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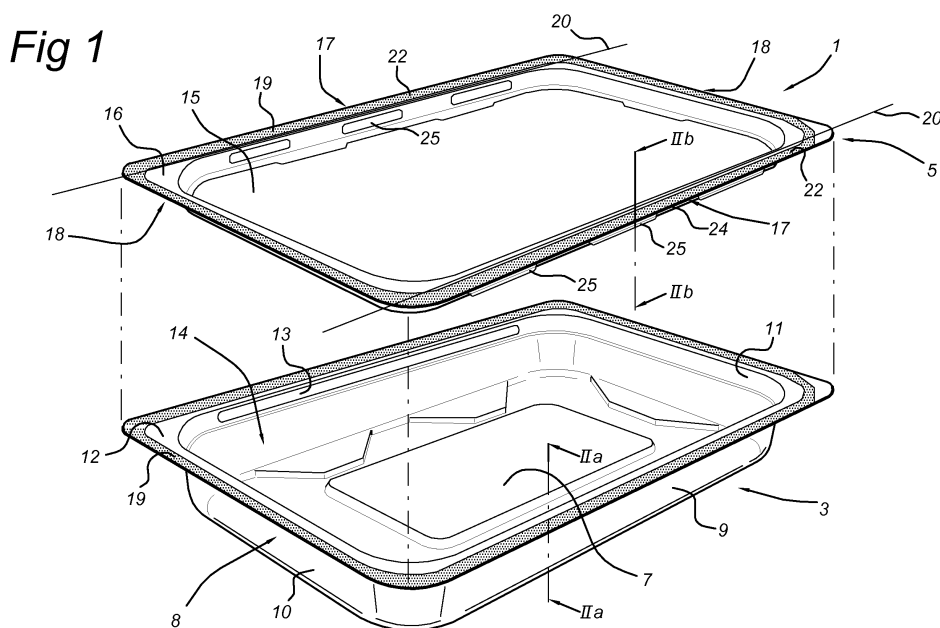
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Packaging for accomodating a food product and method for producing a packaging of this type

(57)

A packaging for accommodating a food product, in particular cheese or cheese slices, comprises a tray-shaped container (3) which is provided with a bottom (7) and a standing peripheral wall (8) which extends from the bottom. The container has a peripheral first collar (12) which projects outwards substantially transversely from the peripheral wall. The container is open at an upper end which is remote from the bottom. A lid (5) is provided for closing the open upper end of the container. The lid comprises a peripheral second collar (16) which is

aligned with respect to the peripheral first collar of the container and is attached thereto by means of a peripheral sealing seam (19). At least one of the collars comprises at least one line of weakening (20), which is provided in such a manner that a removable tear strip (22) is formed, which at least partly corresponds to the sealing seam (19). The line of weakening (20) is provided in the peripheral second collar (16) of the lid. The lid is provided with a multilayer film (36) which comprises several plastic layers. The line of weakening (16) is formed by a laser beam.



Description

[0001] The invention relates to a packaging for accommodating a food product, in particular cheese or cheese slices, comprising:

- a tray-shaped container which is provided with a bottom, a standing peripheral wall which extends from the bottom, as well as a peripheral first collar, which projects outwards substantially transversely from the peripheral wall, and which container is open at an upper end which is remote from the bottom,
- a lid for closing the open upper end of the container, which lid comprises a peripheral second collar which corresponds to the peripheral first collar of the container and is attached thereto by means of a peripheral sealing seam.

[0002] A so-called top-forming packaging or duo hard packaging is known. This packaging is, for example, used for packaging a piece of cheese or pre-cut cheese slices. The duo hard packaging comprises a tray, in which the cheese is accommodated. At its upper end, the tray has a peripheral collar which projects outwards. The tray containing cheese is covered by means of an associated lid. The lid also has a peripheral collar which rests on the collar of the tray. The tray and the lid are usually made of a multilayer film comprising a hard plastic, hence the term duo hard packaging.

[0003] The peripheral collars of the tray and the lid, respectively, may be attached to one another in a substantially air-tight manner by means of a heat-sealed connection. The heat-sealed connection forms a sealing seam which seals the packaging with respect to the environment. This is favourable for the quality and shelf life of the packaged cheese.

[0004] If a consumer wants to open the packaging, he or she pulls the lid off the tray, as a result of which the sealing seam between the tray and the lid is severed. If said sealing seam is produced by means of a heat-sealed connection, the consumer has to use significant force in order to achieve this. This adversely affects the ease of use of the packaging. In addition, the lid generally deforms during pulling due to the force which is required. The deformed lid no longer fits the tray very well, which deteriorates resealing of the packaging. The cheese which is returned to the packaging could dry out relatively quickly. After all, there are gaps in the connection between the tray and the deformed lid.

[0005] It is an object of the invention to provide an improved packaging for accommodating a food product.

[0006] According to the invention, this object is achieved in that the lid is provided with a multilayer film which comprises several plastic layers, and the peripheral second collar of the lid comprises at least one line of weakening which is provided in such a manner that a removable tear strip is formed, which at least partly corresponds to the sealing seam, and the line of weakening

is formed by a laser beam. In other words, the collar of the lid comprises at least one line of weakening which defines a removable tear strip, which tear strip at least partially overlaps the sealing seam.

[0007] As the line of weakening is arranged in the peripheral second collar of the lid, a consumer is able to remove the tear strip on the top side of the packaging. This is user-friendly. Incidentally, according to the invention, it is obviously also possible for a line of weakening to be arranged in both peripheral collars, that of the lid and that of the container.

[0008] The line of weakening is produced by a laser beam. Producing a line of weakening by means of a laser beam is referred to by the term laser scoring. By using a laser beam, the depth and the position of the line of weakening can be accurately controlled. Moreover, and in contrast to producing a line of weakening by mechanical means, laser scoring does not result, or hardly results, in wear of the manufacturing equipment.

