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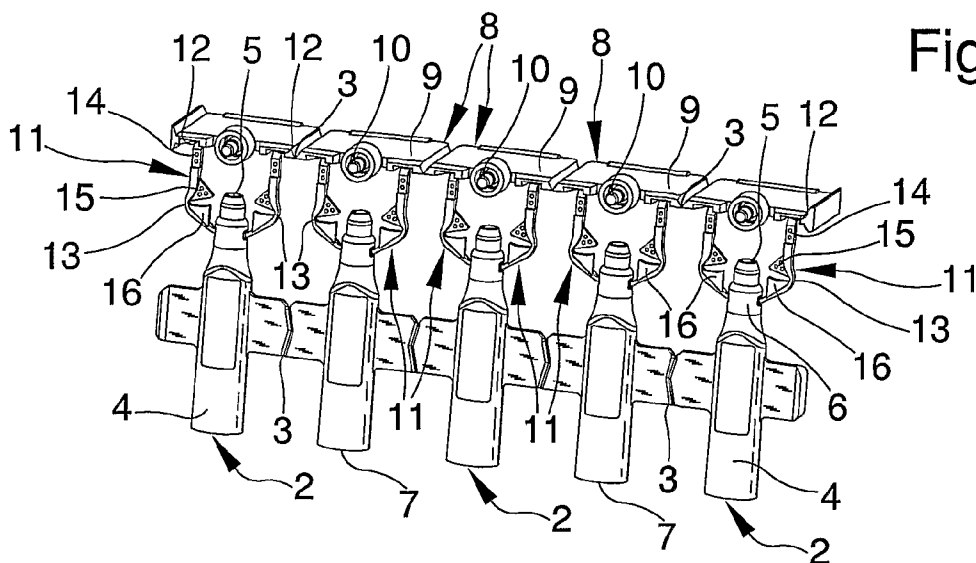


Fig. 1

(57) Abstract: The procedure for manufacturing bottles (2) containing fluids, particularly- cosmetic, medical, pharmaceutical products or the like, comprises a forming phase of a hollow body (4) having a dispensing mouth (5) that can be closed by means of removable closing means (8) comprising shutter means (10) that can be coupled with the mouth, the closing means being made in a single body with the hollow body. During the forming phase, the closing means are arranged with the shutter means substantially transversal to the direction of coupling with the dispensing mouth. After the forming phase a coupling" phase is contemplated of the shutter means with the dispensing mouth.

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PROCEDURE FOR MANUFACTURING BOTTLES CONTAINING FLUIDS, PARTICULARLY COSMETIC, MEDICAL, PHARMACEUTICAL PRODUCTS OR THE LIKE, AND RELATIVE SYSTEM AND BOTTLES

SYSTEM

5 Technical Field

This invention relates to a procedure for manufacturing bottles containing fluids, particularly cosmetic, medical, pharmaceutical products or the like, and relative system.

Background Art

10 Re-closable plastic containers are known for pharmaceutical, cosmetic or other products, which are made by blowing and/or moulding, in two parts, one of which is composed of the container body, while the other part is composed of closing means, to keep the container closed after its manufacture and to close it again after use.

15 In these containers, the closing means remain fitted in the neck of the container, or coupled with this, until this is opened for the first time to be used.

Consequently, the part of the closing means in contact with the container neck is protected against external polluting agents, which cannot deposit on this and, therefore, the risk of said polluting agents being accidentally introduced inside
20 the container when this is closed again after a first use with the same closing means is extremely limited.

The above containers are nevertheless costly to make as they require separate moulds for the two parts of the container, which also have to be assembled after moulding.

25 Re-closable plastic containers are also known, for pharmaceutical, cosmetic or other products, which are made by blowing and/or moulding in a single piece, in which i.e., the container body is made in a single piece with the closing means suitable for keeping the container closed after its manufacture and/or for closing this after use.

30 A container of this type is the subject of the Italian utility model patent Nr. 199.776, which describes a single-dose or multi-dose container for pharmaceutical products comprising a body having a lower opening sealable by

sealing and an upper neck, closed on top by closing means in the form of a peduncle, obtained all one piece with it and with a cap having shutter means to close the container neck again after this has been opened by tearing the peduncle, the shutter means being obtained on the part of the cap turned in the
5 opposite direction with respect to the container neck.

These containers are undoubtedly cheaper to make than the previous ones, but have the drawback that the closing means have to be obtained on the outside of the container during moulding.

The part of the closing means that has to be used to close the container again
10 after use, in point of fact remains exposed to external polluting agents which can thus easily enter the inside of the container when this is closed again after a first use.

This circumstance is considerably hazardous, especially in the case of the containers being used to contain pharmaceutical substances.

15 A further type of re-closable containers made in a single piece is the subject of the industrial invention patent nr. 1.287.450 and consists of a hollow body, having a dispensing mouth, and of a closing cap that has a shutter pin obtained on the part turned towards the mouth.

During moulding, in point of fact, the hollow body and the cap are made
20 slightly distanced the one from the other, with the shutter pin aligned and facing the dispensing mouth, but not in contact with this.

Furthermore, the hollow body and the cap are connected together by means of a pair of thin straps which, after moulding, allow these to be moved closer or away from each other to allow the coupling/uncoupling of the shutter means
25 with/from the dispensing mouth.

This latter type of containers also has several drawbacks however, including the fact that they require particularly complex moulds, that are difficult to make, and do not permit obtaining high-quality containers.

In this respect, it should be considered that the traditional moulds usually
30 consist of a pair of half-shells inside which a core can be fitted for forming the inner surface of the hollow body.

At the shutter pin, the bringing together of the two half-shells determines the

formation of a thin line of burr.

Such line of burr extends along the entire length of the pin and is such as to prevent the sealed coupling of the shutter pin with the mouth of the container in closing configuration.

- 5 There is therefore a very high risk of negatively affecting the sterility of the product inside the container.

Object of the Invention

Such previous state of the art is liable to considerable upgrading as regards the possibility of eliminating the drawbacks indicated above.

- 10 From what has been said above, in fact, the need arises to solve the technical problem of providing a procedure and a system for manufacturing bottles containing fluids, particularly cosmetic, medical, pharmaceutical products or the like, that permit making, in a practical, easy and inexpensive way, bottles which, after being opened, can be closed again so as to reduce to the utmost the
15 risk of polluting the substance they contain.

- Another object of the present invention is to find a procedure and a system for manufacturing bottles containing fluids, particularly cosmetic, medical, pharmaceutical products or the like, that permit overcoming the above-mentioned drawbacks of the state of the art within the framework of a simple,
20 rational, easy and effective-to-use and inexpensive solution.

The above objects are achieved by the procedure for manufacturing bottles containing fluids, particularly cosmetic, medical, pharmaceutical products or the like, comprising the following steps:

- forming at least a hollow body having at least a dispensing mouth that can
25 be closed by means of removable closing means comprising shutter means that can be coupled with said mouth, said closing means being made in a single body with said hollow body;

- coupling said shutter means with said mouth;
characterized by the fact that, during said forming, said closing means are
30 arranged with said shutter means substantially transversal to the direction of coupling with said mouth.

The above-mentioned objects are also achieved by the present system for

manufacturing bottles containing fluids, particularly cosmetic, medical, pharmaceutical products or the like, comprising at least a forming station for forming at least a bottle having at least a hollow body, at least a dispensing mouth obtained on said hollow body, removable closing means for closing said mouth comprising shutter means that can be coupled with the mouth, and connection means placed in between said closing means and said hollow body and suitable for leaving reciprocal movement between said closing means and said hollow body, said forming station comprising at least an outer mould hollow inside and at least an inner core that can be fitted in said mould to define, between the mould and the core, an inter-space for the formation in single body of said bottle, characterized by the fact that, during forming inside said inter-space, said closing means are arranged with said shutter means substantially transversal to the direction of coupling with said mouth.

Brief Description of the Drawings

- 15 Further characteristics and advantages of the present invention will appear more evident from the description of a preferred, but not only embodiment of a system for manufacturing bottles containing fluids, particularly cosmetic, medical, pharmaceutical products or the like, illustrated indicatively by way of non limiting example, in the attached drawings wherein:
- 20 Figure 1 is an axonometric view of a strip of bottles obtained with the system according to the invention, arranged in the first operating configuration;
Figure 2 is an axonometric view of the strip of figure 1 with the bottles arranged in the second operating configuration;
Figure 3 is an axonometric view of the strip of figure 1 with the bottles
25 arranged in the closing configuration of the dispensing mouths;
Figure 4 is a front, schematic and partial view of the forming station contemplated by the system according to the invention;
Figure 5 is a section view along the V – V plane of figure 4;
Figure 6 is a plan, schematic and partial view that shows the forward moving
30 line contemplated by the system according to the invention for making the processing phases after forming;
Figures from 7 to 11 show, in a sequence of side raised views, the operation of

the coupling station contemplated by the system according to the invention; Figures from 12 to 14 show, in a sequence of side raised views, the operation of the blockage station contemplated by the system according to the invention.

