

(No Model.)

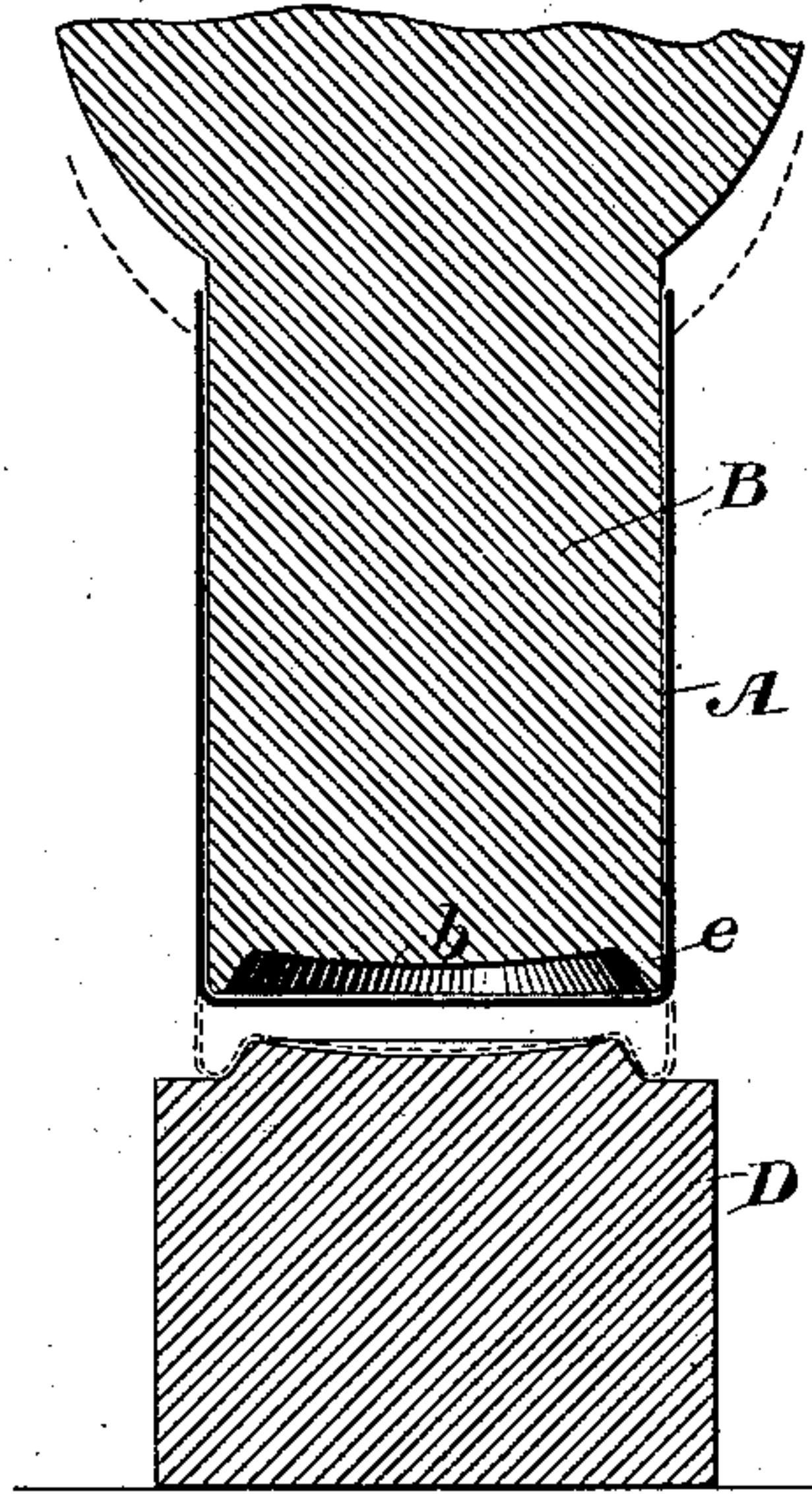
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WROUGHT AND SHEET IRON VESSELS.

