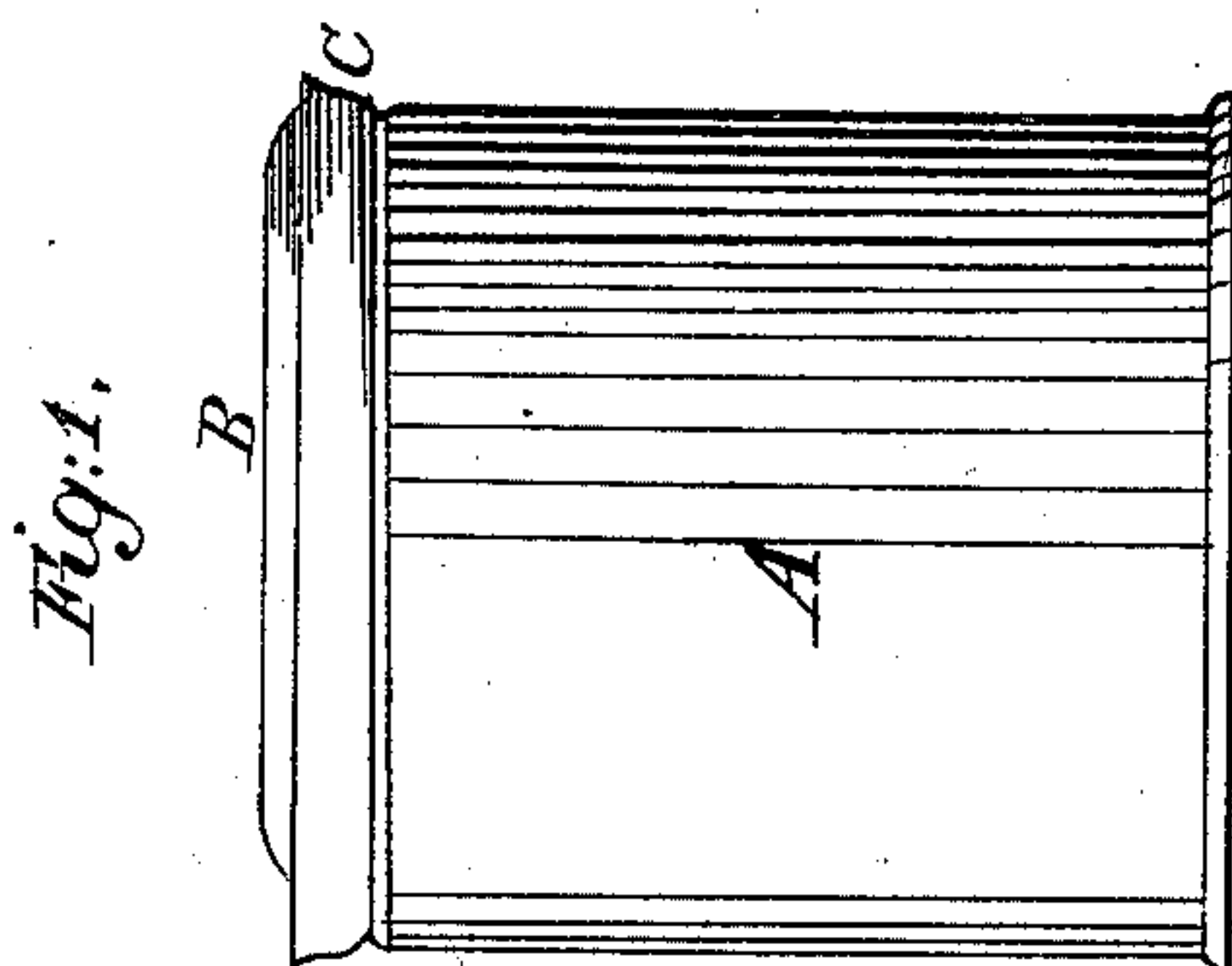