Embodiments of the Invention

5 With particular reference to such figures, by 1 is generally indicated a system for manufacturing bottles containing fluids, particularly cosmetic, medical, pharmaceutical products or the like.

With particular reference to such embodiment of the invention shown in the illustrations, the bottles 2 obtained by means of the system 1 are made in series
10 to form strips of five pieces each, joined together along weakened temporary connection segments 3.

Different embodiments of the invention cannot however be ruled out in which the bottles 2 are made individually, or in strips with quantities of bottles 2 different to those shown in the illustrations.

15 Each bottle 2 comprises a hollow body 4 made of plastic intended for the future containing of the fluid product.

At one end, the hollow body 4 has a mouth 5 for dispensing the fluid product.

In particular, the hollow body 4 has a substantially tubular and elongated shape, and the above end of the hollow body 4 extends into a neck 6, at the top of
20 which the mouth 5 is defined.

At the end of the hollow body 4 opposite the neck 6 an opening 7 is defined for introducing the product; the closing of the opening 7 (e.g., by sealing the lips of the opening itself) is done once the product has been introduced inside.

Furthermore, each bottle 2 comprises closing means 8 for closing the mouth 5,
25 of the removable type and which can be associated with the hollow body 4 at the neck 6.

In detail, the closing means 8 consist of a grip 9 supporting shutter means 10 engageable at the mouth 5.

In the particular embodiment of the invention shown in the illustrations, the grip
30 9 is substantially defined plate-shaped and the shutter means 10 are composed of a small pin that can be fitted sealed inside the mouth 5.

The operating surface of the small pin 10, meaning by operating surface that

intended to come into contact with the mouth 5 to ensure its seal, consists in practice of a cylindrical surface complementary to that of the inner surface of the mouth 5.

Alternative manufacturing solutions are however possible where the grip 9 and the small pin 10 have different shapes.

Between the grip 9 and the neck 6 connection means 11 are placed suitable for leaving reciprocal movement between the closing means 8 and the hollow body 4.

The connection means 11, in particular, are composed of two straps of elongated shape, that extend from the hollow body 4 to the closing means 8 and are arranged from parts diametrically opposite the neck 6.

Each strap 11 has a first segment 12 with weakened section, which is obtained at the point of joining to the grip 9 and is suitable for allowing the rotation of the closing means 8 between a first operating configuration, in which the small pin 10 is arranged substantially at right angles to the direction of coupling to the mouth 5 (figure 1), and a second operating configuration, in which the shutter means 10 are turned towards and aligned with the mouth 5 (figure 2).

Furthermore, the straps 11 have a second segment 13 with weakened section, which is obtained in substantially median position with respect to the entire length of the straps 11 and which is suitable for allowing the bending of the straps themselves between the second operating configuration and the closing configuration of the mouth 5 (figure 3).

In detail, the straps 11 have a first portion 14, that extends between the first segment 12 and the second segment 13 and which can be superimposed on the grip 9 during switch from the first to the second operating configuration.

Furthermore, astride the second segments 13, the straps 11 have a second portion 15 and a third portion 16 which are superimposable during switch from the second operating configuration to the closing configuration of the mouth 5.

The bottle 2 comprises locking means for locking the straps 11 in the closing configuration of the mouth 5.

Such locking means consist, e.g., of a first sealing point 17 of the first portions 14 with the grip 9 superimposed the one on the other, and of a second sealing

point 18 of the second and the third portions 15 and 16 superimposed the one on the other.

The fitting of the locking means 17 and 18 does in fact strengthen the straps 11 and makes them suitable to act as a seal of guarantee, because they do not allow
5 their elastic deformation and do not allow the bottle 2 to be opened without their being broken.

For the manufacture of the bottles 2, the system 1 contemplates a forming station 19 for the formation of the strips of bottles 2 (figures 4 and 5).

The forming station 19 has an outer mould 20, hollow inside, and a plurality of
10 inner cores 21 that can be fitted in the outer mould 20 so as to define between the mould 20 and the cores 21 an inter-space 22 for the formation in a single body of the strip of bottles 2.

The outer mould 20 and the inner cores 21 are shaped so that, during forming inside the inter-space 22, the closing means 8 of the bottles 2 are arranged with
15 the shutter means 10 substantially transversal, in particular at right angles, to the direction of coupling to the mouth 5.

In detail, the outer mould 20 comprises a first shaped shell 23 and a second shaped shell 24, separable from each other and having cavities 25 that can be reciprocally coupled together to form corresponding portions of the surface of
20 the bottles 2.

Advantageously, the cavity 25a intended for forming the operating surface of the small pin 10 are entirely obtained in just one of the shaped shells, and in particular in the first shaped shell 23.

At the above cavity 25a, furthermore, the first shaped shell 23 has a gap 26
25 suitable for introducing a dispenser nozzle 27 which permits injecting plastic material under pressure in fluid state inside the inter-space 22.

The outer mould 20, furthermore, comprises a third shaped shell 28, suitable for cooperating with the first and the second shaped shells 23 and 24 for forming the grip 9 of the closing means 8.

30 Different embodiments of the outer mould 20 cannot however be ruled out in which, e.g. the third shaped shell 28 is obtained integral with the second shaped shell 24.

Coming out of the forming station 19, in point of fact, the bottles 2 are arranged in the first operating configuration.

For the working phases of the bottles 2 subsequent to forming, the system 1 has a forward moving line 29 of the bottles 2 located downstream of the forming station 19 (figure 6).

Such forward moving line comprises a guide rail 30 that is engaged sliding by a plurality of slides 31 which support the bottles 2.

In the particular embodiment shown in figure 6, each slide 31 is sized to carry a single strip of bottles 2, but it is easy to appreciate how these can usefully have different shapes and dimensions according to the type of bottles 2 and/or of strips of bottles 2 to be conveyed.

The guide rail 30 extends from a loading station 32, where the bottles 2 just formed are collected and arranged above the slides 31, as far as a working cabin 33, containing the remaining stations (34, 35, 36 and 37) for working the bottles 2.

Inside the working cabin 33, the forward moving line 29 branches out.

This does in fact have an auxiliary segment 38 for moving the bottles 2, which is arranged parallel with the guide rail 30, and conveyor means 39, of the shuttle type or the like, that allow moving the bottles 2 from the guide rail 30 to the auxiliary segment 38.

Inside the working cabin 33, a coupling station 34 is located suitable for coupling the closing means 8 to the mouths 5 of the bottles 2.

Such coupling station comprises: a base frame 40 arranged along the guide rail 30; first grip means 41 of the hollow bodies 4 of the bottles 2; second grip means 42 of the grips 9 of the bottles 2; rotation means 43 for placing in relative rotation the first grip means 41 and the second grip means 42 around a work axis A substantially at right angles to the small pins 10 of the bottles 2, suitable for rotating the first grip means 41 with respect to the second grip means 42 until the small pins 10 of the bottles 2 are aligned with the mouths 5 of the bottles themselves; relative bringing closer means 44 of the closing means 8 and of the hollow bodies 4 of the bottles 2 until the small pins 10 are associated with the mouths 5.

The first grip means 41, in detail, consist of a first vice defined by a stop element 45, associated integral with the base frame 40 above the guide rail 30, and by a lifting element 46 for lifting the slides 31.

The lifting element 46, in point of fact, is suitable for vertically moving the slide
5 31 that transits in the coupling station 34 and firmly positioning the hollow bodies 4 of the bottles 2 between the stop element 45 and the above slide 31.

The second grip means 42 consist of a second vice associated with the base frame 40 by interposition of the rotation means 43 and of the relative bringing closer means 44.

10 The rotation means 43, in particular, are composed of a bracket, of the type of a plate or the like, which is fitted on the base frame 40 in a way turnable around the work axis A and which supports the second grip means 42 and the relative bringing closer means 44.

The start of rotation of the bracket 43 is triggered by means of a first linear
15 actuator 47, of the type of a pneumatic jack, the liner of which is hinged to the base frame 40 and the stem of which is hinged to the bracket 43.

The relative bringing closer means 44 are defined by a support body which supports the second grip means 42 and which is fitted on the bracket 43 in a way sliding along a direction substantially at right angles to the work axis A.

