

Galvanic cell with a cylindrical container

This invention relates to a galvanic cell comprising a cylindrical container having an open end with an inwardly turned peripheral edge, said container including therein active ingredients of the cell. The invention particularly relates to a seal closure assembly of the resealable type for the open end of the cell container comprising a cover having a resilient annular flange depending from the lower side thereof and a notch circumferentially disposed about said flange, said peripheral edge coming to be seated within said notch upon depressing said cover into said container.

Resealable vent closures for cylindrical dry cell are well known in the art. In U.S. Patent No. 3,802,923 the open end of the cell is closed by a cover which operates as a valve in conjunction with the open end of the cell for releasing trapped gas when the pressure within the cell exceeds a predetermined limit. The cover also serves to secure the cell from internal and external displacement forces. The latter is accomplished by providing the cover with a depending flange having an annular notch which is adapted to engage the peripheral edge of the open container and lock it in place. For small diameter cells such as, for example, the "AAA" size dry cell the locking forces provided by this closure arrangement may be insufficient to protect against release of the closure particularly after long periods of storage during which the zinc and/or plastic may creep.

Additional closure protection may also be necessary for other round cell sizes in applications where abusive external forces may exist to cause separation of the cell container from the cover member. For example, internally developed forces may form in a dry cell from the trapped gas below the cathode mix at the bottom end of the cell which may tend to cause the entire cathode mix structure to rise up against the seal closure and unlock the cover from inside the container. In addition, the external jacket of the dry cell which is usually of a paper composition is not designed to provide protection against externally applied forces or to support the container from internally developed forces.

In U.S. Patent No. 3,740,271 there is disclosed a cylindrical dry cell having a closure assembly which comprises a cover having an annular recess extending from the outside into the cover. The recess is adapted to receive a cylindrical flange of a cup-shaped reinforcing element. In this known closure assembly the reinforcing element serves as rigid backing-up structure to take up the forces which are applied by pressing a sealing cap onto the plastic cell container wall being pressure-sandwiched between the reinforcing element and the sealing cap. Apart from serving as a backing-up structure the flange of the reinforcing element

does not in any way act as a locking element preventing the cell cover from coming-off. The cell cover is exclusively kept in place by the compressed sealing cap. Thus this known closure assembly does not provide for a resealable vent closure operating as a valve under inside gas pressure and does therefore not belong to the kind of closure assemblies concerned by the present invention.

The problem to be solved by the present invention is to provide an improved seal closure assembly of the releasable vent closure type for a cylindrical galvanic cell which can vent internally developed gas while securing the open end of the container in an improved locked relationship to the closure assembly under relatively large internal and/or external displacing forces.

For a galvanic cell according to the first part of claim 1 this problem is solved according to the invention by providing an annular recess in the upper side of said cover and extending into the resilient annular flange to a level below the level of said notch, and a generally rigid locking collar adapted to be inserted within that recess after assembly of said cover in order to prevent said resilient annular flange from snapping out of engagement with said notch.

According to a preferred embodiment an improved seal is obtained by providing a second resilient annular flange surrounding that first annular flange and extending over the inwardly turned peripheral edge for forming a resilient flapper valve member in combination therewith.

Figure 1 is a perspective view, partly in cross-section, of an assembled primary galvanic dry cell incorporating a seal closure embodiment according to the invention;

Figure 2 is an exploded perspective view partly in cross-section of the seal closure assembly of Figure 1; and

Figure 3 is an exploded perspective view of another embodiment of the seal closure assembly of the invention.

Referring now in particular to Figures 1 and 2 in which is shown a primary galvanic dry cell 10 embodying the closure assembly of the present invention. The dry cell 10 includes a cylindrical container 12 having an open peripheral top edge 13 which is inwardly turned to form a curved rim 14. The top edge 13 is mechanically locked to the closure assembly 16 for sealing the cell 10 in a manner to be explained in more detail hereinafter. The cell container 12 serves as the anode for the cell 10 and may be formed from an electromechanically consumable metal such as zinc. A cathode in the form of a bobbin 18 is disposed within the container 12 about a centrally disposed cathode collector rod 20. A layer of separator material 22 which contains electrolyte, e.g. a thin bibulous paper coated

with an electrolyte gel paste surrounds the cathode bobbin 18 for separating the cathode 18 from the anode container 12. The cathode bobbin 18 may represent a depolarizer mix cake containing, for instance, manganese dioxide, a conductive material such as carbon black or graphite and electrolyte. The cathode bobbin 18 may be molded about the collector rod 20 in a separate operation prior to cell assembly and placed inside the cell container 12 with the upper end 24 of the cathode collector rod 20 protruding through the open end of the cell container 12. An air space 36 is formed between the cathode bobbin 18 and the top edge 13 of the container 12 to accommodate any liquid spew that may be formed on discharge of the cell.