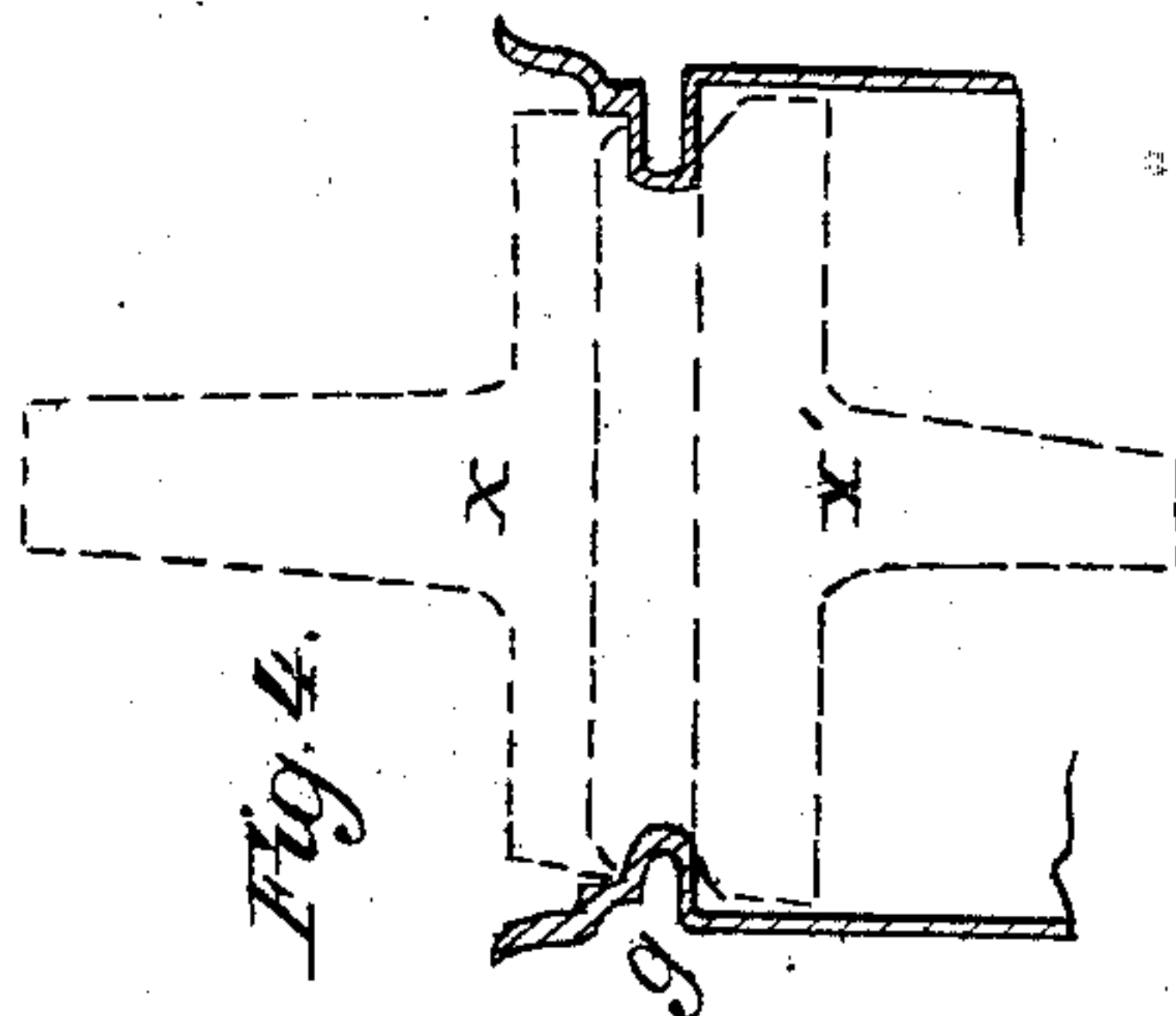
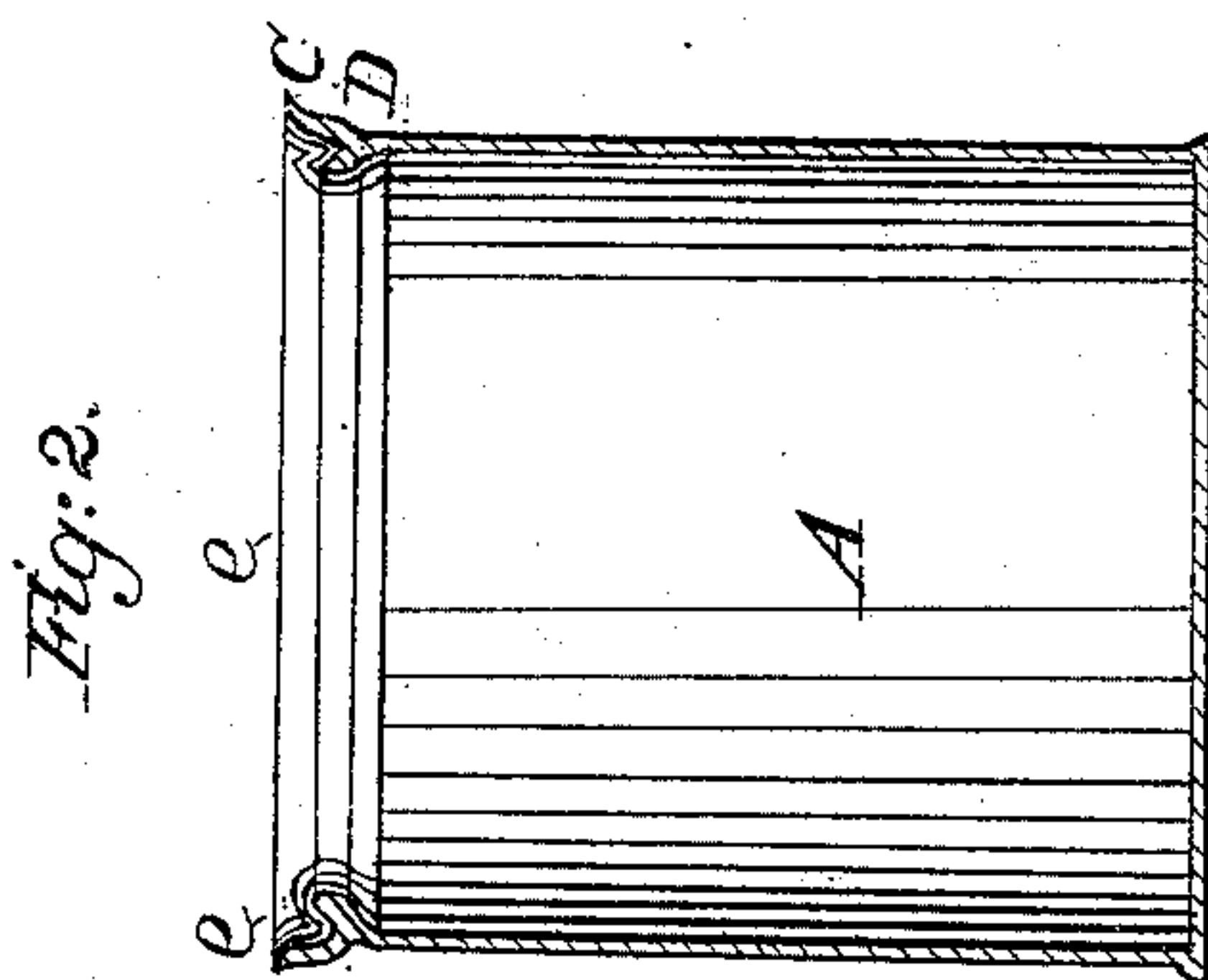