20 The movement of the support body 44 is triggered by means of a second linear actuator 48, of the type of a pneumatic jack, the liner of which is fitted integral on the bracket 43 and the stem of which drives the support body 44.

The second grip means 42 consist of a first jaw 49, associated integral with the support body 44 and of a second jaw 50 associated with the support body 44 in
25 a way sliding along a closing and opening direction of the vice.

The movement of the second jaw 50 with respect to the first jaw 49 is triggered by means of a third linear actuator 51, of the type of a pneumatic jack, the liner of which is integral with the support body 44 and the stem of which drives the second jaw 50.

30 In point of fact, the bottles 2, which are still arranged in the first operating configuration, reach the coupling station 34 along the guide rail 30 (figure 7) and are lifted with respect to the forward moving line 29 until the hollow bodies

4 are trapped in the first vice 41 and the closing means 8 are placed between the open jaws 49 and 50 of the second vice 42, which promptly close (figure 8).

Starting from this position, the starting in series of the first linear actuator 47 and of the second linear actuator 48 initially allows positioning the bottles 2 in the second operating configuration (figure 9) and, therefore, placing them in the
5 closing configuration of the mouths 5 (figure 10).

Afterwards, by means of the opening of the second vice 42, the moving away of the support body 44 from the bottles 2 and the rotation of the bracket 43 (figure 11), the bottles 2 can be returned to the guide rail 30 to continue their travel
10 along the forward moving line 29 and reach a blockage station 35 of the straps 11 of the bottles 2 in the closing configuration of the mouths 5.

Such blockage station is arranged along the auxiliary segment 38 of the forward moving line 29 and has a base 52 that supports a sealing apparatus 53, suitable for sealing the straps 11, and movement means 54 for moving the bottles 2,
15 suitable for transferring the bottles 2 from the auxiliary segment 38 to the sealing apparatus 53 and vice versa.

The movement means 54 have a grip element 55 for gripping the bottles 2, of the type of one or more suction-cups, which is mounted on a series of sliding actuators 56 that make it mobile between the auxiliary segment 38 of the
20 forward moving line 29 and the sealing apparatus 53.

The sealing apparatus 53 has a plurality of attachment bodies 57 for gripping the bottles 2 once these have been released from the grip element 55.

The attachment bodies 57 consist, e.g., of a series of elongated and horizontal pintles, which can be fitted in the inner cavities of the hollow bodies 4 through
25 the openings 7 of the bottles 2.

The sealing apparatus 53 comprises placing means for placing the bottles 2 against a locator plate 58.

These placing means consist of an actuator device 59 that permits moving the attachment bodies 57 along a vertical direction closer to and away from the
30 locator plate 58.

Over the locator plate 58, heating means 60 are located, which move vertically to be positioned in contact with the straps 11 of the bottles 2 and apply the

sealing points 17 and 18.

Such heating means, in detail, are defined by a hot punch, suitable for crushing the straps 11 of the bottles 2 against the locator plate 58.

In point of fact, the bottles 2 coming from the coupling station 34, are conveyed
5 from the guide rail 30 to the auxiliary segment 38 of the forward moving line 29 by means of the shuttle 39, and from here (figure 12) they are picked up by the grip element 55 and placed on the pintles 57 (figure 13).

After the pintles 57, first, and the hot punch 60, next, have dropped, the sealing points 17 and 18 are applied to the straps 11 (figure 14).

10 Repeating the movement of the hot punch 60, of the pintles 57 and of the grip element 55 in reverse, the bottles 2 can be returned to the auxiliary segment 38 of the forward moving line 29 to be conveyed to a control station 36, suitable for checking the coupling seal between the small pins 10 and the mouths 5 of the bottles 2, and, finally, to a packaging station 37.

15 With reference to the preferred, but not only embodiment, of the system 1 as described and illustrated, the procedure for manufacturing bottles containing fluids, particularly cosmetic, medical, pharmaceutical products or the like, comprises the following steps:

- 20 - forming of the bottles 2 by the injection moulding of plastic material in fluid state, so that, during forming, the closing means 8 are arranged with the small pins 10 substantially transversal, and in particular at right angles, to the direction of coupling to the mouths 5;
- coupling the shutter means 10 to the mouths 5, by turning the closing means 8 with respect to the hollow bodies 4 until the small pins 10 are aligned with
25 the mouths 5 and moving the closing means 8 close to the hollow bodies 4 until the small pins 10 are associated with the mouths 5;
- fastening by sealing the straps 11 of the bottles 2 in the closing configuration of the mouths 5, the fastened straps 11 being suitable to act as a guarantee seal.

30 It has in point of fact being ascertained how the described invention achieves the proposed objects.

The invention thus conceived is susceptible to numerous modifications and

variations, all of which falling within the scope of the inventive concept.

Furthermore all the details can be replaced with others that are technically equivalent.

In practice, the materials used, as well as the contingent shapes and dimensions,
5 may be any according to requirements without because of this moving outside
the protection scope of the following claims.

CLAIMS

- 1) Procedure for manufacturing bottles containing fluids, particularly cosmetic, medical, pharmaceutical products or the like, comprising the following steps:
- 5 - forming at least a hollow body having at least a dispensing mouth that can be closed by means of removable closing means comprising shutter means that can be coupled with said mouth, said closing means being made in a single body with said hollow body;
- coupling said shutter means with said mouth;
- 10 characterized by the fact that, during said forming, said closing means are arranged with said shutter means substantially transversal to the direction of coupling with said mouth.
- 2) Procedure according to claim 1, characterized by the fact that, during said forming, said closing means are arranged with said shutter means substantially
- 15 at right angles to the direction of coupling of said shutter means with said mouth.
- 3) Procedure according to one or more of the preceding claims, characterized by the fact that said coupling comprises turning said closing means with respect to said hollow body until said shutter means are aligned with said mouth, and
- 20 moving said closing means close to said hollow body until said shutter means are associated with said mouth.
- 4) Procedure according to one or more of the preceding claims, characterized by the fact that said forming is obtained by the injection moulding of plastic material.
- 25 5) Procedure according to one or more of the preceding claims, characterized by the fact that said forming comprises injecting plastic material in fluid state inside a mould comprising at least a first shaped shell and a second shaped shell, separable from each other and having cavities that can be reciprocally coupled together to form corresponding portions of the surface of said bottle, the cavities
- 30 intended for forming the operating surface of said shutter means being entirely obtained in just one of said shells.
- 6) Procedure according to one or more of the preceding claims, characterized

by the fact that said forming comprises defining connection means placed in between said closing means and said hollow body and suitable for leaving reciprocal movement between said closing means and said hollow body.

7) Procedure according to one or more of the preceding claims, characterized
5 by the fact that said connection means comprise at least a thin strap.

8) Procedure according to one or more of the preceding claims, characterized by the fact that it comprises fastening said connection means in the closing configuration of said mouth, the fastened connection means being suitable to act as a guarantee seal.

10 9) Procedure according to one or more of the preceding claims, characterized by the fact that said fastening comprises hot sealing said strap.

10) System for manufacturing bottles containing fluids, particularly cosmetic, medical, pharmaceutical products or the like, comprising at least a forming station for forming at least a bottle having at least a hollow body, at least a
15 dispensing mouth obtained on said hollow body, removable closing means for closing said mouth comprising shutter means that can be coupled with the mouth, and connection means placed in between said closing means and said hollow body and suitable for leaving reciprocal movement between said closing means and said hollow body, said forming station comprising at least an outer
20 mould hollow inside and at least an inner core that can be fitted in said mould to define, between the mould and the core, an inter-space for the formation in single body of said bottle, characterized by the fact that, during forming inside said inter-space, said closing means are arranged with said shutter means substantially transversal to the direction of coupling with said mouth.

25 11) System according to claim 10, characterized by the fact that, during forming inside said inter-space, said closing means are arranged with said shutter means substantially at right angles to the direction of coupling with said mouth.

12) System according to one or more of the preceding claims, characterized by the fact that said mould comprises at least a first shaped shell and a second
30 shaped shell, separable from each other and having cavities that can be reciprocally coupled together to form corresponding portions of the surface of said bottle, the cavities intended for forming the operating surface of said

shutter means being entirely obtained in just one of said shells.

13) System according to one or more of the preceding claims, characterized by the fact that said mould comprises at least a third shaped shell suitable for cooperating with at least one between said first and second shells for forming a
5 grip of said closing means.

14) System according to one or more of the preceding claims, characterized by the fact that said inter-space is shaped to define a plurality of said bottles joined together in a strip.

15) System according to one or more of the preceding claims, characterized by
10 the fact that it comprises at least a forward moving line of said bottles located downstream of said forming station.

