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(54) **VALVE**

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VALVE

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Description

[0001] This invention relates to a valve for an aerosol container with the aid of which a quantity of the contents thereof can be dispensed. The invention has particular application to the dispensing of metered doses of medicaments, though it is applicable to the dispensing of aerosols generally.

[0002] Containers for aerosol formulations commonly comprise a vial body coupled to a valve. The valve comprises a valve stem through which the formulation is dispensed. Generally the valve includes a rubber valve seal intended to allow reciprocal movement of the valve stem while preventing leakage of propellant from the container.

[0003] It has been found that in some conventional devices the valve stem tends to stick, pause, or drag during the actuation cycle with the result that the valve stem may not move smoothly, particularly when released. This may be partly caused by the drug sedimenting or precipitating out of the drug-propellant suspension or solution formulation and depositing on the internal valve components, the presence of drug on the sliding interface creating increased friction during operation.

[0004] Prior art seals generally comprise a rubber ring formed by stamping out a ring shape from a sheet of rubber material. The ring aperture, thus, inevitably has square-cut edges which present a relatively high area of contact between the seal and the stem. Furthermore, when the valve stem is moved in such square-cut seals the seal deforms in such a way that the surface area, and hence the frictional contact area, between the seal and stem increases.

[0005] The Applicants have now found that the above described problem may be ameliorated without compromising sealing performance if the valve seal is shaped such as to reduce the area of contact between the seal and the stem. If a manufacturing process based upon moulding is employed a ring may be formed having a ring aperture with rounded edges. When such a rounded edge ring is used as a valve seal the area of contact between the seal and the stem is less than that for a ring of equivalent thickness having square-cut edges. On movement of the stem within the seal there is also less tendency for the seal to deform such as to increase the contact area between the seal and the stem.

[0006] WO-A-99/00315 discloses a valve having the pre-characterising clause of claim 1.

[0007] EP-A-0870699 discloses various other valves.

[0008] According to the present invention there is provided a valve according to claim 1.

[0009] Preferably, the area of contact between the sealing ring(s) and the valve stem is less than 90%, more preferably less than 70%, most preferably less than 50% of what the area of contact would be if the inner surface of the sealing ring(s) had square-cut edges.

[0010] In another aspect, the inner surface the first and/or second sealing ring presents a lobed surface to the stem. That is to say the surface comprises one or more lobe features.

[0011] Preferably all the stem-receiving edges of the inner surface of the first and/or second sealing rings are rounded.

[0012] Preferably the first sealing ring and/or second sealing ring comprises an elastomeric material. The ring is typically resiliently deformable.

[0013] The elastomeric material may either comprise a thermoplastic elastomer (TPE) or a thermoset elastomer which may optionally be cross-linked. The sealing ring may also comprise a thermoplastic elastomer blend or alloy in which an elastomeric material is dispersed in a thermoplastic matrix. The elastomers may optionally additionally contain conventional polymer additives such as processing aids, colorants, tackifiers, lubricants, silica, talc, or processing oils such as mineral oil in suitable amounts.

[0014] Suitable thermoset rubbers include butyl rubbers, chloro-butyl rubbers, bromobutyl rubbers, nitrile rubbers, silicone rubbers, fluoro-silicone rubbers, fluorocarbon rubbers, polysulphide rubbers, polypropylene oxide rubbers, isoprene rubbers, isoprene-isobutene rubbers, isobutylene rubbers or neoprene (polychloroprene) rubbers.

[0015] Suitable thermoplastic elastomers comprise a copolymer of about 80 to about 95 mole percent ethylene and a total of about 5 to about 20 mole percent of one or more comonomers selected from the group consisting of 1-butene, 1-hexene, and 1-octene as known in the art. Two or more such copolymers may be blended together to form a thermoplastic polymer blend.

[0016] Another suitable class of thermoplastic elastomers are the styrene-ethylene/butylene-styrene block copolymers. These copolymers may additionally comprise a polyolefin (e.g. polypropylene) and a siloxane.

