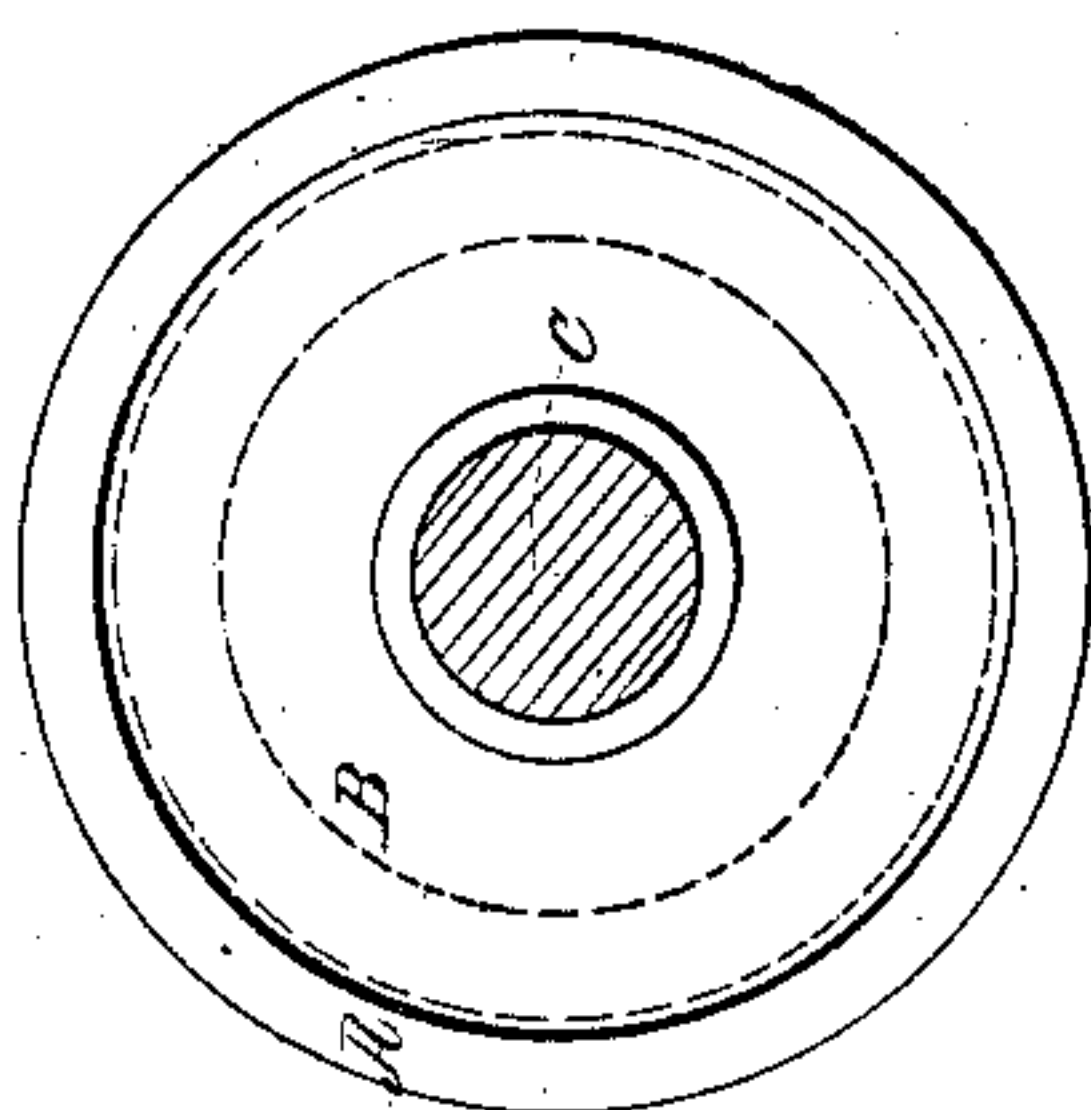


*J. W. Millet,*  
*Soldering Clamp.*

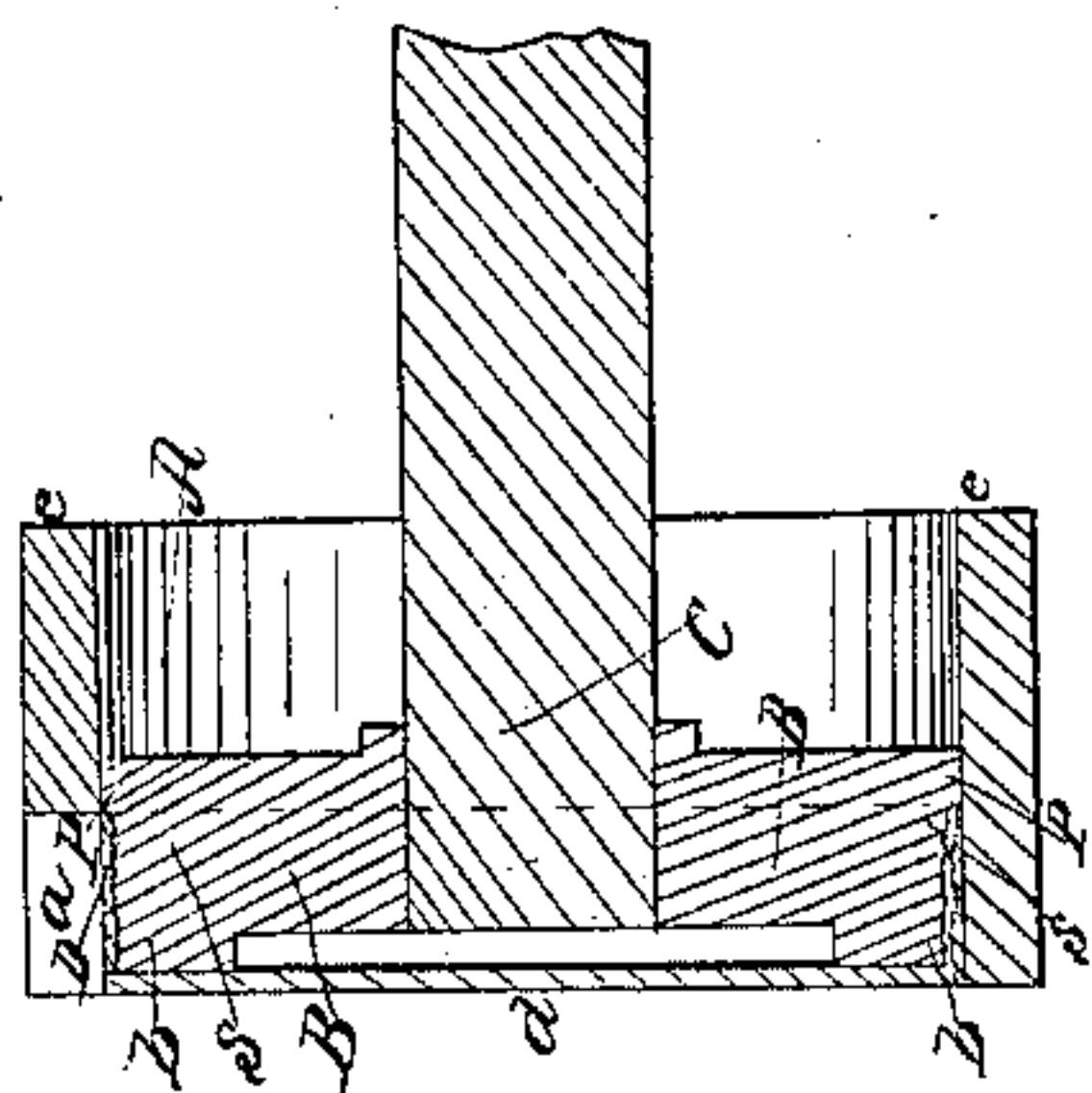
*N<sup>o</sup> 44,737.*

*Patented Oct. 18, 1864.*

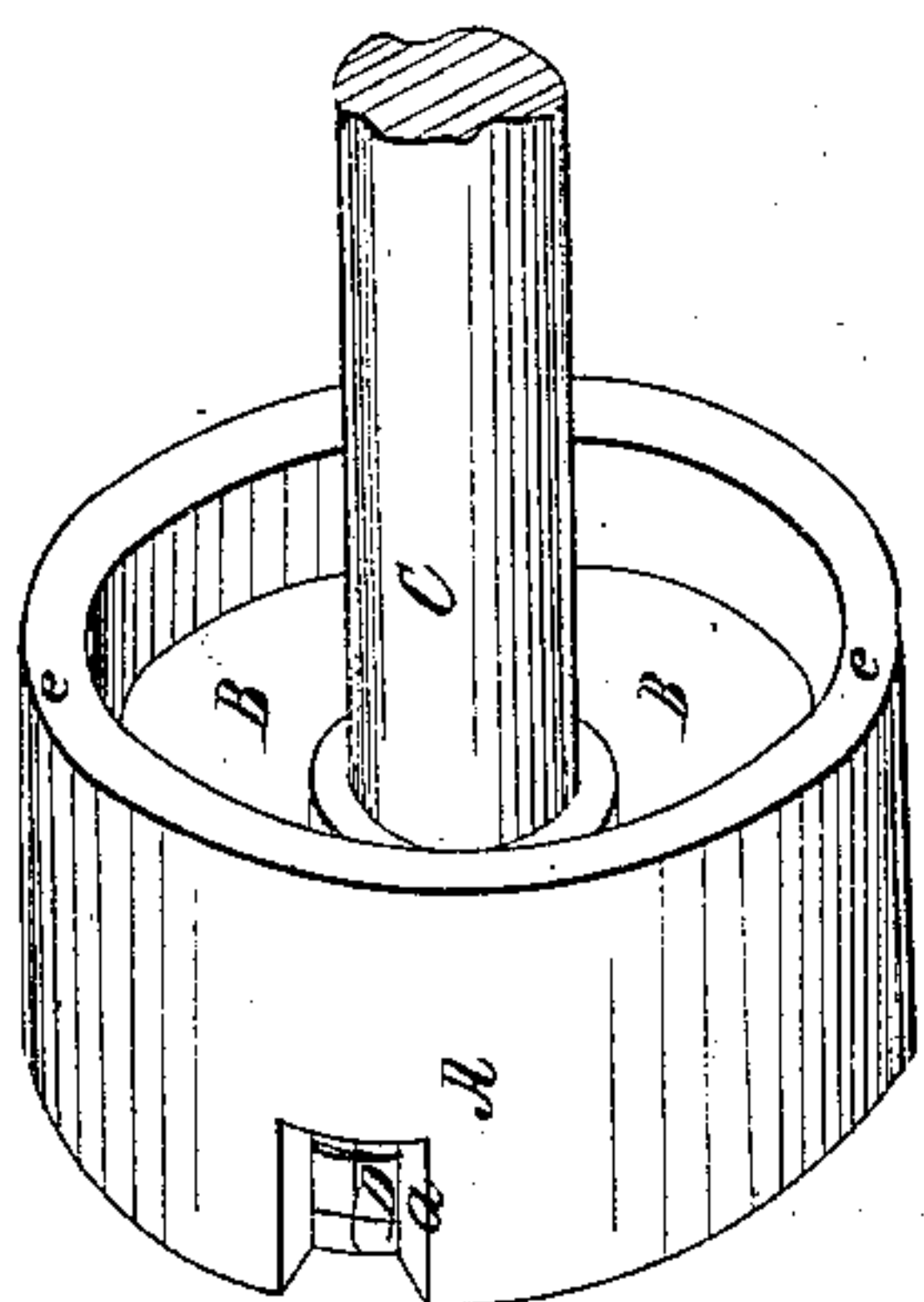
*Fig: 3*



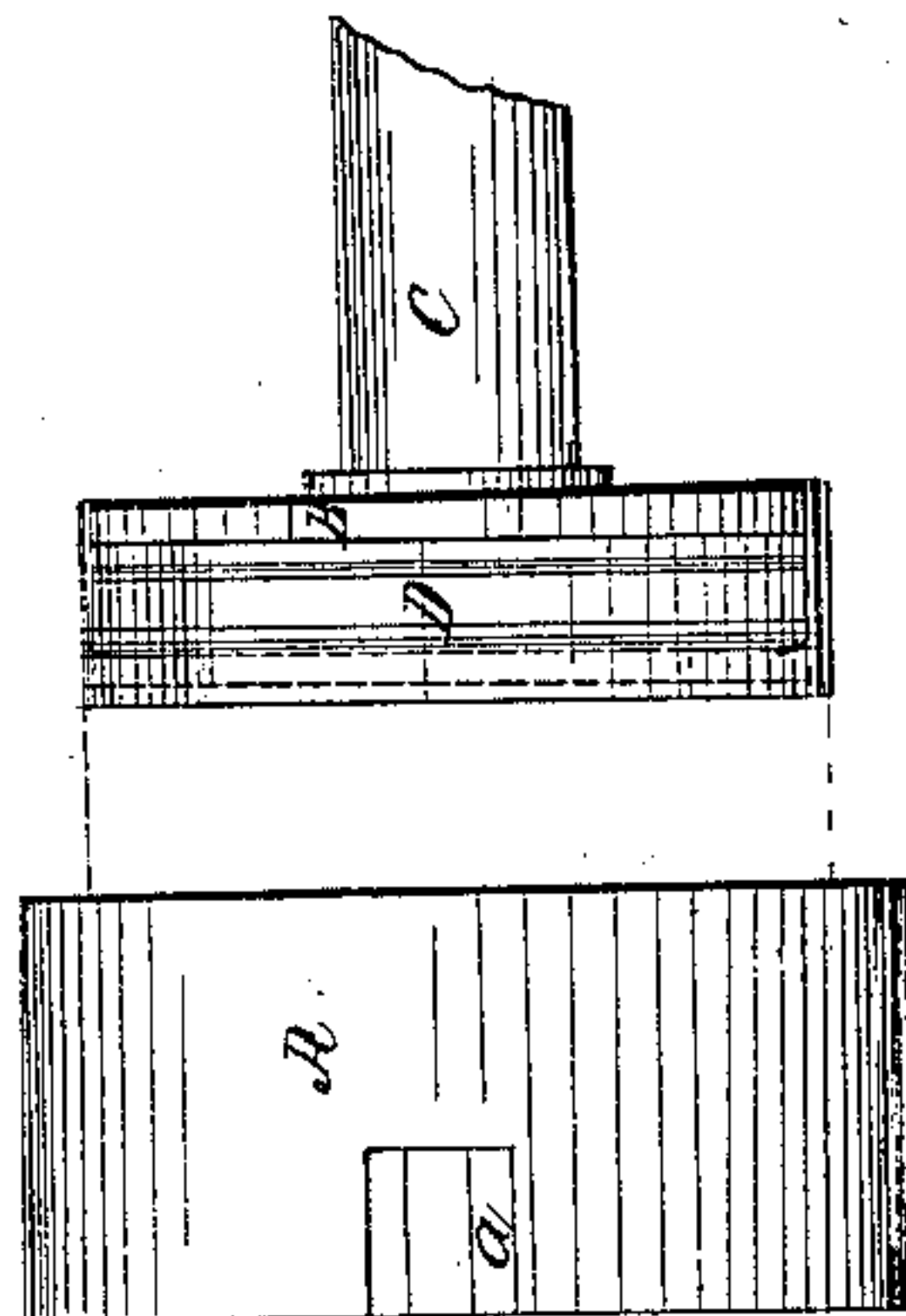
*Fig: 2*



*Fig: 1*



*Fig: 4*



*Witnesses:*  
*Edw. J. Phelps*  
*H. C. Batchman*

*Inventor:*  
*John W. Millet*

# UNITED STATES PATENT OFFICE.

JOHN W. MILLET, OF BATCHELLERVILLE, NEW YORK.

## IMPROVEMENT IN MANUFACTURING CANS AND BOXES.

Specification forming part of Letters Patent No. 44,737, dated October 18, 1864.

*To all whom it may concern:*

Be it known that I, JOHN W. MILLET, of Batchellerville, in the county of Saratoga and State of New York, have invented a new and useful