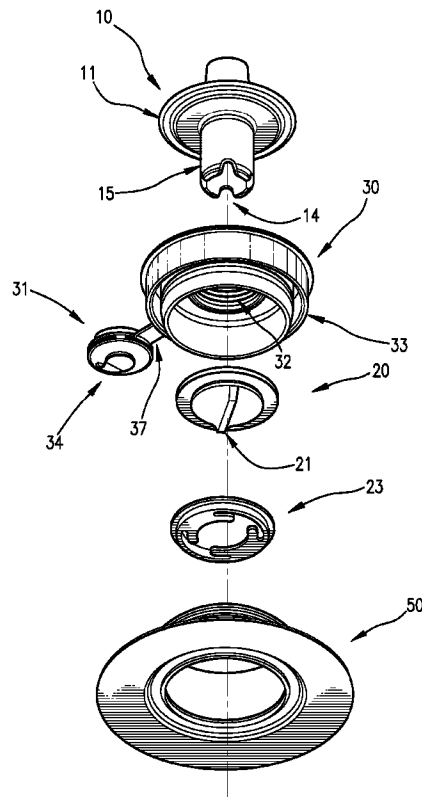




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(54) **Titre :** CLOISON A CAPUCHON-PRESSION A BEC DE CANARD ASEPTIQUE POUR UN RECIPIENT PLIABLE
(54) **Titre:** ASEPTIC DUCKBILL FLIP-CAP FITMENT FOR A COLLAPSIBLE CONTAINER



(57) **Abstrégé/Abstract:**

Disclosed herein is a fitment for use with a collapsible bag for dispensing liquids or semi-solids comprising a spout having a generally cylindrical body attached to a collapsible bag, an aseptic flip-cap attached to the spout having positioned therein a flexible cap duckbill that allows for the flow of fluid when engaged with a probe assembly, wherein said duckbill flip-cap fitment forms an aseptic seal with the spout on the collapsible bag.

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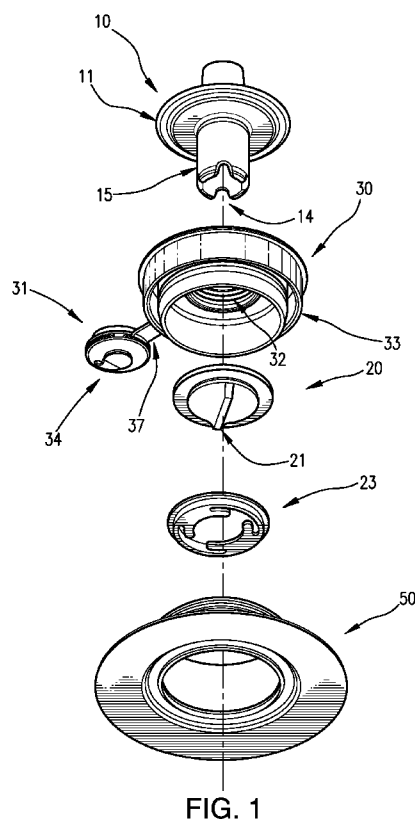
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(54) Title: ASEPTIC DUCKBILL FLIP-CAP FITMENT FOR A COLLAPSIBLE CONTAINER



(57) Abstract: Disclosed herein is a fitment for use with a collapsible bag for dispensing liquids or semi-solids comprising a spout having a generally cylindrical body attached to a collapsible bag, an aseptic flip-cap attached to the spout having positioned therein a flexible cap duckbill that allows for the flow of fluid when engaged with a probe assembly, wherein said duckbill flip-cap fitment forms an aseptic seal with the spout on the collapsible bag.

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TITLE**Aseptic Duckbill Flip-Cap Fitment for a Collapsible Container****CROSS REFERENCE TO RELATED APPLICATION**

- 5 This application claims the benefit of United States Provisional Application No. 61/528,508 filed August 29, 2011.

FIELD OF THE INVENTION

- 10 The present disclosure relates to a fitment and its use with a collapsible container for dispensing liquids or semi-solids from said container. More particularly, the present disclosure relates to a fitment comprising a duckbill flip-cap for use on a collapsible container to dispense liquids and semi-solids from the container, wherein said duckbill flip-cap fitment forms an aseptic seal with the spout on said collapsible container.

15 **BACKGROUND**

- Many systems dispense liquids or semi-solids from a disposable package consisting of a flexible collapsible bag in a corrugated box. Such a package is commonly referred to as a bag-in-box dispensing package. Generally, these systems include a bag that is provided with a fitment in the form of a spout through which filling and dispensing occur. It is generally desirable to provide a quick-disconnect coupling between the spout and the service line of the pump or other type of beverage mixing and dispensing system.
- 20

- However, these closures often employ complicated sealing structures to provide an adequate seal to prevent a product spill. In the past, elastomeric check-valves and O-ring seals have been employed. Furthermore, because the assembly requires multiple parts, it renders these closure valves non-cost-effective.
- 25

- Typically, these fluid couplings use connections such as an insert, and/or cap, connected with a fluid source, such as a bag or bag-in-box. The insert is coupled with a connector or coupler body that can access a fluid dispensing system such as a fluid line. Many connectors employ a piercing member at one end to puncture a membrane seal disposed on the insert when the connector is mated with the insert for fluid dispensing. Further, such connectors used to mate with the insert on the fluid source are produced so as to be reusable.
- 30

In addition, the industry needs coupling valve assemblies that can be reused with various connections. The present invention addresses this need and provides a non-disposable coupling-valve assembly that can be utilized with various fluid conduit adaptors.

- 5 Commercial and industrial applications routinely employ disposable containers to transport and dispense a variety of liquids or fluids such as food products, cleaning solutions and detergents. Some containers are constructed of semi-rigid plastic while others are constructed of flexible plastic and are often supported within a protective box.
- Commonly, such containers are equipped with valve structures that facilitate dispensing fluids
10 to or from the containers. The valve structures are preferably designed to quickly couple with exterior coupling members.

The female coupling includes a releasable locking or quick-connecting/disconnecting mechanism for locking the male and female couplings together in a coupled state. U.S. Pat. No.
15 4,436,125 discloses a quick-connect/disconnect coupling assembly. A female coupling member includes a poppet valve assembly that automatically shuts off the fluid passageway in the female coupling member when the female coupling member is not interconnected to the male coupling member.

20 **SUMMARY OF THE INVENTION**

One aspect of the present invention is fitment for use on a collapsible bag for dispensing of liquids and semi-solids from the bag, the fitment comprising:

- (a) a spout comprising a generally hollow cylindrical body having an external surface capable of mating with an aseptic flip-cap, the spout having at one end, a base portion for
25 securing the spout to the collapsible bag;
- (b) an aseptic flip-cap having an outer collar and an inner collar with the outer collar and the inner collar each having an inner and outer surface, the inner surface of the outer collar and the outer surface of the inner collar forming a cavity adapted to be removably
30 attachable to the spout, the inner surface of the inner collar being capable of attaching to a cap duckbill, the aseptic flip-cap further comprising a hollow cylinder section comprising a proximal end and a distal end with each having an inner and outer surface, the cylinder section being fixedly attached at its distal end to the inner collar, the inner surface of the inner collar and the outer surface of the proximal end of the cylinder

forming a cavity, the aseptic flip-cap optionally comprising a flange fixedly attached to the outer surface of the outer collar;

wherein the outer surface of said inner collar comprises at least one sealing ring;

5

(c) a slidably removable probe; and

(d) a substantially hollow cap duckbill adapted to mate with the proximal end of the aseptic flip-cap and which forms a seal within the fitment that can be unsealed by insertion of the probe into the fitment through the hollow cylinder of the aseptic flip-cap, the cap duckbill having a tapered end and an ejection end, the tapered end having a reversibly sealable slit capable of preventing fluid flow through the aseptic flip-cap upon removal of the probe from the fitment.

