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(54) Title: **THE APPARATUS AND METHOD FOR ATTACHING HEAT EXCHANGE UNIT AND VALVE TO THE BOTTOM OF SELF-COOLING AND SELF-HEATING FOOD OR BEVERAGE CONTAINERS**

(57) Abstract

A method and apparatus of forming a flange (14) in the bottom of a container (10) by first removing a portion of the container bottom (28) and then forming or swaying the material around the opening (28) to form a flange (14) extending away from the container bottom. A valve (24) and valve cup (22) assembly along with a heat exchange unit (16, 18, 32) are positioned adjacent the flange (14) and the combination is crimped to permanently affix the heat exchange unit (16, 18, 32) to the bottom of the container (12).

