H. WRIGHT.

Jug-Top.

No. 163,560. Patented May 18, 1875.

Fig. 1.

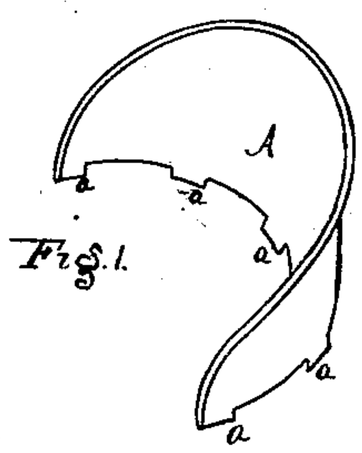


Fig. 6

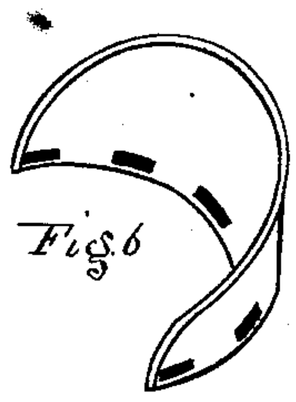


Fig. 7.

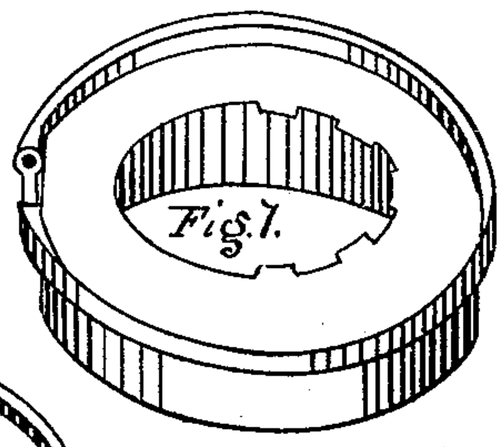


Fig. 2

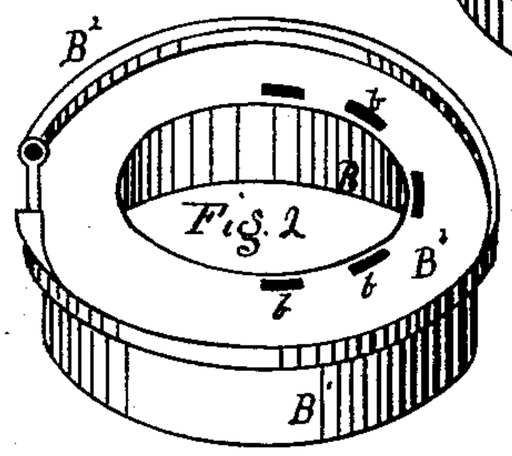


Fig. 4

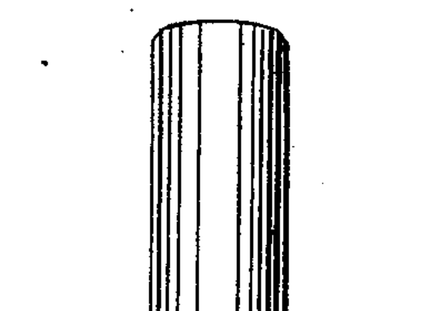


Fig. 3.

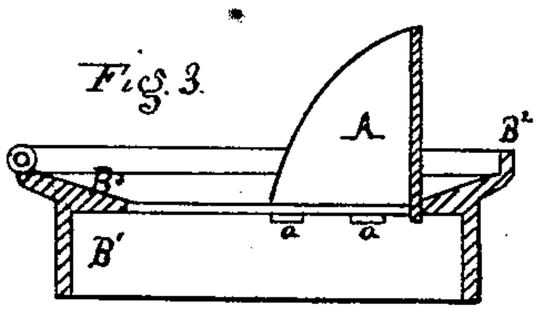


Fig. 5.

