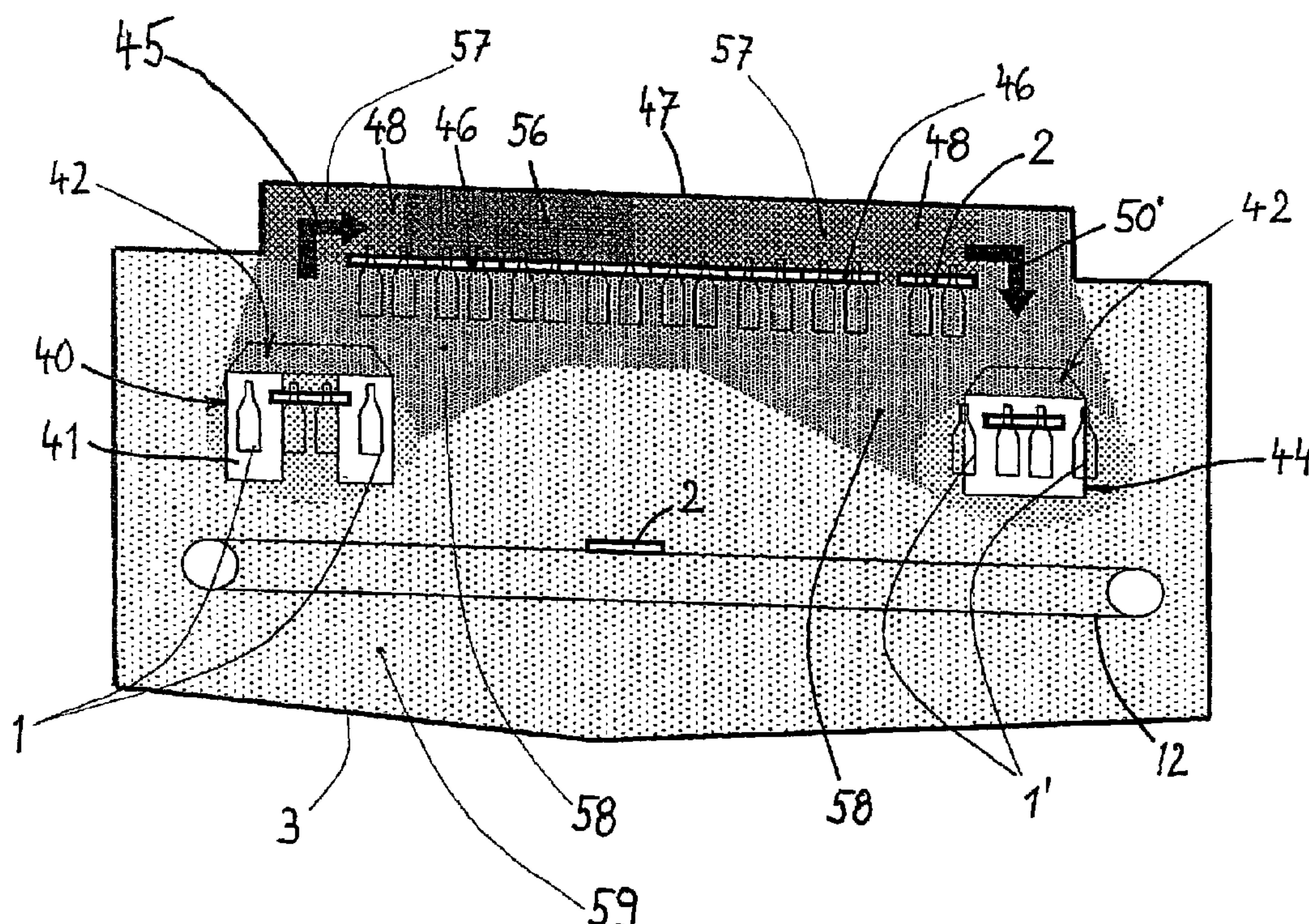




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(54) Title: DEVICE FOR FILLING BOTTLE-SHAPED PACKAGING IN STERILE CONDITIONS



(57) Abrégé/Abstract:

A device for sterile filling of bottle-shaped packages for fluid foodstuffs includes a conveyor circuit comprising a hygiene chamber; an upper intermittently driven conveyor to carry the package carriers in an adjacent relationship to present a predominantly closed field to an upper space in the chamber while passing through in a first direction of movement; a return conveyor having a second direction of movement substantially parallel, but in opposed direction, to the first direction of movement; unloading and loading conveyors operatively connecting the first and second conveyors; pressure means for forcing sterilizing medium through at least one inlet into the upper space; gas extraction means outside the hygiene chamber entrance and exit, comprising a dynamic lock through which the package carriers pass; and gap regions proximate ends of the first conveyor comprising an extraction path for the sterilizing medium. Efficiency of sterilization is increased while reducing contamination.



ABSTRACT

A device for sterile filling of bottle-shaped packages for fluid foodstuffs includes a conveyor circuit comprising a hygiene chamber; an upper intermittently driven conveyor to carry the package carriers in an adjacent relationship to present a predominantly closed field to an upper space in the chamber while passing through in a first direction of movement; a return conveyor having a second direction of movement substantially parallel, but in opposed direction, to the first direction of movement; unloading and loading conveyors operatively connecting the first and second conveyors; pressure means for forcing sterilizing medium through at least one inlet into the upper space; gas extraction means outside the hygiene chamber entrance and exit, comprising a dynamic lock through which the package carriers pass; and gap regions proximate ends of the first conveyor comprising an extraction path for the sterilizing medium. Efficiency of sterilization is increased while reducing contamination.

Device for the sterile filling of bottle-shaped packages

The invention relates to a device for the sterile filling of bottle-shaped packages with fluid foodstuffs, for example drinks, in which an intermittently driven conveyor in a line in the conveyance direction (first direction of movement), has package carriers arranged one behind the other that can be moved through processing stations, and is arranged in a hygiene chamber provided with openings for the packages to pass through at the entrance and exit, and with at least one inlet for sterilizing medium.

For the manufacture and in particular the completion of packages, in the case of known machines, the packages are held in work-piece carriers and, by means of continuously circulating conveyor belts, intermittently conveyed to individual processing stations, in which the respective package, for example after unfolding is completed, is filled and finally sealed. The conveyor belts run around two guide rollers, in which the work-piece carriers in their conveyor arcs are turned from a vertical alignment into a horizontal, and then again into a vertical alignment. The vertical alignment is that for the process level, because such conveyors are frequently used in the packaging of liquid foods which are filled from above into the package open at the top, standing underneath. In many conveyors the work-piece carriers are rigidly concatenated, for example via roller or link chains. If such conveyors are to be used in the foodstuffs sector, sterile packaging is often necessary, and in the case of roller or link chains, moving parts have to be lubricated, with the result that such conveyors cannot work in a hygienic clean room, where however the filling of the packages takes place.

In order to increase the mechanical output of packaging machinery, and in particular of fillers, i.e. in order to be able to process a larger number of packages per unit of time in a machine, along the process level several package carriers have been

arranged next to each other, which are therefore arranged at right angles to the first direction of movement. Insofar as continuous conveyors of such a kind can be used at all for multiplication in the width, the width of such a process level is however at least for static reasons subject to limits which do not allow a further increase in output.

Similarly to continuous conveyors, according to the invention the packages are also intermittently conveyed back in a first direction of movement (conveyance direction) in package carriers on a first process level in positions below various processing stations and on a second return level in a second direction of movement, parallel to the first direction of movement, forming a conveyance circuit.

Schematically, the conveyance circuit runs according to a loop or a rectangle when the conveyor is viewed from the side. There are open packaging systems without hygiene chambers with measures for sterilization of the filling product and the inside of the package, including the neck of the bottle in the case of bottle-like packages. There are also closed conveyance systems which have conveyors in a closed hygiene room.

In the known machines described above, with conveyor belts and work-piece carriers held on these, in which the respective package is conveyed under the processing stations, the work-piece carriers act as blades so that packages introduced from the germ-contaminated ambient air are conveyed onwards at least partially on the outside also with the germ-contaminated air in a clean room, or else germ-contaminated air outside and inside the package are conveyed under the sterilized processing stations. Therefore germs are disadvantageously conveyed from outside to positions where the air volume is actually meant to be sterile. This disadvantage has been partly recognized, and attempts have been made to remedy it, by immediately re-extracting the air which partially and possibly contains germs.

