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(54) **Title:** A CAPSULE, A SYSTEM FOR PREPARING A POTABLE BEVERAGE FROM SUCH A CAPSULE AND USE OF SUCH A CAPSULE IN A BEVERAGE PREPARATION DEVICE

(57) **Abstract:** A capsule containing a substance for the preparation of a beverage by supplying a fluid under pressure into the capsule. The capsule has an aluminum capsule body with an outwardly extending flange and a cover sheet attached to the flange and hermetically closing off the capsule. A deformable sealing ring portion of the flange projects axially from base portions of the flange, to which said cover is attached. The deformable sealing ring portion has an inner wall portion extending from and contiguous with an inner base portion of the flange, an outer wall portion extending from and contiguous with an outer base portion of said flange and a bridge portion interconnecting the inner wall portion and the outer wall portion. The bridge portion is located axially spaced from the base portions of the flange. A support member is arranged between the inner and outer wall portions.



Title: **A capsule, a system for preparing a potable beverage from such a capsule and use of such a capsule in a beverage preparation device**

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The invention relates to a capsule containing a substance for the preparation of a potable beverage by extracting and/or dissolving the substance by means of supplying a fluid under pressure into the capsuler.

10 The invention also relates to a system for preparing a potable beverage from a capsule using a fluid supplied under pressure into the capsule and to a use of such a capsule.

Such a capsule, such a system and such a use are known from EP-B-1 700 548, which discloses a capsule provided with a sealing structure having the shape of a step, i.e. a sudden increase of the diameter of the
15 sidewall of the capsule, and the enclosing member of this known system has a sealing surface acting on the sealing structure to provide deflection of the sealing structure, the sealing surface being inclined so that the deflection of the sealing structure is an inwards and downwards deformation of the step. Furthermore in the known system the enclosing member comprises a
20 capsule holder and a manually operated or an automatic mechanism for relative displacement of the enclosing member and the capsule holder. The manually operated or automatic mechanism applies a force on the sealing structure of the capsule when the enclosing member closes on the capsule holder. This force should ensure the fluid tight seal between the enclosing
25 member and the capsule. Because the manually operated or automatic mechanism is arranged to be moved relative to the base, the sealing capabilities of the system can depend on the pressure of the fluid injected by the fluid injection means. If the pressure of the fluid increases, the force between the sealing structure of the capsule and the annular end surface of

the enclosing member increases too and thereby the force between the sealing structure of the capsule and the annular end surface of the enclosing member increases also. Such a system is described further on. The sealing structure of the capsule must be arranged such that upon reaching the

5 maximum fluid pressure in the enclosing member the sealing structure should still provide a fluid sealing contact between the enclosing member and the capsule. However, the sealing structure must also be arranged such that prior to, or at the start of, brewing when the pressure of the fluid in the enclosing member outside the capsule is relatively low, the sealing structure

10 also provides a sealing contact between the enclosing member and the capsule. If at the start of brewing, there would not exist a sealing contact between the capsule and the enclosing member, leakage will occur. However, if leakage occurs there is a real chance that the pressure in the enclosing member and outside the capsule will not sufficiently increase for

15 increasing the force on the sealing structure by means of the annular end surface of the enclosing member if the manually operated or automatic mechanism moves the enclosing member towards the capsule holder. Only if there is a sufficient initial sealing, the pressure in the enclosing member will increase whereby also the force of the annular end surface of the

20 enclosing member acting on the sealing structure of the capsule will increase for providing a sufficient sealing contact at also the increased fluid pressure. Moreover, this increased fluid pressure outside the capsule also provides an increased fluid pressure inside the capsule, which is essential if the capsule is provided with a cover, which is arranged to tear open on relief

25 members of the capsule holder (also called an extraction plate) of the beverage preparation device under the influence of fluid pressure in the capsule.

It follows from the above that the sealing structure is a member, which is very critical in design. It should be able to provide a sealing contact

30 between the enclosing member and the capsule at a relatively low fluid

pressure if only a relatively small force is applied on the sealing structure by means of the annular end surface of the enclosing member but it should also provide a sealing contact at a much higher fluid pressure in the enclosing member outside the capsule if a higher force is applied by means of the

5 annular end surface of the enclosing member to the sealing structure of the capsule. In particular when the annular end surface of the enclosing member is provided with radially extending open grooves which act as air inlet passage once the force between the enclosing member and the capsule holder is released so that it is easier for a user to take out the capsule, the

10 sealing structure must also be able to 'close' the radially extending open grooves to provide an effective seal.

One or more embodiments of the invention may provide a capsule that reliably seals against the annular end surface of an enclosing member of a beverage preparation device if the capsule is positioned in the enclosing

15 member of the beverage preparation device and the enclosing member is closed by means of a closing member of the beverage preparation device, such as an extraction plate of the beverage preparation device, a portion of the outwardly extending flange of the capsule and the sealing structure of the capsule being clamped between the annular end surface of the enclosing

20 member and the closing member of the beverage preparation device, even in case of an enclosing member of which the annular end surface is provided with radially extending open grooves and which can still be manufacture at low costs.

The present invention provides a capsule containing a substance for the

25 preparation of a potable beverage by extracting and/or dissolving the substance by means of supplying a fluid under pressure into the capsule, said capsule comprising:

an aluminum capsule body having a central capsule body axis, said aluminum capsule body comprising a bottom, a sidewall, an outwardly

30 extending flange and a sealing structure at said flange; and

a cover sheet attached to said flange and hermetically closing off the capsule;

wherein said sealing structure is deformable for providing a fluid sealing contact with an annular end surface of an enclosing member of a beverage preparation device when the capsule is positioned in said enclosing member and said enclosing member is closed by means of a closing member of the beverage preparation device, such as an extraction plate of the beverage preparation device, at least portions of said flange and said sealing structure being clamped between said annular end surface and said closing member; said annular end surface optionally being provided with a plurality of radially extending open grooves

wherein said sealing structure includes a deformable sealing ring portion of said flange, said sealing ring portion projecting axially from base portions of said flange, to which said cover sheet is attached, on a side of said base portion opposite of said cover sheet, said deformable sealing ring portion comprising:

an inner wall portion extending from and contiguous with an inner base portion of said flange;

an outer wall portion extending from and contiguous with an outer base portion of said flange, said outer wall portion being located outward of and spaced from said inner wall portion;

a bridge portion interconnecting said inner wall portion and said outer wall portion, said bridge portion being located axially spaced from said base portions of said flange; and

at least one support member between said inner and outer wall portions, wherein the support member supports the bridge portion.

Because the sealing structure includes a deformable sealing ring portion of the flange, the sealing ring portion projecting axially from base portions of the flange, to which the cover is attached, on a side of the base portions opposite of the cover, the sealing structure is integrated in the

flange of the capsule, so the capsule can be manufactured quickly at low costs.

Because the deformable sealing ring portion of the flange has at least one support member between the inner and outer wall portions, the bridge portion can be of a relatively easily deformable design that allows local deformation of the aluminum sheet material of the bridge portion already at low clamping pressure to accommodate to the shape of the annular end surface of the enclosing member when clamped between the annular end surface of the enclosing member and the closing member, while the support member ensures that at higher clamping pressures enough counter pressure is exerted to reliably seal against a higher pressure drop over the seal. Even in case of an enclosing member of which the annular end surface is provided with radially extending open grooves, the sealing structure can accommodate to the succession of projections and recesses in circumferential sense formed by the annular end surface of the enclosing member. Thus, the sealing structure effectively seals, also against the recessed surface portions of the annular end surface, both during an early stage of the closing of the enclosing member, when the clamping pressure at which the enclosing member and the closing member are pressed against each other is relatively low and the pressure drop over the seal is low, and during a final stage of the closing of the enclosing member, when the clamping pressure at which the enclosing member and the closing member are pressed against each other is relatively high and the pressure drop over the seal is high. In the present context, the meaning of 'aluminum' is understood to also include aluminum alloy.

It is noted that for the sealing between the annular end surface of the enclosing member and the sealing ring portion of the flange to be effective for ensuring that the pressure drop over the substance in the capsule is sufficient for the desired beverage preparation process, it does not have to be hermetically fluid tight under all circumstances. At a liquid

leakage of up to 4% and preferably not beyond 2.5 % of the liquid volume pumped through the capsule, the seal is still effective for allowing the beverage preparation apparatus to generate the desired pressure drop over the substance. Accordingly, a sealing allowing such a leakage constitutes an effective sealing.

The invention also provides a system for preparing a potable beverage from a capsule using a fluid supplied under pressure into the capsule comprising:

a beverage preparation device comprising an enclosing member for receiving the capsule, wherein the enclosing member comprises fluid injection means for supplying fluid under pressure into the capsule, wherein the beverage preparation device further comprises a closing member, such as an extraction plate, for closing the enclosing member of the beverage preparation device, wherein said enclosing member has an annular end with an annular end surface, said annular end surface optionally being provided with a plurality of radially extending open grooves;

a capsule containing a substance for the preparation of a potable beverage by extracting and/or dissolving the substance by means of supplying a fluid under pressure into the capsule, said capsule comprising:

an aluminum capsule body having a central capsule body axis, said aluminum capsule body comprising a bottom, a sidewall, an outwardly extending flange and a sealing structure at said flange; and

a cover sheet attached to said flange and hermetically closing off the capsule;

wherein said sealing structure is deformable and in fluid sealing contact with said annular end surface if the capsule is positioned in said enclosing member and said enclosing member is closed by means of said closing member, at least portions of said flange and said sealing structure being clamped between said annular end surface and said closing member;

wherein said sealing structure includes a deformable sealing ring portion of said flange, said sealing ring portion projecting axially from base

portions of said flange, to which said cover sheet is attached, on a side of said base portion facing said enclosing member when said capsule is in said enclosing member, said deformable sealing ring portion comprising:

an inner wall portion extending from and contiguous with an
5 inner base portion of said flange;

an outer wall portion extending from and contiguous with an
outer base portion of said flange, said outer wall portion being located
outward of and spaced from said inner wall portion; and

a bridge portion interconnecting said inner wall portion and said
10 outer wall portion, said bridge portion being located axially spaced from said
base portions of said flange;

at least one support member between said inner and outer wall
portions, wherein the support member supports the bridge portion.

