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(54) **Title:**

**RECLOSING CAN FOR FOOD PRODUCT**

(57) **Abstract:**

A can end (2) is described for a metal beverage can, optionally for carbonated drinks, the can end including a cap top (3), arranged in connection to a pull tab (4) configured to remove the cap top along a pre-defined groove (9), to thereby create a drinking or pouring aperture; an elastic resilient element (10) attached to the can end; and a resiliently operated shut-off valve (6) that is part of or is connected to the elastic resilient element (10) and that is configured to seal the drinking or pouring aperture after drinking or pouring; wherein the cap top (3) is configured to remain located, after the removal, on top of the shut-off valve (6). Further, a can including such a can end, and a method for opening and reclosing such a can are described, as well as a method for producing such a can.



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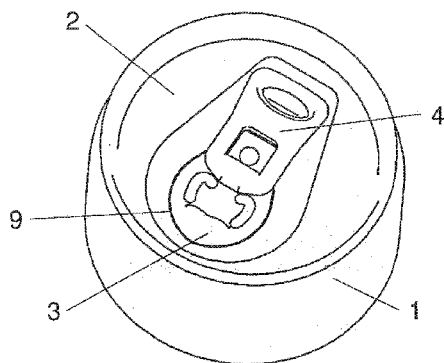


Fig. 1a

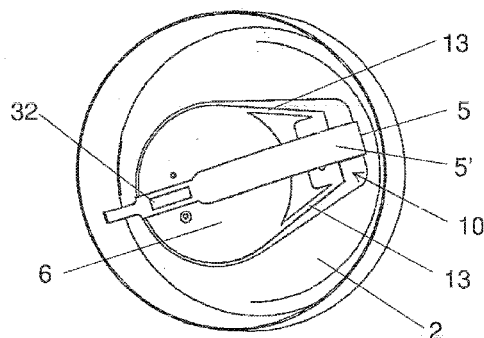


Fig. 1b

(57) Abstract: A can end (2) is described for a metal beverage can, optionally for carbonated drinks, the can end including a cap top (3), arranged in connection to a pull tab (4) configured to remove the cap top along a pre-defined groove (9), to thereby create a drinking or pouring aperture; an elastic resilient element (10) attached to the can end; and a resiliently operated shut-off valve (6) that is part of or is connected to the elastic resilient element (10) and that is configured to seal the drinking or pouring aperture after drinking or pouring; wherein the cap top (3) is configured to remain located, after the removal, on top of the shut-off valve (6). Further, a can including such a can end, and a method for opening and reclosing such a can are described, as well as a method for producing such a can.



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**[DESCRIPTION]**

## RECLOSING CAN FOR FOOD PRODUCT

## 5 FIELD OF THE INVENTION

The present invention relates to a container such as a can for a food product, especially a beverage, as well as a method of manufacturing the container or can. The container or can is especially suitable for carbonated beverages or  
10 drinks. The container or can can be provided with means for easily reclosing after the first opening.

## BACKGROUND TO THE INVENTION

15 Metal beverage cans usually have a pull tab (working as a lever mechanism) to allow for the opening of the can along a pre-determined shallow groove. This design allows venting the excess pressure in the can when it is opened. As the tab is lifted, first a vent score is severed, allowing the gases in the can to be released, and then the aperture score is ruptured, which defines an aperture  
20 through which the contents of the beverage can may be dispensed. The groove has the shape of a non-closed loop, so that when pressure is applied by the lever to rip the metal along the groove, the metal tab that is ripped off remains attached to the top of the can, even when the lever is returned to its original position.

25

With existing cans, a permanent opening is formed by these manipulations, so that the contents of the can may be drunk, but on the other hand carbon dioxide may escape and spills may occur.

30 Patents US4784283 and US5810189 disclose beverage cans that include a spring-loaded tab inside the can that is configured to reclose the drinking aperture after the can is opened for the first time. However, for a carbonated

beverage can, pressure is built up in the can because of the gases. The pressure decreases as the amount of liquid in the can decreases, but the pressure can be quite high initially: depending on the temperature of the liquid, this pressure can be between 3 and 4 bar. Such a high pressure on a closing  
5 surface of e.g. 2.5 to 3.5 cm<sup>2</sup> results in a large force that needs to be counteracted when opening the can for drinking when the can still contains a large amount of beverage.

Patent application US 2008/0314904, with inventor Perra, discloses a closing  
10 device for a food product container, more particularly a drink container, that includes a wall part provided with an opening and a shield member sealing the opening. The shield member is displaceable between a first, closed position sealing the opening in the wall part and a second, opened position leaving the opening at least partly open. The shield member is provided with a locking  
15 member securing the shield member in the first, closed position, and the shield member oriented in the first, closed position can be unlocked by displacing a locking member. The operations of unlocking and opening a (drinking) opening are separated such that both operations can be optimized independently of each other. The food product container can be used for carbonated drinks, such  
20 as sparkling water. In this case, pressure is built up in the drink container because of the gases. In an embodiment, a closing device with a gas passage is disclosed that acts as a relief valve to decrease pressure in the drink container when it is opened for the first time. Instead of for carbonated beverages, the food product container can also be used for other food articles,  
25 such as for example non-carbonated beverages, instant soup, instant coffee, oil, honey, sauces, dairy products such as milk or yoghurt, et cetera.

## SUMMARY OF THE INVENTION

30 The present invention provides an alternative container, e.g. a can for food products, especially beverages such as carbonated drinks. An advantage of embodiments of the container or can is that it is provided with means for easily

reclosing after it is opened for the first time. Thus, spilling food or liquid is avoided. In some embodiments the reclosing is not only liquid tight but also gas tight. In case of a carbonated drink, the carbon dioxide will then not escape from the can as is the case with a traditional can, since the can according to the  
5 present invention is reclosed.

The present invention provides in one embodiment a can end for a metal beverage can optionally for carbonated drinks, the can end comprising:

- a cap top, arranged in connection to a pull tab configured to remove the  
10 cap top from the can end along a pre-defined groove, to thereby create a drinking or pouring aperture;
- an elastic resilient element attached to the can end;
- a resiliently operated shut-off valve that is part of or is connected to the elastic resilient element and that is configured to seal the drinking or  
15 pouring aperture after drinking or pouring;

wherein the cap top is configured to remain located, after the removal, on top of the shut-off valve.

The elastic resilient element may have holding means for holding the shut-off  
20 valve in an opened position upon moving the cap top.

The present invention also includes a metal beverage can optionally for carbonated drinks comprising a can body and a can end in accordance with the  
25 invention.

The present invention further includes a method for producing a can, embodiments of the method comprising producing a can end in accordance with the invention, producing a can body, and attaching the can end to the can  
30 body.

Embodiments of the present invention also include a method for using a reclosing metal beverage can, optionally for carbonated drinks, said can comprising a can body and a can end, the method comprising the steps of:

- actuating a pull tab of said can end, thus removing a cap top of said can end along a predetermined groove of said can end, thus creating a drinking or pouring aperture;
- resiliently opening, by said actuating said pull tab, a shut-off valve that is part of or is connected to an elastic resilient element of said can end and that is configured to seal said drinking or pouring aperture after drinking or pouring, wherein said removed cap top remains located on top of said shut-off valve.

The method may further comprise holding said shut-off valve in an opened position by said elastic resilient element.

