

Title (en)  
Method for producing a metal can body

Title (de)  
Verfahren zum Herstellen eines Körpers einer Metalldose

Title (fr)  
Méthode de production du corps d' une boîte métallique

Publication  
**EP 1419831 A1 20040519 (EN)**

Application  
**EP 02079802 A 20021114**

Priority  
EP 02079802 A 20021114

Abstract (en)  
Method for producing a metal can body, comprising the steps: v. providing an intermediate cup (1) comprising a bottom section and a side wall, the intermediate cup being a result of a previous operation including at least a step of deep drawing a blank comprising a metal sheet, the metal sheet having a thickness t; vi. placing the intermediate cup coaxially into a redrawing die (3), having, when viewed in its axial cross section, a blank holder face (2) connected to an axial inside peripheral surface via a redrawing radius (Rd); vii. inserting an annular blank holding member (5) inside the intermediate cup, the blank holder having, when viewed in its axial cross section, a counter blank holder face (4) connected to a peripheral face (7) via a holding radius (Rh), whereby the intermediate cup is clamped between the blank holder face and the counter blank holder face; viii. moving a punch (6) in axial direction relative to the redrawing die through the annular blank holding member into engagement with the intermediate cup, followed by redrawing the intermediate cup; whereby the holding radius (Rh) is chosen in dependence with thickness t in accordance with a condition  $R_h / t > 4.35$ . <IMAGE>

IPC 1-7  
**B21D 22/28**; **B21D 22/30**

IPC 8 full level  
**B21D 22/28** (2006.01); **B21D 22/30** (2006.01)

CPC (source: EP)  
**B21D 22/28** (2013.01); **B21D 22/30** (2013.01)

Citation (search report)  
• [X] US 5105645 A 19920421 - KOBAYASHI TOMOMI [JP], et al  
• [X] US 4425778 A 19840117 - FRANEK JOSEF T [GB], et al  
• [X] EP 0664169 A1 19950726 - TOYO KOHAN CO LTD [JP]  
• [A] EP 0425704 A1 19910508 - TOYO SEIKAN KAISHA LTD [JP]

Designated contracting state (EPC)  
AT BE BG CH CY CZ DE DK EE ES FI FR GB GR IE IT LI LU MC NL PT SE SK TR

DOCDB simple family (publication)  
**EP 1419831 A1 20040519**

DOCDB simple family (application)  
**EP 02079802 A 20021114**