However, with this air is also extracted sterilizing medium which is later missing during sterilization. This could only be compensated for by adding very large streams of sterilizing medium.

5 A person skilled in the art therefore does not know how the entry of germ-contaminated air can be avoided with the known devices, and on the other hand how the growth conditions, in particular in closed systems with hygiene chambers, are to be reduced, so that for example germs introduced do not grow, or are spread less vigorously. A person skilled in the art would pump sterile air or a sterilizing medium
10 in the form of sterile air and sterilization agent, e.g. H_2O_2 into the hygiene room, and continuously maintain therein an excess pressure of this sterilizing medium vis-à-vis the environment. However this would have the disadvantage not only of consuming a very large amount of sterilizing medium and energy for the sterile air, but the environment would also be heavily charged with hydrogen peroxide, with all the
15 health risks.

The object of the invention is therefore to create a device of the type initially mentioned, in which the growth conditions for germs, bacteria and spores are reduced in a hygiene chamber and the preconditions for contamination already in the
20 hygiene chamber are reduced despite the use of small quantities of sterilization agent.

This object is achieved by means for the adjacent movement of the package carriers in the region of the upper side of the conveyor, such that the package carriers form a
25 predominantly closed field, which is arranged under formation of an upper space at a distance below the upper wall of the hygiene chamber, further through an inlet for the sterilizing medium produced in the upper wall of the hygiene chamber, means for the forcing of the sterilizing medium, under excess pressure, into the upper space of the hygiene chamber and moreover by means for the conveyance of the sterilizing

medium essentially parallel to the conveyance direction (first direction of movement) of the package carriers, gaps being provided at the ends of the closed carrier field, next to the end-surfaces of the hygiene chamber in order to guide the sterilizing medium out of the upper space and through the openings for packages to pass
5 through, formed as dynamic locks into gas extraction devices provided next to the latter and outside the hygiene chamber. The whole conveyance system according to the invention is therefore constructed such that one package carrier is in contact with the next, and several package carriers in the region of the upper surface of the conveyor form a complete surface or a field. This field represents a type of wall, even
10 if it has holes and gaps. This wall forms the lower partition of an "upper space" which lies between the upper wall of the hygiene chamber and precisely this closed field. This upper space above the closed field formed by the package carrier can even be open in front and behind at the field. Nevertheless, it is possible to imagine the upper space limited at the sides, above and below, in the upper region of the hygiene
15 chamber. If in the upper wall of the hygiene chamber, i.e. above the upper space, at least one inlet is produced for the sterilizing medium, then this upper space can be filled with sterilizing medium via the at least one inlet as desired. This is achieved particularly favourably by means, for example, impeller wheels, fans, pumps, for the forcing of the sterilizing medium, under excess pressure, into the upper space of the
20 hygiene chamber. If for example fresh or highly concentrated sterilizing medium enters the upper space of the hygiene chamber through the upper wall, then this stream of sterilizing medium can be directed and optionally also introduced at different speeds by means of different pressures. The package carriers can be constructed, or provided with additions constructed in such a way that they form
25 means for the guiding of the sterilizing medium essentially parallel to the conveyance direction (the first direction of movement) of the package carriers. This concept involves the streaming of the sterilizing medium, which is generally in gaseous or also mist form, in the conveyance direction of the package carriers and against this conveyance direction; in both cases parallel to the conveyor.

The upper space in the hygiene chamber is more or less closed and is open at its entry end as also at its exit end (in each case seen in the conveyance direction) of the closed carrier field. In particular the upper space next to the end-surfaces of the hygiene chamber is open in the region of the ends of the closed carrier field because of gaps. These gaps offer means for the guiding of the sterilizing medium out of the upper space into other regions within the hygiene chamber, in which the pressure is lower, for example where the sterilizing medium is extracted. To simplify the device according to the invention, the bottle-shaped packages to be filled enter the hygiene chamber from outside through openings in partitions of the hygiene chamber. It is especially favourable if these openings for packages to pass through are constructed as dynamic locks. These are not standard locks with separate spaces, in which different atmospheres can be produced charge-wise, and which are then opened to one or other side, rather the dynamic lock according to the invention is a space next to the openings for packages to pass through, where, due to the entry of the packages from outside together with partially germ-contaminated air, this germ-contaminated air is extracted, replaced by sterile air from the hygiene chamber, or mixed with the latter and also extracted. In the region around the packages delivered to the hygiene room, there is a space with relatively active gas exchange under continuous extraction of these cases, until after a minimum time the gases around the packages essentially have a concentration of sterilization medium, such as at least the spaces in the hygiene chamber with low concentration. During or after the exchange of the package content, i.e. the outflow of the still contaminated air and inflow of sterile gases, the packages leave the dynamic locks and then pass into spaces at a somewhat greater distance from the gas extraction devices. The gas extraction devices in the form of fans, impeller wheels, pumps or the like are provided next to the openings for packages to pass through and partially outside the hygiene chamber.

The advantage of these gas extractions is that, on the one hand, only a small quantity of sterile air is lost to the circuit, and on the other hand, these sterile gases do not simultaneously contaminate the ambient air. Advantageously, less sterilization agent is required, and nevertheless the growth conditions for germs are reduced throughout the hygiene chamber. The mentioned measures of the new device allow the entry of only small quantities of germ-contaminated air into the hygiene space. The inlets for the sterilizing medium in the upper wall of the hygiene chamber can be constructed and operated in such a way that a large quantity of sterile air with sterilization agent is blown in, but is simultaneously recovered by the gas extraction devices and retained in the circuit. The packages to be filled must be introduced into the hygiene chamber before filling, and guided out afterwards. In both cases the packages pass through their openings. Therefore, next to the openings for packages to pass through on the entry side and also on the exit side, there are provided the gas extraction devices, for example outlet-like, funnel-shaped suction lines into which the external air introduced with the packages is also partly extracted. After leaving the dynamic locks, only the volumes of the respective insides of the bottles represent carriers of contamination, as contaminated air has been extracted from outside. In the case of a well-functioning machine, the bottle-shaped package is in direct contact with the sterilization medium for approximately 24 seconds, resulting in a considerable reduction in the number of germs.

It is preferable for the bottle-shaped packages, hereafter shortened to "bottles", to be held with their opening towards the top, and transported in such a way that the open side of the bottle in each case faces the upper wall with the inlets for the sterilizing medium. The essentially gaseous sterilizing medium is then preferably blown into the bottles, so that the exchange of the germ-contaminated air from the inside of the bottle is already quickly completed, but at the latest in the region of the treatment stations, where sterilization medium is sprayed in and dried out. However, this process and the device according to the invention can also be used in the case of

closed bottles or other packages. The germ reduction is all the more intensive, the less a bottle has to be sterilized inside, if for example bottles are sterile inside due to the production process and are kept closed and are only sterilized from outside and then opened shortly before filling. It is expedient for the sterile air to be heated above
5 70°C and hydrogen peroxide (H_2O_2) in gaseous form to be sprayed in as sterilization agent at a temperature which lies slightly below the condensation temperature. In the upper wall of the hygiene chamber, along the closed field, a large number of inlets for the sterilizing medium are preferably arranged in rows one behind the other, wherein preferably, according to the invention, the inlet for the sterilizing medium has
10 a plurality of openings produced at a distance from one another in the upper wall of the hygiene chamber. If these openings, in the case of a further version of the invention, are connected to valve-controlled delivery lines, then one or other opening can be closed or opened further by the valves in the individual delivery lines, in order to achieve a specific flow pattern of the sterilizing medium in the hygiene chamber
15 and to change this. The many openings in the upper wall of the hygiene chamber can be arranged more or less spread out. The concentration of the openings can preferably be greatest in the region after the spraying-in of the sterilizing medium (preferably in gaseous form) and during the first drying. Then the sterilizing medium can be introduced there at the maximum temperature and then blown further in or
20 against the conveyance direction.

