(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau

(43) International Publication Date
12 June 2008 (12.06.2008)

PCT

(10) International Publication Number
WO 2008/068169 A1

(51) International Patent Classification:
*B21D 51/26* (2006.01) *B21D 22/30* (2006.01)

(21) International Application Number:
PCT/EP2007/062886

(22) International Filing Date:
27 November 2007 (27.11.2007)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
0624337.2 6 December 2006 (06.12.2006) GB

(71) Applicant *(for all designated States except US)*: **CROWN PACKAGING TECHNOLOGY, INC** [US/US]; 11535 S.Central Avenue, Alsip, Illinois 60803-2599 (US).

(72) Inventor; and
(75) Inventor/Applicant *(for US only)*: **DAVIES, Mark** [GB/GB]; The Close, West Street, Childrey Oxfordshire OX12 9UL (GB).

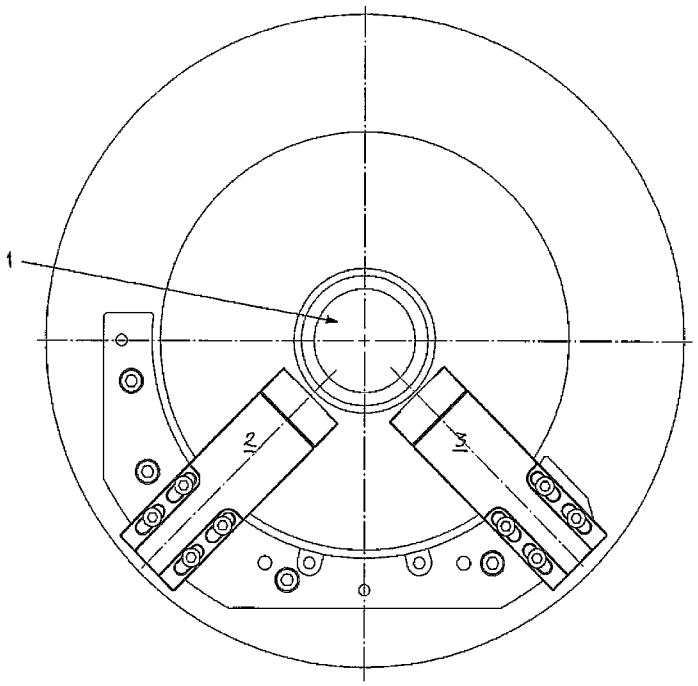
(74) Agent: **RATLIFF, Ismay**; Downsview Road, Wantage Oxfordshire OX12 9BP (GB).

(81) Designated States *(unless otherwise indicated, for every kind of national protection available)*: AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BH, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RS, RU, SC, SD, SE, SG, SK, SL, SM, SV, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States *(unless otherwise indicated, for every kind of regional protection available)*: ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, LV, MC, MT, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

**Published:**
— *with international search report*

(54) **Title:** DETECTOR SYSTEM FOR FIXING TO A CAN BODYMAKER AND METHOD TO DYNAMICALLY MEASURING RAM ALIGNMENT IN A CAN BODYMAKER




(57) **Abstract:** A real time detector system for monitoring ram alignment in a can bodymaker measures ram (10) position immediately before and during impact with the dome forming station (1). Displacement measurements of the ram enable the user to adjust dome (1) position or otherwise correct ram (10) alignment and avoid multiple can failures.

WO 2008/068169 A1

DETECTOR SYSTEM FOR FIXING TO A CAN BODYMAKER AND METHOD TO DYNAMICALLY MEASURING RAM ALIGNMENT IN A CAN BODYMAKER

## Description

### Technical Field

[0001] This invention relates to the alignment of a ram in a can bodymaker. In particular it relates to the alignment of the ram as it contacts a station for forming a dome in the base of a so-called "two-piece" can such as are in common use for the packaging of beverages.

### Background Art

[0002] In the manufacture of two piece cans, a punch on a bodymaker ram is used to push a drawn metal cup through wall ironing dies in order to iron the side wall and make a taller can. After passing through dies, the punch carries the drawn and wall ironed can into contact with a doming station.