15

In a preferred embodiment, the container or can includes a can end, the can end comprising a cap top, arranged in connection to a pull tab configured to remove the cap top along a pre-defined groove or other form of mechanical weakness, to thereby create a drinking aperture. The can end preferably comprises a resiliently operated, e.g. spring operated shut-off valve configured to open the drinking aperture during drinking and to seal the drinking opening when the can is not in use. The sealing may be a liquid and/or gas tight sealing. The cap top is preferably configured to remain located, after the removal, on top of the shut-off valve. Preferably, the can end comprises an elastic resilient element attached to the can end, that has holding means for holding the shut-off valve in an opened position upon moving the cap top.

Moving the cap top, so that it can be held in an opened position, may be done in different ways. The cap top may be moved by moving the pull tab. In one embodiment, the cap top comprises a raised lip-contact portion on its upper surface, and the cap top may then be moved by moving said raised lip-contact portion. The cap top may also be moved by a finger of the user.

30

In one preferred embodiment, the shut-off valve includes a relief valve, optionally actuatable by interaction with the cap top and e.g. configured to release gas pressure from inside the can, upon the first pressure exerted on the relief valve.

Preferred embodiments of the container or can according to the present invention are suitable for mass production.

One advantage of some embodiments of the invention, when used for carbonated beverages, is that means may be provided for relieving the internal pressure in the can. In a carbonated beverage can, pressure is built up in the can because of the gases. In some embodiments of the invention, when the can is being opened for the second or for a subsequent time, the internal pressure is relieved before reopening, so that the can can be reopened easily since no large force needs to be counteracted.

Another advantage of some embodiments in accordance with the invention is a security pressure relief. When an already opened can that contains a carbonated beverage is reclosed, pressure builds up underneath the can end. As the drinking opening has already been created, the strength of the can end has significantly decreased, and the can end may gradually deform under the built up pressure. Such a deformation causes the can end to bulge outwards. Especially in high temperatures (e.g. when the can is in the sun in a car) this effect may become important and there may be a risk of rupture of the can. In some embodiments of the invention, a security pressure relief then decreases pressure before it becomes too high, and thus makes sure that a can that contains a carbonated beverage will not be ruptured and will not explode.

Yet another advantage of some embodiments of cans in accordance with the invention is that they are spilling-proof: when they are tipped over or are dropped, they are closed automatically.



Further, some embodiments of cans according to the invention may be reclosed easily and in different ways, depending on the size and type of the can. Some types of cans may be closed by gently pushing against a side wall of the can.

- 5   Types of cans may be closed by gently tapping against the can, e.g. by putting the can on a table with a small shock.

Another, important advantage of a container or can according to the invention is that it can easily be produced. In comparison with a traditional can, only the can  
10   end is different. Thus, a traditional production line of cans can be modified to produce the container or can, e.g. by replacing the production steps for the traditional can end by the production steps for the can end according to the invention; e.g. by adaptation of the tooling for the production line. The production steps and tooling for the can body and for attaching the can end to  
15   the can body can remain unchanged. Moreover, a can end in accordance with the invention requires only a small number of parts. In some embodiments in accordance with the invention, the elastic resilient element has dimensions and properties such that the can ends, each including an elastic resilient element, are stackable. The can ends may thus be stacked one on top of the other, so  
20   that a stack of can ends requires only little space, just as stacked can ends of traditional cans do.

The container or can will be described below especially when used for beverages, particularly carbonated drinks. It will be clear from the description  
25   however that the can may also be used for other food products, such as instant soup, instant coffee, oil, honey, sauces, dairy products such as milk or yoghurt, et cetera.

## BRIEF DESCRIPTION OF THE DRAWINGS

30

The invention will be described, by way of example only, with reference to the accompanying drawings, wherein:

Figs. 1a and 1b show 3D views of an embodiment of a can end and the top portion of a can, seen respectively from the top and from the bottom;

Figs. 2a and 2b show views of an embodiment of an elastic resilient element;

Fig. 3b shows a top view of an embodiment of a can end and the top portion of a can, before its first opening, and Fig. 3a shows a cross section along line A – A in Fig. 3b;

Figs. 4 to 10 are views of an embodiment of a can end and the top portion of a can wherein the front half is cut away, and in which:

Figs. 4 and 5 show the first opening of a can;

Figs. 6a and 6b show a can ready for drinking;

Figs. 7 and 8 show reclosing of a can;

Figs. 9a and 9b show a reclosed can;

Figs. 10a and 10b show reopening of a can, including pressure relief;

Fig. 11 shows another embodiment of a can end and the top portion of a can wherein the front half is cut away;

Fig. 12b shows a top view of an embodiment of a can end and the top portion of another type of can, before its first opening, and Fig. 12a shows a cross section along line B – B in Fig. 12b;

Fig. 13b shows a top view of another embodiment of a can end and the top portion of the type of can shown in Figs. 12a and 12b, before first opening of the can, and Fig. 13a shows a cross section along line C – C in Fig. 13b;

Figs. 14a and 14b show, for the embodiment of Figs. 13a and 13b, 3D views of the can end and the top portion of a can, seen respectively from the top and from the bottom;

Fig. 15b shows a top view of an embodiment of a can end and the top portion of a can having a raised lip-contact portion, before its first opening, and Fig. 15a shows a cross section along line F – F in Fig. 15b;

Fig. 16b shows a top view of another embodiment of a can end and the top portion of a can having a raised lip-contact portion, before first opening of the can, and Fig. 16a shows a cross section along line E – E in Fig. 16b;

Figs. 17a and 17b show an embodiment of a can end and the top portion of a can wherein the front half is cut away;

Fig. 18 shows a 3D view of the bottom side of an embodiment of an elastic resilient element;

Figs. 19a and 19b show an embodiment of an elastic resilient element, a cap top and a pull tab;

5 Fig. 20 shows an embodiment of a can end and the top portion of a can wherein the pull tab is partially cut away;

Fig. 21 shows an embodiment of an elastic resilient element having asymmetric elastic coupling means;

10 Fig. 22 shows an embodiment of an elastic resilient element with a strengthened portion;

Fig. 23 shows an embodiment of an elastic resilient element including a shut-off valve with incisions;

Figs. 24a and 24b show an embodiment of an elastic resilient element including braking means;

15 Figs. 25a and 25b show an embodiment of a can having an additional locking feature;

Fig. 26 shows a number of can ends according to one embodiment, stacked on top of each other;

20 Fig. 27 shows an embodiment of an elastic resilient element, suitable for being used in stackable can ends as shown in Fig. 26;

Figs. 28a and 28b show a top view and a bottom view of the elastic resilient element of Fig. 27, in a folded state;

Fig. 29 shows an embodiment of an intermediate element;

Fig. 30 shows the intermediate element of Fig. 29, mounted in a can end;

25 Fig. 31 shows the elastic resilient element shown in Fig. 28a being assembled to the intermediate element of Fig. 29;

Fig. 32 shows the assembly illustrated by Fig. 31 of the elastic resilient element and the intermediate element, mounted in a can end;

30 Figs. 33a and 33b show 3D views of another embodiment of a can end, seen respectively from the top and from the bottom;

Figs. 34a and 34b show an embodiment of an elastic resilient element used in the embodiment of Figs. 33a and 33b;

Figs. 35a and 35b show an embodiment of an assembly including the elastic resilient element of Figs. 34a and 34b;

Figs. 36a and 36b show cross sections of embodiments of can ends;

Figs. 37 and 38 show stacks of embodiments of can ends;

5 Fig. 39 shows an embodiment of an intermediate element;

Fig. 40 shows an exploded view of an assembly including the intermediate element of Fig. 39.

