

(No Model.)

T. W. BURGER.
SHEET METAL CAN OR BOX.

No. 310,120.

Patented Dec. 30, 1884.

Fig. 1.

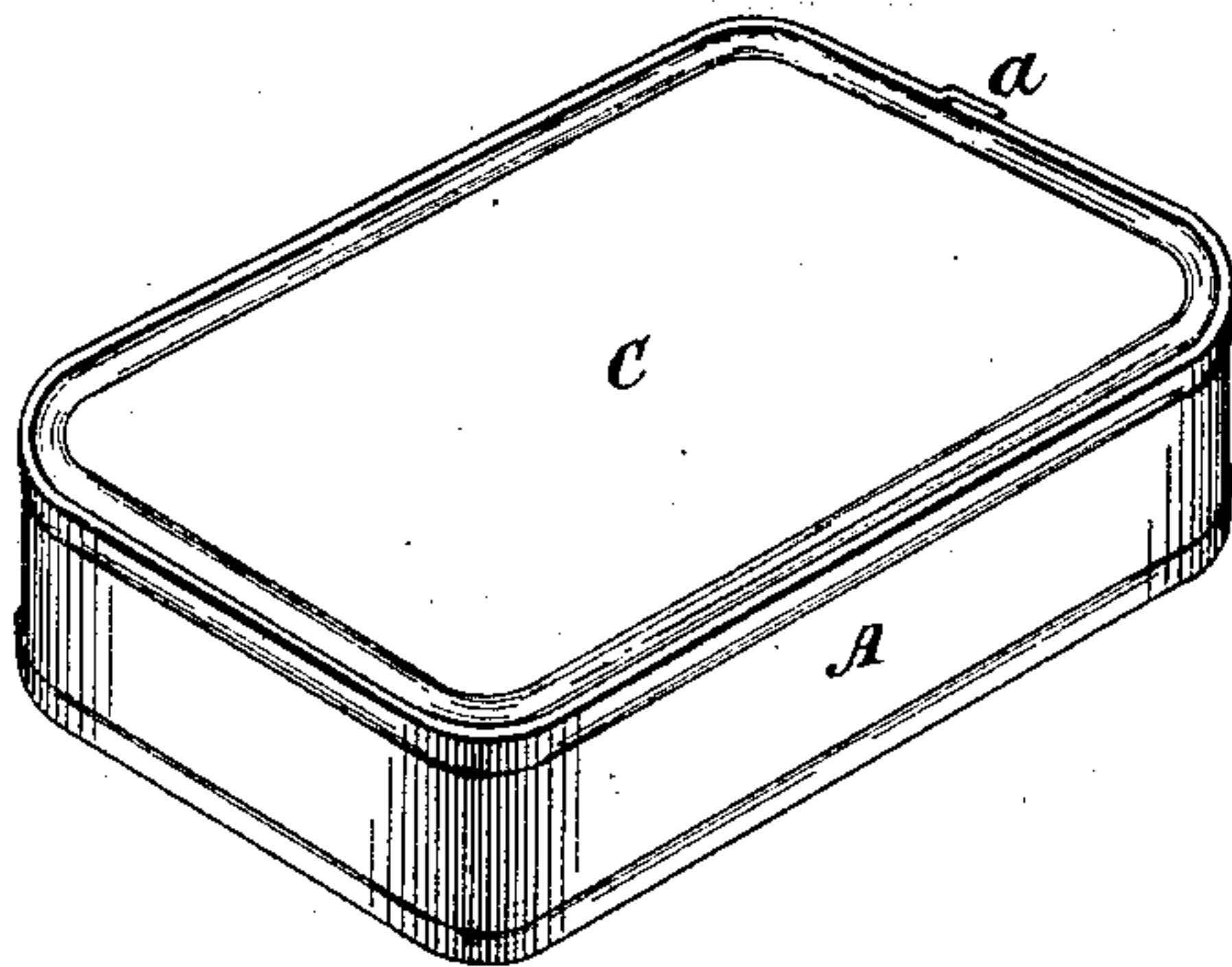


Fig. 2.

