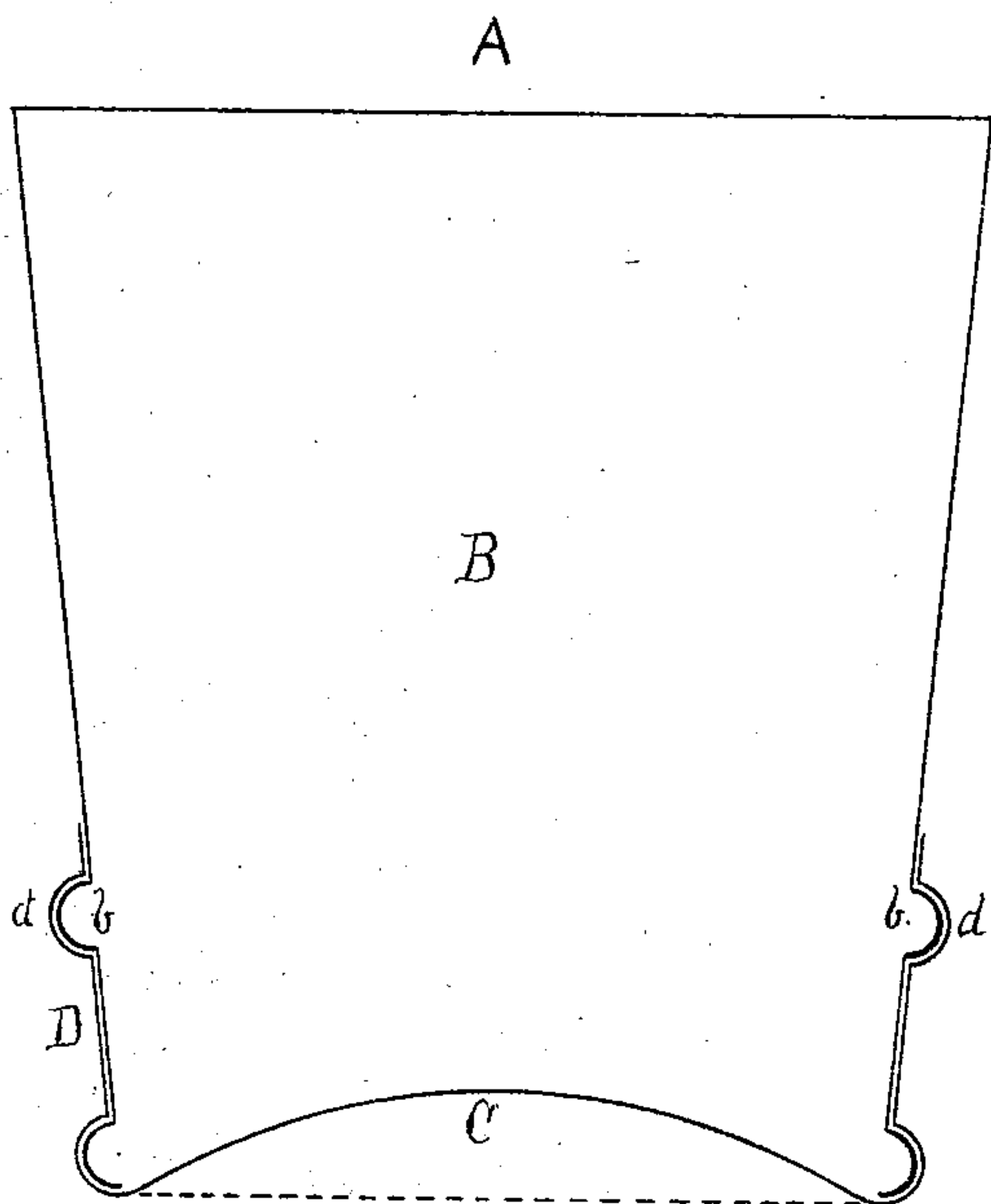


H. W. SHEPARD.
Sheet-Metal Vessels.

No. 135,855.

Patented Feb. 11, 1873.



WITNESSES.
Edwin James.
K. V. Gordon.

INVENTOR.
Henry W. Shepard.
per J. E. S. Holmead.
Attorney.

UNITED STATES PATENT OFFICE.

HENRY W. SHEPARD, OF NEW YORK, N. Y.

IMPROVEMENT IN SHEET-METAL VESSELS.

Specification forming part of Letters Patent No. 135,855, dated February 11, 1873.

To all whom it may concern:

Be it known that I, HENRY W. SHEPARD, of the city, county, and State of New York, have invented certain new and useful Improvements in Metallic Pails, of which the following is a full, clear, and exact description, reference being had to the accompanying drawing and the letters of reference marked thereon making part of this specification, in which is represented a vertical sectional view of my improved pail.

The nature of my invention consists in securing a bottom and an outer hoop, formed out of one piece of metal, to the cylinder or body of the pail or other vessel by bead or groove connections.

The construction and operation of my invention are as follows: A is the pail or other vessel. The body or cylinder B I propose to make of black iron, instead of sheet-tin. Tin of sufficient dimensions to permit of the cylinder of an ordinary-sized pail being formed out of a single sheet is so expensive as to have rendered its use by manufacturers entirely impracticable. Consequently these cylinders have heretofore been invariably constructed out of small sheets, soldered together, leaving in each cylinder numerous seam-joints, and which to secure involves both labor and expense, and, besides, are most objectionable, especially in milk-pails, owing to the great difficulty in keeping the same clean. But when black iron is used in the construction of the cylinder, as I design doing, the entire cylinder is formed out of one piece and connected by a single-lap seam. C is the bottom, and may be convex or flat, as indicated in dotted lines on the drawing, or of any other desired form, and D is its outer hoop. The

bottom C and hoop D are stamped or otherwise formed out of a single piece of metal. *d d* are two beads or grooves on the hoop, one at its base and the other at its upper section. On the cylinder B there are corresponding beads or grooves *b b*, and which are designed to enter and fit in the beads or grooves *d d*, and through which arrangement of beads or grooves, at an immense saving of labor and without the expense of solder, a permanent connection between the cylinder, bottom, and hoop is effected, the beads or grooves uniting the parts of the pail so firmly together that the tinning makes it, as it were, one solid piece.

The great advantage of the pail constructed as herein described is found in its durability, simplicity of construction, and cheapness of manufacture, saving, as it does, the expense of solder and labor of soldering.

What I claim as new, and desire to secure by Letters Patent of the United States, is—

As a new article of manufacture, the pail or vessel A, consisting of the cylinder B formed with a single-lap joint and having beads or grooves *b b*, the bottom C, and hoop D, when the latter is formed with beads or grooves *d d*, and out of the same piece of metal with the bottom, the whole being constructed, combined, and arranged substantially as described.

In testimony whereof I have signed my name to this specification in the presence of two subscribing witnesses.

H. W. SHEPARD.

Witnesses:

WM. P. CRAGIN,
BIRNEY J. MOORE.