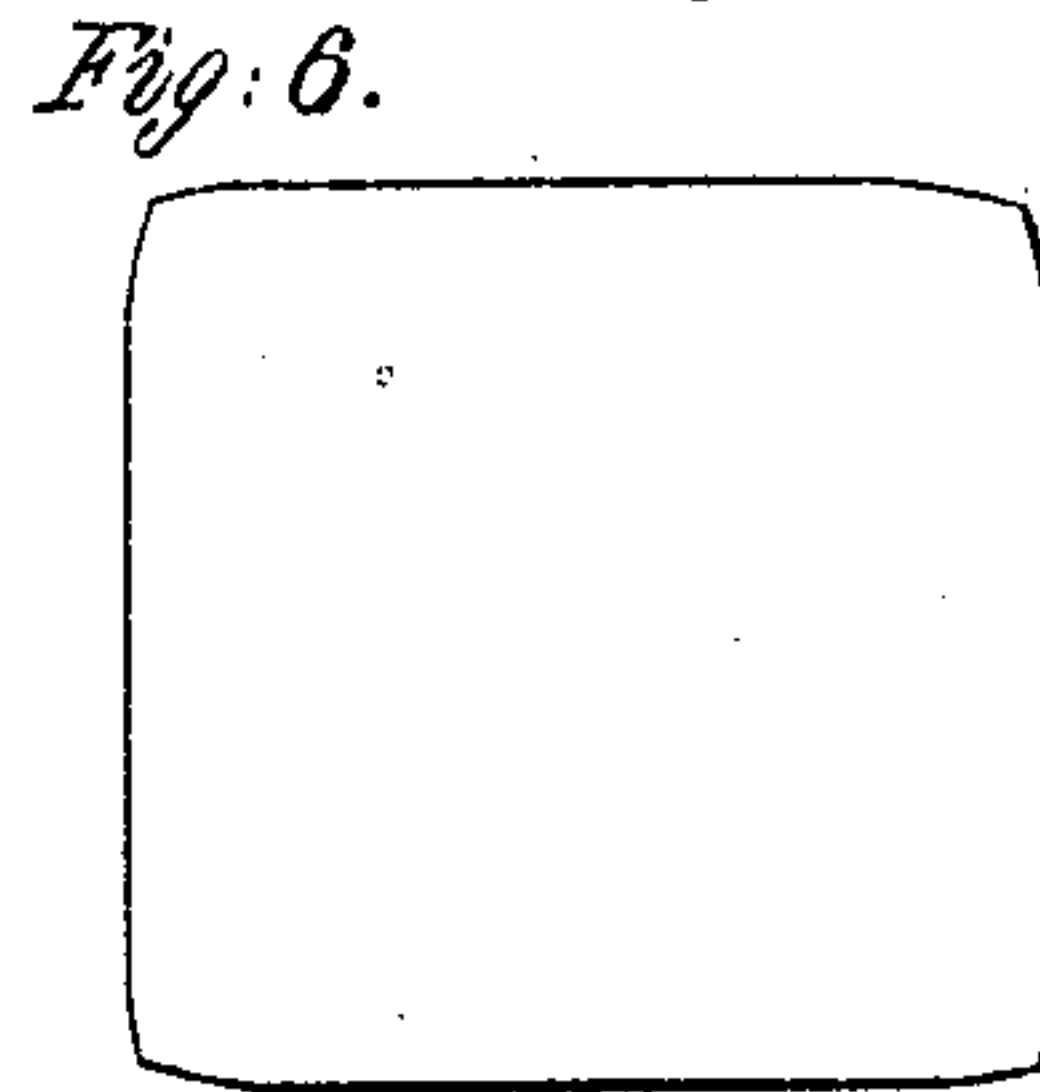
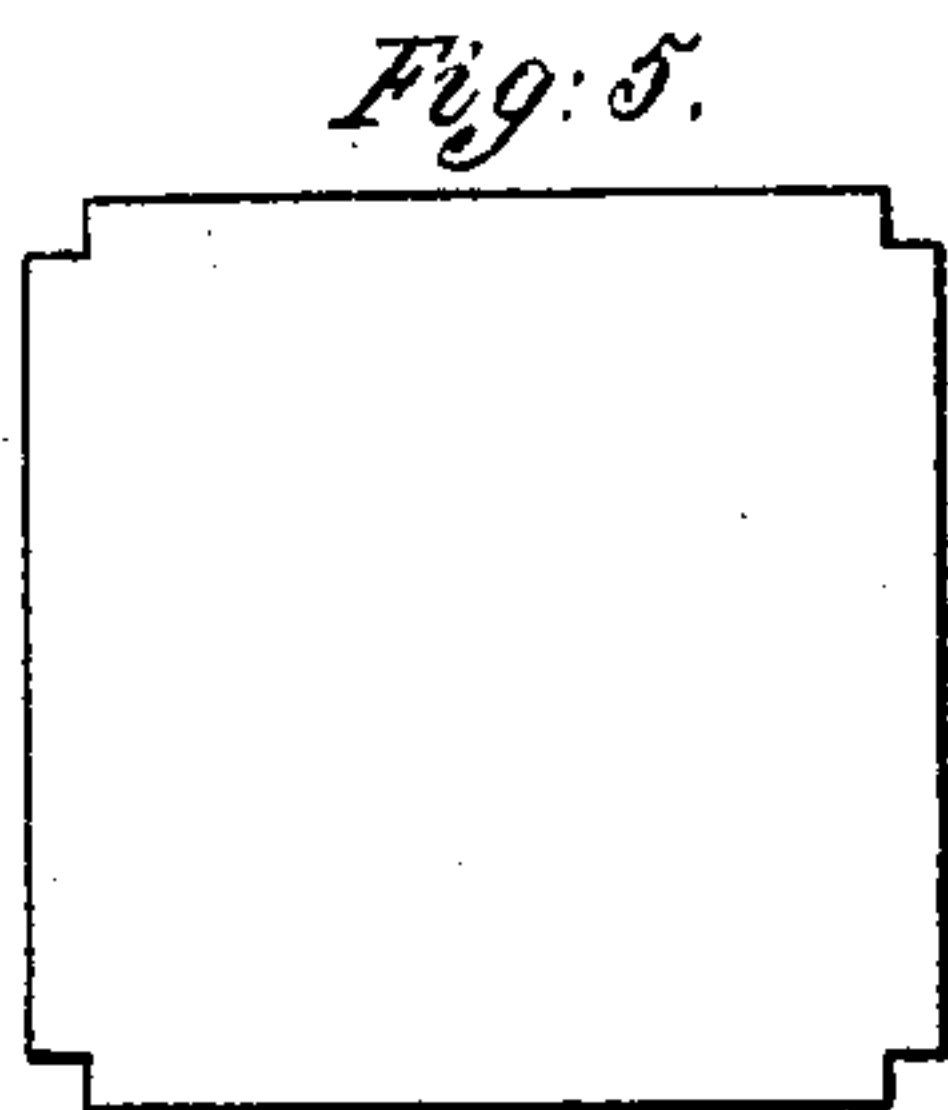
