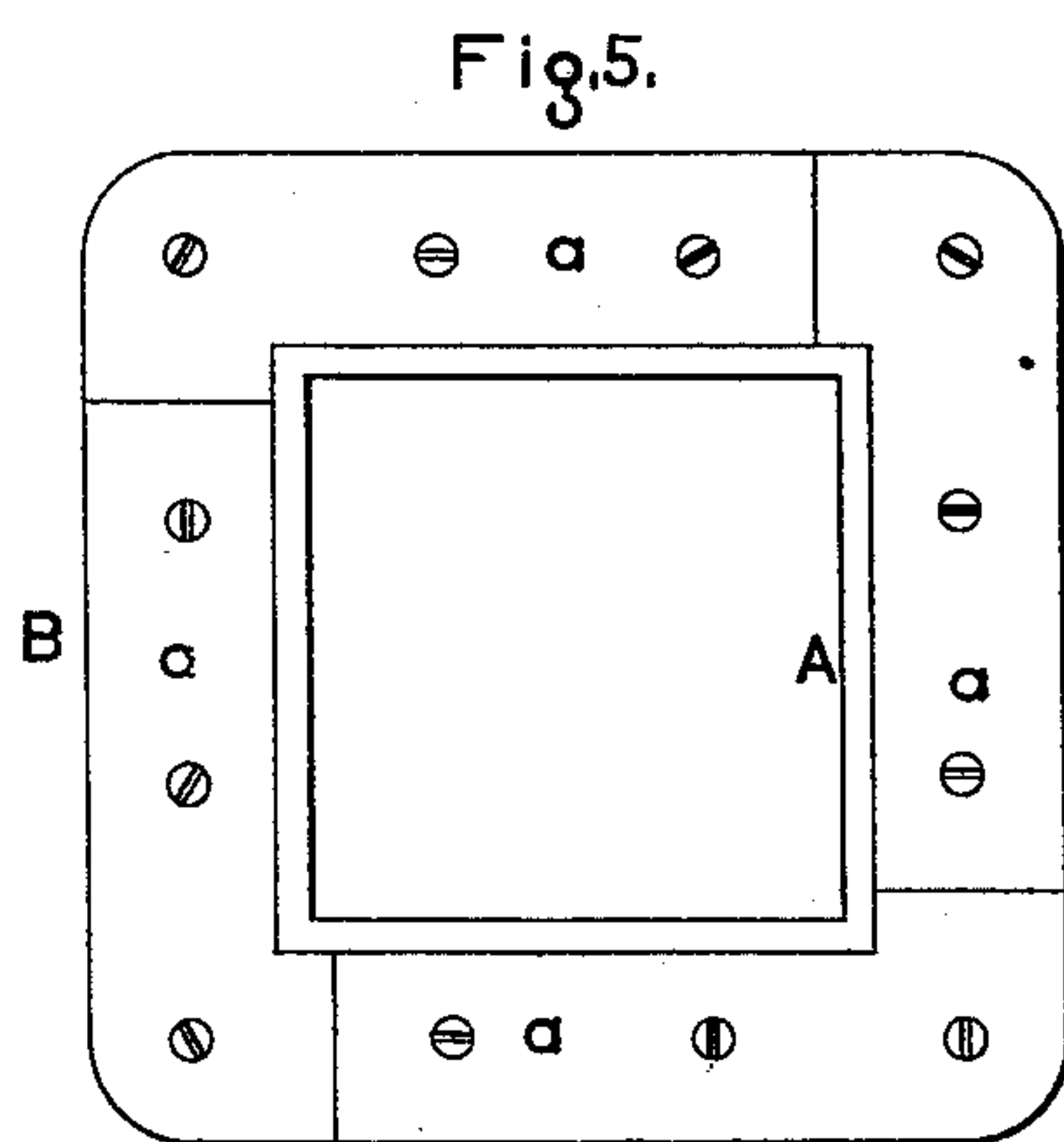
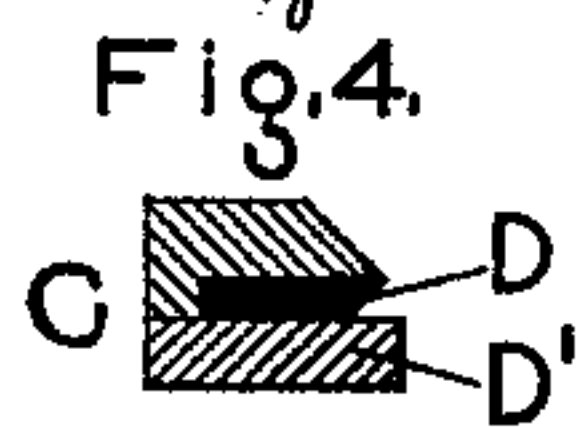