[0009] The line of weakening runs substantially parallel to and at a distance from the outer edge of the collar of the lid. A consumer who wants to open the packaging first pulls the tear strip loose along the line of weakening. As a result, the connection between the container and the lid which is formed by the sealing seam is weakened or even severed. After all, the line of weakening is aligned with respect to the sealing seam in such a manner that the tear strip, after it has been removed, at least partially exposes the sealing seam. The connection formed by the sealing seam is then at least partially severed. The consumer can subsequently remove the lid from the container in a simple manner. The force which is required to achieve this is relatively limited, which is advantageous with respect to the ease of use. Also, the risk of the lid deforming is reduced, which means that the packaging according to the invention can readily be resealed.

[0010] It should be noted that a packaging for margarine is disclosed in EP 656300. The packaging comprises a tray-like container and a lid. The tray-like container has a cardboard outer layer inside which a plastic inner container is arranged. The plastic inner container and the lid are made by thermoforming a single layer, i.e. the lid does not comprise a multilayer film. Thus, the packaging is not a duo hard packaging. In addition, the lid may have a line of weakening, such as a perforated line, along its periphery, but it is not disclosed that said line of weakening is produced by means of a laser.

[0011] Furthermore, EP 1340693 describes a packaging which comprises a tray and a lidding film. The tray has a foam support which is coated with a liner film having gas-barrier properties. The lidding film is provided on the liner film along a peripheral edge of the tray in such a manner that it can be peeled off. A line of weakening is provided on the bottom side of an enlarged corner region of the peripheral edge of the tray. In order to open the packaging, a user breaks off said corner region along the line of weakening, so that a lip is created by means of which he or she can pull off the lidding film. However, the

lidding film does not form a lid which comprises a multilayer film and therefore this packaging does not constitute a duo hard packaging. Furthermore, the line of weakening is provided in the tray and not in the lid. Producing the line of weakening by means of laser scoring is not disclosed herein either.

[0012] US 3626143 describes a method of forming a line of weakening in a thermoplastic material by means of a laser. However, the use of laser scoring with packaging is not described, particularly not with packaging which comprises a multilayer film lid.

[0013] It should furthermore be noted that a bag-shaped packaging is known from US 5630308. This packaging is formed by two sheets which are laid on top of one another and which are attached to one another at a peripheral edge by means of a sealing seam. The packaging has two parallel laser scores which define a tear strip. This tear strip is at a distance from the sealing seam on the peripheral edge. By removing the tear strip, the front end of the packaging, between the tear strip and the peripheral edge with the sealing seam, is detached, resulting in a permanent opening. This packaging therefore has no tray-shaped container which can be resealed by means of a lid. Also, the tear strip and the sealing seam do not overlap, as the tear strip is entirely adjacent to the sealing seam. As a result, the tear strip according to this known packaging leaves the sealing seam intact. This tear strip is not suitable for weakening the sealing seam.

[0014] According to the invention, producing lines of weakening by laser scoring can be effected by various lasers. For example, a laser having a wavelength of 10-11 μm may be used, such as a CO_2 laser. Due to its absorption properties, this wavelength can be used for many thermoplastics. The laser power is, for example, between 0.1 - 5000 W.

[0015] In one embodiment, the container is provided with a multilayer film which comprises several layers of plastic. It is possible for the multilayer film of the container to comprise, viewed from the outside to the inside, at least a reinforcing layer, a gas-barrier layer and a bonding layer. In this case, said multilayer film may be provided with a water-barrier layer between the reinforcing layer and the gas-barrier layer. Using laser scoring in order to produce a line of weakening in a duo hard packaging offers the advantage that the depth and position of the line of weakening can be accurately controlled. This reduces the risk of the line of weakening affecting the shelf life properties of the packaging. The duo hard packaging contains, for example, cheese which is protected from drying out by the sealed packaging.

[0016] It is furthermore possible for the multilayer film of the lid to comprise, viewed from the outside to the inside, at least a reinforcing layer, a gas-barrier layer and a bonding layer. The multilayer film of the lid may in this case be provided with a water-barrier layer between the reinforcing layer and the gas-barrier layer.

[0017] The abovementioned layers of the container

and the lid may be designed in different ways and comprise different materials. It is also possible for a number of the abovementioned layers to be integrated into a common layer. For example, the multilayer film of the container or the lid comprises a single layer made of a suitable material which combines the functions of the reinforcing layer and the bonding layer.

[0018] In one embodiment, the reinforcing layer comprises amorphous polyethylene terephthalate (APET) and/or the gas-barrier layer comprises ethylene vinyl alcohol (EVOH) and/or the bonding layer comprises polyethylene (PE) and/or the water-barrier layer comprises polyethylene (PE). A film comprising an EVOH layer enclosed by two PE layers is commercially available. In this case, the PE layers are usually attached to the EVOH layer by connecting layers - referred to as tie layers. The APET layer can subsequently be attached to said film in order to form a multilayer film which is provided with, viewed from the outside to the inside, an APET layer, a PE layer, a tie layer, an EVOH layer, a tie layer and a PE layer.

[0019] It is preferable for the line of weakening to have a maximum depth which is smaller than the thickness of the reinforcing layer. As a result, the line of weakening does not go beyond the reinforcing layer. The other layers of the multilayer film are not affected. If the multilayer film is provided with, viewed from the outside to the inside, an APET layer, a PE layer, a tie layer, an EVOH layer, a tie layer and a PE layer, the line of weakening only extends in the APET layer. Since the line of weakening does not reach the EVOH layer, the gas-barrier function of the latter remains intact. The risk of the packaged cheese drying out and rotting is not affected by the line of weakening.

[0020] The multilayer film of the tray-shaped container and the multilayer film of the lid may each be of a different thickness. When the tray-shaped container is formed in a mould, the multilayer film is drawn locally, such as near the corners. Drawing is less important when the lid is being formed. Therefore, the multilayer film of the container is usually thicker than the multilayer film of the lid. The multilayer film of the container is, for example, approximately 250-750 μm , while the lid is formed from a multilayer film having a thickness of approximately 200-500 μm .