[0017] Thermoplastic elastomeric material may also be selected from one or more of the following: polyester rubbers, polyurethane rubbers, ethylene vinyl acetate rubber, styrene butadiene rubber, copolyether ester TPE, olefinic TPE, polyester amide TPE and polyether amide TPE.

[0018] Other suitable elastomers include ethylene propylene diene rubber (EPDM). The EPDM may be present on its own or present as part of a thermoplastic elastomer blend or alloy, e.g. in the form of particles substantially uniformly dispersed in a continuous thermoplastic matrix (e.g. polypropylene or polyethylene). Commercially available thermoplastic elastomer blend and alloys include the SANTOPRENE™ elastomers. Other suitable thermoplastic elastomer blends include butyl-polyethylene (e.g. in a ratio ranging between about 2:3 and about 3:2) and butyl-polypropylene.

[0019] The above-mentioned elastomeric materials can be prepared using methods known to those skilled in the art.

[0020] Preferably, the first sealing ring and/or the second sealing ring additionally comprises lubricant material. Suitably, the first sealing ring and/or the second sealing ring comprises up to 30%, preferably from 5 to 20% lubricant material.

[0021] Preferably, the stem comprises lubricant material. Suitably, the valve stem comprises up to 30%, preferably from 5 to 20% lubricant material.

[0022] The term 'lubricant' herein means any material which reduces friction between the valve stem and seal. Suitable lubricants include silicone oil or a fluorocarbon polymer such as polytetrafluoroethane (PTFE) or fluoroethylene propylene (FEP).

[0023] Lubricant can be applied to the stem, first sealing ring or second sealing ring by any suitable process including coating and impregnation, such as by injection or a tamponage process.

[0024] According to another aspect of the present invention, there is provided an aerosol container comprising a valve as described hereinabove.

[0025] Preferably, the aerosol container comprises a suspension of a medicament in a propellant.

[0026] Preferably, the propellant is liquefied HFA134a or HFA-227 or mixtures thereof.

[0027] Preferably, the medicament is selected from albuterol, salmeterol, fluticasone propionate, beclomethasone dipropionate and ipratropium bromide and salts or solvates thereof and any combination thereof.

[0028] Other features of the invention are set forth in the dependent claims.

[0029] The invention will now be described further with reference to the accompanying drawing in which:

Figure 1 is a section through a metering valve according to the invention;

Figure 2 is a close-up sectional view of a seal-stem contact point in a valve according to the invention;

Figure 3 is a close-up sectional view of a seal-stem contact point in a valve according to the invention;

Figure 4a is a close-up sectional view of a seal-stem contact point in a prior art valve in a rest position; and

Figure 4b is a close-up sectional view of a seal-stem contact point in the valve of Figure 4a in an active position.

[0030] A valve according to the invention is shown in Figure 1 and comprises a valve body 1 sealed in a ferrule 2 by means of crimping, the ferrule itself being set on the neck of a container (not shown) with interposition of a gasket 3 in a well-known manner. The container is loadable with a suspension of medicament, such as salmeterol xinafoate in liquid propellant HFA134a.

[0031] The valve body 1 is formed at its lower part with

a metering chamber 4, and its upper part with a sampling chamber 5 which also acts as a housing for a return spring 6. The words "upper" and "lower" are used for the container when it is in a use orientation with the neck of the container and valve at the lower end of the container which corresponds to the orientation of the valve as shown in Figure 1. Inside the valve body 1 is disposed a valve stem 7, a part 8 of which extends outside the valve through lower stem seal 9 and ferrule 2. The stem part 8 is formed with an inner axial or longitudinal canal 10 opening at the outer end of the stem and in communication with a radial passage 11.

[0032] The upper portion of stem 7 has a diameter such that it can pass slidably through an opening in an upper stem seal 12 and will engage the periphery of that opening sufficiently to provide a seal. The stem seals 9 and 12 are made by a moulding process and have rounded points of contact with the valve stem 7. Upper stem seal 12 is held in position against a step 13 formed in the valve body 1 between the said lower and upper parts by a sleeve 14 which defines the metering chamber 4 between lower stem seal 9 and upper stem seal 12. The valve stem 7 has a passage 15 which, when the stem is in the inoperative position shown, provides a communication between the metering chamber 4 and sampling chamber 5, which itself communicates with the interior of the container via orifice 16 formed in the side of the valve body 1.