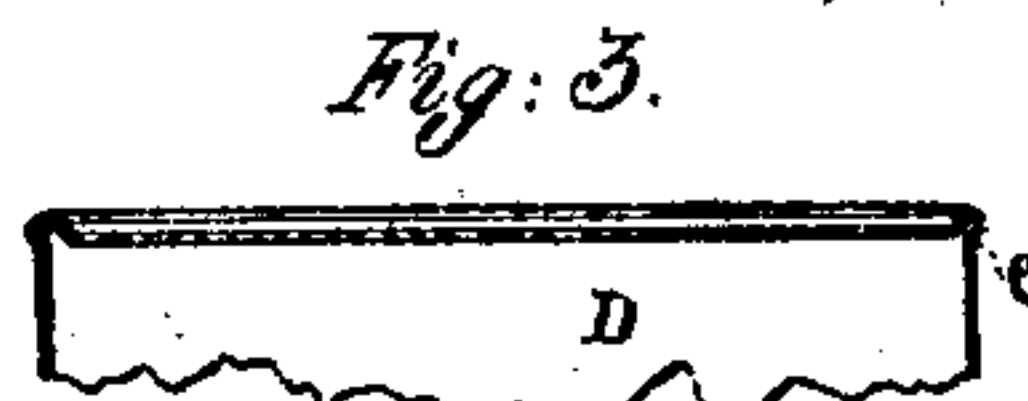
