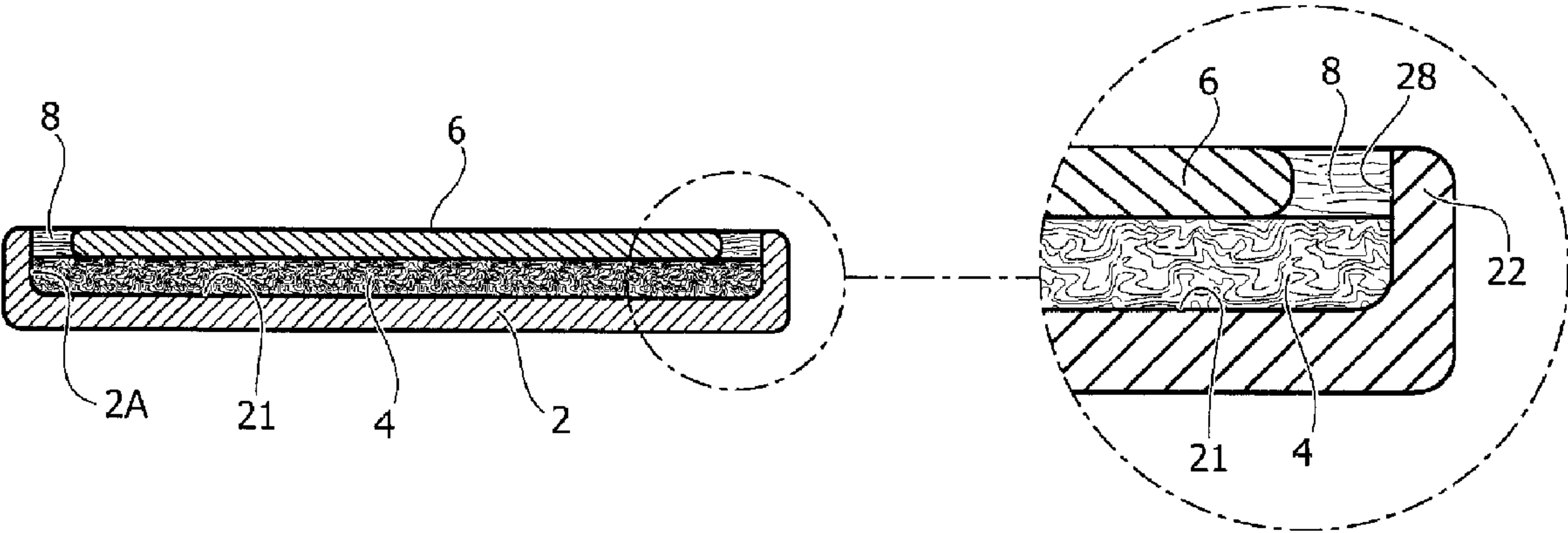




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(54) Titre : GALETTE FOURREE ET PROCEDE DE PRODUCTION CORRESPONDANT  
(54) Title: FILLED BISCUIT AND CORRESPONDING PRODUCTION PROCESS



(57) **Abrégé/Abstract:**  
Described herein is a filled biscuit characterized in that it comprises: - a biscuit body (2) shaped like a container, defining a cavity (2A) contained in which is a filling material (4); - a cover (6) made of biscuit designed to close said cavity (2A) from outside, either partially or completely; and - a second filling material (8) that is set in contact simultaneously with said cover (6), said container body (2), and said filling material (4), so as to seal said cover to said container body and withhold said first filling material within said cavity.

**ABSTRACT**

Described herein is a filled biscuit characterized in that it comprises:

- a biscuit body (2) shaped like a container, defining a cavity (2A) contained in which is a filling material (4);
- a cover (6) made of biscuit designed to close said cavity (2A) from outside, either partially or completely; and
- 10 - a second filling material (8) that is set in contact simultaneously with said cover (6), said container body (2), and said filling material (4), so as to seal said cover to said container body and withhold said first filling material within said cavity.
- 15 (Figure 1)

**"Filled biscuit and  
corresponding production process"**

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Field of the invention

5       The present invention in general relates to the field of filled biscuits. In the category referred to both sweet and savoury biscuits are to be included herein.

Prior art

10       Figure 7 illustrates a known solution of filled biscuit, which is constituted by two disk-shaped bodies made of biscuit set between which is a layer of filling, according to an overall sandwich configuration.

      This type of solution can use as filling only creams  
15   that are particularly viscous and firm, the aim being to prevent the filling from leaking out of the biscuit.

      The possibility of using, instead, softer and more creamy fillings still represents a technical problem that is markedly felt.

20       With these fillings it becomes in fact necessary to devise solutions aimed at guaranteeing containment of the filling and ensuring, more in general, integrity of the biscuit.

      The above problem is particularly felt in the field  
25   of industrial production, on account of the high rates of production and of the types of packaging envisaged, which are poorly suited to very delicate types of product.

Object and subject of the invention

The object of the present invention is to solve the problem mentioned above by means of a filled biscuit that presents the characteristics of Claim 1.

5       The present invention moreover regards a process for producing a filled biscuit according to Claim 7 and a plant for the production of filled biscuits according to Claim 12.

