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(54) Title: AEROSOL TILT VALVE AND METHOD OF FORMING (57) Abstract An aerosol tilt valve has an integrated molded hollow stem shaft (18) and molded conical stem cup (19). An upper outer circumferential edge of the stem cup normally fully seals, except when the valve is tilted, against a gasket surrounding the stem shaft. The outer lower wall of the stem shaft and the inner wall of the stem cup define an annular space. At least one molded metering orifice below the upper edge of the stem cup extends from the annular space through the stem shaft. The stem shaft is molded with a molded annular recess about the lower shaft end and with the at least one molded metering orifice. The molded stem shaft is inserted in a mold cavity. A lower portion of an annular shield blocks the metering orifice, and together with the mold cavity and lower part of the stem shaft, defines the stem cup shape. The stem cup is molded having an annular projection extending into the annular recess to form a strong and fully integrated stem cup and stem shaft functioning essentially as one piece. The lower portion of the shield also defines the annular space.		