In addition, there is provided, use of a capsule according to the
15 present invention in a beverage preparation device comprising an enclosing
member for receiving the capsule, wherein the enclosing member comprises
fluid injection means supplying fluid under pressure into the capsule,
wherein the beverage preparation device further comprises a closing
member, such as an extraction plate, closing the enclosing member of the
20 beverage preparation device, wherein said enclosing member has an
annular end with an annular end surface, said annular end surface
optionally being provided with a plurality of radially extending open
grooves, wherein the capsule is positioned in the enclosing member of the
beverage preparation device, the enclosing member is closed by means of the
25 closing member of the beverage preparation device, and at least a portion of
the sealing structure is clamped between the enclosing member and the
closing member of the beverage preparation device causing the sealing
structure to be brought in sealing contact with the annular end surface.

In operation of such a system and in such a use, the bridge
30 portion easily deforms locally, thereby accommodating to the shape of the

annular end surface of the enclosing member when it is clamped between the annular end surface of the enclosing member and the closing member. More in particular, the sealing structure accommodates to the succession of projections and recesses in circumferential sense formed by the annular end surface of the enclosing member and effectively seals, also against the recessed surface portions of the annular end surface both during an early stage of the closing of the enclosing member when the clamping pressure at which the enclosing member and the closing member are pressed against each other is relatively low and the pressure drop over the seal is low and during a final stage of the closing of the enclosing member when the clamping pressure at which the enclosing member and the closing member are pressed against each other is relatively high and the pressure drop over the seal is high.

A particularly easy deformation of the bridge portion and accordingly a high degree of conformability to the shape of the annular end surface of the enclosing member can be achieved if the deformable sealing ring portion and the bridge portion are positioned and have a widths such that the annular end portion contacts the deformable sealing ring portion between the inner and outer wall portions if the capsule is positioned in the enclosing member and the enclosing member is closed by means of the closing member of a compatible beverage preparation device such that at least portions of the sealing structure are clamped between the annular end surface and the closing member.

The support member or support members may be of elastomeric and/or plastomeric material. In such a material adjacent portions may be deformed easily to highly different degrees, so that it easily accommodates to variations in circumferential sense of the degree of deformation resulting from successive raised and recessed portions of the annular end surface of the enclosing member pressing against the deformable sealing ring portion.

For allowing relatively large deformations, the support member or support members may be of a compressible foam material.

Alternatively, the support member or support members may be a spring member or spring members. Thus a high degree of resiliency can be achieved with a relatively stiff material, such as a metal. This allows the support member to be of for instance aluminum, so that it can be recycled after use and disposal together with the capsule body and with the cover, if the cover is of aluminum as well.

In some embodiments, the capsule comprises a plurality of support members arranged in circumferential succession, each support member having a length equal to or smaller than a pitch between successive grooves in said annular end surface of said enclosing member of said beverage preparation device. If a plurality of support members is arranged in circumferential succession, each support member having a length equal to or smaller than a pitch between successive grooves in the annular end surface of the enclosing member of a compatible beverage preparation device, successive support members can deform substantially independently of each other, so that the support members do not hinder circumferentially adjacent sections of the sealing ring portion of the flange to be deformed to widely varying degrees. Accordingly, a particularly high degree of conformability can be achieved.

A high degree of conformability to the shape of the annular end surface and accordingly a particularly effective and reliable sealing already at low sealing pressure can be achieved if in cross-sectional view, a top of the bridge portion axially most remote from the base flange portions is flat or has a center plane curved with a radius of curvature larger than two times a wall thickness of the top of the bridge portion.

For a good conformability to the shape of the annular end surface it is further advantageous if at least a portion of the top of the bridge portion has a reduced wall thickness smaller than a wall thickness of the

inner and outer wall portions. In some of these embodiments, the capsule may further comprise a coating on at least one side of said capsule body, said coating being absent in at least said portion of the top of said bridge portion having a reduced wall thickness to provide an uncoated portion of
5 said bridge portion.

If the capsule body has a coating to at least one side, leaving out the coating in at least the portion of the top of the bridge portion having a reduced wall thickness reduces the risk of the coating being damaged or becoming unstuck during relatively large deformations occurring when the
10 wall thickness is reduced during manufacturing. The coating may also be removed while reducing the wall thickness during manufacturing, for instance if reducing the wall thickness involves removing wall material.

A further enhanced sealing effect can be achieved if the uncoated portion of the bridge portion is on a side of the flange opposite of the cover
15 and has a textured surface. A texture in the surface can further improve the conformability during early stages of clamping, when the sealing pressure is still low, because clamping force is transferred via raised portions of the texture only, so that at the raised portions a higher contact pressure is exerted than would be exerted over a full smooth contact surface.

20 A particularly improved sealing effect can be achieved if the textured surface includes ridges and valleys extending in circumferential sense of the flange, because early conformation to the shape of the annular end surface is then achieved in generally annular areas or ring sectors extending mainly in circumferential sense.

25 Also provides is a method of manufacturing a capsule according to certain embodiments of the present invention, starting from a semi finished deep drawn cup member, the method comprising reducing a wall thickness of a portion of said flange for forming said portion of said top of said bridge portion having a reduced wall thickness smaller than a wall thickness of
30 said inner and outer wall portions, wherein said coating is removed from

said portion of said flange of which the wall thickness is to be reduced prior to or during reducing the wall thickness. The coating is efficiently removed from the portion of the flange of which the wall thickness is to be reduced prior to or during reducing the wall thickness.

5 A particularly efficient manufacturing of the reduced wall thickness can be achieved if the coating is removed from the portion of the flange of which the wall thickness is to be reduced during a material removal step for removing wall material for reducing the wall thickness.

10 A particularly easy accommodation to the shape of the annular end surface may be achieved if the top of the bridge portion is positioned for being contacted first by the annular end portion, when the sealing ring portion is clamped between the annular end surface and the closing member of a compatible beverage preparation device.

15 The top of the bridge portion forms a rounded or flat crest extending circumferentially around the center line of the capsule. By providing that the crest formed by the top of the bridge portion has a diameter of 29-33 mm, more preferably 30.0-31.4 mm and most preferably 30.3-31.0 mm, the top of the bridge portion is located centrally relative to the annular end surface for first contacting a central portion of the annular
20 end surface when the sealing ring portion is clamped between the annular end surface and the closing member of widely used and commercially available beverage preparation devices such as the Citiz, Lattissima, U, Maestria, Pixie, Inissia and Essenza.

25 The invention may be particularly advantageous when in an embodiment of a capsule the capsule is filled with 5-20 grams, preferably 5-10 grams, more preferably 5-7 grams of an extractable product, such as roasted and ground coffee.

In an embodiment of a capsule according to the invention, which is, in particular easy to manufacture the outer diameter of the outwardly
30 extending flange of the capsule is larger than the diameter of the bottom of

the capsule. Preferably, the outer diameter of the outwardly extending flange is approximately 37.1 mm and the diameter of the bottom of the capsule is about 23.3 mm.

5 The invention may be particularly advantageous when in an embodiment of a capsule the thickness of the plate material of the aluminum capsule body is 20 to 200 micrometer, preferably 100 micrometer.

10 The invention may be particularly advantageous when in an embodiment of a capsule the thickness of the aluminum cover is 15 to 65 micrometer, preferably 30-45 micrometer and more preferably 39 micrometer.

In an embodiment of a capsule according to the invention the thickness of the aluminum cover is smaller than the thickness of the aluminum capsule body.

15 In a further embodiment of a capsule according to the invention the aluminum cover is arranged to tear open on a closing member of the beverage preparation device, such as an extraction plate of the beverage preparation device under the influence of fluid pressure in the capsule.

20 In an embodiment of a capsule according to the invention which may be particularly easy to manufacture the sidewall of the aluminum capsule body has a free end opposite the bottom, the outwardly extending flange extending from the free end of the sidewall in a direction at least substantially transverse to the central capsule body axis. Preferably, the outwardly extending flange comprises a curled outer edge, which is beneficial in obtaining for a satisfactory sealing with the annular end surface provided with radially extending open grooves. The radius about the central capsule body axis of an inner edge of the curled outer edge of the outwardly extending flange is preferably at least 32 mm, so that clearance from the annular end surface of the enclosure member is ensured. It is then preferred that the sealing structure is positioned between the free end of the sidewall of the aluminum capsule body and an inner edge of the curled outer

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edge of the outwardly extending flange to obtain a still further satisfactory sealing.

To ensure that the curled outer edge does not interfere with operation of a wide variety of commercially available and future beverage preparation apparatuses, the outwardly extending flange has a largest
5 radial cross-sectional dimension of about 1.2 millimeter.

The invention may be particularly beneficial for capsules of which the inner diameter of the free end of the sidewall of the aluminum capsule body is about 29.5 mm. The distance between the free end of the sidewall of
10 the aluminum capsule body and an outermost edge of the outwardly extending flange can be about 3.8 millimeter. The preferred height of the aluminum capsule body is about 28.4 mm.

