

(No Model.)

D. BLOCK.  
EAR FOR TIN PAILS.

No. 285,105.

Patented Sept. 18, 1883.

Fig. 1.

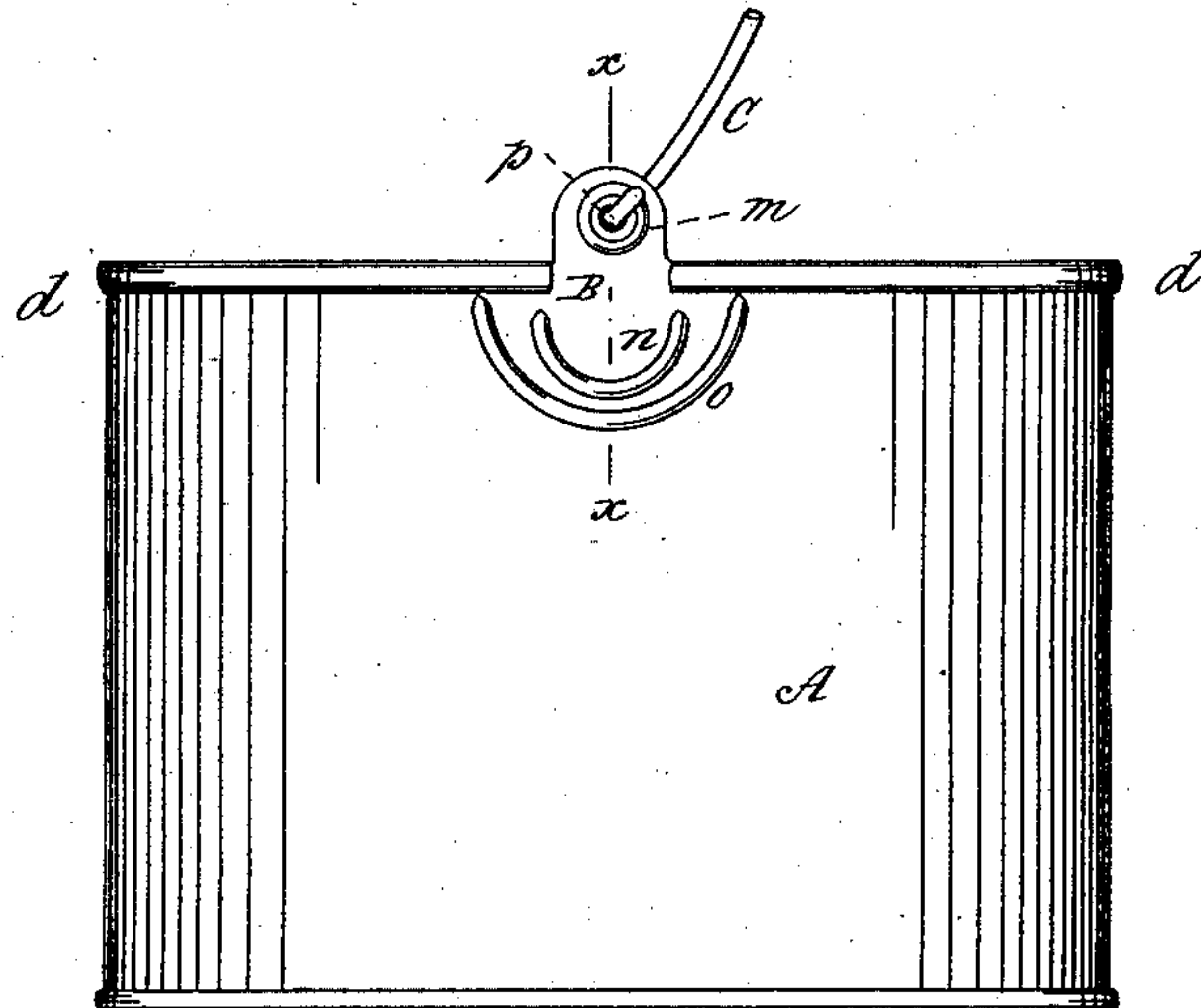


Fig. 2.