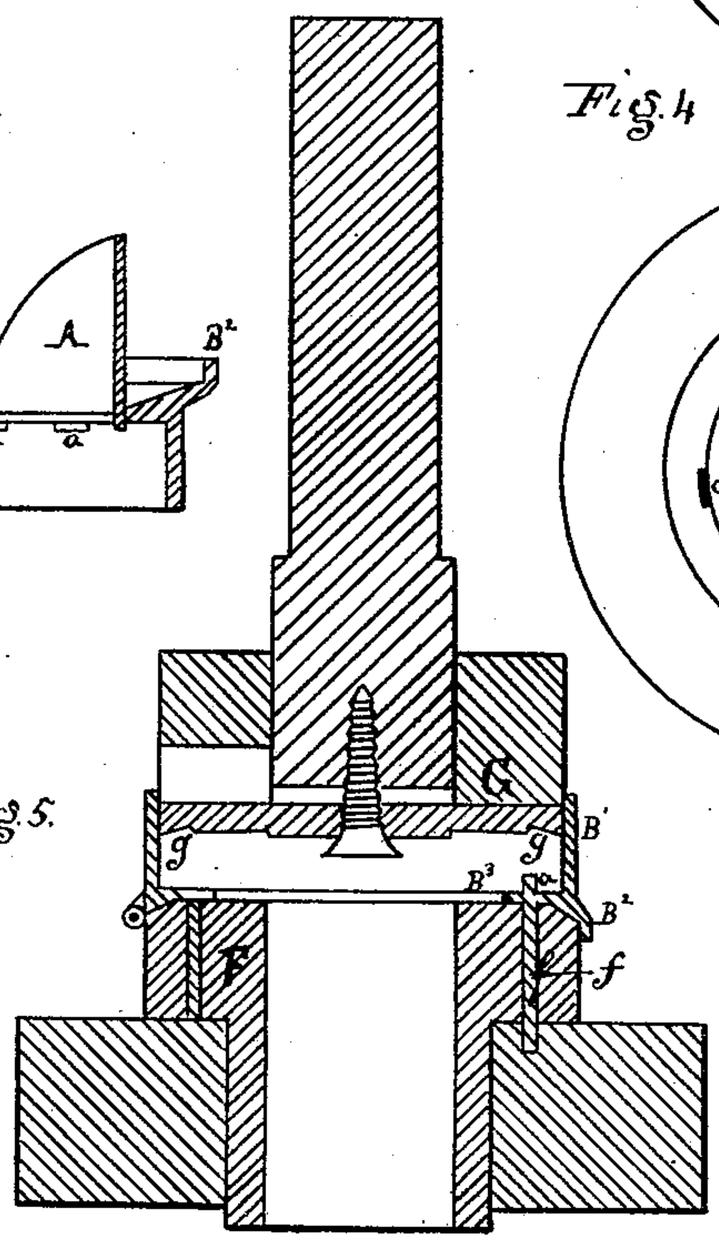
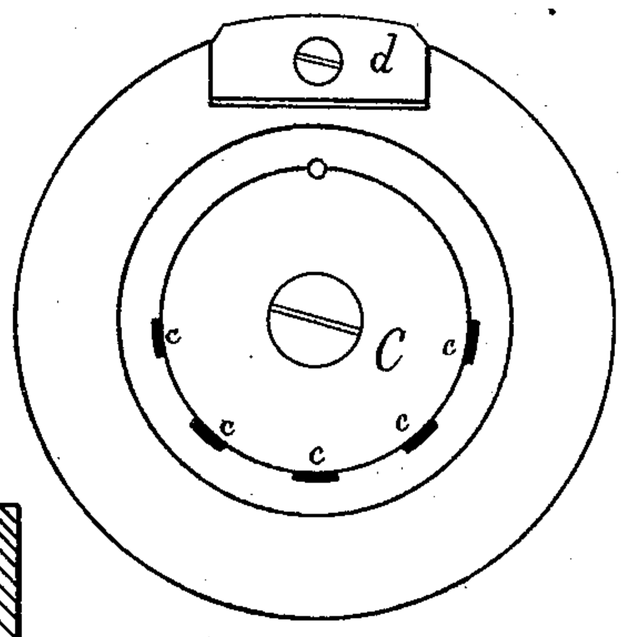


Fig. 4



WITNESSES

Walter S. Reese.

James D. Kay

INVENTOR

Homer Wright

by Bakewell & Kerr

Attys

THE GRAPHIC CO. PHOTO-LITH. 39 & 41 PARK PLACE, N.Y.

UNITED STATES PATENT OFFICE.

HOMER WRIGHT, OF PITTSBURG, PENNSYLVANIA.

IMPROVEMENT IN JUG-TOPS.

Specification forming part of Letters Patent No. **163,560**, dated May 18, 1875; application filed November 17, 1874.