In an embodiment of a capsule according to the invention which after use is easier for a user to take out of a beverage preparation device the
15 aluminum capsule body is truncated, wherein preferably the sidewall of the aluminum capsule body encloses an angle with a line transverse to the central capsule body axis of about 97.5°.

In an advantageous embodiment of a capsule according to the invention the bottom of the aluminum capsule body has a largest inner
20 diameter of about 23.3 mm. It is preferred that the bottom of the aluminum capsule body is truncated, preferably having a bottom height of about 4.0 mm and that the bottom further has a generally flat central portion opposite the cover having a diameter of about 8.3 mm.

In many cases a satisfactory seal can be obtained in an
25 embodiment of a capsule according to the invention in which the height of the sealing structure is at least about 0.1 mm, more preferably at least 0.2 mm and most preferably at least 0.8 mm and at most 3 mm, more preferably at most 2 mm and most preferably at most 1.2 mm.

Regarding the preferred embodiments of the system as mentioned in the dependent claims which relate to the same features as the features of the dependent claims of the capsule reference is made to the above.

The invention may be particularly suitable in a system according to the invention wherein, in use, the maximum fluid pressure in the enclosing member of the beverage preparation device is in the range of 6-20 bar, preferably between 12 and 18 bar. Even at such high pressures a satisfactory seal between capsule and beverage preparation device can be obtained.

Preferably the system is arranged such that, in use, during brewing, the annular end surface of the enclosing member of the beverage preparation device exerts a force F_2 on the sealing structure of the capsule to provide a sealing contact between the outwardly extending flange of the capsule and the enclosing member of the beverage preparation device, wherein F_2 is in the range of 500-1500 N preferably in the range of 750-1250 N when the fluid pressure P_2 in the enclosing member of the beverage preparation device outside the capsule is in the range of 6-20 bar, preferably between 12 and 18 bar. In particular the system is arranged such that, in use, prior to or at the start of brewing, the annular end surface of the enclosing member of the beverage preparation device exerts a force F_1 on the sealing structure of the capsule to provide a sealing contact between the outwardly extending flange of the capsule and the enclosing member of the beverage preparation device, wherein F_1 is in the range of 30-150 N preferably in the range of 40-150 N, more preferably 50-100 N, when the fluid pressure P_1 in the enclosing member of the beverage preparation device outside the capsule is in the range of 0.1-4 bar, preferably 0.1-1 bar.

In an embodiment of a system according to the invention wherein the plurality of radially extending open grooves are uniformly spaced relative to each other in tangential direction of the annular end surface of the annular element of the beverage preparation device so that it is easier

for a user to take out the capsule while a satisfactory seal between capsule and beverage preparation device can still be provided.

In an advantageous embodiment of a system according to the invention the longest tangential width of each groove (top to top, i.e. equal to the groove to groove pitch) is 0.9 - 1.1 mm, preferably 0.95 to 1.05 mm, more preferably 0.98 to 1.02 mm, wherein a maximal height of each groove in an axial direction of the enclosing member of the beverage preparation device is 0.01 - 0.09 mm, preferably 0.03 to 0.07 mm, more preferably 0.045 to 0.055 mm, most preferred 0.05 mm and wherein the number of grooves is 90 to 110, preferably 96. The radial width of the annular end surface at the location of the grooves may for instance be 0.05- 0.9 mm, preferably 0.2- 0.7 mm and more preferably 0.3 - 0.55 mm.

The invention may be particularly suitable when applied to an embodiment of system according to the invention in which during use when the closing member of the beverage preparation device closes the enclosing member of the beverage preparation device the enclosing member of the beverage preparation device can move relative to the closing member of the beverage preparation device under the effect of the pressure of the fluid in the enclosing member of the beverage preparation device towards the closing member of the beverage preparation device for applying the maximum force between the flange of the capsule and the annular end surface of the enclosing member of the beverage preparation device.

Further aspects, effects and details of the invention will now be further described with reference to, non-limiting, examples shown in the drawing, in which:

Fig. 1 shows a schematic representation of an embodiment of a system according to the invention;

Fig. 2 in a perspective view shows an embodiment of a beverage preparation device of a system according to the invention showing the

annular end surface of the enclosing member of the beverage preparation device with the plurality of radially extending open grooves;

Fig. 3A in cross section shows an embodiment of a capsule according to the invention before use;

5 Fig. 3B shows an enlarged detail of a the capsule of Fig. 3A showing the outwardly extending flange and the sealing structure;

Fig. 3C shows an enlarged detail of the outwardly extending flange of the capsule in Figs. 3A and 3B after use;

10 Fig. 4 shows a schematic cross-sectional view along a plane through the centerline of the capsule of a flange area of a first example of a capsule according to the invention;

Fig. 5 shows a schematic cross-sectional view of a section of a flange area of the capsule of Fig. 4 along a plane V-V in Fig. 4, the plane being cylindrical and coaxial with the capsule; and

15 Fig. 6 shows a schematic cross-sectional view along a plane through the centerline of the capsule of a flange area of a second example of a capsule according to the invention.

Fig. 1 shows a schematic representation, in cross sectional view, of an embodiment of a system 1 for preparing a potable beverage from a capsule using a fluid supplied under pressure into the capsule. The system 1 comprises a sealed capsule 2 and a beverage preparation device 4. The device 4 comprises enclosing member 6 for holding the capsule 2. The device 4 further comprises a closing member, such as an extraction plate, 8 for supporting the capsule 2.

25 In Fig. 1 a gap is drawn between the capsule 2, the enclosing member 6 and the extraction plate 8 for clarity. It will be appreciated that, in use, the capsule 2 may lie in contact with the enclosing member 6 and the extraction plate member 8. Commonly, the enclosing member 6 has a shape complementary to the shape of the capsule 2. The apparatus 4 further

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comprises a fluid injection means 10 for supplying an amount of a fluid, such as water, under a pressure in the range of 6-20 bar, preferably between 12 and 18 bar, to the exchangeable capsule 2.

In the example shown in Fig. 1, the exchangeable capsule 2 has
5 an aluminum capsule body 12 having a central capsule body axis 12A and an aluminum cover 14 hermetically sealing an open side of the capsule body 12. In this example, the aluminum capsule body 12 comprises a sidewall 16, a bottom 18 closing the sidewall 16 at a first end, and a outwardly extending flange 20 extending outwardly of the circumferential wall 16 at a second end
10 opposite the bottom 18. The sidewall 16, the bottom 18 and the cover 14 enclose an inner space 22 comprising a substance for the preparation of a potable beverage by extracting and/or dissolving the substance. Preferably the substance is 5-20 grams, preferably 5-10 grams, more preferably 5-7 grams of an extractable product, such as roasted and ground coffee for the
15 preparation of a single beverage. The capsule is initially sealed, i.e. is hermetically closed prior to use.

The system 1 of Fig. 1 comprises bottom piercing means 24 for piercing the bottom 18 of the capsule 2 for creating at least one entrance opening 25 in the bottom 18 for supplying the fluid to the extractable
20 product through the entrance opening 25.

The system 1 of Fig. 1 further comprises cover piercing means 26, here embodied as protrusions of the closing member 8, for piercing the cover 14 of the capsule 2. The cover piercing means 26 may be arranged to tear the cover 14 once a (fluid) pressure inside the inner space 22 exceeds a
25 threshold pressure and presses the cover 14 against the cover piercing means 26 with sufficient force. The aluminum cover 14 thus is arranged to tear open on the closing member 8 of the beverage preparation device under the influence of fluid pressure in the capsule.

The capsule 2 further comprises a sealing structure 28, in Figs. 1,
30 3A and 3B indicated as a general box but more detailed described with

reference to Figs. 4-6, which sealing structure 28 is arranged at the outwardly extending flange 20 for providing a fluid sealing contact with the enclosing member 6 if the capsule 2 is positioned in the enclosing member 6 and the enclosing member 6 is closed by means of the extraction plate 8, such that the outwardly extending flange 20 of the capsule 2 and at least a portion of the sealing structure 28 are sealingly engaged between the enclosing member 6 and the extraction plate 8.

As shown in Fig. 2 the enclosing member 6 of the beverage preparation device comprises an annular element 41 having a central annular element axis 41A and a free annular end surface 30. The annular end surface 30 of the annular element 41 is provided with a plurality of radially extending open grooves 40. The plurality of radially extending open grooves 40 are uniformly spaced relative to each other in tangential direction of the annular end surface 30 of the annular element 41. The longest tangential width of each groove 40 is 0.9 - 1.1 mm, preferably 0.95 to 1.05 mm, more preferably 0.98 to 1.02 mm, wherein a maximal height of each groove 40 in an axial direction of the enclosing member 6 is 0.01 - 0.09 mm, preferably 0.03 to 0.07 mm, more preferably 0.045 to 0.055 mm, and most preferred 0.05 mm. The number of grooves 40 lies in the range of 90 to 110, preferably 96. The radial width of the annular end surface at the location of the grooves may for instance be 0.05- 0.9 mm, preferably 0.2- 0.7 mm and more preferably 0.3 - 0.55 mm.

An embodiment of a capsule according to the invention is shown more detailed in Figs. 3A and 3B. In the shown embodiment the outer diameter ODF of the outwardly extending flange 20 is larger than the diameter DB of the bottom 18 of the capsule 2. In the shown embodiment the outer diameter ODF of the outwardly extending flange 20 is approximately 37.1 mm and the diameter DB of the bottom 18 is about 23.3 mm.

In the present example, the wall thickness of the aluminum capsule body 12 is 100 micrometer. Generally, a wall thickness of, depending on various considerations, 20 to 200 micrometer is preferred.