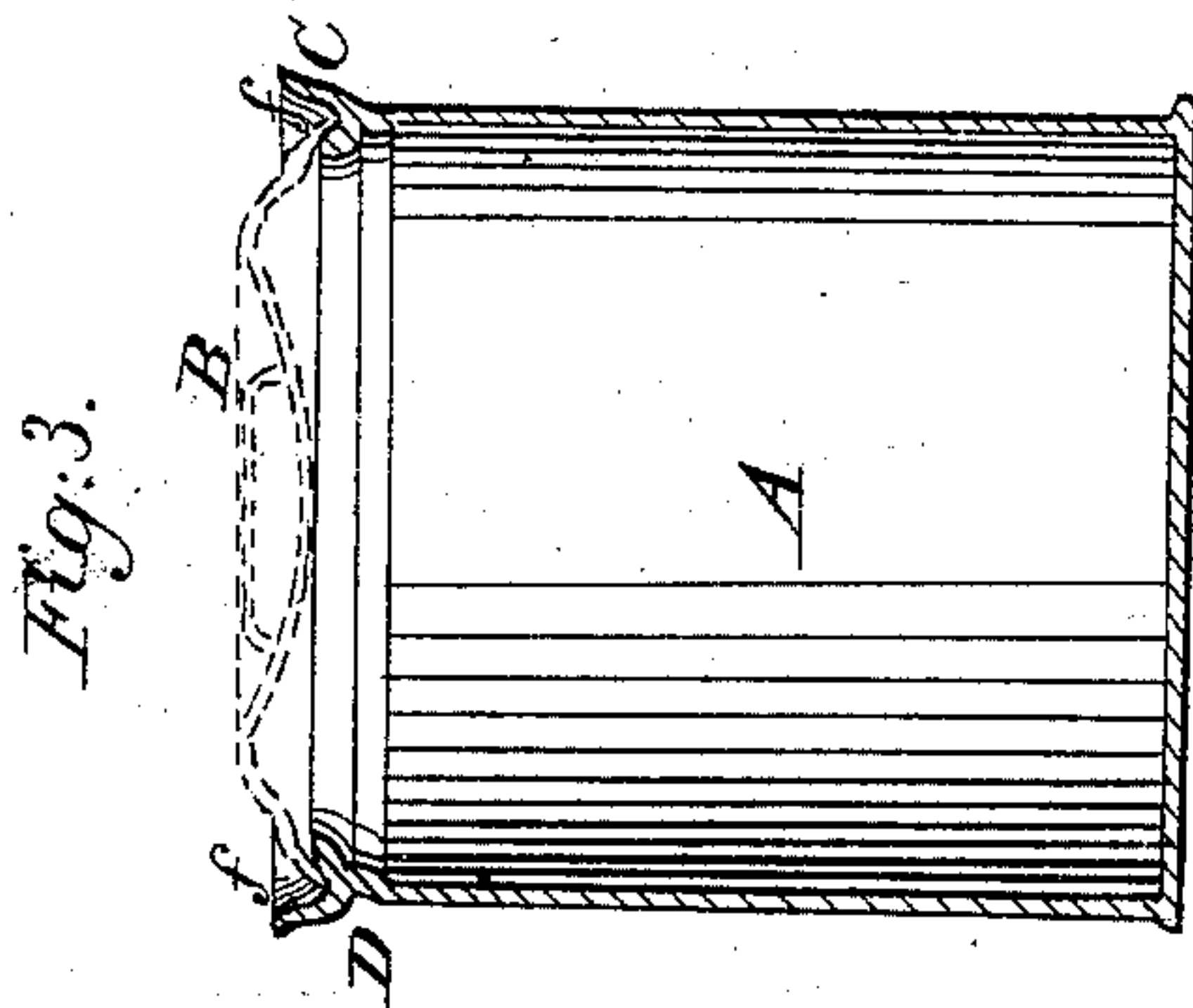