[0003] Although the ram is supported in bearings, alignment of the ram will vary due to friction and wear. In addition, vibration of a high speed reciprocating ram means that the can still does not always contact the doming station in a fully concentric and aligned position.

[0004] Undesirable vibration of the ram will arise not only due to the variable 'droop' of the cantilever supported ram as it moves towards and back from its fully extended position, but also due to the impact of the can at the dome forming station.

[0005] Misalignment of the ram/punch when it carries a can into contact with the doming station will ultimately lead to split domes, particularly in aluminium cans. When the ram is only slightly misaligned, an arcuate split (referred to hereinafter as a 'smile') in the base of the can could arise which subsequently may result in burst cans at the fillers or customer. Base faults like smiles are not easily detectable by the naked eye during manufacture.

[0006] This invention seeks to provide an apparatus for detecting base defects such as split domes during manufacture and for measuring ram alignment dynamically.

### Disclosure of Invention

[0007] According to the present invention, there is provided a detector system for fixing to a can bodymaker, the detector comprising: at least two sensors

for measuring the amplitude of ram displacement both directly adjacent a doming station and during contact with the dome station; and means for converting the amplitude data into real time alignment measurements, whereby dynamic tracking and likelihood of fault development in can dome profile is assessed.

[0008] Unlike previous alignment measuring systems, the system of the invention is not only dynamic but also monitors ram alignment at the fully extended ram position where the most extreme misalignment is likely to occur due to the cantilever nature of ram support and the vibration associated with high speed bodymakers and impact of the punch in the dome station.

[0009] The detector system may use sensors which are positioned at 90° to each other. As a result of this positioning, the sensors provide an X-axis and Y-axis displacement measurement.

[0010] In the detector system, there may be an array of sensors around the fully extended position of the ram, adjacent the dome forming station. In this alternative detector system, arrangement of the sensors can be regularly (or irregularly) spaced, and provide not only 0° and 90° but also other angular displacement measurements, such as 180° and 270°. The limiting factor of routing cables may be overcome if, for example, radio or other remote signalling sensors are used.

[0011] Ideally, the detector system further comprises means for analysing ram displacement data and determining the likelihood of 'smiles' or split domes. Typically analysis is achieved by software which provides the user with likelihood of ‘smiles’ or splits in real time, in contrast with known manual/visual can monitoring. Slight misalignment which could result in ‘smile’ production is not reliably visible by the naked eye, especially if the person carrying out the assessment is tired.

[0012] The detector system may further comprise means for adjusting lateral dome station position to centralise the impact target of the ram in the dome station. This adjustment was previously done as a result of any visible misalignment but without quantifiable data was at best a rough correction to the dome station position. Even where the means for adjusting the dome position with the present invention is manual, it can be

carried out based on real data as described below. Ideally, however, the correction can be achieved by mechanical means such as by adjustable bolt position.

[0013] According to a further aspect of the present invention, there is provided a method of dynamically measuring ram alignment in a can bodymaker, the method comprising: measuring ram displacement immediately adjacent a doming station; measuring ram displacement during contact between a can carried on the ram and the dome station; converting the amplitude data into real time alignment measurements; and assessing faults and likelihood of fault development in the can dome profile. The method may also include steps corresponding to the additional apparatus features described above.

## Brief Description of Drawings

[0014] A preferred embodiment of the invention will now be described, by way of example only, with reference to the drawings, in which:

Figure 1 is a schematic longitudinal view of a dome station and a detector system according to the invention;

Figure 2 is a schematic perspective view of a ram carrying a can in the dome forming station;

Figure 3 is a view corresponding to that of figure 2, showing the sensors and ram displacement data;

Figure 4 is a view corresponding to that of figure 3, also showing ram displacement data; and

Figure 5 is a schematic target showing multiple dome contact positions corresponding to ram misalignment,

## Mode(s) for Carrying Out the Invention

[0015] Figure 1 shows a can dome forming station 1 with sensor mounts 2 and 3. Sensors are conventional positional sensors which are mounted in the ends of mounts 2 and 3. These provide X and Y data so as to evaluate ram displacement at 90° to each other and immediately adjacent the bottom or dome forming position.