16) System according to one or more of the preceding claims, characterized by the fact that said forward moving line comprises a guide rail that is engaged sliding by at least a slide which supports said bottles.

15 17) System according to one or more of the preceding claims, characterized by the fact that said forward moving line comprises an auxiliary segment for moving said bottles and conveyor means of said bottles between said guide rail and said auxiliary segment.

18) System according to one or more of the preceding claims, characterized by
20 the fact that it comprises at least a coupling station for coupling said closing means to said mouths of the bottles.

19) System according to one or more of the preceding claims, characterized by the fact that said coupling station is arranged along said forward moving line.

20) System according to one or more of the preceding claims, characterized by
25 the fact that said coupling station comprises at least a base frame, first grip means of said hollow bodies of the bottles, second grip means of said closing means of the bottles, rotation means for placing in relative rotation said first grip means and said second grip means around a work axis substantially at right angles to said shutter means of the bottles, until said shutter means are aligned
30 with said mouths of the bottles, and relative bringing closer means of said closing means and of said hollow bodies until said shutter means are associated with said mouths.

- 21) System according to one or more of the preceding claims, characterized by the fact said first grip means comprise at least a first vice having at least a stop element associated with said base frame above said forward moving line and having at least a lifting element for lifting said slide suitable for positioning said bottles between said stop element and said slide.
- 22) System according to one or more of the preceding claims, characterized by the fact that said second grip means comprise at least a second vice associated with said base frame by interposition of said rotation means and of said relative bringing closer means.
- 23) System according to one or more of the preceding claims, characterized by the fact that said rotation means comprise at least a bracket, which is associated with said base frame in a way turnable around said work axis and supporting said second grip means and said relative bringing closer means.
- 24) System according to one or more of the preceding claims, characterized by the fact that said relative bringing closer means comprise at least a support body supporting said second grip means which is fitted on said bracket in a way sliding along a direction substantially at right angles to said work axis.
- 25) System according to one or more of the preceding claims, characterized by the fact that said second grip means comprise at least a first jaw associated integral with said support body and at least a second jaw associated with said support body in a way sliding along a closing and opening direction of the vice.
- 26) System according to one or more of the preceding claims, characterized by the fact that it comprises at least a blockage station of said connection means of the bottles in the closing configuration of said mouths.
- 27) System according to one or more of the preceding claims, characterized by the fact that said blockage station is arranged along said forward moving line.
- 28) System according to one or more of the preceding claims, characterized by the fact that said blockage station comprises a supporting base that supports at least a sealing apparatus, suitable for sealing said connection means, and movement means for moving said bottles between said forward moving line and said sealing apparatus.
- 29) System according to one or more of the preceding claims, characterized by

the fact that said movement means comprise at least a grip element for gripping said bottles that is associated with said base in a mobile way between said forward moving line and said sealing apparatus.

30) System according to one or more of the preceding claims, characterized by
5 the fact that said grip element is of the suction-cup type.

31) System according to one or more of the preceding claims, characterized by the fact that said sealing apparatus comprises at least an attachment body for gripping the bottles released from said movement means.

32) System according to one or more of the preceding claims, characterized by
10 the fact that said attachment body comprises at least an elongated pintle, which can be fitted into a cavity of said bottles.

33) System according to one or more of the preceding claims, characterized by the fact that said sealing apparatus comprises placing means of said bottles against a locator plate.

15 34) System according to one or more of the preceding claims, characterized by the fact that said placing means comprise at least an actuator device that moves said attachment body along a direction closer to and away from said locator plate.

35) System according to one or more of the preceding claims, characterized by
20 the fact that said sealing apparatus comprises heating means which can be positioned in contact with said connection means of the bottles.

36) System according to one or more of the preceding claims, characterized by the fact that said heating means comprise at least a hot punch, suitable for crushing said connection means of the bottles against said locator plate.

25 37) Bottle for containing fluids, particularly cosmetic, medical, pharmaceutical products or the like, comprising at least a hollow body having at least a dispensing mouth, removable closing means of said mouth having shutter means that can be coupled with the mouth, and connection means placed in between said closing means and said hollow body and suitable for leaving reciprocal
30 movement between said closing means and said hollow body, said hollow body, said closing means and said connection means being made in a single body, characterized by the fact that said connection means comprise at least a strap

that extends from said hollow body to said closing means and has a first segment with weakened section, suitable for allowing the rotation of said closing means between a first operating configuration, in which said shutter means are arranged substantially transversal to the direction of coupling to said mouth, and a second operating configuration, in which said shutter means are turned towards and aligned with said mouth.

38) Bottle according to claim 37, characterized by the fact that said strap comprises at least a second segment with weakened section, suitable for allowing the bending of the strap itself between said second operating configuration and the closing configuration of said mouth.

39) Bottle according to one or more of the preceding claims, characterized by the fact that said strap comprises at least a first portion which is superimposable with said closing means during switch from said first operating configuration to said second operating configuration.

40) Bottle according to one or more of the preceding claims, characterized by the fact that said strap comprises at least a second and a third portions which are superimposable the one on the other during switch from said second operating configuration to the closing configuration of said mouth.

41) Bottle according to one or more of the preceding claims, characterized by the fact that it comprises locking means of said connection means in the closing configuration of said mouth, the fastened connection means being suitable to act as a guarantee seal.

42) Bottle according to one or more of the preceding claims, characterized by the fact that said locking means comprise at least a first sealing point of said first portion of the strap and of said closing means superimposed the one on the other.

43) Bottle according to one or more of the preceding claims, characterized by the fact that said locking means comprise at least a second sealing point of said second and third portions of the strap superimposed the one on the other.

44) Bottle according to one or more of the preceding claims, characterized by the fact that said connection means comprise at least two of said straps.

45) Bottle according to one or more of the preceding claims, characterized by

the fact that said straps are arranged from parts diametrically opposite the neck of said hollow body.

- 46) Bottle according to one or more of the preceding claims, characterized by the fact that it comprises at least a weakened temporary connection segment
- 5 with another bottle arranged adjacent.