To all whom it may concern:

Be it known that I, HOMER WRIGHT, of Pittsburg, in the county of Allegheny and State of Pennsylvania, have invented a new and useful Improvement in the Manufacture of Jug-Tops; and I do hereby declare the following to be a full, clear, and exact description thereof, reference being had to the accompanying drawing, forming a part of this specification, in which—

Figure 1 is a perspective view of an inner lip. Fig. 2 is a similar view of a jug-top body. Fig. 3 is a vertical section through the body and lip. Fig. 4 is a view of dies for punching the mortises in the jug-top body. Fig. 5 is a vertical section of the dies for clinching the tangs of the inner lip, and shows a top between the dies. Figs. 6 and 7 are modifications.

Like letters refer to like parts in the several figures.

My invention relates to jug-tops constructed so as to return the drippings or overflow to the jug in a jug-top having the inner sheet-metal lip secured to the body by means of tangs upon the one and slots or mortises in the other.

Heretofore, in the construction of jug-tops of this class, various methods have been adopted for securing the inner lip to the body. In some cases the lip has been cast with the body, in others the lip has been first formed from sheet metal and the body afterward cast upon it, while in still other cases the lip and body have been separately formed and subsequently joined by soldering. Each of these methods is subject to objections from various causes which need not be herein recited, the object of the present invention being to simplify the construction.

To enable others skilled in the art to make and use my invention, I will now proceed to describe the same.

A represents a lip, which, by means of suitable dies, I cut from sheet metal, forming upon the straight edge tangs or projections *a*, which enter mortises formed in the inner flange of the body. This lip is then bent into the general half-circular shape shown. I then form, by casting or otherwise, the body B, Fig. 2, having a collar, B^1, of sufficient size for the reception of the jug to which it is to be attached, the ring or cup B^2, and the flange B^3. This flange B^3 I provide with slots or mortises *b* around its inner edge, for the reception of the tangs of the inner lip, said tangs being, after their introduction through the slots, turned down to form the union between the lip and body. To facilitate the formation of the slots in the body B and the turning down or clinching of the tangs of the lips, I make use of two sets of dies, (illustrated in Figs. 4 and 5,) which I will now proceed to describe. C, Fig. 4, represents the face of the lower punch-die, which is provided with slots *c*, corresponding in number with the slots or mortises to be formed in the flange B^3 of the body-piece B. This lower die is shaped so as to receive and sustain the body B under the thrust of the upper die, and is provided with a guard, *d*, placed opposite the slots *c*, which guard registers with the hinge for the top, so as to retain the body in proper position for the formation of the slots. E is the face of the upper punch-die, which is provided with the projections *e*, corresponding in number with the slots in the face of the lower die, and arranged to register therewith. F, Fig. 5, represents the lower clinching-die, having beveled edges corresponding to the flange B^3, and provided with a slot, *f*, corresponding in width and depth with the lip A, which it receives. G is the upper die or ram used in riveting or clinching the tangs of lip A, and is grooved, as at *g*, so as to turn over or bend down the projecting tang and set it against the under side of flange B^3.

The operation of these devices is as follows: The body B of the jug-top, having been cast or otherwise produced with the inwardly-projecting flange B^3, is placed on the die C so that the hinge will correspond with the guard *d*, and the flange B^3 rest upon the face of the die. The upper die E then descends, punching out the mortises or slots *b* in the flange. The body is then removed from the die, and a lip of proper shape, and provided with tangs or projections *a*, formed as before described, is attached by passing the tangs *a* through the slots *b*, and the whole is then placed on the die F, the lip A entering the slot *f* of die F. The upper die G or ram then descends

and clinches or rivets the tangs, which are guided or turned over by the groove *g* in the face of the die, thus securely attaching the lip to the body, neatly, simply, and with little labor.

It is obvious from the above description that the slots might be made in the lip, as shown in Fig. 6, and the tangs on the flange B^3, as shown in Fig. 7, the two being thereafter joined, as before described, and this without departing from the spirit of my invention.

I am aware that it is common to secure the several parts of metal articles by means of tangs and notches, and lay no claim thereto; but

Having thus described my invention, what I claim, and desire to secure by Letters Patent, is—

The jug-top consisting of the lip A, body B, and drip-flange B^3, the lip being secured to the drip-flange by means of tangs upon one and slots in the other part, substantially as and for the purpose specified.

In testimony whereof I, the said HOMER WRIGHT, have hereunto set my hand.

HOMER WRIGHT.

Witnesses:
F. W. RITTER, Jr.,
W. N. PAXTON.