10

15 This invention also relates to a process for filling an unfilled collapsible bag for dispensing of liquids and semi-solids from said collapsible bag, comprising a fitment as recited above, comprising:

(a) introducing said unfilled collapsible bag into a filling chamber under aseptic conditions;

20 (b) dismounting said fitment from said spout on said unfilled collapsible bag under aseptic conditions;

(c) filling said unfilled collapsible bag with material for dispensation;

25 (d) re-mounting said fitment on said spout; and

(e) closing the aseptic flip-cap.

Other objects and advantages will become apparent to those skilled in the art upon reference to the detailed description that hereinafter follows.

30

BRIEF DESCRIPTION OF THE FIGURES

FIG. 1 is a bottom view of an exploded assembly of the fitment.

FIG. 2 is a top view of an exploded assembly of the fitment.

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FIG. 3 is a side view of an exploded assembly of the fitment.

FIG. 4 is a cross sectional view of the assembly of the fitment taken at line A – A of FIG. 3.

5

FIG. 5 is a cross sectional view of the aseptic flip-cap fitment.

FIG. 6 is a perspective of the cross sectional view of the aseptic flip-cap fitment mounted on the spout.

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FIG. 7 is a magnified view of the sealing rings and inner collar in cross section view of the aseptic flip-cap fitment.

FIG. 8 is a magnified view of a cross section of the aseptic flip-cap showing sealing rings on the outside wall of the aseptic flip-cap.

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FIG. 9 is a magnified view of a cross section of the aseptic flip-cap having sealing rings mounted on the spout.

FIG. 10 is a magnified view of a cross section of the aseptic flip-cap not having sealing rings thereon.

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FIG. 11 is a magnified view of a cross section of the aseptic flip-cap not having sealing rings thereon mounted on a spout having sealing rings on the inner wall of the spout.

25

DETAILED DESCRIPTION OF THE INVENTION

When an amount, concentration, or other value or parameter is given as either a range, preferred range, or a list of upper preferable values and lower preferable values, this is to be understood as specifically disclosing all ranges formed from any pair of any upper range limit or preferred value and any lower range limit or preferred value, regardless of whether ranges are separately disclosed. Where a range of numerical values is recited herein, unless otherwise stated, the range is intended to include the endpoints thereof, and all integers and fractions

30

within the range. It is not intended that the scope of the invention be limited to the specific values recited when defining a range.

Definitions

5 In the context of this disclosure, a number of terms shall be utilized.

As used herein, the term “about” or “approximately” means within 20%, preferably within 10%, and more preferably within 5% of a given value or range.

10 The term “comprising” is intended to include embodiments encompassed by the terms “consisting essentially of” and “consisting of”. Similarly, the term “consisting essentially of” is intended to include embodiments encompassed by the term “consisting of.”

Fitment

15 The aseptic fitment of the present invention is attached to a liquid container, which usually is a flexible bag of a plastic material or a semi-rigid container, also of a plastic material, that holds liquids or semi-solids that are to be dispensed. The fitment can be tailored to the size of the bag or container so that a desired level of flow can be achieved. A wide variety of liquids or semi-solids can be dispensed using the fitment, such as liquid foods, for example, coffee, soda, milk,
20 cooking oil, or liquid chemicals of various types, such as, detergents, cleaning liquids, hand soap, pastes, glue.

FIG. 1 shows an exploded bottom view of the fitment assembly of this invention. A probe **10** is fitted into an aseptic flip-cap **30** having a flip lid **31** with a pull tab **34**. Cap duckbill **20** is
25 positioned in the bottom of the aseptic flip-cap **30**. A duckbill lock ring **23** is positioned between the cap duckbill **20** and the spout **50**. Upon engagement of the cap duckbill **20** with the duckbill lock ring **23** and the spout **50**, the duckbill lock ring **23** locks into aseptic flip-cap **30** and holds the duckbill product flow opening **21** in the cap duckbill **20**, closed, and prevents seepage or leakage of liquid that is to be dispensed from the bag or container (not shown) to
30 which spout **50** is attached. Extended periods of holding the liquid container at cold temperatures can cause distortion of the cap duckbill **20** thereby allowing liquid to seep through the flow opening **21**. The use of the duckbill locking ring **23** generally prevents such seepage. The present invention, however, provides an additional mechanism to seal the collapsible

container (not shown), that is, providing an aseptic flip-cap **30** that engages the spout **50** in such fashion that the seal between the fitment and the spout **50** is aseptic.

Probe **10** through which material from the bag or container is dispensed, typically is a molded thermoplastic material usually a polyolefin, such as, polyethylene, copolymers and terpolymers of polyethylene, polypropylene, copolymers and terpolymers of polypropylene, polybutylene and copolymers and terpolymers thereof, fluorocarbon polymers and copolymers thereof, polyvinyl chloride and copolymers thereof, polyvinylidene chloride and fluorocarbon polymers and copolymers thereof. Thermosetting polymers such as epoxy resins, phenolic resins, melamine resins can also be used for dispersing some substances. Preferably, polyethylene, polypropylene and copolymers and terpolymers thereof are used for most applications.

FIG. 2 shows a top view of an exploded assembly of the fitment of this invention. Probe **10** is fitted into the inner circular opening **32** of aseptic flip-cap **30** having flip lid **31** attached thereto by hinge **37**. Hinge **37** fits into the recessed area **38** of cap **30** allowing flip lid **31** to recess into the inner circular opening **32** of aseptic flip-cap **30** (shown in **FIG. 1**) thereby providing a level and even surface to the top of aseptic flip-cap **30** when flip lid **31** is in a closed position. Duckbill lock ring **23** is positioned between cap duckbill **20** and the top of spout **50** and locks into cap **30**.

20

FIG. 3 shows a side view of an exploded assembly of the fitment of **FIG. 1**. The probe **10**, which typically is a molded plastic part, has a nozzle **16** and a flange **11** molded to the nozzle **16** that presses against the aseptic flip-cap **30**. The flange **11** is reinforced with a flange-strengthening rib **12**. A locking bead **13** is molded to flange strengthening rib **12** of the probe **10**. The locking bead **13** of the probe **10** is attached to the aseptic flip-cap **30** and forms a seal with the aseptic flip-cap **30**. Probe lead-in **15**, preferably having at least two more, and preferably four, product flow slots **14** through which product flows from bag, engages and forms a seal with the inner circular opening **32** of the aseptic flip-cap **30**. (Also see **FIG. 1** and **FIG. 2**). The probe lead-in **15** need not have these product flow slots **14** and still be operative and allow for flow of fluid from the bag or container.

30

In one embodiment, the total length of the probe **10** is about 1 to 2 inches, typically 1.4 inches, and the nozzle **16** of the probe **10** is about 0.75 inches. In another embodiment, the outer diameter of the nozzle **16** of the probe is about 0.5 inches. In yet another embodiment, the

diameter of the flange **11** that presses against the aseptic flip-cap **30** depends on the width of the cap but typically is about 1.325 inches. In another embodiment, typically, the thickness of the wall of the probe **10** is about 0.095 inch in the nozzle section and about 0.05 inch at the seal at the edge of the flange **11**. The above dimensions can vary depending on the liquid being
5 dispensed.

In one embodiment, the inner diameter of the nozzle **16** of the probe **10** is about 0.25 inch and a variety of hoses typically can be attached to the nozzle **16**. Typically, the hoses are attached to the nozzle **16** by a friction fit of the hose to the nozzle; however, other methods also can be used,
10 such as, a hose clamp or the exterior of the nozzle may be provided with ribs or with a roughened surface for a better friction fit.

