

Gaplast at **CosmeticBusiness**

The specialist for plastic packaging presents new developments

Packaging makes the difference. This is especially the case for cosmetics. For more than 40 years Gaplast is developing and producing packaging solutions, since 2004 also for the international cosmetics industry. At the CosmeticBusiness in Munich the company based in Bavarian Saulgrub (close to Garmisch-Partenkirchen) provides an overview of innovative and creative packaging solutions. This includes in particular the bag in bottle airless system.

Although offering its airless solutions in the cosmetics market only since 2004, Gaplast is presenting again this year numerous successful launches with this system. In addition, the standard series "Regula Airless Dispenser", which was developed in cooperation with Louvrette has been expanded by the sizes 15 and 50 ml.

As an innovation leader Gaplast offers to its international clients from the cosmetics industry packaging and application solutions from a single source - from development and production through to bottling. The sales volume of Gaplast in 2015 was 27 million EURO, the number of employees 180.

Gaplast managing director Leonie Kneer: "Most of our clients are working closely together with us already in the development phase of their new products, a benefit for both sides."

Gaplast, the Company

From a small workshops to an industrial leader

Gaplast has developed over more than four decades from a toll manufacturer for pharmaceutical packaging and medical devices into an independent industrial enterprise with research and development department, patent applications, strong sales activities and a wholly owned mould and special purpose machinery. With its consulting, development, manufacturing and packaging expertise Gaplast provides all relevant components for custom solutions.

“Because we consistently stayed focused from the very beginning, when it came to looking for the needs of the markets and accordingly new solutions to be developed, implemented and further developed or to be adapted to the needs of our customers we have become the company that we are today,” says senior partner Roland Kneer. Because at Gaplast decades of experience are passed on in the family and simultaneously fresh ideas, modern technologies and management methods are incorporated in the company and its products by the second generation, Gaplast is a strong partner.

Outstanding developer of creative packaging

The roots of Gaplast go back to 1969 when the company was developed within the Geiger plastic group. In 1976 it was spun off as an independent corporation. Roland Kneer took over the plant management and extended Gaplast over the years to a major developer and manufacturer of innovative, creative packaging and applications of plastics for pharmaceutical products, cosmetics and medical applications over the years.

Gaplast not only meets the applicable standards in these industries, but even exceeds them. Therefore, quality is a key characteristic that affects all areas of the company. The certification according to DIN EN ISO 9001 is standard since 1994. As an innovative leader of its international customers Gaplast now offers packaging and application solutions from development through to manufacturing and bottling from a single source.

A family-owned enterprise since 1989

As part of a management buy-out in 1989 Roland Kneer took over the company. At the same time his daughter Leonie Kneer started her commercial training, in 1994 she completed a technical training. In 2004 her brother Stephan Kneer joined his father's company after he had successfully completed several years of practical experience in technical development as an engineer for at Audi in Ingolstadt.

In 2014 Roland Kneer extended the management: He remained CEO, while Stephan Kneer was appointed Managing Partner and CTO. At the same time Leonie Kneer took over the position of the CSO and a Managing Partner.

In 1989 Gaplast was a small enterprise with 50 employees and 2.5 million Euro of revenue. Over the years it became an industrial enterprise with 27 million Euro in sales and 180 employees. And with the entry of Stephan and Leonie Kneer the course for the future has been set.

The continuity of growth, many patents for own developments, the new plant in Peiting and a close cooperation with renowned customers from the pharmaceutical, cosmetic and medical field also guarantee for the employees' jobs.

In 2016 Gaplast was nominated at BAYERISCHER GRUENDERPREIS (Bavarian award for founders) in the category successor. This award, an initiative of the Sparkassen, ZDF and Porsche, stands for outstanding achievements in building and maintaining businesses.

A Comprehensive Product Range

The various markets and applications for plastics packaging in the cosmetics, pharmaceutical or medical devices sector are demanding customized solutions and an optimal cost-benefit ratio. With standardized products as well as solutions adapted to customer needs and also completely new developments, Gaplast supports customers at every stage of the packaging design and development, all through to serial production with numerous state-of-the-art plastic processing technologies.

Wide Range of Services – Synergy of Competencies – High Quality Standards

Gaplast is working as a developer, producer and service provider. Using the synergy of these different skills the company is able to cover everything from the first steps of development through to serial production. Whether the idea for a new product comes from the customer or has been brought up from the team in-house, in any case a solution will be found that fits the high quality standards.

