

Description

This invention relates to a method for manufacturing a plastic container as defined in the preamble of claim 1.

Pressure containers have in the past been largely constructed of a metal body and metal end closures. In the instance of the pressure container being an aerosol container, one end closure is contoured to receive and have crimped thereto a metal component referred to in the art as a mounting cup, which cup has affixed thereto a manually-actuable valve.

The metal body of the container is seamed along its length in the case of steel containers. This results, though avoidance is attempted, in an inner shape that is not truly cylindrical, the seam providing a discontinuity in the "true round" shape. In the case of aerosol aluminum containers, though seamless, the thin wall of the container is readily dented and a deviation from the "true round" results.

For many applications of an aerosol package system, for example, where a piston traversing the inner wall of the container body is a component of the package, a deviation from "true round" is undesirable. Where there is deviation from the "true round" a breakage in the seal between the inner wall of the container and the piston will occur with a concomitant loss or decrease in the efficiency of the discharge of the contents of the pressurized container.

Additional shortcomings of metal containers, often manufactured away from the site where the product is introduced into the container, is the shipment of the container to the filling site. Moreover, corrosion may be a problem necessitating a coating of the metal in order to make the inner surface of the container compatible with the product to be dispensed, and consequently and additional manufacturing operation.

The deficiencies of metal containers have resulted in an effort by marketers to replace the metal container with a plastic container.

Plastic pressure container have to date been manufactured by injection molding or blow molding processes. Both processes have serious drawbacks.

When injection molding a container, it is necessary that the body portion of the container have a draft or slope in order to eject the container from the mold. Further, and particularly with containers having a body portion with a length of conventional containers, such as beverage or aerosol containers, it is extremely difficult to fill the cavity defining the body portion of the container with the consequence that channeling or incomplete fill of the injection mold cavity results. As a consequence, in order to properly fill the cavity it is essential to use exces-

sive temperature and pressure conditions, which result in a differential temperature profile over the length of the cavity and consequently stress and strain, warping and embrittlement of the molded container. Additionally, it is difficult to hold the core defining the inside wall of the body portion of the container properly centered with the result that the container wall is of varying thickness. Since permeation from within or external to the container is a function, among others, of the wall thickness, to compensate for a shift from true center of the cavity core, the injection mold cavity must be designed to provide a minimum wall thickness throughout. To assure the necessary minimum thickness necessarily results in a design of a wall thickness excessive to that necessary to properly contain the product.

Blow molding, necessarily, results in the wall of the pressure container being of uneven thickness since the pressure and temperature variations on the surface of the parison or pre-form is not uniform. Moreover, molecular weight variation in the parison and pre-form foreclose formation of a container having a substantially uniform wall thickness. Thus, as in an injection molding process, excessive amounts of plastic must be used in order to assure the minimum wall thickness necessary throughout the container to properly contain the product to be dispensed. Obviously, a variation in the wall thickness precludes formation of a body portion having an inner surface that is "true round" and consequently the container lacks usefulness as a container where the "true round" is essential to the dispensing of the product.

Further, in blow molding a container the end closures necessarily must be formed of the same plastic material. Further, in blow molding design, flexibility is limited. Moreover, in an aerosol-type container, where the top opening is smaller in diameter than the body portion of the container it is impossible to position a piston having a diameter substantially the same as the inside diameter of the container with the container.

In the container defined in the preamble of claim 1 and known from US-A-4 201 306 the joiner between the body portion and the end closure members is achieved by disposing a thermoplastic welding material including heat conductive iron particles into the recesses before inserting the ends of the body portion into the recesses and then, after having inserted the ends, fusing the ends and closure members together by induction heating and applying pressure.

The problem to be solved by the invention is to simplify manufacturing of such a container.

According to the invention this problem is solved as stated in the characterizing part of claim 1.

Preferred embodiments and improvements of this solution are stated in the subclaims.

The invention will be more clearly understood by referring to the drawings herein and the discussion relating thereto.

Figure 1 is a perspective view of the plastic container of this invention with a section through the body portion.

Figure 2 is an exploded cross-section of the body portion and the valve receiving and bottom end closures of the plastic container of this invention.

Figure 3 is a vertical cross-section of the plastic container of this invention.

Figure 4 is a vertical cross-section of the valve receiving end closure of this invention.

