

Title (en)  
METHOD FOR THE PRODUCTION OF THE FILM TUBE BAG AND THE VERTICAL FORM FILL SEAL PACKAGING MACHINE TO IMPLEMENT THE METHOD

Title (de)  
VERFAHREN ZUR HERSTELLUNG EINES FOLIENSCHLAUCHBEUTELS UND VERTIKALE FORM-, FÜLL- UND VERSCHLIESSMASCHINE ZUR IMPLEMENTIERUNG DES VERFAHRENS

Title (fr)  
PROCÉDÉ DE PRODUCTION D'UN SAC TUBULAIRE À BASE DE FILM ET MACHINE À EMBALLER DU TYPE FORMAGE-REMPLISSAGE-SCELLAGE VERTICAL À DES FINS DE MISE EN OEUVRE DU PROCÉDÉ

Publication  
**EP 3122639 B1 20190605 (EN)**

Application  
**EP 15719592 A 20150325**

Priority  
• CZ 2014199 A 20140327  
• CZ 2015000025 W 20150325

Abstract (en)  
[origin: WO2015144100A1] The method of the film tube bag production comprises the following operations: - Shaping the longitudinal foldings (6) on the packing film (8), - Attaching the secondary all-round closure (5) on the inner side (21) of the packing film (8). Its longitudinal axis is perpendicular to the longitudinal axis of the longitudinal foldings (6). The length of the secondary all-round closure (5) corresponds to the size of the inside circumference of the bag (1), - Shaping of the packing film (8) into the form of the film tube, - Closing the film tube and creating the folded flat quadrilateral bottom (3), - Filling the bag and forming the upper cross seam (2). The secondary all-round closure (5) can be formed by a one-piece zipper closure, double-sided adhesive tape, or by the spread of a permanent adhesive. The vertical form fill seal packaging machine comprises the device (11) for the packing film (8) unwinding, the device (12) for shaping and fixing longitudinal foldings (6), the device (17) for the application of the one-piece secondary all-round closure (5), forming collar (13), filling tube (14) and the longitudinal sealing jaw (15), the device (19) for the packing film (8) feed, the device (18) for formation of flat bottom (3) of the bag (1), and lateral sealing and separating jaws (16) to form the cross seam (2, 4) and to separate the filled bag (1).

IPC 8 full level  
**B65B 51/26** (2006.01); **B65B 9/20** (2012.01); **B65B 61/18** (2006.01)

CPC (source: EP US)  
**B65B 9/20** (2013.01 - EP US); **B65B 9/22** (2013.01 - US); **B65B 51/02** (2013.01 - US); **B65B 51/26** (2013.01 - EP US); **B65B 51/30** (2013.01 - US); **B65B 61/18** (2013.01 - EP US); **B65B 61/188** (2013.01 - EP US); **B65B 2220/12** (2013.01 - EP US)

Citation (examination)  
• US 2002046548 A1 20020425 - FORMAN HAROLD M [US]  
• US 4840611 A 19890620 - VAN ERDEN DONALD L [US], et al

Designated contracting state (EPC)  
AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

DOCDB simple family (publication)  
**WO 2015144100 A1 20151001**; CZ 2014199 A3 20150603; CZ 305197 B6 20150603; EP 3122639 A1 20170201; EP 3122639 B1 20190605; US 2017113821 A1 20170427

DOCDB simple family (application)  
**CZ 2015000025 W 20150325**; CZ 2014199 A 20140327; EP 15719592 A 20150325; US 201515129216 A 20150325