The closure assembly 16, as is more clearly shown in Figure 2 comprises a cover 38 and a locking collar 40. The cover 38 should be composed of an electrically insulating and corrosion resistant material such as a resilient plastic which may be molded into one piece. Suitable resilient plastic material for this purpose includes thermoplastic organic resins such as polyethylene and polypropylene. The cover 38 includes three annular ring flanges depending from its lower side, i.e., an inner flange 42, an intermediate flange 44 and an outer flange 46. The flanges are all spaced apart and are substantially concentric with one another. On the upper side 39 of cover 38 is formed an annular recess 48 which should lie within the intermediate flange 44 to accommodate the locking collar 40 and should extend below the level of notch 60 as described later. The annular recess 48 has a preferred right angle cross-sectional geometry with an inclined wall 50 which facilitates entry of the locking collar 40 and a substantially vertical wall 52 which may have a slight taper of up to about 3.0 degrees with respect to the vertical. The locking collar 40 is a metal one piece member having a cylindrical body with a raised top portion 41 for covering and gripping the protruding end 24 of the rod 20. The locking collar 40 is inserted into the annular recess 48 after the cover 38 is assembled in place over the container 12 as will be explained in detail hereafter.

A central opening 54 of substantially cylindrical geometry extends through the inner flange 42 of the cover 38 and is of a diameter substantially equivalent to the diameter of the collector rod 20 so as to establish a tight interference fit with the collector rod 20. The collector rod 20 penetrates the opening 54 when the seal assembly 16 is pressed into place. The inner flange 42 may be chamfered at its bottom end 56 to facilitate entry of the collector rod 20.

The outer flange 46 is in the form of a thin annular lip which extends over the curved rim 14 of the container 12. The diameter of the outer flange is slightly smaller than the diameter

of the cell container 12 so that when the cover 38 is pressed over the open end of the cell container 12 the outer flange 46 flares outwardly to engage the curved rim 14. The curved rim 14 may be formed by crimping the peripheral edge 13 of the open cell container 12 using a conventional crimping tool which has the desired radius of crimp (e.g., approximately 6.5 mm radius in the case of a standard "D" size zinc can). The crimping tool is forced over the open cell container 12 to turn the peripheral edge 13 inwardly until a curved rim 14 is formed having an appropriate radius of curvature. The flange 46 engages the curved rim 14 in interference fit to form an effective fluid-tight seal at the open end of the cell container 12. This fluid-tight seal remains closed during normal shelf storage and operation of the dry cell. Hence, the cell is effectively sealed against the escape of electrolyte or moisture by evaporation and is also sealed against the ingress of air or oxygen from the atmosphere. However, when the cell is subjected to severe or abusive conditions of discharge or high temperature shelf the gas pressure inside the cell 10 may reach an undesirable or excessive level. Upon the development of excessive gas pressure of above a predetermined level the outer flange 46 is caused to deflect outwardly in a direction away from the curved rim 14 thereby breaking the seal and allowing gas to escape or event from inside the cell 10. One the gas pressure is released, the resiliency of the outer flange 46 causes it to reseat and to reestablish the seal. Accordingly, the outer flange 46 acts as a resilient flapper valve member which functions in conjunction with the curved rim 14 of the container 12 for resealably releasing an excess of gas pressure from inside the cell 10.

The intermediate flange 44 of the cover 38 is formed with an annular notch 60 surrounding its circumference. The inwardly turned edge 13 snaps into engagement with the annular notch 60 upon depressing the cover 38 into the container 12. Although this connection provides a relatively secure mechanical lock, the holding power of this lock is greatly enhanced by the insertion of the locking collar 40 into the annular recess 48. To realize maximum benefit from the locking collar 40 it is important that the collar 40 extend down within the recess 48 to a level at least equal and preferably below the level of the notch 60 so as to prevent the intermediate flange 44 from unsnapping.

The seal closure is assembled by placing the cover 38 on top of the cell container 12 with the inner flange 42 surrounding the cathode collector rod 20. The cover is then pressed downwardly so as to force the intermediate flange 44 through the open container 12 until the peripheral edge 13 snaps into engagement with the notch 60. The locking collar 40 is then pushed down into the annular recess 48 until its lower edge lies below the level of notch 60 and

top 41 is seated in gripping engagement with electrode rod 20.