In one embodiment, the cap duckbill **20** is a molded elastomeric product or a soft flexible plastic material having a duckbill product flow opening **21**. (See **FIG. 1** also.) The duckbill seal **22** is
15 fitted into the bottom of the probe **10** and engages with the inner wall of the nozzle **16**. The duckbill product flow opening **21** (illustrated in **FIG. 1** in a closed position) of the cap duckbill **20** typically is a re-closable opening, such as a slit in the cap duckbill **20** that allows fluid to flow from the bag or container upon engagement of the probe **10** by application of a downward force applied to the duckbill **20**. As pointed out above, the duckbill lock ring **23** prevents seepage of
20 liquid through the product flow opening **21** until there is engagement by the probe **10**. The product flow opening **21** of the cap duckbill **20** can be molded in such a manner that it would be broken open on engagement of probe **10**. In the alternative, the product flow opening **21** can be sealed with a thin layer of material that is broken on engagement of the probe **10**, or the opening itself can be sealed but breakable on engagement of the probe **10** and then re-sealable
25 when the probe is disengaged. The duckbill seal **22** fits into aseptic flip-cap **30** and forms a seal with inner circular opening **32** of the aseptic flip-cap **30**. Optionally, the duckbill seal **22** can be permanently attached to the aseptic flip-cap **30** by welding or heat sealing it to the aseptic flip-cap **30**.

30 The primary advantage of the use of the cap duckbill **20** is to prevent back flow from the bag or container through the aseptic flip-cap **30** when the probe **10** is not engaged and the hose attached to the probe **10** is removed. The cap duckbill shape as shown in **FIG. 1** is preferred but other shapes can be used that would provide the same function. Typically, the length of the cap

duckbill **20** is from about 0.375 to 1.000 inch and the width about 0.3 inch, but these dimensions may vary depending on the design of the fitment.

5 The cap duckbill **20** is molded from an elastomeric material or a soft flexible plastic material that can withstand the effects of the fluid being dispensed. Typically useful elastomers are styrene/butadiene copolymers, butyl rubbers, polysulfide rubbers, polyisoprene, ethylene-propylene terpolymers (EPDM rubber), silicone rubbers, polyurethane rubbers, and the like. A soft flexible plastic material can also be used such a linear low molecular weight polyethylene or copolymers and blends thereof. The duckbill lock ring **23** also can be molded from any of the
10 above materials, preferably, a plastic material, such as high density polyethylene or high density polypropylene.

In one embodiment, the aseptic flip-cap **30** is a molded plastic part preferably formed of polyethylene but any of the aforementioned thermoplastics can be used. The aseptic flip-cap **30**
15 has attached to it a flip lid **31** by hinge **37**, which can be moved and engaged with the opening of the aseptic flip-cap **32** and forms a seal to retain liquid in the bag or container when the probe **10** is not inserted into or when it is removed from the opening of the aseptic flip-cap **32**. Also, a seal of a thin film of plastic, coated paper, metal foil and the like can be sealed over the opening **32** of the flip-cap to keep liquid product in the container or bag fresh and prevent spoilage. This
20 seal can readily be removed, broken, or punctured at the time when product is to be removed from the container or bag. A pull tab **34** is molded to the flip lid **31** for easy opening and closing of the flip lid **31**. The aseptic flip-cap **30** has a handling flange **33** for holding the aseptic flip-cap **30** while it is being moved over the spout **50** or removed there-from. The interior of the aseptic flip-cap **30** fits over the sealing bead(s) **53** of the spout **50** to form liquid tight seal with
25 the spout **50**. The spout **50** also has a sealing flange **52** molded thereto and forms a liquid tight seal with the bag or container (not shown) when attached thereto.

The flip lid **31** of the aseptic flip-cap **30** is an optional feature and can be eliminated in particular when a seal is positioned over the opening **32** of the cap **30** and when the fitment is
30 used only for an initial installation and the bag or container is not subsequently removed or closed after disengagement of the probe **10**.

Another optional feature is that the hinge **37** of the flip lid **31** can be recessed into a slot or recessed area **38** in the aseptic flip-cap **30** to form a even surface on the flip lid **30**. The

recessed area **38** in the aseptic flip-cap **30** is of a sufficient depth so that the flip lid **31** and the pull tab **34** are also recessed in the aseptic flip-cap **30**.

FIG. 4, which is a cross sectional view of the assembly of the fitment (taken at line **A-A'** in **FIG. 3**) shows the positioning of the cap duckbill **20** in the aseptic flip-cap **30** and the aseptic flip-cap **30** onto the spout **50**. The aseptic flip-cap **30** has two U-shaped collar openings: **35**, which is the outer opening, and **36**, which is the inner opening. The duckbill seal **22** of the cap duckbill **20** fits into the U-shaped collar opening **36** of the cap duckbill **20** and forms a seal. When the probe lead-in **15** of the probe **10** engages with the cap duckbill **20**, the flow opening **21** of the cap duckbill **20** is forced open and fluid is allowed to flow. Similarly, when the probe **10** is disengaged, the flow opening **21** closes and seals and prevents further flow of any fluid from the bag. Duckbill lock ring **23** holds the flow opening **21** of the cap duckbill **20** closed until the probe **10** engages the cap duckbill **20** to allow flow of liquid and the top ring of the duckbill lock ring **23** fits into the inner opening **36** of the aseptic flip-cap **30** and forms a seal with the aseptic flip-cap **30**.

As illustrated in the **FIG. 4**, the aseptic flip-cap **30** fits over the spout **50**. The proximal end of the spout **50** fits into the outer U-shaped collar opening **35** of the aseptic flip-cap **30** and a seal is formed with the spout seal beads **53** of the spout **50**.

FIG. 5 is a partial cross sectional view of the aseptic flip-cap **30**.

FIG. 6 is a perspective of the cross-sectional view that shows the aseptic flip-cap **30** mounted on the spout **50**. The aseptic flip-cap **30** is mounted on the spout **50** with the outer U-shaped collar opening **35** creating an aseptic seal with the inner wall **41** of the spout **50**. The outer U-shaped collar opening **35** has an inner collar **60** and an outer flange **61**. The inner collar **60**, of outer U-shaped collar opening **35**, comprises at least one sealing ring or sealing bead **42** on the inner collar **60**'s outside wall **62**. The sealing ring **42** is a protrusion projecting outward from the outside wall **62** of the inner collar **60** of the outer U-shaped collar opening **35**. Because it protrudes outwardly, the sealing ring **42** exerts sufficient force on the inner wall **41** of the spout **50** to create an aseptic seal.

In an alternative embodiment, as shown in **FIG. 7**, more than one sealing rings **42**, **43**, and **44**, are provided on the outside wall **62** of the inner collar **60**. The surface of the protruding sealing

rings **42-44** can be flat or curved. As shown in **FIG. 7**, the surface of the sealing ring **44** is flat while the surfaces of the sealing rings **42** and **43** are curved. The curvature of the protruding sealing rings can assume a flat-shape or a triangular shape with only a line contact with the inner wall **41** of the spout **50**. The curvature of the protruding sealing rings can assume shapes
5 that are intermediate between the flat shape and the triangular shape.

It should be noted that in alternative embodiments, the sealing ring **42** may not protrude outside of the outside wall **62** of the inner collar **60** of the outer U-shaped collar opening **35**, and instead may be generally flush with said outside wall **62** of the inner collar **60** of the outer
10 U-shaped collar opening **35**. Stated another way, the sealing rings **42**, **43**, and **44** may be formed by the circular depression (trough) **40** shown in **FIG. 6**.