[0033] Valve stem 7 is biased downwardly to the inoperative position by return spring 6 and is provided with a shoulder 17 which abuts against lower stem seal 9. In the inoperative position as shown in Figure 1 shoulder 17 abuts against lower stem seal 9 and radial passage 11 opens below lower stem seal 9 so that the metering chamber 4 is isolated from canal 10 and suspension inside cannot escape.

[0034] A ring 18 having a "U" shaped cross section extending in a radial direction is disposed around the valve body below orifice 16 so as to form a trough 19 around the valve body. As seen in Figure 1 the ring is formed as a separate component having an inner annular contacting rim of a diameter suitable to provide a friction fit over the upper part of valve body 1, the ring seating against step 13 below the orifice 16. However, the ring 18 may alternatively be formed as an integrally moulded part of valve body 1.

[0035] To use the device the container is first shaken to homogenise the suspension within the container. The user then depresses the valve stem 7 against the force of the spring 6. When the valve stem is depressed both ends of the passage 15 come to lie on the side of upper stem seal 12 remote from the metering chamber 4. Thus a dose is metered within the metering chamber. Continued depression of the valve stem will move the radial passage 11 into the metering chamber 4 while the upper stem seal 12 seals against the valve stem body. Thus, the metered dose can exit through the radial passage 11 and the outlet canal 10.

[0036] Releasing the valve stem causes it to return to the illustrated position under the force of the spring 6. The passage 15 then once again provides communication between the metering chamber 4 and sampling chamber 5. Accordingly, at this stage liquid passes under pressure from the container through orifice 16, through the passage 15 and thence into the metering chamber 4 to fill it.

[0037] Figure 2 shows a cut-away detail of a seal-stem contact point of a valve herein. The upright valve stem 108 which has a circular cross-section is sealingly contacted by a sealing ring 112. The ring aperture 130 of the sealing ring 112 has rounded edges. It may be understood that the area of contact of the ring 112 with the stem 108 is less than it would be if the ring 112 had square-cut edges. When the stem 108 is moved upwards, the ring 112 will tend to flex into free-space 140.

[0038] Figure 3 shows a cut-away detail of a seal-stem contact point of a second valve herein. The upright valve stem 208 which has a circular cross-section is sealingly contacted by a sealing ring 212. The ring aperture of the sealing ring 212 is edged by two rounded lobes 230, 232. The area of contact of the ring 212 with the stem 208 is less than it would be if the ring 212 had square-cut edges. When the stem 208 is moved within the ring 212, the ring 212 will tend to flex into free-space 240 and well 242. The well 242 may be wholly or partially filled with a lubricant material.

[0039] Figures 4a and 4b show a cut-away detail of a seal-stem contact point of a prior art valve, wherein Figure 4a shows a rest configuration and Figure 4b shows the configuration when the valve is in an active position. The upright valve stem 308 which has a circular cross-section is sealingly contacted by a sealing ring 312. The ring aperture 330 of the sealing ring 312 has square-cut edges 330. When the stem is moved upwards as shown in Figure 4b, the ring 312 is deformed and spreads out such that the area of contact between the ring 312 and the stem 308 is increased. The frictional contact between the ring 312 and stem is thus, also increased.

[0040] It may be appreciated that a number of different configurations of the sealing ring are possible, in addition to those described in Figures 2 and 3, in which the contact area between the sealing ring and the valve stem is reduced. One possible configuration is similar to that shown in Figure 3 but the ring aperture is edged by more than 2 lobes. Another possible configuration has a sealing ring aperture with straight tapered edges leading to a point (such that its cross section is triangular in shape) which has reduced contact with the valve stem compared to straight cut edges. A lobed version of this sealing ring is also possible wherein there are two or more lobes each tapered to a point. A further configuration which reduces the contact area with the valve stem has sections of the top and bottom sides of the ring aperture cut away to leave a smaller projecting portion to form a seal with the valve stem. The projecting portion may have straight cut or shaped edges. Cutting one or

more grooves or small channels in the non stem-receiving surfaces of the sealing ring provides space for the stem-receiving part of the sealing ring to move into upon movement of the valve stem, resulting in reduced deformation and friction at the contact surface with the valve stem.