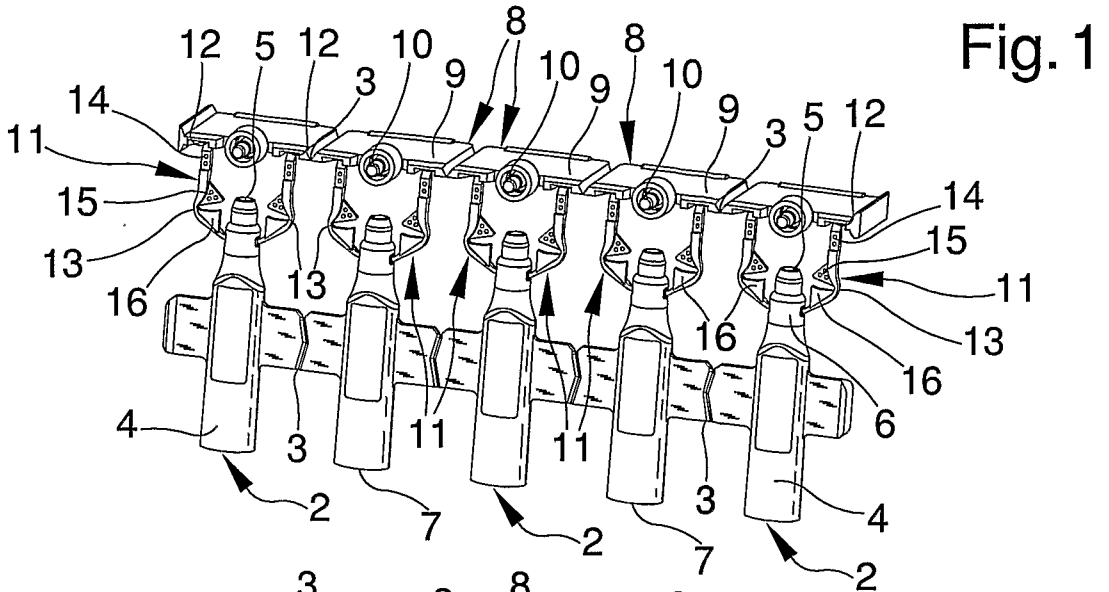


Fig. 1

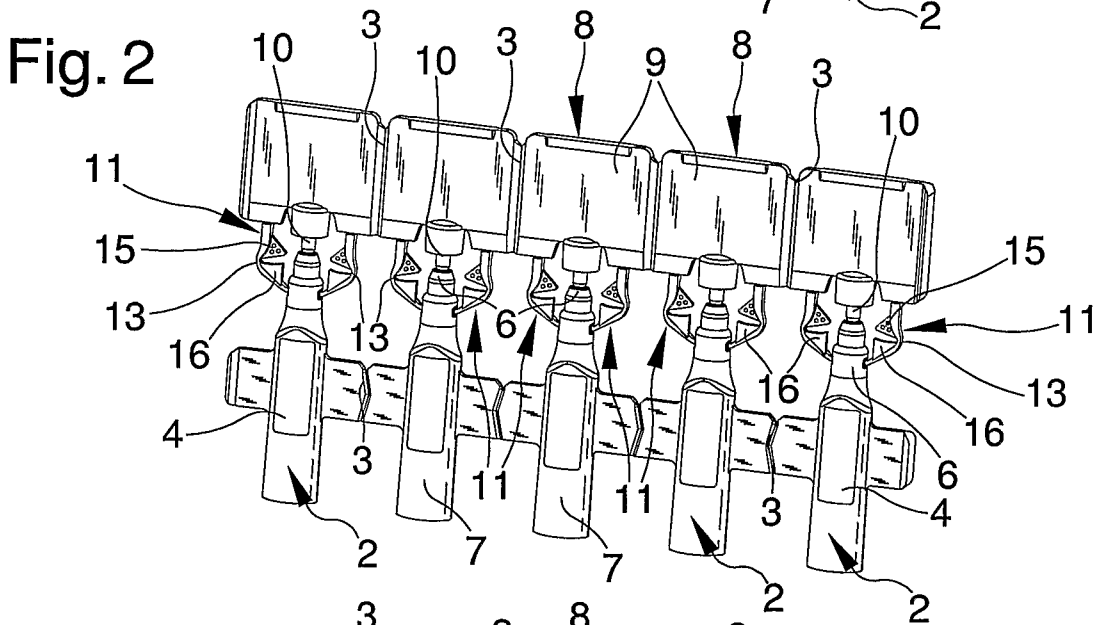


Fig. 2

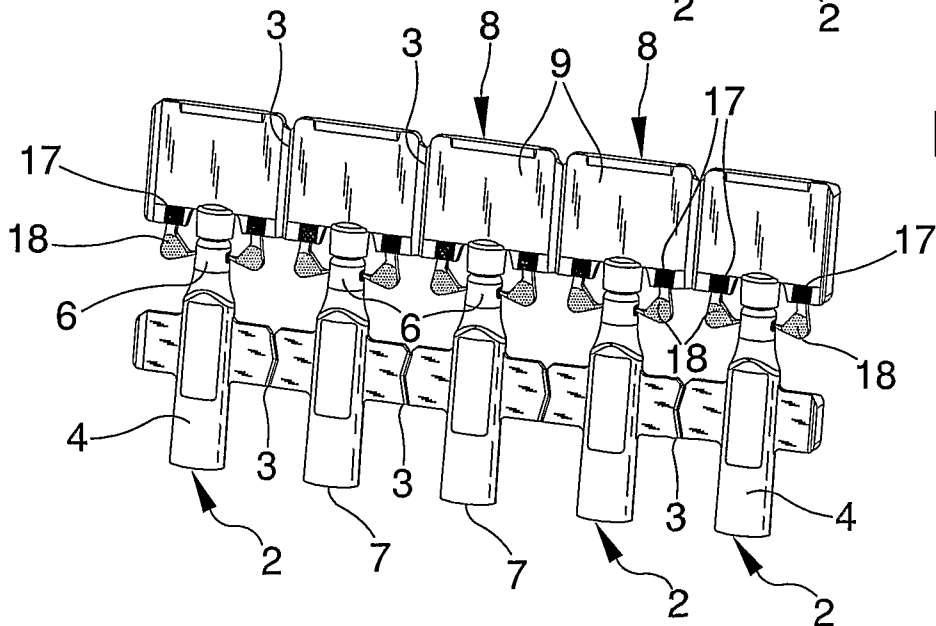


Fig. 3

Fig. 4