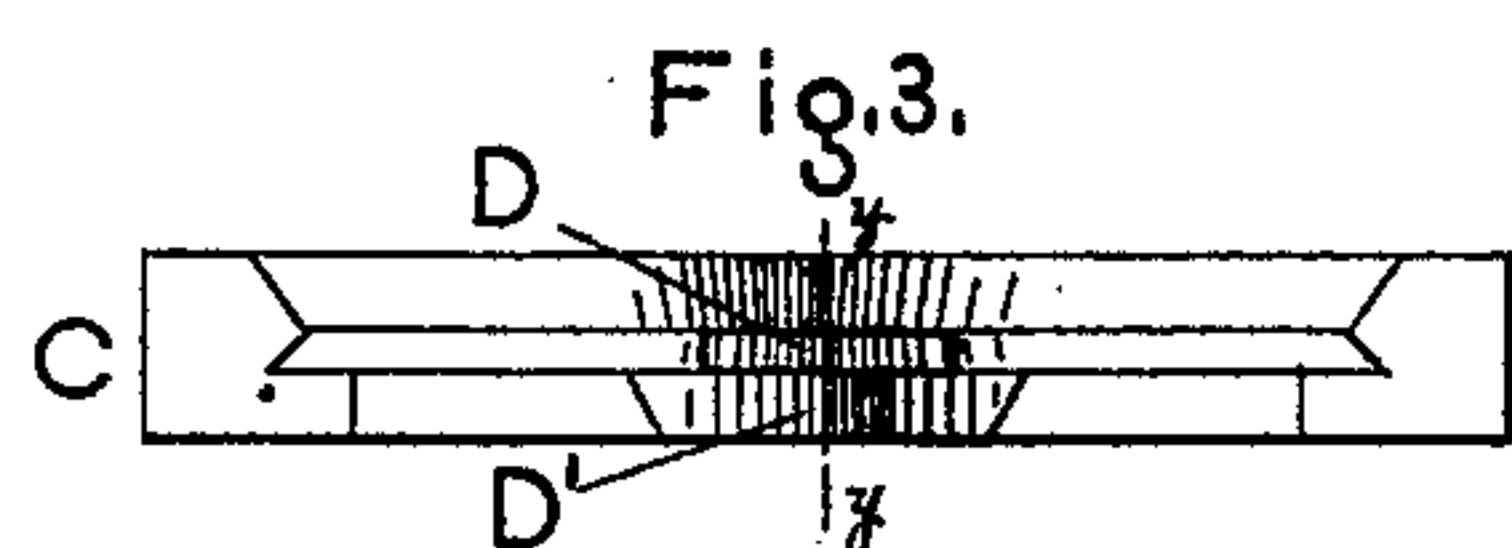
