Claims

1. An injection-molded container, preferably a capsule for use in a food preparation machine, said container for use in a food preparation machine comprising:

(i) a rigid or semi-rigid structure (1) with a lower side (2), at least three pillars (3) extending from the lower side and linked to a circular upper frame (4) which defines the surroundings of the container top side, the pillars (3) having cross-sections $\mathbf{S_1}$, $\mathbf{S_2}$ and $\mathbf{S_3}$, the lower side (2) being a solid wall that comprises a through hole as a dispensing opening (5) for the container, that is centered across the vertical symmetry axis *VSA* of said container, and

(ii) a label (6) attached to the outer surface of the lower side (2), of the pillars (3) and of the upper circular frame (4), thus forming an envelope that defines container side walls,

characterized in that the injection point *IP* of the container is off-centered in the vicinity of said dispensing opening (5), opposed the pillar (3) having a cross-section $\mathbf{S_3}$ relatively to the vertical symmetry axis *VSA* of the container, and in that $\mathbf{S_1}=\mathbf{S_2}$ and $\mathbf{S_3}>\mathbf{S_1}$.

2. A container according to claim 1, wherein the circular upper frame (4) has a substantially L-shaped cross-section with a first circular portion (7) disposed vertically to which the pillars (3) are linked, said vertical portion (7) being linked at its upper side to a second horizontal circular portion (8) forming a peripheral edge, said first vertical portion (7) having a height a and a thickness x, said second horizontal portion (8) having a width b and a thickness y, and the ratio of thicknesses of the container top edge portions (7, 8) is such that x > y, and the ratio of the cross-sections of the container top edge portions (7, 8) is such that xa > yb.

3. A container, preferably a capsule according to any of the preceding claims 1 and 2, wherein the lower side (2) of the capsule has the shape of a cone, a disk, a truncated pyramid or a hemisphere.

4. A container, preferably a capsule according to any of the preceding claims, wherein the in-mould label (6) is of lower rigidity than the support structure (1) and designed to ~~liquid-tightly~~ seal said structure (1) in a liquid-tight manner, at least along the side walls of the capsule.

5. A container, preferably a capsule according to any of the preceding claims, wherein the support structure (1) is dimensioned and/or designed to be easily compacted by compressing, twisting or pinching said capsule.

6. A container, preferably a capsule according to any of the preceding claims, wherein the support structure (1) comprises predetermined weakened zones.

7. A container, preferably a capsule according to any of the preceding claims, wherein the in-mould label (6) is at least partially transparent or translucent.

8. A container, preferably a capsule according to any of the preceding claims, wherein a top membrane (9) is sealed onto the circular upper frame (4), so as to close the upper side of said capsule.

9. A container, preferably a capsule according to any of the preceding claims, which comprises at least one wall disposed across the capsule internal chamber, such that the internal volume of said capsule is divided into at least two distinct compartments.

10. A container, preferably a capsule according to claim 9, wherein said at least one wall is disposed horizontally within the capsule chamber, such that the corresponding compartments are superimposed one onto the other.

~~**11.** A method for manufacturing a container, preferably a capsule as claimed in claims 1 to 10, the method comprising the steps of:~~

~~- positioning an in-mould label into a mould,~~

~~- injecting a plastic material into the mould such that it forms a support structure having at least one hollow portion closed by the label.~~

~~**12.** A method according to claim 11, wherein the in-mould label is connected to axial and/or transversal support pillars of the structure, thereby sealing the at least one hollow portion of the support structure.~~

~~**13.** A method according to claim 11 or 12, wherein the in-mould label and the support structure are positioned relative to each other such that the in-mould label essentially forms at least a lateral side wall of the capsule.~~

~~14.~~11. A system for the preparation of food products, particularly beverages, which comprises in combination:

(i) a capsule according to any of the claims 1 to 10 which encloses at least one ingredient to be dissolved and/or extracted by a fluid injected in said capsule, and

(ii) a machine for the preparation of said food product, which is adapted to receive said capsule and inject a fluid under pressure inside said capsule, so as to prepare a food product, preferably a beverage, by extraction and/or dissolution of the ingredient contained in said capsule with said fluid.