Figure 5 is a vertical cross-section of a further embodiment of the invention.

Figure 6 is a vertical cross-section of a specific embodiment of an end closure of this invention.

Figure 7 is a vertical cross-section of a further embodiment of an end closure of this invention.

In Figure 1, the container generally designated as 10, has a valve receiving end closure 12, a cylindrical body portion 14, and an end closure 16.

As shown in Figure 2, the body portion 14 is seamless and in the form shown, cylindrical. The body portion should be able to withstand pressures within the container normally attendant to pressurized containers, such as, for example aerosol dispensers.

The body portion 14 is extrusion formed. It has been found that a group of polyethylene terephthalate resins, referred to as barrier resins and marketed under trademarks, such as Selar® PT resins (marketed by E.I. du Pont de Nemours) are suitable materials for the body portion. Specific Selar® PT resins found suitable are Selar® PT and Selar® PT 5270. Another barrier resin, useful in forming translucent body portions is Selar® PA 3426, this resin being an amorphous nylon. It has been found that with the aforementioned Selar® resins, a container having a wall thickness of 0.254 mm to 1.524 mm (.010" to .060") is satisfactory to function as the container body under normal aerosol dispenser pressures of 0.689 bar to 10.34 bar (10 to 150 PSI).

Conventional extrusion equipment, not shown, may be used to form the body portion 14. Conventional injection molding equipment, not shown, may be used to form the end closures 12 and 16.

The valve receiving end closure 12 has an annular wall 18 having a bead portion 20 defining an opening 34 for receiving a conventional aerosol valve (not shown) and a shoulder portion 22 having an extending portion 23, the outer surface 24 of the annular wall 18 and the inner surface 26 of the extending portion 23 forming a recess 28 to re-

ceive the end portion 30 of the body portion 14. In the base of the recess 28 is an annular undercut 32.

When the end 30 is positioned in the recess 28, the components are spin welded by conventional techniques, the end portion 30 of the body 14 melting and flowing into the undercut 32 to thereby effect a fluid tight seal between the body portion 14 and the end closure 12.

A fluid tight seal between the walls defining the recess 28 and the outer 40 and inner 42 surfaces of the body portion 14 may also be accomplished through sonic welding of the contiguous surfaces of the recess 28 and the surfaces 40 and 42 of the body portion 14.

The end closure 16 has an annular upstanding wall 36, traversing which is a domed portion 38. As in end closure 12, closure 16 has an annular upstanding wall 44 and a shoulder 46 having an extending portion 48, the outer surface 50 of the annular walls 36 and 44 and the inner surface 52 of the extending portion 48 forming a recess 54 to receive the end portion 56 of the body portion 14. In the base of the recess 54 is an annular undercut 58.

The end closure 16 and the body portion 14 may be joined to form a fluid tight seal in the manner discussed aforesaid in reference to the end closure 12.

An annular bead 70, shown in Figure 6, may be formed in the undercuts 32 and 58 of the end closures 12 and 16 by melting the end portions of the body portion 14 and effecting a flow of the plastic body portion into the respective undercuts. The bead 70 effects a mechanical joinder between the end closures and the body portion of the container.

The undercuts 32 and 58 in the respective end closures 12 and 16 may be formed, alternatively, in the outside surface of the annular walls 18 and 50 of the end closures 12 and 16, respectively. Moreover, the recesses 28 and 54 of the end closures 12 and 16 may have disposed therein a heat conductive material, such as metal, which will act as a heat sink to transfer heat to the contiguous plastic components and effect a more rapid softening or melting of said contiguous plastic components and consequent formation of the bead 70.

Additionally, a magnetic material may be disposed within the recess 54 (shown in Figure 7 as 72), which material may function to magnetically affix the aerosol container beneath the surface of a normally floatating medium; for example, beneath the water surface in a water bath testing apparatus.

Moreover, an adhesive material having a melting point below that of the body portion and end closures may be disposed in the respective recesses of the end closures or on the terminal portions

of the end closures, which adhesive will melt and flow into the undercuts to form an annular bead, thus effecting a mechanical bonding between the closure and the body portion. Additionally, the adhesive material may contain a magnetic material to serve the function set forth above for said material.

Shown in Figure 5 is a plastic container assembly, wherein, in addition to the structure shown in Figure 3 there is a port 60 and a piston 62 (shown in dotted line as it moves toward the valved end of the container during evacuation of the container contents).

