

A B S T R A C T

FILLING CANS

A method of filling a can with a non-carbonated product comprises in sequence the steps of (a) filling an open topped can with the product to leave a headspace; (b) blowing a permanent gas into the headspace to
5 substantially fill the headspace and displace water vapour from the headspace; (c) seaming a can end onto the can to close the can; and (d) deforming the can end or can bottom from a first stable shape to a second stable shape so reducing the headspace volume and increase the headspace
10 pressure to a level such that in anticipated conditions of processing, transit and storage the internal pressure remains above 1 atmosphere.

The benefits arising are that cans having a thin side wall are supported against abuse or collapse and the cans
15 remain in their desired shape.

This Sheet Has Been Replaced