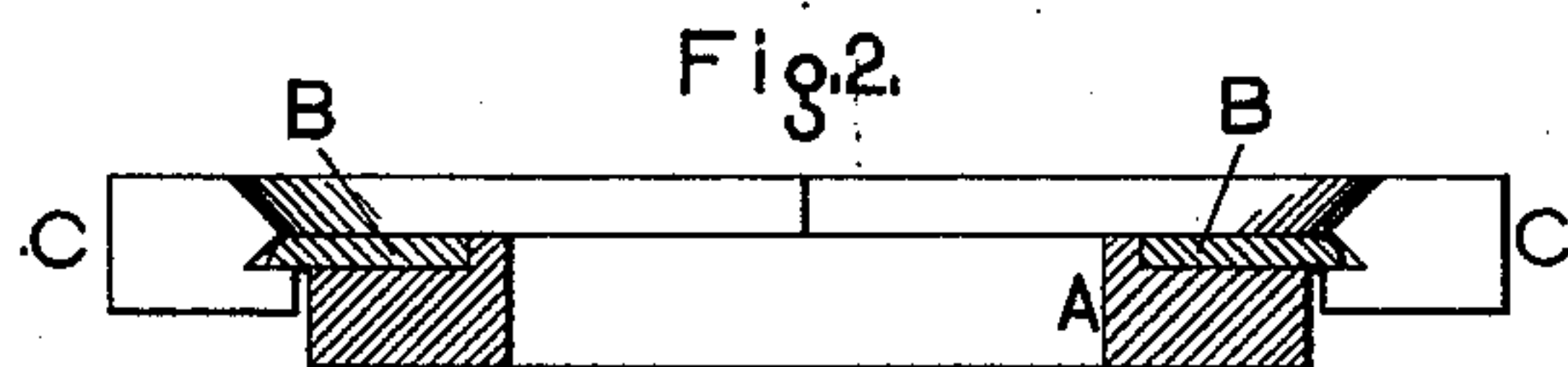
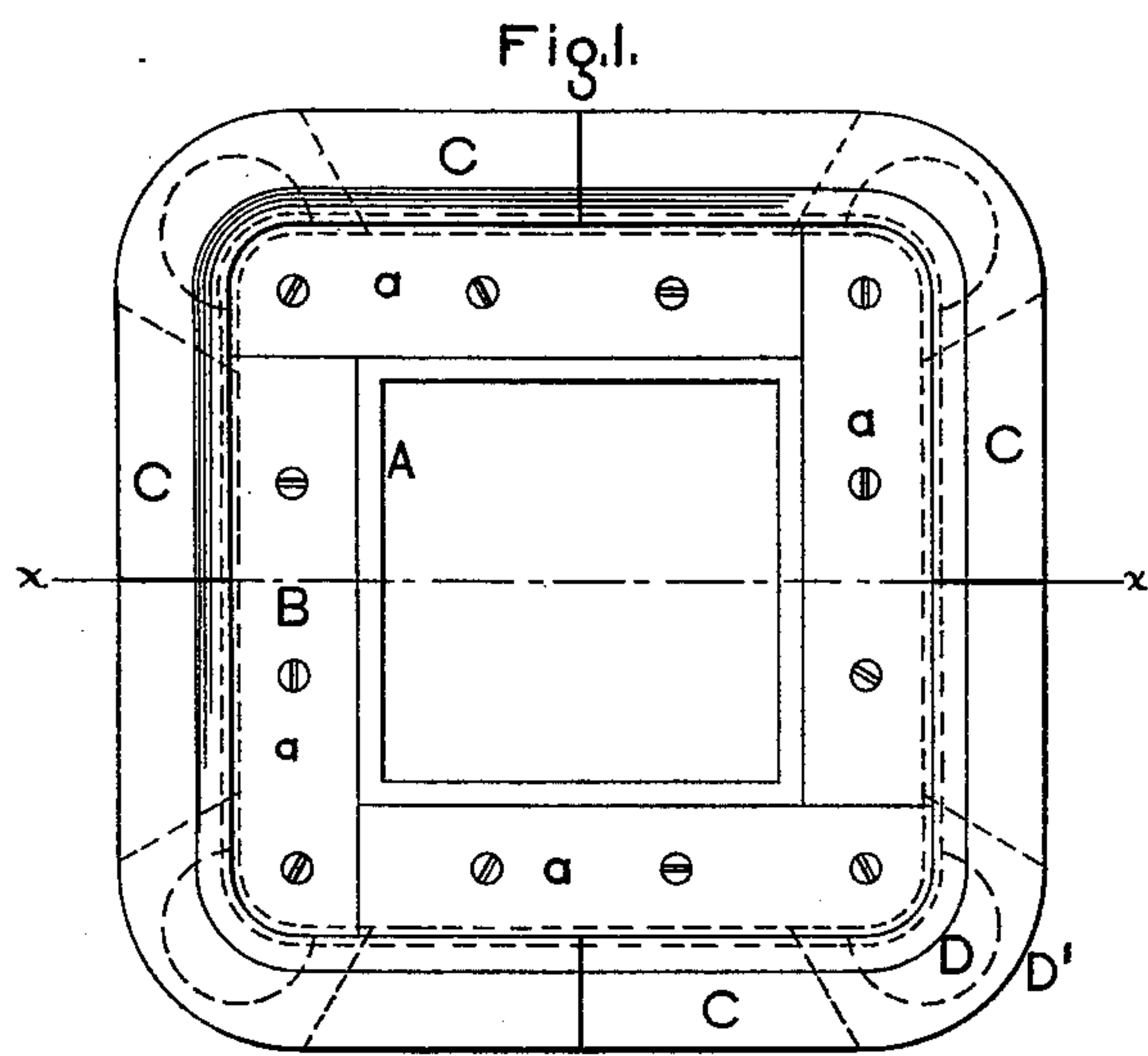