The end closures may be injection molded. It has been found that polyacetal polymers form satisfactory injection molded end closures.

The end closure may be constructed to accommodate varying body portion diameters. As shown in Figure 4, the bead portion 20 of the valve end closure 12 to which the valve is crimped may be constructed to maintain a standard valve opening by an annular wall 82 projecting inwardly and upwardly from the wall 18 and terminating in the bead 20.

While the invention has been illustrated showing a body portion 14 of cylindrical design, it should be understood that the shape of the body portion is not so limited; the body portion 14 being limited to exclude only shapes incapable of being extrusion formed. Thus, for example, the body portion may be rectangular, triangular, oval, hexagonal, etc. Moreover, the body portion 14 may be formed by coextruding different plastic materials to tailor permeability and other physical properties of the body portion 14.

As with a cylindrically shaped body portion, the inner surface of the extruded body portion is dimensionally uniform throughout the length of the body portion. Consequently, the body portion may more efficaciously function as a container body having a piston traversing its length.

With the subject invention plastic pressure containers may be manufactured which obviate the deficiencies enumerated above that are associated with injection and blow molding processes. Uniform wall thickness and a substantially uniform inner diameter through the entire length of the body portion of the container is readily attainable. Moreover by extrusion forming the body portion and injection molding, for example, of the end closures, a plastic container having end closures of a material dissimilar to the body portion of the container may be readily fabricated. By being able to form the end closures of a material different than the body portion, enables the container manufacturer to utilize plastic materials in the end closure having the necessary strength characteristics to affix an aerosol valve to the end closure.

Additionally the standard concave shaping of the bottom of the conventional aerosol container is attainable to allow for an undue bulging. When blow-molding a plastic pressure container, the container design must have a spherical shape at the base of the container in order to withstand the pressure.

Claims

1. A method for manufacturing a container (10) suitable for dispensing pressurized products and comprising an extruded seamless plastic body portion (14) capable of withstanding pressures associated with the product to be dispensed, the body portion having protuberances (70) at each end, and plastic end closure members (12, 16) each having an annular recess (28; 54) with an undercut (32; 58) for receiving the respective end (30; 56) and protuberance (70) of the body portion (14) and thereby forming a fluid tight seal between the body portion (14) and the end closure members (12, 16), characterized in that the protuberances (70) on the ends (30, 56) of the tubular body portion (14) are formed in situ in said recesses (28, 54) by heating said ends to flow the plastics of the tubular body portion (14) into said undercuts (32, 58).
2. The method according to claim 1, wherein the body portion is cylindrical, rectangular, triangular or hexagonal in cross-section.
3. The method according to claim 1 or 2, wherein the undercuts (32, 58) are located at the base of the annular recesses (28, 54) in the end closure members (12, 16).
4. The method according to any one of claims 1 to 3, wherein the undercuts are located in the outer wall (26, 52) defining the recesses (28, 54) around the end closure members.
5. The method according to any one of claims 1 to 4, wherein the end closure members (12, 16) are secured, or additionally secured, on the ends (30, 56) of the tubular body portion (14) by an adhesive located in said recesses (28, 54).
6. The method according to any one of claims 1 to 5, wherein the end closure members (12, 16) are secured, or additionally secured, on the ends (30, 56) of the tubular body portion (14) by heat welding.

of the end closures, which adhesive will melt and flow into the undercuts to form an annular bead, thus effecting a mechanical bonding between the closure and the body portion. Additionally, the adhesive material may contain a magnetic material to serve the function set forth above for said material.

Shown in Figure 5 is a plastic container assemblage, wherein, in addition to the structure shown in Figure 3 there is a port 60 and a piston 62 (shown in dotted line as it moves toward the valved end of the container during evacuation of the container contents).

The end closures may be injection molded. It has been found that polyacetal polymers form satisfactory injection molded end closures.

The end closure may be constructed to accommodate varying body portion diameters. As shown in Figure 4, the bead portion 20 of the valve end closure 12 to which the valve is crimped may be constructed to maintain a standard valve opening by an annular wall 82 projecting inwardly and upwardly from the wall 18 and terminating in the bead 20.