Gaplast has been a partner of the pharmaceutical industry for more than 40 years. Therefore, quality is a key feature of our work and affects all areas of our company. The certification according to DIN EN ISO 9001 has been a standard at Gaplast already since 1994.

The System Standards ISO 15378 and ISO 9001 as well as production conditions according to GMP (good manufacturing practise) guarantee compliance with national and international regulatory guidelines. Moreover, it is possible at Gaplast to produce under ISO 8 clean room conditions.

Engineering

"novel solutions in plastics" - Drive and passion!

Gaplast puts the clients' ideas as well as own ones into practice: With in-house designers and project managers, as well as with own tool and [special purpose machinery manufacture](#) - these teams represent more than one fifth of the total workforce. All developments are accompanied by a defined "Advanced Product Quality Planning" = APQP process.

In 2006 Gaplast was awarded Top 100 Innovator. More than 100 patents, of which 46 have been implemented, and another 32 patents in development phase are proving: Gaplast systematically and continuously looks for new solutions for its customers.

Serial Production - Plastic Processing Technologies

Gaplast is using the following production technologies:

Altenau plant:

- extrusion blow moulding machines (for hollow bodies of up to 3,000 ml)
- Coextrusion blow moulding machines (for airless bodies of <5 ml to 1250 ml)

Peiting plant:

- injection moulding machines (from 250 KN to 2,800 KN clamping force)
- injection blow moulding machines

Gaplast has specialized in these four technologies to combine the product characteristics of them and to be able to offer everything from one source. This special feature is extremely demanding for competent employees in production and quality assurance.

Finish and Refine

During this process the products get added the finishing touches. This includes for example the filling of the closures with desiccant or the insertion of air ventilation holes into multilayer bottles to make them real airless bottles – „bag in bottle“. The entire process is accompanied by an established Quality Control.

The quality of packaging or application systems depends on the individual components, but also on quality-control during the assembly process which can optionally be carried out under clean room conditions according to ISO 8. The assembly production lines are individually designed by Gaplast according to the requirements of the product and often even being built and programmed in-house.

In the packaging industry downstream process steps such as decoration or filling are increasingly gaining importance. In some cases, Gaplast is co-operating with partners, such as in printing, labeling or sterilization of packaging as well as bottling. However, the sleeve technology is on the rise, not only because it can be optimally adapted to almost any type of packaging but also because the entire surface of the packaging can be completely used for decoration and information. Thanks to its in-house sleeve system costs and flexibility can be optimized.

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The Gaplast Management Team

Roland Kneer is the main shareholder and CEO. Born in January 1947 in Allmendingen he trained as a machinist. He completed his subsequent studies as Dipl. Ing. (FH) Kunststofftechnik (academic degree for plastics technology). Roland Kneer's career is also the history of the company Gaplast, which he took over in 1989 as part of a management buy-out. Even today, he is a mentor responsible for the strategic development of the company, the construction of the corporate expansion and for product development. In his leisure time Roland Kneer is flying, sailing, mountain biking and driving classic cars and fast runabouts.

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Leonie Kneer is part of the family business since 1989. Here she started her training as an industrial management assistant and later trained as a process engineer for plastics and rubber. Over the years she has taken care of many areas of the company. She worked as a field worker, later as head of sales. Today she is responsible as managing partner and CSO (Chief Sales Officer) for all sales and related tasks. That means, she is responsible for the sales strategy, as well as for customer care, even for the strategic company alignment together with her colleagues from the management team. As a mother of two children she is a member of the "Health Care Women". Her hobbies are children, her family and reading.

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Stephan Kneer is part the company since 2004. After High School in Garmisch-Partenkirchen, he studied plastic technology in Aalen. He finished his university thesis on plastics engineering as a Dipl. Ing. (FH) at BMW in Landshut. Later he worked as a test engineer at Audi in Ingolstadt in charge of the bumper systems of the Audi A3 and A6. Stephan Kneer is today managing director and as the technical director (CTO) responsible for production, development, quality and IT. This includes the restructuring of business processes and transfer in IT, optimization of the IT operations, technical sales and marketing support, product and process developments with patent applications and much more. He also provides support for Bachelor students, is lecturing at universities, in industry and at trade shows. He also works on the further development of quality management system such as ISO 15378. In his spare time he recovers in mountain biking, cross-country skiing, hiking and sailing.