5 In the shown embodiment the thickness of the aluminum cover 14 is 39 micrometer, preferred thickness ranging from 15-65 micrometer and more in particular 30-45 micrometer. Preferably the thickness of the aluminum cover 14 is smaller than the thickness of the aluminum capsule body 12.

10 The sidewall 16 of the aluminum capsule body 12 has a free end 42 opposite the bottom 18. The inner diameter IDF of the free end 42 of the sidewall 16 of the aluminum capsule body 12 is about 29.5 mm. The outwardly extending flange 20 extends from that free end 42 in a direction at least substantially transverse to the central capsule body axis 12A. The outwardly extending flange 20 comprises a curled outer edge 43, which is
15 beneficial for obtaining a seal between the capsule and the enclosing member. In the shown embodiment the curled outer edge 43 of the outwardly extending flange 20 has a largest radial cross-sectional dimension of about 1.2 millimeter. The distance DIF between the free end 42 of the sidewall 16 of the aluminum capsule body 12 and an inner edge 43A of the
20 curled outer edge 43 is about 2.7 mm, while the distance DOF between the free end 42 of the sidewall 16 of the aluminum capsule body 12 and an outermost edge 43B of the outwardly extending flange 20 is about 3.8 millimeter.

As shown in Figs. 3A and 3B the sealing structure 28 is positioned
25 between the free end of the sidewall 16 of the aluminum capsule body 12 and the inner edge 43A of the curled outer edge 42 of the outwardly extending flange. The sealing structure 28 is indicated as a general box, but will be described in more detail below. Irrespective of the embodiment of the sealing structure 28 the height of the sealing structure is preferably at least
30 about 0.1 mm, more preferably at least 0.2 mm and most preferably at least

0.8 mm and at most 3 mm, more preferably at most 2 mm and most preferably at most 1.2 mm for providing a correct seal.

As can be seen from Fig. 3A the aluminum capsule body 12 is truncated. In the embodiment shown, the sidewall 16 of the aluminum capsule body 12 encloses an angle A with a line transverse to the central capsule body axis 12A of about 97.5° . The bottom 18 of the aluminum capsule body 12 has a largest inner diameter DB of about 23.3 mm. The bottom 18 of the aluminum capsule body 12 is also truncated, and in the shown embodiment has a bottom height BH of about 4.0 mm. The bottom 18 further has a generally flat central portion 18A opposite the cover 14, which central portion 18A has a diameter DEE of about 8.3 mm and in which central portion 18A the entrance opening(s) 25 may be made. The entrance openings may also be made in the truncated portion between the central portion 18A and the side wall 16. The total height TH of the aluminum capsule body 12 of the capsule is about 28.4 mm.

The system 1 shown in Fig. 1 is operated as follows for preparing a cup of a potable beverage, in the present example coffee, the substance in the capsule being roasted and ground coffee.

The capsule 2 is placed in the enclosing member 6. The extraction plate 8 is brought into contact with the capsule 2. The bottom piercing means 24 pierce the bottom 18 of the capsule 2 for creating the entrance openings 25. The fluid, here hot water under pressure, is supplied to the extractable product in the inner space 22 through the entrance openings 25. The water will wet the coffee grounds and extract the desired substances to form the coffee beverage.

During supplying the water under pressure to the inner space 22, the pressure inside the capsule 2 will rise. The rise in pressure will cause the cover 14 to deform and be pressed against the lid piercing means 26 of the extraction plate. Once the pressure reaches a certain level, the tear strength of the cover 14 will be surpassed and the cover 14 will rupture

against the lid piercing means 26, creating exit openings. The prepared coffee will drain from the capsule 2 through the exit openings and outlets 32 (see Fig. 1) of the extraction plate 8, and may be supplied to a container such as a cup (not shown).

5 The system 1 is arranged such that prior to or at the start of brewing, the annular end surface 30 of the enclosing member 6 exerts a force F1 on the sealing structure 28 of the capsule 2 to provide a sealing contact between the outwardly extending flange 20 of the capsule 2 and the enclosing member 6 of the beverage preparation device, wherein the force
10 F1 is in the range of 30-150 N, preferably 40-150 N and more preferably 50-100N, when the fluid pressure P1 in the enclosing member of the beverage preparation device outside the capsule is in the range of 0.1-4 bar, preferably 0.1-1 bar. During brewing, the annular end surface 30 of the enclosing member 6 exerts a force F2 on the sealing structure 28 of the
15 capsule 2 to provide a sealing contact between the outwardly extending flange 20 of the capsule 2 and the enclosing member 6, wherein the force F2 is in the range of 500 -1500 N, preferably in the range of 750-1250 N, when the fluid pressure P2 in the enclosing member 6 of the beverage preparation device outside the capsule 2 is in the range of 6-20 bar, preferably between
20 12 and 18 bar. In the shown embodiment a part 6B of the enclosing member 6 can move relative to the extracting plate 8 under the effect of the pressure of the fluid in the enclosing member 6 towards the extraction plate 8 for applying the maximum force between the outwardly extending flange 20 and the annular end surface 30 of the enclosing member 6. This movement
25 can take place during use, i.e. at the start of brewing and during brewing. The enclosing member 6 has a first part 6A and a second part 6B wherein the second part comprises the annular end surface 30. The second part 6B can move relative to the first part 6A between a first and second position. The second part 6B can move from the first position towards the second
30 position in the direction of the closing member 8 under the influence of fluid

pressure in the enclosing member 6. The force F1 as discussed above may be reached if the second part 6B is in the first position with a fluid pressure P1. The force F2 as discussed above may be reached if the second part 6B is moved towards the second position under the influence of the fluid pressure
5 P2 in the enclosing member 6.

As a result of the force applied the sealing structure 28 of the capsule according to the invention undergoes a plastic deformation and closely conforms to the grooves 40 of the annular end surface 30 and thus provides a sealing contact between the enclosing member 6 and the capsule
10 3 at a relatively low fluid pressure during start up of brewing but also provides a sealing contact at the much higher fluid pressure in the enclosing member outside the capsule during brewing. This close conformation to the grooves 40 of the enclosing member is indicated in Fig. 3C which shows the capsule 2 of the invention after use, and which clearly indicates that the
15 outwardly extending flange 20 comprises deformations 40' which conform to the grooves 40 of the enclosing member.

Now exemplary embodiments of a sealing structure 28 at the outwardly extending flange 20 of the capsule 2 according to the invention will be described in more detail with reference to Figs. 4 to 6.

20 Figs. 4 and 5 show a flange area of first example of capsule 2 according to the invention. A lower portion of the sidewall 16, the outwardly extending flange 20 and the sealing structure 28 at the flange 20 as well as a portion of the cover sheet 14 cover sheet attached to the flange 20 and hermetically closing off the capsule 2 are also shown. The capsule 2 is
25 positioned in an enclosing member 6 with an annular end surface 30 of a compatible beverage preparation device. Portions of the flange 20 and the sealing structure 28 are clamped between the annular end surface 30 and the closing member 8.

The sealing structure 28 is deformable for providing a fluid
30 sealing contact with the annular end surface 30 of the enclosing member 6

(of which an end portion is shown) if the capsule 2 is positioned in the enclosing member 6 and the enclosing member 6 is closed by means of the closing member 8 and at least portions of the flange 20 and the sealing structure 28 are clamped between the annular end surface 30 and the

5 closing member 8.

The sealing structure 28 includes a deformable sealing ring portion of the flange that projects axially from base portions 44, 45 of the flange 20 (i.e. portions to which the cover 14 adheres) on a side of the base portions 44, 45 opposite of the cover. The deformable sealing ring portion

10 has: an inner wall portion 46 extending from and contiguous with an inner base portion 44 of the flange 20, an outer wall portion 47 extending from and contiguous with an outer base portion 45 of the flange, the outer wall portion being located outward of and spaced from the inner wall portion 46, and a bridge portion 48 interconnecting the inner wall portion 46 and the

15 outer wall portion 47. The bridge portion 48 is located axially spaced from the base portions 44, 45 of the flange 20.

The sealing structure 28 further includes a support member 49 between the inner and outer wall portions 46, 47. Because the support member 49 supports the bridge portion 48, the bridge portion 48 can be of a

20 relatively easily deformable design that allows local deformation already at low clamping pressure to accommodate to the shape of the annular end surface 30 of the enclosing member 6 when clamped between the annular end surface 30 and the closing member 8. The support member 49 ensures that at higher clamping pressures enough counter pressure is exerted to

25 reliably seal against a higher pressure drop over the seal.

As is best seen in Fig. 5, even in case of an enclosing member 6 of which the annular end surface 30 is provided with radially extending open grooves 50 each located between raised areas 51, the grooves 50 and raised areas 51 alternating in circumferential sense of the annular end surface 30,

30 the sealing structure 28 can accommodate to the succession of projections 51

and recesses 50 in circumferential sense of the annular end surface 30. Thus, the sealing structure 28 effectively seals against the recessed surface portions 50 of the annular end surface 30 during an early stage of the closing of the enclosing member 6, when the clamping pressure at which the enclosing member 6 and the closing member 8 are pressed against each other is relatively low, and the pressure drop over the seal is low. During a final stage of the closing of the enclosing member 6, when the clamping pressure at which the enclosing member 6 and the closing member 8 are pressed against each other is relatively high and the pressure drop over the seal is high, the support member causes the bridge portion 48 to be pressed against the annular end surface 30 with additional pressure, so that the seal between the bridge portion 48 to be pressed against the annular end surface 30 can resist the then applied higher pressure drop over the seal.

