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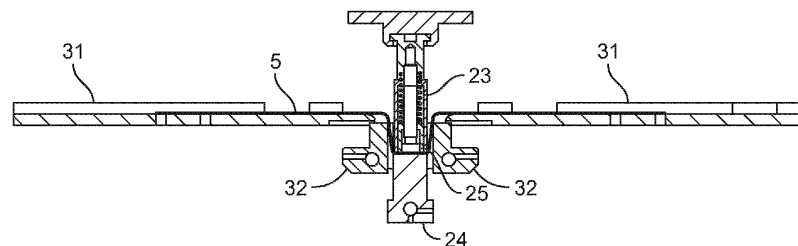


FIG. 12

(57) Abstract: The present invention is directed to a process for manufacturing a flexible package suitable for containing a food or beverage ingredient and suitable for use with a food or beverage preparation machine, wherein said process comprises punching a flexible flat blank sheet between a plunger and a cavity that are movable relative to one another. According to the invention, the plunger has a concave end side and convex lateral sides, and the profile curvature of its end side is identical to the profile curvature of each of its lateral sides.

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