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(71) Applicant (for all designated States except US): **BALL CORPORATION** [US/US]; 10 Longs Peak Drive, Broomfield, CO 80021 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **BATHURST, Jess, N.** [US/US]; 1721 Globe Court, Fort Collins, CO 80528 (US). **TRAPHAGEN, James, D.** [US/US]; 12599 Dale Court, Broomfield, CO 80020 (US).

(74) Agents: **KUGLER, Bruce, A.** et al.; Sheridan Ross P.C., 1560 Broadway, Suite 1200, Denver, CO 80202-5141 (US).

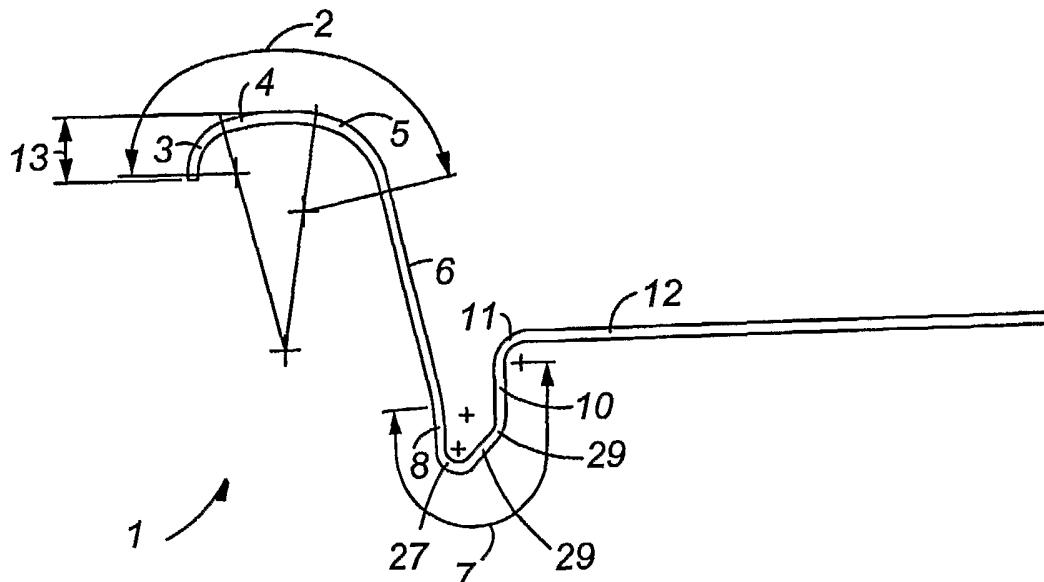
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(54) Title: METHOD AND APPARATUS FOR SHAPING A METALLIC CONTAINER END CLOSURE



(57) Abstract: The present invention describes an apparatus and forming process to manufacture container end closures with improved internal buckle strength. The present invention provides greater material and dimensional control during the forming process by utilizing a pressure sleeve to provide support to at least a portion of an end closure chuck wall and seaming panel radius while placing an end closure countersink in compression during the forming process.

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**METHOD AND APPARATUS FOR  
SHAPING A METALLIC CONTAINER END CLOSURE**

**FIELD OF INVENTION**

The present invention relates to a manufacturing process for forming metallic containers and container end closures, and more specifically a method and apparatus for forming high strength geometries while maintaining necessary chuck wall and seaming panel characteristics.

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**BACKGROUND OF INVENTION**

Metallic beverage can end closures have historically been designed and manufactured to provide a stiffening bead referred to as countersink. This feature may include vertical walls attached by a full radius bottom forming a channel, and in some embodiments may incorporate arcuate shapes or other geometric profiles. Absolute vertical walls may not exist, but generally the more vertical they become the greater the resistance to deformations resulting from internal pressure.

Beverage can bodies and end closures must be durable to withstand high internal pressures, yet manufactured with extremely thin and durable materials such as aluminum to decrease the overall cost of the manufacturing process and the weight of the finished product. Accordingly, there exists a significant need for a durable beverage can end closure which can withstand the high internal pressures created by carbonated beverages, and the external forces applied during shipping, yet which are made from durable, lightweight and extremely thin metallic materials with geometric configurations which reduce material requirements. To obtain these characteristics, can end closures require aggressive material working to achieve the various forms and geometries, which is generally accomplished utilizing a male/female tool combination. Unfortunately, this process may lead to inconsistencies within a given

contour or geometry. Formation inconsistencies also apply to strength performance. The aggressive forming within the countersink may alter other characteristics within the body of the entire structure. Thus, there is a significant need to provide an apparatus and material forming technique which provides improved end closure on container geometries which have improved strength and buckle resistance. These features are obtained in one embodiment by placing the end closure material in compression during forming to avoid thinning and unwanted material deformation, while simultaneously supporting certain portions of the end closure chuck wall and seaming crown geometry during forming while not supporting other portions to create a predetermined shape.

One patent related to a method and apparatus for producing a container end closure countersink is described in U.S. Pat. No. 5,685,189, (the “‘189 patent”) which is incorporated herein by reference in its entirety. In the ‘189 patent, a portion of the countersink is formed when the countersink is unsupported by tooling while the countersink is placed in compression. Unfortunately, with lighter gage stock materials this process has been found to allow unwanted deformation in the chuck wall and seaming crown, and thus inconsistencies in the end closure geometry.

#### SUMMARY OF THE INVENTION

The present invention relates to an apparatus and method for forming a preferred geometric shape in containers and end closures utilizing thin walled materials (.0084 or less gauge) which have improved strength characteristics and material properties. Thus, in one aspect of the present invention a “free forming” process is used in the manufacturing of a metallic container end closure, wherein at least a portion of the material is placed in compression during forming, and is thus

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less likely to become “coined” or thinned, and ultimately weakened. It is a further aspect of the present invention to provide a method and apparatus for forming a predetermined shape from a metallic material wherein a portion of the metallic material is unsupported by a tool during formation. Thus, a portion of the metallic material is allowed to “free form” into a desired shape without being substantially supported on both the entire upper or lower surface of the material.

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It is a further aspect of the present invention to provide a forming press to form a preferred geometry in a metallic end closure with existing high speed forming processes currently known in the industry and having improved reliability. Thus, in one aspect of the present invention an inner pressure sleeve is utilized in combination with critical forming parameters to assure that the end closure achieves a predetermined geometry, and is extracted efficiently from the forming process at speeds of 1800 - 11,000 end closures/minute.

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It is a further aspect of the present invention to provide an inner pressure sleeve which is driven with pins extending between itself and either a pneumatic piston, spring plate or individual springs to apply a sufficient force to support a portion of an end closure chuck wall to form a preferred geometry during manufacturing.

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It is another aspect of the present invention to provide an apparatus and method for forming a preferred geometric shape in container end closures where other portions of the end closure are supported on both an interior and exterior surface to prevent movement and unwanted deformation, while another portion is allowed to “free form”. Thus, in one embodiment of the present invention a “pressure sleeve” is used to support an end closure chuck wall and/or the seaming panel radius against a

die core ring during forming, while at least a portion of the countersink is placed in compression to form a preferred geometry. Thus, in one aspect of the present invention an apparatus for forming a preferred shape in a metallic blank to create a beverage container end closure with a preferred geometry. It is another aspect of the present invention to provide a method and apparatus for forming improved end closure geometries by generally utilizing tooling equipment which is well known in a container end closure manufacturing plant, and thus requires only minor modifications to implement. Thus, in one embodiment of the invention, an apparatus is provided to form a metallic end closure which generally comprises:

10 a first tool in opposing relationship to a second tool which is adapted to provide a clamping force on a portion of a seaming panel of the metallic material; a third tool in opposing relationship to a fourth tool which is adapted to providing a clamping force on a central panel portion of the metallic material; a fifth tool positioned between said first tool and said third tool, which is adapted to support at least a portion of a chuck wall portion of said metallic material; and

15 providing a reciprocating motion between at least said fifth tool and said first and second tools while a portion of a countersink in the container end closure remains unsupported, wherein a preferred geometry is created in the countersink producing a material thickening, thus avoiding a reduction of material thickness of the countersink.

In another aspect of the present invention, a method for forming a predetermined shape in a metallic container end closure is provided herein, the end closure generally comprising a seaming panel interconnected to a downwardly

extending chuckwall, a central panel having a substantially vertical center axis, and a countersink integrally interconnected to a lower portion of the chuck wall and the central panel, comprising:

- positioning an end closure blank in a forming press;
- 5 providing a clamping force on at least a portion of the seaming panel between a first tool and a second tool;
- providing a clamping force on at least a portion of the central panel between a third tool and a fourth tool to substantially prevent movement of the central panel;
- 10 supporting at least a portion of the chuckwall on both an interior surface and an exterior surface to substantially prevent movement of at least a portion of the chuckwall;
- supporting a first portion of the countersink with at least one of said third tool and said fourth tool while allowing another portion of the countersink to remain unsupported; and
- 15 providing a compressive force on the countersink while retaining the chuck wall in a preferred position, wherein the end closure is formed into a predetermined shape.

#### BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is a cross-sectional front elevation view of a typical beverage container end closure;

20 Fig. 2 is a cross-sectional front elevation view of another embodiment of a beverage container end closure;

Fig. 3 is a cross-sectional front elevation view of another embodiment of a beverage container end closure;

25 Fig. 4 is a cross-sectional front elevation view of an end closure being formed

in a prior art single action forming press;

Fig. 5 is a cross-sectional front elevation view of the end closure countersink shown in Fig. 4 as the countersink is being formed;

5 Fig. 6 is a cross-sectional front elevation view of a prior art apparatus used to form an end closure as disclosed in U.S. Pat. No. 5,685,189;

Fig. 7 is a cross-sectional front elevation view of the prior art apparatus depicted in Fig. 6 and further identifying movement in the chuck wall;

10 Fig. 8 is a cross-sectional front elevation view of one embodiment of the present invention and identifying an inner pressure sleeve positioned against the chuck wall and the forces acting on the end closure during countersink forming;

Fig. 9 is a diagram depicting the timing of the inner pressure sleeve and forming cycle as the inner pressure sleeve travels from top dead center to bottom dead center and returning to top dead center;

15 Fig. 10 is a cross-sectional front elevation view of one embodiment of the present invention shown during forming of an end closure and identifying a pressure sleeve providing support to a portion of a chuck wall and inner seaming panel radius;

Fig. 11 is a cross-sectional front elevation view depicting one embodiment of an inner pressure sleeve;

20 Fig. 12 is a cross-sectional front elevation view comparing the prior art forming apparatus on the right hand portion of the drawing and one new embodiment of the present invention shown on the left hand side of the drawing during the forming process;

Fig. 13 is a cross-sectional front elevation view comparing the prior art forming apparatus on the right hand portion of the drawing and one new embodiment

of the present invention shown on the left hand side of the drawing during the forming process;

Fig. 14 is a cross-sectional front elevation view comparing the prior art forming apparatus on the right hand portion of the drawing and one new embodiment of the present invention shown on the left hand side of the drawing during the forming process;

Fig. 15 is a cross-sectional front elevation view comparing the prior art forming apparatus on the right hand portion of the drawing and one new embodiment of the present invention shown on the left hand side of the drawing during the forming process;

Fig. 16 is a cross-sectional front elevation view comparing the prior art forming apparatus on the right hand portion of the drawing and one new embodiment of the present invention shown on the left hand side of the drawing during the forming process;

Fig. 17 is a cross-sectional front elevation view comparing the prior art forming apparatus on the right hand portion of the drawing and one new embodiment of the present invention shown on the left hand side of the drawing during the forming process;

Fig. 18 is a cross-sectional front elevation view comparing the prior art forming apparatus on the right hand portion of the drawing and one new embodiment of the present invention shown on the left hand side of the drawing during the forming process;

Fig. 19 is a cross-sectional front elevation view comparing the prior art forming apparatus on the right hand portion of the drawing and one new embodiment

of the present invention shown on the left hand side of the drawing during the forming process;

5 Fig. 20 is a cross-sectional front elevation view comparing the prior art forming apparatus on the right hand portion of the drawing and one new embodiment of the present invention shown on the left hand side of the drawing during the forming process;

10 Fig. 21 is a cross-sectional front elevation view comparing the prior art forming apparatus on the right hand portion of the drawing and one new embodiment of the present invention shown on the left hand side of the drawing during the forming process;

Fig. 22 is a cross-sectional front elevation view comparing the prior art forming apparatus on the right hand portion of the drawing and one new embodiment of the present invention shown on the left hand side of the drawing during the forming process;

15 Fig. 23 is a cross-sectional front elevation view comparing the prior art forming apparatus on the right hand portion of the drawing and one new embodiment of the present invention shown on the left hand side of the drawing during the forming process;

20 While an effort has been made to describe various alternatives to the preferred embodiment, other alternatives will readily come to mind to those skilled in the art. Therefore, it should be understood that the invention may be embodied in other specific forms without departing from the spirit or central characteristics thereof. Present examples and embodiments, therefore, are to be considered in all respects as illustrative and not restrictive, and the invention is not intended to be limited to the

details given herein.

	<u>#</u>	<u>Component</u>
	1	Unseamed beverage end closure
5	2	Seaming panel
	3	Outer seaming panel radius
	4	Seaming panel radius
	5	Inner seaming panel
	6	Chuck wall
10	7	Countersink
	8	Countersink outer panel wall
	9	Countersink inner panel wall lower portion
	10	Countersink inner panel wall
	11	Center panel radius
15	12	Center panel
	13	Uncurled seam height
	14	Metallic material
	15	Die construction, shown at the stop position
	16	Blank punch
20	17	Cut edge
	18	Draw ring
	19	Die core ring
	20	Panel punch
	21	Countersink punch
25	22	Outer pressure sleeve
	23	Re-draw die
	24	Inner pressure sleeve
	25	Inner panel wall lower end
	26	Cup radius

- 27 First countersink radius
- 28 Second countersink radius
- 29 Third countersink radius
- 30 Cup bottom
- 5 31 Blank punch face
- 32 Blank punch inner diameter
- 33 Draw ring face
- 34 Die core ring top surface
- 35 Die core ring outermost diameter
- 10 36 Die core ring inner wall
- 37 Panel punch face
- 38 Panel punch outer wall
- 39 Panel punch radius
- 40 Panel punch core angle
- 15 41 Die core radius
- 42 Die core face
- 43 Knockout face

#### DETAILED DESCRIPTION

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Referring now to Figs. 1-3, cross-sectional front elevation views are provided of alternative embodiments of uncurled beverage can end closures capable of being formed with the process defined herein. Other end closure geometries not shown herein may also be formed using the invention described herein as appreciated by one skilled in the art. More specifically, a metallic beverage can end closure 1 is generally comprised of a circular seaming panel 2, a chuck wall 6, a countersink 7, a central panel 12, and an inner panel radius 11 which interconnects the central panel 12 to the countersink 7. Further, the uncurled seam height 13 may extend beyond the seaming panel 2. The circular seaming panel 2 is additionally comprised of an outer seaming panel radius 3, seaming panel radius 4, and inner seaming panel radius 5.

The seaming panel 2 is designed for interconnection to a neck of a container by double seaming or other methods well known in the art. The countersink 7 is generally comprised of an outer countersink panel wall 8, a countersink radius 9, and an inner countersink panel wall 10. In some embodiments, the chuck wall 6 may 5 additionally be comprised of multiple straight angles, radii and arcs depending on any specific application, and as appreciated by one skilled in the art the process described herein is not limited to any specific end closure shape or geometry.

Referring now to Fig 3, another embodiment of an end closure capable of being formed with the present process is provided herein. In this figure the terms "A" 10 represent a specific angle, "D" a specific diameter, "G" and "H" a specific height, "R" a specific radius and "W" a specific width. As appreciated by one skilled in the art, any of these variables may be modified to provide an end closure specifically suited for a given container, pressure, projected use, etc.

Referring now to Figs. 4 and 5, a cross-sectional front elevation view of one 15 embodiment of a prior art single action press for forming a container end closure as shown herein. More specifically, Fig. 5 identifies the cross-sectional front elevational view showing in greater detail the end closure countersink geometry with respect to the forming tool shown in Fig. 4. As shown in Figs. 4-5, the seaming panel 2 of the uncurled beverage shell 1 is held in position between the die core ring top surface 34 and the knock out or pressure sleeve face 43, while the end closure chuck wall is 20 positioned against the die core ring inner walls 36. The end closure central panel 12 is clamped between the countersink punch 21 and the panel punch 20. Fig. 5 depicts in greater detail the geometry of the end closure 1 which depicts the positioning of the die core ring 19, the panel punch 20 and the die core 21.

25 Referring now to Figs. 6 and 7, a front cross-sectional elevation view of a prior art method of forming an end closure is provided herein, and as described in U.

S. Patent No. 5,685,189 to Nguyen and Farley. More specifically, the positioning of the end closure 1 is identified and more specifically shows where a clamping force is placed on the end closure seaming panel and central panel as depicted by the arrows. More specifically, the numbering related to these drawings in Fig 5D and 5E are found in the '189 patent, which is incorporated herein in reference in its entirety.

Referring now to Fig. 8, a cross-sectional front elevation of one embodiment of the present invention is provided herein, and which further identifies the use of an inner pressure sleeve 24 which is operably positioned opposite the die core ring to hold the end closure chuck wall 6 and seaming panel radius 5 in a preferred position. 10 More specifically, the inner pressure sleeve 24 provides support for the chuck wall 6 and seaming panel radius 5 while the die core ring and outer pressure sleeve 22 move upwardly and the countersink is placed in compression. As further shown in the drawing, the central panel 12 is additionally clamped along with the seaming panel of the uncurled beverage shell 1.

15 Referring now to Fig. 9, a depiction of the inner pressure sleeve timing is provided herein, and which shows the operative steps as the pressure sleeve moves from top dead center to bottom dead center returning to top dead center. More specifically, the forming cycle begins when the die center clamps material against the panel punch. The inner pressure sleeve then clamps the material against the die core ring, while the final form is achieved through compression as identified and represented by the number 3.

20 Referring now to Fig. 10, a cross-sectional front elevation view of one embodiment of the present invention is provided herein, and which shows additional detail regarding the positioning of the various components with respect to the uncurled beverage shell 1, and at the conclusion of the forming process. As further shown in this drawing, the inner pressure sleeve 24 is shown providing support on an

exterior surface of the end closure chuck wall and seaming panel radius 5, and retaining the end closure chuck wall securely to the die core ring 19 to prevent any relative movement therein. As compression is provided to the uncurled beverage shell countersink 7, a preferred geometric shape is obtained while retaining the 5 geometry of the chuck wall 6 and seaming panel radius 5 in a preferred orientation.

Referring now to Fig. 11, a cross-sectional front elevation view of an inner pressure sleeve is provided herein, and which depicts the location of compression on the chuck wall of the uncurled beverage shell 1 to control the chuck wall geometry during the forming process. Furthermore, and as appreciated by one skilled in the art, 10 the geometry of the inner pressure sleeve face will also determine the overall geometry of the chuck wall 6 and seaming panel radius 5 during the forming process.

