WHAT IS CLAIMED IS:

1. A heat exchange unit for housing a pressurized medium for use in cooling a food or beverage disposed within a container and surrounding the heat exchange unit comprising:

a metal shell having an outer surface, a closed bottom and an open upper end terminating in a rim;

a metal top section having an opening defined by a solid curl and a skirt fitted over the open upper end of said metal shell and extending downwardly along the outer surface of said shell; and

a metal to metal adhesive disposed between said top section and said shell to permanently secure said metal top section to said metal shell.

2. A heat exchange unit as defined in claim 1 which further includes compressed carbon particles received within said metal shell.

3. A heat exchange unit as defined in claim 1 wherein said skirt of said top section includes an inner surface, said adhesive being disposed on said inner surface.

4. A heat exchange unit as defined in claim 3 wherein said inner surface of said skirt includes a continuous shoulder disposed intermediate said opening therein and a terminus of said skirt, said rim of said metal shell abutting said shoulder when said top section is placed on said metal shell.

5. A heat exchange unit as defined in claim 2 which further includes a valve secured to said solid curl for injecting a pressurized medium into said heat exchange unit to be adsorbed by said carbon and for desorbing said pressurized medium to cool said food or beverage.

6. A heat exchange unit as defined in claim 1 wherein said metal top section is substantially thicker than said metal shell.

7. A heat exchange unit as defined in claim 6 wherein said metal top section is die cast.

8. A heat exchange unit as defined in claim 6 wherein said metal top section is machined.

9. A heat exchange unit as defined in claim 6 wherein said metal shell and said metal top section are constructed from aluminum and said shell is impact extruded.

10. A heat exchange unit as defined in claim 6 wherein the inner diameter of said skirt is substantially the same as the outer diameter of said metal shell but dimensioned to allow said skirt to slip fit over said metal shell during assembly.

11. A heat exchange unit as defined in claim 2 wherein said pressurized medium is carbon dioxide.

12. A heat exchange unit as defined in claim 3 wherein said inner surface of said top section defines at least one groove and said adhesive indisposed at least within said groove.

WHAT IS CLAIMED IS:

1. A heat exchange unit for housing a pressurized medium for use in cooling a food or beverage disposed within a container and surrounding the heat exchange unit comprising: a metal shell having an outer surface, a closed bottom and an open upper end terminating in a rim; a die cast metal top section being substantially thicker than said metal shell and having an opening defined by a solid curl and a skirt having an inner surface and a terminus shoulder fitted over the open upper end of said metal shell and extending downwardly along the outer surface of said shell; said rim of said metal shell abutting said shoulder of said skirt inner surface so that the skirt inner surface overlaps the outer surface of said shell for a substantial distance; and a metal to metal bonding adhesive disposed between said top section inner surface and said shell outer surface to permanently secure said metal top section to said metal shell.

2. The heat exchange unit as defined in claim 1 which further includes compressed carbon particles received within said metal shell.

3. The heat exchange unit as defined in claim 2 which further includes a valve secured to said solid curl for injecting a pressurized medium into said heat exchange unit to be absorbed by said carbon and for desorbing said pressurized medium to cool said food or beverage.

4. The heat exchange unit as defined in claim 3 wherein said metal top section is die cast zinc.

5. The heat exchange unit as defined in claim 3, wherein the inner diameter of said skirt is substantially the same as the outer diameter of said metal shell but dimentioned to allow said skirt to slip fit over said metal shell during assembly.

6. The heat exchange unit as defined in claim 2 wherein said pressurized medium is carbon dioxide.