[0041] It may be appreciated that any of the parts of the metering valve which contact the medicament suspension may be coated with materials such as fluoropolymer materials which reduce the tendency of medicament to adhere thereto. Suitable fluoropolymers include polytetrafluoroethylene (PTFE) and fluoroethylene propylene (FEP). Any movable parts may also have coatings applied thereto which enhance their desired movement characteristics. Frictional coatings may therefore be applied to enhance frictional contact and lubricants used to reduce frictional contact as necessary.

[0042] The aerosol container and valve of the invention is suitable for dispensing medicament, particularly for the treatment of respiratory disorders such as asthma and chronic obstructive pulmonary disease (COPD).

[0043] Appropriate medicaments may thus be selected from, for example, analgesics, e.g., codeine, dihydromorphine, ergotamine, fentanyl or morphine; aninal preparations, e.g., diltiazem; antiallergics, e.g., cromoglycate, ketotifen or nedocromil; antiinfectives e.g., cephalosporins, penicillins, streptomycin, sulphonamides, tetracyclines and pentamidine; antihistamines, e.g., methapyrilene; anti-inflammatory, e.g., beclomethasone dipropionate, fluticasone propionate, flunisolide, budesonide, rofleponide, mometasone furoate or triamcinolone acetonide; antitussives, e.g., noscapine; bronchodilators, e.g., albuterol, salmeterol, ephedrine, adrenaline, fenoterol, formoterol, isoprenaline, metaproterenol, phenylephrine, phenylpropanolamine, pirbuterol, reproterol, rimiterol, terbutaline, isoetharine, tulobuterol, or (-)-4-amino-3,5-dichloro- α -[6-[2-(2-pyridinyl)ethoxy] hexyl]methyl] benzenemethanol; diuretics, e.g., amiloride; anticholinergics, e.g., ipratropium, tiotropium, atropine or oxitropium; hormones, e.g., cortisone, hydrocortisone or prednisolone; xanthines, e.g., aminophylline, choline theophyllinate, lysine theophyllinate or theophylline; therapeutic proteins and peptides, e.g., insulin or glucagon. It will be clear to a person skilled in the art that, where appropriate, the medicaments may be used in the form of salts, (e.g., as alkali metal or amine salts or as acid addition salts) or as esters (e.g., lower alkyl esters) or as solvates (e.g., hydrates) to optimise the activity and/or stability of the medicament.

[0044] Preferred medicaments are selected from albuterol, salmeterol, fluticasone propionate and beclomethasone dipropionate, and ipratropium bromide and salts or solvates thereof, e.g., the sulphate of albuterol and the xinafoate of salmeterol.

[0045] Medicaments can also be delivered in combinations. Preferred formulations containing combinations of active ingredients contain salbutamol (e.g., as the free base or the sulphate salt) or salmeterol (e.g.,

as the xinafoate salt) in combination with an anti-inflammatory steroid such as a beclomethasone ester (e.g., the dipropionate) or a fluticasone ester (e.g., the propionate).

[0046] It will be understood that the present disclosure is for the purpose of illustration only and the invention extends to modifications, variations and improvements thereto within the scope of the appended claims.