10       The claims form an integral part of the technical teaching provided herein in relation to the invention.

Brief description of the drawings and detailed description of one or more embodiments of the invention

15       Further characteristics and advantages of the invention will emerge clearly from the ensuing description with reference to the annexed drawings, which are provided purely by way of non-limiting example and in which:

20       - Figure 1 illustrates, according to an axonometric view, an example of filled biscuit of the type described herein;

      - Figure 2 is a cross-sectional view of the biscuit of Figure 1, according to the plane of section II-II;

      - Figure 3 is a schematic illustration of an embodiment of the process described herein;

25       - Figure 4 illustrates a part of biscuit according to a further embodiment of the biscuit described herein;

      - Figure 5 is a schematic illustration of a step of the process described herein;

      - Figure 6 illustrates a detail of means used in the

process described herein; and

- Figure 7 illustrates an example of filled biscuit according to the prior art.

In the ensuing description, various specific details  
5 are illustrated aimed at enabling an in-depth understanding of the embodiments. The embodiments may be provided without one or more of the specific details, or with other methods, components, or materials, etc. In other cases, known structures, materials, or operations  
10 are not shown or described in detail so that various aspects of the embodiment will not be obscured.

The references used herein are only provided for convenience and hence do not define the sphere of protection or the scope of the embodiments.

15 In general, the filled biscuit described herein comprises (see Figures 1 and 2) a container body 2, which defines a cavity 2A, contained in which is a filling 4, and a cover 6, which closes at least partially the cavity 2A with the filling 4 inside it.  
20 The body 2 and the cover 6 are both made of biscuit.

The biscuit described herein further comprises a second filling material 8, which is set in contact simultaneously with the body 2, the cover 6, and the layer of filling 4 so as to seal the cover 6 to the body  
25 2, and at the same time withhold the filling 4 inside the cavity 2A of the body 2.

The material 8 hence performs the dual function of barrier against exit of the filling, on the one hand, and, on the other, of adhesive between the body 2 and

the cover 6, thus ensuring a firm connection thereof.

In view of the characteristics mentioned above, in the biscuit described herein it is possible to use as filling even soft and creamy substances, without there  
5 being the drawbacks mentioned at the start, since the filling is practically sealed within the cavity 2A. In fact, in preferred embodiments, filling 4 is creamy in texture.

The composition of the material 8 may vary according  
10 to the requirements of application. For example, according to the recipe and the organoleptic properties envisaged for the biscuit, the material may be constituted by a fatty base or else by a sugary base.

Generally, the filling material 8 has a melting  
15 point higher than that of the main filling 4. Once again in general, the melting point of the material 8 will moreover be higher than the temperature envisaged for preservation and consumption of the biscuit, for example higher than 20°C or 22°C for biscuits to be consumed at  
20 room temperature, precisely to be able to perform the functions referred to above.

By way of example, it should now be noted that the present applicant has identified a preferred composition of the filling material 8, obtained from the following  
25 recipe:

- 40-60wt% of fatty phase, in particular refined stearin with a melting point of 45°C, preferably a percentage of between 45-55wt%;
- 5-9wt% of cocoa powder;

- 40-44wt% of lactose; and
- soy lecithin for the remaining part.

The above composition has proven suitable for performing the functions indicated above of sealant and adhesive, specifically in applications for biscuits to be consumed at room temperature (its melting point is around 50°C - 60°C), and moreover its organoleptic properties have proven compatible and appreciable in combination with a filling constituted by the spreadable cream Nutella® produced by a company of the same Group the present applicant belongs to.

As regards the body 2 and the cover 6, they may be obtained from any dough for the production of biscuits.

Generally, a dough for biscuits comprises water (5-25wt%), flour (30-80 wt%), leavening agents (0.1-6wt%), sugar and/or other sweetening substances (5-35wt%), for example glucose syrup, and finally butter or else vegetable fat (5-40wt%). To these typical basic ingredients there may then be added further components, such as cacao, hazelnuts, etc.

The dough may be either a dough for dry biscuits or a dough for biscuits of the shortbread type.

The two types mentioned can thus be distinguished as follows: for 100 kg of flour,

- the dough for dry biscuits comprises from 5 to 12 kg of fats and from 14 to 40 kg of water; and
- the dough for biscuits of the shortbread type comprises from 15 to 25 kg of fats and from 14 to 18 kg of water.

In preferred embodiments, body 2 and cover 6 are crunchy in texture.

On the other hand, as mentioned at the start, the filled biscuit described herein may also constitute a savoury product, and hence in this case the parts made of biscuit and the two filling materials will comprise in the their recipe a savoury component that completely or partially replaces a sweet component.

To return to the body 2 and to the cover 6, these may have various shapes and dimensions, so that, through the solution described herein, it is in effect possible to offer the consumer a wide range of products. The container body 2 may in particular envisage any generally hollow conformation, whether this be defined by cylindrical walls and flat bottom, as in the example of Figures 1 and 2, or also, for example, by a single hemispherical wall or a wall of a similar but irregular type. The profiles in plan view of the bodies 2 and 6 may clearly be of any desired shape.

In various preferred embodiments, as in the one illustrated, the body 2 has a mouth edge 22 that defines a top opening larger than the overall dimensions in plan view of the cover 6, so that the latter will rest completely on the layer of filling 4, and between the latter and the edge 22 a gap 28 is created of a substantially annular shape. In this case, the material 8 is applied along the gap 28 surrounding the cover 6.