It should be understood that the seal closure assembly 16 of the present invention does not preclude the passage of gas from within the cell through the connection at notch 60. Internally developed gas follows a path from the air space 36 through the mechanical juncture formed between the edge 13 of the container 12 and the notch 60 and then into the annular space 62 between the curved rim 14 and the outer flange 46 which is sealed off during

normal use of the cell. The gas pressure inside the annular space 62 is substantially the same as the gas pressure inside the cell container 10 and is not released by the outer flange 46 until the pressure reaches a predetermined level.

The advantages of the closure arrangement of the present invention is evidenced from the following Table I which compares holding power for a mock-up "N" cell configuration using the seal closure of Figures 1 and 2 both with and without the locking collar 40:

TABLE I - "N" SIZE CELL MOCK-UP

Without Locking Collar on 8 mm (.315") I.D. Crimp		With Locking Collar on 8 mm (.315") I.D. Crimp	
Mechanical Pull-Off Force	Gas Pressure Release Force	Mechanical Pull-Off Force	Gas Pressure Release Force
6,7 N (1 1/2 lb.)	2,3 bar (33 psi)	on 30 # Limit Force Gage	13,8 bar (200 psi)
8,9 N (2 lb.)	1,5 bar (22 psi)	133 N (30 lb.)	
20,0 N (4 1/2 lb.)	2,2 bar (32 psi)	133 N (30 lb.)	
	2,3 bar (33 psi)	on 50 # Limit Force Gage	
		189 N (42 1/2 lb.)	

The following Table II shows the venting characteristics for a typical "N" cell using the seal closure assembly of the present invention.

TABLE II

"N" SIZE CELL-VENTING CHARACTERISTICS AT ROOM TEMPERATURE

Sample No.	Zinc Can Crimp I.D.	Initial Venting Pressure	Six Days Venting Pressure	Twelve Days Venting Pressure
1	8,08 mm (.318")	4,1 bar (60 psi)*	5,2 bar (75 psi)	5,5 bar (80 psi)
2	8,15 mm (.321")	3,8 bar (55 psi)	2,1 bar (30 psi)	2,1 bar (30 psi)
3	8,15 mm (.321")	4,1 bar (60 psi)*	2,6 bar (38 psi)	2,5 bar (37 psi)
4	8,20 mm (.323")	4,1 bar (60 psi)*	3,9 bar (56 psi)	Perforated Can - No Test

* 4,1 bar (60 psi) Limit of Gage.

Figure 3 shows an alternative embodiment of the present invention wherein the locking collar 40 is divided into independently functioning component members 70 and 72 respectively. The locking member 70 has a cylindrical body portion which is pressed into the annular recess 48 to increase the holding power of the mechanical connection between the edge 13

and the notch 60 as explained heretofore. For this purpose member 70 may be composed of either plastic or metal. The contact member 72, on the other hand, functions as the positive terminal cap for the cell and must be of metal. The member 72 is positioned over and in contact with the collector rod 20 and has a rim 76 which is seated upon a circular ledge 78

formed in the cover 38. The member 70 has a partially closed top surface 74 which is fitted over member 72. If desired rim 76 of member 72 can be embedded in cover 38 by molding or mechanically pressing to form a unitary structure.

The container 12 is crimped at its open end as explained heretofore to form the curved rim 14. An additional indenting operation may be carried out to form a number of inwardly directed projections 80 around the peripheral edge 13 of the container 12. The projections 80 will bite into the bottom of notch 60 upon depressing the cover 38 into the container 12 to provide an additional locking force for holding the edge 13 in place within the notch 60. It should be understood that this feature may be used in combination with the one piece locking collar 40 of Figures 1 and 2 or alternatively the two-piece locking collar of Figure 3 may be used with the crimped container 12 without forming the projections 80.

The rawcell 10 of either embodiment, after the seal closure assembly 16 has been secured to the container 12, may be finished in a conventional manner by encasing it within an outer paper jacket (not shown). The paper jacket need only extend up to the outer flange 46 of the cover 38.