## 10 DETAILED DESCRIPTION OF PREFERRED EMBODIMENTS OF THE INVENTION

The present invention will be described with respect to particular embodiments and with reference to certain drawings but the invention is not limited thereto but only by the claims. The drawings described are only schematic and are non-  
15 limiting. In the drawings, the size of some of the elements may be exaggerated and not drawn to scale for illustrative purposes. The dimensions and the relative dimensions do not correspond to actual reductions to practice of the invention.

Furthermore, the terms first, second, third and the like in the description and in  
20 the claims, are used for distinguishing between similar elements and not necessarily for describing a sequential or chronological order. It is to be understood that the terms so used are interchangeable under appropriate circumstances and that the embodiments of the invention described herein are capable of operation in other sequences than described or illustrated herein.

25

Moreover, the terms top, bottom, over, under and the like in the description and the claims are used for descriptive purposes and not necessarily for describing relative positions. It is to be understood that the terms so used are interchangeable under appropriate circumstances and that the embodiments of  
30 the invention described herein are capable of operation in other orientations than described or illustrated herein.

It is to be noticed that the term “comprising”, used in the claims, should not be interpreted as being restricted to the means listed thereafter; it does not exclude other elements or steps. It is thus to be interpreted as specifying the presence of the stated features, integers, steps or components as referred to, but does not preclude the presence or addition of one or more other features, integers, steps or components, or groups thereof. Thus, the scope of the expression “a device comprising means A and B” should not be limited to devices consisting only of components A and B. It means that with respect to the present invention, the only relevant components of the device are A and B.

10

Fig. 1a shows a 3D view of the top portion of a container or can, e.g. a re-sealable beverage can in accordance with an embodiment of the present invention. The can includes a can body 1 and a can end 2 attached to the body. The can body may be a standard can body, typically made out of steel, or out of aluminum. The can end is often produced in aluminum. None of these materials represent a limitation to the invention, e.g. the can end 2 in accordance with the invention may be made from steel. If steel is used, for the can body 1, the can end 2 or for both, it is customarily coated. The invention may be applied to different standard containers such as beverage cans and sizes, as well as to so-called “slim” and “super sized” cans. Fig. 1a shows a “slim sized” can, with a so-called small drinking opening. A standard can with a large drinking opening is shown and discussed further below. Other designs of openings such as drinking or pouring openings may be used as well. In an embodiment, the edge of the can end 2 is standard, especially the way it has to be assembled on the can body 1 after filling with the food product.

25

In the embodiment shown in Figs. 1a and 1b, the central part of the can end 2 has a tear panel 3, called the cap top in this document, which is very similar to the pull-off part of a standard beverage can end. As in a known, traditional beverage can, the cap top 3 can be torn off along the pre-formed shallow groove 9 or other form of mechanical weakness, by pulling at the pull tab 4, which works as a lever. The opening that is thus created serves as a pouring or

30

drinking opening, as in a traditional beverage can. However, in a traditional beverage can the cap top remains attached to the can, whereas in the disclosed embodiment according to the invention the cap top 3 is torn completely from the can end along the groove 9. After tearing off the cap top 3, the cap top 3  
5 remains attached to a shut-off valve 6 (shown in Fig. 1b), which is configured to reseal the pouring or drinking opening after drinking, by the action of an elastic resilient element 10, which is described in detail further below. In the shown embodiment, before it is opened for the first time, the can is closed in the same way as a traditional can. It is opened by making a rupture through metal, as is  
10 the case for a traditional can, and it is thus as leak-proof as a traditional can. Many other existing re-sealable cans rely on other opening mechanisms, e.g. on opening by a rotation, and they are often not at all as leak-proof.

In an embodiment, the shut-off valve 6 is a plate-like element, which is  
15 resiliently biased, e.g. spring-biased against the underside of the can end 2, by the resilient force, e.g. spring force, exerted by a resilient member such as a spring means 5 being part of elastic resilient element 10, and further, possibly, by any force resulting from the internal pressure that is built up when the can is filled with a carbonated drink. The shut-off valve may be round, it may be oval, it  
20 may have another shape. The shut-off valve 6 may be provided with a relief valve. Different embodiments of this relief valve are disclosed further below.

In the embodiment shown in Figs. 1a and 1b, the consumer can drink or pour from the can by tearing open the cap top 3 by actuating the pull tab 4, as  
25 explained above; when moving the pull tab 4 further, the shut-off valve 6 is held in an opened position so that the consumer can drink or pour. This is explained in detail further below, with reference to Figs. 4 - 6; Figs. 4 and 5 illustrate the first opening of the can, while Figs. 6a and 6b show the can ready for drinking. Fig. 6a shows a side view of an embodiment of a can, while Fig. 6b shows a  
30 detail of the area indicated in Fig. 6a. In Fig. 6a, the cap top 3, and hence the shut-off valve 6 below the cap top, was pushed downwards by actuating pull tab 4, against the force of the elastic resilient element 10. In Fig. 6a, pull tab 4 is

now being put back in its original position, as indicated by arrow 64. Shut-off valve 6 is held in an opened position by holding means 32 of elastic resilient element 10; in the embodiment of Figs. 6a and 6b, this holding means 32 is a slit 32 engaging with a slightly downwards bent hook 31 of shut-off valve 6 and thus holding the valve.

In the embodiment of Figs. 1a and 1b, the elastic resilient element 10 comprises spring means 5. This embodiment of the elastic resilient element 10 is shown in detail in Figs. 2a and 2b, which show respectively a bottom view and a top view of the elastic resilient element 10, and element 10 is further shown in Fig. 3a, which is a cross section of a top portion of a can. In this embodiment, the elastic resilient element 10 comprises spring means 5, and the shut-off valve 6 is part of the elastic resilient element 10. In other embodiments of the invention, the shut-off valve 6 may be a separate element, connected to the elastic resilient element. The elastic resilient element, and the shut-off valve if it is not part of the elastic resilient element, may be made e.g. from HSS (High Strength Steel), which has fairly good resilience, combined with good mechanical properties for stamping and distortion. In some embodiments, the elastic resilient element may comprise a plurality of parts. In the embodiment of Figs. 1 – 3, the elastic resilient element 10 is a single part, and is a specially designed plate element. The elastic resilient element 10 is now further discussed with reference to Figs. 2a, 2b and 3. The elastic resilient element 10 comprises shut-off valve 6 and spring means 5; shut-off valve 6 is attached to spring means 5 by elastic coupling means, which are, in the embodiment shown in Figs. 2a and 2b, narrow, elastic strips 13. Before being mounted in the can, a portion of the elastic resilient element 10 is bent backwards so that a bent-back portion 5' is obtained. This bent-back portion 5' may include a curved portion 5'' and an end 5'''. The end 5''' of bent-back portion 5' is biased against the underside of shut-off valve 6 (Fig. 3a). Strips 13 and spring means 5, that includes the bent-back portion 5', bias shut-off valve 6 against the underside of the can end 2 (Fig. 1b). Referring again to Fig. 3a, some embodiments of the elastic resilient element 10 may further comprise an extended portion 14 of end 5''' and/or a protrusion 33;

both are shown in the embodiment of Fig. 3a. The extended portion 14, that may be a narrow strip, is positioned underneath rim 30 of can end 2, and acts as a security pressure relief. The protrusion 33 is used to reclose the can in some embodiments. Both protrusion 33 and the security pressure relief are  
5 discussed in more detail further below, as well as the other portions of the elastic resilient element 10. Elastic resilient element 10 may be made of a type of material having good resilient properties, e.g. a metal such as steel. Elastic resilient element 10 may have an opening 11 (shown in Fig. 2b) through which it may be attached to the can end 2, via a fixing device such as a rivet 12 (Figs.  
10 3a and 3b). In Fig. 3a, pull tab 4 is attached to can end 2 by another rivet 52.