Referring now to Figs. 12-23, cross-sectional front elevation views are provided herein which compare the prior art forming process in the right hand portion of the drawing to shape an uncurled beverage shell, as compared to the new free 15 forming method of the present invention shown on the left hand side. As shown in these drawings, the use of an inner pressure sleeve 24 has not previously been used in the art to provide support on the chuck wall and seaming panel radius 5 on the outer surface during the forming process, while simultaneously placing the end closure countersink in compression to allow free forming.

20 Referring again to Figs. 10-23, each drawing provides a cross sectional front elevation view intended to identify a tooling assembly with the various components necessary to produce an unseamed beverage container end closure. A complete die may include a single pocket or tooling assembly as illustrated, or multiple pockets, the quantity being limited more so by material width rather than press or tonnage 25 capabilities. The lower tooling components generally include a cut edge 17, a draw ring 18 or die core ring 19, and a panel punch 20. The upper tooling components may

include a counter sink punch 21, blanking punch 16, and may include an inner pressure sleeve 24. The die generally operates but is not limited to within a press including a single slide or ram. Beginning in an open position the upper tools are affixed to a die shoe which is attached to a press slide driven by a crankshaft and connection rods tied to a slide. The metallic forming material 14, most commonly aluminum, feeds over the lower tooling, although other well known metals used in the container industry could be utilized.

Referring now to the following figures in greater detail, a brief description of the forming operation is provided herein:

10 Figure 12: The upper tooling is shown traveling downward with the blanking punch 16 contacting the material 14, thus initializing a blanking action.

15 Figure 13: The blank metallic material 14 is clamped between blanking punch face 31 and draw ring face 33 at, during or after blanking, with continued downward travel. The clamping force may be a result of a spring, pneumatic application or other similar methods utilized to apply a force. The material is drawn tightly over the top surface of the die core ring 34. With continued downward travel, the metallic material 14 is drawn between the inner most diameter of the blanking punch 32 and the outer most diameter of the die core ring 35. Simultaneously, the metallic material 14 is being clamped between the upper surface of the die core ring 34 and the draw ring 22. The draw ring 22 applies pressure to the metallic material 14 during the forming sequence to control material flow and prevent unwanted distortion. Again, the clamping force may be obtained within a spring, pneumatic application or other similar methods utilized to apply a force.

20 Figure 14-15: With continued downward travel, the die core 21 comes in contact with the material and begins the drawing process of the metallic material 14 to begin forming the interior geometry of the beverage can end. During the downward travel,

the metallic material 14 becomes clamped between the die core 21 and the panel punch 20, and the die core ring 19 and inner pressure sleeve 24.

Figure 16: With continued downward travel, the forming sequence reaches the final downward movement, known as bottom dead center. At this stage of the sequence, 5 the seaming panel 2 and chuckwall 6 have substantially been formed. In addition, the metallic material 14 available to form the final countersink geometry 7 and the center panel geometry 12 has been drawn to the interior diameter of the die core ring 19 between surfaces 36 and 39.

Figure 17 - 18: The forming sequence is shown continuing with upward travel of the 10 blanking punch 16, die core 21, and the panel punch 20. The sequence continues upward until the panel punch 20 returns to its original position, or also referred to as stop position free forming and compressing the final countersink geometry 7 with the inner pressure sleeve 24 continuing to clamp on the die core ring 19 up to or beyond the stop position.

15 At this stage of the sequence, the uncurled beverage end formation is complete, however removal of the completed container beverage end must be accomplished.

Figure 19-23: The forming sequence continues upward until the full open position is achieved. The outer pressure sleeve 22 serves to strip the now finished yet uncurled 20 container end from the innermost diameter 32 of the blanking punch 16 and the shell is ejected by air or other similar method.

Referring again to Figs. 12-23, a comparison of the prior art method of forming an end closure is shown on the right hand side, while the new forming technique is shown on the left. As depicted in this sequence of drawings, the new forming process provides distinct advantages, including:

25 a) capable of producing end closures with aggressive geometries while maintaining total control of the chuck wall and seaming panel;

- b) allows the forming of difficult chuck wall and countersink geometries without metal thickness reductions;
- c) allows the formation of end closure countersinks with material thickening, wherein the prior art may create thinning or coining in the metal in various locations;
- 5 d) the added control of the present invention allows tooling designs which more accurately define closure contours than previous apparatus with aggressive forms;
- e) capable of producing closure with higher strength materials without the metal fatigue normally associated with tight forms and radii;
- 10 f) the greater control and latitude provided by the present invention allow higher strength end closures with lower material gauge; and
- g) improved operating efficiency during manufacturing and removal of the container end closures from the forming press.

15 While an effort has been made to describe various alternatives to the preferred embodiment, other alternatives will readily come to mind to those skilled in the art. Therefore, it should be understood that the invention may be embodied in other specific forms without departing from the spirit or central characteristics thereof. Present examples and embodiments, therefore, are to be considered in all respects as 20 illustrative and not restrictive, and the invention is not intended to be limited to the details given herein.

What is claimed is:

1. A method for forming a predetermined shape in a metallic container end closure adapted for interconnection to a neck of a container, comprising:
  - positioning a metallic end closure blank in a forming press;
  - 5 providing a clamping force on at least a portion of a seaming panel between a first tool and a second tool;
  - providing a clamping force on at least a portion of the central panel between a third tool and a fourth tool to substantially prevent movement of the central panel within said first tool and said second tool;
  - 10 supporting at least a portion of a chuckwall and an inner seaming panel radius on both an interior surface and an exterior surface to substantially prevent movement of at least a portion of the chuckwall and seaming panel radius;
  - supporting a first portion of the countersink with at least one of said third tool and said fourth tool while allowing another portion of the countersink to remain 15 unsupported; and
  - providing a compressive force on the countersink while retaining the chuck wall in a preferred position, wherein the end closure is formed into a predetermined shape.
- 20 2. The method of Claim 1, wherein the end closure countersink material retains substantially the same thickness during the forming of the end closure.
3. The method of Claim 1, wherein the unsupported portion of the countersink changes shape during the forming process.

4. The method of Claim 1, wherein said first tool comprises a pressure sleeve and said second tool comprises a die core ring.

5. The method of Claim 1, wherein the chuck wall is supported on the 5 interior surface with a die core ring and on an exterior surface with a pressure sleeve.

6. The method of Claim 2, wherein the third tool comprises a countersink punch and said fourth tool comprises a panel punch.

10 7. The method of Claim 1, wherein the countersink is placed in compression as the inner pressure sleeve travels from a position of top dead center to bottom dead center.

15 8. The method of Claim 1, wherein the end closure chuckwall is supported on an exterior surface by a pressure sleeve.

9. The method of Claim 8, wherein the pressure sleeve may have a distinct geometry to define a chuck wall shape during the forming process.

20 10. The method of Claim 1, wherein providing a clamping force on a portion of the seaming panel provides compression between said first tool and said second tool.

11. An apparatus for forming a preferred shape in a metallic material to create a beverage end closure adapted for interconnection to a container, comprising:

11.1. a first tool in opposing relationship to a second tool which is adapted to provide a clamping force on a portion of a seaming panel of the metallic material;

11.2. a third tool in opposing relationship to a fourth tool which is adapted to provide a clamping force on a central panel portion of the metallic material;

11.3. a fifth tool positioned between said first tool and said third tool, which is adapted to support at least a portion of a chuck wall portion of said metallic material;

11.4. and

11.5. providing a reciprocating motion between at least said fifth tool and said first and second tools while a portion of a countersink in the container end closure remains unsupported, wherein a preferred geometry is created in the countersink, thus substantially avoiding a reduction of material thickness of the countersink.

12. The apparatus of Claim 11, wherein said first tool comprises an outer pressure sleeve.

13. The apparatus of Claim 11, wherein said second tool comprises a die core ring.

14. The apparatus of Claim 11, wherein said third tool comprises a countersink punch.

15. The apparatus of Claim 11, wherein said fourth tool comprises a panel punch.

16. The apparatus of Claim 11, wherein said fifth tool comprises an inner pressure sleeve.

17. The apparatus of Claim 11, further comprising a blank punch and draw ring which are adapted to retain a portion of metallic material during manufacturing 5 and which are positioned adjacent the die core ring and outer pressure sleeve.