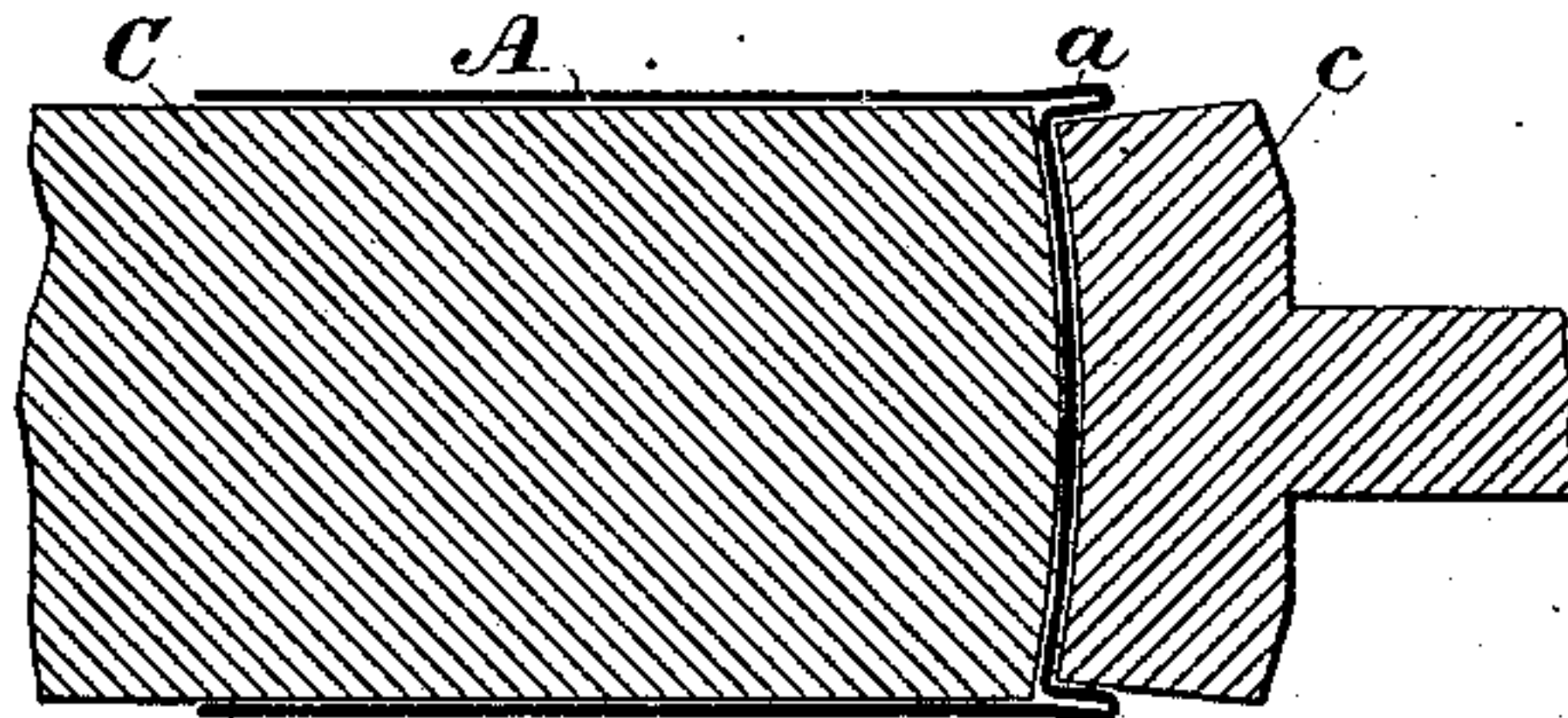
No. 287,624.

Patented Oct. 30, 1883.

