C l a i m s

1. A process for producing a filled and closed container, in particular in accordance with the blow molding, filling and sealing process, in which an initially open, blow-shaped by a blow mandrel and/or vacuum-shaped container part (52) held in a mold tool (46), is filled via its clear, upwardly aligned container part opening (54) by means of metering units (12, 14) in succession with media (74, 76) of different types, in particular different viscosities, and then a container head part (60) is formed by closing the head mold halves (56, 58) of the mold tool (46), and the container part (52) is closed to form the container,
wherein every medium (74, 76) to be filled into the container part (52) is supplied with its own assignable metering unit (10, 12),
characterized
in that container part (52) is sequentially filled with media (74, 76) of different types to enable the filled media (74, 76) to be separated from each other in the container part (52); and
in that in the sequence of filling with the respective medium (74, 76) the assignable metering units (10, 12) are moved in succession over the free container part opening (54) such that the first metering unit (10) is moved from a starting position over the free opening (54) of the container part (52) to a dispensing position, dispenses the first medium (74) into the interior of the container part (52) via this clear opening (54) and then returns to its original position, and that subsequently a second (12) and any further metering units are moved from their original positions in sequence to their dispensing positions at the clear container part opening (54) for a medium dispensing operation and back to their original positions.

2. The process according to claim 1, characterized in that at least one medium (74), which is filled into the container part (52) is a highly viscous product, such as an ointment, a cream or a gel.

3. The process according to claim 1 or 2, characterized in that at least one further medium (76) to be filled into the container part (52) is also selected from among the highly viscous products, such as ointments, creams, and gels.

4. The process according to any one of the preceding claims, characterized in that in the container part (52) the individual media (74, 76) to be filled are introduced in superposition such that there is no mixing between the adjacent media (74, 76), in that the separating layer (75) formed between the adjacent media (74, 76) is produced free of craters during filling.

5. The process according to any one of the preceding claims, characterized in that the respective media (74, 76) are, preferably substantially free of air pockets, filled in predetermined quantities into the container part (52) by means of a volumetric metering unit (10, 12).

6. The process according to any one of the preceding claims, characterized in that the travel paths of the individual metering units (10, 12) that occupy only a common dispensing position on the clear, stationarily arranged container part opening (54) for a media dispensing operation are selected separately from each other.

7. The process according to any one of the preceding claims, characterized in that after the medium (76) dispensed last into the container part (52) by means of its metering unit (12), an end part, preferably in the form of a ball (64), is placed on the former and subsequently, upon the formation of a container head part (60), the container with the filled-in media (74, 76) and the end part (64) is closed and removed from the production mold (46, 48, 50, 56, 58).

8. A device, in particular for performing a process according to one of the preceding claims, wherein at least two metering units (10, 12) are each fixed on a displacement unit (38) for dispensing media (74, 76) into a container part (52) via its clear opening (54), characterized in that the displacement unit (38) moves the respective metering units (10, 12) from a starting position to a dispensing position over the container part opening (54) and back again by means of at least one drive means (26, 28, 30) via a skewed guide (22) of a sliding block guide (20).

9. The device according to claim 8, characterized in that the individual oblique guide (22) runs as part of the sliding block guide (20) in a base support (18), which has a spindle drive (26), which moves a bracket (34), on which the displacement unit (38) with the associated metering unit (10, 12) is arranged movably in the horizontal direction, in the vertical direction.

10. A container, produced by a process according to claims 1 to 7 and using a device according to claims 8 or 9, characterized in that at least two media (74, 76) are held in superposition and separated from each other in its closed container part (52).