J. B. & D. J. Fleming,

Metal Powder Keg.

No. 82,818. Patented Oct. 6, 1868.

Fig. 2.

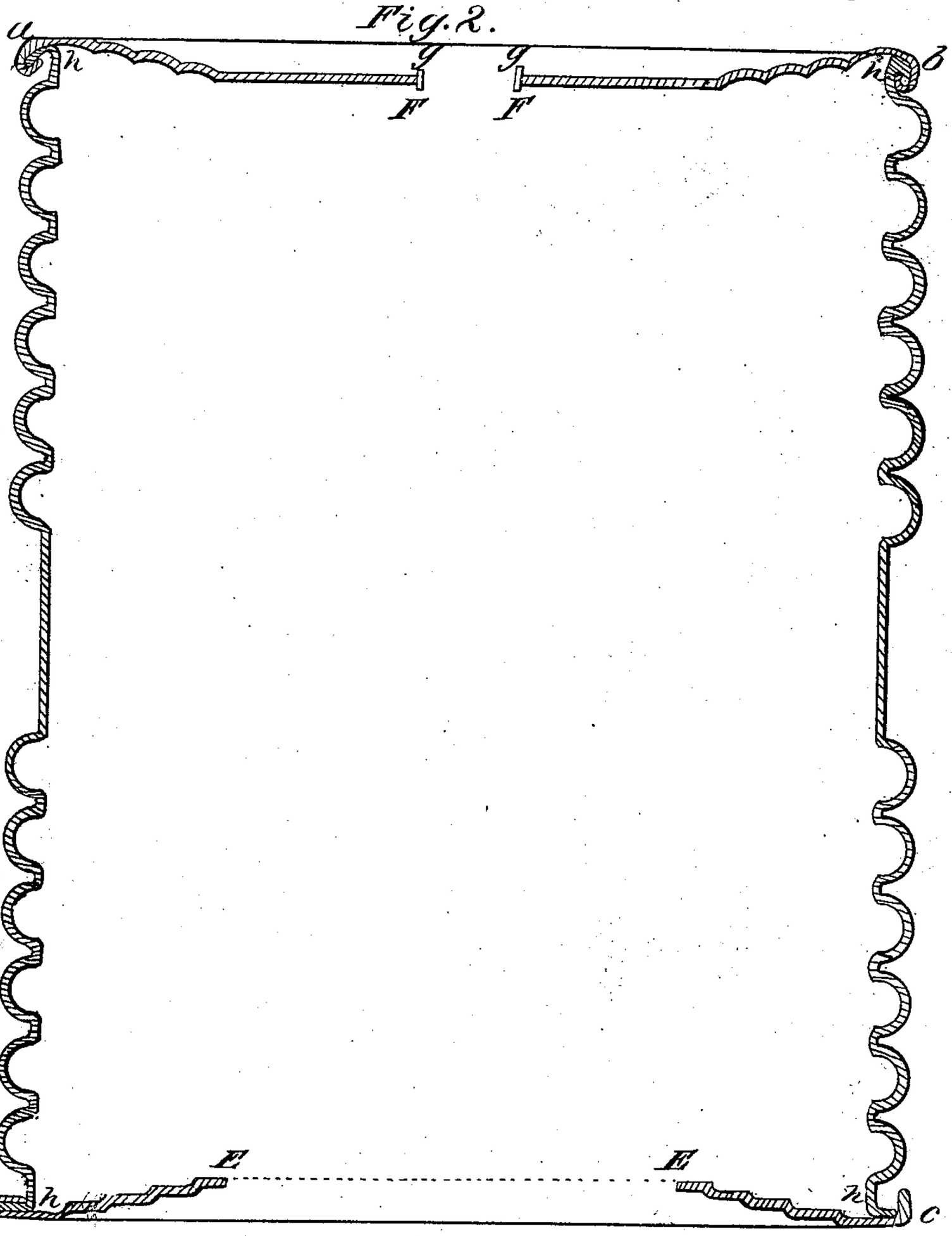

Fig. 1.

Witnesses.
H. Carey
A. B. Shearer

Inventors.
Joseph B. Fleming
Daniel J. Fleming

United States Patent Office.

JOSEPH B. FLEMING AND DANIEL J. FLEMING, OF XENIA, OHIO.

Letters Patent No. 82,818, *dated October* 6, 1868.

IMPROVEMENT IN THE CONSTRUCTION OF POWDER-KEGS.

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, JOSEPH B. FLEMING and DANIEL J. FLEMING, of Xenia, in the county of Greene, and State of Ohio, have invented an Improvement in Powder-Kegs, metallic cylinders, and cans, and also in the manufacture of the same, which said improvement applies to all water-tight seams in metallic cylinders, of which the following is a full and exact description, reference being had to the accompanying drawing, making a part of this specification, in which—

Figure 1 represents the head of the keg-cylinder or can, as constructed by us.

Figure 2 shows the position of the head when attached to the keg-cylinder or can.

The nature of our invention consists in constructing both the heads of the keg, cylinder, or can, of tin, sheet iron, brass, copper, or zinc, or a combination of any two or more of said metals in the construction of the said kegs, cylinders, or cans, the heads of said kegs, cylinders, or cans being constructed with a shoulder and external flange, and in employing a mandrel or other instrument at *h h h h*, on the inside, in order to form the double seam, which unites the head to the cylinder, keg, or can, thus forming a solid and substantial support to the cylinder, more cheap and durable than any method of uniting the heads to the cylinder heretofore adopted. This is effected by first putting on the head *d c*, and then the other head, *a b*, and then soldering on the cap or centre of the head, E E.

The opening F F is a Britannia female screw, fastened and closed by a Britannia cap and screw *g g*. Hitherto it has been practicable to double-seam one head by inserting a mandrel within the cylinder. By the means of this, our invention, both heads can be put on in precisely the same way, viz, by the use of the mandrel on the inside of the cylinder, after which the cap E E can be soldered on, as aforesaid, thus making easy what has hitherto been deemed impossible.

Having thus described our invention, we do not claim broadly a metallic keg or can, but

What we do claim as new, and desire to secure by Letters Patent, is—

1. The process of making sheet-metal kegs, cans, &c., as above described, the essential feature of which process consists in leaving a large opening, E E, in the head that is last attached, through which opening a mandrel is inserted, upon which to form the joint around the edges or chimes, after the removal of which the opening is closed up by means of a piece soldered over it.

2. A keg or can, constructed as above set forth.

In witness whereof, we have hereunto set our hands and seals, this 28th day of January, A. D. 1868.

JOSEPH B. FLEMING. [L. S.]
DANIEL J. FLEMING. [L. S.]

Witnesses:
W. A. HAWLY,
H. CAREY.