With reference to the detail of Figure 2, it may be seen that the material 8 is in contact, laterally, with

the cover 6 and the edge 22 of the body 2, and, at the bottom, with the layer of filling 4. It acts, on the one hand, as adhesive that holds together the cover 6 and the body 2, and, on the other, constitutes a barrier  
5 designed to prevent exit of the layer of filling 4 from the cavity 2A.

In further preferred embodiments (see in this connection Figure 4), the body 2 moreover has, in a substantially central internal area thereof, a relief 24  
10 that rises from the bottom of the body 2 for a height that allows it to set itself in contact with the cover 6 and support it. In various preferred embodiments, as in the one illustrated, the height of the relief 24 is such that the cover 6 that rests thereon is substantially  
15 flush with the edge 22 of the body 2.

The relief 24 clearly constitutes a support for the cover 6 and its function becomes particularly significant at the moment when the consumer bites into the biscuit.

20 In fact, when the consumer bites into the biscuit, usually in its central area, the cover, in addition to being cut by the action of the teeth also undergoes bending stress and, as a result of its brittleness, tends to break into a number of parts, which then sink  
25 into the filling, above all when this is creamy as in the applications to which main reference is made herein.

This evidently entails a complete breaking up of the biscuit and hence the risk for the consumer of getting dirty already at the first bite.

Instead, the relief 24, which is substantially in the point where the consumer bites the biscuit, supports the cover during the bite, preventing the cover from breaking up into a number of parts and sinking into the  
5 filling.

Figure 3 illustrates a preferred process for the production of the filled biscuit described herein. The example illustrated starts from a condition where the body 2 and the cover 6 have already been produced, this  
10 for simplicity of description since the two parts made of biscuit can be produced according to any conventional process.

The process described herein envisages, in a station 102, a first step for dispensing the filling 4 on the  
15 body 2, the latter coming, for example, directly from the baking station of the line that has produced it. This step may be carried out by a conventional dispensing head that supplies in a substantially central position of the body 2 a preset amount of filling.

20 The body 2, together with the filling dispensed thereon, then goes on to a station 104 that is designed to spread the filling over all the cavity 2A of the body 2. For this purpose, the station 104 may be provided with vibrating means that impart on the body 2 a  
25 vibrational movement, for example in a vertical direction, a horizontal direction, or an orbital direction, or else combinations of these movements, such as to induce the filling, by the dynamic effect, to distribute substantially evenly over the entire cavity

2A.

At this point, the body 2 is sent on to a second dispensing station 106, which has the task of applying the second filling material 8.

5 As schematically represented in the figure, this station is preferably provided with a dispensing head that is able to dispense the material 8 along a preset path, in the plane of the layer of filling 4. This station may, for example, be provided with a spot-  
10 dispensing system, for applications in the foodstuff sector, of any type commercially available today.

Finally, the body 2 is sent on to a station 108, provided for example with a device of a pick-and-place type, in which the cover 6 coming from another line, is  
15 positioned on the body 2 in contact with the layer of filling 4 and with the filling material 8, as in the configuration illustrated in Figure 2.

Possibly, the process envisages cooling the biscuit formed so as to cause fast hardening of the material 8,  
20 in view of subsequent handling of the biscuit for packaging.

Clearly, the representation provided of the process of Figure 3 is altogether schematic, and the real process will envisage conveying lines designed to feed  
25 to the various stations more or less large lots of bodies 2 and covers 6.

In this connection, it should be noted that usually industrial lines for production of biscuits envisage simple conveyor belts on which the biscuits are rested,

as represented schematically in Figure 3.

Instead, the process described herein envisages, according to various preferred embodiments, that at least during the steps described above, the bodies 2  
5 will be housed, individually, within respective cells provided in moulds that are moved along the line of the plant. This prearrangement is typical of lines for production of chocolate products, whereas it is altogether new in the sector of production of biscuits.  
10 Alternatively, it is in any case also possible to envisage conveyance of the biscuits, free on a belt.

By way of example, Figure 5 illustrates a series of moulds 122 that carry the bodies 2 containing the filling 4 and that are moving through a dispensing  
15 station corresponding to the station 104 of Figure 2. The moulds 122 are moved via known means (not illustrated), for example via a chain movement system.

For obvious requirements of production, the dispensing head 128 is inevitably provided with a  
20 multiplicity of nozzles in order to carry out simultaneous dispensing on a number of bodies 2. The head 128 is controlled by a control unit 132 that moves it along a path corresponding to the one according to which the material 8 is to be applied on the body 2.

25 The cells 124 of the moulds perform the function of providing a reference for positioning of the bodies 2 on the biscuit-production line, and to keep them in the right position throughout the steps of the process, also during the treatment that the bodies 2 undergo in the

station 102.

In various preferred embodiments (as in the one illustrated (see Figures 5 and 6), the cells 124 are delimited by walls that are defined along the sides of a circumscribed theoretical polygon, a rhombus in the embodiment illustrated. As compared, for example, to a circular profile corresponding to the profile of the bodies 2, this configuration affords the advantage of making it possible to manage the variations in size between the individual bodies 2, due to the production tolerances, and at the same time to guarantee, in general, a more precise and centred positioning of the bodies 2 within the cells.