Claims

1. Valve for an aerosol container, the valve comprising a valve body (1) which has a metering chamber (4), with first and second openings thereto, and a sampling chamber (5) adjacent the second opening; within said valve body, a first sealing ring (9) at the first opening and a second sealing ring (12) at the second opening between the metering and sampling chambers; and a valve stem (7) which extends through the metering chamber via the first and second openings and is mounted for sliding movement within the metering chamber of the valve with an outer surface of the valve stem being in sliding sealing contact with an inner surface (130;230) of both the first and second sealing rings, wherein the valve stem has a dispensing passage (10) and a transfer passage (15) and wherein the valve stem is slidably sealingly movable within the first and second sealing rings from a valve-closed position, in which the dispensing passage is isolated from the metering chamber and the metering chamber is in communication with the sampling chamber via the transfer passage, to a valve-open position, in which the dispensing passage is in communication with the metering chamber and the transfer passage is isolated from the metering chamber, **characterised in that** the inner surfaces of the first and second sealing rings each have at least one rounded edge in sliding sealing contact with the outer surface of the valve stem such as to reduce the contact area between the first and second sealing rings and the valve stem.
2. Valve according to claim 1 wherein the first and/or second sealing ring is formed by a moulding process.
3. Valve according to claim 2 wherein the moulding process is injection moulding.
4. Valve according to claim 2 wherein the moulding process is compression moulding.
5. Valve according to claim 2 wherein the moulding process is transfer moulding.
6. Valve according to any of claims 1 to 5, wherein the

inner surface of the first and/or second sealing ring presents a lobed surface to the outer surface of the stem.

7. Valve according to claim 6, wherein the lobed surface and the outer surface of the stem define one or more wells (242).
8. Valve according to claim 7, wherein said one or more wells contain lubricant material therein.
9. Valve according to any of claims 1 to 8 wherein the first and/or second sealing ring comprises an elastomeric material.
10. Valve according to claim 9 wherein the elastomeric material is selected from the group consisting of
 - (a) a thermoplastic elastomer comprising a copolymer of about 80 to about 95 mole percent ethylene and a total of about 5 to about 20 percent mole percent of one or more of 1-butene, 1-hexene and 1-octene;
 - (b) a styrene-ethylene/butylene-styrene block copolymer;
 - (c) an ethylene propylene diene rubber (EPDM)
 - (d) a thermoplastic elastomer blend of EPDM dispersed in a polypropylene or polyethylene matrix;
 - (e) a butyl polyethylene;
 - (f) a butyl-polypropylene; and any mixtures thereof.
11. Valve according to any of claims 1 to 10, wherein the first and/or second sealing ring additionally comprises lubricant material.
12. Aerosol container comprising a valve according to any of claims 1 to 11.
13. Aerosol container according to claim 12 comprising a suspension of a medicament in a propellant.
14. Aerosol container according to claim 13, wherein the propellant is liquefied HFA134a or HFA-227 or mixtures thereof.
15. Aerosol container according to either of claims 13 or 14, wherein the medicament is selected from the group consisting of albuterol, salmeterol, fluticasone propionate, beclomethasone dipropionate, ipratropium bromide and salts or solvates thereof and any combination thereof.

Patentansprüche

1. Ventil für einen Aerosolbehälter, mit:

einem Ventilkörper (1) mit einer Abmesskammer (4) mit einer ersten und einer zweiten Öffnung, und einer Probenkammer (5) angrenzend an die zweite Öffnung; wobei sich innerhalb des Ventilkörpers ein erster Dichtungsring (9) bei der ersten Öffnung und ein zweiter Dichtungsring (12) bei der zweiten Öffnung zwischen der Abmesskammer (4) und der Probenkammer (5) befindet; und
 einem Ventilschaft (7), der sich durch die Abmesskammer hindurch über die erste und die zweite Öffnung hinweg erstreckt und für eine gleitende Bewegung innerhalb der Abmesskammer des Ventils angebracht ist, wobei eine äußere Oberfläche des Ventilschafts in gleitendem abdichtendem Kontakt mit einer inneren Oberfläche (130; 230) sowohl des ersten als auch des zweiten Dichtungsrings steht, wobei der Ventilschaft einen Ausgabedurchgang (10) und einen Transferdurchgang (15) hat und gleitend und abdichtend innerhalb des ersten und des zweiten Dichtungsrings aus einer geschlossenen Ventilstellung, in welcher der Ausgabekanal von der Abmesskammer isoliert ist und die Abmesskammer über den Transferdurchgang in Verbindung mit der Probenkammer steht, in eine offene Ventilstellung beweglich ist, in welcher der Ausgabedurchgang in Verbindung mit der Abmesskammer steht und der Transferdurchgang von der Abmesskammer isoliert ist,

dadurch gekennzeichnet, dass die inneren Oberflächen des ersten und des zweiten Dichtungsrings jeweils zumindest eine abgerundete Kante in gleitendem abdichtendem Kontakt mit der äußeren Oberfläche des Ventilschafts haben, um so den Kontaktflächenbereich zwischen dem ersten und dem zweiten Dichtungsring und dem Ventilschaft zu reduzieren.