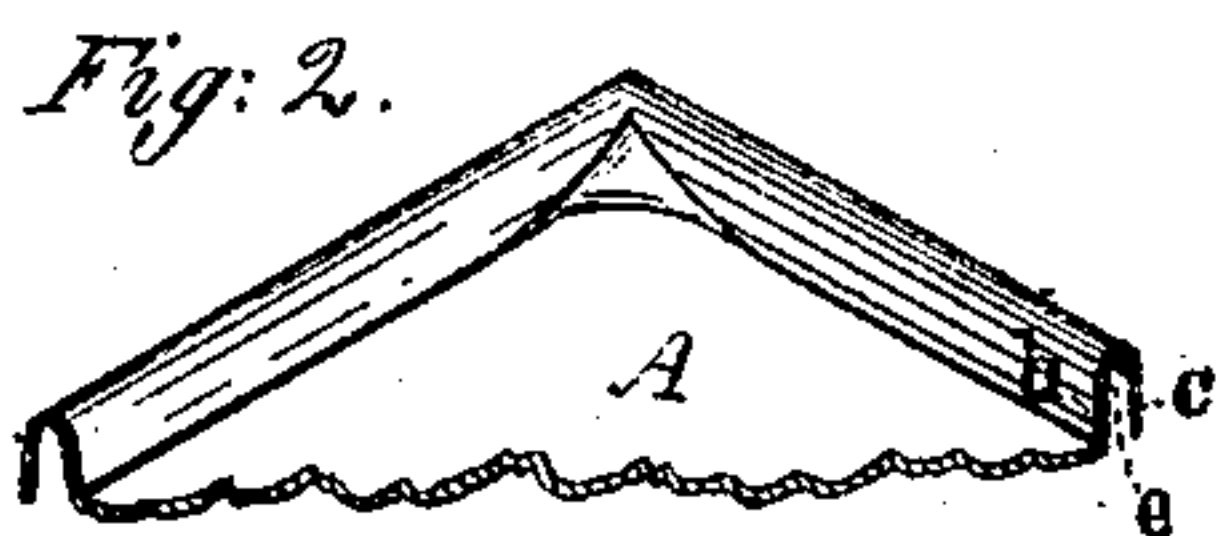
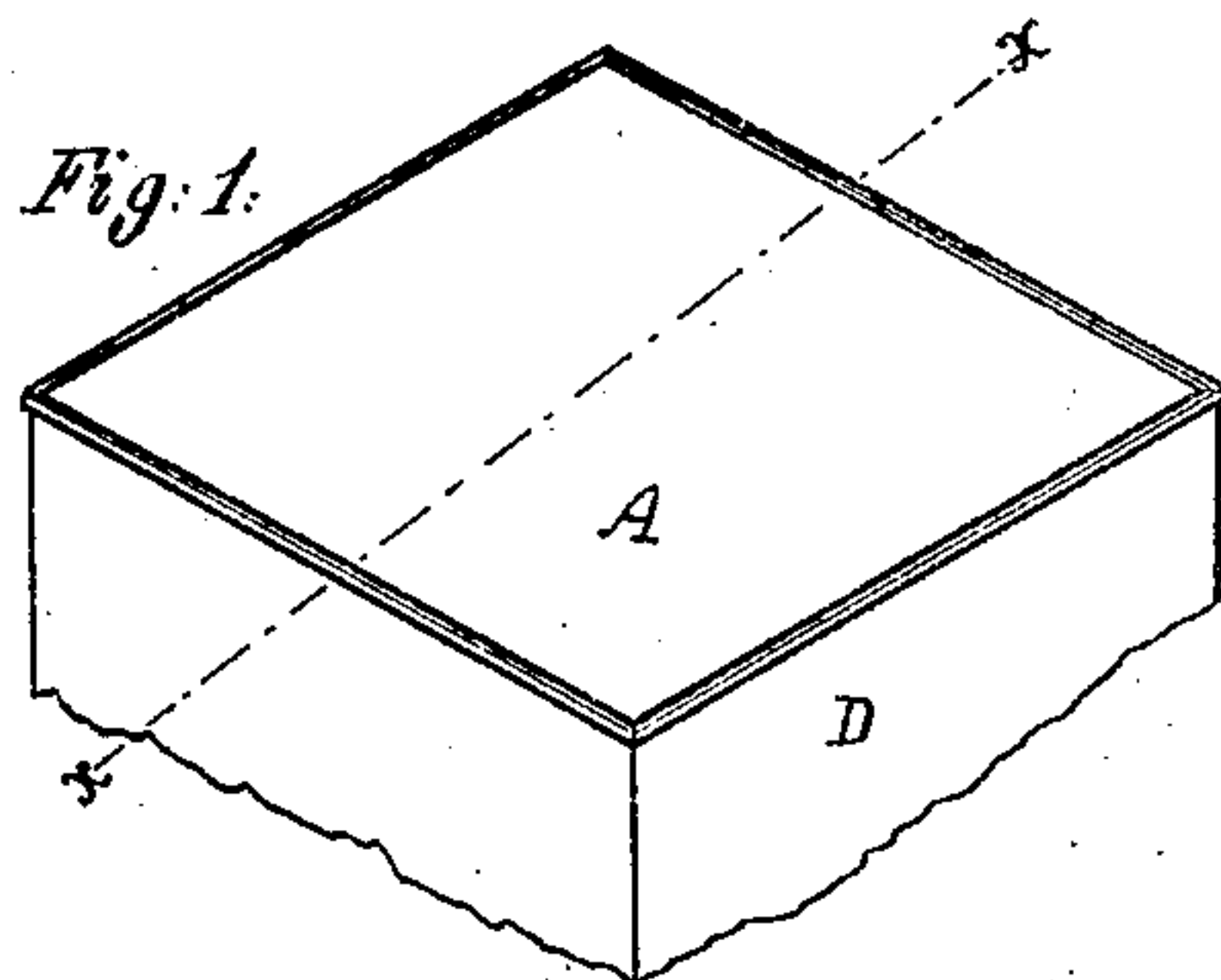