Opening, reclosing and reopening embodiments of a can in accordance with the invention are illustrated in Figs. 4 to 10, which show side views of a can wherein the front half is cut away.

15

Fig. 4 shows an embodiment of a can in accordance with the invention that is opened for the first time. Pull tab 4 is actuated by a user in the direction of arrow 61 and thereby removes cap top 3 from can end 2 by tearing it off along pre-formed groove 9. Cap top 3, on top of shut-off valve 6, is pushed downwards  
20 and against the force exerted by elastic resilient element 10 on shut-off valve 6, by the action of pull tab 4.

In Fig. 5, pull tab 4 is moved still further in the direction of arrow 62. By this action, the curved portion 5" (see Figs. 4 and 5) of the bent-back portion 5' of  
25 elastic resilient element 10 is stretched, as is indicated by arrow 63 in Fig. 5. This stretching is caused by the geometry, in general the shape, and the elastic properties of the elastic resilient element 10. The stretching is important since protrusion 33 is thus brought nearer to the side wall 35 of the can, which will be used to reclose the can, as will be discussed in connection to Figs. 7 and 8.  
30 Thus, in a preferred embodiment the bent-back portion 5' has a shape such that, upon opening the can, the protrusion 33 is moved nearer to the side wall 35 of the can.



The next step is shown in Figs. 6a and 6b. Pull tab 4 is now moved, in the direction of arrow 64, back to its original position. Shut-off valve 6, and on top of it cap top 3, are held in an opened position, as is best shown in Fig. 6b which is a detail of the area indicated in Fig. 6a. The can is now in a position for drinking or pouring. Shut-off valve 6 is held in an opened position by holding means 32, which is in the embodiment of Figs. 6a and 6b a slit 32 (also shown in Fig. 1b) engaging with a slightly downwards bent hook 31 of shut-off valve 6. Of course other holding means can be used. In another embodiment, the engaging means of the elastic resilient element is a hook, that engages with engaging means of the shut-off valve.

An embodiment of reclosing the can is shown in Figs. 7 and 8. In the embodiment of Fig. 7, the user pushes gently against the side wall 35 of the can at a location opposite to the pull tab 4. The side wall of a can is thin, and the user thus exerts a force, through the side wall 35, on the protrusion 33 of the end of the bent-back portion of the elastic resilient element 10. Protrusion 33 now moves in the direction of arrow 65, and the hook 31 and the slit 32 disengage, as shown in Fig. 8. Because of the force exerted by elastic resilient element 10, the shut-off valve 6 now moves in the direction of arrow 66, to close the drinking aperture.

Fig. 9a and Fig. 9b, which is a detailed view of the area indicated in Fig. 9a, show an embodiment of the reclosed can. Shut-off valve 6 now has closed the drinking aperture, which is tightly sealed by seal 19 of shut-off valve 6. The shut-off valve 6 has such a seal 19 all around its circumference, so that the drinking aperture is tightly closed (e.g. in Fig. 8, only half of this seal, and half of the shut-off valve, is shown - the front half is cut away in this drawing; in Fig. 17a, the complete seal is shown). Seal 19 may e.g. be made from silicone or another suitable material. In the embodiment shown in Fig. 9b, the cap top 3 is now a small distance, e.g. a few tenths of mm, below the plane of can end 2. An advantage is that burrs, that may occur on the border of the cap top 3 due to the

tearing removal of the cap top upon opening of the can, will not touch the can end 2. Thus, these burrs will not entangle with the drinking aperture, and will not hinder reopening of the can. In the embodiment of Figs. 9a and 9b, the cap top 3 may move slightly towards the shut-off valve 6 after the can is opened, because of the way the cap top 3 is fastened to the shut-off valve 6. In this embodiment, two staples 36 are used (only one staple 36 is shown in Figs. 9a and 9b). Each staple 36 is clamped to an embossment 38 in the cap top 3, pierces the shut-off valve 6 via a hole 21, and ends in a thickening, a so-called mushroom 37. (Two embossments 38 for staple means 36 are shown in Fig. 3b). When the can is opened for the first time, the staple means 36 are pushed downwards, and the thickness of seal 19 is large enough so that, when the can is reclosed, the cap top 3 is a small distance below the plane of can end 2, as discussed above. Further, the staples 36 are long enough so that cap top 3 remains located on top of shut-off valve 6, but can still move a bit upwards or downwards. Of course cap top 3 may be fastened in other ways to shut-off valve 6.

Fig. 10a and Fig. 10b, which shows in detail the area indicated in Fig. 10a, illustrates reopening a can, wherein the can includes an embodiment of a pressure relief valve 8. To open the can, the user actuates pull tab 4 in the direction of arrow 67. This first pushes cap top 3 downwards. Cap top 3 comprises a bulging portion 25, pointing downwards. Shut-off valve 6 has a hole 26, positioned in front of bulge 25. Hole 26 may have a crater-shaped cross-section, in order to receive the bulge 25. Bent-back portion 5' of elastic resilient element 10 is provided near its end with a portion 5''' which is substantially parallel to shut-off valve 6 and which is provided with a seal element 27 which effectively closes the opening 26 when the can is not used by the consumer, since the portion 5''' is then biased against the underside of shut-off valve 6. When actuating pull tab 4 in the direction of arrow 67, cap top 3 is pushed downward and bulge 25 pushes - through hole 26 - against seal element 27. Thus, portion 5''' is pushed away from the shut-off valve 6, in the direction of arrow 68, before the shut-off valve 6 itself opens. This action releases pressure

from inside the can through opening 26 and thereafter facilitates opening of the shut-off valve 6 itself, when pull tab 4 is further moved in the direction of arrow 67. Thus, the opening 26 together with the bulging portion 25 and the seal 27 act as a pressure relief valve 8.

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Preferably, a can in accordance with the invention also includes a security pressure relief means. One embodiment is shown in Fig. 3a. This cross section of a can shows that the extended portion 14 of end 5'' of elastic resilient element 10 extends underneath the rim 30 of the can end 2. The extended portion 14, together with pressure relief valve 8, acts as a security pressure relief means, as will now be explained. When an already opened can that contains a carbonated beverage is resealed by shut-off valve 6, pressure builds up underneath the can end, as discussed already above. As the drinking opening has been created, the strength of the can end has significantly decreased, and the can end may gradually deform under the built up pressure. Such a deformation causes the can end to bulge outwards. Especially in high temperatures, this effect may become important and there may be a risk of rupture of the can. However, when the can end has deformed to a certain degree, extended portion 14 comes into contact with the rim 30 of the can end (see Fig. 3a). When the deformation continues, extended portion 14 will be pushed downwards and eventually cause seal 27 to be removed from opening 26, thus opening the pressure relief valve 8. Gases are thus released and pressure inside the can decreases, so that the deformation decreases as well. Thus, extended portion 14, together with relief valve 8, provides a security pressure relief means: even at very high pressure, a can that contains a carbonated beverage will not be ruptured and will not explode.