J. W. FARRELL.
Die for Making Sheet-Metal Cans.

No. 222,261.

Patented Dec. 2, 1879.



Witnesses:

So. P. Grant
W. D. Kircher

Inventor:

James W. Farrell
John A. Diederheim
ATTORNEY.

UNITED STATES PATENT OFFICE.

JAMES W. FARRELL, OF PHILADELPHIA, PENNSYLVANIA.

IMPROVEMENT IN DIES FOR MAKING SHEET-METAL CANS.

Specification forming part of Letters Patent No. **222,261**, dated December 2, 1879; application filed October 6, 1879.

To all whom it may concern:

Be it known that I, JAMES W. FARRELL, of the city and county of Philadelphia and State of Pennsylvania, have invented a new and useful Improvement in Dies for Making Sheet-Metal Cans, which improvement is fully set forth in the following specification and accompanying drawings, in which—

Figure 1 is a top or plan view of the apparatus embodying my invention. Fig. 2 is a vertical section thereof in line *x x*, Fig. 1. Fig. 3 is a view of an inner corner of one of the jaws of the apparatus. Fig. 4 is a vertical section in line *y y*, Fig. 3, one of the die-plates being shown in a solid black line. Fig. 5 is a plan view of a modification.

Similar letters of reference indicate corresponding parts in the several figures.

In the manufacture of sheet-metal cans it is customary to place the shaped bottom or top of the can on a support or bed, the lower edge of the body of the can resting in the grooves of said bottom or top. Suitable jaws or dies are then advanced against the grooved portions, the effect whereof is to squeeze and securely clamp together the body and the bottom or the body and the top. The strain consequent to such operations often breaks the flange or working-edge of the bed and the sliding jaws or dies, matters of considerable expense and inconvenience.

My invention consists in forming the flange of the bed of separate and removable matched plates, whereby, when the plates are broken, fractured, or worn, they may be removed and replaced by new ones, and so constructing and disposing the plates that joints at the corners of the flange are obviated.

It also consists in providing the corners of the squeezing jaws or dies with plates, which, when broken, fractured, or worn, may be readily removed and replaced by new ones.

Referring to the drawings, A represents the support or bed for sustaining the bottom of a can during the operations of securing the body and bottom or top thereof; B, the work-

ing-flange, and C the clamping or squeezing jaws or dies, which are actuated to move toward the can and close the seam of the body and bottom or top, as is well known.

The flange B is constructed of matched plates *a* separate one from the other, and removably connected to the bed A for displacement of old or broken plates, and application of new ones, and furthermore formed of quadrilateral pieces, so that one end of each plate abuts against the side of the contiguous plate, by which means I obviate joints at the corners of the flange, the same result being accomplished by constructing the plates right angular or L shape.

As the clamping or squeezing jaws or dies advance against the corners of the can the angles of said dies are subjected to strain and liable to break. I therefore cut away the corner of each die, so as to form therein an upper and lower horizontal pocket, preferably with dovetailed sides, and fit into the upper pocket a removable plate, D, which is adapted to work against the metal on the upper side of the flange B and into the lower pocket, a removable plate, D', to work against the metal on the lower side of said flange, it being noticed that there is a space between the working-faces of the plates, so as to receive said metal of the can against which the dies are advanced.

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

1. The bed provided with a flange formed of separate and removable matched plates, substantially as and for the purpose set forth.

2. The squeezing-dies C C, provided with upper and lower removable plates D D' fitted in pockets in the corners of said dies, substantially as and for the purpose set forth.

J. W. FARRELL.

Witnesses:

JOHN A. WEIDERSHEIM,
A. P. GRANT.