

Title (en)

Method of lidding containers, cover film for carrying out this method and product thus obtained

Title (de)

Verfahren zum Deckelverschliessen von Behältern, Deckelfolie zum Durchführen dieses Verfahrens und so hergestelltes Produkt

Title (fr)

Procédé pour l'operculation de récipients, feuille d'operculation pour la mise en oeuvre de ce procédé et produit industriel obtenu

Publication

EP 0915013 B1 20051214 (FR)

Application

EP 98402767 A 19981106

Priority

FR 9714016 A 19971107

Abstract (en)

[origin: EP0915013A1] To seal a container, with its contents, a continuous film of at least two layers (1,2) is used, with perforations (3) in the inner film in a density of 100-10000 perforations/dm<2>, and an adhesive bond (5) between them. The adhesive bond leaves a grid (6,7) of zones free of adhesive, to give at least one longitudinal channel to the film edge after cutting. The film is placed over the filled container (A), and is adhesive (4) bonded all round its edge (C). The sealing adhesive is activated through the outer layer (2) without damage to the inner layer (1), to leave the edge channel after bonding to the container edge and after cutting. The continuous sealing adhesive is applied to the inner layer before perforation. The two layers are assembled together in a material which can be wound in a roll as a feed at the sealing station. The adhesive bond (5) between the layers and the sealing adhesive are activated together, when the film material is placed over the filled container. The sealing adhesive has a lower fusion point than the bonding adhesive, and the two adhesives are of different types, where the bonding adhesive is produced by condensation and the sealing adhesive by polymerization. A sealing adhesive is applied to at least one of the layers at the intersections of at least one of the open channels (6,7) at a temperature over ambient levels, but below a temperature where the container contents are heated. The perforated layer can be formed by at least two inner layers, bonded together, where the innermost gives a secure bond with the edge of the container and its covering layer gives a firm bond with the outer layer through the bonding adhesive. The perforations (3) can be in a density of 200-2000 perforations/dm<2> or 500-1200 perforations/dm<2>, equidistant or at different intervals on both plan axes. The open channels have a width of 2-5 mm or 3.0-3.5 mm, in a channel density of 5-15 per dm. Some legs of at least one channel (6,7) carry sealing adhesive (4).

IPC 1-7

B65B 7/16; **B65D 77/20**

IPC 8 full level

B65D 51/16 (2006.01); **B65D 77/20** (2006.01); **B65D 77/22** (2006.01)

CPC (source: EP)

B65D 51/1633 (2013.01); **B65D 77/225** (2013.01); **B65D 2205/00** (2013.01)

Cited by

EP3575084A1; ES2221563A1; EP1422163A1; GB2377906A; GB2377906B; GB2367527A; GB2367527B; WO2019228822A1; WO02051716A1; WO2004098317A1; WO2004048225A1

Designated contracting state (EPC)

AT BE CH DE DK ES FI FR GB GR IE IT LI LU MC NL PT SE

DOCDB simple family (publication)

EP 0915013 A1 19990512; **EP 0915013 B1 20051214**; AT E312757 T1 20051215; DE 69832771 D1 20060119; DK 0915013 T3 20060501

DOCDB simple family (application)

EP 98402767 A 19981106; AT 98402767 T 19981106; DE 69832771 T 19981106; DK 98402767 T 19981106