Fig. 11 represents an embodiment of a can end and a can without a protrusion 33 of the end of the bent-back portion of the elastic resilient element 10 (compare Fig. 11 to Fig. 7). The embodiment of the can of Fig. 11 has the same engaging means 31 of the shut-off valve 6 and the same engaging means 32 of the elastic resilient element 10 as the embodiment shown in Fig. 7. The

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embodiment of the can of Fig. 11 cannot be reclosed by gently pushing against the sidewall of the can. Instead, such a can is closed by gently tapping against the can, e.g. by putting the can on a table with a small shock. By such gentle tapping, the engaging means of the shut-off valve and of the elastic resilient element (e.g. a hook and a slit) disengage, and the shut-off valve is closed by the force exerted on it by the elastic resilient element. The user can also e.g. hold the can in one hand and gently tap the can with a finger of the other hand. He can also push gently on the cap top 3 in its opened position, e.g. with his thumb. Any of these actions will close the can. Another advantage of this embodiment is that the can will automatically reclose when it is dropped or tipped over; thus, the content of the can will not be spilled if the can accidentally falls.

Fig. 11 further shows an embodiment of the positions of two hinge points: the hinge point 45, around which the bent-back portion 5' of the elastic resilient element 10 rotates, and the hinge point 12 (e.g. a rivet fastening the elastic resilient element) around which the shut-off valve 6 rotates. Because of the relative positioning of these hinge points 45 and 12, when the can is opened by actuating the pull tab 4 in the direction of arrow 69, the end point 46 of shut-off valve 6 moves on a circle with a smaller radius than point 47 near the end of bent-back portion 5' of elastic resilient element 10. Therefore, although the engaging means 32 of the elastic resilient element 10 is initially nearer to the hinge points 12 and 45 than the engaging means 31 of the shut-off valve, by opening the can both engaging means will come closer to each other and will engage. Further, in the embodiment shown in Fig. 5, the bent-back portion of elastic resilient element 10 is stretched when opening the can (see arrow 63 in Fig. 5), which also contributes to the engaging means coming closer to each other.

As mentioned already above, the present invention can be applied to different types of cans: standard cans, slim sized cans, super sized cans, etc. Figs. 3a and 3b show a slim sized can; such cans are used e.g. for Red Bull<sup>TM</sup> drinks.

For a standard can, such as is used in general for Coca Cola™ drinks, Figs. 12a and 12b show the same views as Figs. 3a and 3b, i.e. a top view of the can before its first opening in Fig. 12b and a cross section along line B – B in Fig. 12a. These standard cans have a larger drinking opening, as is clear when  
5 comparing the cap top 3 in Fig. 12b with the one in Fig. 3. Another difference is the larger distance between the rim 30 of the can end and the side wall 35 of the can. Due to this large distance, in order to close the can by pushing against the side wall 35, a very long protrusion 33 is required as shown in Fig. 13a and in Fig. 14b (which represent respectively a cross section along line C – C in the  
10 top view shown in Fig. 13b, and a 3D view of the can end and top portion of the can, from the bottom). A can end 2 having an elastic resilient element 10 with such a long protrusion 33 is more difficult to mount on a can body, as will be discussed further below. Further, when in a production line the can ends are transported, e.g. on a belt, to the station where they will be mounted on the can  
15 bodies, the long protrusions may become entangled and thus cause transportation problems. Therefore, it may be preferable to use an embodiment without protrusion, as shown in Figs. 12a and 12b, instead of the embodiment with protrusion, as shown in Figs. 13a, 13b, 14a and 14b. Such a can will then not be closed by pushing against the side wall, but it will be closed e.g. by  
20 tapping, as discussed above.

To reopen a can in accordance with the invention, a user may move the cap top in different ways, as mentioned already above. The cap top may be moved by moving the pull tab 4, as discussed already above. Figs. 15 and 16 show  
25 another embodiment of a can end, wherein the cap top 3 comprises a raised lip-contact portion 7 on its upper surface. By contacting the raised lip-contacting portion 7 with his lips, the consumer pushes the cap top down, and creates an opening, so that he can drink from the can. Functioning of such a lip-contacting portion is discussed and explained in detail in patent application  
30 PCT/EP2011/052078, filed by the same applicant as the present patent application, and incorporated herein by reference. Figs. 16a and 16b show an embodiment of a can having a raised lip-contact portion 7 and comprising a

protrusion 33 of the end of the bent-back portion of the elastic resilient element 10. Figs. 15a and 15b show another embodiment of a can having a raised lip-contact portion 7 and having no protrusion 33. The lip-contact portion 7 may be used to push the cap top 3 down far enough so that the shut-off valve 6 may be held by holding means 32, as explained above. It may also be used to push cap top 3 less far down, so that shut-off valve 6 closes, by the force of the elastic resilient element 10, when the pressure exerted on the lip-contact portion 7 is taken away. In another embodiment, a can end includes a raised lip-contact portion 7 but no holding means 32, so that the shut-off valve 6 is automatically closed when the consumer stops pushing the lip-contact portion 7 down, and this irrespective of the depth that the lip-contact portion was pushed down.

Mounting an embodiment of a can end 2 on a can body 1, wherein the can end 2 comprises an elastic resilient element 10 having a protrusion 33, is now discussed with reference to Figs. 17a and 17b, wherein Fig. 17b shows a detail of the area indicated in Fig. 17a. Only half of the can end 2 and the top portion of the can body 1 is shown; the front half is cut away. If the protrusion 33 sticks out further than the contour of the can end 2, the can end 2 may be held slightly inclined to mount the can end 2 on the can body 1, before it is attached to the can body 1. It is also possible to keep the can end horizontal during mounting, or to hold it at a smaller inclination angle, by means of an embodiment as shown in Figs. 17a and 17b. In this embodiment, a single staple 39 is used instead of the two staples 36 discussed above with reference to Figs. 9a and 9b. This single staple 39 attaches the cap top 3 to the can end 2 (which is also a function of the two staples 36) and additionally it forms a closed connection beneath the bent-back portion 5' of the elastic resilient element 10, as is also shown in Fig. 18, which is a 3D view of the bottom side of the elastic resilient element 10. Fig. 19a shows a 3D view of staple 39 and Fig. 19b shows a detail of the area indicated in Fig. 19b. In the embodiment shown in Fig. 18, the bent-back portion 5' now comprises two raised lips 40 that can interact with staple 39. Before mounting the can end 2 on the can body 1, the bent-back portion 5' can now be moved in the direction of arrow 70 on Figs. 17a and 18. The bent-

back portion 5' will then deform as shown by arrows 71 in Fig. 17a but, what is more important, the raised lips 40 will catch behind staple 39, as shown in Fig. 18 and in Fig. 17b. As shown in Fig. 17a by dotted line 50, the protrusion 33 now no longer sticks out further than the contour of the can end 2 (or, in some cases, it will stick out only slightly, and much less than was the case before).  
5 Can end 2 can now be mounted and attached much more easily to can body 1. When the can is opened for the first time, staple 39 is pushed downwards, analogously to the staples 36 as discussed above, and again staple 39 is long enough (in the direction approximately perpendicular to the cap top 3) so that  
10 the cap top 3 can still move slightly downwards or upwards. Moreover, staple 39 is long enough so that, when it is pushed downwards when the can is opened for the first time, the raised lips 39 move past staple 40 (in the direction opposite to the direction of arrow 70), so that the elastic resilient element can now function as explained hereinbefore; the position of the elastic resilient element  
15 10 in Fig. 17a is only for mounting purposes. Of course, instead of staple 39, other staple means as known in the art may be used.