[0021] In one embodiment, the bottom is substantially rectangular, and the peripheral wall is provided with four side walls which are attached to one another, the lid being substantially rectangular and the peripheral second collar of the lid comprising two long sides and two narrow sides. In this case, for example, two lines of weakening are provided, each of which extends on opposite long sides of the lid. Each line of weakening forms a respective tear strip. The consumer removes two tear strips on the long sides of the packaging, following which he or she can remove the lid.

[0022] It is also possible for a single line of weakening to be provided which extends at least on a first long side,

a narrow side and a second long side of the peripheral second collar of the lid. Said line of weakening forms a so-called cross-web line of weakening. If the consumer removes the tear strip which is defined by the latter, the sealing seam on several sides of the packaging becomes detached in a single operation.

[0023] In this case, it is preferable if the line of weakening is rounded off between the narrow side and each of the long sides of the peripheral second collar of the lid. When the tear strip is torn along the corner between the narrow side and the long sides, the rounding reduces the risk of the tear strip tearing away from the line of weakening.

[0024] The invention also relates to a method for producing several packagings for accommodating a food product, in particular cheese or cheese slices, comprising:

- providing a first multilayer film,
- forming tray-shaped containers in the first multilayer film, which tray-shaped containers are each provided with a bottom and a standing peripheral wall, which extends from the bottom to an open upper end,
- introducing food products in the tray-shaped containers formed,
- providing a second multilayer film,
- forming lids in the second multilayer film, each of which formed lids corresponds to the open upper end of in each case one container,
- aligning the second multilayer film comprising the formed lids with respect to the first multilayer film comprising the formed tray-shaped containers,
- attaching the first multilayer film to the second multilayer film by providing in each case one peripheral sealing seam around the standing peripheral walls of the formed containers in order to close said containers of the first multilayer film by means of the lids of the second multilayer film,
- cutting the multilayer films which are attached to one another between the sealing seams in order to form individual packagings, each of which have a peripheral first and second collar of the container and the lid, respectively, into which the sealing seam is incorporated,

and in which lines of weakening are provided in the second multilayer film in such a manner that the lines of weakening in said individual packagings extend in the peripheral second collar of the lid, and in which said lines of weakening are provided in such a manner that a removable tear strip is formed in each individual packaging, which at least partially corresponds to the sealing seam of said packaging, and in which the lines of weakening are produced by means of a laser beam.

[0025] In this case, the lines of weakening are preferably provided in the second multilayer film prior to the lids being formed therein. The lines of weakening are, for example, produced in a first line, following which the

multilayer film which has been provided with lines of weakening is rolled up to form a roll, and in which said roll is fed to a second line in which the tray-shaped containers and/or lids are formed. By producing the lines of weakening offline, the packaging line for forming packagings remains unchanged. It is possible, for example, to use a known top-forming packaging line. The lines of weakening provided in the multilayer film do not, or hardly, increase the risk of failures in the packaging line.

[0026] Producing lines of weakening offline is particularly advantageous if they are produced by means of a laser beam. The laser scoring process requires a manufacturing environment which may be different from the packaging line. Laser scoring produces dust, for example, which dust may adversely affect the packaging of a food product. Also, the expertise with respect to laser scoring is greater with producers who specialize therein. The multilayer film which is used in the packaging line is therefore preferably already pre-treated with the lines of weakening formed by laser scoring.

[0027] The invention will be explained in more detail below with reference to the attached drawing, in which:

Fig. 1 shows an exploded perspective view of a first embodiment of a packaging according to the invention;

Fig. 2a shows a cross-sectional view along line IIa-IIa in Fig. 1;

Fig. 2b shows a cross-sectional view along line IIb-IIb in Fig. 1;

Fig. 3a shows a top view of the packaging illustrated in Fig. 1.

Fig. 3b shows a top view of a second embodiment of a packaging according to the invention;

Fig. 3c shows a top view of a third embodiment of a packaging according to the invention;

Fig. 3d shows a top view of a fourth embodiment of a packaging according to the invention; and

Fig. 4 diagrammatically shows a packaging line for producing packagings according to the invention.

[0028] The packaging illustrated in Fig. 1 is denoted in its entirety by reference numeral 1. The packaging 1 is a so-called top-forming packaging or duo hard packaging. The packaging 1 comprises a tray-shaped container 3 and a lid 5. The tray-shaped container 3 can be closed by means of the lid 5. A food product is accommodated in the packaging 1, such as a piece of cheese or slices of cheese (not shown).

[0029] The tray-shaped container 3 comprises a bottom 7 and a standing or upright peripheral wall 8, which extends from the bottom 7. The peripheral wall 8 is closed off at its lower end by the bottom 7. At the top end which is remote from the bottom 7, the tray-shaped container 3 has a peripheral, continuous first collar 12. The peripheral collar 12 projects outwards transversely from the peripheral wall 8. The peripheral collar 12 delimits an opening 14 of the tray-shaped container 3.

[0030] In this exemplary embodiment, the bottom 7 is substantially rectangular. The peripheral wall 8 comprises two long side walls 9 and two narrow side walls 10 which are connected to one another. The peripheral wall 8 has a peripheral groove 11 below the peripheral collar 12. An elongate slot 13 is in each case formed in the peripheral groove 11 on the long side walls 9.

[0031] The lid 5 comprises a peripheral, continuous second collar 16 which corresponds to the peripheral first collar 12 of the tray-shaped container 3. The peripheral second collar 16 has two long sides 17 and two narrow sides 18. When the packaging 1 is closed, the peripheral collars 16, 12 abut one another.

[0032] In this exemplary embodiment, a continuous peripheral edge 24 projects downwards from the peripheral second collar 16, so that the central section 15 of the lid 5 is recessed with respect to said collar 16. The peripheral edge 24 is provided with several lugs 25. The peripheral edge 24 comprising the lugs 25 can be accommodated in the slots 13 of the peripheral groove 11 of the tray-shaped container 3.