Claims

1. A galvanic cell (10) comprising a cylindrical container (12) having an open end with an inwardly turned peripheral edge (13), said container (12) including therein active ingredients of the cell and a seal closure assembly (16) of the resealable vent type for said open end, said seal closure assembly (16) comprising a cover (38) having a resilient annular flange (44) depending from the lower side thereof and a notch (60) circumferentially disposed about said flange (44), said peripheral edge (13) coming to be seated within said notch (60) upon depressing said cover (38) into said container (12), characterized by an annular recess (48) in the upper side (39) of said cover (38) and extending into the resilient annular flange (44) to a level below the level of said notch (60), and a locking collar (40) for insertion within said recess (48) to prevent said resilient annular flange (44) from snapping out of engagement with said notch (60).

2. A galvanic cell as defined in claim 1 wherein said locking collar (40) extends to below the level of said notch (60).

3. A galvanic cell as defined in claim 1 or 2, characterized in that it further comprises a second resilient annular flange (46) surrounding said first annular flange (44) and extending over said inwardly turned peripheral edge (13) for acting as a resilient flapper valve member in conjunction therewith.

4. A galvanic cell as defined in one of claims

1 to 3, characterized in that said annular recess (48) has a substantially vertical outside wall (52) and an inclined inside wall (50).

5. A galvanic cell as defined in claim 4, characterized in that said wall (52) substantially aligned with the vertical has a predetermined taper of up to about 3.0 degrees.

6. A galvanic cell as defined in one of claims 1 to 5, characterized in that said cover (38) is plastic and wherein said locking collar (40) is metal.

7. A galvanic cell as defined in one of claims 1 to 6, characterized in that said locking collar (40) is of unitary construction having a cylindrical lower body and a raised centrally disposed upper portion (41) representing the positive terminal cap for said cell.

8. A galvanic cell as defined in one of claims 1 to 6, characterized in that said locking collar (40) consists of a cup-shaped member (70) extending with a lower cylindrical portion within said annular recess (48) and having a central opening for accommodating a terminal cap (72) for said cell.

9. A galvanic cell as defined in one of claims 1 to 8, characterized in that said inwardly turned peripheral edge (13) has a predetermined number of indented projections (80) extending therefrom for gripping said notch (60).

Revendications

1. Une pile galvanique (10) comprenant un boîtier cylindrique (12) présentant une extrémité ouverte avec un bord périphérique (13) recourbé vers l'intérieur, ledit boîtier (12) contenant des ingrédients actifs de la pile et un ensemble (16) d'obturation étanche du type à évent pouvant être rebouché, destiné à ladite extrémité ouverte, ledit ensemble (16) d'obturation étanche comprenant un couvercle (38) ayant un rebord annulaire élastique (44) qui fait saillie de sa face inférieure et une encoche (60) ménagée circonférentiellement autour dudit rebord (44), ledit bord périphérique (13) venant se loger dans ladite encoche (60) lorsque ledit couvercle (38) est introduit sous pression dans ledit boîtier (12), caractérisée par un évidement annulaire (48) dans la face supérieure (39) dudit couvercle (38) et s'étendant dans le rebord annulaire élastique (44) jusqu'à un niveau inférieur au niveau de ladite encoche (60), et une bague (40) de blockage destinée à être introduite dans ledit évidement (48) pour empêcher ledit rebord annulaire élastique (44) de se dégager élastiquement de ladite encoche (60).

2. Une pile galvanique selon la revendication 1, dans laquelle ladite bague (40) de blockage s'étend jusqu'au-dessous du niveau de ladite encoche (60).

3. Une pile galvanique selon la revendication 1 ou 2, caractérisée en ce qu'elle comprend en outre un second rebord annulaire élastique (46)

formed in the cover 38. The member 70 has a partially closed top surface 74 which is fitted over member 72. If desired rim 76 of member 72 can be embedded in cover 38 by molding or mechanically pressing to form a unitary structure.

The container 12 is crimped at its open end as explained heretofore to form the curved rim 14. An additional indenting operation may be carried out to form a number of inwardly directed projections 80 around the peripheral edge 13 of the container 12. The projections 80 will bite into the bottom of notch 60 upon depressing the cover 38 into the container 12 to provide an additional locking force for holding the edge 13 in place within the notch 60. It should be understood that this feature may be used in combination with the one piece locking collar 40 of Figures 1 and 2 or alternatively the two-piece locking collar of Figure 3 may be used with the crimped container 12 without forming the projections 80.

The rawcell 10 of either embodiment, after the seal closure assembly 16 has been secured to the container 12, may be finished in a conventional manner by encasing it within an outer paper jacket (not shown). The paper jacket need only extend up to the outer flange 46 of the cover 38.