In still another alternative embodiment, the orientation of the inner collar **60** of the outer U-shaped collar opening **35** as compared to the spout **50** may not be vertical (the angle between
15 the spout annular wall and the annular wall of the inner collar **60** of the outer U-shaped collar opening **35** is 180°) but instead, may vary between 155° and 205° . When the angle is greater than 180° , the proximal end of the inner collar **60** of the outer U-shaped collar opening **35** will be closer to the spout **50** than the distal end.

FIG. 8 shows a magnified view of a cross section of the aseptic flip-cap **30** showing three sealing rings **45**, **46** and **47** on the outside wall **62** of the aseptic flip-cap. **FIG. 9** shows the aseptic flip-cap **30** as shown in **FIG. 8** positioned over spout **50** wherein the inner wall **41** of the spout **50** is flat and sealing rings **45**, **46** and **47** form a seal with the inner wall **41** of the
25 spout **50**.

FIG. 10 shows a magnified view of a cross section of the aseptic flip-cap **30** that does not have sealing rings on the outside wall **62** but has a flat section **48** which engages with seals on the spout as shown in **FIG. 11**.

FIG. 11 shows a magnified view of a cross section of the aseptic flip-cap **30** that does not have sealing rings as shown in **FIG. 10** wherein the flip-cap **30** is mounted on spout **50**. The spout **50** has sealing rings **49** and **49.1** positioned on the inner wall **41** of the spout and these rings **49** and **49.1** form a seal with the flat section **48** of the outside wall **62** of the flip-cap **30**.

In one embodiment, the aseptic seal comprises at least one seal ring. In another embodiment, the aseptic seal comprises 1, 2, 3, 4, or 5, seal rings. In an embodiment with more than one seal rings, at least two of the seal rings have different curvatures as described above. In another embodiment with more than one seal ring, all seal rings have the same curvature of their surface as described above.

Spout **50** is attached to a bag not shown via the molded sealing flange **52**. Typically, the sealing flange **52** is heat sealed to the bag or container. The spout **50** has a handling flange **51** for ease of handling the fitment and the bag when attached. The spout **50** is molded from any of the aforementioned thermoplastic materials, although, polyethylene is preferred.

The aseptic flip-cap, in one embodiment is made from the same material as the spout. In another embodiment, the aseptic flip-cap is made from a material that has a higher hardness than that of the material of the spout. In yet another embodiment, the aseptic flip-cap is made from a material that has a lower hardness than that of the material of the spout. In another embodiment, the aseptic flip-cap is made from a material that has a higher toughness than that of the material of the spout. In yet another embodiment, the aseptic flip-cap is made from a material that has a lower toughness than that of the material of the spout.

The aseptic seal is advantageous in filling operation. In one embodiment, an unfilled a collapsible bag has a fitment assembly with the aseptic flip-cap mounted on the spout. The aseptic flip-cap ensures that the collapsible bag is completely sealed before the filling operation. In one embodiment, during the filling operation, the liquid to be filled into the collapsible bag is introduced into the collapsible bag under aseptic conditions. In one embodiment, the filler mechanism removes the aseptic flip-cap mounted on the spout on the unfilled collapsible bag, fills the collapsible bag and remounts or reattaches the aseptic flip-cap onto the spout. Thus the liquid now in the filled bag is under aseptic seal.

The invention as fully described above may embody other specific forms or variations without departing from its spirit or essential characteristics. In that regard, the embodiments described above are to be considered in all respects as illustrative and not restrictive, the scope of the invention being indicated by the claims rather than by the foregoing description and any and all changes which come within the meaning and range of equivalency of the claims are intended to be embraced therein.

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CLAIMS

What is claimed is:

1. A fitment for use on a collapsible bag for dispensing of liquids and semi-solids from the bag, the fitment comprising:
- (a) a spout comprising a generally hollow cylindrical body having an external surface and an internal surface, the spout having at one end, a base portion for securing the spout to the collapsible bag;
 - (b) an aseptic flip-cap having an outer collar and an inner collar with the outer collar and the inner collar each having an inner and an outer surface, the inner surface of the outer collar and the outer surface of the inner collar forming a cavity adapted to be removably attachable to the spout, the inner surface of the inner collar being capable of attaching to a cap duckbill, the aseptic flip-cap further comprising a hollow cylinder section comprising a proximal end and a distal end with each having an inner and an outer surface, the cylinder section having a distal end and being fixedly attached at the distal end to the inner collar, the inner surface of the inner collar and the outer surface of the proximal end of the cylinder forming a cavity;
- wherein the external surface of the spout is configured to mate with the aseptic flip-cap, and wherein the internal surface of the spout is configured to form an aseptic seal with the aseptic flip-cap;
- wherein the outer surface of said inner collar of the aseptic flip-cap comprises at least one sealing ring configured to form an aseptic seal with the internal surface of the spout;
- (c) a slidably removable probe; and
 - (d) a substantially hollow cap duckbill adapted to mate with the proximal end of the aseptic flip-cap and which forms a seal within the fitment that is configured to be

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unsealed by insertion of the probe into the fitment through the hollow cylinder of the aseptic flip-cap, the cap duckbill having a dome and a tapered end and an ejection end, the tapered end having a reversibly sealable slit capable of preventing fluid flow through the aseptic flip-cap upon removal of the probe from the fitment.

2. The fitment of Claim 1, wherein the probe comprises a generally hollow cylindrical body having a proximal end and a distal end, the distal end forming a nozzle having a nipple capable of mating with a tube, the proximal end having an external surface adapted to mate with the inner surface of the distal end of the aseptic flip-cap, the proximal end further having at least one indentation which permits fluid flow through the probe when the dome of the cap duckbill has been collapsed by the probe, the proximal end and distal end being separated by a flange on the outer surface of the probe which extends around the circumference of the probe, the probe when mated with the aseptic flip-cap, collapsing the dome of the cap duckbill thereby removing the seal between the aseptic flip-cap and the cap duckbill to allow fluid flow from the bag through the fitment, and the probe when removed from mating with the aseptic flip-cap uncollapsing the dome of the cap duckbill thereby resealing the seal between the aseptic flip-cap and the cap duckbill.
3. The fitment of Claim 2, further comprising a substantially hollow cap duckbill adapted to mate with the inner surface of the probe near the proximal end of the probe, the cap duckbill having a tapered end and a receiving end, the tapered end having a reversibly sealable slit capable of preventing backflow of fluid upon removal of the tube from the probe, the receiving end being in fluid communication with the flow from the spout when the seal between the aseptic flip-cap and the cap duckbill has been removed.
4. The fitment of any one of Claims 1, 2, or 3, wherein the aseptic flip-cap further comprises a flip-top lid joined to the aseptic flip-cap by a hinge which allows the flip-top lid to move between a closed position on the aseptic flip-cap whereby the hollow cylinder section is covered and an open position away from the hollow cylinder.

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5. The fitment of Claim 1, wherein the aseptic flip-cap further comprises a removable or breakable seal, which covers the distal end of the aseptic flip-cap.
6. The fitment of Claim 5, wherein the breakable seal is broken by the first insertion of the probe into the cylinder of the aseptic flip-cap.
7. The fitment of Claim 5, wherein the seal comprises a thin material selected from the group consisting of plastic, paper or metal foil.
8. The fitment of Claim 1, wherein the cap duckbill is attached to the inner surface of the collar of the aseptic flip-cap.
9. The fitment of Claim 8, wherein the cap duckbill is attached by being welded or heat sealed to the collar of the aseptic flip-cap.
10. The fitment of Claim 1, wherein the reversibly scalable slit of the cap duckbill is sealed closed and when punctured by the probe is opened and then reseals on removal of the probe.
11. The fitment of Claim 4, wherein the hinge of the flip-top lid is recessed into the aseptic flip-cap and thereby allowing the flip-top lid to be recessed into the cavity in the aseptic flip-cap.
12. The fitment of Claim 1, having a duckbill lock ring in engagement with the cap duckbill to prevent flow of liquid from the bag until the probe engages the cap duckbill.
13. The fitment as recited in Claim 1, wherein said aseptic flip-cap comprises 1-5 sealing rings.
14. The fitment as recited in Claim 13, wherein said aseptic flip-cap comprises more than one sealing ring and the surface of said sealing rings are identical.
15. The fitment as recited in Claim 13, wherein said aseptic flip-cap comprises more than one sealing ring and the surface of at least two of said sealing rings have different curvatures.