BECKER, ROSS & STEUERNAGEL.

Making Fruit Cans.

No. 79,890.

Patented July 14, 1868.



WITNESSES:

A. C. Johnston
James I. Johnston

INVENTOR:

Charles Becker
John H. Ross
Jacob Steuernagel

United States Patent Office.

CHARLES BECKER, JOHN A. ROSS, AND JACOB STEUERNAGEL, OF ALLE-
GHENY CITY, PENNSYLVANIA.

Letters Patent No. 79,890, dated July 14, 1868.

IMPROVEMENT IN THE MANUFACTURE OF FRUIT-CANS.

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

TO ALL WHOM IT MAY CONCERN:

Be it known that we, CHARLES BECKER, JOHN A. ROSS, and JACOB STEUERNAGEL, all of the city and county of Allegheny, in the State of Pennsylvania, have invented a new and useful Improvement in Method of Constructing Fruit-Cans; and we do hereby declare that the following is a full and exact description thereof, reference being had to the accompanying drawings, and to the letters of reference marked thereon.

The nature of our invention consists in providing fruit-cans with an inner flange for supporting the lid, said flange being formed in one piece with the body of the can, by the method hereinafter described.

To enable others skilled in the art to make and use our invention, we will proceed to describe its construction and operation.

In the accompanying drawings which form part of our specification—

Figure 1 is a side elevation of our improvement in fruit-cans.

Figure 2 is a vertical section of the body of the can.

Figure 3 is a transverse section of the lid, and a vertical section of the body of the can, and represents the relation of the lid to the inner flange of the body of the can.

Figure 4 is a vertical section of the upper part of the body of can, and represents the method of forming the flange in one part with the body of the can.

In the drawings, A is the body of the can; B represents the lid; C represents a flaring rim; D represents the inner flange, which is formed in one part with the body of the can. The flaring rim C and inner flange D form a V-shaped groove, *e*, as clearly shown in figs. 2 and 3. In this groove is placed the drooping edge *f* of the lid B, as shown in fig. 3. By means of the flaring rim C, inner flange D, drooping edge *f* of the lid, and V-shaped groove *e*, a recess is formed between the inner surface of the rim C, and the outer surface of the lid B, for the reception of sealing-cement.

The method of forming the inner flange D is as follows: The body A of the can, prior to furnishing it with its bottom, is grooved or corrugated, as represented at *g*, by means of ordinary grooving or swaging-tools. Then, by means of swaging-dies, the contour of which is clearly shown by the dotted lines *x* and *x'*, the grooved portion *g* is swaged or otherwise formed into the shape represented at D, in figs. 2 and 3. By this method of forming the inner flange D, we form the flange in one piece with the body of the can, and thereby save the labor and trouble of soldering the flange D to the body of the can, and in every case we make a close and sure joint, and a flange which is even and uniform, having a rounded edge, which is a great desideratum when cleaning out the cans.

By our method of providing cans with the inner flange, we avoid the use of solder, (which is an alloy,) which when brought in contact with the juice or liquid, and acid matter of the fruit, will injure both fruit and can.

We wish it clearly understood that we do not claim broadly an inner flange on fruit-cans; but

What we do claim as of our invention, is—

The method herein described for forming and providing fruit-cans with an inner flange, for the purpose set forth.

Witnesses:

A. C. JOHNSTON,
JAMES J. JOHNSTON.

CHARLES BECKER,
JOHN A. ROSS,
JACOB STEUERNAGEL.