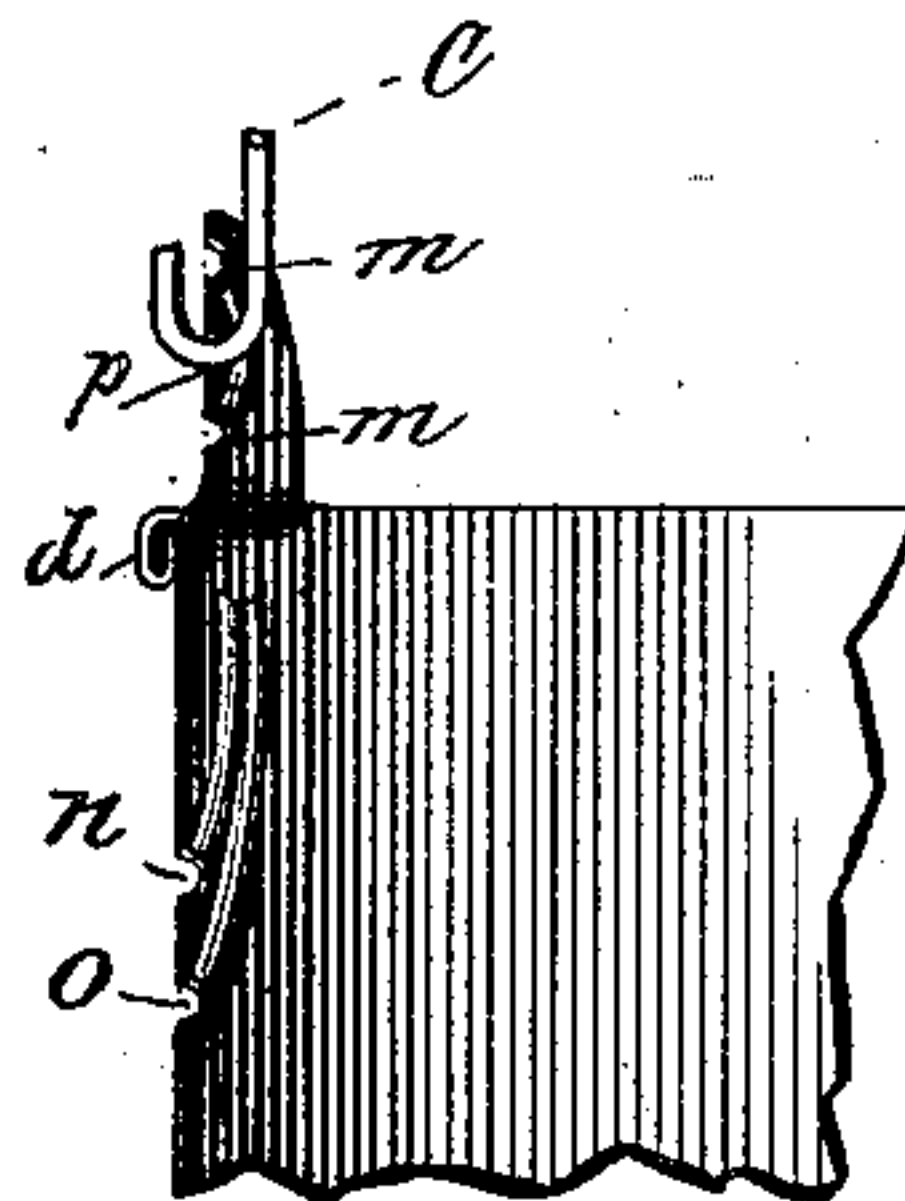
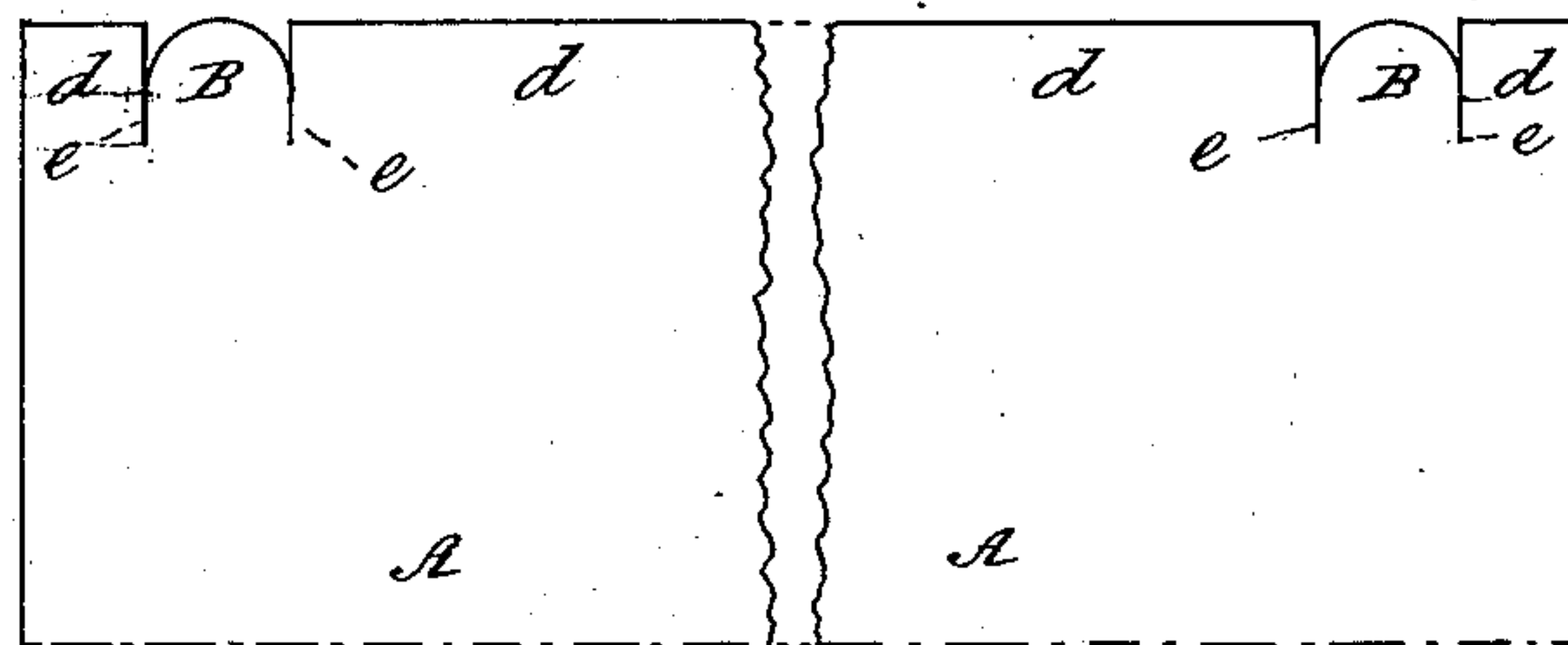