EDWARD T. COVELL.

Improvement in Heads for Rectangular Cans.

No. 121,490.

Patented Dec. 5, 1871.



Witnesses.

*H. H. Young*  
*E. A. Dick*

Inventor.

*Edward T. Covell*

*By David A. Brown*  
*att'y.*

# UNITED STATES PATENT OFFICE.

EDWARD T. COVELL, OF BROOKLYN, NEW YORK.

## IMPROVEMENT IN HEADS FOR RECTANGULAR CANS.

Specification forming part of Letters Patent No. 121,490, dated December 5, 1871.

*To all whom it may concern:*

Be it known that I, EDWARD T. COVELL, of Brooklyn, in the county of Kings and State of New York, have invented an Improved Head-Plate for Rectangular Sheet-Metal Cans, of which the following is a specification:

My invention relates to an improvement in the construction of that form of end or head-plates for rectangular sheet-metal cans in which a hook-shaped flange is turned up along the edges of the plate, to project above the upper face thereof at a right angle thereto, or nearly so, so that the channel in said flange shall receive, fit down upon, and embrace the simple straight edges of the plate forming the body of the can; and it consists in so forming the corners of each end plate as that its projecting hook-shaped flange shall present a perfect angle, without break or seam, and without interruption of the inner groove or channel formed by and embraced between its folds; the object of my invention being to remedy the tendency to leakage at the corners which exists in cans closed with end plates formed with hook-shaped flanges embracing the straight edges of the body thereof, where the corners of the end plates are cut out to form an angle in the flange thereof, as has heretofore been the practice.

In the accompanying drawing, Figure 1 is a view in perspective of one of my improved head or end plates when fixed upon a can; Fig. 2, an enlarged view of a corner broken away; Fig. 3, a vertical section in line *x x* of Fig. 1; Fig. 4, a similar section through one of the corners of the can; Figs. 5 and 6, views of blanks to form end plates; and Fig. 7, a view of one of the corners as heretofore made.

A is an end plate or head-plate made in pursuance of my invention. *b*, Fig. 2, is the first, and *c* the second fold of its hook-shaped flange. The first fold *b* is bent up at right angles, or nearly so, to the face of the end plate A, and the second fold *c* is bent over parallel to the first, so as

to include and form a deep groove or channel, *e*, between the two. D is the body of a can whose edges are left straight and plain to pass up into the groove or channel *e* of the flange *b c*, as shown in Fig. 3. Heretofore this form of head or end plate, provided with a hook-shaped flange, has been made from a blank having its corners cut out, as illustrated in Fig. 5 of the drawing, forming a corner, as illustrated in Fig. 7, in which the flange is divided, leaving an opportunity for leakage at this point. In my invention the head is stamped up from a blank of substantially the form illustrated in Fig. 6, between dies so shaped as that the outer fold of the flange shall be formed between them into a sharp angle at the corner of the plate, while the inner fold shall be narrowed in depth just as it approaches the corner from either direction, so that it will produce a sharp angle at the upper edge only in said corner, and be curved or rounded below, as illustrated in Fig. 2 of the drawing.

By this peculiar formation of the inner fold, which I have invented as the result of long-continued experiments, the two folds of a right-angle hook-shaped flange projecting above the plate are made to form an unbroken corner, in which the channel of the flange will remain unobstructed, as herein illustrated, and which will form so close a joint as to effectually prevent all danger of a leakage thereat.

I claim, therefore, as my invention—

Unbroken, seamless corners, formed substantially as herein described, in combination with the within-described hook-shaped flange formed upon the edges of a rectangular plate to receive the edges of the sides of a rectangular can and form a joint therewith, substantially as and for the purpose herein set forth.

EDWARD T. COVELL.

Witnesses:

CHARLES H. WOODBURY,  
T. C. HUXLEY.

(136)