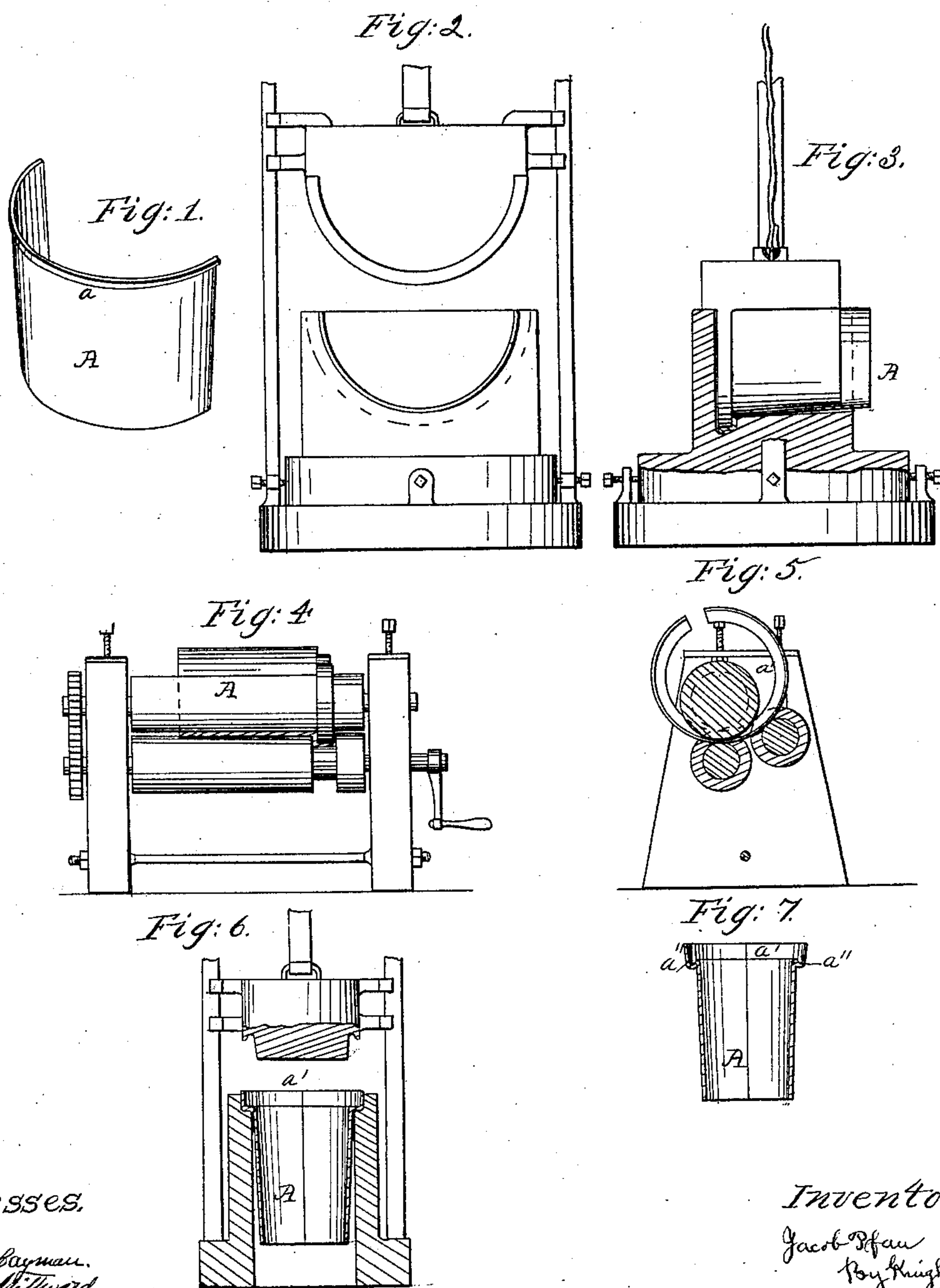


J. Pfau,
Sheet-Metal Die.
N^o 78,605. Patented June 2, 1868.



Witnesses.

Samuel H. Layman.
Frank Millward

Inventor.

Jacob Pfau
By Knight Bros
Atty

United States Patent Office.

JACOB PFAU, OF CINCINNATI, OHIO.

Letters Patent No. 78,605, dated June 2, 1868.

IMPROVEMENT IN MANUFACTURING FRUIT-CAN BODIES.

The Schedule referred to in these Letters Patent and making part of the same.

TO WHOM IT MAY CONCERN:

Be it known that I, JACOB PFAU, of Cincinnati, Hamilton county, and State of Ohio, have invented certain new and useful Manufacture of Fruit-Can Bodies; and do hereby declare the following to be a full, clear, and exact description thereof, reference being had to the accompanying drawings, making part of this specification.

My invention relates to an expeditious and easy mode of making that class of fruit-cans having an open mouth, surrounded by an external crease or groove.

Figure 1 represents a piece of tin which has been edged and bent into a semi-cylindrical form.

Figures 2 and 3 are a front view, and a longitudinal section of a drop-press for imprinting the desired shoulder preparatory to creasing.

Figures 4 and 5 are a side elevation and a transverse section of the rolls for converting the semi-cylindrical sheet into a true cylinder or fruit-can.

Figure 6 is a vertical section of the creasing-press, with the cam in position for creasing.

Figure 7 is a vertical section of the can-body complete.

An edge, *a*, is first turned on the sheet of tin, *A*, of suitable size, with an ordinary edging-machine, and the sheet is then placed between the dies of a forming-machine, and a semi-cylindrical shape imparted to it, (see fig. 1.)

This semi-cylinder is now placed in a drop-press, figs. 2 and 3, and a single blow of the plunger forces the tin into a suitable die, and thus produces a shoulder or ledge, *a'*, which projects outwardly from the cylinder.

The semi-cylinder is then placed in a peculiarly-constructed forming-machine, figs. 4 and 5, which converts it into a true cylinder, the machine being constructed in such a manner that the shoulder does not become broken or wrinkled while passing through it. The edges of the tin composing the cylinder are now soldered, (no lock-joint being required,) and it is then placed within another drop-press or swage, fig. 6, and the crease is formed at a single stroke. A can-body with creased shoulder is thus formed in one piece, (see fig. 7.) The bottom of the can may be soldered on as usual.

I claim herein as new, and of my invention—

1. The mode of manufacture of a creased and open-mouthed fruit-can body in one piece, substantially as described.

2. An open-mouthed and creased fruit-can, whose body and the shoulder for receiving the wax are formed of one piece, in the manner set forth.

In testimony of which invention, I hereunto set my hand.

JACOB PFAU.

Witnesses:

GEO. H. KNIGHT,
JAMES H. LAYMAN.