[0016] In figure 2, the ram 10 has passed through the wall ironing dies and a

stripping die 12 to its fully extended position. The ram 10 is carrying a can 20 into the doming station 1. After the dome has been formed, the ram is retracted through the dies and the can is removed from the punch by stripper 12.

[0017] The sensors 2 and 3 are shown schematically in figure 3 with the arrows indicating real time measurement taken for ram position. In this example, the sample graphs show ram displacement position in X-axis and Y-axis positions respectively before contact with the dome station.

[0018] In figure 4, a like view to that of figure 3 is shown but with the continuous measurements showing both before entering the dome station (left hand arrows) and while within the dome station forming a dome in the base of the can (right hand arrows). As can be clearly seen from the right hand graph, there has been misalignment in the Y-axis graph, as indicated by the step change and the arrows below the ram.

[0019] The target picture of figure 5 gives a visual of how the base of the can contacts the doming station in a series of base forming operations. The cluster of can impact points indicates that there is a small misalignment in the 0° direction. The bold circles on the target show positions which would need immediate correction: where impact with the dome station occurs between the concentric circles, 'smiles' are likely to occur. These have been particularly difficult or impossible to detect by eye alone in the past. The catastrophic failure of split domes arises outside the outer circle. In the past, split dome failures have in fact been more readily detected by eye in the factory than were ‘smiles’ and so the occurrence of ‘smiles’ has been a major issue which affected cans in the market.

[0020] The detector system of the present invention is particularly cost-effective and can be developed to provide multiple axis data in real time.

## Claims

1. A detector system for fixing to a can bodymaker, the detector comprising:
   at least two sensors for measuring the amplitude of ram displacement both directly adjacent a doming station and during contact with the dome station; and
   means for converting the amplitude data into real time alignment measurements;
   whereby dynamic tracking and likelihood of fault development in can dome profile is assessed.
2. A detector system according to claim 1, in which the sensors are positioned at 90° to each other and provide an X-axis and Y-axis displacement measurement.
3. A detector system according to claim 1 or claim 2, in which the detectors comprises an array of sensors around the fully extended position of the ram, adjacent the dome forming station.
4. A detector system according to any one of claims 1 to 3, further comprising means for analysing ram displacement data and determining the likelihood of 'smiles' or split domes.
5. A detector system according to any one of claims 1 to 4, further comprising means for adjusting lateral dome station position to centralise the impact target of the ram in the dome station.
6. A method of dynamically measuring ram alignment in a can bodymaker, the method comprising:
   measuring ram displacement immediately adjacent a doming station;
   measuring ram displacement during contact between a can carried on the ram and the dome station;
   converting the amplitude data into real time alignment measurements; and
   assessing faults and likelihood of fault development in the can dome profile.