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16. The fitment as recited in Claim 1, wherein said at least one sealing ring is flush with the surface of the outer wall of said inner collar.
17. The fitment as recited in Claim 1, wherein an angular orientation between the spout annular wall and the annular wall of the inner collar is in the range of from 155° to 205°.
18. The fitment as recited in Claim 1, wherein said aseptic flip-cap material is selected from the group consisting of (a) a material that is the same material as the spout; (b) a material that has a higher hardness than that of the material of the spout; (c) a material that has a lower hardness than that of the material of the spout; (d) a material that has a higher toughness than that of the material of the spout; and (e) a material that has a lower toughness than that of the material of the spout.
19. A fitment for use on a collapsible bag for dispensing of liquids and semi-solids from the bag, the fitment comprising:
 - (a) a spout comprising a generally hollow cylindrical body having an external surface capable of mating with an aseptic flip-cap and an internal surface having at least one sealing ring capable of forming a seal with the aseptic flip-cap, the spout having at one end, a base portion for securing the spout to the collapsible bag;
 - (b) an aseptic flip-cap having an outer collar and an inner collar with the outer collar and the inner collar each having an inner and an outer surface, the inner surface of the outer collar and the outer surface of the inner collar forming a cavity adapted to be removably attachable to the spout, the inner surface of the inner collar being capable of attaching to a cap duckbill, the aseptic flip-cap further comprising a hollow cylinder section comprising a proximal end and a distal end with each having an inner and an outer surface, the cylinder section having a distal end and being fixedly attached at the distal end to the inner collar, the inner surface of the inner collar and the outer surface of the proximal end of the cylinder forming a cavity; wherein the outer surface of said inner collar of the aseptic flip-cap forms a seal with the at least one sealing ring of the spout;

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- (c) a slidably removable probe; and
- (d) a substantially hollow cap duckbill adapted to mate with the proximal end of the aseptic flip-cap and which forms a seal within the fitment that is configured to be unsealed by insertion of the probe into the fitment through the hollow cylinder of the aseptic flip-cap, the cap duckbill having a dome and a tapered end and an ejection end, the tapered end having a reversibly sealable slit capable of preventing fluid flow through the aseptic flip-cap upon removal of the probe from the fitment.
20. A process for filling an unfilled collapsible bag for dispensing of liquids and semisolids from said collapsible bag, comprising a fitment as recited in Claim 1, comprising:
- (a) introducing said unfilled collapsible bag into a filling chamber under aseptic conditions;
- (b) dismounting said fitment from said spout on said unfilled collapsible bag under aseptic conditions;
- (c) filling said unfilled collapsible bag with material for dispensation;
- (d) re-mounting said fitment on said spout; and
- (e) closing the aseptic flip-cap.
21. The fitment of Claim 1, wherein the aseptic flip-cap further comprises a flange fixedly attached to the outer surface of the outer collar.
22. The fitment of Claim 19, wherein the aseptic flip-cap further comprises a flange fixedly attached to the outer surface of the outer collar.