2. Ventil nach Anspruch 1, bei welchem der erste und/oder der zweite Dichtungsring mittels eines Gießvorgangs ausgebildet ist.
3. Ventil nach Anspruch 2, bei welchem der Gießvorgang ein Spritzgießvorgang ist.
4. Ventil nach Anspruch 2, bei welchem der Gießvorgang ein Kompressions-Gießvorgang ist.
5. Ventil nach Anspruch 2, bei welchem der Gießvorgang ein Transfer-Gießvorgang ist.
6. Ventil nach einem der Ansprüche 1 bis 5, bei welchem die innere Oberfläche des ersten und/oder des zweiten Dichtungsrings eine hin zu der äußeren Oberfläche des Schafts gewölbte Oberfläche auf-

weist.

7. Ventil nach Anspruch 6, bei welchem die gewölbte Oberfläche und die äußere Oberfläche des Schafts zumindest einen Schacht (242) definieren.
8. Ventil nach Anspruch 7, bei welchem der zumindest eine Schacht ein Schmiermaterial beinhaltet.
9. Ventil nach einem der Ansprüche 1 bis 8, bei welchem der erste und/oder der zweite Dichtungsring ein elastomerisches Material aufweist.
10. Ventil nach Anspruch 9, bei welchem das elastomerische Material aus der Gruppe ausgewählt ist, die besteht aus
 - (a) einem thermoplastischen Elastomer, das ein Copolymer von ungefähr 80 bis ungefähr 95 Molprozent Ethylen und insgesamt ungefähr 5 bis ungefähr 20 Molprozent aus 1-Buten, 1-Hexen und/oder 1-Octen aufweist,
 - (b) einem Styren-Ethylen/Butylen-Styrenblockcopolymer,
 - (c) einem Ethylenpropylenelastomer (EPDM),
 - (d) einer thermoplastischen Elastomermischung von EPDM, dispergiert in einer Polypropylen- oder Polyethylen-Marix,
 - (e) einem Butylpolyethylen,
 - (f) einem Butyl-Polypropylen

und allen Mischungen daraus.

11. Ventil nach einem der Ansprüche 1 bis 10, bei welchem der erste und/oder der zweite Dichtungsring außerdem ein Schmiermaterial aufweist.
12. Aerosolbehälter mit einem Ventil nach einem der Ansprüche 1 bis 11.
13. Aerosolbehälter nach Anspruch 12, mit einer Suspension eines Medikaments in einem Treibmittel.
14. Aerosolbehälter nach Anspruch 13, bei welchem das Treibmittel verflüssigtes HFA134a oder HFA-227 oder Mischungen daraus ist.
15. Aerosolbehälter nach Anspruch 13 oder 14, bei welchem das Medikament ausgewählt ist aus der Gruppe, die aus Albuterol, Salmeterol, Fluticasonpropionat, Beclomethasondipropionat, Ipratropiumbromid und Salzen oder Solvaten von diesen und allen Kombinationen daraus besteht.