In the device according to the invention, the whole space in the hygiene chamber can be made sterile from the start of operation, so that the basic load of the air in the hygiene chamber with respect to germs is already reduced. Using the measures
25 according to the invention, it is possible to continue keeping the atmosphere in the hygiene chamber sterile, with only little use of material. Sterilizing medium is introduced continuously or in a controlled manner through the inlets in the upper wall of the hygiene chamber, while more or less sterile air, and also germ-contaminated air is extracted simultaneously at the inlets and outlets for the packages and

optionally also through other openings. Scarcely one contaminating layer with many germs will therefore remain or form on the surface of the respective package. In the dynamic lock a kind of pre-sterilization of the bottle is carried out by the extracted air flows. Contaminated air from the inside of the bottle also preferably still enters the
5 region of the dynamic locks at the extraction points and advantageously cannot get into other more critical regions, in particular into the filling region.

Defined flow conditions and flow directions of the sterile air can be achieved using the measures according to the invention. The risk of recontamination of a treated
10 bottle or package is considerably reduced.

With simple means, the air can be subjected to a specific flow pattern. By arranging the closed field of the package carriers in the upper region of the hygiene chamber, a relatively shallow upper space can be formed, with the consequence that the sterile
15 air/the sterilizing medium primarily flows to the two open ends of the closed field and from there from the "process level" downwards into the main space of the hygiene chamber. As sterilization agent is preferably only conveyed from above, the concentration of sterilization agent in the sterile air in the hygiene chamber diminishes downwards. A volume of highest concentration can be produced above
20 the process level in the upper space, and of high concentration at the ends of the closed field of the package carrier, and further downwards, of average/low concentration of sterilization agent.

The package carriers can preferably have the form of pallets which can also be
25 called carrier pallets. The conveyor creates a movement of the package carriers along a closed route, which can have the form either of a loop or the form of a rectangle or other quadrangle. This closed, mechanical carrier circuit continuously passes through the different regions of concentration within the hygiene chamber.

According to the invention, it is expedient for processing stations in the upper space of the hygiene chamber to be arranged below its upper wall. The row of processing stations arranged behind one another in the conveyance direction is located at the height of the "first process level", the conveyor also essentially running horizontally at this process level, as also in the second return level arranged under it. Vertically operating second and fourth lifting conveyors are connected in between. Each conveyor preferably has a separate drive. In a further version of the invention, a further third loading level is located horizontally between the upper first process level and the lower second return level. All three levels are arranged substantially horizontally.

In an advantageous version of the invention, each package carrier has a substantially flat construction and is held above the conveyance circuit in a substantially horizontal position. In the region of the third, middle loading level, means for loading and unloading the packages into and/or out of the package carriers are provided in a loading direction, which is parallel to the first direction of movement (the conveyance direction) of the packages.

If a simplified conveyor configuration is imagined with the already mentioned rectangular conveyance route and a clock-wise movement, then the package carriers are moved in the first process level (for example starting on the left), from left to right by the first conveyor, at the end lowered vertically by the second lifting conveyor downwards into the second return level, there returned horizontally to the left by the third conveyor, so that the fourth lifting conveyor then lifts the package carriers vertically back into the starting position, upwards into the first process level.

The compact construction of the conveyor experiences no restriction at all if the middle, third loading level is provided between the upper first process level and the lower second return level. By arranging this loading level, however, the output of the

conveyor can be considerably increased, in that the loading and unloading can be carried out surprisingly rapidly. The loading and unloading means can remove completed packages from the package carriers with considerable acceleration over a short distance, and on the other hand push empty packages into the package
5 carriers at the loading position. This can be carried out simultaneously for a plurality of packages, providing that the package carriers can hold several packages.

Again looking at the simple conveyor configuration with the upper space above the closed field of the package carriers and the main space of the hygiene chamber
10 situated below it, it is then expedient for the dynamic lock to be arranged under the inlet and outlet end of the closed field of the package carriers both for the introduction of the bottle-shaped packages (bottles) and for their removal. If the packages for example run from the left at the entrance end to the right where they are removed at the exit end, then the dynamic lock for the supply of packages is
15 arranged approximately in the middle between the upper level of the closed field of the package carriers and the return conveyor below. At the exit end, its behaviour corresponds to that of the dynamic removal lock. In both cases, it is thereby possible to convey a bottle carrier vertically directly from the loading level into the upper process level and from there to transfer it into the horizontal conveyor, which
20 intermittently advances the respective package carrier in the conveyance direction one step at a time. At the end of the process level, the closed packages are still in the package carrier, which however is removed from the process level and lowered into the loading level, where it is received and held in the dynamic removal lock. There, in a similar manner as with filling and supplying similar unloading means, in
25 each case a row of packages are unloaded simultaneously from the package carrier. The empty package carrier can then be vertically lowered onto the lower return level, so that there it can be moved to the left under the dynamic supply lock. From there, the package carrier is lifted into the supply lock.

It is favourable if the package carrier, on two diametrically opposite sides, has U-shaped recesses that are open outwards and are aligned in the first direction of movement of the first conveyor. A vertical axis can be imagined in the centre of a U. If a further U, inversely aligned, is arranged at a distance below this U, such that both central axes fall on one line, this gives the above-described alignment of the two recesses. In addition, the invention subsequently gives the teaching that this central line of the two U-shaped recesses arranged opposite to one another is parallel to the first direction of movement. The alignment of these recesses has a particularly favourable effect in the third loading level during loading and unloading. During unloading, the one package is pushed or pulled out of the recess which is open towards the outside in the conveyance direction, this direction of movement being for example the same as the first direction of movement. The other opposite package is then moved out in the opposite direction. Both these operations take place simultaneously and require only a little time. The other advantage of the two recesses is that the package carrier in this way doubles its capacity. A person skilled in the art knows that the width of a machine and also of a conveyor cannot be increased at will, because strength conditions place a limit on the widening of a package carrier. By arranging two recesses which are aligned with one another, it is possible to hold, transport, load and unload two packages instead of one on this track.

According to the invention, it is also favourable for the package carrier to have the form of an elongated strip extending at right angles to the first direction of movement, such that the recesses lie next to each other in pairs. Apart from the above-mentioned doubling of capacity of a package carrier from one to two packages, the extension of capacity in the transverse direction is possible to a certain extent as allowed by the strength conditions. For this purpose, the package carrier can be constructed in strip or rod form, and the recesses arranged next to each other in pairs. The loading and unloading devices which operate in the third loading level can

then simultaneously move all the packages, arranged next to each in a strip, outwards or inwards. The capacity of such a conveyor is considerably increased as a result.

- 5 According to the invention, it is also advantageous if the package carrier for holding the bottles is a strip-shaped sheet with pairs of U-shaped recesses facing away from each other, arranged next to each other at right angles to the first direction of movement, the width of the U-shaped recesses corresponding to the external diameter of the neck of the bottle. A favourable field of use of the conveyor according
- 10 to this invention is the receiving, holding and transport of bottles open at the top, preferably made from plastic. The width of the respective U-shaped recess then corresponds approximately to the external diameter of the relevant neck of a bottle. It is self-evident that it is only necessary to push a bottle from outside into the base of the U, in order to provide a good hold for the bottle there. Conversely, unloading is
- 15 just as favourable. The production of such a package carrier is economical and technically surprisingly simple. A correspondingly constructed sheet or a strip with double walls and stiffening rails can be produced simply and, apart from cleaning, requires no maintenance whatsoever. Such a package carrier can be inserted into the devices described above and be transported via the different conveyor routes.
- 20 Carriers, connecting pieces and rails attached to these can be provided at the narrow ends of a preferred strip-shaped sheet, so that the package carriers are moved along the first process level and also along the second return level with simple means and preferably sliding on bearing rails.
- 25 According to the invention, it is particularly advantageous if means are provided for the feeding of sterile, gaseous nitrogen into the respective package during filling of almost the whole volume of the package with nitrogen, preferably before filling of the package with the product (liquid food). It is favourable if the nitrogen is introduced at approximately 20°C. This nitrogen has a germ-reducing effect or is germ-free,

especially if nitrogen gas is fed through a sterile filter, and rinses the respective packaging, whose volume will be almost completely filled with nitrogen, three times with the volume of the package. It has been shown that in the case of filling with fruit juices, the storage time can be considerably increased using this measure. Due to
5 the above measures, the liquid nitrogen which is non-sterile when it leaves the factory does not need to be sterilized with heat beforehand.