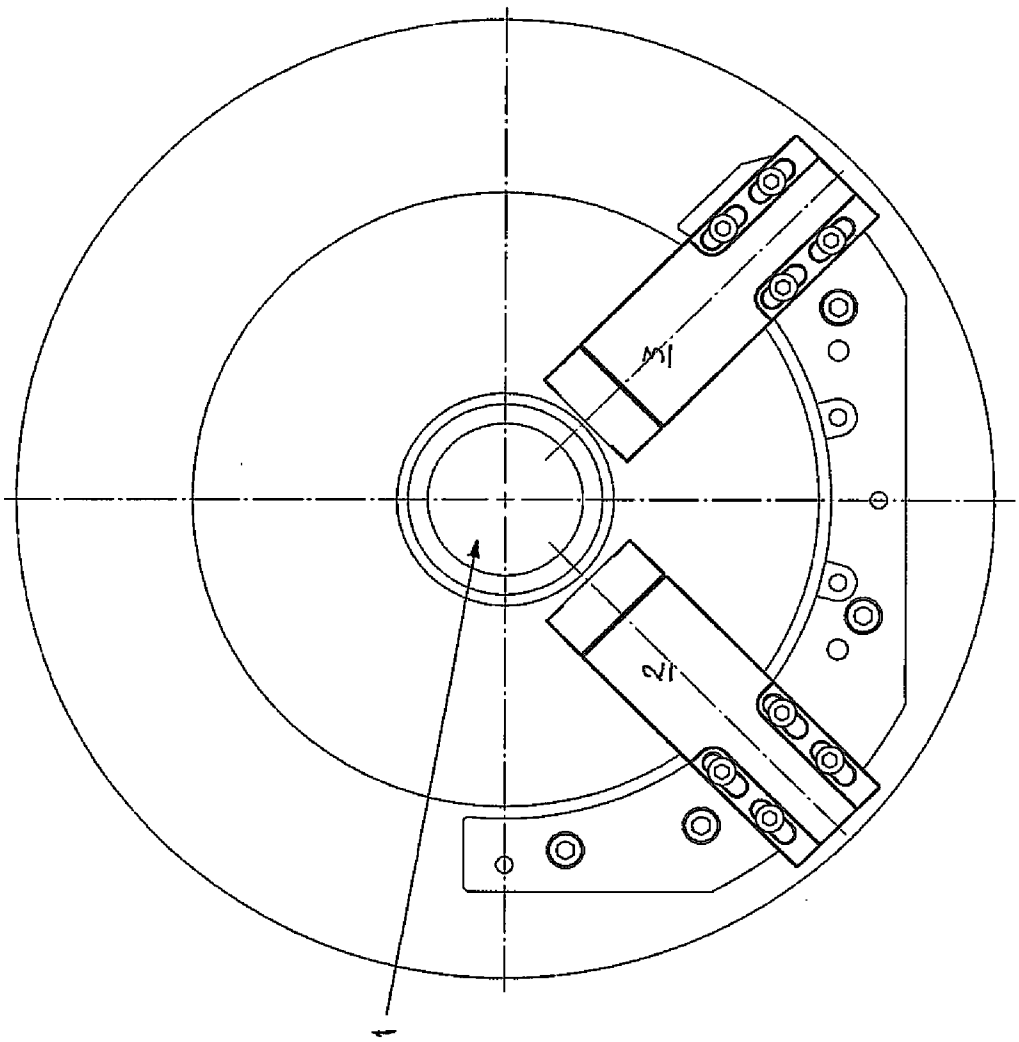


Fig. 1

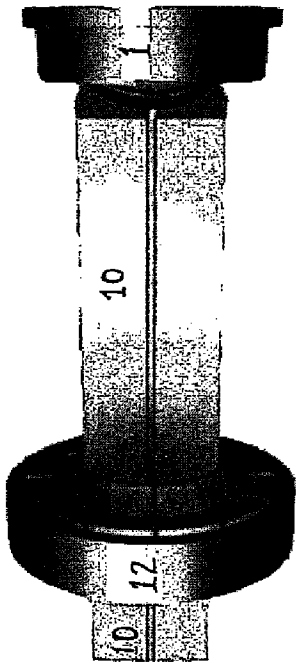



Fig. 2

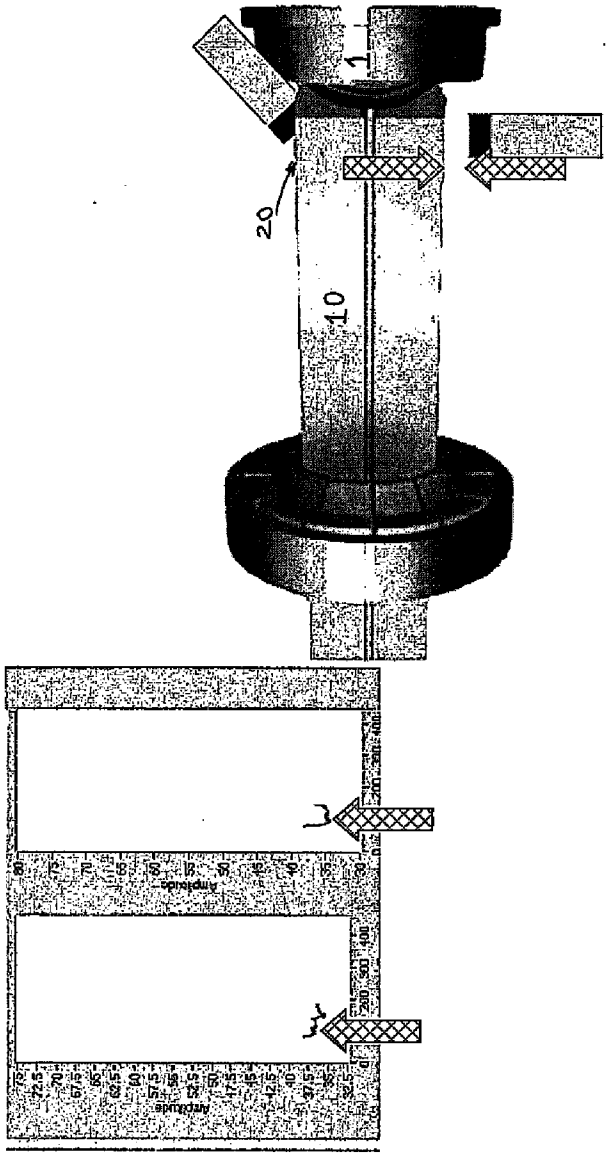



Fig. 3

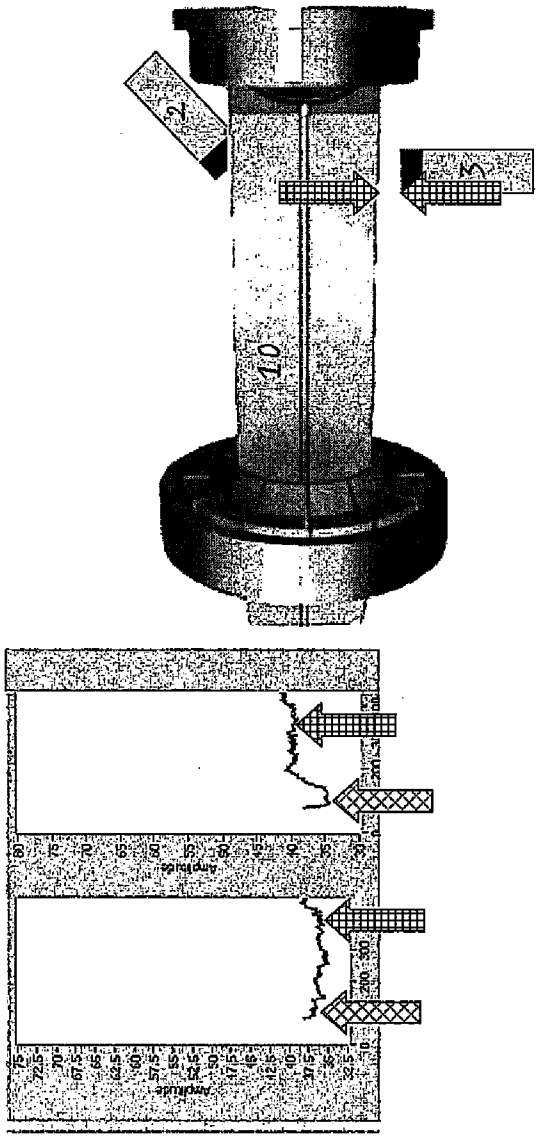



Fig. 4

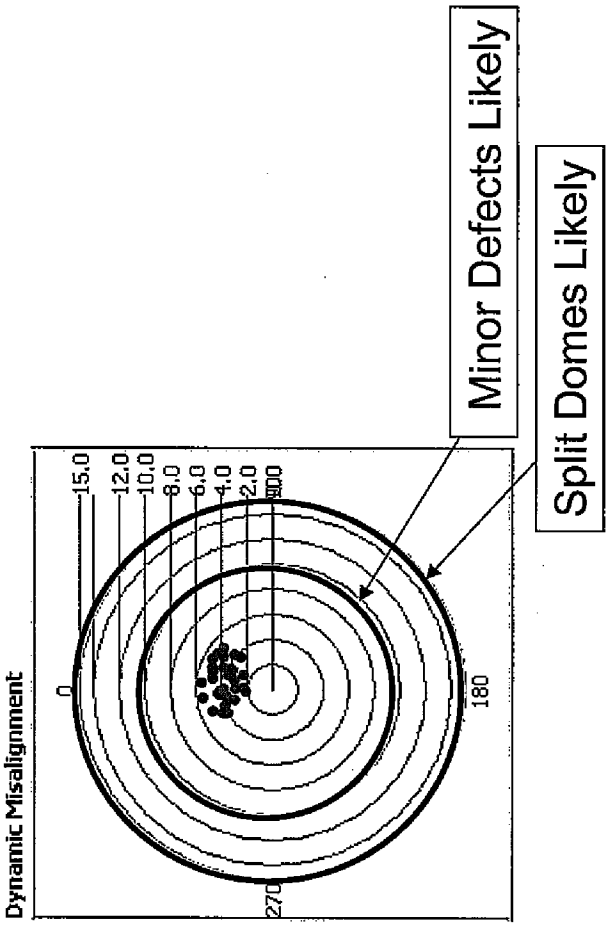

Minor Defects Likely
Split Domes Likely
Dynamic Misalignment
15.0
12.0
10.0
8.0
6.0
4.0
2.0
0
180
270

Fig. 5

# INTERNATIONAL SEARCH REPORT

International application No
PCT/EP2007/062886

A. CLASSIFICATION OF SUBJECT MATTER
INV. B21D51/26 B21D22/30

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
B21D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)
EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

| Category* | Citation of document, with indication, where appropriate, of the relevant passages | Relevant to claim No. |