[0033] In this exemplary embodiment, the tray-shaped container 3 and the lid 5 are each made from a multilayer film 26 and 36, respectively (see Figs. 2a and 2b). The first multilayer film 26 of the container 3 comprises, for example, viewed from the outside to the inside of the container 3, a reinforcing layer 27, a water-barrier layer 29, a first connecting layer 30 (tie layer), a gas-barrier layer 31, a second connecting layer (tie layer) 32 and a bonding layer 33. The second multilayer film 36 of the lid is composed correspondingly, that is to say, the second multilayer film 36 comprises, viewed from the outside to the inside of the lid 5, a reinforcing layer 27, a water-barrier layer 29, a first connecting layer 30 (tie layer), a gas-barrier layer 31, a second connecting layer (tie layer) 32 and a bonding layer 33. Due to the fact that the peripheral collars 12, 16 project outwards, the inner bonding layers 33 thereof are turned towards one another.

[0034] In this exemplary embodiment, the reinforcing layer 27 comprises APET, while the gas-barrier layer 31 is made of EVOH. The EVOH layer 31 determines the length of the shelf life of the packaged cheese. Both the water-barrier layer 29 and the bonding layer 33 are made from PE. The PE layers 29, 33 protect the interposed EVOH layer 31.

[0035] Incidentally, the thicknesses of the layers of the first multilayer film 26 of the tray-shaped container 3 may differ from the thicknesses of the corresponding layers of the second multilayer film 36 of the lid 5. The total thickness of the first multilayer film 26 of the tray-shaped container 3, for example, is greater than the total thickness of the second multilayer film 36 of the lid 5.

[0036] The peripheral collars 12, 16 are connected to one another by means of a sealing seam 19 (see Fig. 1). The sealing seam 19 runs along the outer edge of the peripheral collars 12, 16. The sealing seam 19 forms a severable connection between the tray-shaped container 3 and the lid 5. The sealing seam 19 is, for example,

formed by a heat-sealed connection. However, the sealing seam 19 can be produced in any suitable manner.

[0037] In the exemplary embodiment illustrated in Fig. 1, two lines of weakening 20 are provided in a section of the peripheral sealing seam 19 - in this exemplary embodiment along the long sides 17 of the peripheral collar 16 of the lid 5. The lines of weakening 20 are in the reinforcing layer 27, as illustrated in Fig. 2b. Between the lines of weakening 20 and the outer edge of said long sides 17, there are two respective tear strips 22. The lines of weakening 20 extend at a distance from the sealing seam 19, so that the sealing seam 19 is completely inside the tear strips 22 on the long sides 17 (see also Fig. 3a). By removing the tear strips 22, the connection between the lid 5 and the tray-shaped container 3 is broken along the long sides 17. The lid 5 can then readily be detached without the lid 5 being deformed.

[0038] Fig. 3b shows a second embodiment of the packaging 1, in which the lines of weakening 20 are aligned with respect to the inside boundary of the sealing seam 19. However, the lines of weakening 20 can also run through the sealing seam 19, as is illustrated in Fig. 3c. The position of the lines of weakening 20 determines the width of the tear strips 22.

[0039] The embodiment of the packaging illustrated in Fig. 3d comprises a line of weakening 20 which extends along a first long side 17, a narrow side 18 and a second long side 17 of the lid 5. The transitions of the lines of weakening 20 between the long sides 17 and the narrow sides 18 comprise a rounding 35. The consumer can tear off the tear strip 22 formed by the line of weakening 20 in a single operation.

[0040] The lines of weakening 20 of the above-described embodiments are produced by means of a laser beam. As a result of using a laser beam, the depth and position of the lines of weakening can be accurately controlled. The depth of the lines of weakening 20 in the APET reinforcing layer 27 is smaller than the thickness of said APET reinforcing layer 27 (see Fig. 2b). As a result, the PE/tie/EVOH/tie/PE layers 29, 30, 31, 32, 33 remain intact. This is particularly favourable for the shelf life of the packaged cheese.

[0041] Fig. 4 diagrammatically shows a packaging line for producing a plurality of packagings. A first multilayer film 26 is fed to a first heating station 41 from a first roll 40. The heated film 26 then passes to a first forming station 42 for forming tray-shaped containers 3 in the film 26. The first forming station 42 comprises, for example, a mould in which the film 26 is formed under the effect of compressed air, vacuum and/or mechanical drawing. The film 26 comprising the formed containers 3 is then passed to a filling station 43. The filling station 43 fills the containers 3 in the film 26 with food products, such as cheese. The film 26 comprising the filled containers 3 then passes to a sealing station 49.

[0042] A second multilayer film 36 is provided on a second roll 45. The second multilayer film 36 on the second roll 45 is already provided with lines of weakening

20. The lines of weakening 20 are produced in the second multilayer film 36 away from the packaging line shown in Fig. 4, that is to say offline. The lines of weakening 20 are for example formed by laser scoring.

[0043] From the second roll 45, the second multilayer film 36 successively passes a second heating station 46 and a second forming station 47. The second heating station 46 heats the second multilayer film 36. The second forming station 47 produces the shape of the lids 5 in the second multilayer film 36. The second multilayer film 36 is fed to the sealing station 49 from above. The exemplary embodiment of the packaging line illustrated in Fig. 4 carries out the so-called top-forming process. The packagings which are formed thereby are referred to as top-forming packagings.

[0044] The first multilayer film 26 comprising the formed containers 3 and the second multilayer film 36 comprising the lids 5 are joined in the sealing station 49. The two multilayer films 26, 36 are in this case aligned in such a manner that each container 3 is covered by a lid 5. In the sealing station 49, a sealing seam 19 is provided around the peripheral wall 8 of each container 3. The packaged food products are then sealed in a substantially air-tight manner. In the sealing station 49, a protective atmosphere can be introduced into the packagings 1, for example by the addition of nitrogen (N₂) and/or carbon dioxide (CO₂). The two films 26, 36 which have been joined to one another are subsequently cut in a cutting station 50 to form individual packagings 1. The second multilayer film 36 from which the lids 5 have been cut, is transported away in an upward direction.

[0045] The invention is not limited to the embodiments illustrated in the figures. Those skilled in the art may propose various modifications which are within the scope of the invention. For example, the lines of weakening may be provided in the tray-shaped container rather than the lid. It is also possible to provide both the lid and the tray-shaped container with lines of weakening. In addition, it is possible to produce the lines of weakening inline, that is to say, the packaging line comprises a (laser) station for producing the lines of weakening.