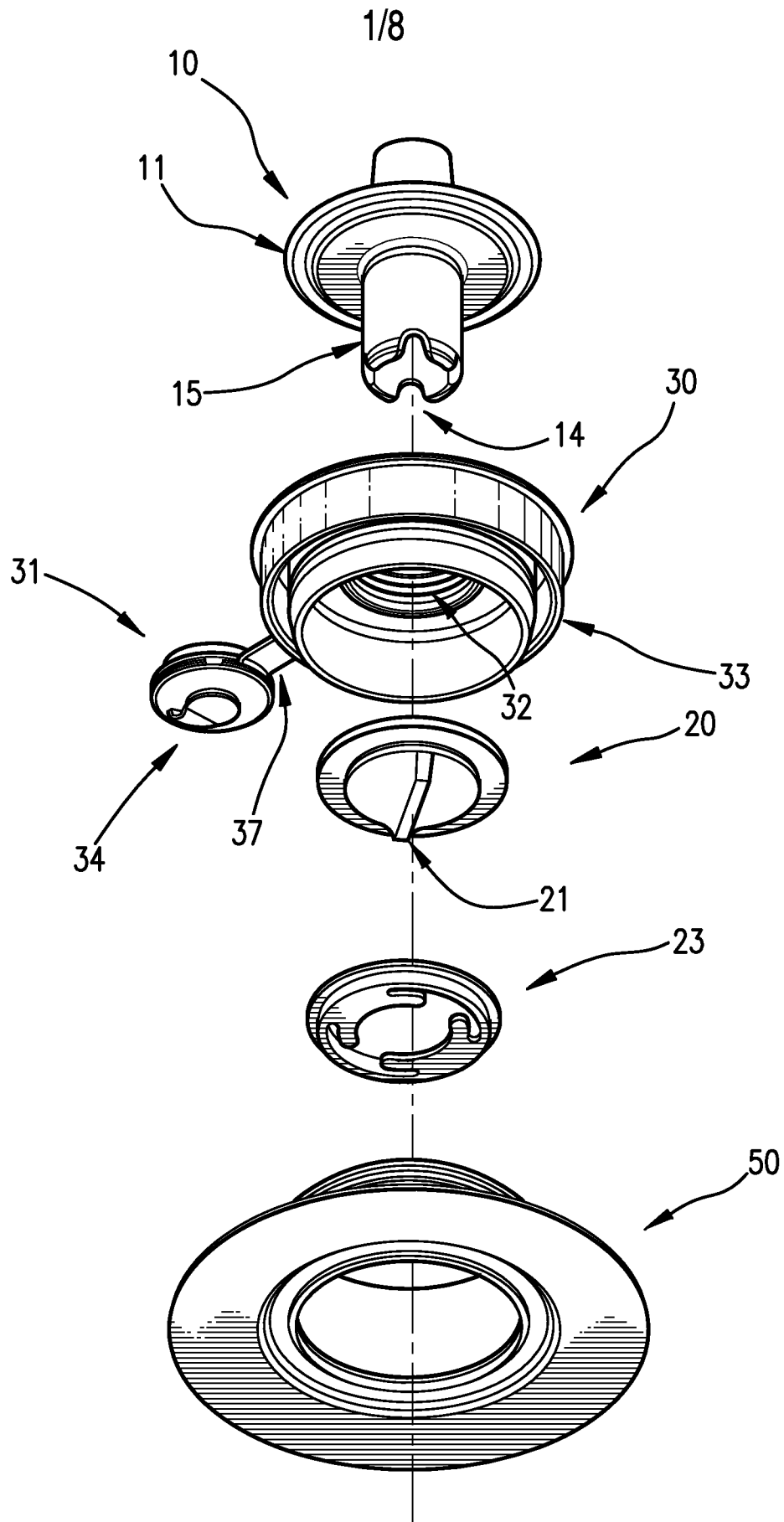


FIG. 1

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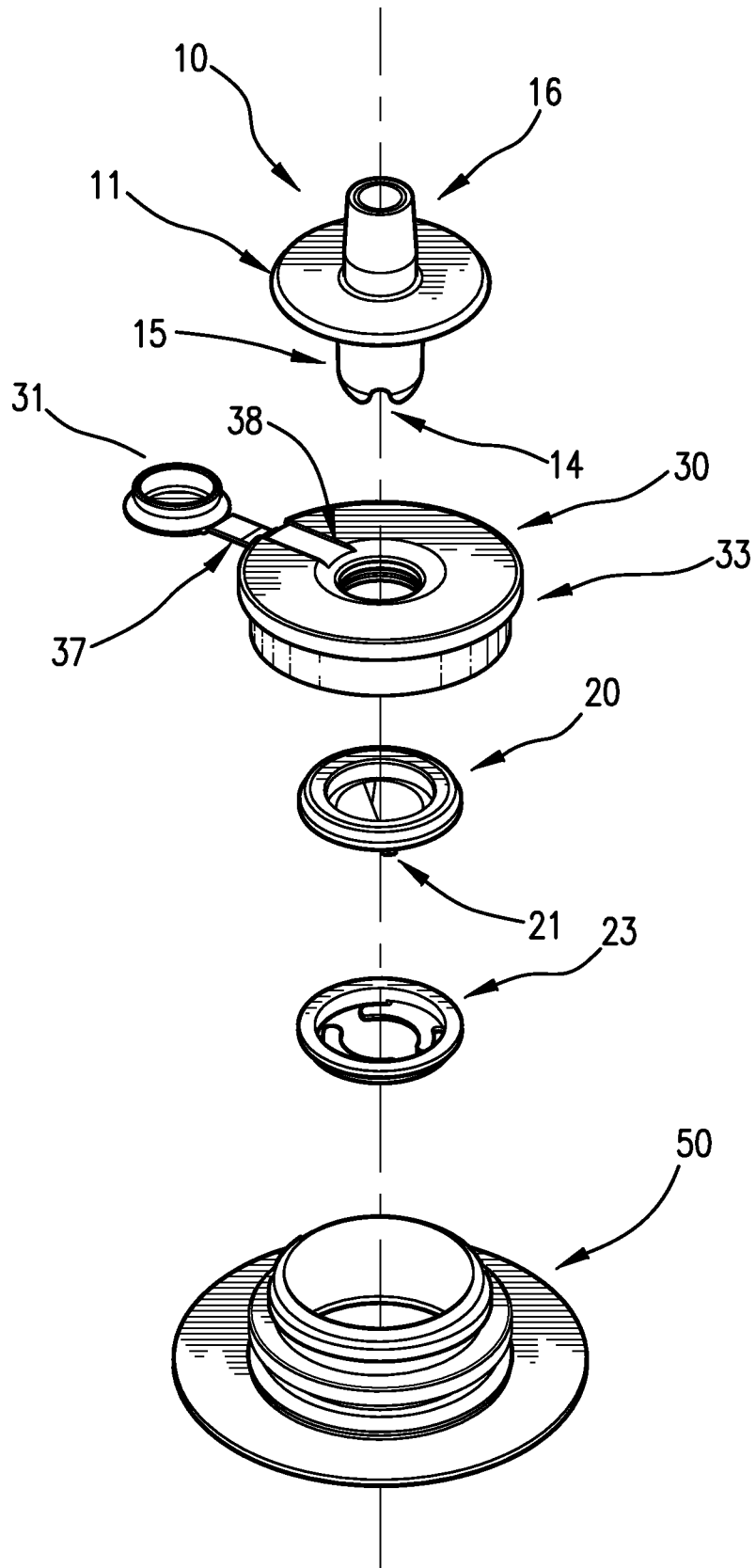
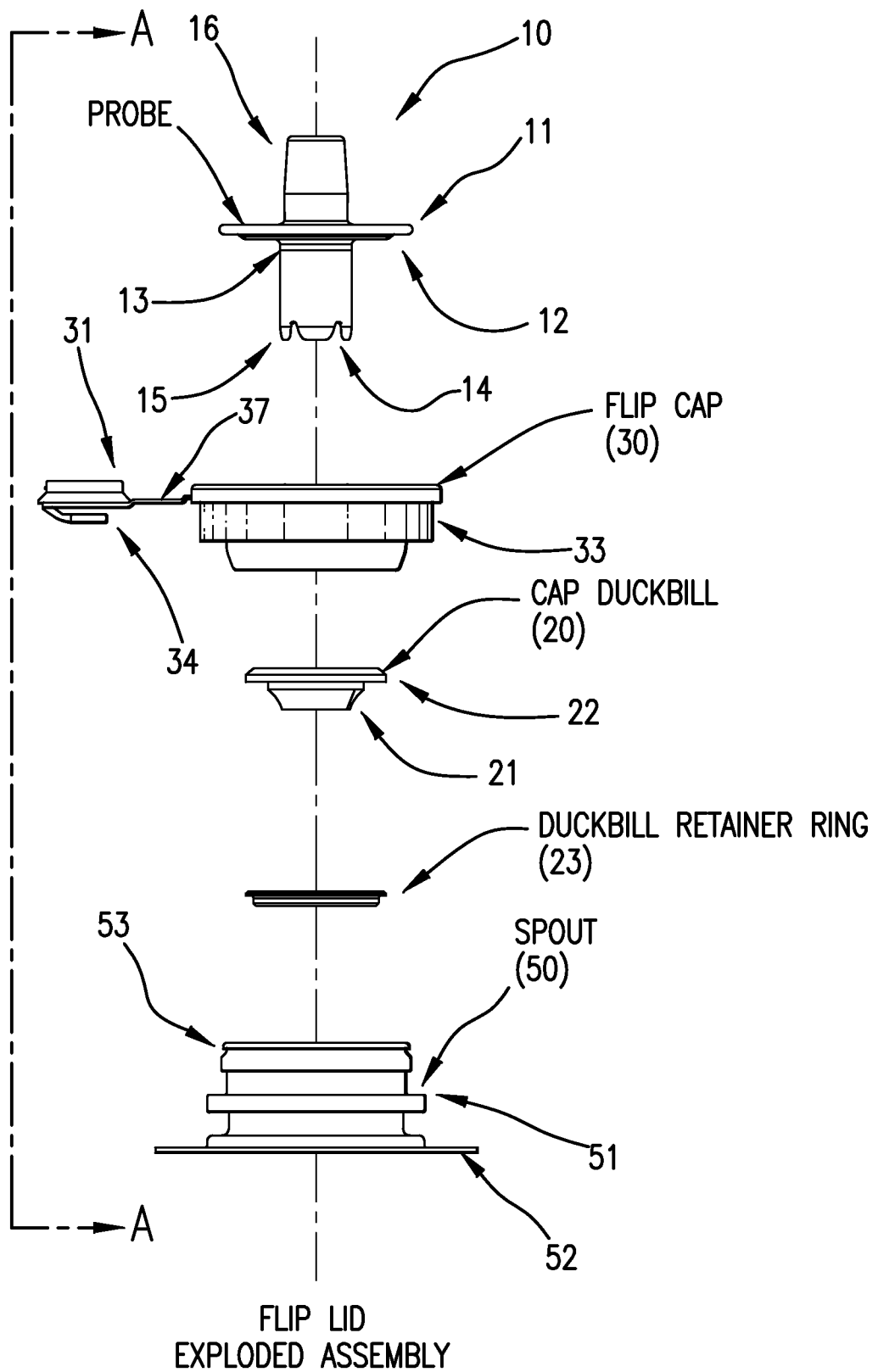