machine for manufacturing boxes and cans made of sheet metal rims or hoops and wood tops and bottoms; and I do hereby declare that the following is a full, clear, and exact description of the construction and operation of the same, reference being had to the annexed drawings, making a part of this specification, in which—

Figure 1 is a perspective view of the machine. Fig. 2 is a vertical section of the same. Fig. 3 is an end view. Fig. 4 is a side view with the form B in another position.

The machine consists of a stationary hollow cylinder, A, and a form, B, attached to a mandrel, C, which moves horizontally in boxes, as shown in Figs. 1 and 4. The interior diameter of the cylinder A is the same as the outer diameter of the box or can to be made, except at the end *e e*, where it is larger, allowing the box to enter the cylinder with ease. The diameter of the form B at SS, as shown in Fig. 2, is the same as the inner diameter of the box. At *b b* it is a little less, and at PP it fits closely in the hollow cylinder, making a shoulder for the edge of the tin rim to rest against, as shown in Fig. 2.

The design of the machine is to make a box or can composed of a tin rim and wood top and bottom, though I do not limit it to that kind of a vessel. The rim is first bent and crimped into the form required when the box is completed by a machine for that purpose. Then the wood top or bottom is put into the rim in its proper place, when the box is put upon the form B, as shown in Fig. 4, or put in such a position that the form B will carry it into the hollow cylinder A, as shown in Fig. 1, always bringing the lap D into the slot *a*, where it can be soldered or otherwise fastened. The box remains for the solder to cool till another box is forced into the cylinder, each box driving the preceding one out, thus continuing to operate as the form B is moved out and into the cylinder A.

What I claim as my invention, and desire to secure by Letters Patent, is—

The use or employment of a hollow cylinder, or its equivalent, into which a box or can is forced for the purpose of drawing or pressing the rim of the box or can closely around the top or bottom for soldering or otherwise fastening.

JOHN W. MILLET.

Witnesses:

ISAAC NOYES, Jr.,  
H. G. BATCHELLER.