Claims

1. Packaging for accommodating a food product, in particular cheese or cheese slices, comprising:

- a tray-shaped container (3) which is provided with a bottom (7), a standing peripheral wall (8) which extends from the bottom (7), as well as a peripheral first collar (12), which projects outwards substantially transversely from the peripheral wall (8), and which container (3) is open at an upper end which is remote from the bottom (7),
- a lid (5) for closing the open upper end of the container (3), which lid (5) comprises a peripheral

eral second collar (16) which corresponds to the peripheral first collar (12) of the container (3) and is attached thereto by means of a peripheral sealing seam (19),

characterized in that the lid (5) is provided with a multilayer film (36) which comprises several plastic layers, and the peripheral second collar (16) of the lid (5) comprises at least one line of weakening (20) which is provided in such a manner that a removable tear strip (22) is formed, which at least partly corresponds to the sealing seam (19), and the line of weakening (20) is formed by a laser beam.

2. Packaging according to Claim 1, in which the container (3) is provided with a multilayer film (26) which comprises several layers of plastic.

3. Packaging according to Claim 1 or 2, in which the multilayer film (36) of the lid (5) and/or the multilayer film (36) of the container (3) comprises, viewed from the outside to the inside, at least a reinforcing layer (27), a gas-barrier layer (31) and a bonding layer (33).

4. Packaging according to Claim 3, in which the multilayer film (36) of the lid (5) and/or the multilayer film (36) of the container (3) is provided with a water-barrier layer (29) between the reinforcing layer (27) and the gas-barrier layer (31).

5. Packaging according to Claim 3 or 4, in which the reinforcing layer (27) comprises amorphous polyethylene terephthalate (APET) and/or the gas-barrier layer (31) comprises ethylene vinyl alcohol (EVOH) and/or the bonding layer (33) comprises polyethylene (PE) and/or the water-barrier layer (29) comprises polyethylene (PE).

6. Packaging according to one of Claims 3-5, in which the line of weakening (20) is provided in the reinforcing layer (27) of the multilayer film (36) of the lid (5) and has a maximum depth which is smaller than the thickness of said reinforcing layer (27).

7. Packaging according to one of the preceding claims, in which the bottom (7) is substantially rectangular, and in which the peripheral wall (8) is provided with four side walls (9, 10) which are attached to one another, and in which the lid (5) is substantially rectangular and the peripheral second collar (16) of the lid (5) comprises two long sides (17) and two narrow sides (18).

8. Packaging according to Claim 7, in which two lines of weakening (20) are provided, each of which extends on opposite long sides (17) of the lid (5).

9. Packaging according to Claim 7, in which a single line of weakening (20) is provided which extends at least on a first long side (17), a narrow side (18) and a second long side (17) of the peripheral second collar (16) of the lid (5).
10. Packaging according to Claim 9, in which the line of weakening (20) is rounded off between the narrow side (18) and each of the long sides (17) of the peripheral second collar (16) of the lid (5).
11. Packaging according to one of the preceding claims, in which the packaging (1) contains cheese.
12. Method for producing several packagings (1) for accommodating a food product, in particular cheese or cheese slices, comprising:

- providing a first multilayer film (26),
 - forming tray-shaped containers (3) in the first multilayer film (26), which tray-shaped containers (3) are each provided with a bottom (7) and a standing peripheral wall (8), which extends from the bottom (7) to an open upper end,
 - introducing food products in the tray-shaped containers (3) formed,
 - providing a second multilayer film (36),
 - forming lids (5) in the second multilayer film (36), each of which formed lids (5) corresponds to the open upper end of in each case one container (3),
 - aligning the second multilayer film (36) comprising the formed lids (5) with respect to the first multilayer film (26) comprising the formed tray-shaped containers (3),
 - attaching the first multilayer film (26) to the second multilayer film (36) by providing in each case one peripheral sealing seam (19) around the standing peripheral walls (8) of the formed containers (3) in order to close said containers (3) of the first multilayer film (26) by means of the lids (5) of the second multilayer film (36),
 - cutting the multilayer films (26, 36) which are attached to one another between the sealing seams (19) in order to form individual packagings (1), each of which have a peripheral first and second collar (12, 16) of the container (3) and the lid (5), respectively, into which the sealing seam (19) is incorporated,
- and in which lines of weakening (20) are provided in the second multilayer film (36) in such a manner that the lines of weakening (20) in said individual packagings (1) extend in the peripheral second collar (16) of the lid (5), and in which said lines of weakening (20) are provided in such a manner that a removable tear strip (22) is formed in each individual packaging (1), which at least partially corresponds to the sealing

seam (19) of said packaging (1), and in which the lines of weakening (20) are produced by means of a laser beam.