In the context of the process described herein, the precise and preset positioning of the bodies 2 constitutes an important characteristic in order to be able to provide high production volumes and, at the same time, guarantee a high quality. For instance, with reference to the step of dispensing of the material 8 of Figure 5, it is clear that any possible misalignment of the individual bodies 2 may entail that the ring of material is deposited partially outside one or more biscuits, this jeopardizing both the functions for which the material is designed and the aesthetic appearance of the product.

In the light of the foregoing, the cells 124 instead enable limitation of this misalignment, hence reducing production waste.

Of course, without prejudice to the principle of the

invention, the details of construction and the  
embodiments may vary, even significantly, with respect  
to what has been illustrated herein purely by way of  
non-limiting example, without thereby departing from the  
5 scope of the invention, as defined by the annexed  
claims.

### CLAIMS

1. A filled biscuit characterized in that it comprises:
- a biscuit body (2) shaped like a container, defining a cavity (2A) contained in which is a filling material (4);
  - a cover (6) made of biscuit designed to close said cavity (2A) from outside, either partially or completely; and
  - a second filling material (8), which is set in contact simultaneously with said cover (6), said container body (2), and said filling material (4), so as to seal said cover to said container body and withhold said first filling material within said cavity.
2. The biscuit according to Claim 1, wherein said second filling material (8) is provided along the mouth edge (22) of said container body (2) so as to close any passage of said first filling material between said cover (6) and said container body (2).
3. The biscuit according to Claim 1 or Claim 2, wherein the mouth edge (22) of said container body defines an opening that has a size larger than a corresponding size of said cover (6), thus creating between said cover and said container body a section (28) along which said second filling material is set.
4. The biscuit according to any one of the preceding claims, wherein the mouth edge of said container body (2) defines an opening larger than the overall dimensions in plan view of said cover (6), thus creating between said cover and said container body an annular

gap (28) along which said second filling material is set.

5. The biscuit according to any one of the preceding claims, wherein said second filling material (8) has a  
5 higher melting point than said first filling material (4).

6. The biscuit according to any one of the preceding claims, wherein said body (2) has a relief (24) that rises from the bottom of said body (2) for a height that  
10 allows it to set itself in contact with said cover (6) and support it, preferably said relief being positioned in an internal, substantially central, area of said body (2).

7. A process for producing a filled biscuit of the type  
15 having at least a biscuit body (2) and a filling material (4),

said process envisaging the steps of:

- providing a biscuit body (2) shaped like a container, defining a cavity (2A);
  - 20 - dispensing said filling material (4) into said cavity (2A);
  - providing a cover (6) made of biscuit;
  - setting said cover (6) on said container body (2) so as to close said cavity (2A), either partially or  
25 completely; and
  - dispensing a second filling material (8) before or after setting said cover (6) on said container body (2);
- wherein said second filling material (8) is set in contact simultaneously with said cover (6), said

container body (2), and said first filling material (4) so as to seal said cover (6) to said container body (2) and withhold said first filling material (4) within said cavity (2A).

5 8. The process according to Claim 7, wherein said steps are provided in different stations of a production line, said process envisaging feeding said container body along said line, housed within a cell (124) of a mould (122).

10 9. The process according to Claim 8, wherein said container body (2) has a circular contour, and said cell (124) of said mould is shaped so as to centre said container body with respect to a reference point.

10. The process according to Claim 9, wherein said cell  
15 (124) is delimited by walls that are set along the sides of a circumscribed theoretical polygon.

11. The process according to any one of the preceding claims, wherein said second filling material (8) is dispensed on said container body (2) along a preset  
20 path.

12. A plant for producing a plurality of filled biscuits via a process according to any one of Claims 6 to 10, comprising:

- a first station (102) for dispensing said first  
25 filling material (4);
- a second station (106) for dispensing said second filling material (8);
- a coupling station (108) for setting the covers (6) of said plurality of biscuits on the container

bodies (2) of said plurality of biscuits; and

- a conveyor line for feeding said container  
bodies through said stations, wherein said conveyor line  
includes a plurality of moulds (122) provided with cells  
5 shaped so as to centre said container bodies with  
respect to reference points of said line.

13. The plant according to Claim 12, wherein said cells  
(124) are delimited by walls that are defined along the  
sides of a circumscribed theoretical polygon.