18. A method for forming a metallic end closure adapted for interconnection to a neck of a container, comprising:

10 a first clamping means for holding a first portion of a metallic material;  
a second clamping means for holding a second portion of the metallic material, said second portion of the metallic material positioned interior to said first portion;

15 a pressure sleeve positioned between said first clamping means and said second clamping means, and comprising an engagement surface in operable engagement with said metallic material, and wherein a void is located between said first clamping means, said second clamping means and said pressure sleeve;

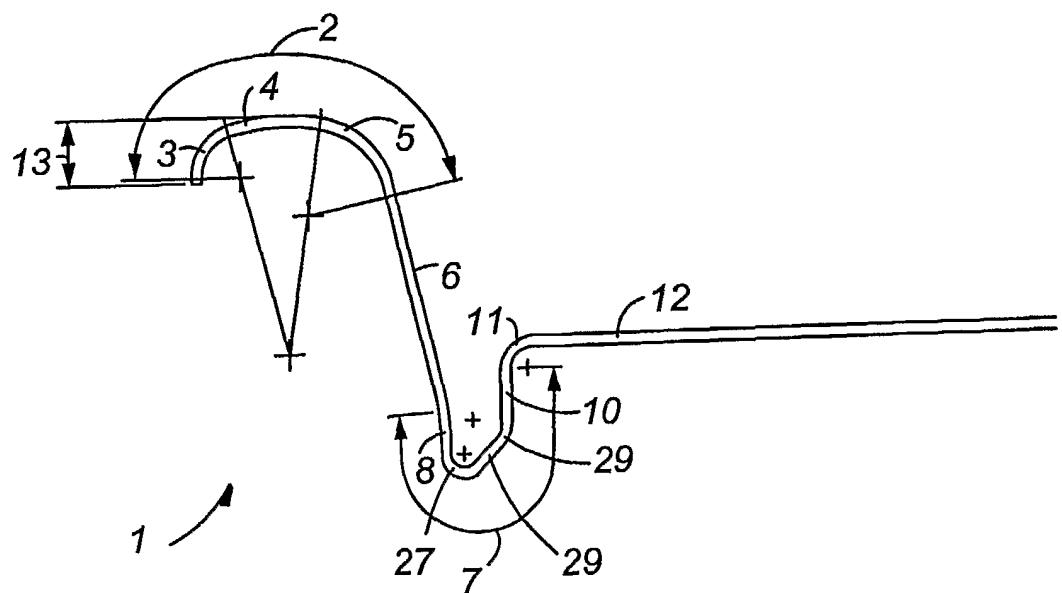
20 wherein at least a portion of said first clamping means and said second clamping means travels with respect to said pressure sleeve, wherein a preferred metal geometry is formed in compression within said void while a portion of said metallic material is retained between said pressure sleeve and said first clamping means.

19. The method of Claim 18, wherein said first clamping means comprises an outer pressure sleeve in opposing relationship to a die core ring.

20. The method of Claim 18, wherein said second clamping means comprises a countersink punch positioned opposite to a panel punch.

21. The method of Claim 18, wherein said preferred metal geometry in  
5 said void comprises a countersink in the metallic end closure.

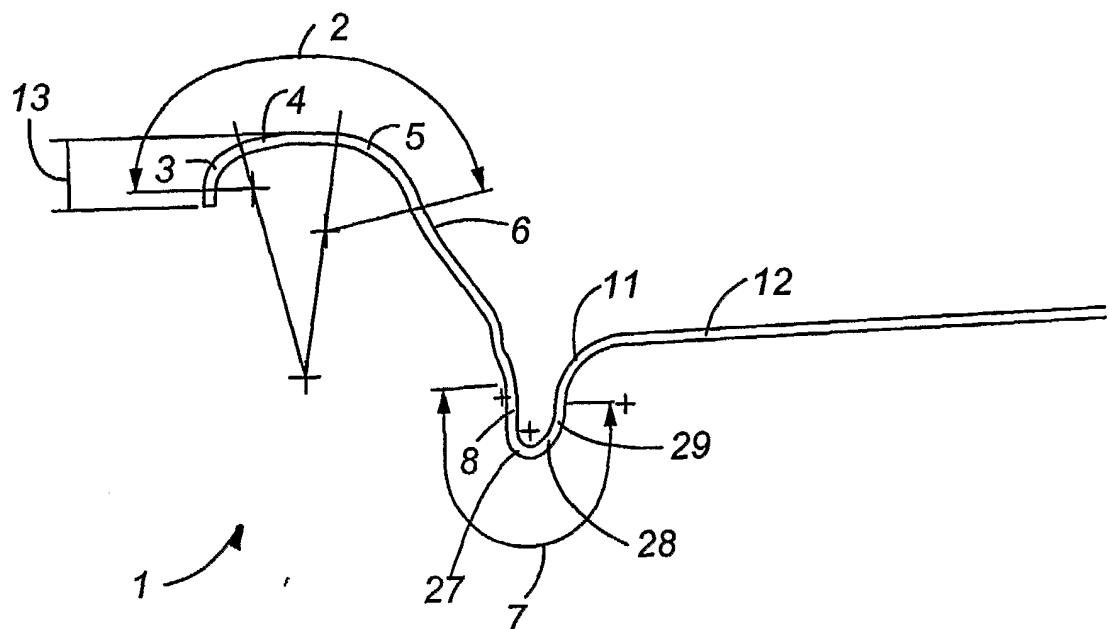
22. The method of Claim 19, further comprising a blank punch and draw ring positioned adjacent said outer pressure sleeve and die core ring, respectively which are adapted to clamp a portion of said metallic material.



*Fig. 1*

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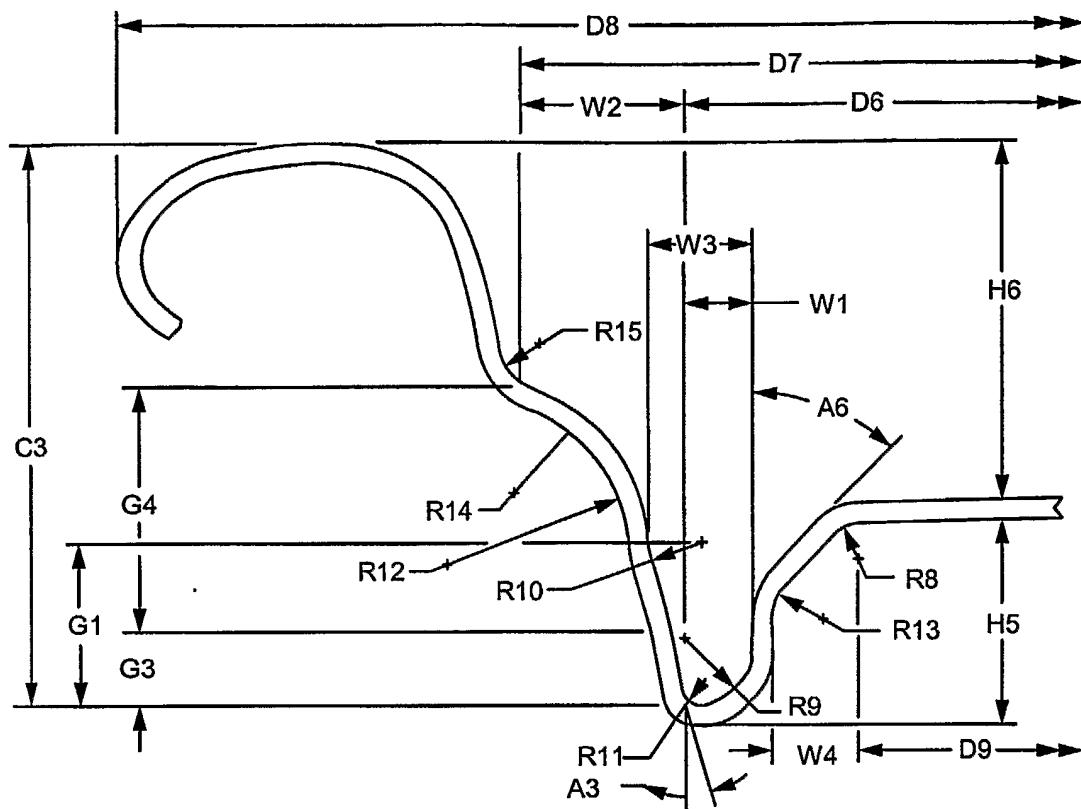
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***Fig. 2***

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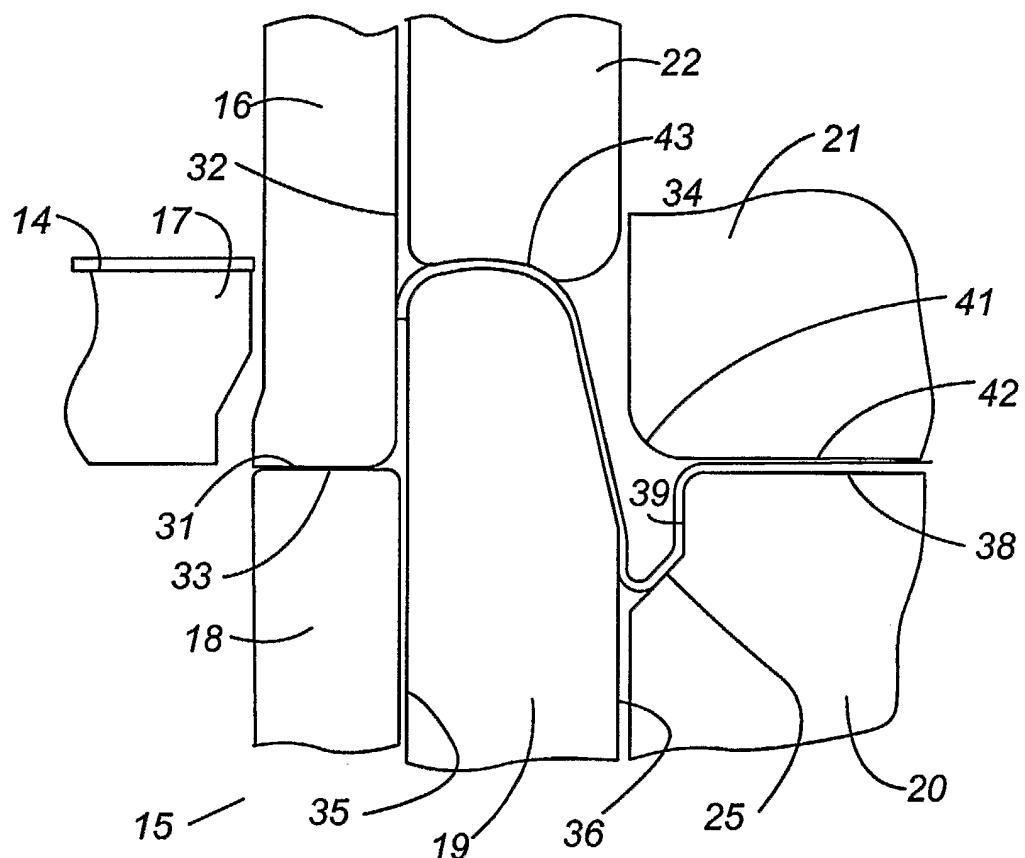