Claims

1. A galvanic cell (10) comprising a cylindrical container (12) having an open end with an inwardly turned peripheral edge (13), said container (12) including therein active ingredients of the cell and a seal closure assembly (16) of the resealable vent type for said open end, said seal closure assembly (16) comprising a cover (38) having a resilient annular flange (44) depending from the lower side thereof and a notch (60) circumferentially disposed about said flange (44), said peripheral edge (13) coming to be seated within said notch (60) upon depressing said cover (38) into said container (12), characterized by an annular recess (48) in the upper side (39) of said cover (38) and extending into the resilient annular flange (44) to a level below the level of said notch (60), and a locking collar (40) for insertion within said recess (48) to prevent said resilient annular flange (44) from snapping out of engagement with said notch (60).

2. A galvanic cell as defined in claim 1 wherein said locking collar (40) extends to below the level of said notch (60).

3. A galvanic cell as defined in claim 1 or 2, characterized in that it further comprises a second resilient annular flange (46) surrounding said first annular flange (44) and extending over said inwardly turned peripheral edge (13) for acting as a resilient flapper valve member in conjunction therewith.

4. A galvanic cell as defined in one of claims

1 to 3, characterized in that said annular recess (48) has a substantially vertical outside wall (52) and an inclined inside wall (50).

5. A galvanic cell as defined in claim 4, characterized in that said wall (52) substantially aligned with the vertical has a predetermined taper of up to about 3.0 degrees.

6. A galvanic cell as defined in one of claims 1 to 5, characterized in that said cover (38) is plastic and wherein said locking collar (40) is metal.

7. A galvanic cell as defined in one of claims 1 to 6, characterized in that said locking collar (40) is of unitary construction having a cylindrical lower body and a raised centrally disposed upper portion (41) representing the positive terminal cap for said cell.

8. A galvanic cell as defined in one of claims 1 to 6, characterized in that said locking collar (40) consists of a cup-shaped member (70) extending with a lower cylindrical portion within said annular recess (48) and having a central opening for accommodating a terminal cap (72) for said cell.

9. A galvanic cell as defined in one of claims 1 to 8, characterized in that said inwardly turned peripheral edge (13) has a predetermined number of indented projections (80) extending therefrom for gripping said notch (60).

Revendications

1. Une pile galvanique (10) comprenant un boîtier cylindrique (12) présentant une extrémité ouverte avec un bord périphérique (13) recourbé vers l'intérieur, ledit boîtier (12) contenant des ingrédients actifs de la pile et un ensemble (16) d'obturation étanche du type à évent pouvant être rebouché, destiné à ladite extrémité ouverte, ledit ensemble (16) d'obturation étanche comprenant un couvercle (38) ayant un rebord annulaire élastique (44) qui fait saillie de sa face inférieure et une encoche (60) ménagée circonférentiellement autour dudit rebord (44), ledit bord périphérique (13) venant se loger dans ladite encoche (60) lorsque ledit couvercle (38) est introduit sous pression dans ledit boîtier (12), caractérisée par un évidement annulaire (48) dans la face supérieure (39) dudit couvercle (38) et s'étendant dans le rebord annulaire élastique (44) jusqu'à un niveau inférieur au niveau de ladite encoche (60), et une bague (40) de blockage destinée à être introduite dans ledit évidement (48) pour empêcher ledit rebord annulaire élastique (44) de se dégager élastiquement de ladite encoche (60).

2. Une pile galvanique selon la revendication 1, dans laquelle ladite bague (40) de blockage s'étend jusqu'au-dessous du niveau de ladite encoche (60).

3. Une pile galvanique selon la revendication 1 ou 2, caractérisée en ce qu'elle comprend en outre un second rebord annulaire élastique (46)



entourant letit premier rebord annulaire (44) et s'étendant au-dessus dudit bord périphérique (13) recourbé vers l'intérieur afin de se comporter comme un clapet élastique en coopération avec le bord.

4. Une pile galvanique selon la revendication 1 à 3, caractérisée en ce que letit évidemment annulaire (48) comporte une paroi extérieure sensiblement verticale (52) et une paroi intérieure inclinée (50).

5. Une pile galvanique selon la revendication 4, caractérisée en ce que ladite paroi (52) sensiblement alignée avec la verticale présente une inclinaison prédéterminée pouvant atteindre environ 3,0 degrés.

6. Une pile galvanique selon la revendication 1 à 5, caractérisée en ce que letit couvercle (38) est en matière plastique et dans laquelle ladite bague (40) de blocage est en métal.