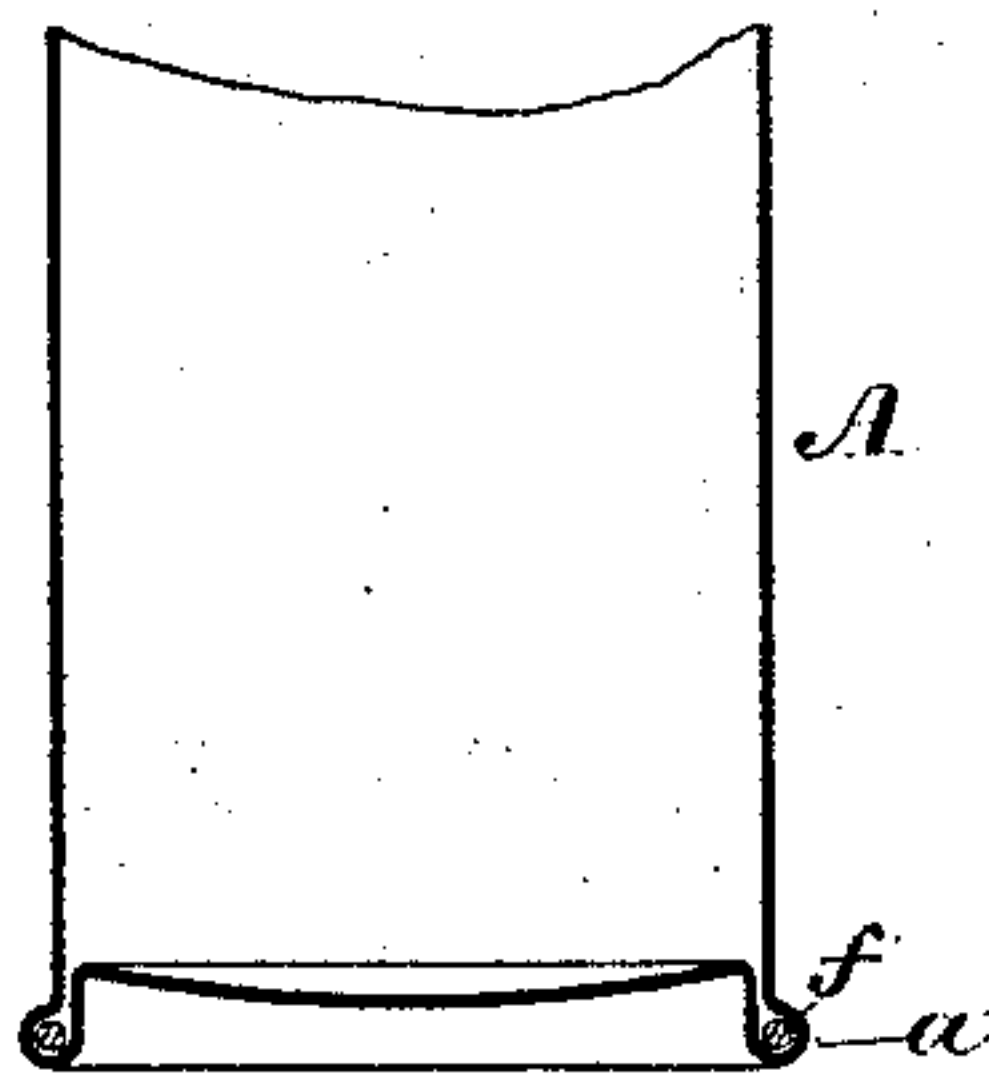
*Fig. 1,*



*Fig. 2,*



*Fig. 3,*



WITNESSES

*Wm A. Skink.*

*Geo W. Breck.*

INVENTOR

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By his Attorneys

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# UNITED STATES PATENT OFFICE.

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## WROUGHT AND SHEET IRON VESSEL.

SPECIFICATION forming part of Letters Patent No. 287,624, dated October 30, 1883.

Application filed July 13, 1883. (No model.)

*To all whom it may concern:*

Be it known that I, JULES CHAUMONT, a citizen of the United States, residing at Wood Haven, in the county of Queens and State of New York, have invented certain new and useful Improvements in Wrought and Sheet Iron Vessels, of which the following is a specification.

My invention more particularly relates to that class of sheet or wrought iron vessels in which a projecting flange extends around the edge of the bottom of the vessel and projects downward therefrom, so as to form a strong and durable foot or support for the vessel.

In the accompanying drawings, Figures 1 and 2 are sectional views of apparatus which I prefer to employ in the construction of my improved vessel. Fig. 3 is a vertical section of the lower portion of a vessel formed according to my invention.

I prefer to construct the vessel as follows: I first stamp or press by means of dies a flat blank of sheet-iron of the proper size into the shape shown at A in Fig. 1. The blank is thus given a form having a flat bottom and cylindrical sides. The blank is next placed upon the mandrel or die B, which is of circular form, and has a recessed and preferably slightly convex bottom, *b*. This bottom is surrounded by the flanged edge *e*. A die, D, having its upper end shaped to fit within the recessed bottom of the mandrel B, is securely held directly beneath the latter, when the mandrel B and the blank A are allowed to descend upon the die D under sufficient pressure to force the bottom of the blank into the shape of the respective upper and lower surfaces of the die D and mandrel B. The blank A is next removed from the mandrel B, and is placed upon another mandrel, C, the sides and bottom of which should be formed to fit the corresponding parts of the interior of the blank. The mandrel C is adapted to be

mounted upon the spindle of a lathe, and after being placed thereon, together with the blank A, the back center of the lathe is brought to bear upon the chuck *c*, the bottom of the blank being tightly clamped between mandrel C and chuck *c*. Rotary motion is then imparted to the mandrel C and chuck *c*, and by means of burnishers or analogous tools employed in the process of sheet-metal spinning the outer and inner sides of the flange *a* of the blank are compressed and forced closely together, thus making a strong foot or base for the vessel. By the proper and well-known manipulation of the burnisher the bead *f* (shown in Fig. 3) is formed upon the extreme edge of the flange, and made to project slightly outward from the flange *a*, thus greatly increasing the strength and durability of the completed article.

It is sometimes preferable to form the bead *f* by the aid of a wire inserted in the interior of the flange between its sides. The wire should be inserted after the blank has received the form given it by the operation exhibited in Fig. 1. In Fig. 3 I have shown the wire in place.

I claim as my invention—

1. The hereinbefore-described vessel, having the seamless supporting flange or foot, and the annular bead upon the lower edge of said flange.

2. The hereinbefore-described vessel, having the seamless supporting flange or foot, and the annular bead with inclosed strengthening-wire upon the lower edge of said flange.

In testimony whereof I have hereunto subscribed my name this 12th day of July, A. D. 1883.

JULES CHAUMONT.

Witnesses:

JAMES COCHRAN,  
CHARLES SMITH.