10

FIG. 1

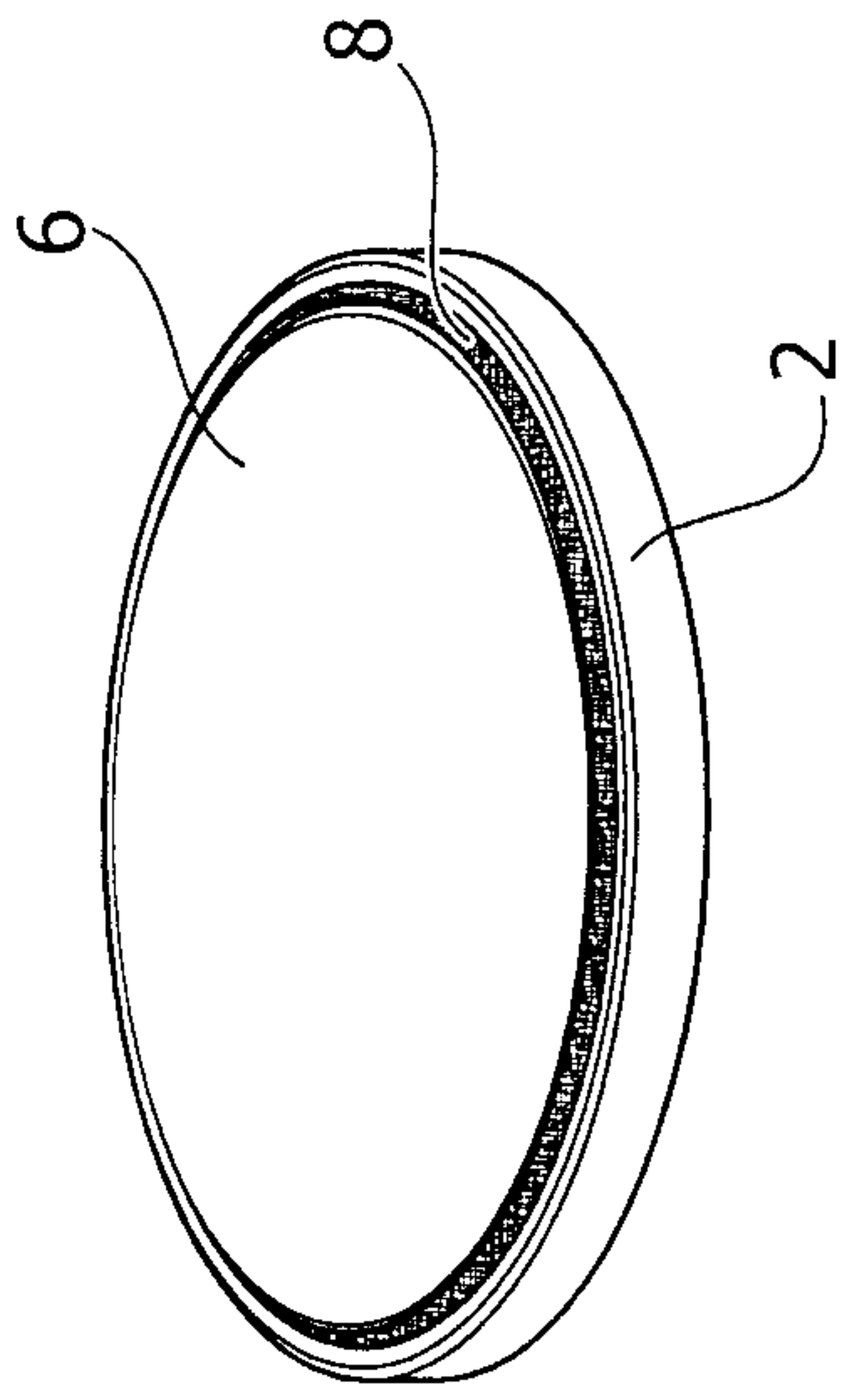
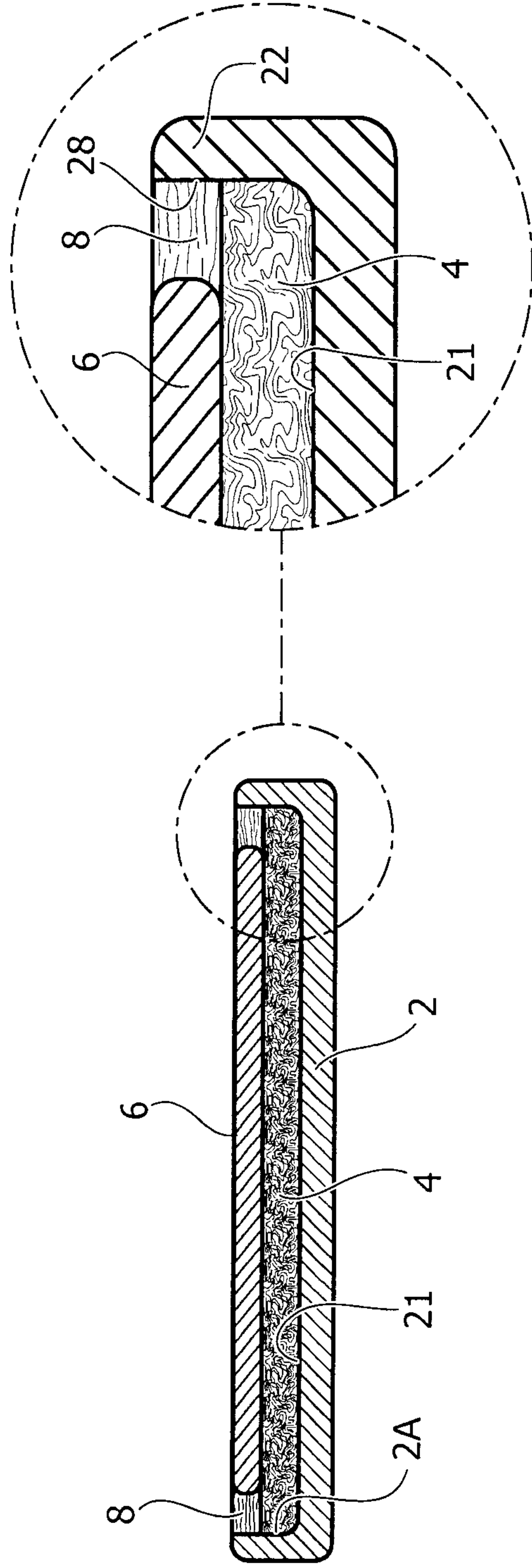