**Fig. 3**

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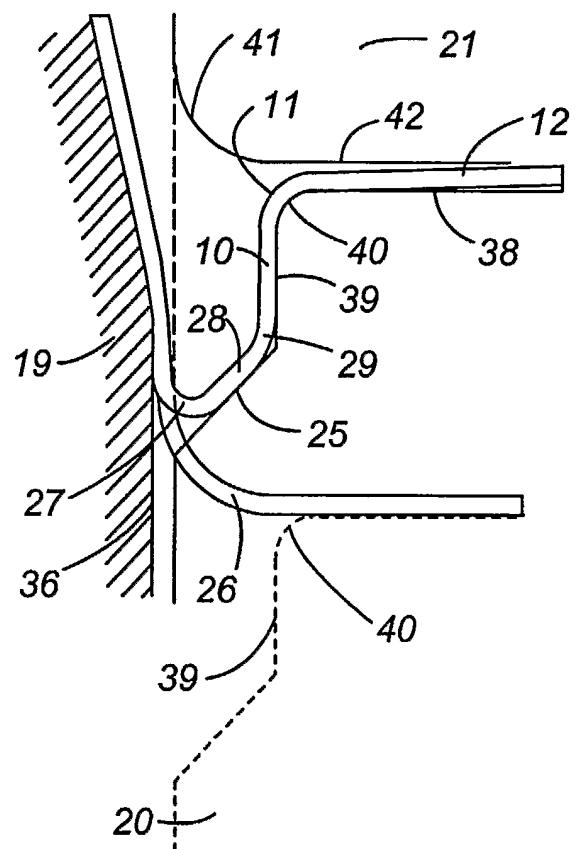
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*Prior Art Compression Forming  
Single Action Press*



***Fig. 4***

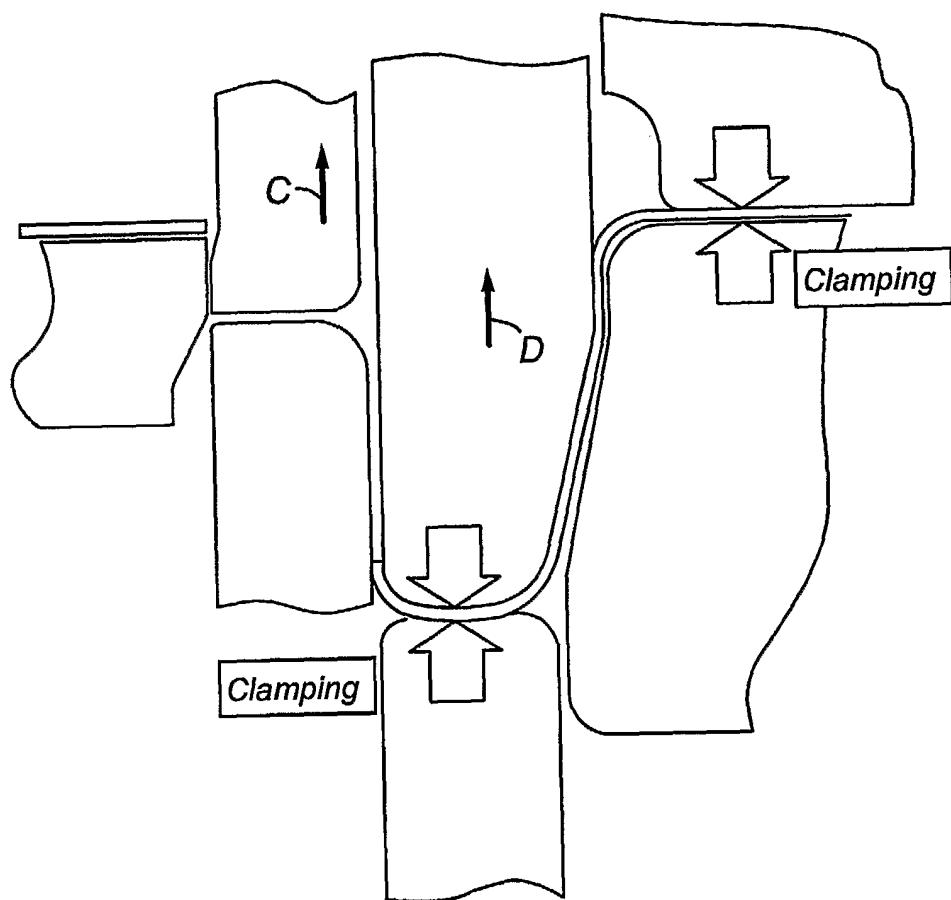
SUBSTITUTE SHEET (RULE 26)



***Fig. 5***

SUBSTITUTE SHEET (RULE 26)

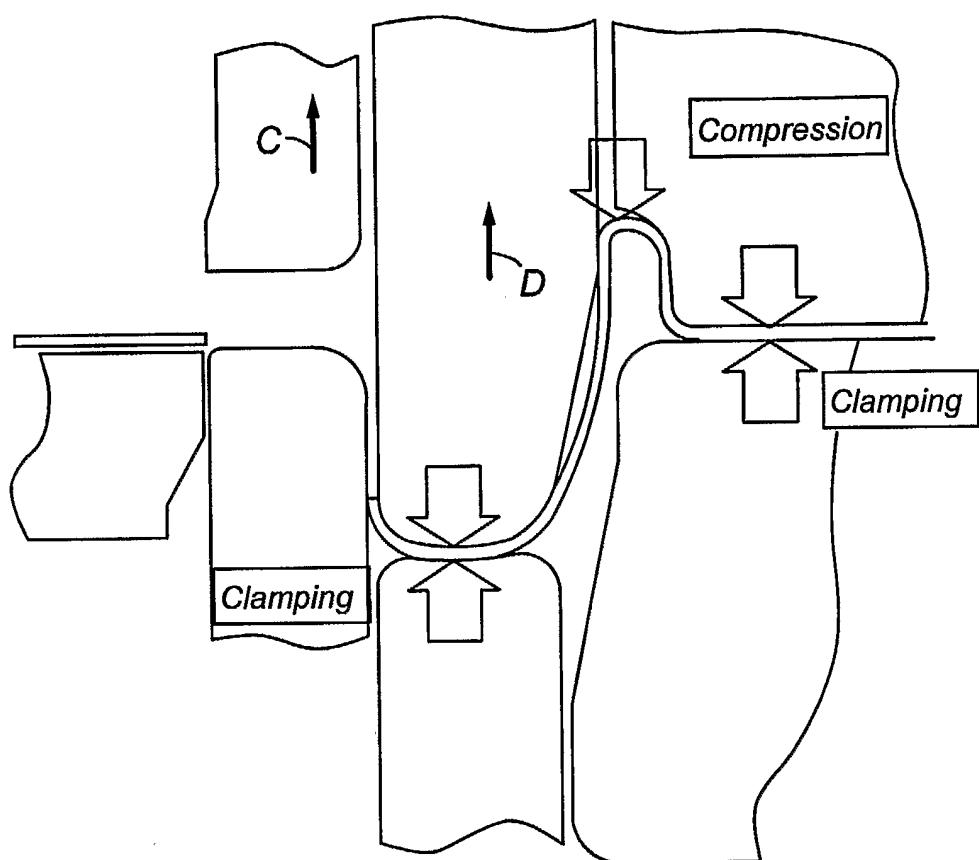
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**Fig. 6**

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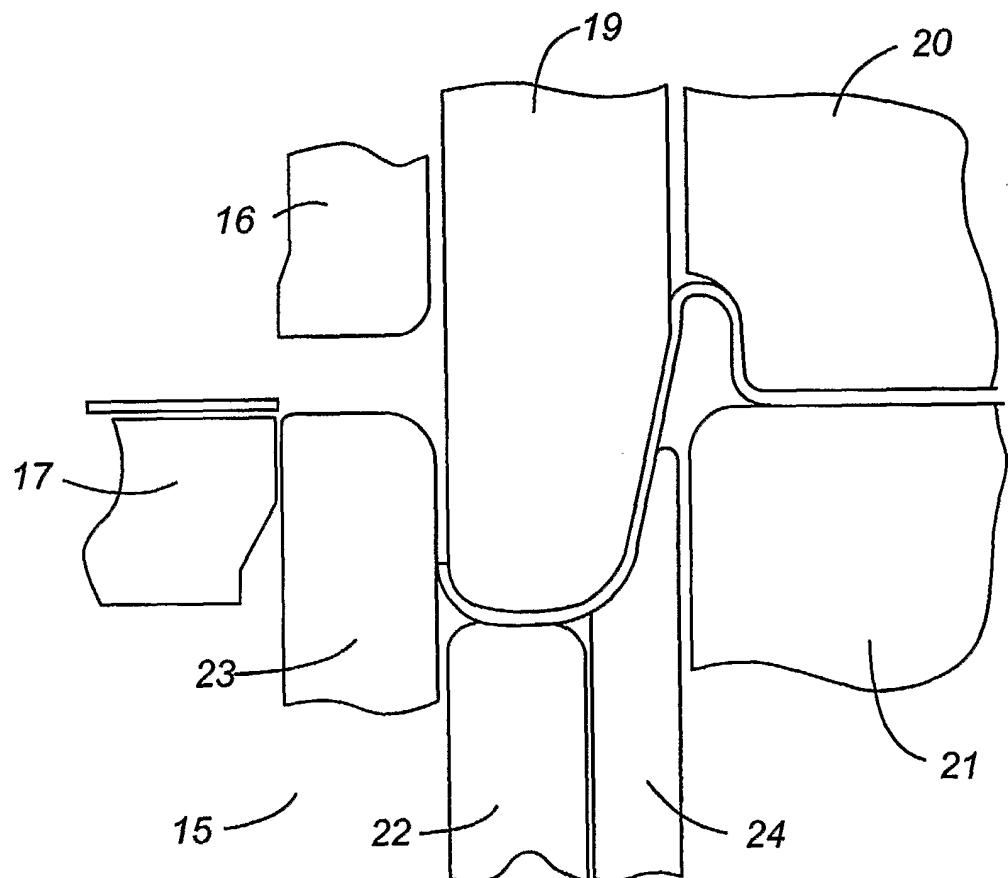