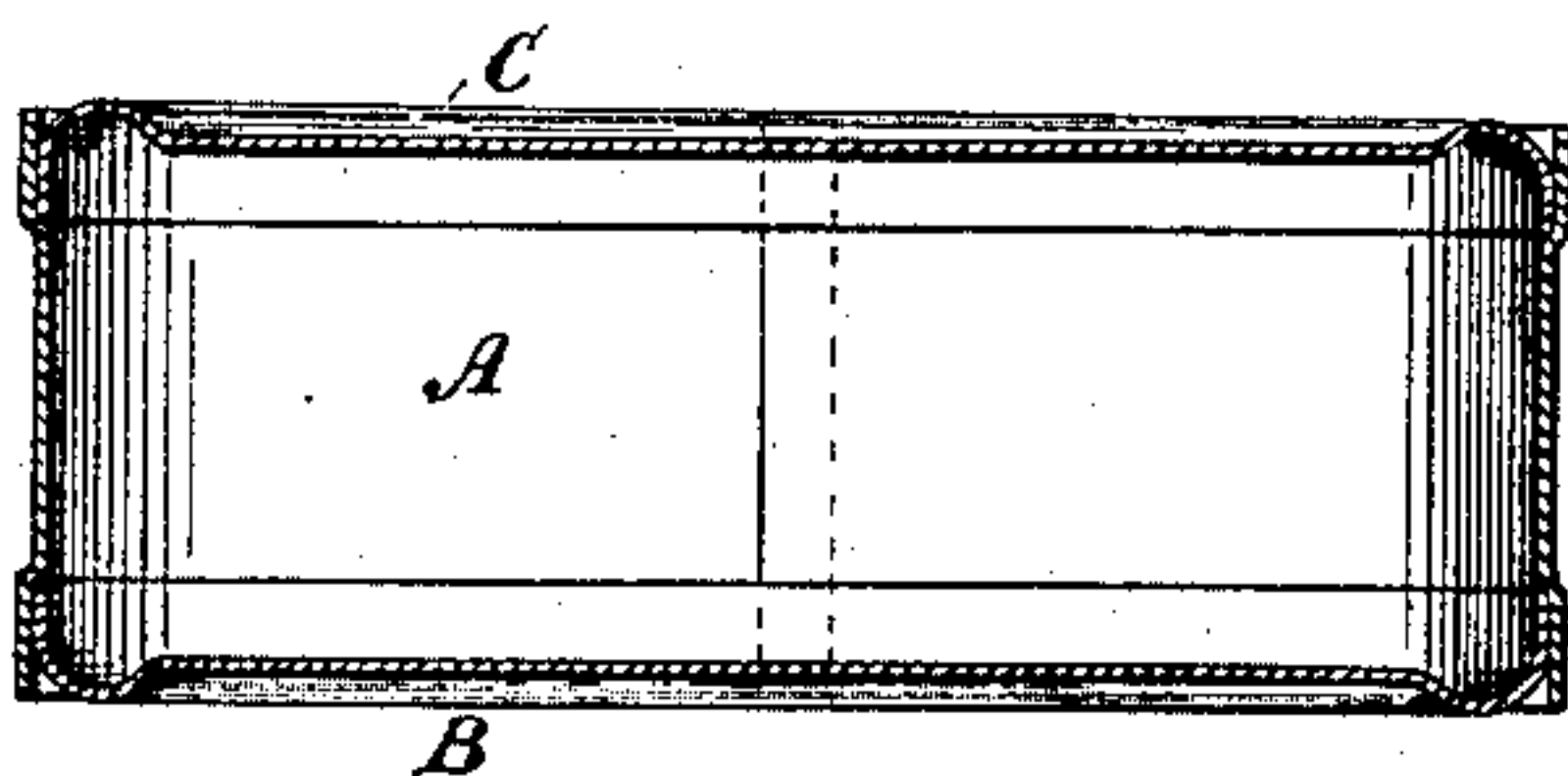


Fig. 3.