During the introduction of nitrogen into the whole volume of the package before filling with liquid food, liquid nitrogen can, however, also be introduced into the head space
10 above the food filling the package. The nitrogen then boils and gives the head space in the bottle a slight excess pressure, which can sometimes be desirable.

As a treatment station, there are the stations for preheating, sterilizing, for example spraying, and optionally repeated drying, filling and sealing. Considerable variation
15 can be used here, for example by installing several preheating stations, by providing several drying stations, or else by providing processing stations to feed aromatics or to feed orange pieces, if fruit juices are being packaged. All these variations and changes in the number and type of processing stations in the upper space of the hygiene chamber have no influence on the remaining measures of sterilizing and
20 keeping sterile.

As a sterilizing medium, according to the invention sterile air and a sterilization agent, for example hydrogen peroxide, are preferably used as a mixture. In order to make the air sterile, it is pre-filtered and then heated to a temperature above 380°C.
25 This sterile air can preferably be introduced via approximately 70 to 90% of the inlet openings for the sterilizing medium in the upper wall of the hygiene chamber. The sterilization agent is introduced through the remaining inlets. The latter preferably takes place in the front region (with respect to the conveyance direction) of the upper space after the pre-heating of the bottle-shaped packages conveyed. The bottles can

be held by the package carriers in such a way that only the necks of the bottles, and the openings in the case of bottles open at the top, project above the closed field of the package carriers into the upper space. After preheating of the bottles held in this way, the sterilization agent plus sterile air is supplied for example at the first spraying
5 station or the first sterilizing station, whilst subsequently only sterile air is again introduced through the inlets in the upper wall of the hygiene chamber.

The openings for extracting the more or less strongly sterile gases are located in a partition of the hygiene chamber. The gas extraction devices extend like roof-shaped
10 funnels above tunnel-like spaces, which are in each case filled by a row of bottles to be treated or bottles already treated. From these spaces in the dynamic lock, the packages are then simultaneously pushed into the package carriers in the described manner. This takes place in a very short time over a very short route, with the result that the loading of the package carrier takes place quickly and without problems. The
15 same also applies to the removal tunnels, although fewer germs are extracted there with the gases surrounding the bottles.

A further advantage of the U-shaped recesses in the package carrier with the widths matched to the necks of the bottles is that bottle bodies of a different format are
20 received and can be transported by the same package carrier, provided that only the external measurements of the neck of the bottle are identical. In the case of many bottles of a different format, the neck measurements are standardized and have a solid structure.

25 In contrast to the state of the art, the package carriers according to the invention are not rigidly concatenated with one another, so that they can be flexibly staggered. For example, almost all the package carriers can be conveyed into the first process level, and the device cleaned at the other partial conveyor, or almost all the package carriers can be conveyed into the second return level, in order to clean the individual

processing stations from all sides. Sections of the whole conveyor according to the invention can therefore be run empty. Due to the practical and simple holding of the package carriers on the bearing rails, it is possible to exchange these in a very short
5 time and with very simple tools. This may possibly be necessary, for example during the exchange of bottles or formats.

In a preferred embodiment, the loading of the package carriers on both sides from the front and from the rear allows the packages on both sides to be loaded rapidly
10 and in a space-saving manner.

In accordance with a first aspect of the present invention, there is provided a device for sterile filling of bottle-shaped packages for fluid foodstuffs, having a plurality of conveyors together comprising a conveyor circuit, constructed and arranged to carry
15 package carriers, the conveyor circuit comprising

- (i) a hygiene chamber having an entrance and an exit, and an upper wall comprising at least one sterilizing medium inlet and defining an upper space;
- (ii) an upper intermittently driven conveyor having a first conveyor access end and a first conveyor discharge end, and constructed and arranged to carry and retain a
20 plurality of the package carriers in an adjacent relationship such that upper surfaces of the package carriers together with openings in packages carried therein present a predominantly closed field to the upper space while passing through the hygiene chamber at a process level in a first direction of movement;
- (iii) a return conveyor having a second conveyor access end and a second conveyor
25 discharge end and a second direction of movement substantially parallel, but in opposed direction, to the first direction of movement;
- (iv) an unloading conveyor operatively adjacent to the first conveyor discharge end and the second conveyor access end, and a loading conveyor operatively adjacent to the second discharge end and the first conveyor access end;
- 30 (v) pressure means for selectively forcing a sterilizing medium through the sterilizing medium inlet into the upper space;

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- (vi) a first and a second gas extraction means respectively provided outside the hygiene chamber entrance and exit and each comprising a dynamic lock constructed and arranged for the package carriers to pass therethrough; and
- 5 (vii) a first and second gap region respectively proximate each of the first conveyor access end and the first conveyor discharge end, each gap region comprising an extraction path for the sterilizing medium from the hygiene chamber.

10 Further advantages features and possible uses of the present invention are made clear with reference to the following description of preferred versions in conjunction with the attached drawings. There are shown in:

- Figure 1 a schematic drawing of the whole conveyance circuit for the sterile filling of bottles, representing three levels and four conveyors,
- 15 Figure 2 an isometric overall view of the conveyor,
- Figure 3 a similar schematic view of the device according to the invention for the sterile filling of bottles, in which here the conveyance circuit is largely omitted and only reproduced schematically simplified, however with representation of the hygiene chamber, the upper space and the
- 20 gas streams represented by means of arrows,
- Figure 4 a similar view to Figure 3 wherein, instead of the stream arrows, the various spaces in the hygiene chamber, in which different concentrations of sterilization agent are formed, are represented by shades of grey, and
- 25 Figure 5 an isometric oblique top view of the package carrier with plastic bottles inserted as packages.

In the versions shown here, the packages designated 1 are plastic bottles, and the bottle-shaped packages 1 in the following description of the preferred versions are designated "bottle". The bottles sit in package carriers 2. Under a frame, which at the same time also forms the upper limitation of a hygiene chamber 3, various processing stations, 4, 5, 6 are installed from left to right, for example blast nozzles for preheating, then spray nozzles in the case of the spraying-in of a sterilizing mixture as sterilizing medium, then various drying stations, a cutting station, a filling station 6 and the sealing station 5, by means of which the filled bottles are sealed. In a preferred version which packages liquid food, this sealing can be carried out for example by sealing with a plastic-coated aluminium film. It is recognized that both the processing stations 4 and 6 are formed double, i.e. two rows of bottles are always processed simultaneously, for example filled in the filling station 6, whereas the sealing station 5 with the relatively expensive sealing tools is formed only singly/in one row.

The row of package carriers 2 under the processing stations 4 to 6 is located in the first process level 7, in which the package carriers 2 and with it the bottles 1 are moved in the first direction of movement represented in Figure 1 by the arrow 8, i.e. from left to right in Figure 1.

When the bottles 1 have reached the right-hand outlet end in the first process level 7, i.e. they are filled and sealed, the package carrier concerned is changed over to the second vertically-operating lifting conveyor, generally designated 9 (Figure 2). In this, the package carrier 2 is lowered corresponding to the arrows 10 and 10' (vertical second direction of movement downwards), initially in the second direction of movement 10 as far as a third loading level 11 and then in the second direction of movement 10' to the lowest position, where the package carrier 2 is moved by means of the horizontally operating third conveyor 12 (Figures 2 and 4) in the second return level 13. This movement is shown by the arrows 14 pointing towards

the left in Figure 1, which indicate a third direction of movement, which runs in the direction opposite to the first direction of movement, but parallel to the latter. If the package carrier 2 after completing the second return level 13 has arrived at the end of the conveyor at the bottom left, it is changed over onto the fourth lifting conveyor 5 15 (Figure 3), which operates vertically upwards in the direction of the arrows 16 and 16', which is the fourth direction of movement. This vertical lifting of the fourth lifting conveyor 15 takes place in two steps. The first step is represented by the lower arrow 16 and reaches as far as the third loading level 11, after which the second half of the fourth direction of movement 16' is connected, until the package carrier 2 has 10 arrived on the level of the first process level 7 and is there changed over, in order to begin the intermittent movement in the first direction of movement 8.