Fig. 3.



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# UNITED STATES PATENT OFFICE.

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## EAR FOR TIN PAILS.

SPECIFICATION forming part of Letters Patent No. 285,105, dated September 18, 1883.

Application filed August 6, 1883. (No model.)

*To all whom it may concern:*

Be it known that I, DAVID BLOCK, of the city of New York, in the county and State of New York, have invented a certain new and useful Improvement in Tin Pails; and I hereby declare the following to be a full, clear, and exact description thereof, reference being had to the accompanying drawings, which form a part of this specification.

This invention relates to an improvement in the construction of tin pails and similar articles made from tin or sheet metal; and the object of the invention is to reduce the cost of construction or manufacture without impairing the utility or durability of the article. More particularly it relates to an improvement in tin pails in which the ears that hold the bow or bail are formed upon the same sheet of metal as the body of the pail and made integral therewith, so as to dispense with the use of separate pieces of metal to form the ears, which latter construction has the disadvantage of forming recesses at the junctions, in which dirt is liable to lodge.

In my improvement the wire ordinarily inserted around the upper edge of the pail is dispensed with, the upper edge of the metal being turned over to form a bead around the upper edge of the pail, except at the ears, which answers the same purpose as the wire, and the two pieces that form the ears are taken from the width of metal used for the purpose of forming said bead, and are not turned over but left intact, and afterward, together with the part of the body adjacent thereto, are strengthened by means of corrugations formed thereon, all of which is hereinafter particularly described.

In the accompanying drawings, Figure 1 represents an elevation of a tin pail made according to my invention. Fig. 2 is a vertical section of the ear taken on the line *x x*; and Fig. 3 represents a portion of the blank from which the pail is made, and showing the mode of forming the ears therefrom.

Similar letters of reference indicate the same parts in all the several figures.

A is the body of the pail. B B are the ears, located on opposite sides of the pail, and C the bow or bail, attached to the same in the usual manner.

*d* represents that portion of the metal which I use to form the bead or rim as a substitute

for the wire ordinarily used. The pieces which form the ears B are detached at their sides from said width of metal by rectangular cuts, as shown at *e*. The remaining portions of said width of metal are then turned over to form the bead by any suitable means, such as are ordinarily used in making articles from tin or sheet metal. Preferably the metal is turned outward, so that the bead is formed on the outer side of the upper edge of the pail. Corrugations are then formed on the metal for the purpose of imparting strength and firmness thereto, as follows—namely, a circular corrugation, *m*, is formed around the aperture *p*, which receives the bow or bail C, and semicircular corrugations *n* and *o* are formed on the body A of the pail, immediately under the ears, for the purpose of imparting strength where the strain is greatest. These corrugations are formed in a press or stamping-machine in the usual manner.

In the drawings the ear is shown as being slightly bent, so as to form a shoulder in the same. This bend may either be inward or outward, or it may be omitted, if desired.

It is obvious that by means of the construction above described the cost of the article is considerably reduced, as the usual wire and separate ear-pieces are dispensed with, and the cost of riveting the latter is also saved; and by forming the rim and the ears in the manner described the pail is as firm and strong as if made in the ordinary manner.

I do not claim as my invention a tin pail or other article of sheet metal having ears formed from and integral with the metal of which the body is formed, separately considered.

What I claim as my invention is—

A tin pail having ears B formed upon the same metal of which the body A is formed, and made integral therewith, and a bead, *d*, formed on its upper edge, as a substitute for the strengthening-wire ordinarily used, and provided with the corrugations *m*, *n*, and *o*, disposed in the manner shown and described, the said ears B being formed from part of the same width of metal from which the bead *d* is formed, and the whole constructed as described, for the purpose set forth.

DAVID BLOCK.

Witnesses:

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