When opening the can for the first time, the cap top 3 is torn off completely, as discussed hereinbefore. In a preferred embodiment, tearing off the cap top is  
20 done asymmetrically. This is now discussed with reference to Figs. 20 and 21, wherein Fig. 20 shows an embodiment of a can end 2 and the top portion of a can wherein the pull tab 4 is partially cut away. Tearing off the cap top asymmetrically avoids that, in case of complete symmetry with respect to the symmetry axis of the pull tab 4, the last portion of the cap top to be torn off,  
25 which is the zone 51 (Fig. 20) around this symmetry axis, is removed difficultly. Tearing off the cap top asymmetrically can be done in different ways. In one embodiment, an asymmetrically located embossment 54 as shown in Fig. 20 is provided in the cap top 3. There is only a single embossment 54 (at the side of the cap top 3 where the not cut-away portion of the pull tab 4 is shown, there is  
30 no embossment). Because of this asymmetrically located embossment 54, when opening the can for the first time, the pull tab 4 will exert different forces on the side of the cap top 3 located to the left of zone 51 and on the side of the

cap top 3 to the right of zone 51, which causes the cap top to be torn off asymmetrically. In another embodiment, the elastic resilient element 10 is asymmetric. Fig. 21 shows such an embodiment. The elastic resilient element 10 in this drawing is still flat, i.e. portion 5' of spring means 5 is not yet bent backwards. In the shown embodiment, shut-off valve 6 is coupled to spring means 5 by elastic coupling means 13 and 13' that have asymmetric elastic properties. In the embodiment of Fig. 21, both coupling means 13 and 13' are narrow, elastic strips, but strip 13' is longer than strip 13 and is attached to shut-off valve 6 in such a way that the attachment zone is on a radius through the center of the, circular, shut-off valve 6. Because of the asymmetric elastic properties, the cap top will be torn off asymmetrically. This embodiment may be combined with the asymmetrically located embossment shown in Fig. 20.

Elastic resilient element may be a plate-like element. It is advantageous to use very thin plate, having a thickness of 0.25 mm or smaller, preferably 0.20 mm or smaller, more preferably 0.15 mm or smaller. The elastic resilient element then weighs only 1.5 g to 2 g. Such a small weight is important to keep the total weight of the can as low as possible. In the embodiment of the elastic resilient element shown in Fig. 22, the width of the spring means 5 is preferably 6 to 8 mm, but other dimensions are also possible. In order to have good elastic properties for the spring means 5, it has a strengthened portion 53 in the shown embodiment (in Fig. 22, the strengthening bulge points "outwards", of course it may also point in the opposite direction, i.e. "inwards").

Fig. 23 shows another embodiment of an elastic resilient element 10 (wherein a portion of spring means 5 is bent backwards). In this embodiment, shut-off valve 6 has a plurality of incisions 56 around its circumference (only a portion of seal 19 is shown; the rest is cut away to show the incisions). An advantage of these incisions is that they make the shut-off valve 6 more flexible at the location of seal 19, so that seal 19 will fit even better to the can end 2. An alternative to these incisions is to make the shut-off valve 6 thin enough, as discussed above. Of course also a thin shut-off valve may comprise incisions.



In Figs. 24a and 24b, an embodiment of an elastic resilient element 10 (that is still flat) is shown that has braking means, or damping means, 55. When the shut-off valve 6 is being closed, the braking means 55 drag against the portion 59 of elastic resilient element 10, thus slowing down closing of the shut-off valve 6. This slowing down helps avoiding splashing of the content of the can during closing; it is not impossible that otherwise splashes might occur, depending on the type of the content and on the geometry and the material properties of the parts of the can end.

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Figs. 25a and 25b show an embodiment of a can having an additional locking feature, which is useful to transport a can that was already opened and that still contains a part of its contents. Fig. 25b shows a top view of the can end and the top portion of the can, and Fig. 25a shows a cross section along line D – D in Fig. 25b. With respect to its normal position, pull tab 4 was rotated over 180° in the direction of arrow 72. In this embodiment, can end 2 has at least one small groove 57, and pull tab 4 has at least one protuberance 58 fitting in this at least one groove. The pull tab 4 is thus locked in the shown position, and it is now possible to take away the can, that still contains part of its content, in a bag, e.g. a ladies' bag, and being sure that the can will not be opened inadvertently, e.g. by contact with other items present in the bag, which could otherwise spill the content of the can.

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Fig. 26 shows a stack of can ends 2 according to one embodiment of the invention. Each can end 2 comprises an elastic resilient element 10. The elastic resilient elements 10 in the can ends 2 have a small total thickness, that is preferably smaller than 2 mm, more preferably smaller than 1 mm, even more preferably smaller than 0,5 mm, so that the can ends can be stacked one on top of the other one, as shown in Fig. 26. The total thickness of an elastic resilient element 10 is the maximum dimension of the elastic resilient element in the direction perpendicular to the plane through the cap top 3 (see Fig. 3a) of can end 2, when the elastic resilient element 10 is mounted on the can end 2,

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as shown in Fig. 26, and as also shown e.g. in Fig. 3a. The stack of can ends 2 preferably requires only as much space as a stacked set of traditional can ends.

Fig. 27 shows a top view of an embodiment of an elastic resilient element 10 in accordance with the invention, that may be used in the can ends 2 shown in Fig. 26. In Fig. 27, the elastic resilient element is not yet folded. Preferably, and similarly to the embodiments of elastic resilient elements discussed above, the elastic resilient element 10 comprises holding means, not shown in Fig. 27, for holding shut-off valve 6 in an opened position, as discussed above. In the shown embodiment the elastic resilient element comprises a plate spring means 95, made e.g. from steel. E.g. stainless austenitic steel 1.4310 C1300 may be used, having a thickness of 0.2 mm, or 0.15 mm, or 0.10 mm, or 0.05 mm. Other materials having good resilience properties and good plasticity (for folding, as discussed below), and other thicknesses, may be used as well.

Figs. 28a and 28b show a top and a bottom view of the elastic resilient element 10 of Fig. 27, when folded. In one embodiment, wherein steel 1.4310 C1300 having a thickness of 0.1 mm is used, the folded elastic resilient element has a total thickness of only about 0.2 mm, thanks to the good plasticity of the material.

In some embodiments of the invention, the pressure relief valve 8, which was discussed above with reference to Figs. 10a and 10b, may be simplified. If e.g. an elastic resilient element as discussed with respect to Figs. 28a and 28b is used, in some embodiments the bulging portion 25 of cap top 3 (see Figs. 10a and 10b) may be very small, and hole 26 of shut-off valve 6 may be omitted. If the total thickness of the elastic resilient element 6 is small enough, e.g. approximately 0,2 mm, the bulging portion 25 may also be omitted. Thanks to the small resilient force of the elastic resilient element 10, when re-opening the can, the cap top moving downwards locally creates a small opening that relieves the pressure in the can.