Revendications

1. Valve pour un conteneur d'aérosol, la valve com-

- prenant un corps de valve (1) qui comporte une chambre de dosage (4), avec des première et seconde ouvertures sur celle-ci, et une chambre d'échantillonnage (5) adjacente à la seconde ouverture ; à l'intérieur dudit corps de valve, un premier anneau d'étanchéité (9) au niveau de la première ouverture et un second anneau d'étanchéité (12) au niveau de la seconde ouverture entre les chambres de dosage et d'échantillonnage; et une tige de valve (7) qui s'étend à travers la chambre de dosage par les première et seconde ouvertures et est montée pour un mouvement coulissant à l'intérieur de la chambre de dosage de la valve, une surface extérieure de la tige de la valve étant en contact étanche coulissant avec une surface interne (130 ; 230) des premier et second anneaux d'étanchéité à la fois, dans laquelle la tige de la valve comporte un passage de distribution (10) et un passage de transfert (15) et dans laquelle la tige de la valve peut être déplacée de façon étanche et coulissante à l'intérieur des premier et second anneaux d'étanchéité à partir d'une position de valve fermée, dans laquelle le passage de distribution est isolé de la chambre de dosage et la chambre de dosage est en communication avec la chambre d'échantillonnage par l'intermédiaire du passage de transfert, vers une position de valve ouverte, dans laquelle le passage de distribution est en communication avec la chambre de dosage et le passage de transfert est isolé de la chambre de dosage, **caractérisée en ce que** les surfaces internes des premier et second anneaux d'étanchéité comportent chacune au moins une extrémité arrondie en contact étanche coulissant avec la surface extérieure de la tige de la valve de façon à réduire la surface de contact entre les premier et second anneaux d'étanchéité et la tige de la valve.
2. Valve selon la revendication 1, dans laquelle le premier et/ou le second anneau d'étanchéité sont formés par un procédé de moulage.
 3. Valve selon la revendication 2, dans laquelle le procédé de moulage est le moulage par injection.
 4. Valve selon la revendication 2, dans laquelle le procédé de moulage est le moulage par compression.
 5. Valve selon la revendication 2, dans laquelle le procédé de moulage est le moulage par transfert.
 6. Valve selon l'une quelconque des revendications 1 à 5, dans laquelle la surface interne du premier et/ou du second anneau d'étanchéité présente une surface lobée par rapport à la surface externe de la tige.
 7. Valve selon la revendication 6, dans laquelle la sur-
- face lobée et la surface extérieure de la tige définissent une ou plusieurs cupules (242).
8. Valve selon la revendication 7, dans laquelle ladite une ou plusieurs cupules contient une substance lubrifiante dans celle-ci.
 9. Valve selon l'une quelconque des revendications 1 à 8, dans laquelle le premier et/ou le second anneau d'étanchéité comprennent un matériau élastomère.
 10. Valve selon la revendication 9, dans laquelle le matériau élastomère est choisi dans le groupe constitué par
 - (a) un élastomère thermoplastique comprenant un copolymère d'environ 80 à environ 95 % en mole d'éthylène et un total d'environ 5 à environ 20 % en mole d'un ou plusieurs parmi le 1-butène, le 1-hexène et le 1-octène ;
 - (b) un copolymère séquencé styrène-éthylène/butylène-styrène ;
 - (c) un caoutchouc d'éthylène propylène diène (EPDM) ;
 - (d) un mélange élastomère thermoplastique d'EPDM dispersé dans une matrice en polypropylène ou polyéthylène ;
 - (e) un polyéthylène butylique ;
 - (f) un polypropylène butylique ; et des mélanges quelconques de ceux-ci.
 11. Valve selon l'une quelconque des revendications 1 à 10, dans laquelle le premier et/ou le second anneau d'étanchéité comprennent une substance lubrifiante.
 12. Conteneur d'aérosol comprenant une valve selon l'une quelconque des revendications 1 à 11.
 13. Conteneur d'aérosol selon la revendication 12 comprenant une suspension d'un médicament dans un gaz propulseur.
 14. Conteneur d'aérosol selon la revendication 13, dans lequel le gaz propulseur est du HFA-134a ou du HFA-227 liquéfié ou des mélanges de ceux-ci.
 15. Conteneur d'aérosol selon l'une quelconque des revendications 13 ou 14, dans lequel le médicament est choisi dans le groupe constitué par l'albutérol, le salmétérol, le propionate de fluticasone, le dipropionate de béclo-métasone, le bromure d'ipratropium et des sels ou solvates de ceux-ci et une quelconque combinaison de ceux-ci.