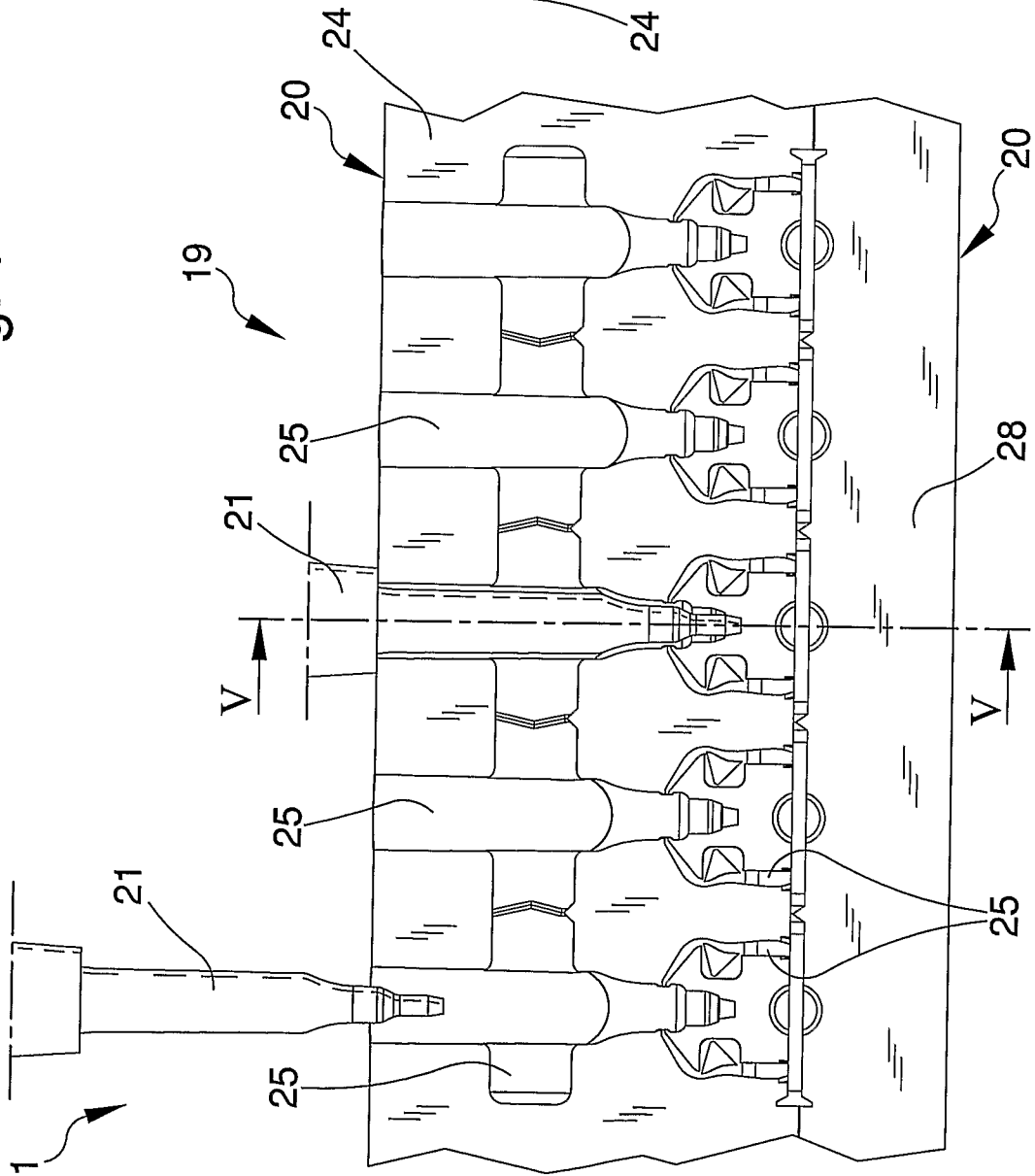


Fig. 5

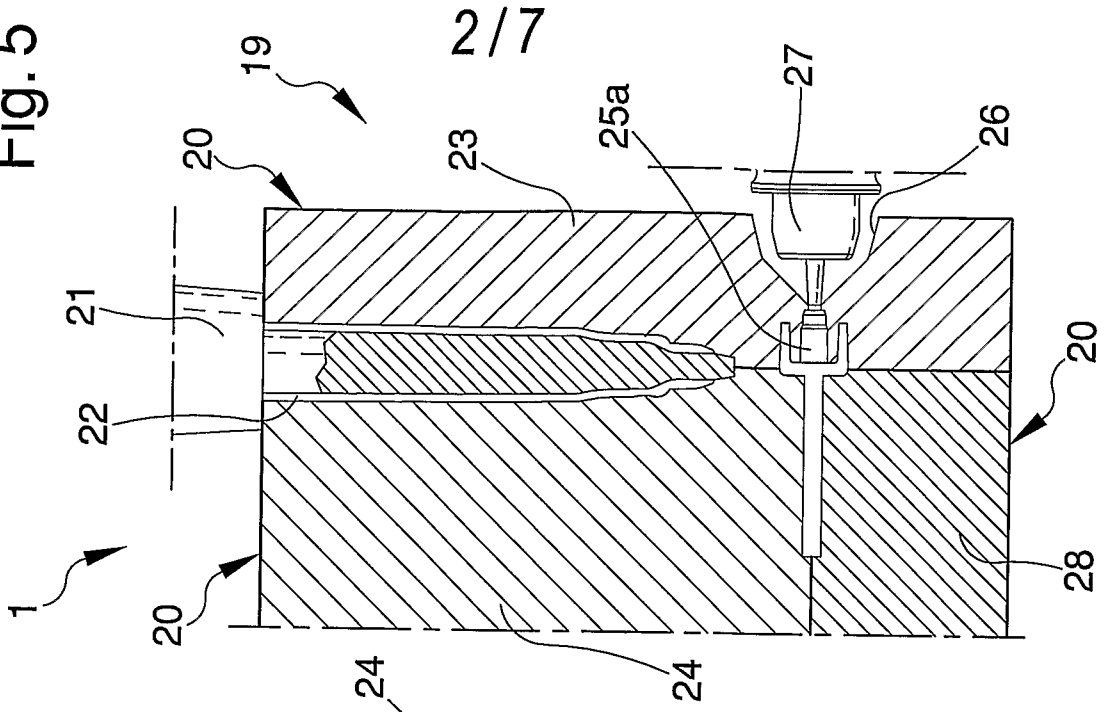


Fig. 6

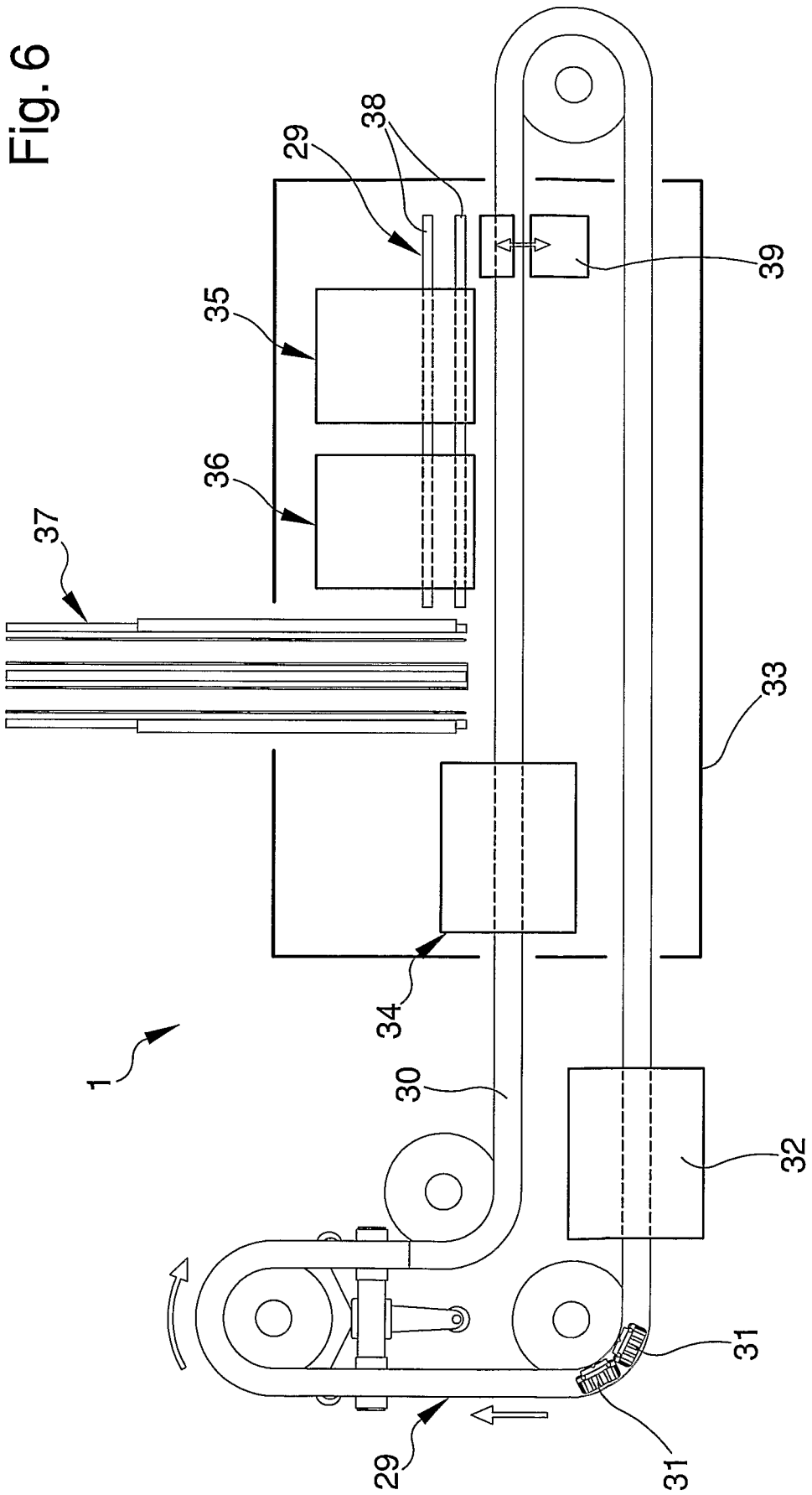


Fig. 7

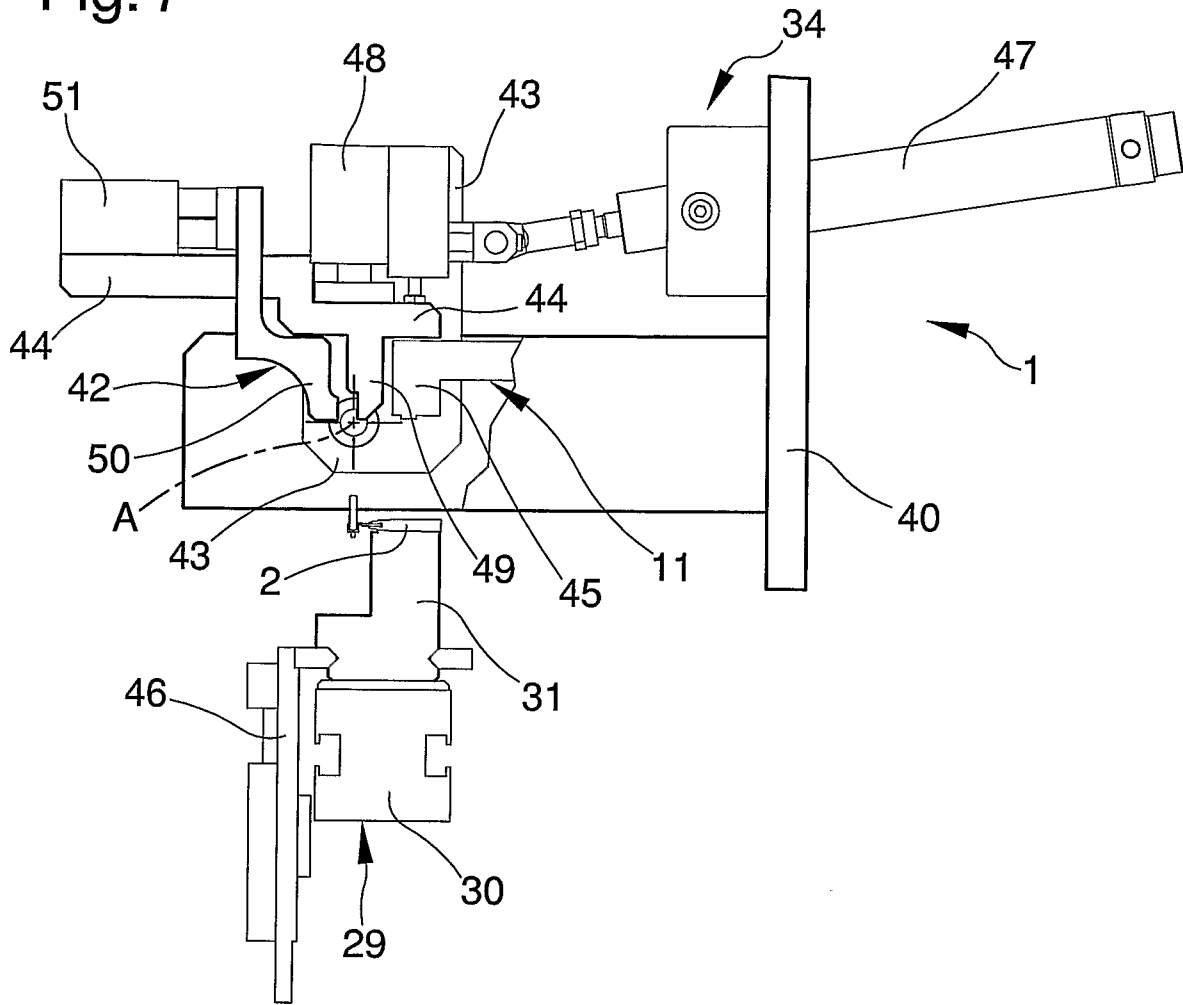