7. Une pile galvanique selon la revendication 1 à 6, caractérisée en ce que ladite bague (40) de blocage est réalisée d'une seule pièce comprenant un corps inférieur cylindrique et une partie supérieure surélevée (41) disposée centralement et représentant le capuchon de la borne positive de ladite pile.

8. Une pile galvanique selon la revendication 1 à 6, caractérisée en ce que ladite bague (40) de blocage est constituée d'un élément (70) en forme de coupelle s'étendant, avec une partie cylindrique inférieure, dans ledit évidemment annulaire (48) et présentant une ouverture centrale destinée à recevoir un capuchon (72) de borne de ladite pile.

9. Une pile galvanique selon l'une des revendications 1 à 8, caractérisée en ce que ledit bord périphérique (13) recourbé vers l'intérieur comporte un nombre prédéterminé de saillies échancrées (80) partant de ce bord pour s'accrocher dans ladite encoche (60).

Patentansprüche

1. Galvanische Zelle (10) mit einem zylindrischen Behälter (12) mit einem offenen Ende mit nach innen gebogener Umfangskante (13), welcher im Innern die aktiven Zellenbestandteile enthält und mit einer abdichtenden Verschlussanordnung (12) vom Typ mit Wiederabdichtung nach Gasaustritt für das offene Ende versehen ist, wobei die Verschlussanordnung (16) einen Deckel (38) mit einem elastischen ringförmigen Flansch (44) einschließt, der sich von der Unterseite des Deckels nach unten erstreckt, und mit einer entlang des Umfanges des Flansches (44) verlaufenden Kerbe (60), in die die Umfangskante (13) zum Eingriff kommt,

nachdem der Deckel (38) auf den Behälter (12) aufgedrückt worden ist, gekennzeichnet durch einen ringförmigen Spalt (48) in der Oberseite (39) des Deckels (38), welcher sich in den elastischen Flansch (44) bis zu einer Tiefe unterhalb der Lage der Kerbe (60) erstreckt, und durch einen Verriegelungskragen (40) zum Einführen in den Spalt (48), um den elastischen Flansch (44) daran zu hindern, daß er aus dem Eingriff mit der Kerbe (60) springt.

2. Galvanische Zelle nach Anspruch 1, dadurch gekennzeichnet, daß der Verriegelungskragen (40) sich bis in eine Tiefe unterhalb der Lage der Kerbe (60) erstreckt.

3. Galvanische Zelle nach Anspruch 1 oder 2, dadurch gekennzeichnet, daß sie weiterhin einen zweiten elastischen, ringförmigen Flansch (46) aufweist, welcher den ersten ringförmigen Flansch (44) umgibt und sich über die nach innen gebogene Umfangskante (13) erstreckt, um in Verbindung mit dieser als nachgiebiges Klappenventilteil zu wirken.

4. Galvanische Zelle nach einem der Ansprüche 1—3, dadurch gekennzeichnet, daß der ringförmige Spalt (48) eine im wesentlichen vertikale Außenwand (52) und eine geneigte Innenwand (50) hat.

5. Galvanische Zelle nach Anspruch 4, dadurch gekennzeichnet, daß diese im wesentlichen senkrecht ausgerichtete Wand (52) mit einer bestimmten Schräge von bis zu 3° versehen ist.

6. Galvanische Zelle nach einem der Ansprüche 1—5, dadurch gekennzeichnet, daß der Deckel (38) aus Kunststoff und der Verriegelungskragen (40) aus Metall besteht.

7. Galvanische Zelle nach einem der Ansprüche 1—6, dadurch gekennzeichnet, daß der Verriegelungskragen (40) als ein zusammenhängendes Teil ausgebildet ist, mit einem zylindrischen unteren Körper und einem mittig angeordneten, hochgezogenen Oberteil (41), welches die positive Polkappe der Zelle darstellt.

8. Galvanische Zelle nach einem der Ansprüche 1—6, dadurch gekennzeichnet, daß der Verriegelungskragen (40) aus einem topartigen Teil (70) besteht, welches sich mit einem unteren zylindrischen Abschnitt innerhalb des ringförmigen Spaltes (48) erstreckt und eine zentrale Öffnung für die Aufnahme einer Polkappe (72) der Zelle aufweist.

9. Galvanische Zelle nach einem der Ansprüche 1—8, dadurch gekennzeichnet, daß die nach innen gebogene Umfangskante (13) eine bestimmte Anzahl von eingedrückten Vorsprüngen (80) aufweist, die von der Umfangskante ausgehen, um die Kerbe (60) zu erfassen.