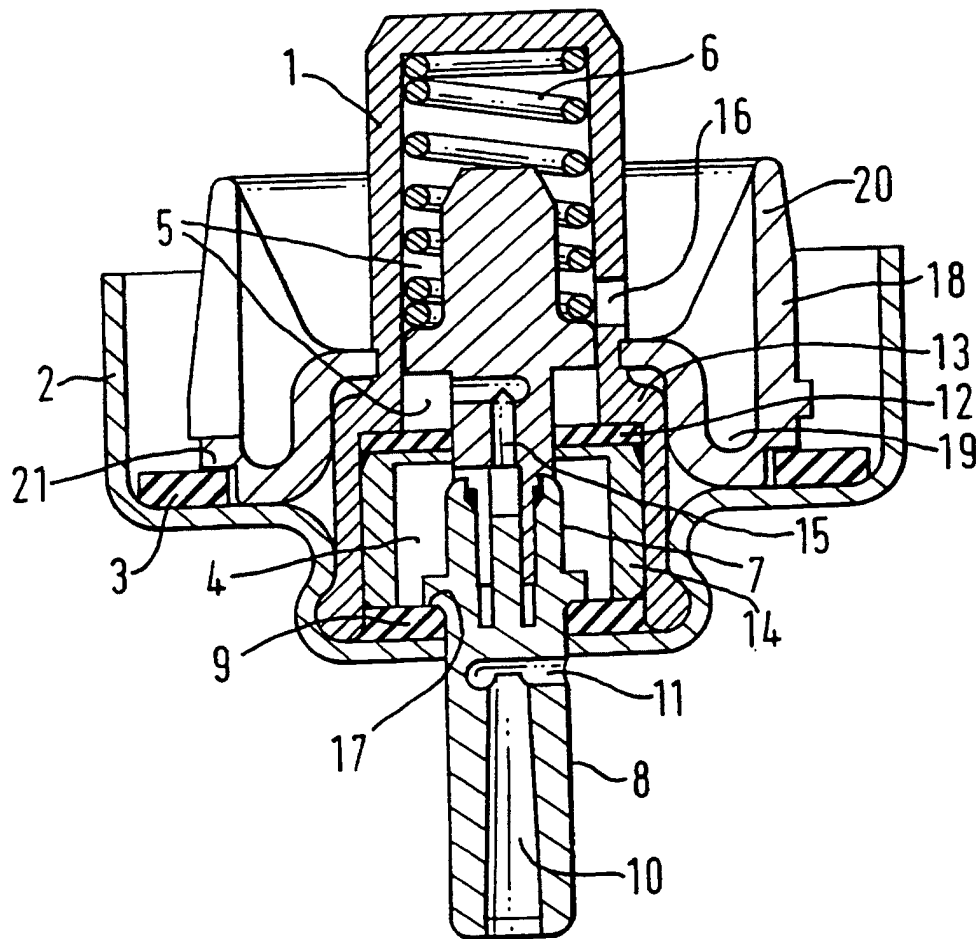


FIG. 1.

FIG. 2.

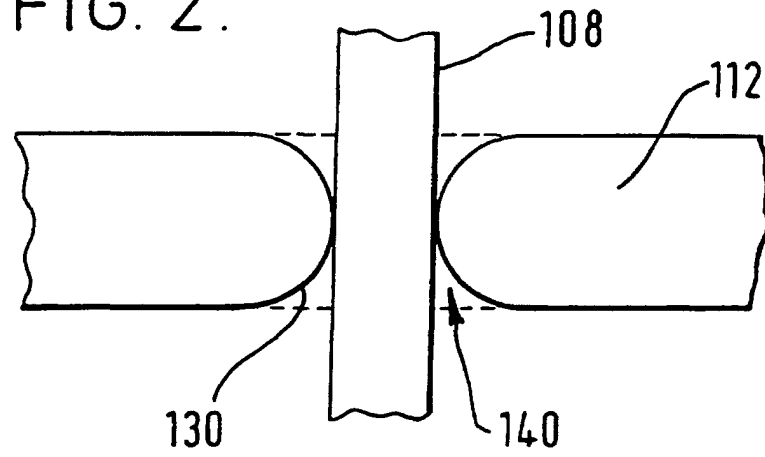


FIG. 3.