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Veronica Pröbstl is Chief Financial Officer of the company (CFO). She was born near Paris, hence her interest in languages. She first completed a business school and an interpreter-training before she became active as an authorized representative of a Spanish company. She then worked in various companies in leadership positions in the areas of administration, finance and personnel. In 1997 she came to Gaplast as a senior executive and took over the department management, finance and human resources. In 1999, she received power of attorney and became a member of the Executive

Committee. Since 2014 she is member of the management team. Her hobbies include nature and reading.

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Gaplast: The History

Gaplast has developed within more than 40 years from a toll manufacturer for pharmaceutical packaging and medical devices into an independent industrial enterprise with research and development department, patent applications, strong sales activities and a wholly owned mould and special purpose machinery manufacture with an international standing.

The most important milestones:

1969	Foundation of the company within the Geiger Plastic Group
1970ies	Toll manufacturing for pharmaceutical packaging
1976	Spin-off as independent "Gaplast Gesellschaft für Kunststoffverarbeitung mbH"; plant manager: Roland Kneer.
1980ies	Expansion of the pharma product range, entry into medical technology
1988	Business enterprise with 50 employees and a total revenue of 2.5 million Euro
1989	Management Buy Out: Roland Kneer takes over the company
1990ies	R & D patents, development bag-in-bottle, amendment of the German Pharmacopoeia due to this packaging solution from Gaplast, sales of in-house developments
1994	Certification according to DIN EN ISO 9001, strategic investment in Ursatec
2000s	Technology transfer into cosmetics, new process technology, patent extension for bag-in-bottle
2001	Acquisition of "B & F Schongau Kunststoffverarbeitung" and further development of the mechanical workshop into a mould and special purpose machinery manufacturing
2006	Awarded TOP 100 Innovator
2008	Winner of the 20th DuPont Packaging Award
2012	Construction of the Peiting plant, relocation of the primary packaging production for pharmaceuticals
2014	Roland Kneer, CEO, expanding the management team: entry of Leonie and Stephan Kneer as managing partners responsible for sales and technology departments
2015	First delivery of the in-house developed implant syringe, initial operation of the qualified ISO 8 clean rooms for moulding and assembly
2016	Gaplast nominated at BAYERISCHER GRUENDERPREIS (Bavarian award for founders) in

	the category successor. Certified according to ISO 15378
Today	Developer and producer of innovative, creative packaging and applications made of plastics for pharmaceutical products, cosmetics and medical applications. Industrial enterprise with 27 million Euro in sales and 180 employees.
2020ies	Manufactory 4.0

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Fact-Sheet Gaplast GmbH

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- Address:** Wurmansauer Strasse 22, D-82442 Saulgrub-Altenau
- Phone:** +49 (0) 8845 - 74 13 - 0
- Fax:** +49 (0) 8845 - 83 53
- Internet:** www.gaplast.de
- E-Mail:** info@gaplast.de
- Commercial Register:** Amtsgericht München: HRB 86631
- Peiting Plant:** August-Moralt-Strasse 9, 86971 Peiting
- Management:** Roland Kneer, Main Shareholder, Chairman of the Board
Leonie Kneer, Managing Director and Chief Sales Officer (CSO)
Stephan Kneer, Managing Director and Chief technical Officer (CTO)
Veronica Pröbstl, Member of the Management, Chief Financial Officer (CFO)
Uwe Berthal, Quality Manager
Alexander Keller, Research & Development
Axel Maier, Production
- Staff:** 180, of which 100 are working in production working in three shifts, 17 trainees
- Total Revenue 2015:** 27 Million Euro
- Products:** Packaging, applications and disposable products for the pharmaceutical, medical and cosmetics areas, among these are the following in-house developments: double-walled containers for airless systems (Bag-in-Bottle Systems), bicameral systems with various modes of application, implant syringe, childproof pressure screw cap with integrated desiccant chamber, ModularDose and ModularInject , disposable valve , tamper-evident and/or childproof closure systems
- Production-Technologies:** Injection moulding with up to 280 to closing pressure, injection blow moulding, extrusion blow moulding up to 3000 ml, coextrusion blow moulding up to 1250 ml, system assembly, own mould and special equipment construction
- References:** Aenova, Aptar, Boehringer Ingelheim Pharma, Ecolab, Gambro, Hermes Arzneimittel, Hermes Pharma, Libbs, L'Oreal, Roche Diagnostics, Sanofi-Aventis, Tropack Packmittel, Ursapharm Arzneimittel, Ursatec Verpackung, Virbac, Wala, Weleda and others.
- Short Profile:** Over more than 40 years Gaplast has developed from a toll manufacturer for pharmaceutical packaging and medical devices into an independent company with research and development department, patent applications, strong sales activities and a wholly owned mould and special purpose machinery manufacture with international standing. With its consulting, development, manufacturing and packaging expertise Gaplast offers all the relevant components for tailor-made solutions.
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Spec Sheet Products