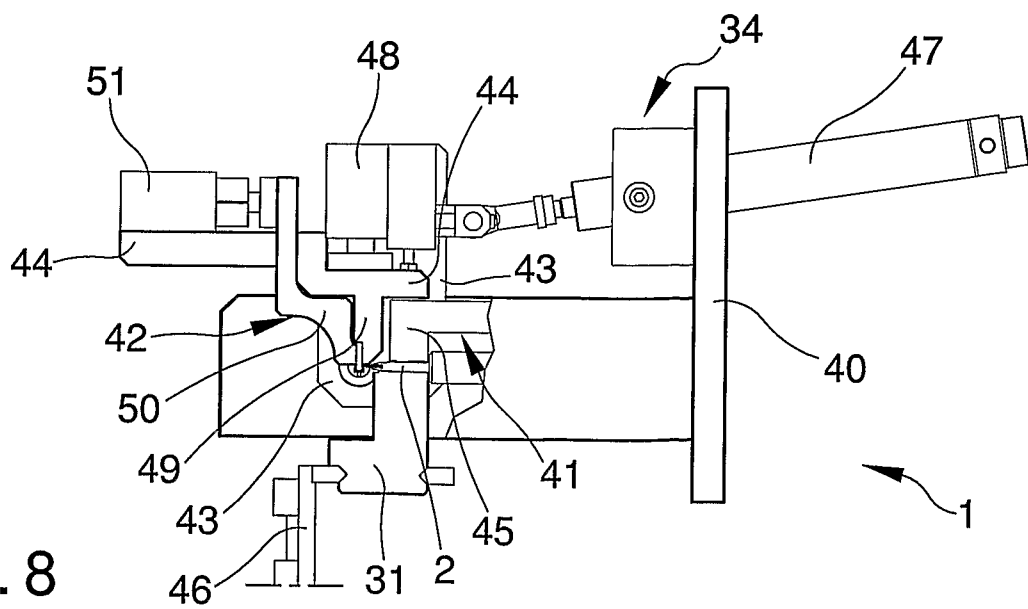


Fig. 8



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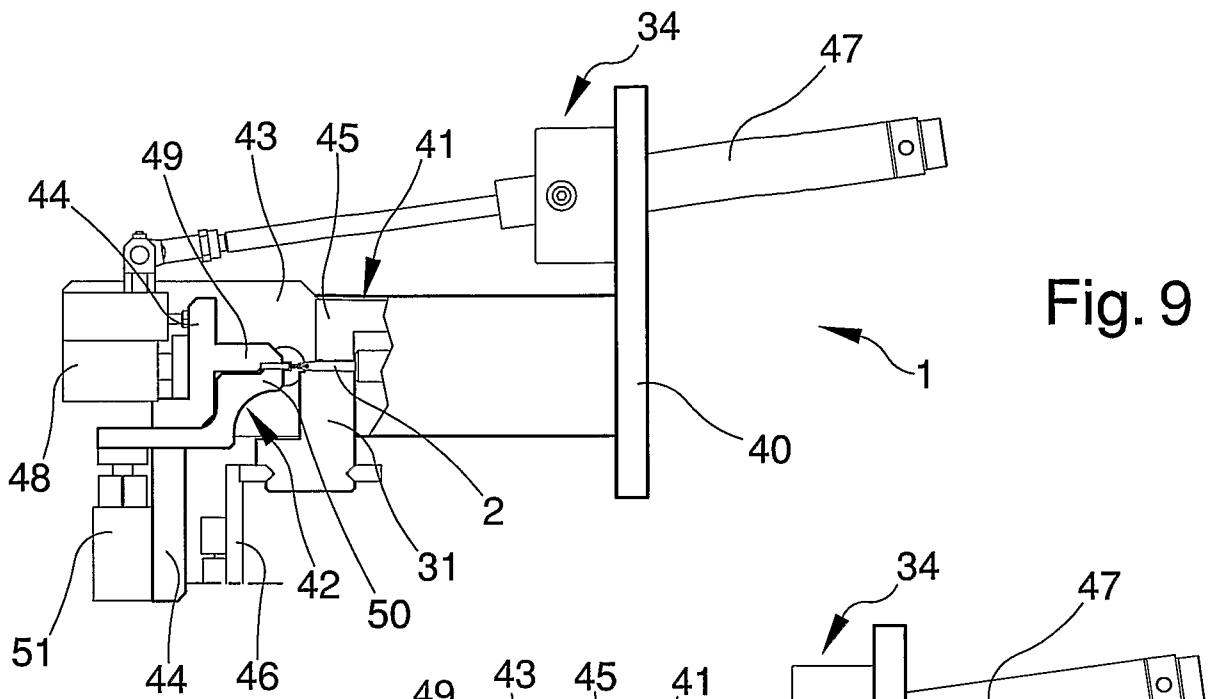