According to Figures 1 and 2, there is therefore a conveyance circuit which is rectangular seen from the side, with a horizontal first direction of movement 8, to 15 which the vertical second direction of movement 10 and 10' is connected to the right-hand outlet end, with the third direction of movement 14 from the right-hand lower end, to the left-hand lower end, and from there in the fourth direction of movement 16, 16' upwards back to the first process level 7.

20 Furthermore, Figure 1 shows three broken lines running parallel to each other, which represent the first process level 7, the second return level 13 and the third loading level 11. Above/below the second lifting conveyor 9 and also above/below the fourth lifting conveyor 15 there are superjacent ends 17/18 and 20/21. 17 is the upper end between the first conveyor 19 operating horizontally and operating along the first 25 direction of movement in the first process level 7, and the second lifting conveyor 9. The lower end 18 is the end of the second lifting conveyor 9 and the beginning of the third conveyor 12, which operates horizontally in the third direction of movement 14. The latter ends in the lower end 20 of the fourth lifting conveyor 15. The fourth lifting

conveyor 15 operating vertically and upwards finally returns the package carrier 2 to the first process level 7, at the upper end 21 of the fourth lifting conveyor.

Corresponding to the directions of movement there are also the four conveyors driven separately from each other, namely the first conveyor 19 running horizontally, the second lifting conveyor running vertically, the third conveyor 12 running horizontally, and the fourth lifting conveyor 15, also operating vertically.

The first conveyor 19 has the front end 21 and the rear end 17. The front end 21 lies above the lower end 20 of the fourth lifting conveyor 15, whilst the end 17 of the first conveyor 19 lies above the lower end 18 of the second lifting conveyor 15. Clearly the ends 17 and 18 on the one hand and 21 and 20 on the other hand lie one above the other. The first conveyor 19 has a motor 22 as a separate drive. Both the lifting conveyor 9 and the lifting conveyor 15 each have a separate motor, which in Figure 2 is attached to the rear conveyor in each case and cannot therefore be seen. Its torque is transmitted via the drive shafts 23. The horizontally operating third conveyor 12 in the second return level 13 is also driven via a separate motor which, in Figure 2, can be envisaged at the left-hand lower and rear end, and is therefore not represented. Its torque is transmitted via the drive shaft 24 to the horizontal conveyor lines 12.

Not only does the third loading level 11 run parallel to the first process level 7, but also the loading directions represented by the arrows 25, 25' and 26, 26'. The means for loading and unloading are not represented in the drawings. However, slides attached to rods oscillating backwards and forwards can easily be imagined, with which a whole row of bottles is moved simultaneously to unload in the directions 25 to the right and left, and to load in direction 26 from the right and from the left into the centre.

During the operation of the conveyor, the movement of the package carrier 2 runs approximately according to the representation in Figures 1 and 2, in such a way that most of the package carriers 2 are situated in the first process level 7 and only one or two package carriers are situated for example in the return section. The motor 22 (Figure 2) drives, via a gear unit 27 from the centre outwards to both sides, a shaft 28 in each case, so that on each side a backward and forward oscillating movement of a carriage 31 is produced via an oscillating lever 29 and a connecting rod 30, in order to move a push rod 32 on each side in the first direction of movement 8 and, conversely, in the opposite direction of movement. This provides the intermittent movement of the individual package carriers 2 one stroke-length at a time, in particular during the movement from one processing station 4 to the next etc. as far as the filling station 6. From there on, a two-step movement to the sealing station 5 takes place, as will be described below.

Figure 3 shows the hygiene chamber 3, in the lower region of which the third conveyor 12 is situated. This moves a package carrier 2 straight to the left, below the bottle feed device generally designated 40. This consists of two tunnel-shaped spaces 41 arranged at a distance from one another, in which bottle-shaped packages 1 are shown. These bottles have been introduced straight through openings for packages to pass through that are not represented, in the direction opposite to the observer's direction of view of Figure 3, into the hygiene chamber 3. The package carrier arranged between the two tunnel-like spaces 41 must first be imagined empty. Only after the bottles have been pushed into the package carrier 2 from the right and left sides by rake-like pushing devices out of holding strips which are not represented, are the bottles also held on the package carrier 2, as represented in Figure 3. Then however, the bottles 1 in the tunnel-like spaces 41 would have to be imagined as taken out. The gas extraction devices are generally designated 42. They are situated above the tunnel-like spaces 41 and extend in the observer's direction of view of Figure 3, from the front to the rear, to the rear wall

designated 43 of the hygiene chamber 3. In this wall 43 are correspondingly constructed and dimensioned holes, through which the gases can be extracted into the space behind the hygiene chamber 3 and out of same.

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A similar construction is also situated below the downstream end of the upper process level 7, namely on the side opposite the bottle feed device 40. Here the bottle removal device is generally designated 44. Similarly to the bottle feed device 40, it consists of tunnel-like spaces, in which here the sterile-filled and sealed bottles
10 1' are situated. Above this, a gas extraction device 42 is again fitted.

The lifting devices not represented in Figures 3 and 4 move the package carriers 2 from below to above/from above to below, resulting, in both figures, in the line represented above of moveable package carriers 2 arranged one behind the other
15 and adjacent to each other. The L-shaped black arrow represented at the top left (Fig. 4), which points to the right, shows the movement track 45 of the package carrier 2, which is just being changed over from the lifting conveyor into the process level 7. The line of adjacent package carriers 2 results in the predominantly closed field 46 of package carriers 2. Between this and the upper wall 47, arranged at a
20 distance and parallel to this, of the hygiene chamber 3, is situated the "upper space" 48. This extends from the inlet end by the arrow 45 to the outlet end at the other L-shaped arrow 50', which points downwards and shows how the last package carrier 2 is moved downwards into the middle, loading level.

25 In Figure 3, in the upper wall 47 of the hygiene chamber 3, a plurality of openings as inlets 50 for sterilizing medium are to be imagined. The many white arrows show the entry of sterile air from a source 51 of sterile air. The two dark arrows signify the supply of sterilization agent from a source 52. Both the sterilization agent from the source 52 and the sterile air from the source 51, i.e. in total the (mixed) sterilizing
30 medium flows into the upper space 48 of the hygiene chamber 3 (in Figure 3,

vertically from top to bottom) and is turned around through the predominantly closed field 46 of the package carriers 2, so that it flows substantially parallel to the conveyance direction (first direction of movement 8) of the package carriers 2. This flow of the sterilizing medium is represented in Figure 3 by the horizontal arrows 53 and the bent arrows 54 shown at the ends of the closed field 46. Smaller quantities of sterilizing medium also pass through the holes and gaps in the package carriers 2, i.e. through the closed field 46, and are shown in the form of the lower arrows 55 as the flow of the sterilizing medium. It can be seen how the sterilizing medium, after leaving the upper space 48, is gradually drawn to the gas extraction devices 42.

Through the flows of the sterilizing medium described and represented in Figure 3, which is mixed with sterilization agent, for example H_2O_2 , different areas are produced with varying concentrations of sterilization agent in the sterilizing medium, as shown in Figure 4. The inside of the hygiene chamber 3 is filled throughout with sterilizing medium, in which the concentration of sterilization agent however varies. Directly next to the inlet 50 for sterilizing medium, through which sterilization agent enters from the source 52 (two dark arrows), a region 56 develops of the highest concentration of sterilization agent within the sterilizing medium in the upper space 48. Downstream and upstream of this region 56, due to the inflow of sterile air through the plurality of openings from the source 51 of sterile air, regions 57 develop of high concentration of the sterilization agent in the sterilizing medium. Next to and below the closed field 46 of the package carriers 2, a region 58 consequently develops of average concentration of the sterilization agent in the sterilizing medium. In the remaining parts of the hygiene chamber 3, the region 59 develops of low concentration of the sterilization agent in the sterilizing medium. The different regions 56 - 59 are characterized by shades of grey in Figure 4 of varying intensity.

In the bottle feed device 40 and in the bottle removal device 44, the white fields in the tunnel-like spaces 41 show the absence of sterilization agent (areas of minimum concentration).

