

Title (en)
IMPROVED STEEL CONTAINER STOCK, METHODS OF FORMING DRAWN AND IRONED CONTAINERS THEREFROM, AND CONTAINERS FORMED THEREBY.

Title (de)
ROHLING FÜR METALLISCHE BEHÄLTER, VERFAHREN ZUR HERSTELLUNG TIEFGEZOGENER UND ABGESTRECKTER BEHÄLTER DARAUS, SOWIE SO HERGESTELLTE BEHÄLTER.

Title (fr)
EBAUCHE DE BOITE METALLIQUE AMELIOREE, PROCEDES DE FORMATION DE BOITES ETIREES SUR MANDRIN A PARTIR DE CES EBAUCHES, ET BOITES AINSI FORMEES.

Publication
EP 0076803 A4 19851030 (EN)

Application
EP 82900896 A 19820211

Priority
• US 23356981 A 19810211
• US 28909781 A 19810731

Abstract (en)
[origin: WO8202683A1] Drawn and ironed can bodies (32) are formed from cold rolled steel sheet having a thin coating of a nickel-zinc alloy electroplated on at least one side. The coated steel sheet is drawn into a cup (31) having a nickel-zinc coating on at least its outer surface and the sidewall of the cup is ironed on a mandrel (42) to reduce its thickness and increase its height. Ironing of the alloy coated steel (11, 92) is improved by use of a toolpack (50) comprising a plurality of ironing ring dies (44, 46, 48) each including a generally conical lead-in surface having an angle relative to the draw axis within the range of about 6 to about 8.5 and a substantially cylindrical land (80) having a length of no more than about 0.063 centimeters. The length of the land (80) on the final ironing ring die (48) is no greater and may be less than that of any preceding ironing ring die in the toolpack and preferably is within the range of about 0.0075 to about 0.018 centimeters. The diameter of the land portion of successive ironing ring dies is progressively smaller in the direction of movement of a can through the toolpack, with the diameter of the final ironing ring die preferably being such as to reduce the sidewall of the cup entering this ironing die by about one half.

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No relevant documents have been disclosed

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