

Title (en)

BOTTOM COATING OF BEVERAGE CANS

Title (de)

BODENLACKIERUNG VON GETRÄNKEDOSEN

Title (fr)

MISE EN PEINTURE DU FOND DE BOITES-BOISSONS

Publication

**EP 1253980 A1 20021106 (DE)**

Application

**EP 01911582 A 20010202**

Priority

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- EP 0101140 W 20010202

Abstract (en)

[origin: WO0156704A1] The aim of the invention is to provide a method, with which the smallest possible amount of paint used for coating the bottom of the can extends beyond the bottom area (30a, 30b) and into the wall area (30c) provided with a decoration, in order to reduce the amount of paint used and to prevent the decoration from being altered. To these ends, the invention involves a coating process that uses a fluid coating substance, whereby the cans (30) each have a can axis (102). The cans (30) are supplied in succession out of an inlet (4) while being retained on a support (3) for at least one time interval of the coating process and while being rotated around at least one axis (100, 101, 102). A spraying head (15, 15a), with a spraying axis (104), sprays the coating substance onto at least one of the supplied cans (30), whereby the coating substance is sprayed with a first angle ( alpha ) of the spraying axis with regard to the can axis (102) onto an outer section (30a) of the bottom area of the at least one can. The coating substance is sprayed with a second angle ( beta ) with regard to the can axis onto a section (30b) of the bottom area that is located further inside in a radial direction, whereby the second angle ( beta ) differs from the first angle ( alpha ).

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