In the present example, easy deformability of the bridge portion 48 and accordingly a high degree of conformability to the shape of the annular end surface 30 is achieved because the deformable sealing ring portion and the bridge portion 48 are positioned and have a widths such that the annular end portion 30 contacts the deformable sealing ring portion between the inner and outer wall portions 46, 47.

The support member or support members may be of elastomeric and/or plastomeric material, preferably completely filling up space under the bridge portion 48 between the inner and outer wall portions 46, 47. In such a material adjacent portions may be deformed easily to highly different degrees, so that it easily accommodates to variations in circumferential sense of the degree of deformation resulting from successive raised and recessed portions 51, 50 of the annular end surface 30 pressing against the deformable sealing ring portion. Even if the material of the support member is relatively soft, e.g. 10-100 Durometer (ASTM D2240 type A scale) and more preferably 20-75 Durometer (ASTM D2240 type A scale), the solid support member 49 can generate substantial support pressure against the

bridge 48, in particular against recessed areas 50, because the support member 49 (of which the volume is substantially constant irrespective of pressure exerted) completely fills up space under the bridge portion 48 between the inner and outer wall portions 46, 47, so local compression at one location requires expansion in another location. Thus, as in hydroforming, additional counter pressure is exerted in less deformed areas as a result of compression in more deformed areas. However, for allowing relatively large deformations, the support member 49 may be of a compressible foam material. In such a material, the above-described effect can be achieved as well after substantially all volume has been compressed out of the voids therein.

For a high degree of conformability to the shape of the annular end surface 30 it is advantageous that, as in the present example, a top of the bridge portion 48 axially most remote from the base flange portions 44, 45 is flat. However, for a high degree of conformability to the shape of the annular end surface 30 it is advantageous if, in cross-sectional view as shown in Fig. 6, the top 152 of the bridge portion 148 has a center plane curved with a radius of curvature larger than two times a wall thickness of the top 152 of the bridge portion 148 (see Fig. 6).

As also illustrated by the example shown in Fig. 6, the support member 149 may also be a spring member. Thus a high degree of resiliency can be achieved with a relatively stiff material, such as a metal. This allows the support member to be of for instance aluminum, so that it can be recycled after use and disposal together with the capsule body and with the cover, if the cover is of aluminum as well.

For a good conformability to the shape of the annular end surface 30 it is further advantageous if at least a portion of the top 152 of the bridge portion 148 has a reduced wall thickness smaller than a wall thickness of the inner and outer wall portions 146, 147.

If the capsule body has a coating to at least one side, leaving out the coating in at least the portion of the top 152 of the bridge portion 148 having a reduced wall thickness reduces the risk of the coating being damaged or becoming unstuck or can result from reducing the wall thickness by removing wall material.

If the uncoated portion of the bridge portion 152 is on a side of the flange 120 opposite of the cover 114, a further improved sealing effect can be achieved if the uncoated portion of the bridge portion 152 has a textured surface, because clamping force is, at least initially, transferred via raised portions of the texture only, so that at the raised portions a higher contact pressure is exerted than would be exerted over a full smooth contact surface.

As shown in Fig. 6, the top 152 of the bridge portion 148 is contacted first by the annular end portion 30. This is also advantageous for a particularly easy accommodation to the shape of the annular end surface 30.

By providing that the top 152 of the bridge portion 148 (which extends circumferentially about the capsule axis) has a diameter of 29-33 mm, more preferably 30.0-31.4 mm and most preferably 30.3-31.0 mm, the top 152 of the bridge portion 148 is located centrally relative to the annular end surface 30 for being contacted by a central portion of the annular end surface 30 first when the sealing ring portion is clamped between the annular end surface and said closing member of widely used and commercially available beverage preparation devices such as the Citiz, Lattissima, U, Maestria, Pixie, Inissia and Essenza.

In the foregoing specification, the invention has been described with reference to specific examples of embodiments of the invention. It will, however, be evident that various modifications and changes may be made therein without departing from the broader spirit and scope of the invention as set forth in the appended claims.

The reference in this specification to any prior publication (or information derived from it), or to any matter which is known, is not, and should not be taken as an acknowledgment or admission or any form of suggestion that that prior publication (or information derived from it) or
5 known matter forms part of the common general knowledge in the field of endeavour to which this specification relates.

Throughout this specification and the claims which follow, unless the context requires otherwise, the word "comprise", and variations such as "comprises" and "comprising", will be understood to imply the inclusion of a
10 stated integer or step or group of integers or steps but not the exclusion of any other integer or step or group of integers or steps.

THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS:

1. A capsule containing a substance for the preparation of a potable beverage by extracting and/or dissolving the substance by means of
5 supplying a fluid under pressure into the capsule, said capsule comprising:
an aluminum capsule body having a central capsule body axis,
said aluminum capsule body comprising a bottom, a sidewall, an outwardly
extending flange and a sealing structure at said flange; and
a cover sheet attached to said flange and hermetically closing off
10 the capsule;
wherein said sealing structure is deformable for providing a fluid
sealing contact with an annular end surface of an enclosing member of a
beverage preparation device when the capsule is positioned in said enclosing
member and said enclosing member is closed by means of a closing member
15 of the beverage preparation device, at least portions of said flange and said
sealing structure being clamped between said annular end surface and said
closing member;
wherein said sealing structure includes a deformable sealing ring
portion of said flange, said sealing ring portion projecting axially from base
20 portions of said flange, to which said cover sheet is attached, on a side of
said base portion opposite of said cover sheet, said deformable sealing ring
portion comprising:
an inner wall portion extending from and contiguous with an
inner base portion of said flange;
25 an outer wall portion extending from and contiguous with an
outer base portion of said flange, said outer wall portion being located
outward of and spaced from said inner wall portion;
a bridge portion interconnecting said inner wall portion and said
outer wall portion, said bridge portion being located axially spaced from said
30 base portions of said flange; and

at least one support member between said inner and outer wall portions, wherein the support member supports the bridge portion.

2. A capsule according to claim 1, wherein said deformable sealing
5 ring portion and said bridge portion are positioned and have a widths such
that said annular end portion contacts said deformable sealing ring portion
between said inner and outer wall portions when the capsule is positioned in
said enclosing member and said enclosing member is closed by means of
said closing member of said beverage preparation device, at least portions of
10 said sealing structure being clamped between said annular end surface and
said closing member.

3. A capsule according to claim 1 or 2, wherein said at least one
15 support member is of elastomeric and/or plastomeric material.

4. A capsule according to any one of the preceding claims, wherein
said at least one support member is of a compressible foam material.

5. A capsule according to any one of the preceding claims, wherein
20 said support member is a spring member.

6. A capsule according to any one of the preceding claims, wherein,
in cross-sectional view, a top of said bridge portion axially most remote from
said base flange portions is flat or has a center plane curved with a radius of
25 curvature larger than two times a wall thickness of said top of said bridge
portion.

7. A capsule according to claim 6, wherein at least a portion of the
top of said bridge portion has a reduced wall thickness smaller than a wall
30 thickness of said inner and outer wall portions.

8. A capsule according to claim 7, further comprising a coating on at least one side of said capsule body, said coating being absent in at least said portion of the top of said bridge portion having a reduced wall thickness to provide an uncoated portion of said bridge portion.
- 5 9. A capsule according to claim 8, wherein said uncoated portion of said bridge portion is on a side of said flange opposite of said cover sheet and has a textured surface.
- 10 10. A capsule according to claim 9, wherein said textured surface includes ridges and valleys extending in circumferential sense of said flange.
11. A capsule according to any one of the preceding claims, wherein said bridge portion is positioned for being contacted first by said annular end portion, when said sealing ring portion is clamped between said annular end surface and said closing member of said beverage preparation device.
- 15 12. A capsule according to claim 11, wherein said top of said bridge portion forms a crest extending circumferentially about the center line of the capsule, said crest having a diameter of 29-33 mm.
- 20 13. A capsule according to claim 12, wherein said crest has a diameter of 30.0-31.4 mm.
- 25 14. A capsule according to claim 12 or 13, wherein said crest has a diameter of 30.3-31.0 mm.
15. A capsule according to any one of the preceding claims, wherein said annular end surface is provided with a plurality of radially extending open grooves.
- 30

16. A capsule according to claim 15, comprising a plurality of support members arranged in circumferential succession, each support member having a length equal to or smaller than a pitch between successive grooves in said annular end surface of said enclosing member of said beverage preparation device.

17. A capsule according to any one of the preceding claims, wherein said closing member is an extraction plate of the beverage preparation device.

18. A system for preparing a potable beverage from a capsule using a fluid supplied under pressure into the capsule comprising:

a beverage preparation device comprising an enclosing member for receiving the capsule, wherein the enclosing member comprises fluid injection means for supplying fluid under pressure into the capsule, wherein the beverage preparation device further comprises a closing member for closing the enclosing member of the beverage preparation device, wherein said enclosing member has an annular end with an annular end surface;

a capsule containing a substance for the preparation of a potable beverage by extracting and/or dissolving the substance by means of supplying a fluid under pressure into the capsule, said capsule comprising:

an aluminum capsule body having a central capsule body axis, said aluminum capsule body comprising a bottom, a sidewall, an outwardly extending flange and a sealing structure at said flange; and

a cover sheet attached to said flange and hermetically closing off the capsule;

wherein said sealing structure is deformable and in fluid sealing contact with said annular end surface if the capsule is positioned in said enclosing member and said enclosing member is closed by means of said closing member, at least portions of said flange and said sealing structure being clamped between said annular end surface and said closing member;

wherein said sealing structure includes a deformable sealing ring portion of said flange, said sealing ring portion projecting axially from base portions of said flange, to which said cover sheet is attached, on a side of said base portion facing said enclosing member when said capsule is in said enclosing member, said deformable sealing ring portion comprising:

an inner wall portion extending from and contiguous with an inner base portion of said flange;

an outer wall portion extending from and contiguous with an outer base portion of said flange, said outer wall portion being located outward of and spaced from said inner wall portion; and

a bridge portion interconnecting said inner wall portion and said outer wall portion, said bridge portion being located axially spaced from said base portions of said flange;

at least one support member between said inner and outer wall portions, wherein the support member supports the bridge portion.