The various markets and applications for plastics packaging in the cosmetics, pharmaceutical or medical devices sector are demanding customized solutions and an optimal cost-benefit ratio, depending on the profile of requirements. With standardized products, solutions adapted to customer needs and also completely new developments, we support our customers at every stage of the packaging design and development, up to serial production with the help of various ultra-modern plastics processing technologies.

Container Closure Systems

The preliminary task of each packaging system is to store and protect the content. But at the same time it is also inevitable to match the ease of use when opening and closing the container.

Whilst fitting to different designs of container openings, like

- snap on (\varnothing 19,85 mm - 54,50 mm)
- screw

or different container materials, like

- plastic
- aluminium
- glass

the following closure features are available solely or in combination:

- tamper-evident
- with integrated desiccant
- for tablet storage
- with distance holder: by an additional bellow or by an integrated spiral
- childproof (ISO 8317 & CFR §1700.20) by integrated, self-resetting push-pull slider

NEW VERSION

Senior friendly desiccant stopper with pull tab

Unfortunately, a gain in ages usually goes along with a loss in power. Therefore, the target is to engineer an easy to use packaging which also fulfils pharmaceutical requirements.

System Benefits (B2B)

- Compatible to standard and already in place snap-on filling lines
No impact on article price

Consumer Convenience (B2C)

- Reducing the initial opening force up to 40%

Use

Once opened, a packaging usually requires less force to be reopened than for the initial opening. To lower this effort, the tamper evident ring can now be torn off at the pull tab prior to levering the closure

Implant Syringe (drug device combination product)

Monodose

The implantation syringe is qualified for the placement of rod-shaped, long-acting tablets. These are intended to release their active substance gradually into the tissue layers of the patient. For this purpose, it is necessary that the tablet is placed subcutaneously by a needle. Generally, this is done with a syringe.

Until today it is still accepted to push the tablet further into virgin layers of the tissue than necessary, if the syringe is not withdrawn smoothly from the tissue. Vice versa, if the syringe is withdrawn too fast, the tablet could stick out of the tissue to a certain extent. This results in a lost administration and an increase of costs and pain for the patient.

System Benefits (B2B)

- The tablet is effectively protected from falling out of the syringe
- The only device which allows the placement of the tablet and the withdrawal of the needle in a single sequential procedure
- Delivery of two sub-assemblies for easy filling and final mounting

Consumer Convenience (B2C)

- Less pain for the patient
- Tablet is not pressed further into the tissue than necessary due to direct placement in the punctured canal
- Tablet does not extend out of the tissue due to fixed placement of the tablet in the punctured canal, therefore no second administration necessary
- Pre-filled syringe reduces the risk of misuse and fail loading as well as costs and time
- Needlestick prevention
- Safe and simple administration for the doctor

Use

After removal of the security clip and protection cap the syringe is ready for use. The doctor applies the implant syringe to the patient's tissue, injects subcutaneously and presses the implant syringe completely together. During the application, the syringe shell is always in touch with the skin. First the tablet (implant) is placed in the tissue via the plunger in the needle channel and then the needle is withdrawn from the patient's tissue. After the administration the needle is protected both by the plunger and by the needle cover, afterwards the syringe can be disposed as usual.

ModularInject Monodose Injection

Unique and smart solution to close the gap between manually applied prefilled syringes and complex auto-injectors.

