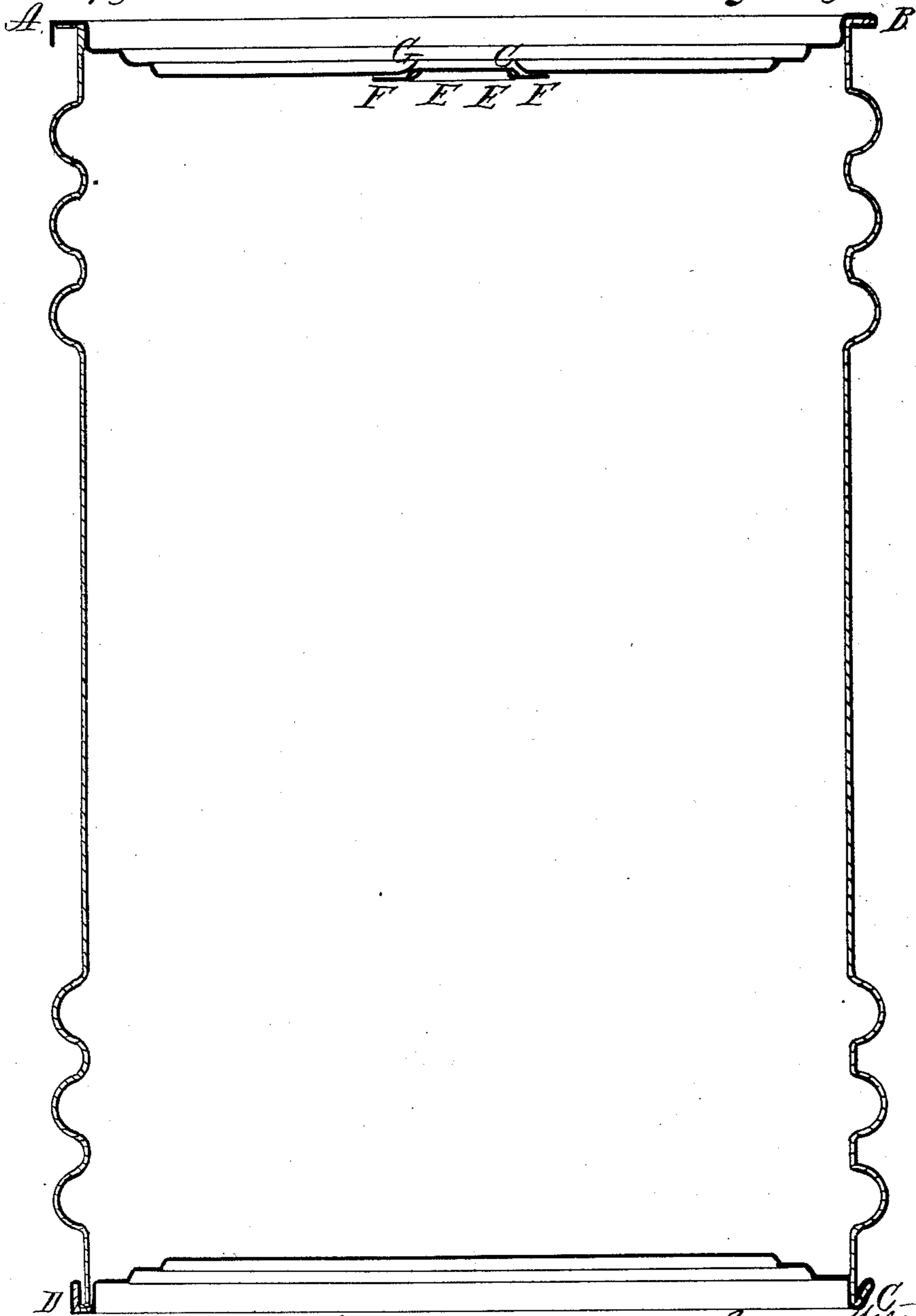


J. Wilson, C. Green & W. Wilson, Jr.,
Attaching Heads of Powder Kegs
N^o 24,772. Patented July 12, 1859.



Witnesses: *W. Mest* Inventors: *J. Wilson*
Joseph Warren *Charles Green Jr.*
W. Wilson Jr.

UNITED STATES PATENT OFFICE.

JAMES WILSON, CHARLES GREEN, AND WILLIAM WILSON, JR., OF WILMINGTON, DELAWARE.

IMPROVEMENT IN ATTACHING THE HEADS OF METALLIC POWDER-KEGS, &c.

Specification forming part of Letters Patent No. 24,772, dated July 12, 1859.

To all whom it may concern:

Be it known that we, JAMES WILSON, CHARLES GREEN, and WILLIAM WILSON, JR., of Wilmington, in New Castle county, and State of Delaware, have invented a new and Improved Powder-Keg; and we do declare the following to be a full and exact description of the same, reference being had to the accompanying drawing.

A cylinder, either plain or corrugated, is first formed. A flange is left upon each end. The heads are struck from a thin plate of metal by a die. Each head is provided with a flange double the width of that left upon the cylinder. This flange is then bent downward, as shown at A. After being bent in this manner, it is firmly pressed upon the flange of the cylinder, as shown at B. The whole is then bent at an angle, as shown at C, in order that in the next operation it may be firmly pressed upon the side of the cylinder, as shown at D. By these means a keg is produced water-tight without the aid of solder. Formerly the kegs requiring to be soldered together rendered the employment of sheet-iron impossible; but by the process above described sheet-iron may be used, thus enabling the kegs to be made at much less expense.

Hitherto it has been possible to double-seam—that is, to produce a joint like the above—on one head of a keg by inserting a mandrel or other instrument suitable for the purpose; but it has been impossible to double-seam both heads, or where a mandrel or other instrument cannot be inserted. In one head a hole is struck by the die in such a manner that upon the upper side an elevation is produced around the hole, as shown at EE. Upon the under side a small plate, FF, having a corresponding opening, but smaller, is riveted to the head. A cap, GG, fits upon the opening in the plate FF. After the keg is filled with powder, this cap may be sealed upon the head.

What we claim as our invention, and desire to secure by Letters Patent, is—

The double seaming of both heads of the keg and the opening in one head, in the manner substantially as above described.

JAMES WILSON.
CHARLES GREEN.
WM. WILSON, JR.

Witnesses:

WM. BURK,
JOSEPH WALKER.