- 5 13. Method according to Claim 12, in which the lines of weakening (20) are provided in the second multilayer film (36) prior to the lids (5) being formed therein.
- 10 14. Method according to Claim 13, in which the lines of weakening (20) are produced in a first line, following which the multilayer film (26, 36) which has been provided with lines of weakening (20) is rolled up to form a roll, and in which said roll (45) is fed to a second line in which the tray-shaped containers (3) and/or lids (5) are formed.
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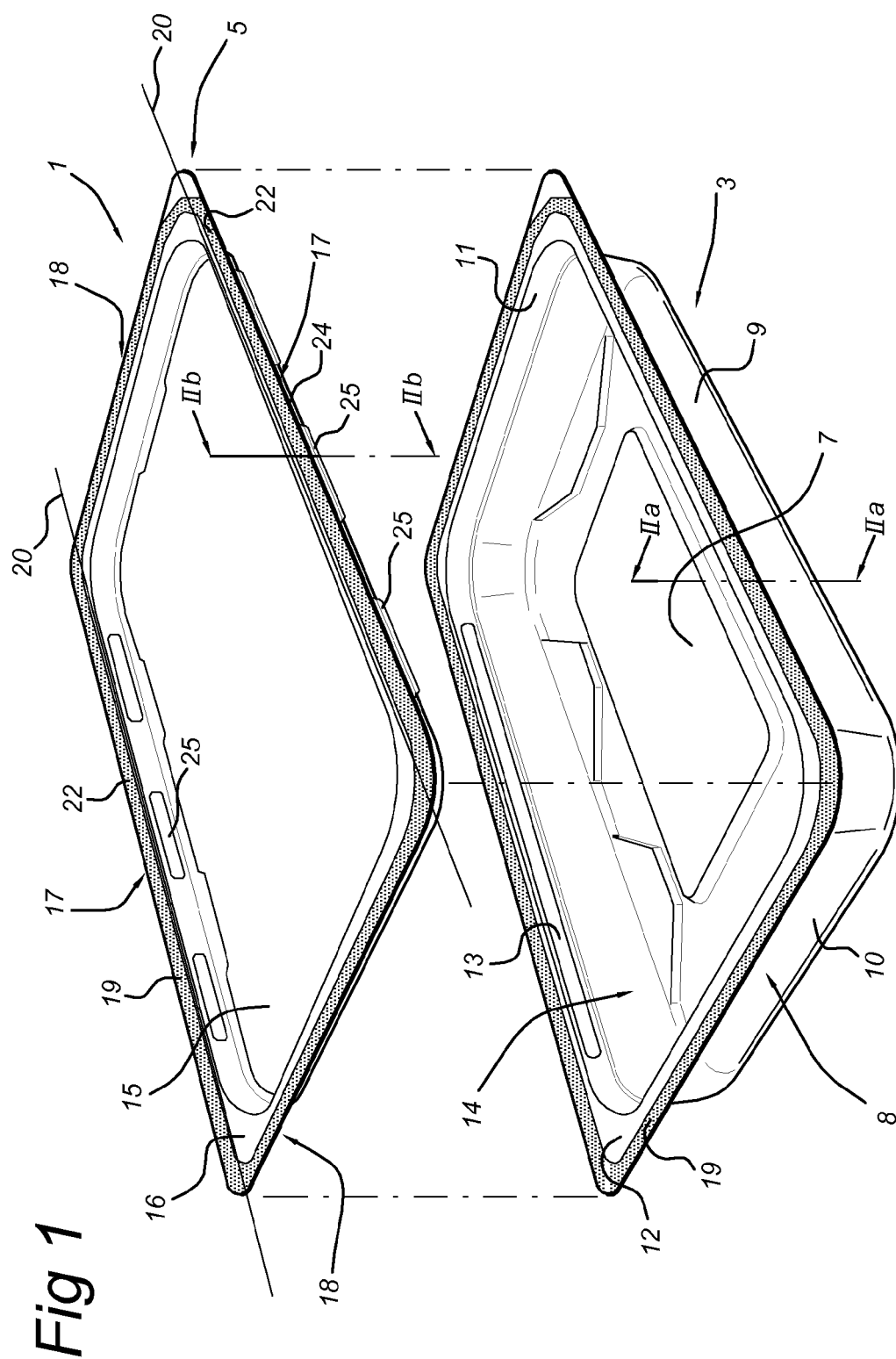


