

Title (en)

METHOD AND ARRANGEMENT FOR THE PRODUCTION OF SCORING LINES IN SHEET METAL, PARTICULARLY FOR THE PRODUCTION OF TEAR-OFF TOPS OF CANS OR THE LIKE CONTAINERS

Publication

**EP 0127837 B1 19871209 (DE)**

Application

**EP 84105832 A 19840522**

Priority

DE 3319949 A 19830601

Abstract (en)

[origin: EP0127837A2] 1. Process for producing tear-open lines in metal sheets (1), in particular for the manufacture of tear-open ends for cans or similar containers, for which the metal sheet (1) is placed on an anvil-like support (3) and a score line is produced by impressing the stamping or scoring edges (5) of a stamping die (2), the shape of which corresponds to that of the tear-open line, to a pre-determined penetration depth, characterized by the support (3) and the stamping die (2) being each formed of individual segments and composed such that score line portions, which are inclined against each other at an acute angle, are consecutively impressed using one individual segment each of the support (3) and the stamping die (2) jointly, with a first portion of the score line being produced first and a further portion of the score line being produced next in a position relative to the first score line portion such that the two score line portions intersect at the vertex of the angle formed between them.

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