

Abstract

Can Ends

A method of forming a can end having a seaming panel 30, a chuck wall 32, and a central panel 17; the central panel being connected to the chuck wall by an outer anti-peaking bead 27 and the can end having one or more flexible beads 24,25 located concentrically within the outer bead, the method comprises the steps of:

a) in a first stage, drawing a preliminary cup having a seaming panel, a chuck wall and a central panel, and forming the inner beads by pressing the central panel between upper and lower profiled tools 15,16; and

b) in a second stage, clamping the seaming panel and the central panel and moving them towards one another to form the outer bead 27 by deformation of material from the chuck wall in an unconstrained rolling action.

Fig. 8.

This Sheet Has Been Replaced