Fig 2a

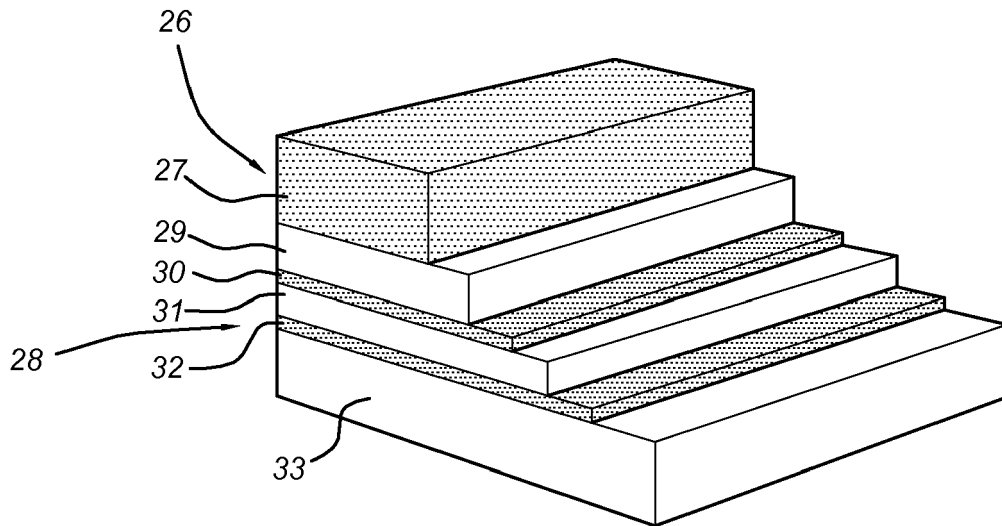


Fig 2b

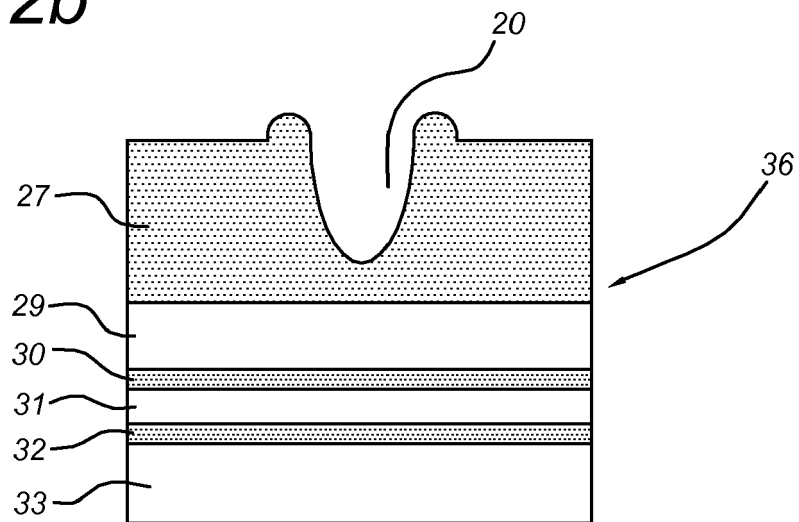


Fig 3a

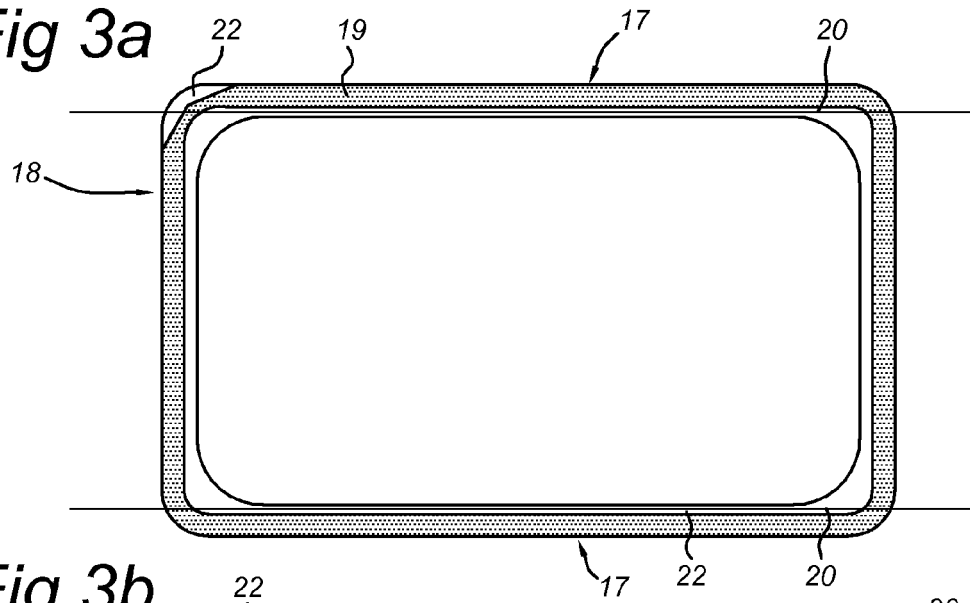


Fig 3b

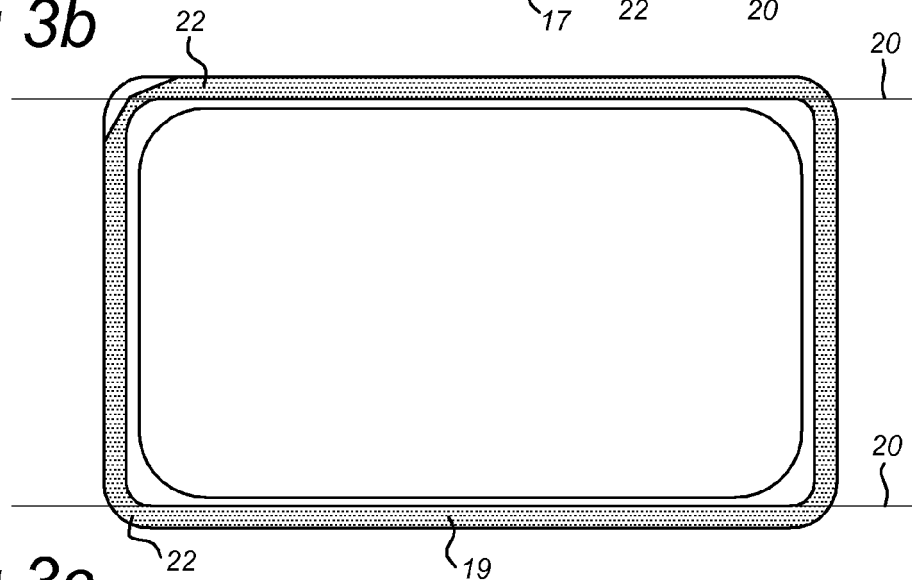


Fig 3c