**Fig. 7**

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*Inner Pressure Sleeve  
Simplified*

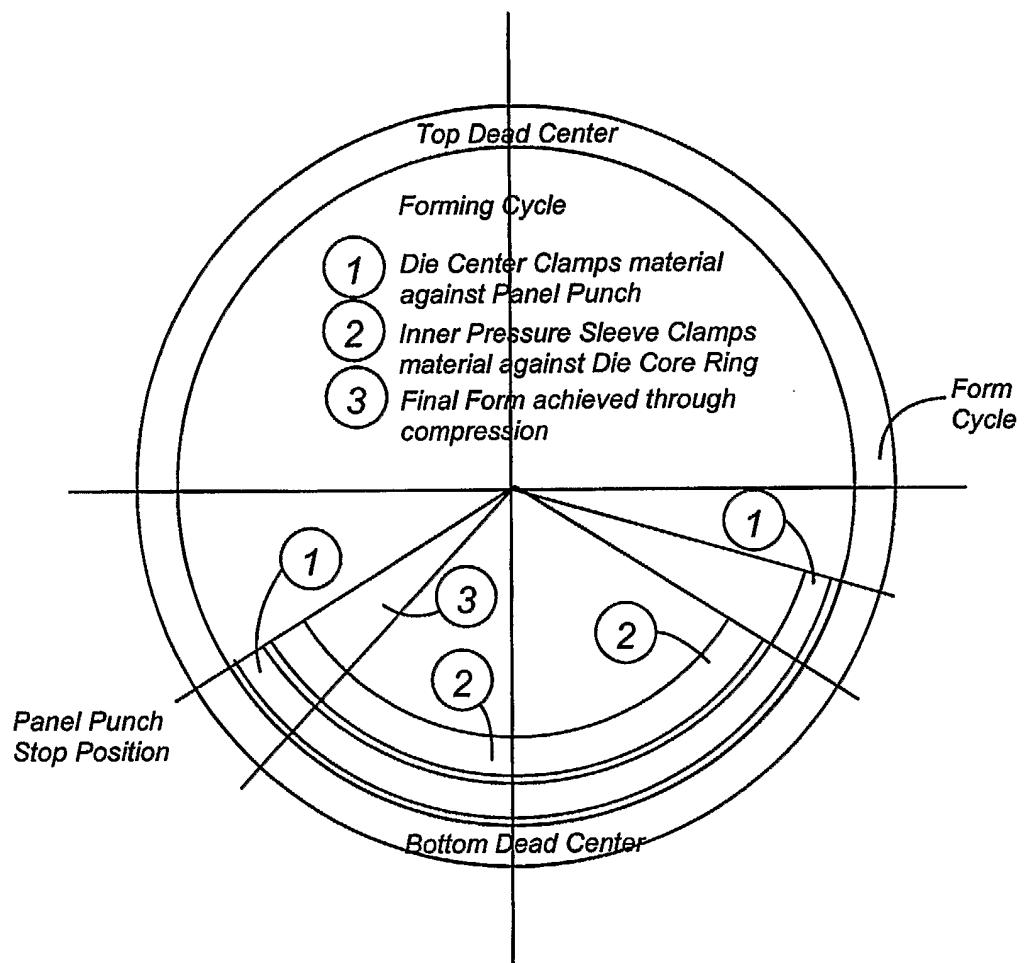


***Fig. 8***

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## Inner Pressure Sleeve Timing

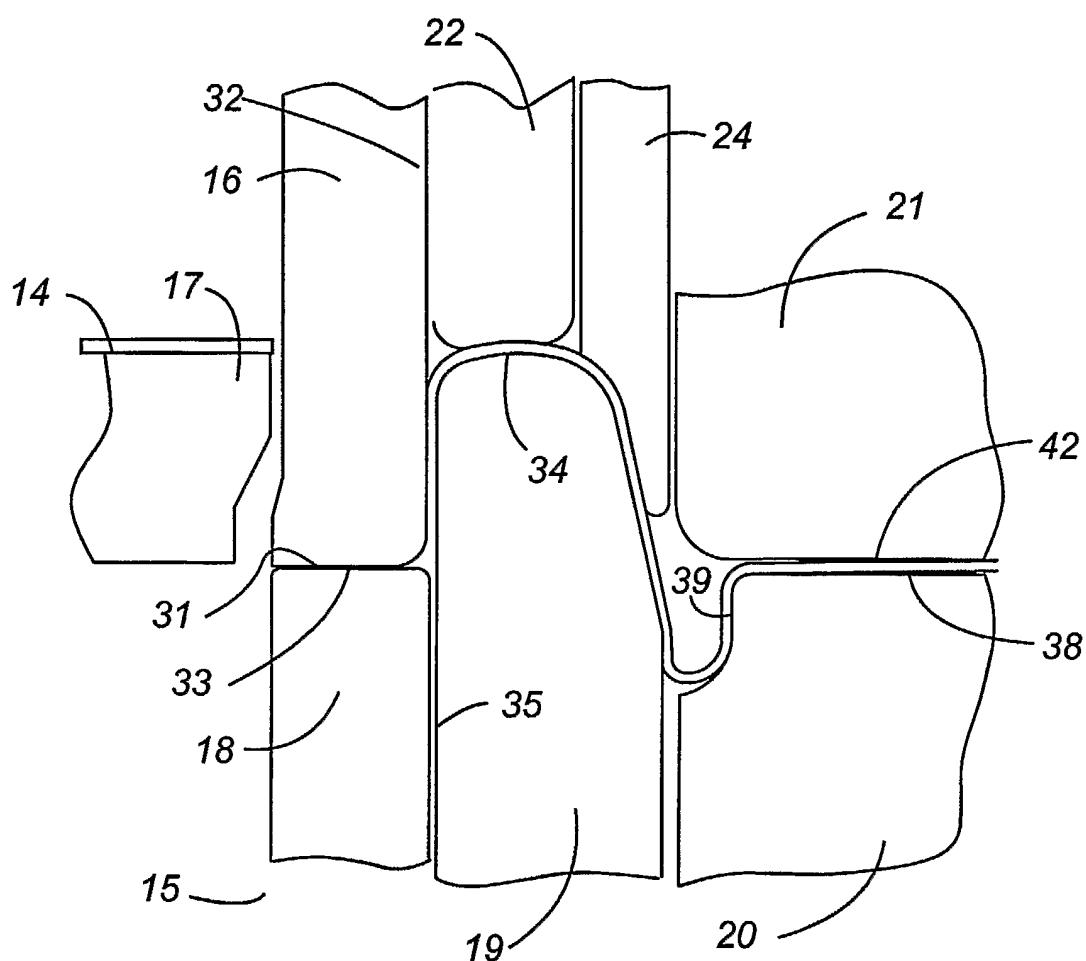


**Fig. 9**

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*Free and Compression Forming  
Single Action*

