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(54) Title: MANUFACTURING TOOLING AND METHODS FOR PRODUCING PUSH BUTTON CONTAINER CLOSURES

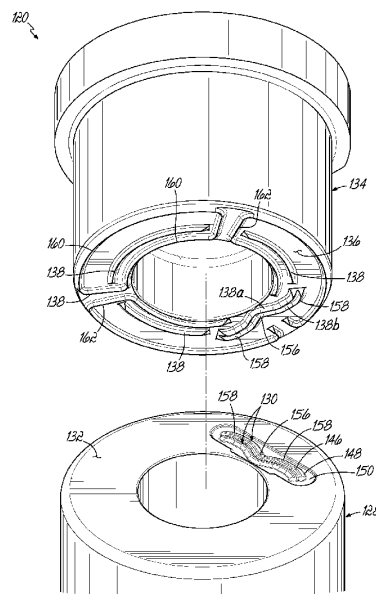


FIG. 8

(57) Abstract: A tooling assembly and related method of manufacture for making a push button container closure 10 are provided. Advantageously, the tooling assembly only includes one "all in one" press station 120 at which all score lines 30, 32, 34 are cut into the blank 50 that is being formed into the container closure 10. Furthermore, the profiles and features of the container closure 10 are generally rotationally symmetrical except at the score lines 30, 32, 34, and as such, no orientation dimples or other features need to be formed in the blank 50 or used to maintain an exact rotational position of the blank 50 as it moves between the various press stations 70, 80, 100, 120 of the tooling assembly. As a result, the manufacturing tooling itself is easier to use and more efficient because at least one press/scoring station and the orientation equipment of conventional tooling designs are no longer necessary in this process.

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