|---|---|---|
| X | US 5 154 075 A (HAHN ROGER A [US] ET AL)<br>13 October 1992 (1992-10-13)<br>column 3, line 37 - column 4, line 22;<br>figures 1-4,6-9<br>column 5, line 47 - column 6, line 8<br>column 7, line 9 - line 26 | 1-6 |
| X | US 5 357 779 A (HAHN ROGER A [US] ET AL)<br>25 October 1994 (1994-10-25)<br>column 6, line 64 - column 7, line 8;<br>claim 1; figures 1-4,6-8,10-13,15,17,22,23 | 1-6 |
| X | US 5 212 977 A (STUART KEITH O [US])<br>25 May 1993 (1993-05-25)<br>abstract; claims 1,3-5,7; figures 1-3 | 1-6 |

☐ Further documents are listed in the continuation of Box C.

☒ See patent family annex.

* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier document but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"&" document member of the same patent family

| Date of the actual completion of the international search | Date of mailing of the international search report |
|---|---|
| 14 February 2008 | 28/02/2008 |

| Name and mailing address of the ISA/ | Authorized officer |
|---|---|
| European Patent Office, P.B. 5818 Patentlaan 2<br>NL - 2280 HV Rijswijk<br>Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,<br>Fax: (+31-70) 340-3016 | CANO PALMERO, A |

# INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No
PCT/EP2007/062886

| Patent document cited in search report | Publication date | Patent family member(s) | Publication date |
|---|---|---|---|
| US 5154075 A | 13-10-1992 | NONE | |
| US 5357779 A | 25-10-1994 | NONE | |
| US 5212977 A | 25-05-1993 | US 5325699 A | 05-07-1994 |
| | | US 5307665 A | 03-05-1994 |