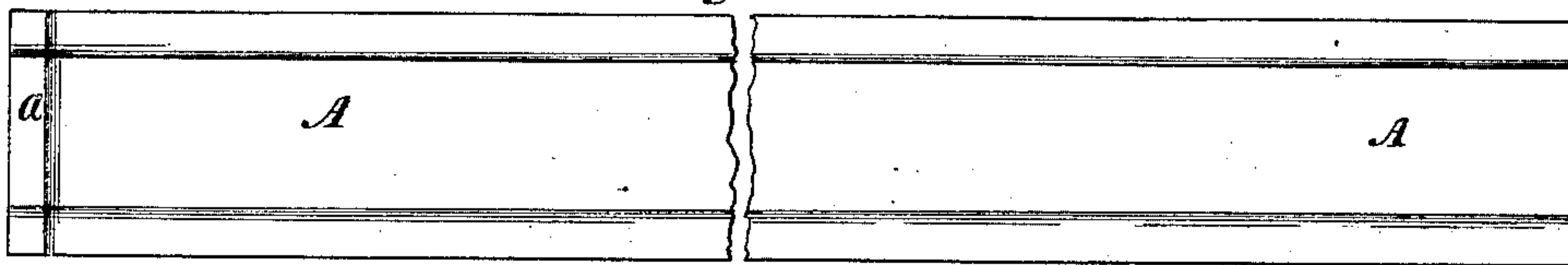
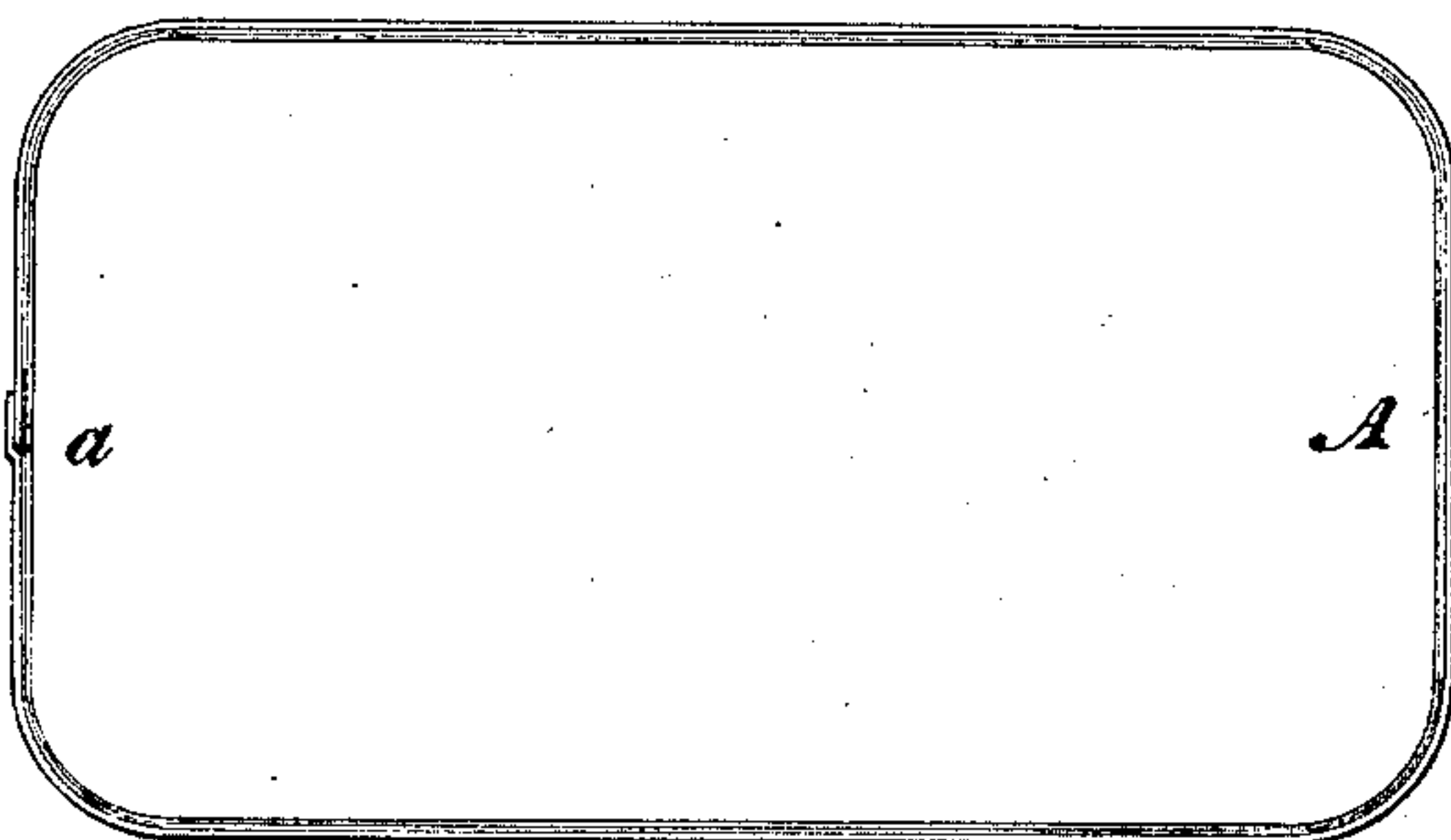


Fig. 4.