FIG. 2

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**FIG. 3**

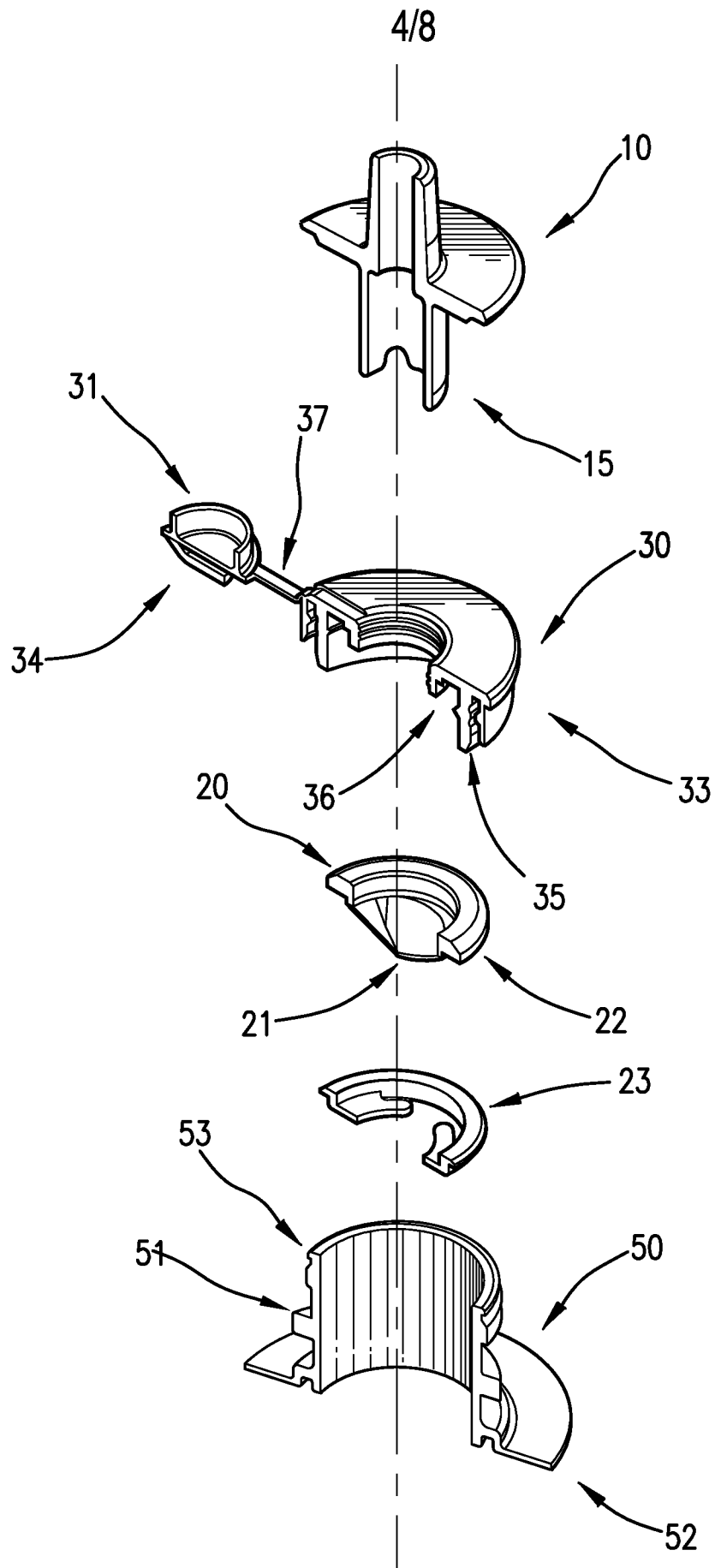


FIG. 4

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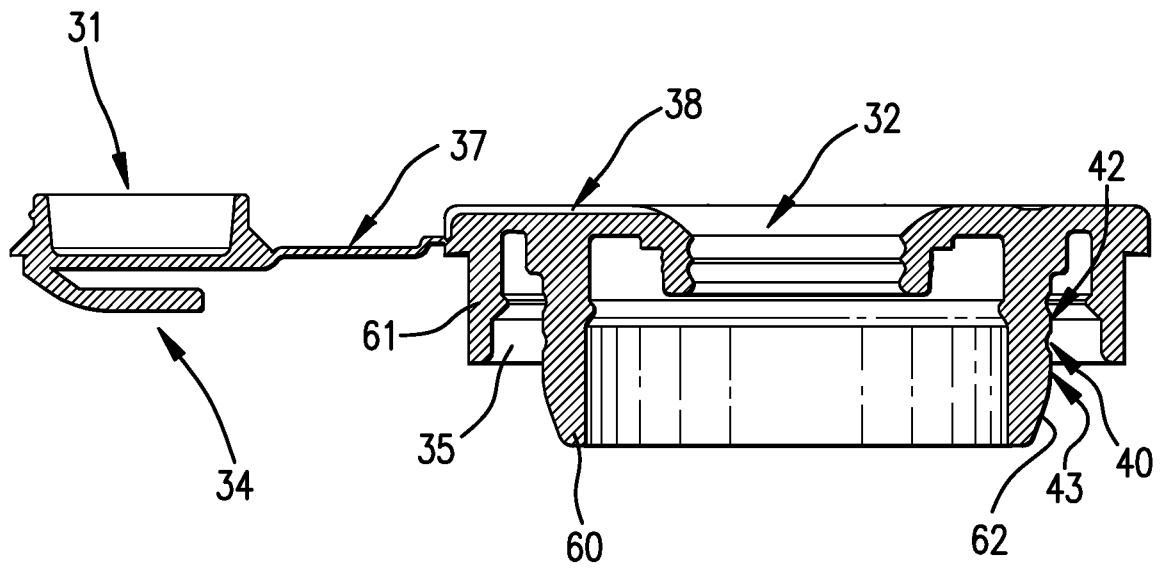