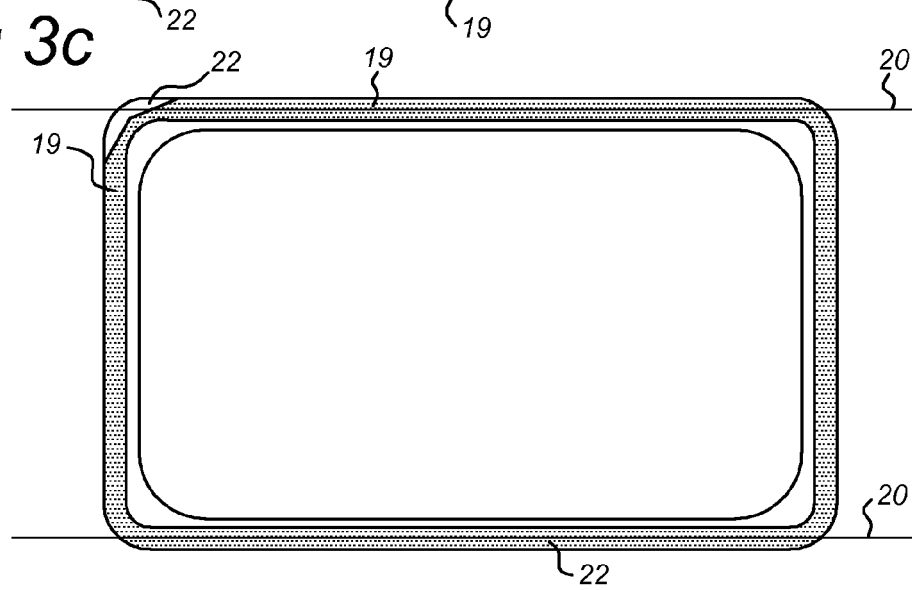
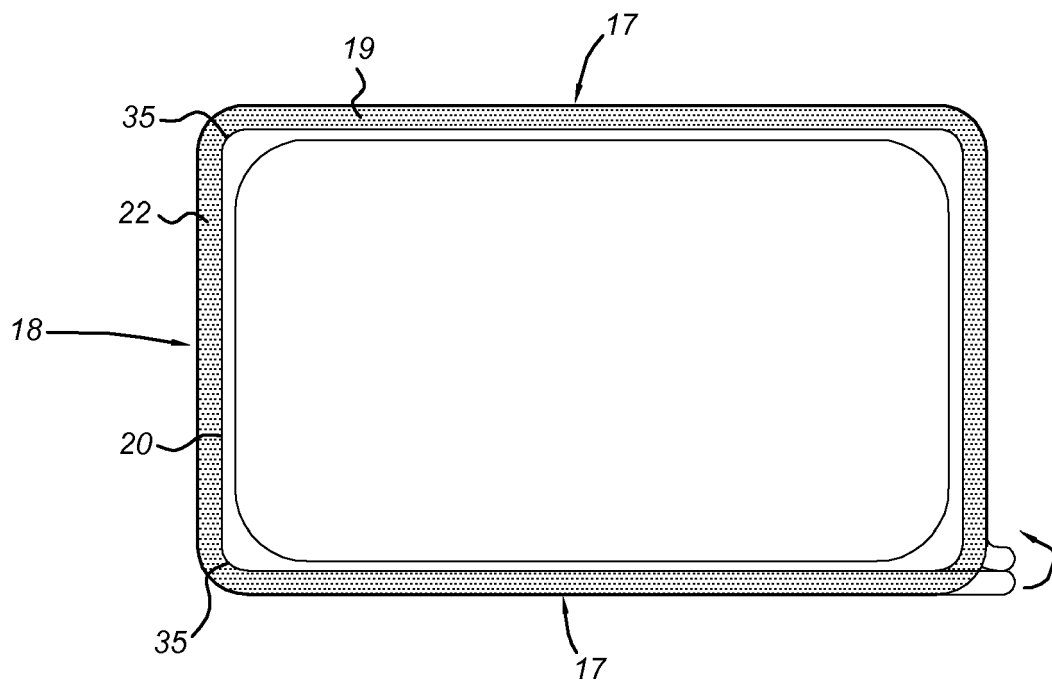
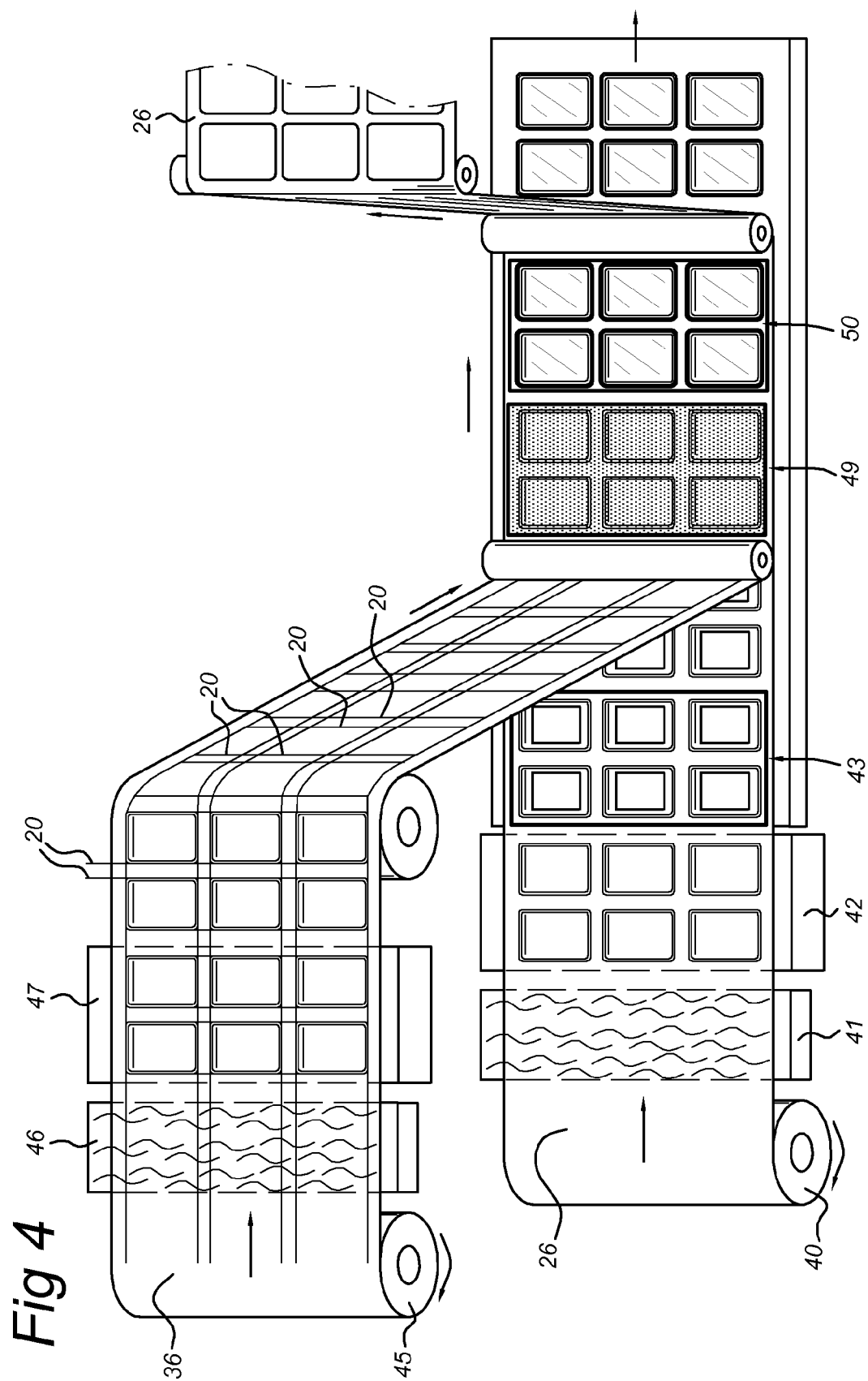


Fig 3d





REFERENCES CITED IN THE DESCRIPTION

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