

H. H. ROE.
Top-Hoops for Milk-Cans.

No. 156,595.

Patented Nov. 3, 1874.

Fig. 1.

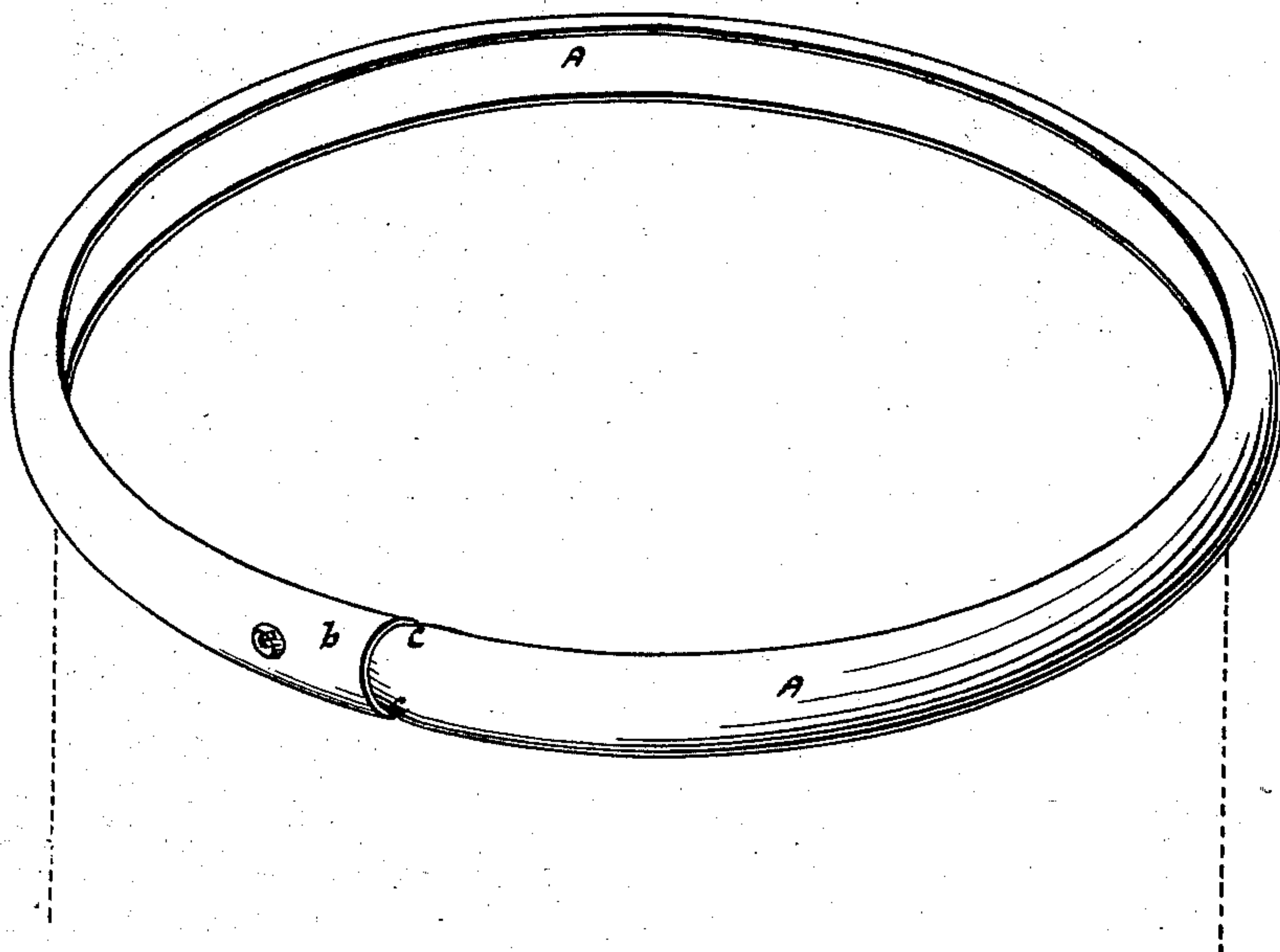
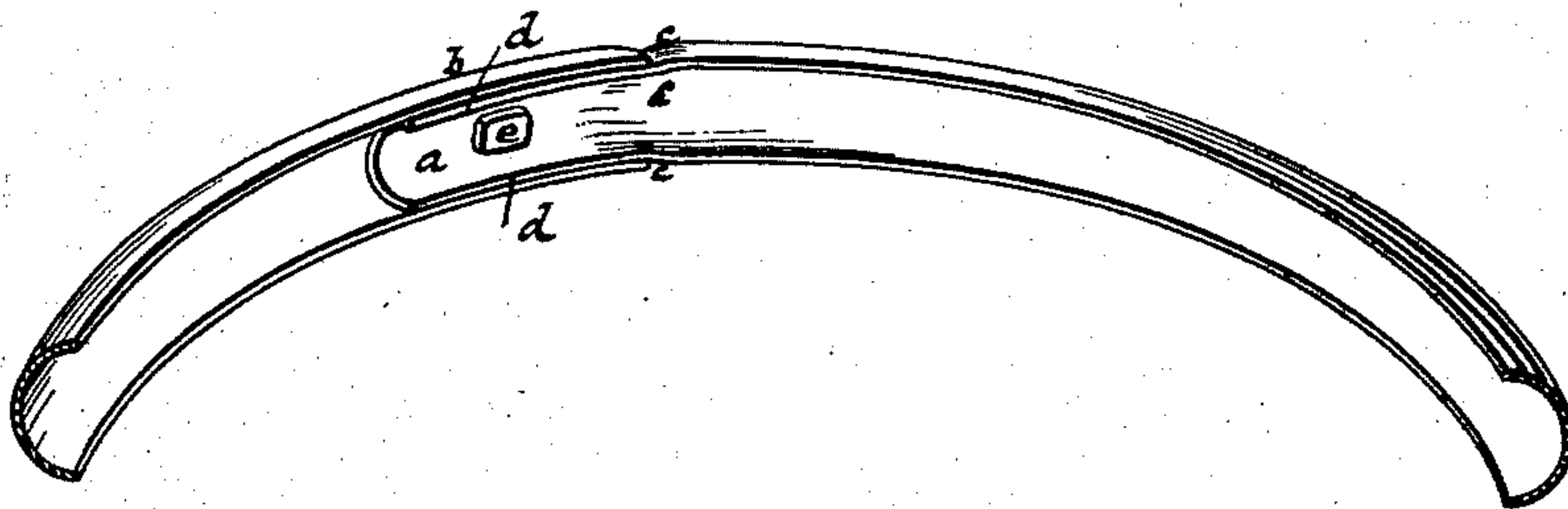