Fig. 29 shows an embodiment of an intermediate element 80 as may be used in embodiments according to the invention. The intermediate element 80 may be positioned between an elastic resilient element 10 and a can end 2, and may be used to attach the elastic resilient element. Fig. 30 shows an embodiment of an intermediate element 80 attached to a can end 2. The intermediate element may e.g. be attached by means of an adhesive. Fig. 31 shows an elastic resilient element 10 being assembled to an intermediate element 80. Both elements may be riveted to each other, using a rivet through opening 81 of intermediate element 80 and opening 91 of elastic resilient element 10, and a rivet through opening 82 of intermediate element 80 and opening 92 of elastic resilient element 10. Fig. 32 shows an embodiment of an assembly of an elastic resilient element 10 and an intermediate element 80, mounted in a can end 2. For the intermediate element, e.g. a stainless steel having good elongation properties may be used. The intermediate element may have a thickness of e.g. 0,05 mm or 0,1 mm, but other thicknesses are possible as well. Using an intermediate element may have several advantages. The elastic resilient element may be riveted to the intermediate element, which may be attached to the can end by means of an adhesive, so that no rivets through the can end are required. The intermediate element may support the can end, and it may support the elastic resilient element as well. Further, using an intermediate element may offer more flexibility.

Figures 33 to 40 illustrate other embodiments of a can end in accordance with the invention, that include a raised lip-contact portion and that moreover can be stacked onto each other. These can ends comprise an elastic resilient element that preferably has a small total thickness, as discussed already above.

Fig. 33a and 33b show a top view respectively a bottom view of such an embodiment of a can end 2 having a raised lip-contact portion 7. Figs. 33a and 33b are similar to Figs. 1a and 1b but now additionally show the raised lip-contact portion 7. A raised lip-contact portion 7a of the elastic resilient element 10 fits in the raised lip-contact portion 7 of the can end 2, as is discussed with

reference to Fig. 35b further below; imprint 7c is used to clamp portion 7a in portion 7, as discussed below.

Holding means 32, as discussed with reference to Figs. 1a and 1b may be present or, in other embodiments, is absent; in Figs. 33 to 40 holding means 32 are not explicitly shown.

The elastic resilient element 10 shown in Fig. 33b has an extended portion 14 that extends underneath a rim 30 of the can end 2, in such a manner that a contact will occur between the extended portion 14 and the rim 30 when internal pressure deforms the can, e.g. due to high temperature, as discussed already above; extended portion 14 then acts as a security pressure relief, as discussed above.

Figs. 34a and 34b show an embodiment of an elastic resilient element 10 used in the embodiment of Figs. 33a and 33b. Fig. 34a shows the elastic resilient element 10 before it is folded; Fig. 34b shows the elastic resilient element 10 after it is folded along folding line LL.

Figs. 35a shows a 3D view an embodiment of an assembly including the elastic resilient element 10 of Figs. 34a and 34b, while Fig. 35b is a side view and cross section of this assembly. As can be seen in Fig. 35b, the raised lip-contact portion 7a of the elastic resilient element fits in a raised lip-contact portion 7 of the can end. Portion 7a is clamped in portion 7, by means of an imprint 7c, but the tolerances are such that both portions fit with a certain play, so that pressure relief valve 8 can function adequately. As discussed already above, a simplified version of the pressure relief valve may be used, if the total thickness of the elastic resilient element is small enough.

Fig. 36a shows a side view and cross section of an embodiment of the invention, discussed with reference to Figs. 33 to 35, for a so called "Standard End" can end 2 from Crown, today Crown Holding Inc. Such a "Standard End" is

customarily used nowadays. Fig. 36b shows a side view and cross section of an embodiment of the invention for a SuperEnd™ can end 2 from Crown Holding Inc, which is a new type of can end.

5 In some embodiments of the invention, the can ends 2 may be stacked one on top of the other, as discussed already above; the shape and dimensions of the can ends are then such that they may be stacked. Fig. 37 shows a stack of "Standard End" can ends 2 as shown in Fig. 36a, while Fig. 38 shows a stack of SuperEnd™ can ends 2; in both cases, each can end 2 has a first side 101 and  
10 a second side 102 opposite to the first side, wherein the second side 102 is adapted for receiving a first side 101 of another identical can end 2. One of the advantages of SuperEnd™ can ends 2 is that a stack of can ends 2 is not necessarily straight: as shown in Fig. 38, in a stack of can ends 2 having a height A, the uppermost can end may be translated over a distance B with  
15 respect to the lowermost can end. This fact may be used advantageously in the production phase, when stacks of can ends are transported.

Fig. 39 shows an embodiment of an intermediate element 80, as discussed already above, that may be used with the embodiment of the resilient element  
20 10 shown in Figs. 33 to 38, while Fig. 40 shows an exploded view of an assembly including this intermediate element 80. In the embodiment of Fig. 40, the elastic resilient element 10 comprises two different parts, part 10a and part 10b. The two parts are as shown in the elastic resilient element 10 of Fig. 34a, when this single element is cut along folding line LL.

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An advantage of having an elastic resilient element of two parts is that the two parts may be made from different materials. Part 10b, that contains the raised lip-contact portion 7a, may be made e.g. from a steel allowing a high plastic deformation, while part 10a may e.g. be made from a stainless austenitic steel  
30 as discussed already above.

Intermediate element 80 may contain two nipples 85, 86 and/or a fold 87. The intermediate element 80 may be attached to can end 2 by an adhesive. In one embodiment, wherein an elastic resilient element 10 out of a single piece is used, it may be attached to the intermediate element 80 via nipples 85 and 86.

- 5 In another embodiment, wherein an elastic resilient element 10 having two parts 10a and 10b is used, both parts 10a and 10b may be clamped to the intermediate element 80 via fold 87.

- 10 The present invention is not limited to the embodiments described above. The scope of the present invention is defined by the appended claims.

**[CLAIMS]**

1. A can end (2) for a metal beverage can optionally for carbonated drinks, said can end comprising:
  - 5 - a cap top (3), arranged in connection to a pull tab (4) configured to remove said cap top from said can end along a pre-defined groove (9), to thereby create a drinking or pouring aperture;
  - an elastic resilient element (10) attached to the can end; and
  - 10 - a resiliently operated shut-off valve (6) that is part of or is connected to said elastic resilient element (10) and that is configured to seal the drinking or pouring aperture after drinking or pouring;wherein said cap top (3) is configured to remain located, after said removal, on top of said shut-off valve (6).
- 15 2. Can end according to claim 1 wherein said elastic resilient element (10) has holding means (32) for holding said shut-off valve (6) in an opened position upon moving said cap top (3).
3. Can end according to claim 2 wherein said holding means (32) is for holding  
20 said shut-off valve (6) in said opened position upon moving said cap top (3) by said pull tab (4).
4. Can end according to any one of claims 1 to 3 wherein said cap top (3) has an upper surface and comprises a raised lip-contact portion (7) on said  
25 upper surface.
5. Can end according to claim 4 wherein said holding means (32) is for holding said shut-off valve (6) in said opened position upon moving said cap top (3) by said raised lip-contact portion (7).
- 30 6. Can end according to any one of claims 1 to 5 wherein said shut-off valve (6) comprises a relief valve (8), actuatable by interaction with said cap top

(3) and configured to release gas pressure from inside the can, upon the first pressure exerted on said relief valve (8).

