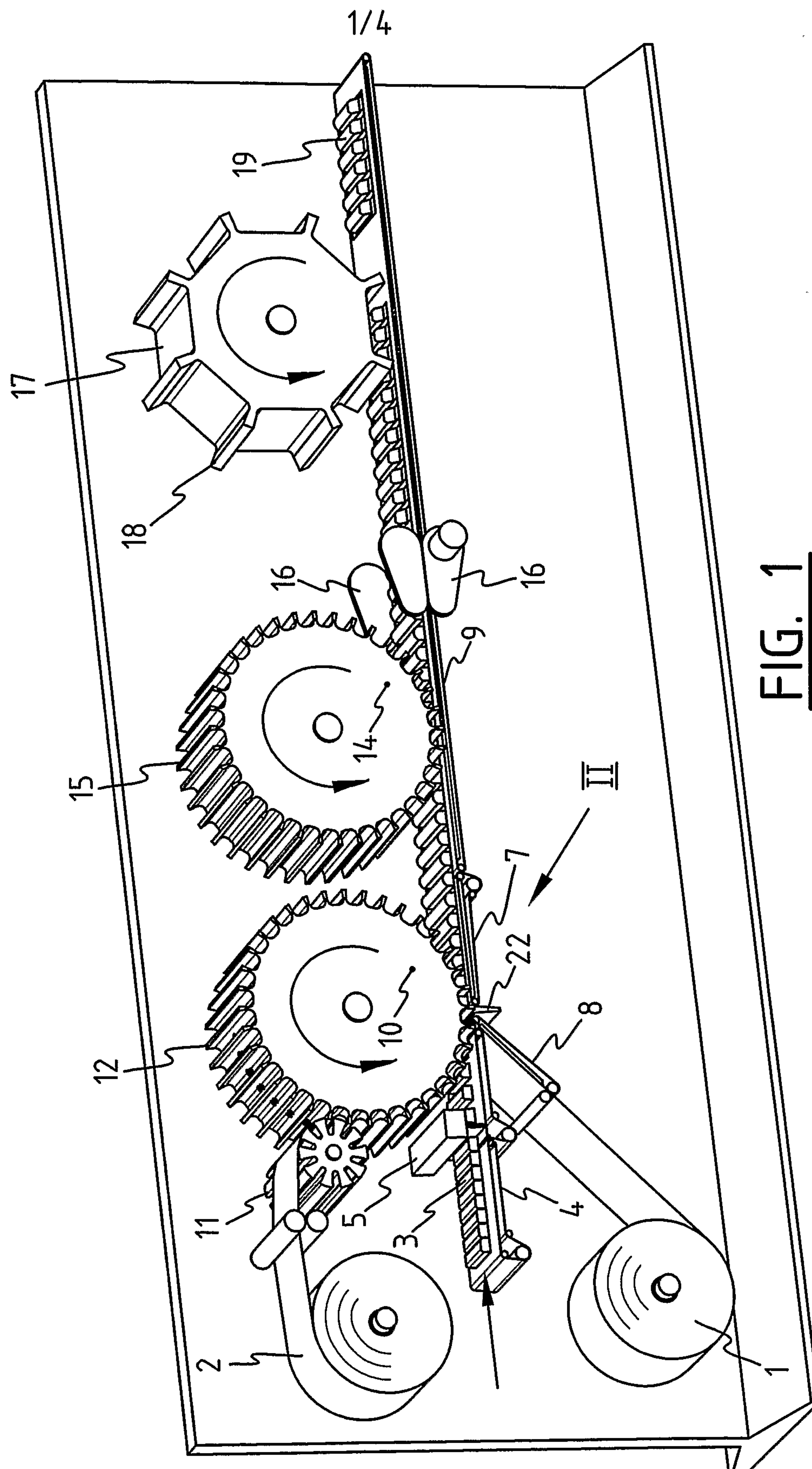


FIG. 1