5 In the preferred version represented here, each package carrier 2 has the form of an elongated strip extending at right angles to the first direction of movement 8, and the form of a sheet. From the front side 33 (Figure 5) of the package carrier 2 extend U-shaped recesses 35 that are open outwards towards this side 33. Also, from the diametrically opposite rear side 34 of the package carrier 2 extend – however in the
10 opposite direction to the recesses on the front side 33 – a row of recesses 35 that are open towards the rear. As the packages 1 here are bottles with a neck 36 arranged at their opening, the width B (Figure 5) is matched to the external diameter D (Figure 5), so that the bottle with its neck 36, which for example has an external thread, can be introduced into the recess 35 and held there. This hold is independent
15 of the design of the bottle in the lower region, be it long, round, angular, short, large or small. The second lifting conveyor 9 and the fourth lifting conveyor 15 operate with vertically driven slides 37 (Fig. 2), which engage on both sides with the respective package carriers 2 and lower these from the first process level 7 into the second return level 13 (lifting conveyor 9) or vice versa (lifting conveyor 15). The third,
20 horizontally operating conveyor 12 operates with a continuous belt 38 on which pockets 39 are fitted, into which the package carriers 2 are vertically pushed.

On each push rod 32, feed cams 49 are attached at distances a (Figure 2) radially projecting at a specific angle from the push rod 32. This distance “a” is equal to the
25 average distance between two package carriers 2 moved adjacent to each other. As a result, the push rods 32 can be driven oscillating via locking grooves that are not described in more detail.

During the operation of the new filling device, the bottles 1 are introduced through the rear wall 43 of the hygiene chamber 3 opposite to the observer's direction of view of Figures 3 and 4 on a holding rail, on which as many bottles 1 hang as can then be introduced into the package carrier 2 (Figure 5). Due to the shape of the entrance
5 openings matched to the bottle contour in the rear wall 43 to the bottle feed device 40, most of the contaminated ambient air is already retained, but a certain proportion still flows into the tunnel-like space 41 and is there removed via the gas extraction device 42. Also the volume inside the bottle is subject to extraction and is gradually removed and replaced by the gases from the hygiene chamber 3. After the loading of
10 the package carrier 2, the outer tunnel-like spaces 41 are empty, so that the package carrier 2 can be conveyed through the space which is empty towards the top, from the loading level 11 upwards into the first process level 7, where it is changed over according to the movement track 45 (black arrow, Figure 4) onto the horizontal conveyor. Here the package carrier 2 connects to the existing line of package
15 carriers, resulting in the closed field 46 of the package carriers 2, as shown in Figures 1 to 4. The bottle openings have in the meantime been moved through the region 58 of average concentration into the region 56 of high concentration and now move in their first direction of movement 8 (from left to right in Figures 1 to 4) under the openings of the inlet 50 for sterilizing medium. In the sterilization region, and
20 subsequently the drying region, the bottles arrive in the region 56 of highest concentration and, after drying of the sprayed-in sterilization agent, are to be regarded as germ-free and sterile. They are then conveyed for further processes, such as for example filling and sealing, onwards to the right into a region 57 of high concentration and arrive at the downstream end of the closed field 46 to be
25 transferred into the lifting conveyor, according to the right-hand, L-shaped black arrow 50' in Figure 4.

The package carrier 2 with the treated, sterile-filled and sealed bottles 1 is conveyed downwards into the third loading level 11. Pushing devices are situated there, which

are similar to those in the region of the bottle feed device 40, which however here, in the bottle removal device 44, remove the treated bottles from the bottle carrier or package carrier 2 sideways outwards into the position 1'. From there the bottles 1' thus transferred can be guided, in the observer's direction of view of Figures 3 and 4, out of the hygiene chamber and transferred to other conveyor belts.

List of reference numbers:

	1	Package, bottle
	2	Package carrier
	3	Hygiene chamber
5	4,5,6	Processing stations
	5	Sealing station
	6	Filling station
	7	First process level
	8	First direction of movement (conveyance direction)
10	9	Second lifting conveyor
	10,10'	Second direction of movement
	11	Third loading level
	12	Third conveyor
	13	Second return level
15	14	Third direction of movement
	15	Fourth lifting conveyor
	16,16'	Fourth direction of movement
	17	Upper end of the second lifting conveyor 9
	18	Lower end of the second lifting conveyor 9
20	19	First conveyor
	20	Lower end of the fourth lifting conveyor 15
	21	Upper end of the fourth lifting conveyor 15
	22	Motor, drive
	23,24	Drive shafts
25	25,25'	Loading direction (unloading)
	26,26'	Loading direction (loading)
	27	Gears
	28	Shaft
	29	Oscillating lever
30	30	Connecting rod
	31	Carriage
	32	Push rod
	33	Front side of the package carrier
	34	Rear side of the package carrier
35	35	Recess
	36	Neck of a bottle
	37	Carriage
	38	Continuous belt
	39	Pocket
40	40	Bottle feed device

	41	Tunnel-shaped space
	42	Gas extraction device
	43	Rear wall of the hygiene chamber 3
	44	Bottle removal device
5	45	Movement direction of the package carrier 2
	46	Closed field of the package carriers 2
	47	Upper wall of the hygiene chamber 3
	48	Upper space
	49	Feed cam
10	50	Inlet for sterilizing medium
	50'	Right arrow for movement track of the package carriers 2
	51	Source of sterile air
	52	Source of sterilization agent
	53	Flow of the sterilizing medium (horizontal, straight arrows)
15	54	Flow of the sterilizing medium (bent arrows)
	55	Flow of the sterilizing medium (lower arrows)
	56	Region of highest concentration of sterilization agent in the sterilizing medium
	57	Region of high concentration of sterilization agent in the sterilizing medium
20	58	Region of average concentration of sterilization agent in the sterilizing medium
	59	Region of low concentration of sterilization agent in the sterilizing medium
	a	Distance between feed cams
	B	Width of recesses 35
25	D	External diameter of the neck of the bottle

We Claim:

1. A device for sterile filling of bottle-shaped packages for fluid foodstuffs, having a plurality of conveyors together comprising a conveyor circuit, constructed and arranged to carry package carriers, the conveyor circuit comprising
 - (i) a hygiene chamber having an entrance and an exit, and an upper wall comprising at least one sterilizing medium inlet and defining an upper space;
 - (ii) an upper intermittently driven conveyor having a first conveyor access end and a first conveyor discharge end, and constructed and arranged to carry and retain a plurality of the package carriers in an adjacent relationship such that upper surfaces of the package carriers together with openings in packages carried therein present a predominantly closed field to the upper space while passing through the hygiene chamber at a process level in a first direction of movement;
 - (iii) a return conveyor having a second conveyor access end and a second conveyor discharge end and a second direction of movement substantially parallel, but in opposed direction, to the first direction of movement;
 - (iv) an unloading conveyor operatively adjacent to the first conveyor discharge end and the second conveyor access end, and a loading conveyor operatively adjacent to the second discharge end and the first conveyor access end;
 - (v) pressure means for selectively forcing a sterilizing medium through the sterilizing medium inlet into the upper space;
 - (vi) a first and a second gas extraction means respectively provided outside the hygiene chamber entrance and exit and each comprising a dynamic lock constructed and arranged for the package carriers to pass therethrough; and
 - (vii) a first and second gap region respectively proximate each of the first conveyor access end and the first conveyor discharge end, each gap region comprising an extraction path for the sterilizing medium from the hygiene chamber.
2. A device according to Claim 1, wherein the unloading and loading conveyors together operatively providing a loading level parallel to, and spaced apart from, the process level.

3. A device according to Claim 2, wherein the first direction of movement is substantially horizontal, and the return conveyor is operatively located substantially vertically below the upper intermittently driven conveyor.

5 4. A device according to any one of Claims 1, 2 or 3, wherein the sterilizing medium inlet comprises a plurality of spaced-apart openings in the upper wall.

5. A device according to Claim 4, wherein the openings are operatively connected to valve-controlled delivery lines.

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6. A device according to any one of Claims 1 to 5, wherein a plurality of processing stations is provided within the upper space.