While the invention has been illustrated showing a body portion 14 of cylindrical design, it should be understood that the shape of the body portion is not so limited; the body portion 14 being limited to exclude only shapes incapable of being extrusion formed. Thus, for example, the body portion may be rectangular, triangular, oval, hexagonal, etc. Moreover, the body portion 14 may be formed by coextruding different plastic materials to tailor permeability and other physical properties of the body portion 14.

As with a cylindrically shaped body portion, the inner surface of the extruded body portion is dimensionally uniform throughout the length of the body portion. Consequently, the body portion may more efficaciously function as a container body having a piston traversing its length.

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Additionally the standard concave shaping of the bottom of the conventional aerosol container is attainable to allow for an undue bulging. When blow-molding a plastic pressure container, the container design must have a spherical shape at the base of the container in order to withstand the pressure.

Claims

1. A method for manufacturing a container (10) suitable for dispensing pressurized products and comprising an extruded seamless plastic body portion (14) capable of withstanding pressures associated with the product to be dispensed, the body portion having protuberances (70) at each end, and plastic end closure members (12, 16) each having an annular recess (28; 54) with an undercut (32; 58) for receiving the respective end (30; 56) and protuberance (70) of the body portion (14) and thereby forming a fluid tight seal between the body portion (14) and the end closure members (12, 16), characterized in that the protuberances (70) on the ends (30, 56) of the tubular body portion (14) are formed in situ in said recesses (28, 54) by heating said ends to flow the plastics of the tubular body portion (14) into said undercuts (32, 58).
2. The method according to claim 1, wherein the body portion is cylindrical, rectangular, triangular or hexagonal in cross-section.
3. The method according to claim 1 or 2, wherein the undercuts (32, 58) are located at the base of the annular recesses (28, 54) in the end closure members (12, 16).
4. The method according to any one of claims 1 to 3, wherein the undercuts are located in the outer wall (26, 52) defining the recesses (28, 54) around the end closure members.
5. The method according to any one of claims 1 to 4, wherein the end closure members (12, 16) are secured, or additionally secured, on the ends (30, 56) of the tubular body portion (14) by an adhesive located in said recesses (28, 54).
6. The method according to any one of claims 1 to 5, wherein the end closure members (12, 16) are secured, or additionally secured, on the ends (30, 56) of the tubular body portion (14) by heat welding.



7. The method according to any one of claims 1 to 6, wherein a sink of heat conductive material is located in the recesses (28, 54) of the end closure members (12, 16).
8. The method according to any one of claims 1 to 7, wherein an annulus of magnetic material (72) is located in the annular recess (54) in at least one of the two end closure members.
9. The method according to claim 8 as dependent on claim 7, wherein said heat conductive material and said magnetic material (72) are provided by one and the same insert in said recess (54).
10. The method according to claim 8, as dependent on claim 5, wherein said magnetic material (72) is incorporated in said adhesive.
11. The method according to any one of claims 1 to 10, wherein the tubular body portion (14) and end closure members (12, 16) are of different plastics materials.
12. The method according to any one of claims 1 to 11, wherein the tubular body portion (14) is of amorphous nylon or polyethylene terephthalate.
13. The method according to any one of claims 1 to 12, wherein the container is intended for use as a plastics aerosol container and one end closure member (12) has a beaded (20) opening therein to receive a valve mounting cup.
14. The method according to claim 13, wherein the other end closure member (16) provides an inwardly domed end cap (38) at the base of the aerosol container.
15. The method according to claim 14, wherein the inwardly domed end closure member has an air vent or aperture (60) therein, and wherein a piston (62) is slidably mounted in the tubular body portion (14) of the container, a fluid tight seal being provided between the piston and the body portion of the container.
16. An aerosol package comprising a container manufactured according to any one of claims 13 to 15 and fitted at said one end with a valve mounting cup and valve assembly.