19. A system according to claim 18, wherein said annular end portion contacts said deformable sealing ring portion between said inner and outer wall portions if the capsule is positioned in said enclosing member and said enclosing member is closed by means of said closing member, at least portions of said sealing structure being clamped between said annular end surface and said closing member.

20. A system according to claim 18 or 19, wherein said annular end surface first contacts said bridge portion when said sealing ring portion is clamped between said annular end surface and said closing member.

21. A system according to claim 18, 19 or 20, wherein the capsule is a capsule according to any one of claims 2 to 14.

22. A system according to any one claims 18 to 21, wherein said annular end surface is provided with a plurality of radially extending open grooves.

5 23. A system according to claim 22, wherein the capsule comprises a plurality of support members arranged in circumferential succession, each support member having a length equal to or smaller than a pitch between successive grooves in said annular end surface of said enclosing member.

10 24. A system according to any one claims 18 to 23, wherein said closing member is an extraction plate of the beverage preparation device.

25. Use of a capsule according to any one of claims 1 to 14 in a beverage preparation device comprising an enclosing member for receiving
15 the capsule, wherein the enclosing member comprises fluid injection means supplying fluid under pressure into the capsule, wherein the beverage preparation device further comprises a closing member closing the enclosing member of the beverage preparation device, wherein said enclosing member has an annular end with an annular end surface, wherein the capsule is
20 positioned in the enclosing member of the beverage preparation device, the enclosing member is closed by means of the closing member of the beverage preparation device, and at least a portion of the sealing structure is clamped between the enclosing member and the closing member of the beverage preparation device causing the sealing structure to be brought in sealing
25 contact with the annular end surface.

26. Use according to claim 25, wherein said annular end surface is provided with a plurality of radially extending open grooves.

30 27. Use according to claim 26, wherein the capsule comprises a plurality of support members arranged in circumferential succession, each

support member having a length equal to or smaller than a pitch between successive grooves in said annular end surface of said enclosing member.

28. Use according to claim 25, 26 or 27, wherein said closing member
5 is an extraction plate of the beverage preparation device.

29. A method of manufacturing a capsule according to claim 7, 8 or 9,
starting from a semi finished deep drawn cup member, the method
comprising reducing a wall thickness of a portion of said flange for forming
10 said portion of said top of said bridge portion having a reduced wall
thickness smaller than a wall thickness of said inner and outer wall
portions, wherein said coating is removed from said portion of said flange of
which the wall thickness is to be reduced prior to or during reducing the
wall thickness.