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7. A device according to any one of Claims 1 to 6, wherein the upper surfaces of the package carriers are substantially planar.

8. A device according to Claim 7, wherein each package carrier has a leading edge and a trailing edge, and U-shaped package receiving recesses are provided in each of the leading edge and trailing edge.

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9. A device according to Claim 8, wherein each package carrier is substantially rectilinear and the U-shaped package receiving recesses are arranged as opposed pairs.

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10. A device according to Claim 9, wherein the recesses each have a width dimensioned to provide an interference fit for a neck of a bottle.

11. A device according to any one of Claims 1 to 10, further comprising means for feeding sterile gaseous nitrogen into the packages.

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12. A device according to Claim 11, wherein the packages are filled with sterile gaseous nitrogen which is retained therein until substantially replaced by a selected fluid foodstuff.

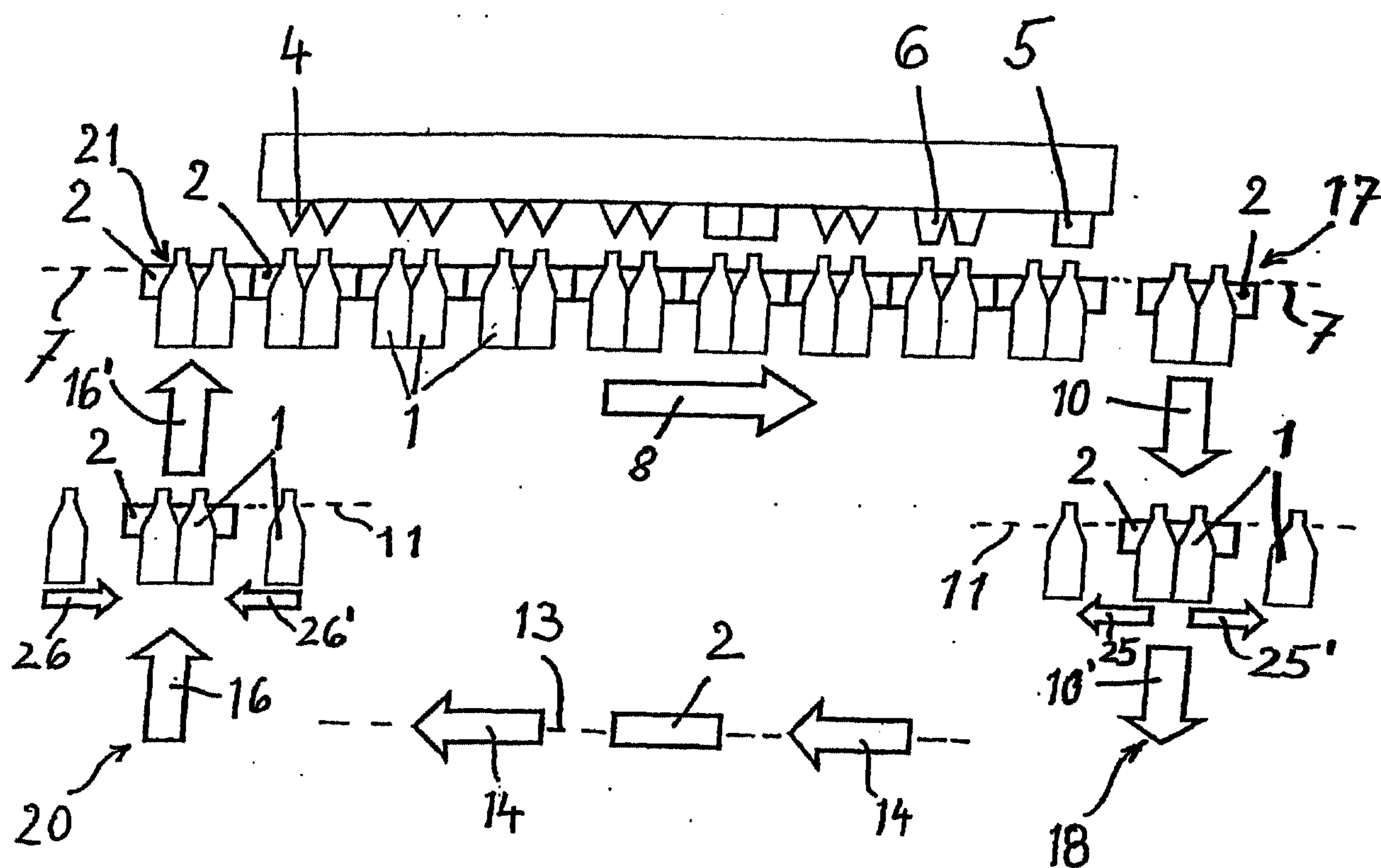


Fig. 1

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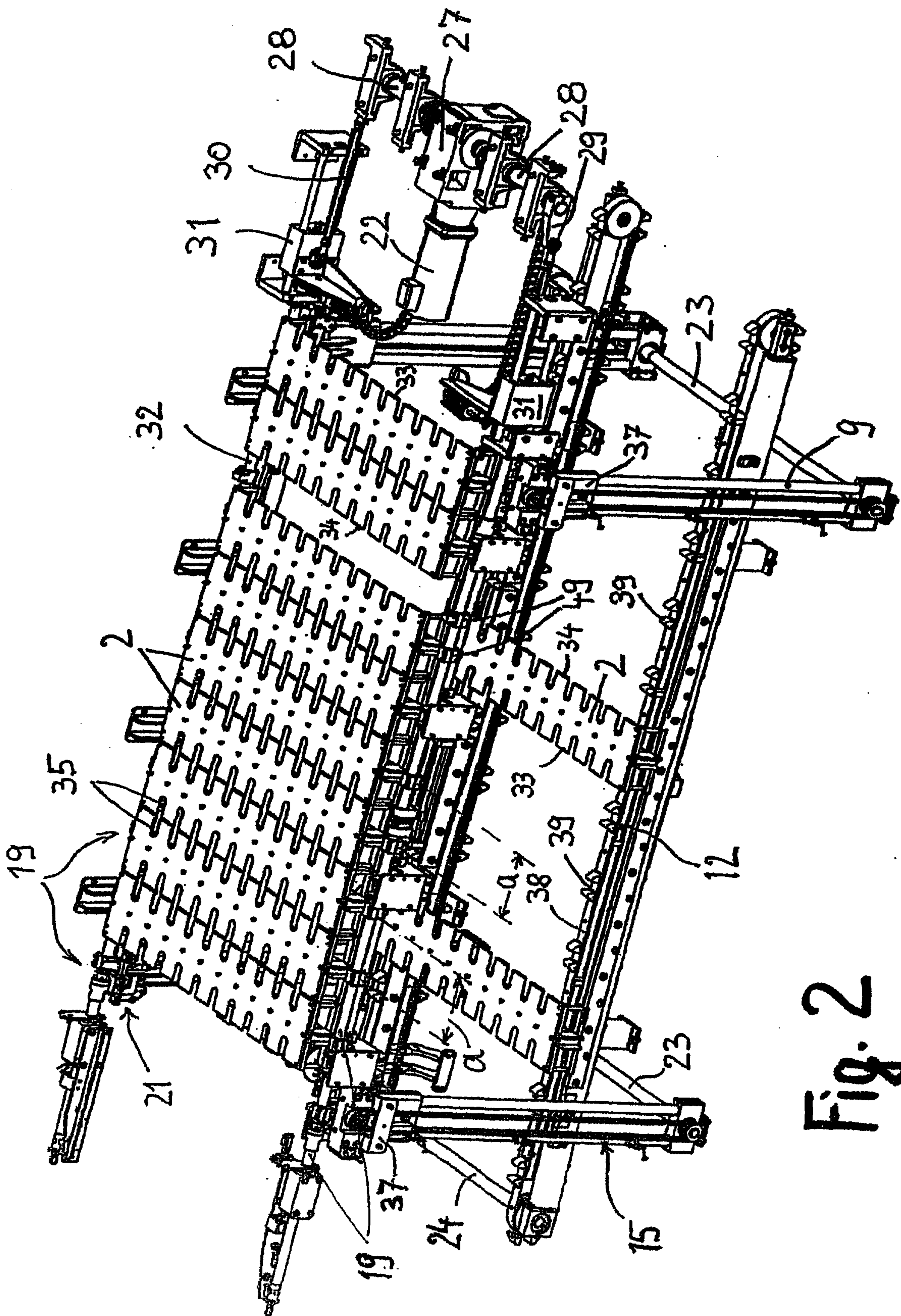