FIG. 2



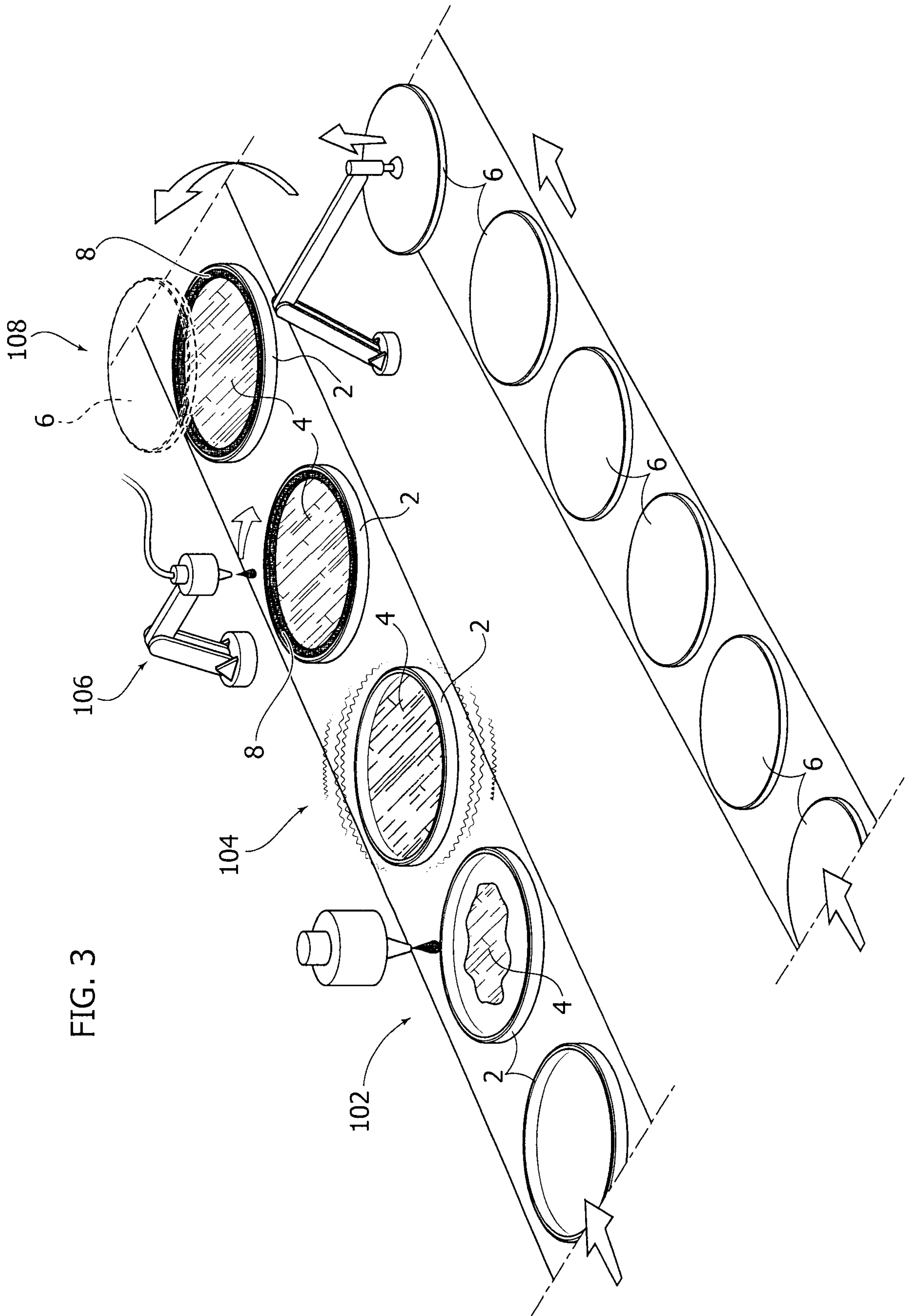


FIG. 3

FIG. 4