Single Use:

- Prefilled syringe with tip cap

Multiple Use:

- One-piece activation device with an integrated plunger, automatic penetration, traveller and needle security functionality

System Benefits (B2B):

- Applied/used either with a standard prefilled syringe in accordance to ISO 11040-4 or alternatively with an own developed packaging optimized prefilled syringe
- Free set combination of different dosages or different drugs in accordance to patient's treatment plan

Consumer Convenience (B2C):

- Automatic penetration, therefore usable also for scary patients to overcome skin resistance.
- Handholds for self or external administration, suitable for right or left -handed people

Active Pharmaceutical Ingredients:

- Heparin
- Vaccine
- Biosimilars
- Monoclonal Antibody and similar

Full Service:

The customer has the choice between a standard prefilled syringe or alternatively an own developed optimized syringe. There is a close collaboration with some selected syringe and filling companies.

Use:

The prefilled syringe is mounted into the reusable activation device. After removal of the tip cap, the ModularInject is placed to the injection point. By activating the device, the skin is penetrated and the drug substance is injected. After the injection is finished, the syringe is discharged and can be disposed as usual. The activation device is ready for the following administration.

Atmospheric squeeze dropper systems Multidose

Standardized application system to squeeze drops in a multiple use. The 100% control of the

dropper guarantees the functionality. Furthermore, the tamper evident screw cap ensures the integrity of the product throughout the shelf life

Atmospheric container for pump application

Multidose

Although products seem to be widely established and standardized, there is always a chance for improvement. For example with the unique and patented cross section bottom design of the 10 ml, 20 ml and 30 ml HDPE bottle, suitable for 20 mm snap on pumps.

System Benefits (B2B)

- Dip tube no longer touches the bottle during assembly of the pump
- Avoids line stops during pump assembly

Consumer Convenience (B2C)

- Regularity of the residual volume
- No risk of malfunction due to bended dip tubes

Airless container for pump & squeeze application

AirlessMotion

Reaching the utmost level of integrity sterility without preservative agents also during multiple use of a dosing system, requires highly engineered packaging. First of all, the container itself has to match these needs. A multilayer bottle has been evolved into a hybrid packaging consisting of a rigid bottle layer and a flexible, contracting integrated bag. The resulting system allows an airless pump not to vent the container with contaminated air during multiple applications, also if there are longer pauses in-between. Numerous patents are protecting the IP of product, function and process.

System Benefits (B2B)

- Formula without preservative agents applicable
- Absolute protection against chemical, physical and microbiological contamination
- Accurate and reliable dosing throughout the period of use (after opening)
- Layers barrier properties e.g. oxygen, water vapour, aroma etc. can be included into the bag
- Deco layer, like soft touch or high gloss, can be added to the bottle
- The only Airless System with a real freedom of design, compatible with all shapes of a complete product line
- established sizes from 5 ml up to 1.250 ml

Consumer Convenience (B2C)

- Real 360° usage, product can be applied at any angle
- High evacuation rate, respectively low residual volume, due to axial controlled folding of the bag
- No preservative agents, no allergic reactions
- Hermetic packaging allows for a fresh dosed product at any time
- Instant repriming after in use storage, hence correct dosage

Use

The AirlessMotion products can be combined with numerous dispensing units for:

- horizontal or vertical outlets
- spray, dropper or lotion pumps
- snap, crimp or screw neck design

push button or trigger activation

Monodose with spray or drip pattern or for injection (ModularFamily)

Monodose with spray, drip or line pattern

ModularUnitDose

The evolution of a monodose results in the patented new development of the ModularUnitDose with a spray, drip or line pattern. To achieve this functionality, the modular dose consists of the following components

Single use:

- Prefilled cartridge with a tamper evident twist off tip
- Tip design according to spray, drip or line pattern
- Moveable stopper

Multiple use

- One-piece activation device with an integrated piston

System Benefits (B2B)

- Reliable and correct dosage of drug delivery
- Combination of different dosages possible, just by varying the filling volume of the prefilled cartridges
- Even the combination of different drugs and / or dosages within one type of therapy possible
- Sustainability

Consumer Convenience (B2C)

- Hygienic tip end,
- Correct dosage, due to prefilled cartridge
- Reliable ease of use
- Perfect restitution rate

Use

The prefilled cartridge is mounted via bayonet into the reusable activation device. After twisting off the tamper evident tip, the modular dose is placed to the intended area of application and the activation device is squeezed to apply the product.



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