- 5 7. Can end according to any one of claims 1 to 6 wherein said holding means is configured to release said shut-off valve (6), when in said opened position, so as to close and seal said drinking or pouring aperture, by upsetting or dropping a can comprising said can end.
- 10 8. Can end according to any one of claims 1 to 6 wherein said holding means is configured to release said shut-off valve (6), when in said opened position, so as to close and seal said drinking or pouring aperture, by exertion of a force on an element selected from the group of said elastic resilient element (10), said shut-off valve (6), said cap top (3).
- 15 9. Can end according to claim 8 wherein said force is exerted by a user of said can.
- 20 10. Can end according to claim 9 wherein said exertion of said force is a tapping by said user against said can.
- 25 11. Can end according to any one of claims 1 to 10 wherein said shut-off valve (6) comprises first engaging means (31) and wherein said holding means (32) comprises second engaging (32) means for engaging said first engaging means (31).
- 30 12. Can end according to claim 11 wherein said first engaging means (31) is a hook means (31).
13. Can end according to any one of claims 1 to 12 wherein said shut-off valve (6) has a circumference and comprises a seal (19) around said circumference.



14. Can end according to any one of claims 1 to 13 wherein said elastic resilient element (10) comprises brake means (55) for slowing down closing of said shut-off valve (6).
- 5 15. Can end according to any one of claims 1 to 14 wherein said elastic resilient element (10) has a total thickness smaller than 2 mm.
16. Can end according to claim 15 wherein said elastic resilient element (10) has a total thickness smaller than 1 mm.
- 10 17. Can end according to claim 16, wherein said elastic resilient element (10) has a total thickness smaller than 0,5 mm.
18. Can end according to any one of claims 15 to 17 wherein said elastic resilient element comprises a plate spring means (95).
- 15 19. Can end according to any one of claims 1 to 18 further comprising an intermediate element (80) between said elastic resilient element (10) and said can end.
- 20 20. Can end according to any one of claims 1 to 19 wherein said elastic resilient element (10) has an extended portion (14), extending underneath a rim (30) of the can end, in such a manner that a contact occurs between said extended portion (14) and said rim (30) when internal pressure deforms said can end, said contact actuating opening of said relief valve (8).
- 25 21. Can end according to any one of claims 1 to 20 wherein said can end has a first side (101) and a second side (102) opposite to said first side (101), wherein said second side (102) is adapted for receiving a first side (101) of an identical can end for forming a stack of can ends.
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22. Can end according to any one of claims 1 to 14 wherein said elastic resilient element (10) comprises a spring means (5) that includes a bent-back portion (5') having an end (5'''), said elastic resilient element (10) being configured for biasing said shut-off valve (6) against an underside of said can end (2), wherein said end (5''') of said bent-back portion (5') is itself biased against an underside of said shut-off valve (6), and wherein said relief valve (8) comprises :
- a relief opening (26) of said the shut-off valve (6);
  - a seal element (27) attached to said end (5''') of said bent-back portion (5') and arranged to close said relief opening (26) when the can is not in use; and
  - a bulging portion (25) of the cap top (3), configured to be positioned above said relief opening (26), in such a manner that upon first contact pressure, the bulging portion (25) pushes the seal element (27) away from the relief opening (26), thereby decreasing an inner pressure from an inside of the can.
23. Can end according to claim 22 wherein said can has a side wall (35) and wherein said elastic resilient element (10) comprises a protrusion (33) extending, when said can end is attached to said can, towards said side wall (35), so as to allow said user to push against said side wall (35) for said exertion of said force on said elastic resilient element (10).
24. Can end according to claim 23 wherein said bent-back portion (5') has a curved portion (5'') for being stretched for moving said protrusion (33) towards said side wall (35) of said can upon moving said shut-off valve (6) towards said opened position.
25. Can end according to any one of claims 22 to 24, wherein said bent back portion (5') has an extended portion (14), extending underneath a rim (30) of the can end, in such a manner that a contact occurs between said extended portion (14) and said rim (30) when internal pressure deforms

said can end, said contact actuating opening of said relief opening (26).

26. Can end according to any one of claims 22 to 25 wherein said spring means (5) is a plate spring (5).

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27. Can according to claim 26 wherein said plate spring (5) has a strengthened portion (53).

28. Can end according to any one of claims 22 to 27 wherein said shut-off valve (6) is coupled to said spring means (5) by elastic coupling means (13, 13').

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29. Can end according to claim 28 wherein said elastic coupling means (13, 13') has asymmetric elastic properties.

15 30. A metal beverage can optionally for carbonated drinks, comprising a can body (1) and a can end (2) according to any one of claims 1 to 29.

31. A method for producing the can according to claim 30, the method comprising the steps of:

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- producing a can end (2) according to any one of claims 1 to 29;
- producing the can body (1);
- attaching the can end to the can body.

25 32. A method for using a reclosing metal beverage can, optionally for carbonated drinks, said can comprising a can body (1) and a can end (2), the method comprising the steps of:

- actuating a pull tab (4) of said can end (2), thus removing a cap top (3) of said can end (2) along a predetermined groove (9) of said can end, thus creating a drinking or pouring aperture;
- 30 - resiliently opening, by said actuating said pull tab (4), a shut-off valve (6) that is part of or is connected to an elastic resilient element (10) of said can end and that is configured to seal said drinking or pouring aperture

after drinking or pouring, wherein said removed cap top (3) remains located on top of said shut-off valve (6).

- 5 33. Method according to claim 32 further comprising holding said shut-off valve (6) in an opened position by said elastic resilient element (10).
- 10 34. Method according to claim 33 further comprising engaging a first element (31) of said shut-off valve (6) with a second element (32) of said elastic resilient element (10), thus holding said shut-off valve (6) in said opened position.
- 15 35. Method according to any one of claims 32 to 34 further comprising exerting a force on said elastic resilient element (10) or on said shut-off valve (6) or on both said elastic resilient element (10) and said shut-off valve (6), when said shut-off valve (6) is in said opened position, thus releasing said shut-off valve (6) from said elastic resilient element (10) and thus closing said drinking or pouring aperture.
- 20 36. Method according to claim 35 wherein said exerting said force comprises tapping against said can, thus releasing said shut-off valve (6) from said elastic resilient element (10) and thus closing said drinking or pouring aperture.
- 25 37. Method according to claim 35 wherein said exerting said force comprises pushing against a side wall (35) of said can, thus pushing against a protrusion (33) of said elastic resilient element (10), thus releasing said shut-off valve (6) from said elastic resilient element (10) and thus closing said drinking or pouring aperture.
- 30 38. Method according to any one of claims 35 to 37 further comprising re-actuating said pull tab (4), thus reopening said shut-off valve (6), and holding said shut-off valve (6) in said opened position, thus reopening said

can.

39. Method according to any one of claims 35 to 37 further comprising contacting a raised lip-contacting portion (7) on an upper surface of said cap top (3), thus reopening said shut-off valve (6) and thus reopening said can.

40. Method according to claim 38 or claim 39 further comprising actuating a relief valve (8), thus releasing gas pressure inside said can, before said reopening said shut-off valve (6).

41. Method according to any one of claims 35 to 40 further comprising deforming said can end (2), thereby contacting an extended portion (14) of said elastic resilient element (10) by a rim (30) of said can end (2) and thereby opening a relief opening (26) of said shut-off valve (6).

42. Method according to claim 41 further comprising heating said can, thus deforming said can end (2).