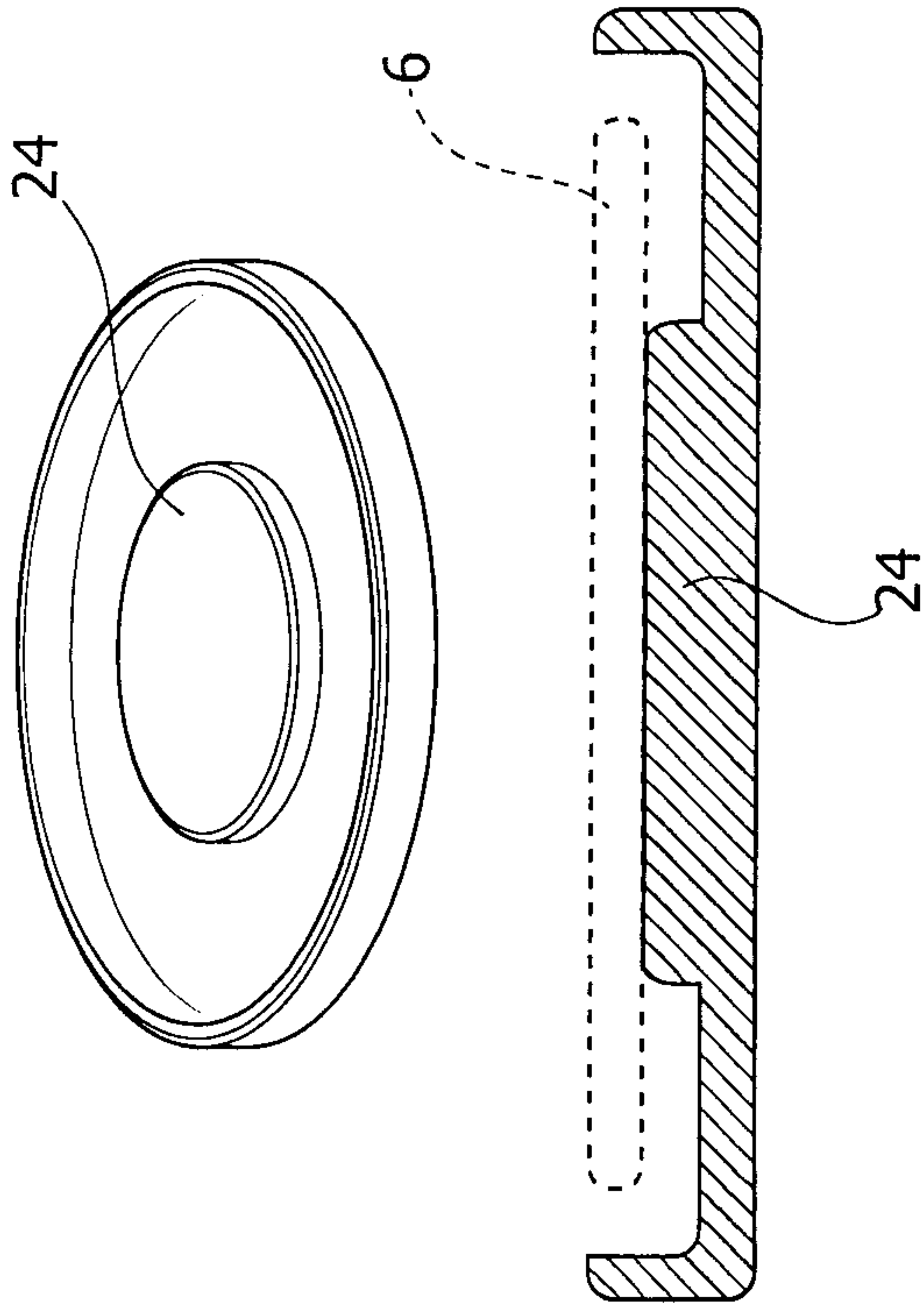


FIG. 7

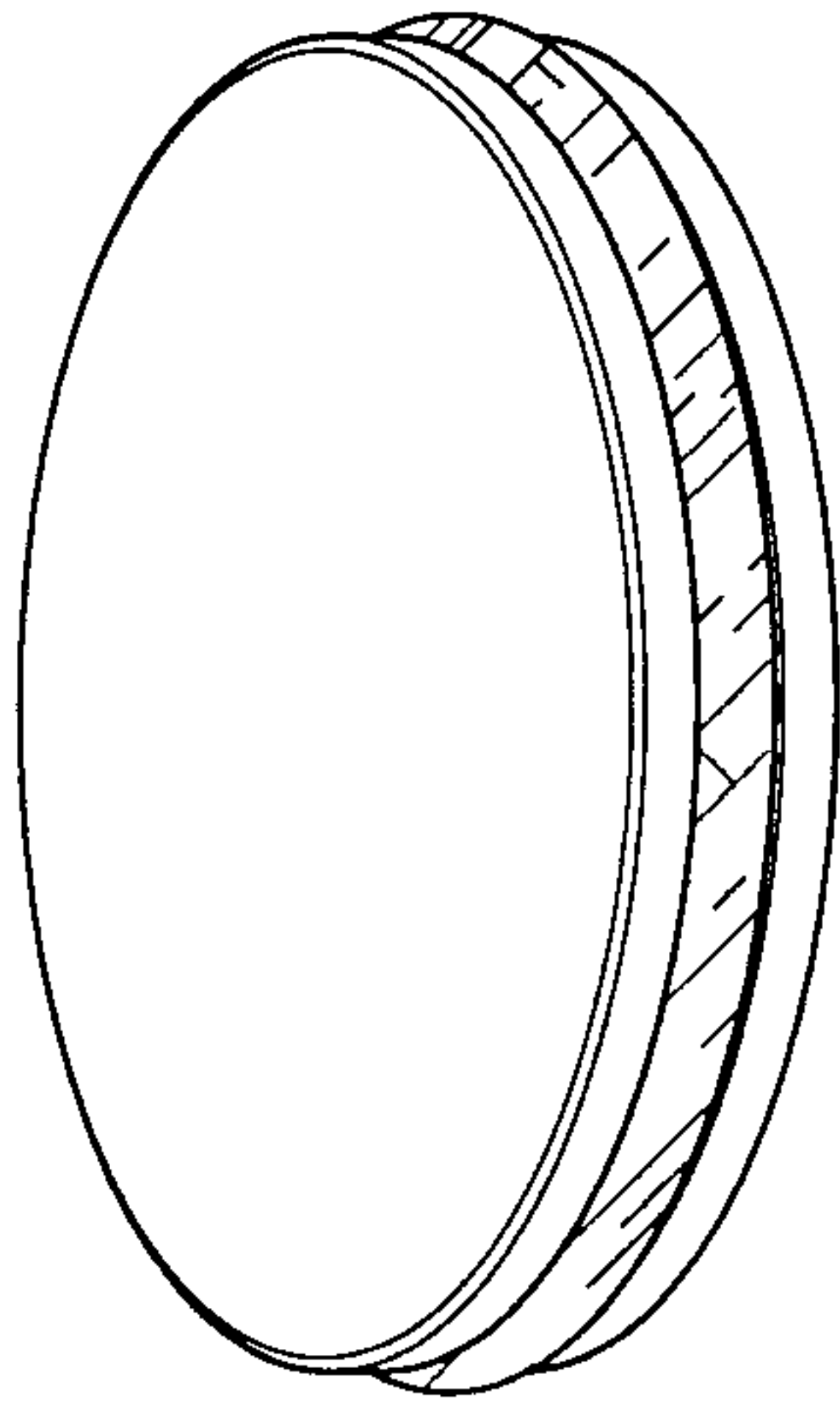