Patentansprüche

1. Verfahren zum Herstellen eines zur Ausgabe unter Druck stehender Erzeugnisse geeigneten

Behälters (10) mit einem extrudierten nahtlosen Kunststoff-Körperteil (14), der dem Druck des auszugebenden Erzeugnisses standzuhalten vermag, wobei der Körperteil Vorsprünge (70) an jedem Ende aufweist, und mit Endverschlußteilen (12, 16) aus Kunststoff, die jeweils eine ringförmige Vertiefung (28; 54) mit einer Hinterschneidung (32; 58) zur Aufnahme des jeweiligen Endes (30; 56) und Vorsprungs (70) des Körperteils (14) aufweisen und dadurch eine fluiddichte Dichtung zwischen dem Körperteil (14) und den Endverschlußteilen (12, 16) bilden, dadurch gekennzeichnet, daß die Vorsprünge (70) an den Enden (30, 56) des rohrförmigen Körperteils (14) in der Einbaulage in den Vertiefungen (28, 54) durch Erwärmung dieser Enden, so daß der Kunststoff des rohrförmigen Körperteils (14) in die Hinterschneidungen (32, 58) fließen kann, gebildet werden.

2. Verfahren nach Anspruch 1, bei dem der Querschnitt des Körperteils zylindrisch, rechteckig, dreieckig oder hexagonal ist.

3. Verfahren nach Anspruch 1 oder 2, bei dem die Hinterschneidungen (32, 58) am Boden der ringförmigen Vertiefungen (28, 54) in den Endverschlußteilen (12, 16) angeordnet sind.

4. Verfahren nach einem der Ansprüche 1 bis 3, bei dem die Hinterschneidungen in der äußeren Wand (56, 52) geformt werden, die die Vertiefungen (28, 54) um die Endverschlußteile herum begrenzt.

5. Verfahren nach einem der Ansprüche 1 bis 4, bei dem die Endverschlußteile (12, 16) an den Enden (30, 56) des rohrförmigen Körperteils (14) durch einen in den Vertiefungen (28, 54) angeordneten Klebstoff befestigt oder zusätzlich befestigt werden.

6. Verfahren nach einem der Ansprüche 1 bis 5, bei dem die Endverschlußteile (12, 16) an den Enden (30, 56) des rohrförmigen Körperteils (14) durch Erwärmungsschweißen befestigt oder zusätzlich befestigt werden.

7. Verfahren nach einem der Ansprüche 1 bis 6, bei dem eine Wärmesenke aus wärmeleitendem Material in den Vertiefungen (28, 54) der Endverschlußteile (12, 16) angeordnet wird.

8. Verfahren nach einem der Ansprüche 1 bis 7, bei dem ein Ring aus magnetischem Material (72) in der ringförmigen Vertiefung (54) in wenigstens einem der beiden Endverschlußteile angeordnet wird.



9. Verfahren nach Anspruch 8, rückbezogen auf Anspruch 7, bei dem das wärmeleitende Material und das magnetische Material (72) durch ein und denselben Einsatz in der Vertiefung (54) ausgebildet werden.
10. Verfahren nach Anspruch 8, rückbezogen auf Anspruch 5, bei dem das magnetische Material (72) in dem Klebstoff eingebettet wird.
11. Verfahren nach einem der Ansprüche 1 bis 10, bei dem der rohrförmige Körperteil (14) und die Endverschlußteile (12, 16) aus verschiedenen Kunststoffen hergestellt werden.
12. Verfahren nach einem der Ansprüche 1 bis 11, bei dem der rohrförmige Körperteil (14) aus einem amorphen Nylon oder Polyethylen-Terephthalat hergestellt wird.
13. Verfahren nach einem der Ansprüche 1 bis 12, bei dem der Behälter zur Verwendung als Kunststoff-Aerosolbehälter dienen soll und der eine Endverschlußteil (12) eine mit einem Wulst (20) versehene Öffnung zur Aufnahme einer Ventilmontagekappe aufweist.
14. Verfahren nach Anspruch 13, bei dem der andere Endverschlußteil (16) eine nach innen gerichtete gewölbte Endkappe (38) am Boden des Aerosol-Behälters bildet.
15. Verfahren nach Anspruch 14, bei dem der nach innen gerichtete gewölbte Endverschlußteil eine Lüftung oder Belüftungsöffnung (60) aufweist und ein Kolben (62) in dem rohrförmigen Körperteil (14) des Behälters verschiebbar gelagert und eine fluiddichte Dichtung zwischen dem Kolben und dem Körperteil des Behälters vorgesehen ist.
16. Aerosol-Packung mit einem Behälter, der gemäß einem der Ansprüche 13 bis 15 hergestellt und an dem einen Ende mit einer Ventilmontagekappe und einer Ventilanordnung versehen ist.