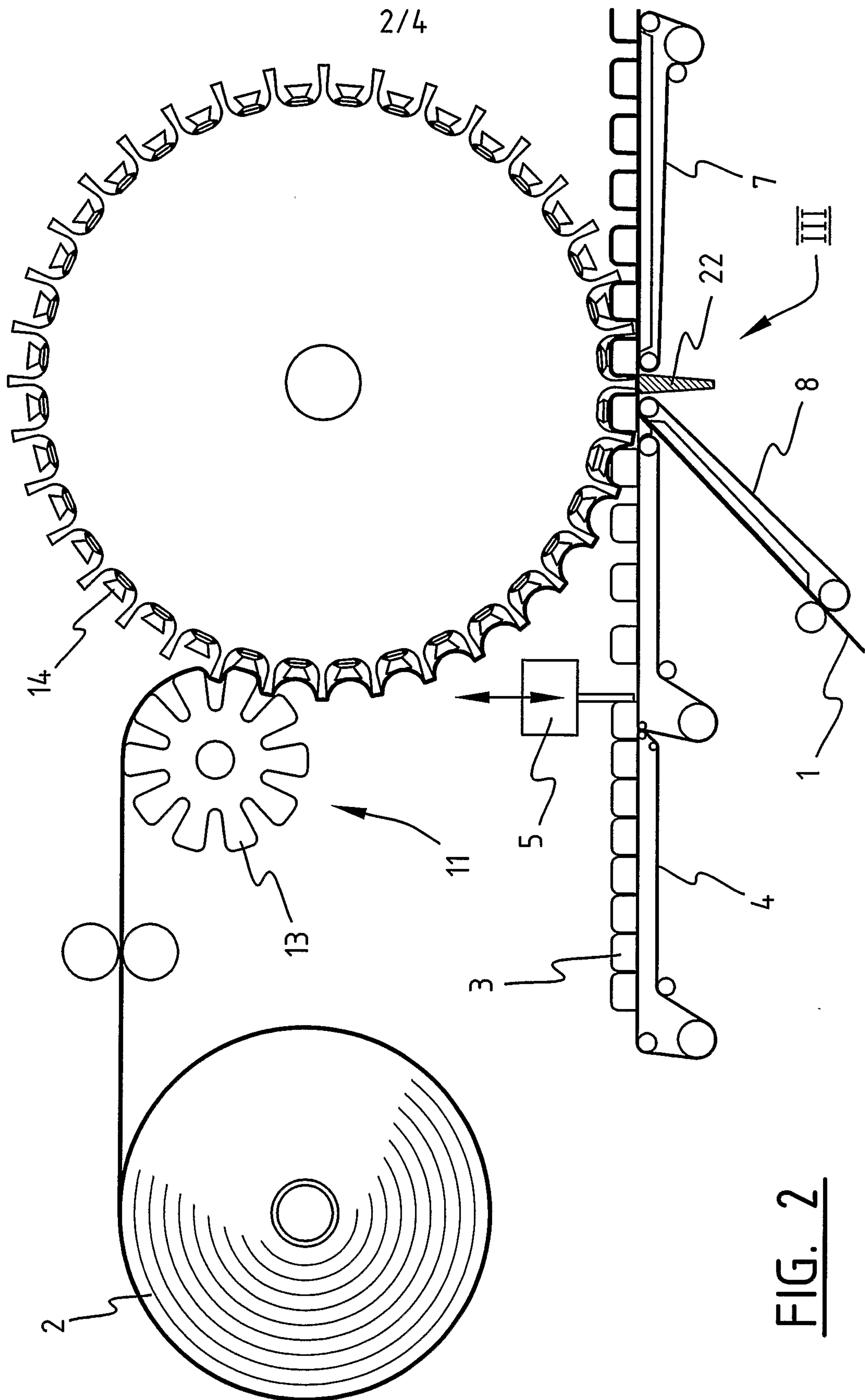
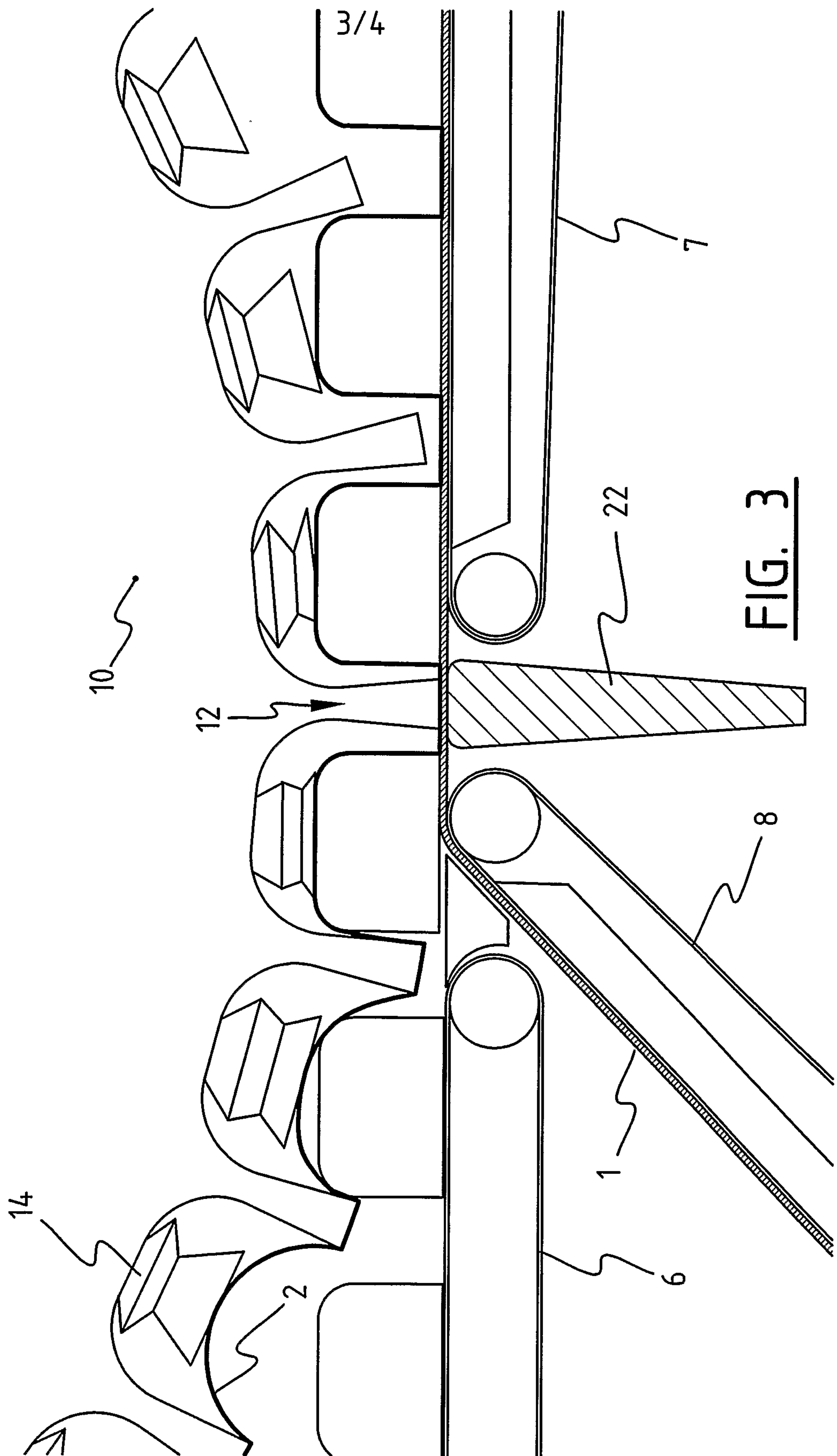


FIG. 2





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