FIG. 6

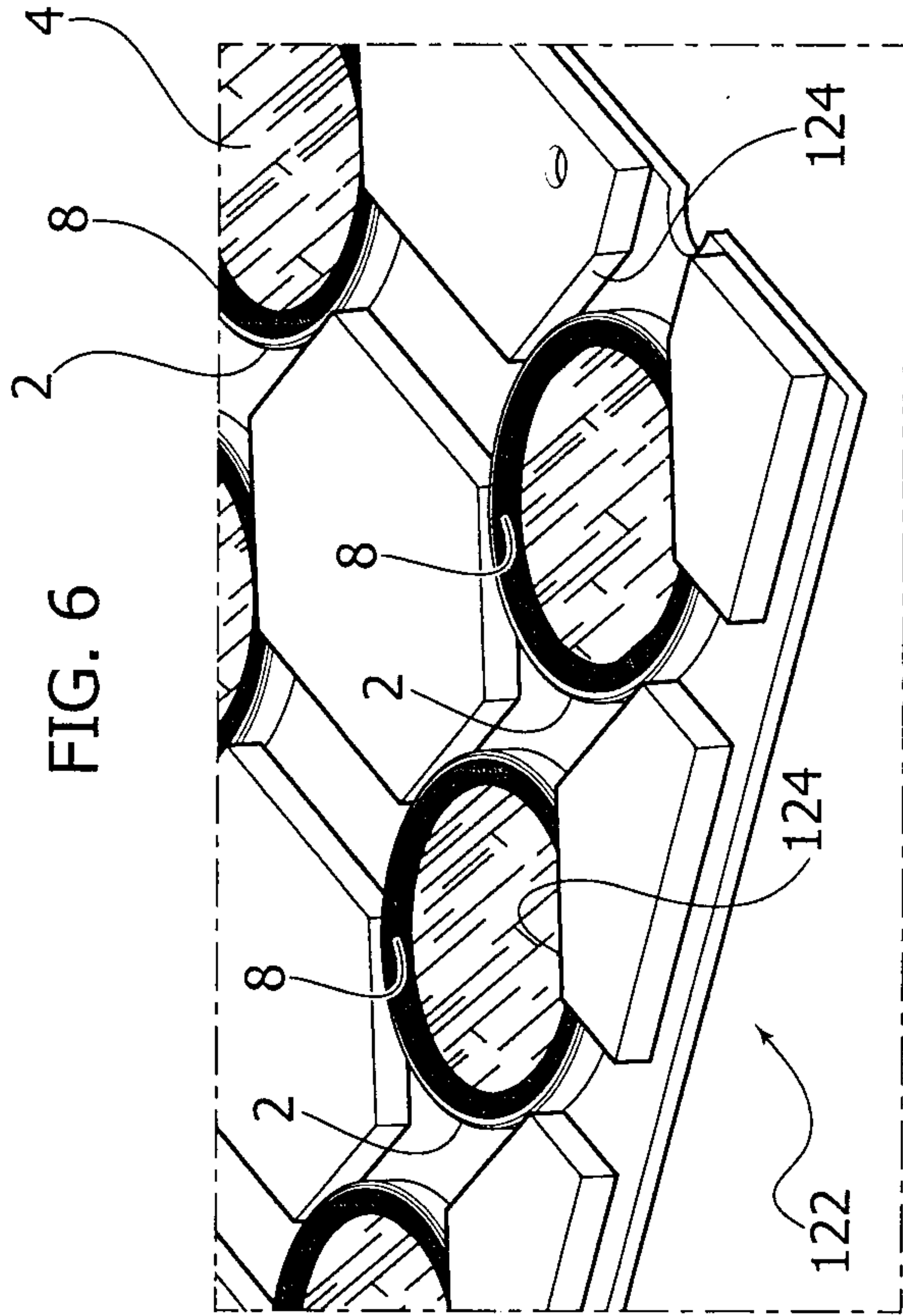


FIG. 5

