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(54) **BEVERAGE BOTTLING PLANT FOR FILLING BEVERAGE BOTTLES HAVING A BOTTLE HANDLING STATION AND A METHOD OF OPERATION THEREOF**

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(52) **U.S. Cl.** ..... **53/426; 53/471; 53/167; 53/282; 53/52; 356/239.5**

(58) **Field of Classification Search** ..... **356/239.5, 356/239.4; 53/167, 426, 52-54, 471, 282**  
See application file for complete search history.

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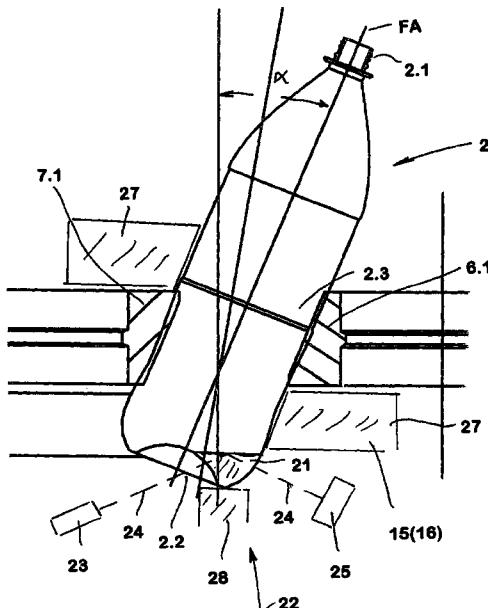
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(57) **ABSTRACT**

A beverage bottling plant for filling beverage bottles having a bottle handling station and a method of operation thereof. The bottle handling station has an inspection station for inspecting bottles for observable contaminants that have been rinsed off of the interior of the bottles using an amount of liquid introduced into the bottles by a liquid dispenser, and then gathered in the amount of liquid in a bottom area of the bottles.

**19 Claims, 11 Drawing Sheets**



**FIG. 1**