Fig. 2

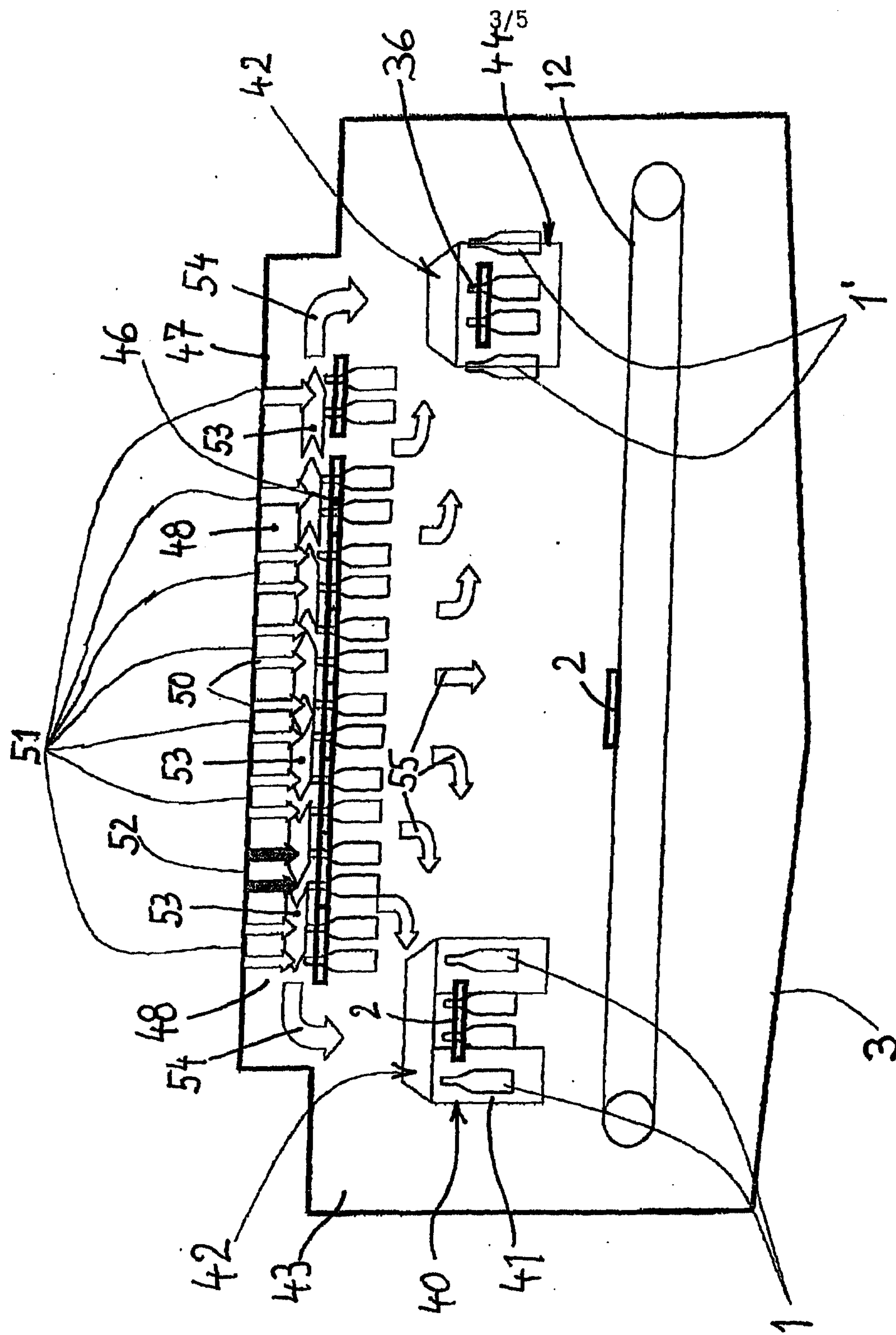


Fig. 3

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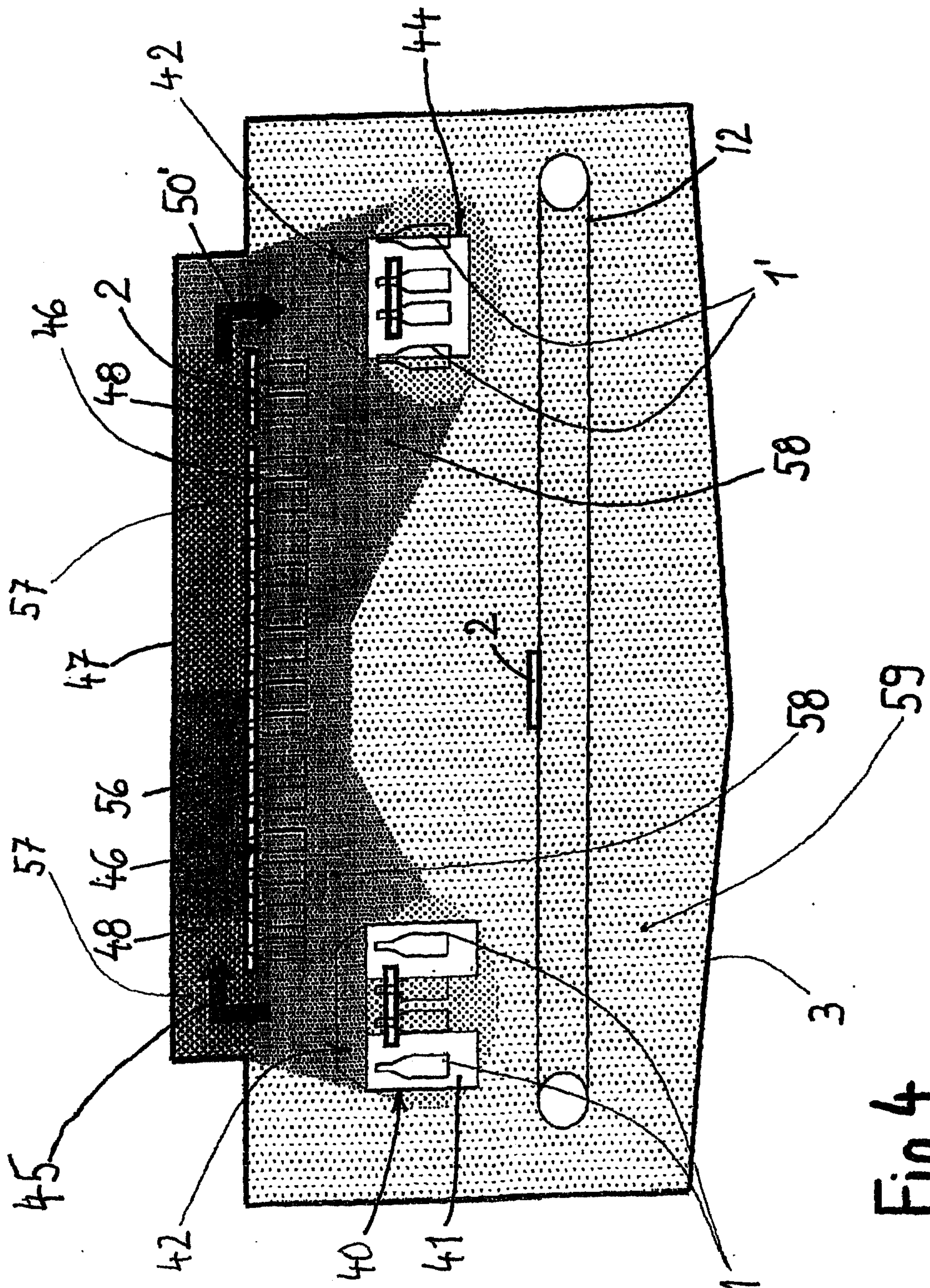


Fig. 4