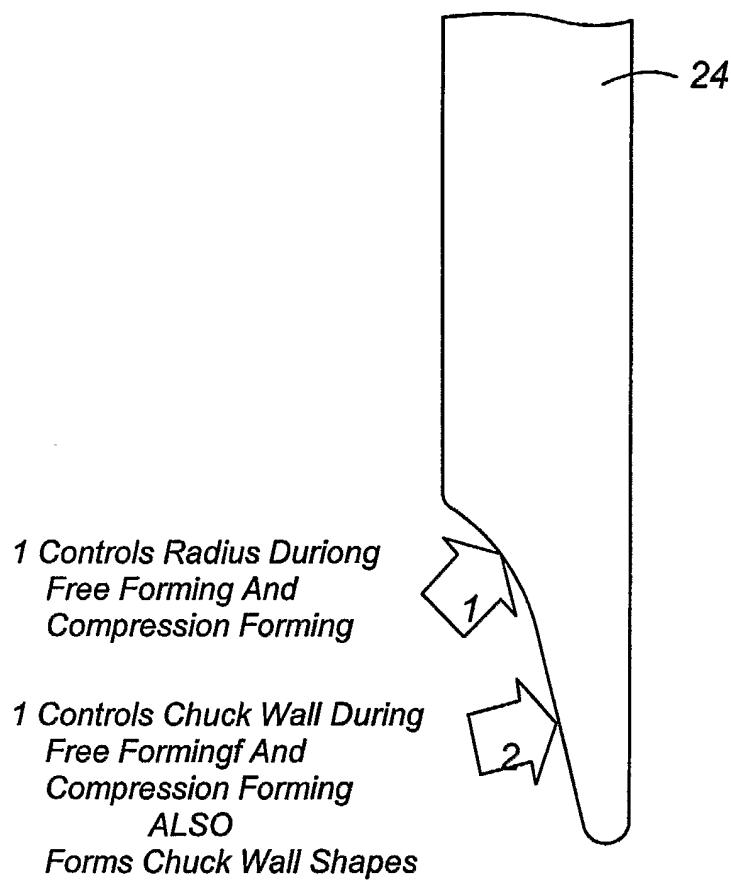


**Fig. 10**

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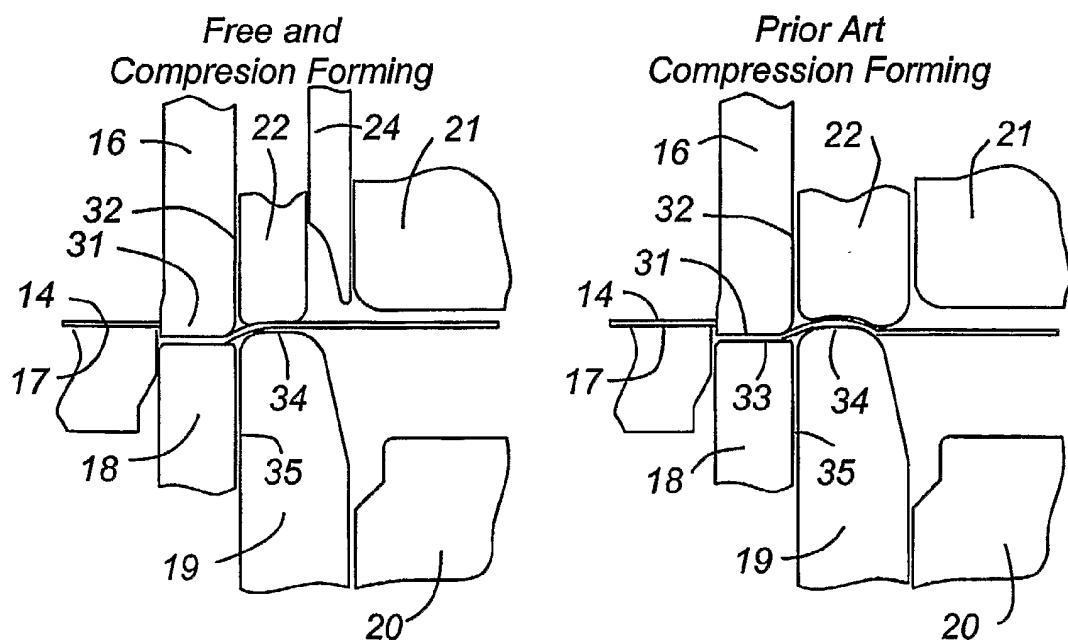
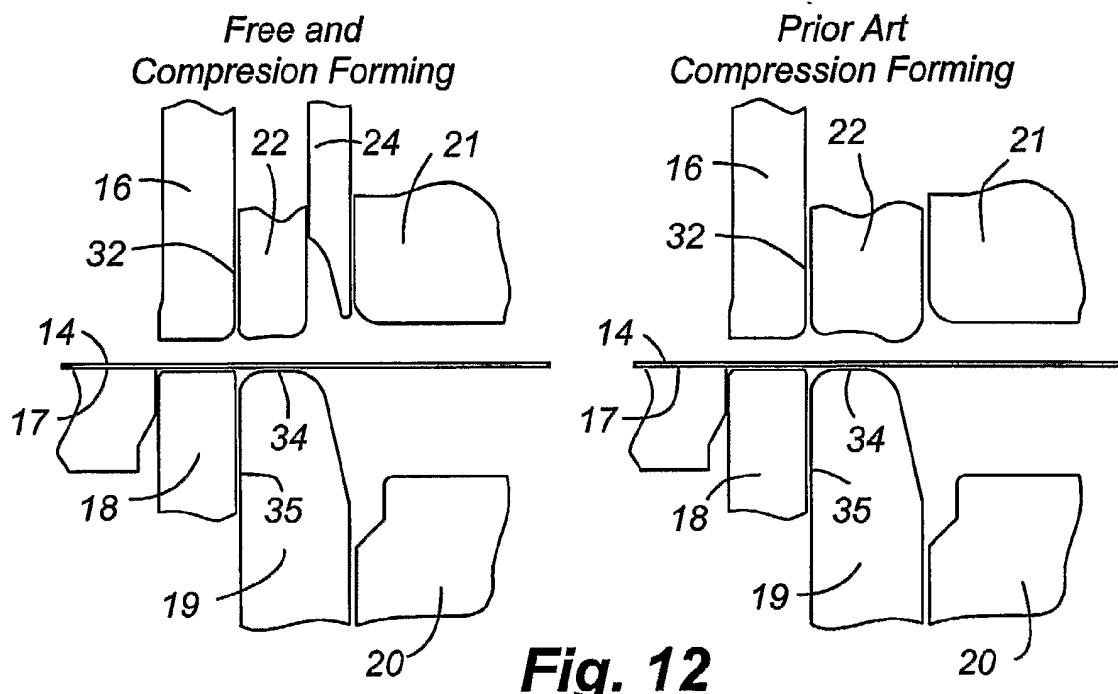
## Inner Pressure Sleeve Features



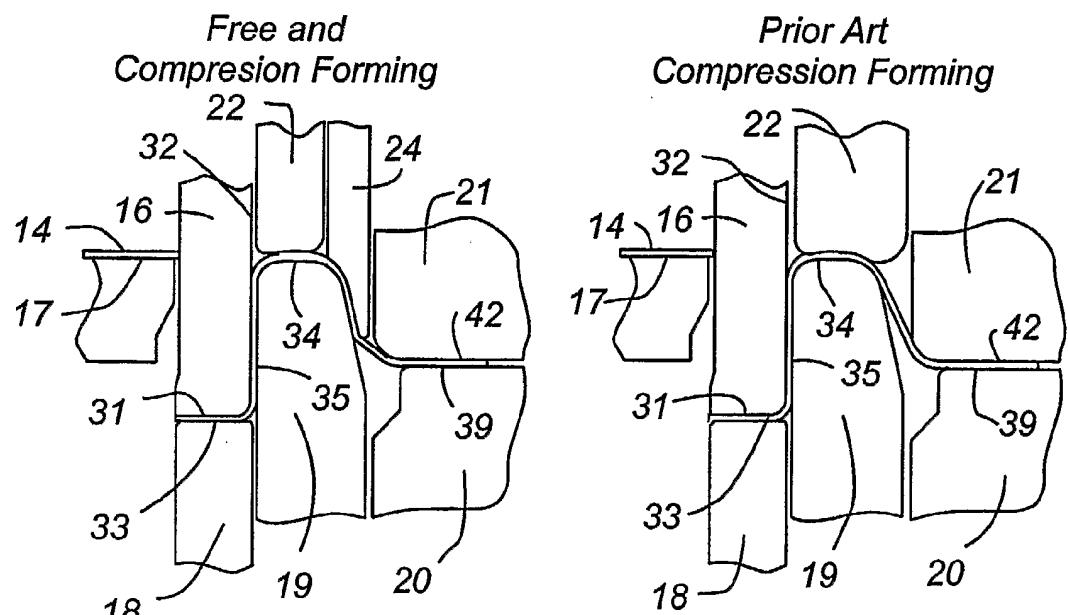
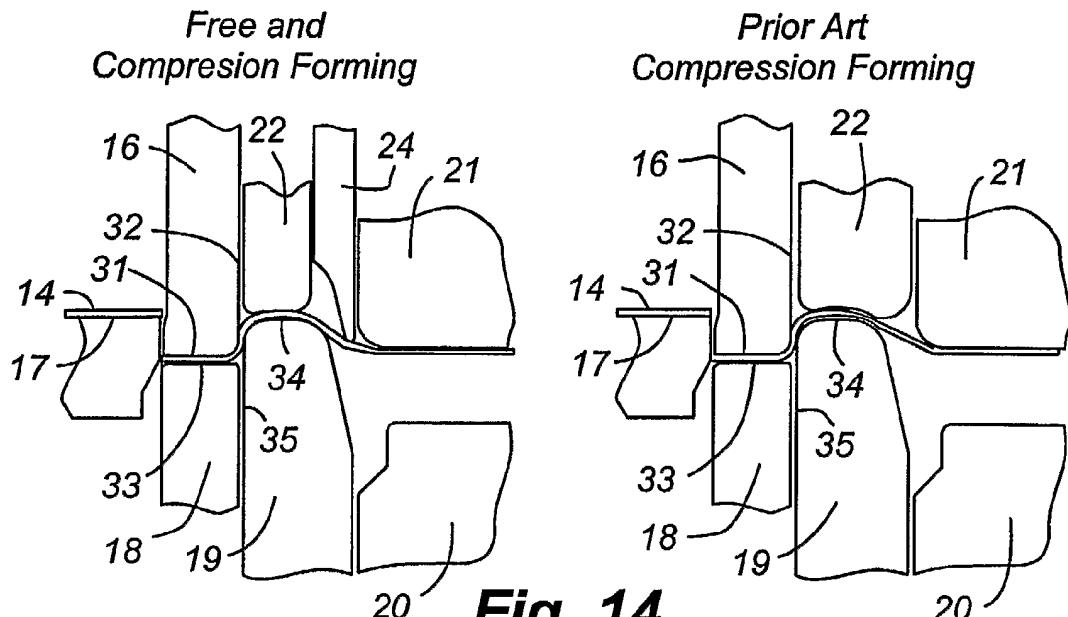
**Fig. 11**

