C l a i m s

1. A container having a sleeve-type neck part (4) connected to a container body (2) as an axial extension, said neck part forming a seat (6) for a pre-formed insert (8) extending along the axis (12) of the neck part (4), and said neck part being formed in the production mold, on a peripheral region (14) of the insert (8), which is a part of the container, wherein at least one sealing element (42; 68) is provided on the insert (8), said sealing element forming a seal in a sealing region surrounding the axis (12), in combination with a contact surface (38) formed on the seat (6) of the neck part (4), wherein the sealing element (42; 68) is formed by the edge of a ring (42; 68) formed on the insert (8) facing the contact surface (38) on the seat (6) of the neck part (4), **characterized** in that the sealing element (42; 68), molten by thermal input, forms a solid, fluid-impermeable barrier to the other adjacent plastic material.

2. The container according to claim 1, characterized in that the sealing element (42; 68) is formed by a molded part of the insert (8) associated with the latter.

3. The container according to claim 1 or 2, characterized in that the sealing element (42; 68) adjoins the end of the peripheral region (14), on which the neck part (4) to the insert (8) is formed, facing the contact surface (38) of the seat (6).

4. The container according to one of the preceding claims, characterized in that the ring-shaped sealing element (42) has the form of an axially protruding rib.

5. The container according to one of the preceding claims, characterized in that

the sealing element (42) is rib-shaped and has a shape tapering towards the rim adjoining the bearing surface (38).

6. The container according to one of the preceding claims, characterized in that at least one axially protruding structural part (46; 74) is provided on the insert (8) extending offset radially inwards to the annular sealing element (42; 68) and beyond the former towards the container body (2).

7. The container according to one of the preceding claims, characterized in that the axially protruding structural part has the shape of a coaxial truncated cone (46) tapering in the direction of the container body (2), which has a concentric passage (36) that is open towards the container body (2).

8. The container according to claim 6, characterized in that the insert (8) forms a hollow cylinder (66) within the peripheral region (14), on the inner wall of which a plurality of axially protruding structure parts in the form of circumferentially arranged distributed wings (74) are provided, the free end regions (76) of which contact the inside of the collar part (10).

9. The container according to one of the preceding claims, characterized in that a hollow syringe cone (28) is connected at the end of the peripheral region (14) of the insert (8) facing away from the container body (2), the cavity (30) of which is flush with the bore-like passage (36) of the truncated cone (46), from which it is separated by a web (32) forming a wall part (34) that can be pierced for an extraction process.

10. The container according to claim 9, characterized in that there are surface irregularities (24, 26; 52; 54; 56; 58; 72) at the peripheral region (14) of the insert (8), which are formed by surface parts separated from each other by radially recessed or raised surface areas and arranged axially offset to the annular sealing element (42) towards the cone (28).

11. The container according to one of the preceding claims, characterized in that an over-mold closure cap (16) enclosing the syringe cone (28) is formed to the

end of the neck part (4) facing away from the container body (2) forming a predetermined breaking point (18) enabling the separation from the neck part (4).

12. The container according to claim 12, characterized in that an integral, male Luer Lock (40) is formed on the insert (8), said Luer Lock having a closure part (92) connected to the over-mold closure cap (16) and when it is removed, can be removed together with the latter at a separation point (91) at the end of the Luer Lock (90), for opening the cone at the upper end of its cone (28).

13. The container according to claim 12 or 13, characterized in that the closure part (92) comprises a bar (93) extending axially away from the cone (28), integrated in the region of the handle parts (82, 84) serving as a turn-off knob in the over-mold closure cap (16).

14. The container according to one of the preceding claims, characterized in that the insert (8) is formed of at least two different materials, of which at least one is softenable at low temperatures.

15. The container according to one of the preceding claims, characterized in that the softenable material is a thermoplastic polymer having good adhesion properties to the polymer material of the container body, in particular a thermoplastic elastomer (TPE), and that there is another polymeric material having a higher softening temperature.

16. The container according to one of the preceding claims, characterized in that the container is a plastic ampoule.

17. A method, which is provided in particular for the manufacture of a container according to one of claims 1 to 16, characterized in that the sealing element (42; 68) of the insert (8) is energetically treated, in particular heated, before its insertion into the blow-molding device (97, 99).

18. The method according to claim 17, characterized in that the operation of

inserting the insert (8) in the blow-molding device (97, 99) is performed such that at first only an axial pressure force is applied, to ensure a fusion bond of the sealing element (42; 68) on the seat (6) of the neck part (4), and that then, delayed, radial forces are applied by closing of the head jaws (97) to achieve the serration of the surface irregularities (24, 26; 52; 54; 56; 58; 72) of the peripheral region (14).