Revendications

1. Procédé destiné à fabriquer un conteneur (10) permettant de distribuer des produits pressurisés et comprenant une partie de corps en plastique sans soudure et extrudé (14) capable de résister à des pressions associées au produit à distribuer, la partie de corps comprenant des protubérances (70) à chaque extrémité, et des éléments de fermeture d'extrémité en plastique (12, 16) chacun possédant une enco-

che annulaire (28, 54) et un évidement (32, 58) permettant de recevoir les extrémités respectives (30, 56) ainsi que la protubérance (70) de la partie de corps (14) et formant ainsi un scellement d'étanchéité fluide entre la partie de corps (14) et les éléments de fermeture d'extrémité (12, 16), caractérisé en ce que les protubérances (70) des extrémités (30, 56) de la partie de corps tubulaire (14) sont formées in situ dans lesdites encoches (28, 54) par chauffage desdites extrémités, afin de faire couler le plastique de la partie de corps tubulaire (14) dans lesdits évidements (32, 58).

2. Procédé selon la revendication 1, dans lequel la partie de corps est cylindrique, rectangulaire, triangulaire ou hexagonale en coupe transversale.
3. Procédé selon la revendication 1 ou 2, dans lequel les évidements (32, 58) sont situés à la base des encoches annulaires (28, 54) dans les éléments de fermeture d'extrémité (12, 16).
4. Procédé selon l'une des revendications 1 à 3, dans lequel les évidements sont situés dans la paroi externe (26, 52) définissant les encoches (28, 54) autour des éléments de fermeture d'extrémité.
5. Procédé selon l'une des revendications 1 à 4, dans lequel les éléments de fermeture d'extrémité (12, 16) sont fixés, ou fixés additionnellement, aux extrémités (30, 56) de la partie de corps tubulaire (14) par un adhésif placé dans lesdites encoches (28, 54).
6. Procédé selon l'une des revendications 1 à 5, dans lequel les éléments de fermeture d'extrémité (12, 16) sont fixés, ou fixés additionnellement, aux extrémités (30, 56) de la partie de corps tubulaire (14) par thermo-soudage.
7. Procédé selon l'une des revendications 1 à 6, dans lequel un diffuseur en matériau conducteur de chaleur est placé dans les encoches (28, 54) des éléments de fermeture d'extrémité (12, 16).
8. Procédé selon l'une des revendications 1 à 7, dans lequel une couronne en matériau magnétique (72) est placée dans l'encoche annulaire (54) dans au moins un des deux éléments de fermeture d'extrémité.
9. Procédé selon la revendication 8 en combinaison avec la revendication 7, dans lequel ledit matériau conducteur de chaleur et ledit maté-



riau magnétique (72) sont réalisés par une unique et même pièce rapportée dans ladite encoche (54).

10. Procédé selon la revendication 8, en combinaison avec la revendication 5, dans lequel ledit matériau magnétique (72) est incorporé dans ledit adhésif. 5
11. Procédé selon l'une des revendications 1 à 10, dans lequel la partie de corps tubulaire (14) et les éléments de fermeture d'extrémité (12, 16) sont en matières plastiques différentes. 10
12. Procédé selon l'une des revendications 1 à 11, dans lequel la partie de corps tubulaire (14) est en nylon amorphe ou en polyéthylène téréphthalate. 15
13. Procédé selon l'une des revendications 1 à 12, dans lequel le conteneur est destiné à servir de conteneur en matière plastique pour aérosols et un élément de fermeture d'extrémité (12) possède une ouverture à rebord (20) destinée à recevoir une cuvette de fixation de valve. 20
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14. Procédé selon la revendication 13, dans lequel l'autre élément de fermeture d'extrémité (16) présente un bouchon bombé vers l'intérieur (38) à la base du conteneur pour aérosol. 30
15. Procédé selon la revendication 14, dans lequel l'élément de fermeture d'extrémité bombé vers l'intérieur possède une bouche d'aération ou ouverture (60), et dans lequel un piston (62) est monté, de manière à pouvoir glisser, dans la partie de corps tubulaire (14) du conteneur, un scellement d'étanchéité fluide étant prévu entre le piston et la partie de corps du conteneur. 35
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16. Emballage pour aérosol comprenant un conteneur fabriqué selon l'une des revendications 13 à 15 et sur lequel sont montés une cuvette de fixation de valve et un assemblage de valve à ladite extrémité. 45

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