SUBSTITUTE SHEET (RULE 26)

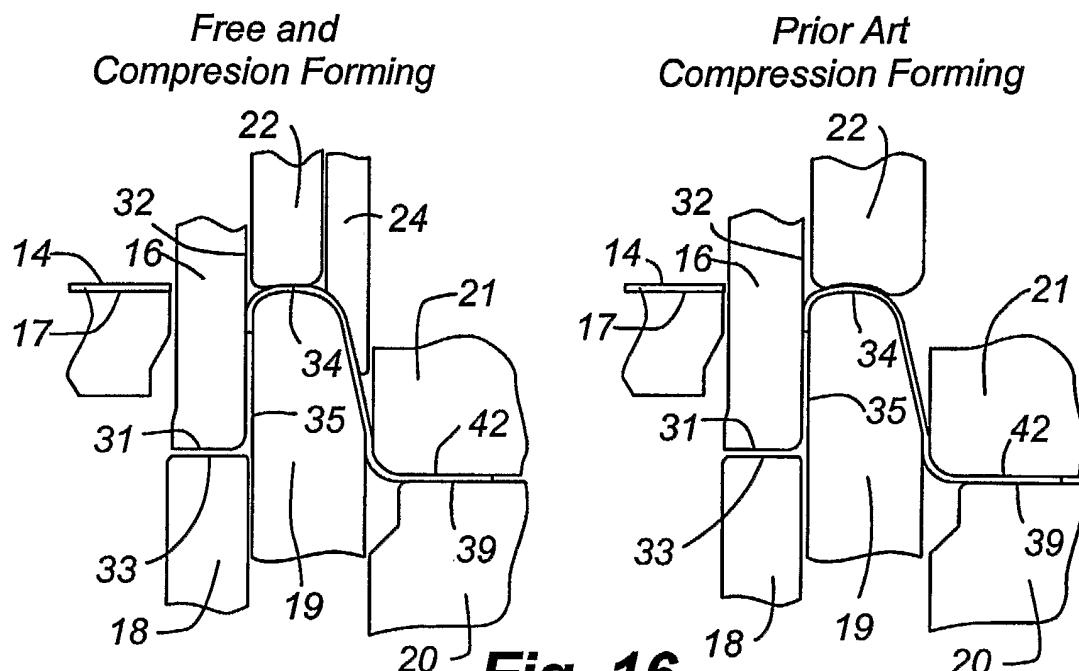
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*Inner Pressure Sleeve Form Comparison*

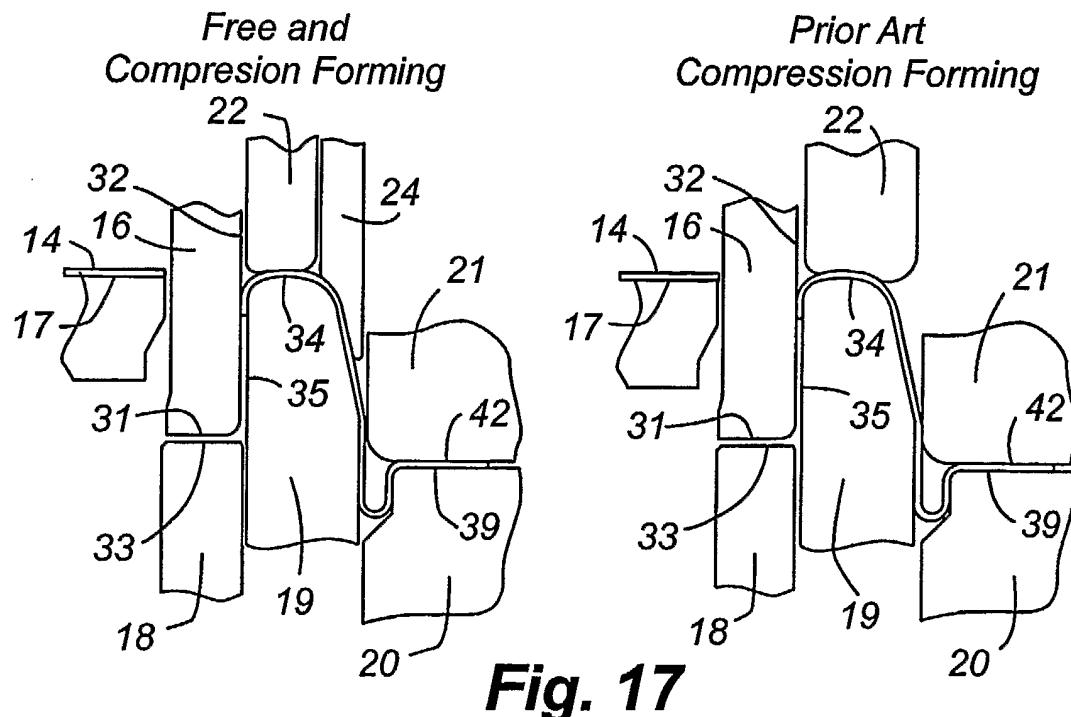
### Inner Pressure Sleeve Form Comparison



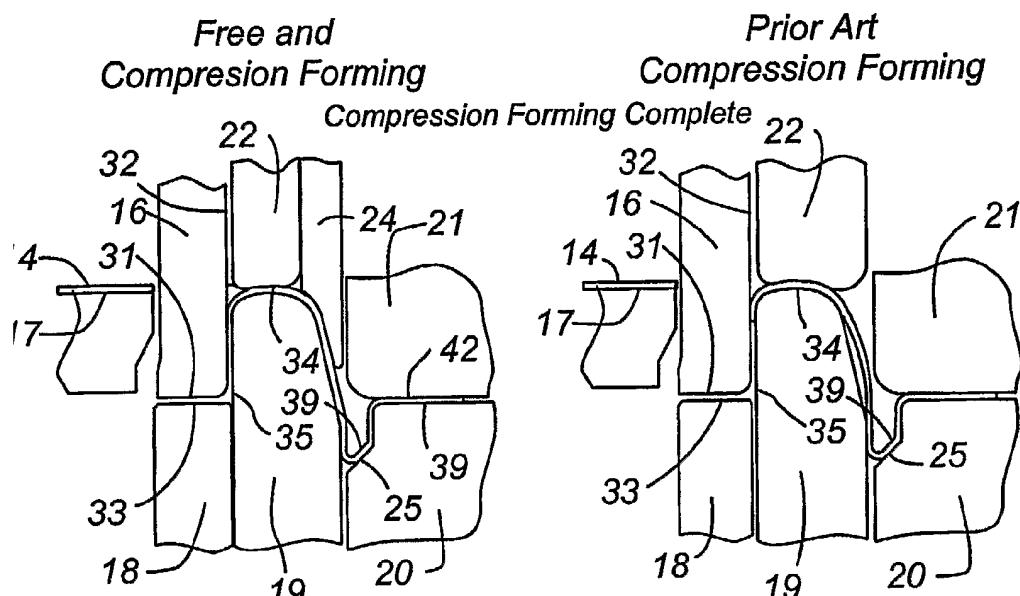
### Inner Pressure Sleeve Form Comparison



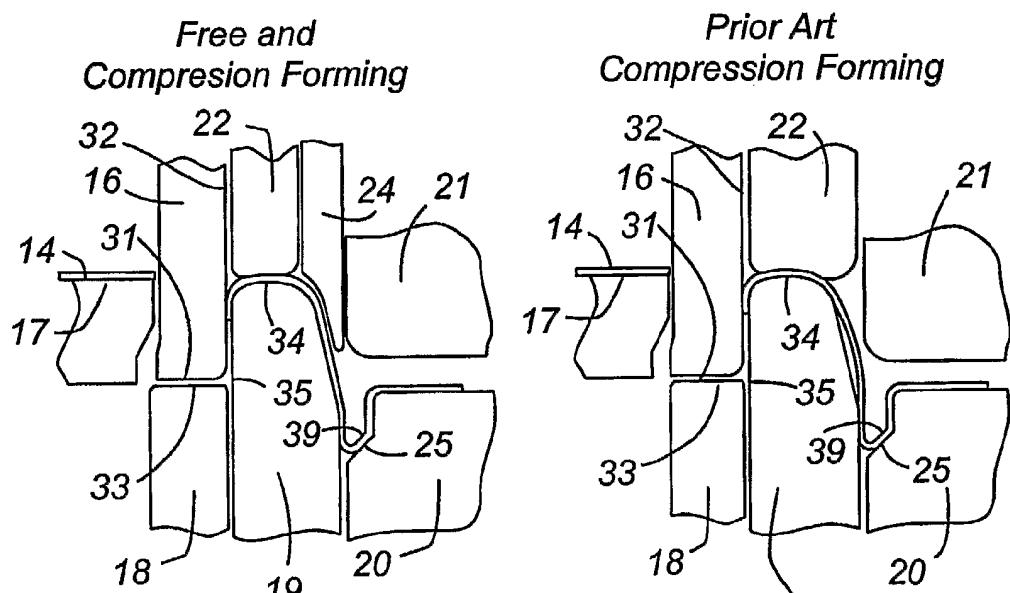
**Fig. 16**  
Bottom Dead Center



**Fig. 17**  
Free Forming Countersink

*Inner Pressure Sleeve Form Comparison***Fig. 18**

*Panel Punch  
STOP*

**Fig. 19**

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## *Inner Pressure Sleeve Form Comparison*

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*Inner Pressure Sleeve Form Comparison*