Fig. 2.



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UNITED STATES PATENT OFFICE.

HENRY H. ROE, OF MADISON, OHIO.

IMPROVEMENT IN TOP-HOOPS FOR MILK-CANS.

Specification forming part of Letters Patent No. **156,595**, dated November 3, 1874; application filed September 28, 1874.

To all whom it may concern:

Be it known that I, HENRY H. ROE, of Madison, Lake county, Ohio, have invented certain new and useful Improvements in Top-Hoops for Milk-Cans, of which the following is a specification:

The top-hoop, or hoop encircling the upper edge of a milk-can, has been made of a solid half-round strip or bar of metal, bent into hoop form, with its ends welded together. It has also been made of a concavo-convex strip, bent in a similar way, with its ends fastened together. The latter form of hoop is that to which my invention refers, and is preferable to the first named, being so much lighter that, notwithstanding the iron for the hollow or concavo-convex hoop costs more per pound than the solid hoop, the total cost of manufacture is less. It is also much better in many other respects—more readily put on the can, &c.

My improvement relates to the joint by which the two contiguous ends of the concavo-convex strip are united.

The accompanying drawing will enable one skilled in the art to understand the nature of my improvement, and the manner in which the same is to be carried into effect.

Figure 1 is a perspective view of the hoop, the dotted lines representing a portion of the sides of the can to the top edge, to which the hoop is applied. Fig. 2 is a perspective view from the inside of that portion of the hoop containing the joint.

A is the hoop made of a concavo-convex strip of metal, preferably of wrought-iron, bent into hoop form, and with its two ends brought together so as to overlap one another. The inside end *a* is drawn in by striking up in a reduced die, or by other suitable means, forming a shoulder at *c*, and this drawn-in portion fits within the concave of the other end *b*. The end *a* is so shaped and trimmed that its edges *d* will be flush with the adjoining edges of the outer end *b*, so that the inner edges of the hoop will be in a smooth, true and continuous curve. The outer face of the hoop will also be practically smooth and continuous, the end *a* being drawn in to such an extent that the height of shoulder *c* will equal

the thickness of the overlapping part *b*, which abuts, or nearly abuts, against the shoulder. Thus the outer face of the hoop will be without break, except a small groove at the junction of the part *b* and shoulder *c*, which groove is partly filled up when the hoop, after being made, is tinned.

The two lapped ends *a b* are pierced with a rivet-hole, and are then riveted together, as seen at *e*, after which the hoop is tinned.

A hoop thus made possesses material advantages over others heretofore made. By lapping the ends the hoop is "trued up," the curve at the joint being made and maintained true more readily and permanently than is the case when the ends, instead of lapping, simply abut, and are riveted to an inside separate piece—such, for instance, as a malleable casting, which has been used for this purpose. Then again the two lapping ends of the hoop will be to a certain extent cemented or bound together by the process of tinning, thus adding to the strength of the joint. Further, it is necessary to set but one rivet, and, consequently, but one rivet-head appears on the surface of the hoop, possessing in this respect a decided advantage over the joint in which each end of the hoop is riveted, independently of the other, to an inside clip.

By my method I not only dispense with any clip, but avoid multiplication of rivets.

In lieu of forming a shoulder on the inner end *a* of the hoop, the outer overlapping end *b* may be expanded so as to form the shoulder on inside or concave thereof, in which case the inner end *a* will fit in the expanded part of end *b*, and against the shoulder formed in the same.

I prefer, however, on many accounts, the arrangement first above described.

The manner of applying the hoop to the can is well known to those skilled in the art to which this invention pertains, and requires no description here.

It will, of course, be understood that the hoop is applicable to cans whether used for holding milk, or for containing other matters.

In conclusion, I would state my claim, as follows:

A top-hoop for milk-cans, consisting of a concavo-convex metallic strip bent into hoop shape, one of its ends being drawn in, and shaped to fit and be contained within the concave of the other overlapping end, and the two being united by riveting, as shown and described.

In testimony whereof, I have hereunto signed my name this 25th day of September, A. D. 1874.

HENRY H. ROE.

Witnesses:

D. THOMAS,
A. J. COVELL.