15

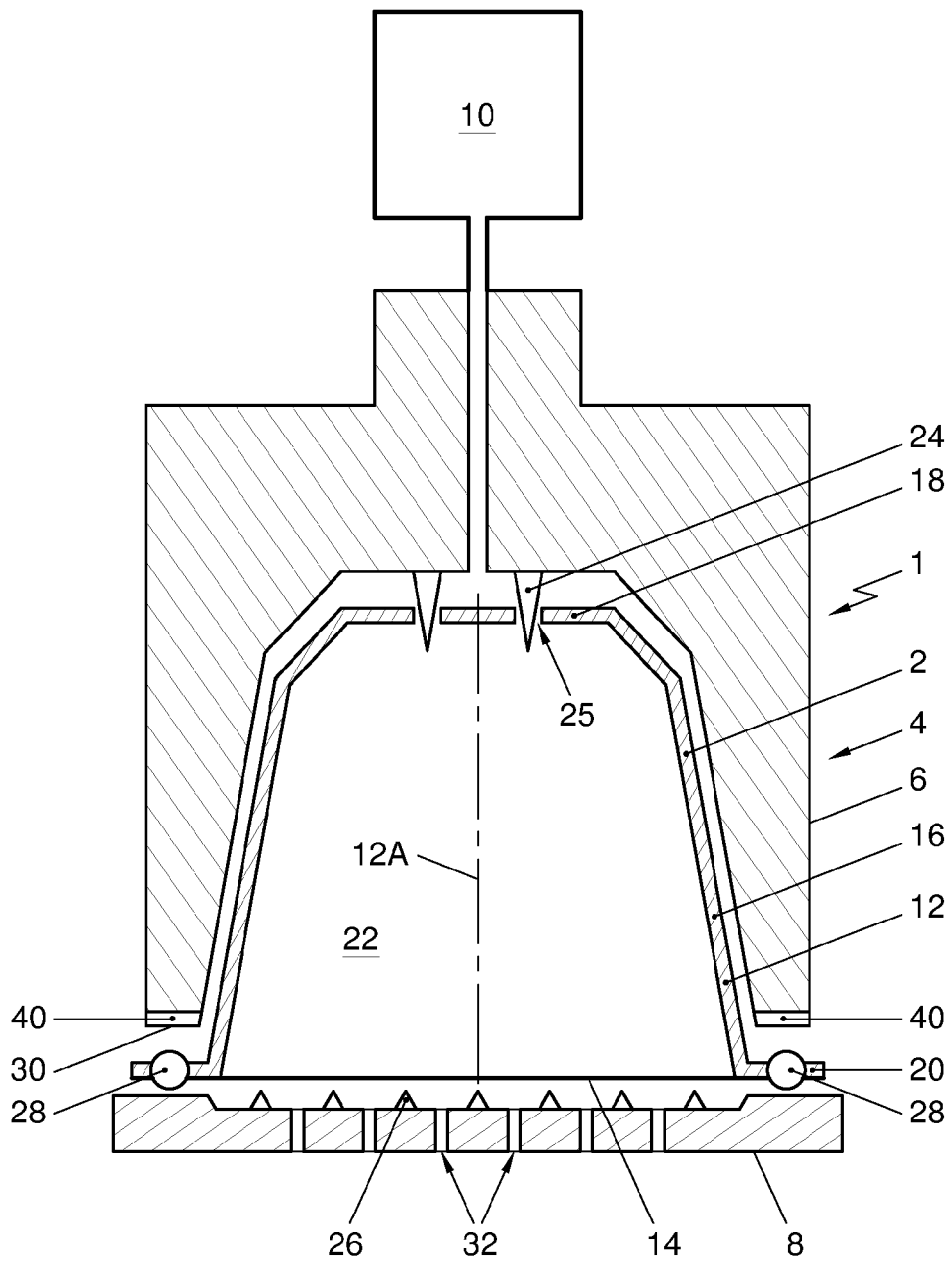


Fig. 1

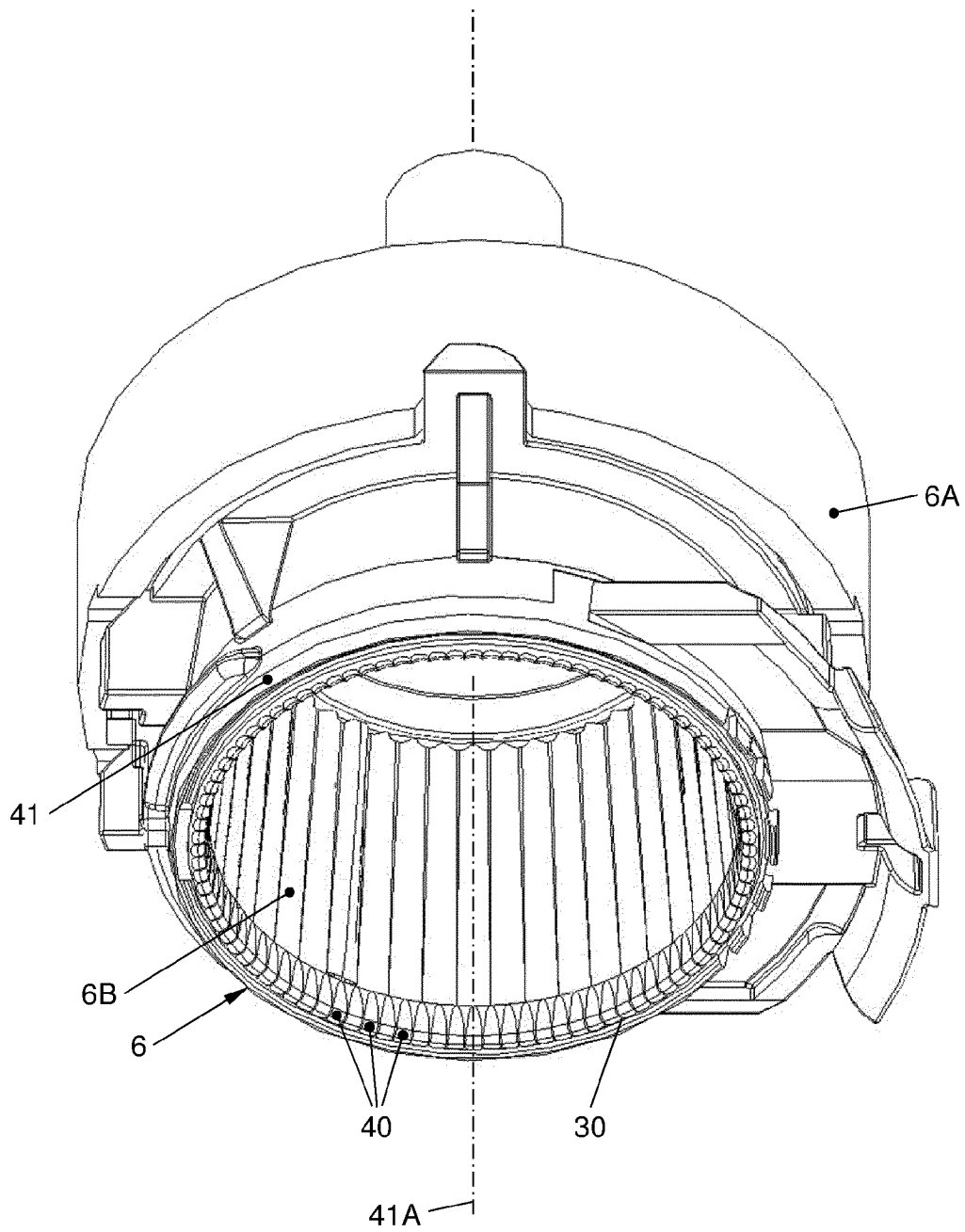


Fig. 2

3/7

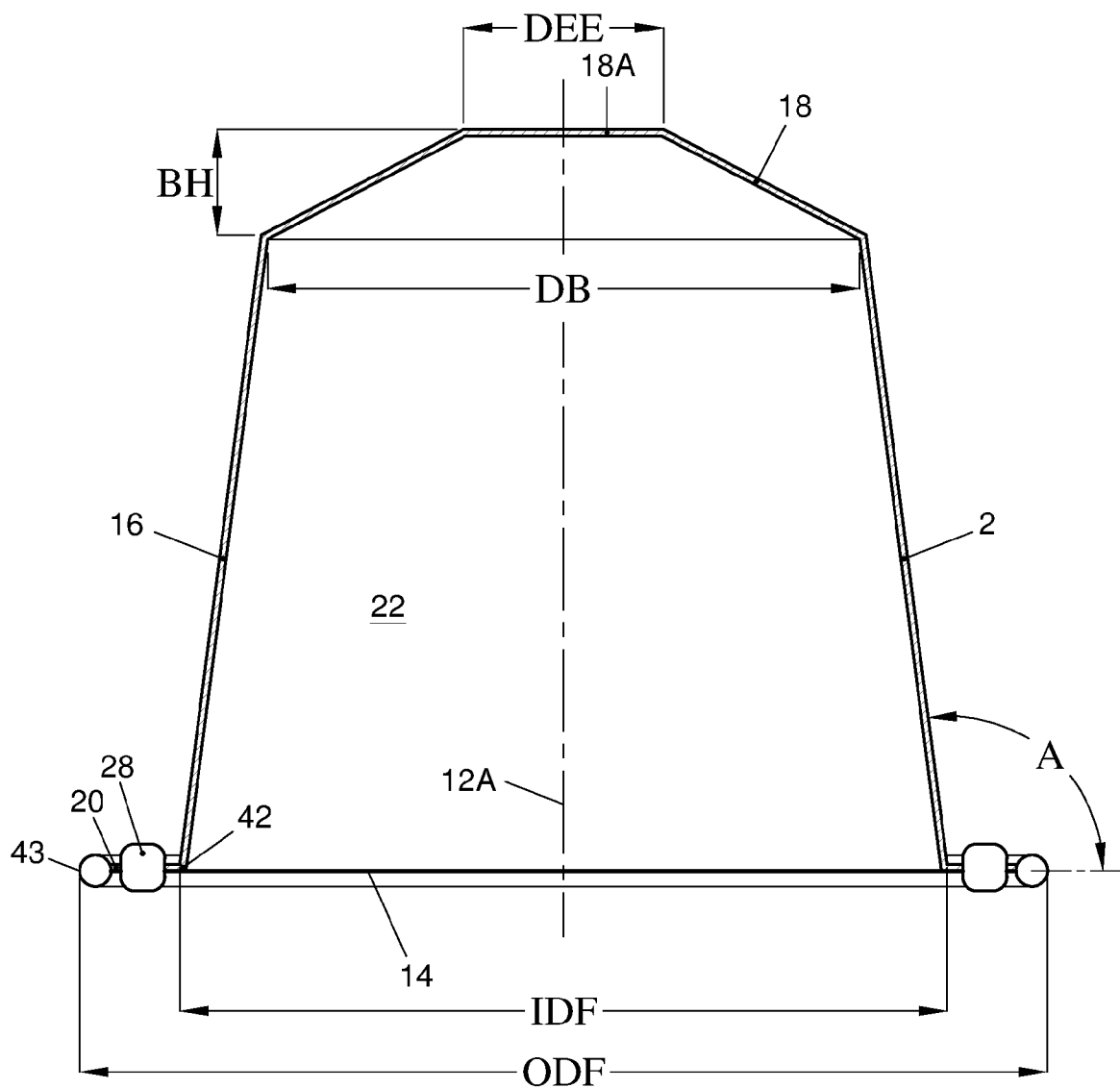


Fig. 3A

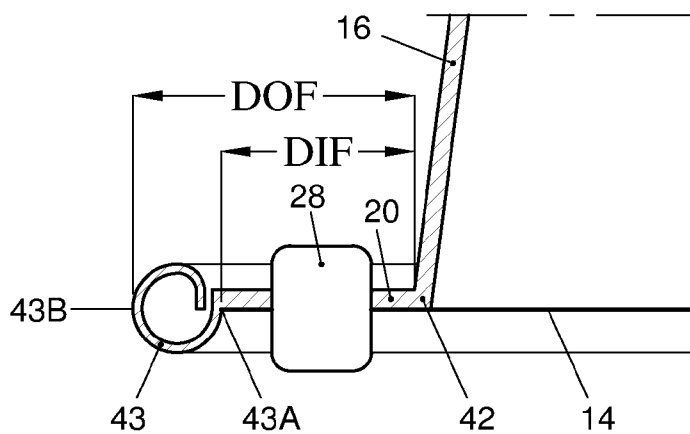