FIG. 5

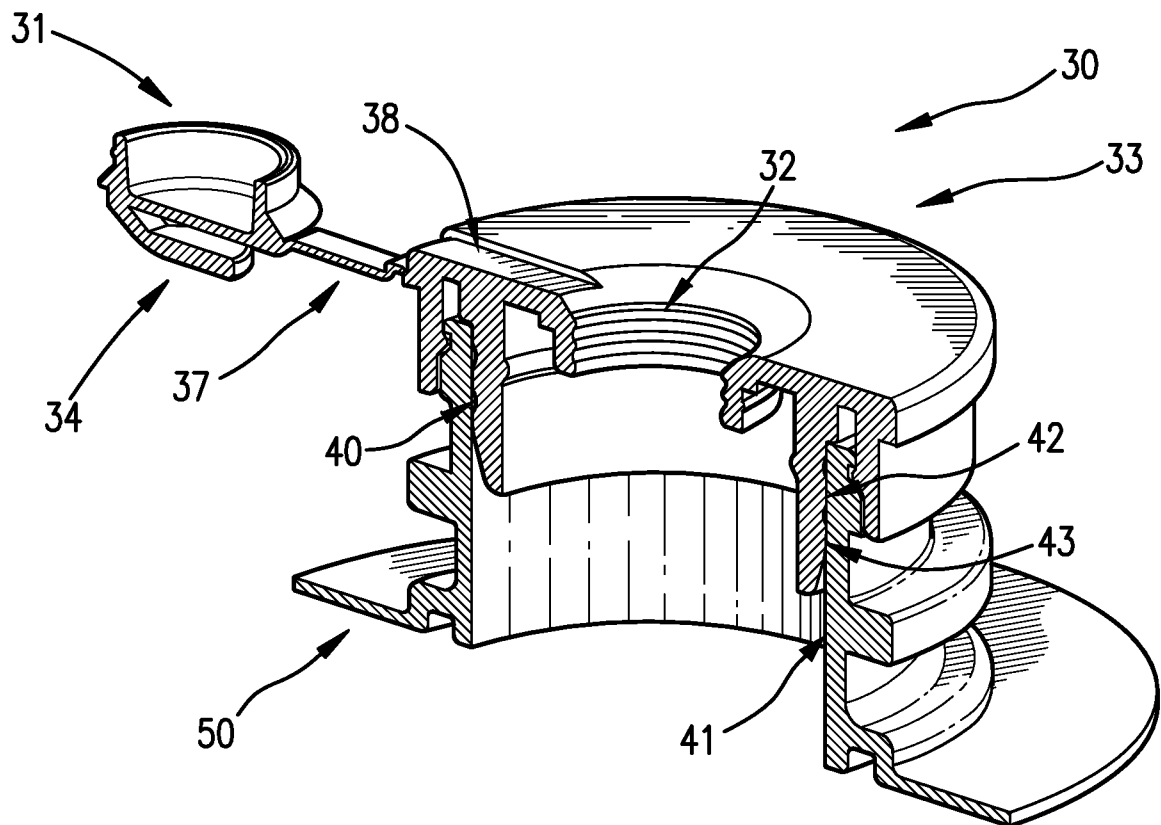


FIG. 6

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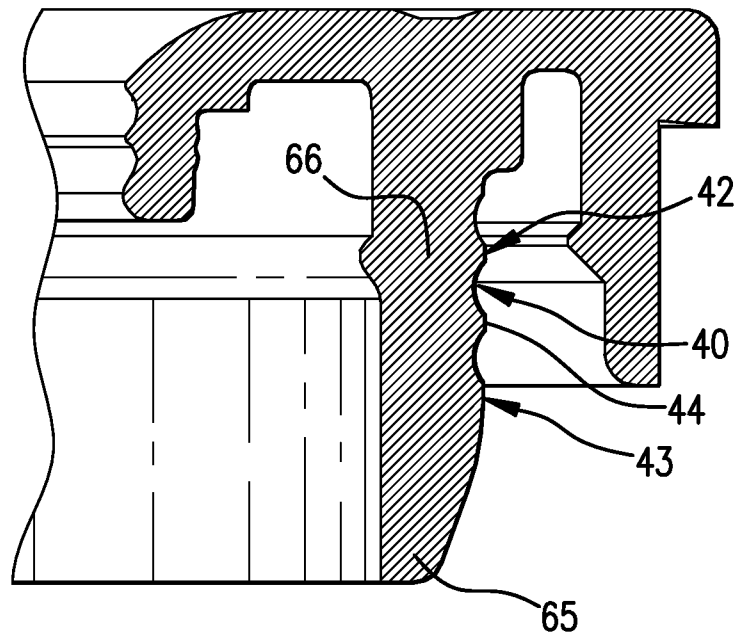


FIG. 7

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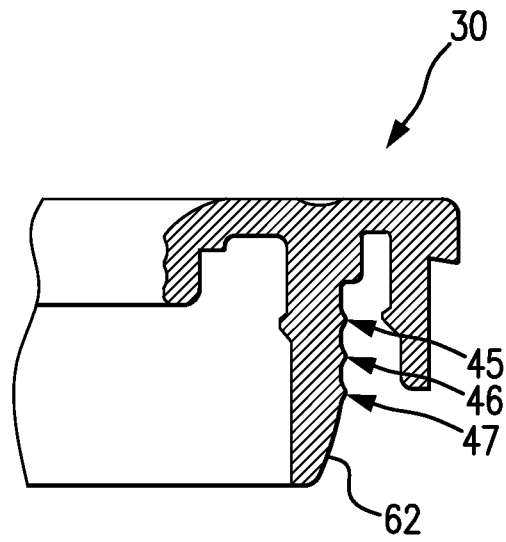


FIG. 8

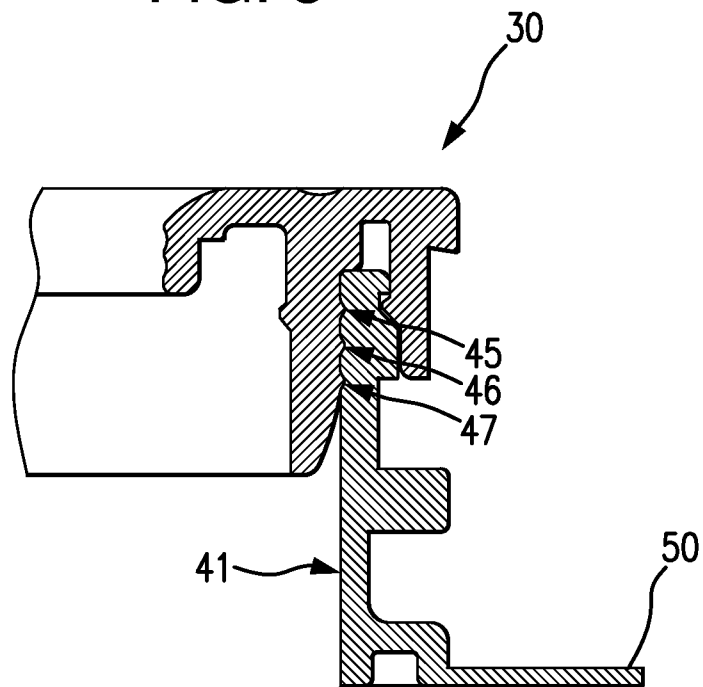


FIG. 9

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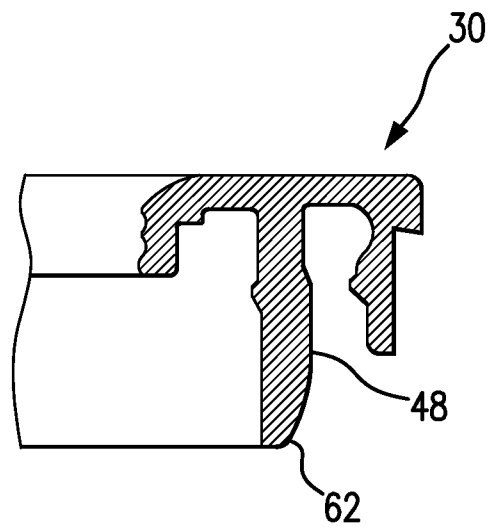


FIG. 10

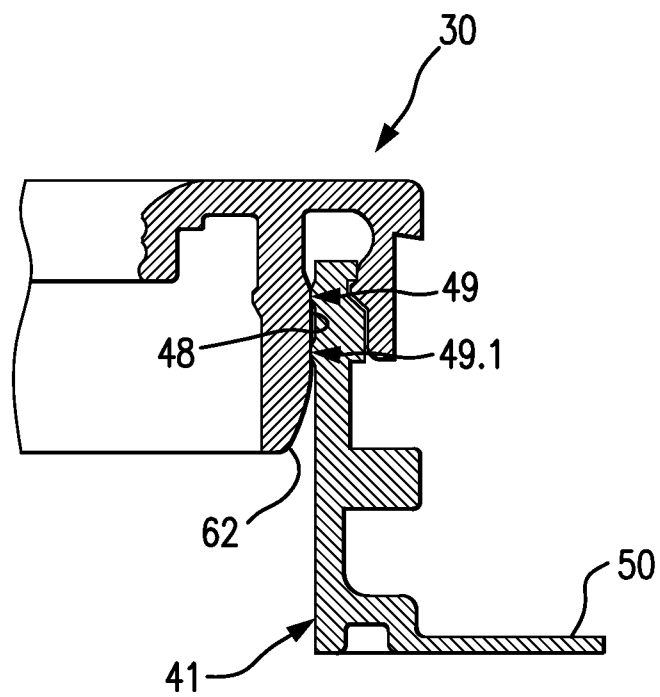


FIG. 11

