

Title (en)
METHOD FOR MANUFACTURING LONG METAL STOPPER CAPS COMPRISING A SKIRT HAVING A CONSTANT THICKNESS

Title (de)
VERFAHREN ZUR HERSTELLUNG VON LANGEN METALLISCHEN VERSCHLUSSKAPPEN MIT EINER SCHÜRZE MIT KONSTANTER DICKE

Title (fr)
PROCEDE DE FABRICATION DE CAPSULES LONGUES DE BOUCHAGE METALLIQUES COMPRENANT UNE JUPE AYANT UNE EPAISSEUR CONSTANTE

Publication
EP 3965977 A1 20220316 (FR)

Application
EP 20723410 A 20200506

Priority

- FR 1904810 A 20190509
- FR 1912577 A 20191108
- EP 2020062546 W 20200506

Abstract (en)
[origin: WO2020225288A1] Disclosed is a method for manufacturing metal stopper caps comprising the following sequence of steps: a) providing a strip or sheet made from aluminium alloy coated on both faces with a layer of varnish; b) a first cutting operation in order to obtain discs referred to as blanks; c) a step of stamping the blanks, in one or more passes, in order to form a stamped preform, comprising a head and a skirt; c') at least one drawing step consisting of passing the stamped preform through at least one drawing ring in order to lengthen the metal and make it thinner, so as to form a cap comprising a head preferably having a diameter of between 20 and 40 mm, and more preferably between 25 and 35 mm, a skirt preferably having a length of between 40 and 85 mm, more preferably between 40 and 83 mm, more preferably still between 40 and 80 mm, more preferably still between 40 and 70 mm, and more preferably still between 45 and 65 mm, the top of the cap being on the head side and the bottom of the cap on the side where the skirt ends, the skirt having a constant thickness of between 0.12 and 0.27 mm, and preferably between 0.15 and 0.25 mm, over at least 20% of its length starting from the bottom of the cap (and preferably up to 60% of its length starting from the bottom of the cap), and comprising a continuous and intact layer of varnish along the entire length of the skirt, on both the inside and the outside of the cap; d) an optional step of degreasing the cap; e) an optional step of printing and/or applying finishing varnish for protection and/or decoration.

IPC 8 full level
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CPC (source: EP US)
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Citation (search report)
See references of WO 2020225288A1

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