Witnesses
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UNITED STATES PATENT OFFICE.

THEODORE W. BURGER, OF PLAINFIELD, NEW JERSEY.

SHEET-METAL CAN OR BOX.

SPECIFICATION forming part of Letters Patent No. 310,120, dated December 30, 1884.

Application filed June 5, 1884. (No model.)

To all whom it may concern:

Be it known that I, THEODORE W. BURGER, of Plainfield, in the county of Union and State of New Jersey, have invented a certain new and useful Improvement in Sheet-Metal Cans or Boxes, of which the following is a specification.

My improvement relates particularly to the manufacture of cans or boxes such as are used for packing sardines. The bodies of these cans or boxes usually are of approximately rectangular form. They are made of a strip of sheet metal bent into the proper shape and united at the ends by solder. The bottom and top are fitted into the body thus made, and are secured there by solder. These cans or boxes are necessarily manufactured very hastily, in order that they shall be produced sufficiently cheap for the market. Difficulty is experienced in bringing the ends of the body together in the proper position for soldering. If the ends are lapped too much, the can or box body will be contracted at the end or side where the ends meet. If the ends are not lapped enough, the can or box body will be expanded beyond proper limits, and if the ends do not extend exactly at right angles to the length of the strip the can or box body will not be straight, or, in other words, neither its top or bottom edge will be in one plane. In any of these cases the bottom and top will not fit properly in the body. A further difficulty in the ordinary mode of construction arises from the fact that the interior surfaces of the can cannot be made flush. When one end of a straight strip is lapped over the other, a ridge is formed by the end of the strip coming upon the inside, which prevents the top and bottom pieces of the can from being inserted flush with the interior surfaces of the strip. A space is thereby left upon one side between the inner surface of the strip and the edges of the top and bottom pieces, which, if not carefully soldered, will permit the contents of the can to leak out. Usually a mark is made with a pencil or scratching-instrument close to one end to indicate the point to which the other end is to extend. This mark is hard to discern, except in a very strong light, and this is especially so because of the

haste in which the joint has to be made between the ends.

It is the object of my improvement to obviate this difficulty.

To this end the improvement consists in the process of manufacturing a can-body of the referred-to kind by cutting a strip of sheet metal to the desired length; in forming an offset at one end by bending the end outwardly; in bending the strip lengthwise into proper shape; in fitting into the end having the offset the other end of the strip, so as to form a body having a flush interior surface; in uniting the ends by solder; in inserting the top and bottom into the flush interior surface of the body, and in securing the top and bottom in place by solder.

In the accompanying drawings, Figure 1 is a perspective view of a box or can made according to my improvement. Fig. 2 is a transverse section of the same. Fig. 3 is a face view of a strip embodying my improvements, and Fig. 4 is an edge view of the same when bent into shape to form the can or box body.

Similar letters of reference designate corresponding parts in all the figures.

A designates the can or box body. It consists of a narrow strip of sheet metal cut to the required length and bent around a former or otherwise to the required shape—in this instance into an approximately rectangular form. When the strip is cut, or after it is cut to the required length, it has an offset, *a*, formed at one end. This offset is formed by bending the end portion of the strip outward. Thus I form on the inner side, at one end, a recess, into which the other end may be fitted so as to produce a flush interior surface for the body in which the top and bottom will fit snugly at all parts. When the plain end of the body is fitted into the recess formed by the offset at the other end, it will abut against the shoulder at the end of the recess. The ends of a strip thus formed may be fitted together accurately, even in great haste and where the light is poor, for they can be adjusted into the proper relation by the sense of feeling. They may be very securely united by solder, for the solder will be received in

the recess and effectually distributed. The bottom B and top C of the can or box will be fitted into the body and secured there by solder in the usual way.

5 What I claim as my invention, and desire to secure by Letters Patent, is—

The process of manufacturing a can-body, consisting in cutting a strip of sheet metal to the desired length; in forming an offset at one
10 end by bending the end outwardly; in bending the strip lengthwise into proper shape; in

fitting into the end having the offset the other end of the strip, so as to form a body having a flush interior surface; in uniting the ends by solder; in inserting the top and bottom
15 into the flush interior surface of the body, and in securing the top and bottom in place by solder, substantially as specified.

T. W. BURGER.

Witnesses:

T. J. KEANE,

E. T. ROCHE.