Fig. 9

Fig. 10

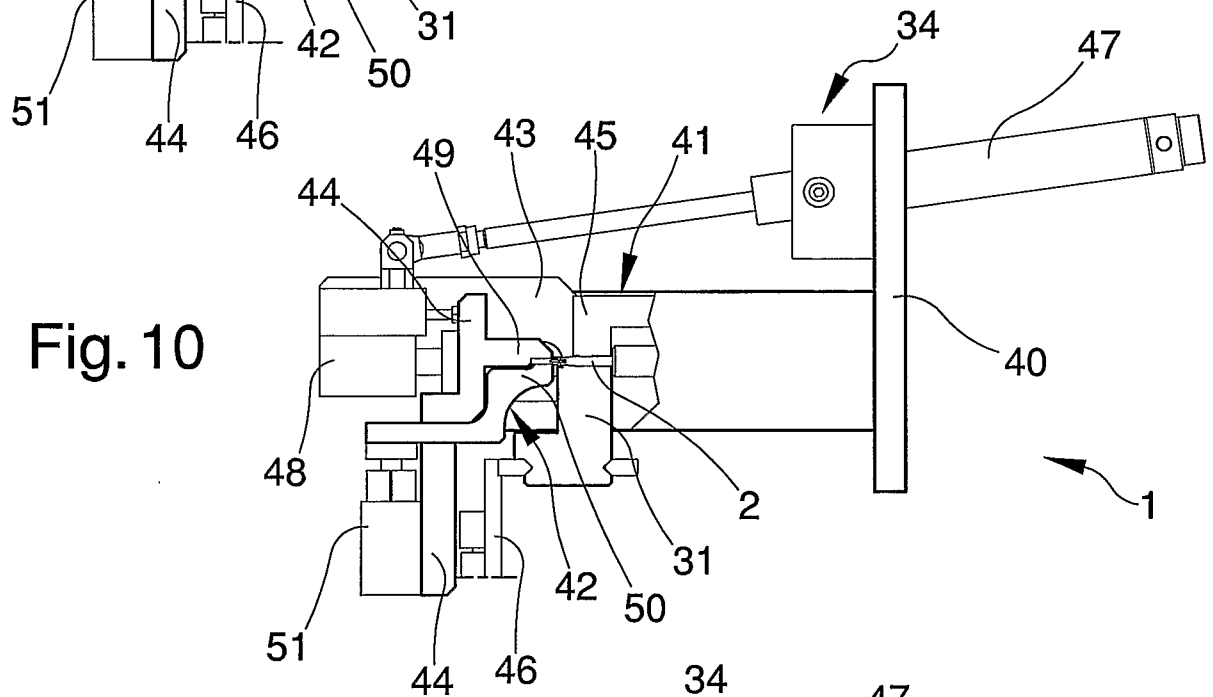


Fig. 11

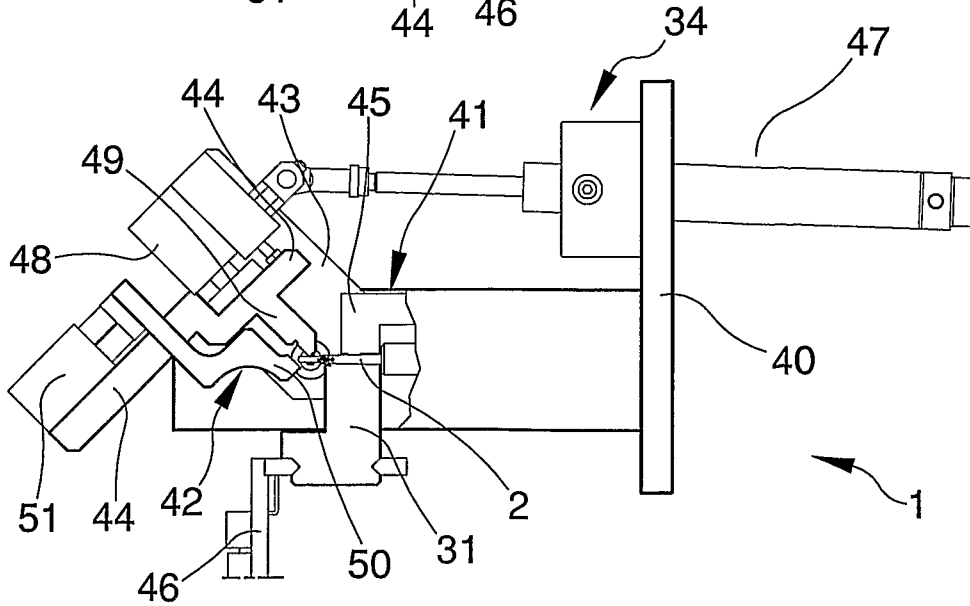


Fig. 11

Fig. 13

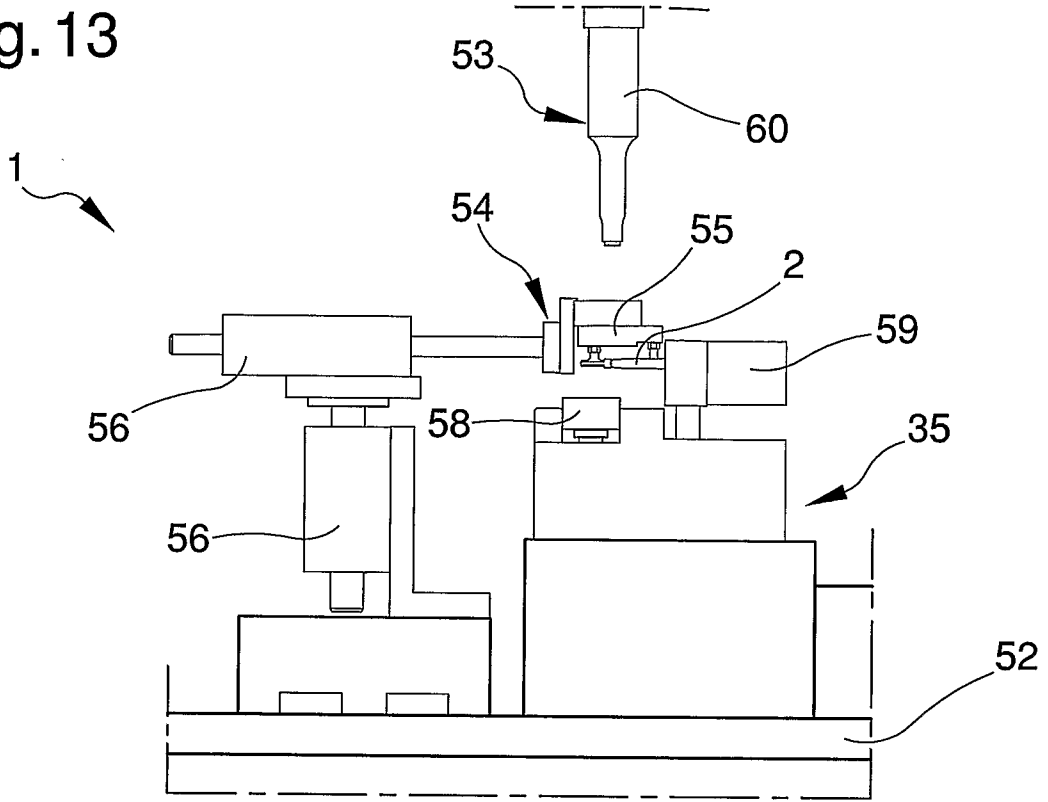
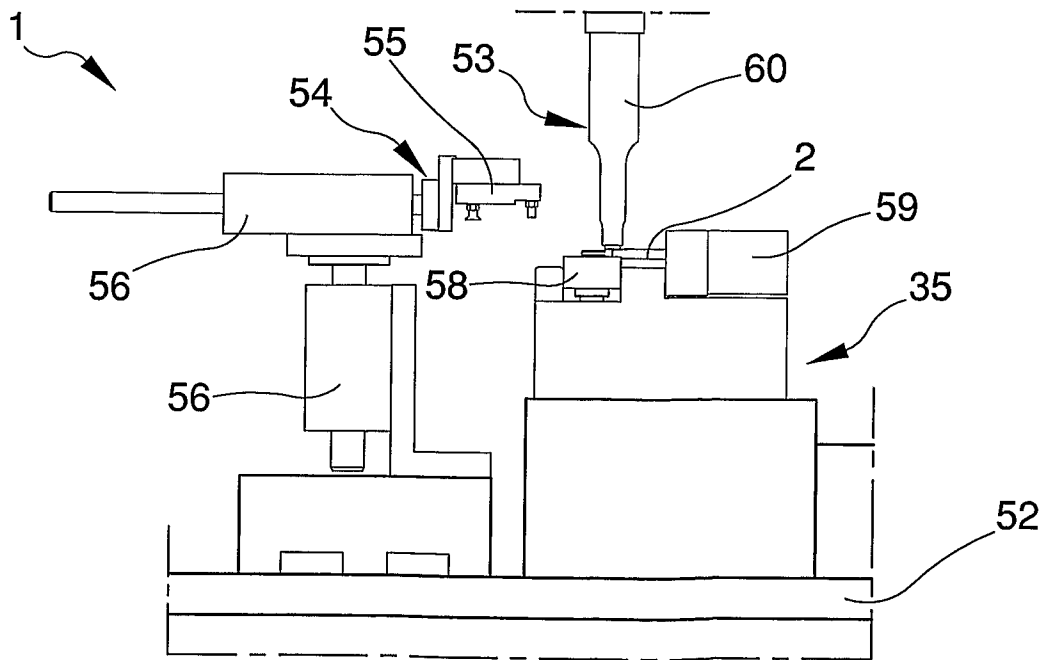


Fig. 14



INTERNATIONAL SEARCH REPORT

International application No
PCT/IB2008/000647

A. CLASSIFICATION OF SUBJECT MATTER
 INV. B29C45/00 B65D1/09 B65D75/48

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED
 Minimum documentation searched (classification system followed by classification symbols)
 B29C B65D

Documentation searched other than minimum documentation, to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)
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C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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X	US 6 290 094 B1 (ARNOLD JAY [US] ET AL) 18 September 2001 (2001-09-18)	1-3, 5-7, 37, 39
Y	WO 97/49611 A (LAMEPLAST SRL [IT]; FARMIGEA SPA [IT]; FEDERIGHI ALBERTO [IT]; FONTANA) 31 December 1997 (1997-12-31)	15-34
	cited in the application	
	figures 1-3	
	-/--	

Further documents are listed in the continuation of Box C. See patent family annex.

* Special categories of cited documents :

<p>*A* document defining the general state of the art which is not considered to be of particular relevance</p> <p>*E* earlier document but published on or after the international filing date</p> <p>*L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>*O* document referring to an oral disclosure, use, exhibition or other means</p> <p>*P* document published prior to the international filing date but later than the priority date claimed</p>	<p>*T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>*X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone</p> <p>*Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.</p> <p>*&* document member of the same patent family</p>
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Date of the actual completion of the international search	Date of mailing of the international search report
10 July 2008	17/07/2008

Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Tx. 31 651 epo nl, Fax: (+31-70) 340-3016	Authorized officer <p style="text-align: center;">Kujat, Christian</p>
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INTERNATIONAL SEARCH REPORT

International application No
PCT/IB2008/000647

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
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A	US 2 778 533 A (ANDRE SAVARY) 22 January 1957 (1957-01-22) figures 1,4 -----	1-46

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