Fig. 3B

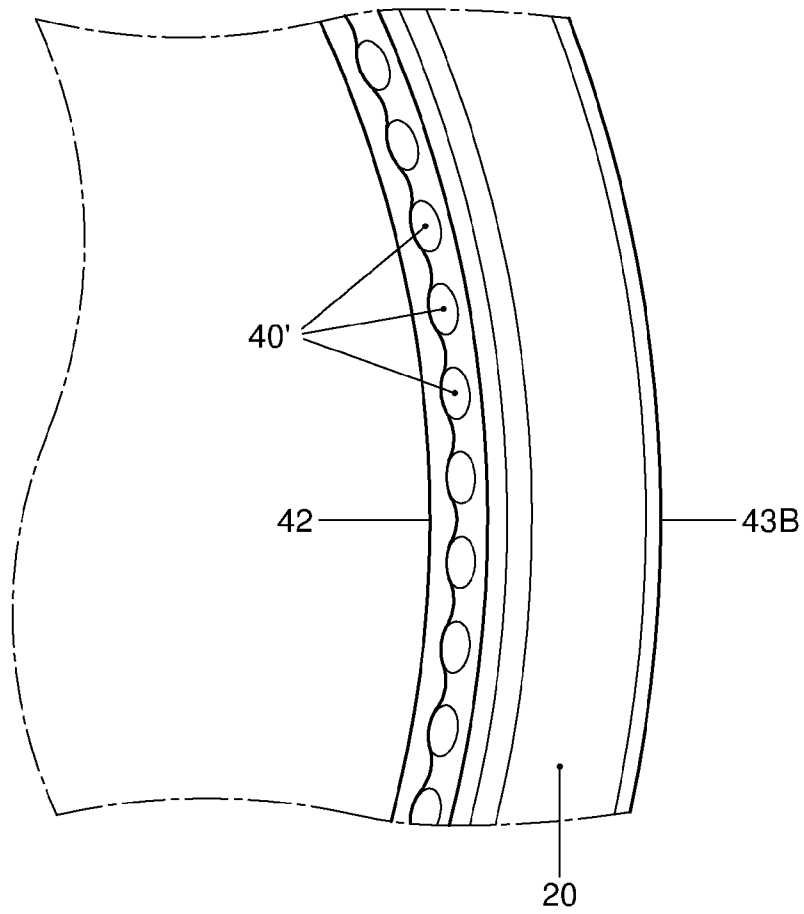


Fig. 3C

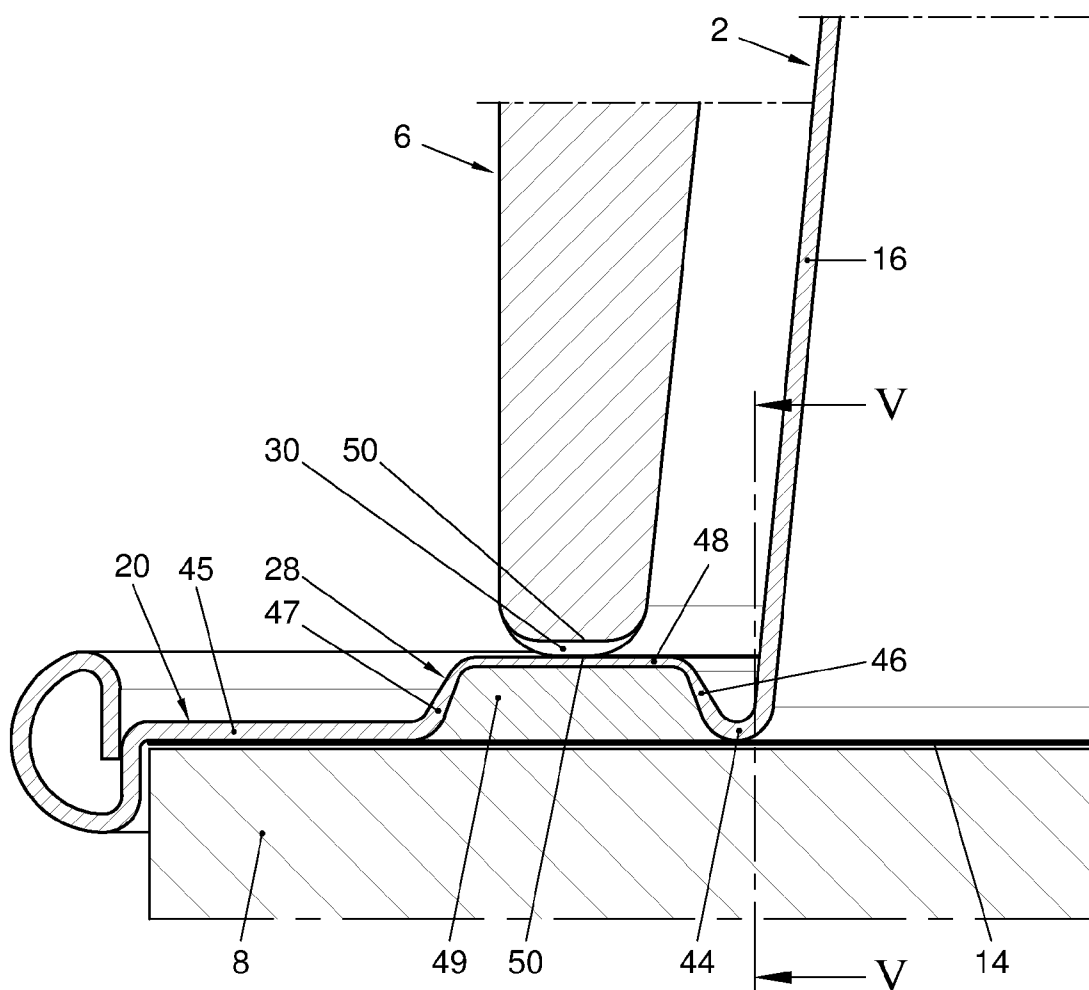


Fig. 4

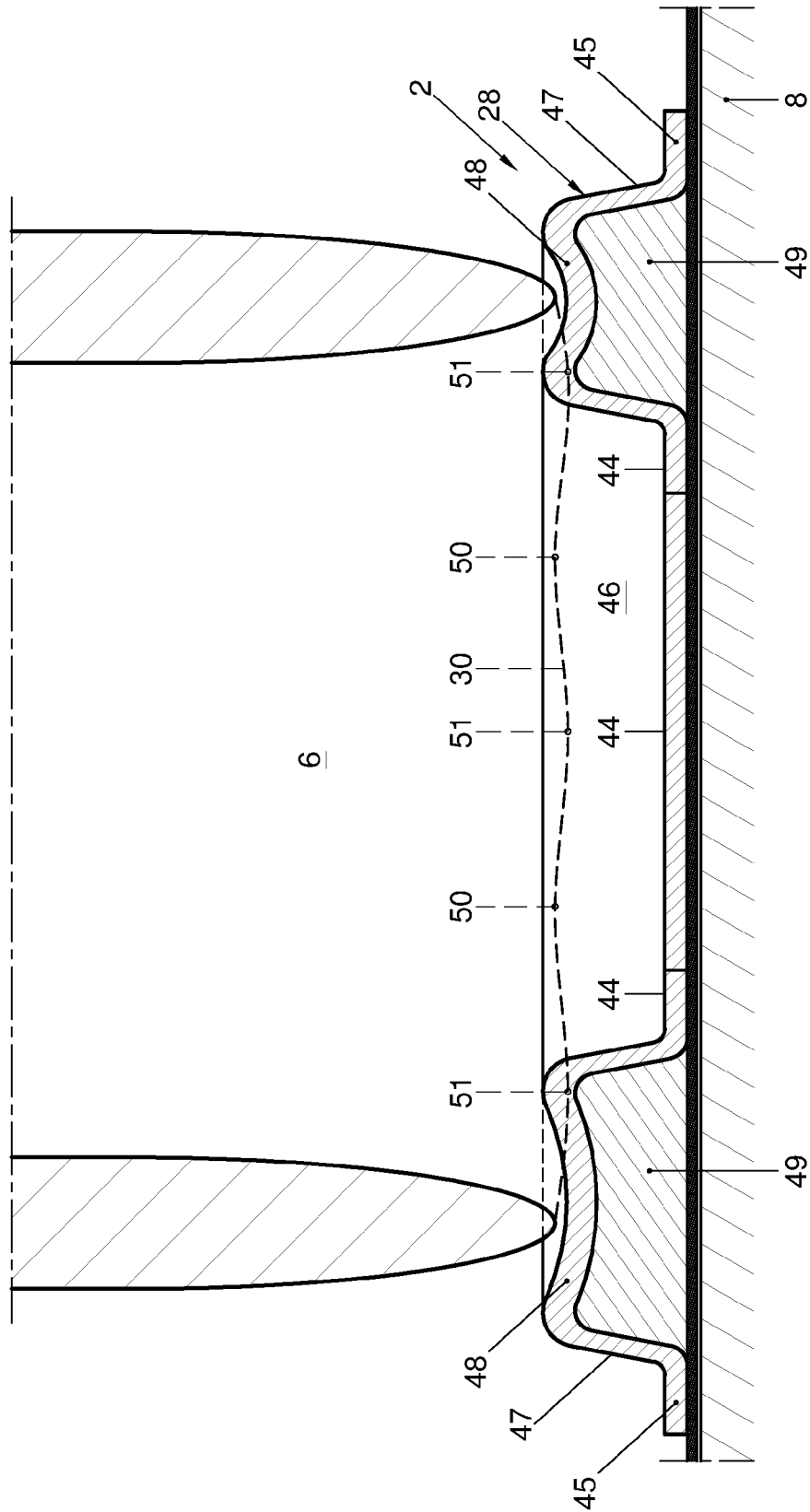


Fig. 5

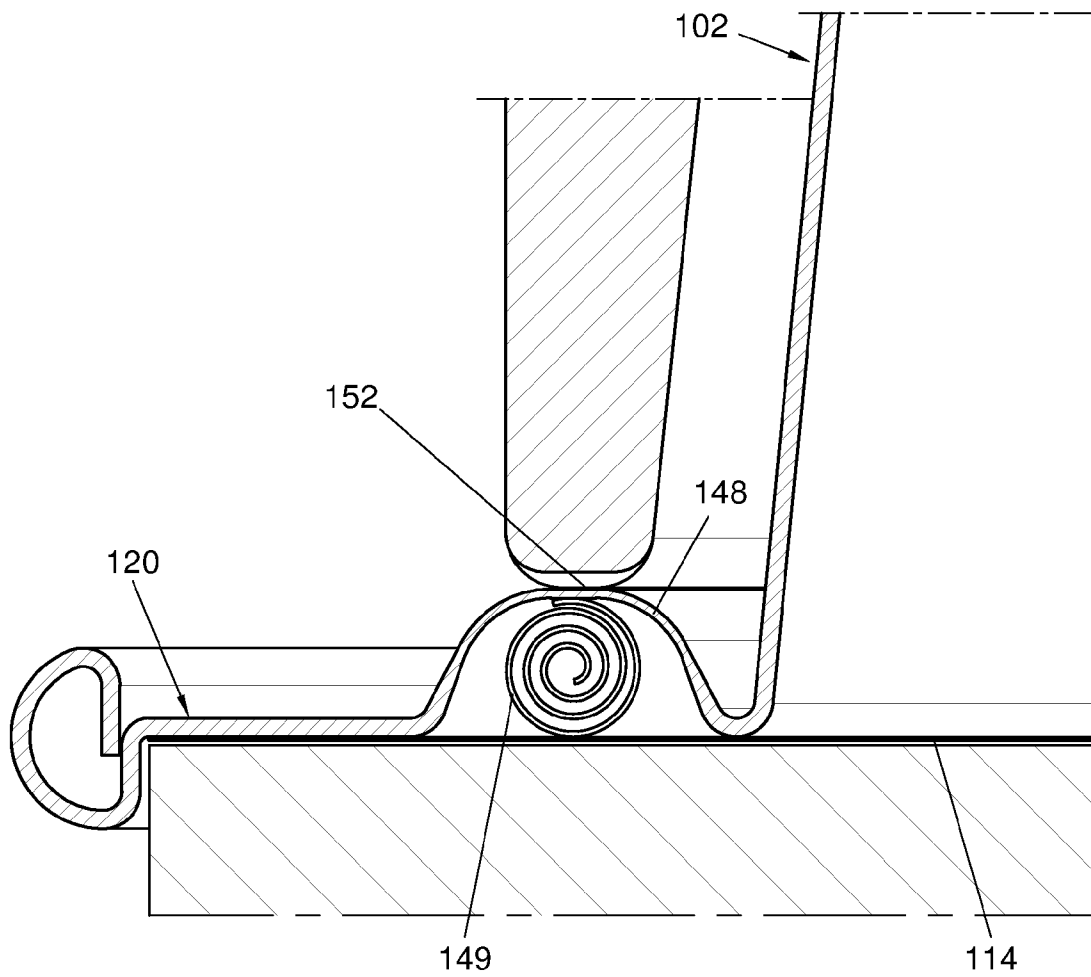


Fig. 6