

(No Model.)

J. C. MILLIGAN & J. CHAUMONT.

MILK CAN.

No. 311,440.

Patented Jan. 27, 1885.

Fig. 1,

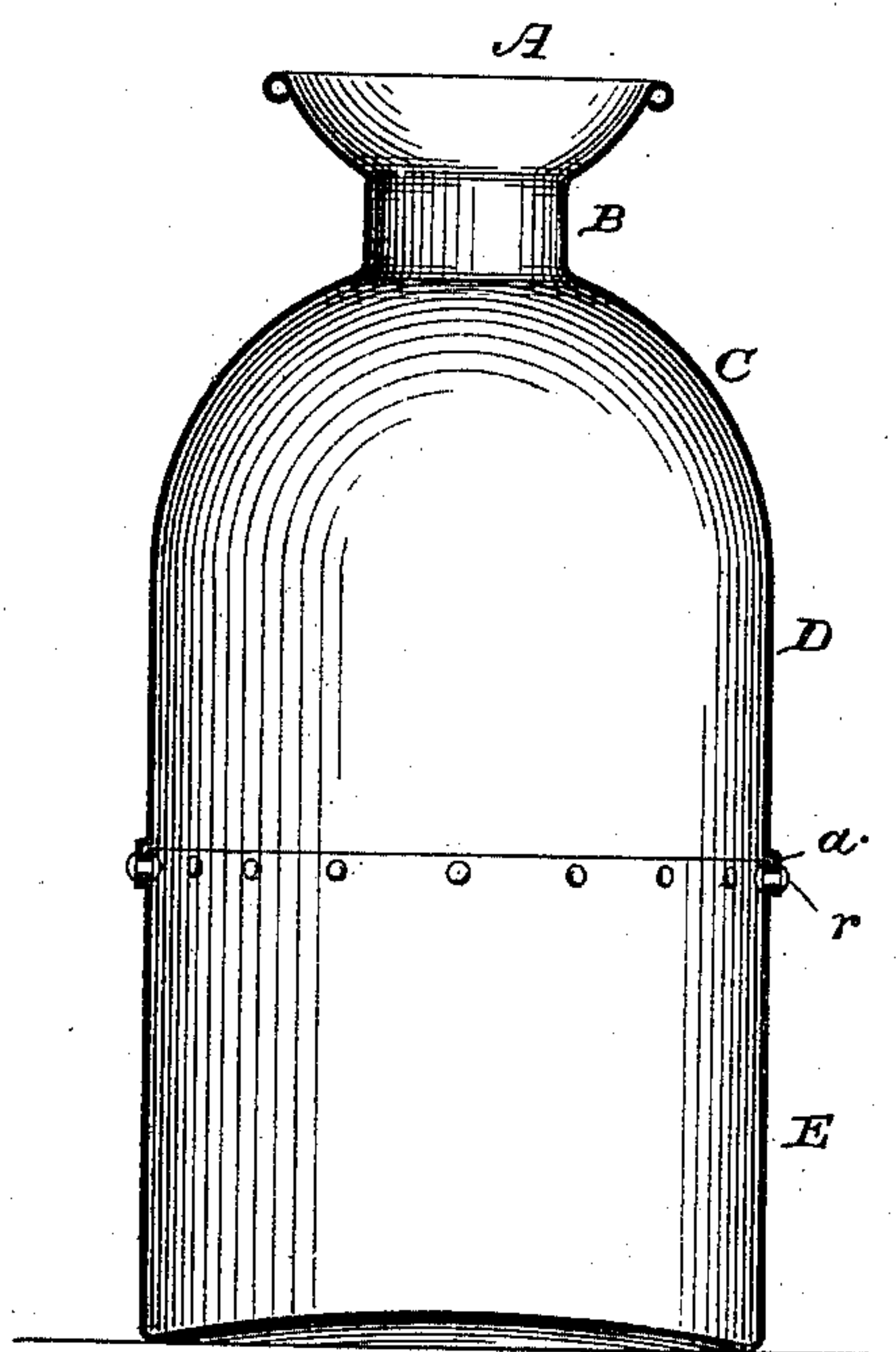
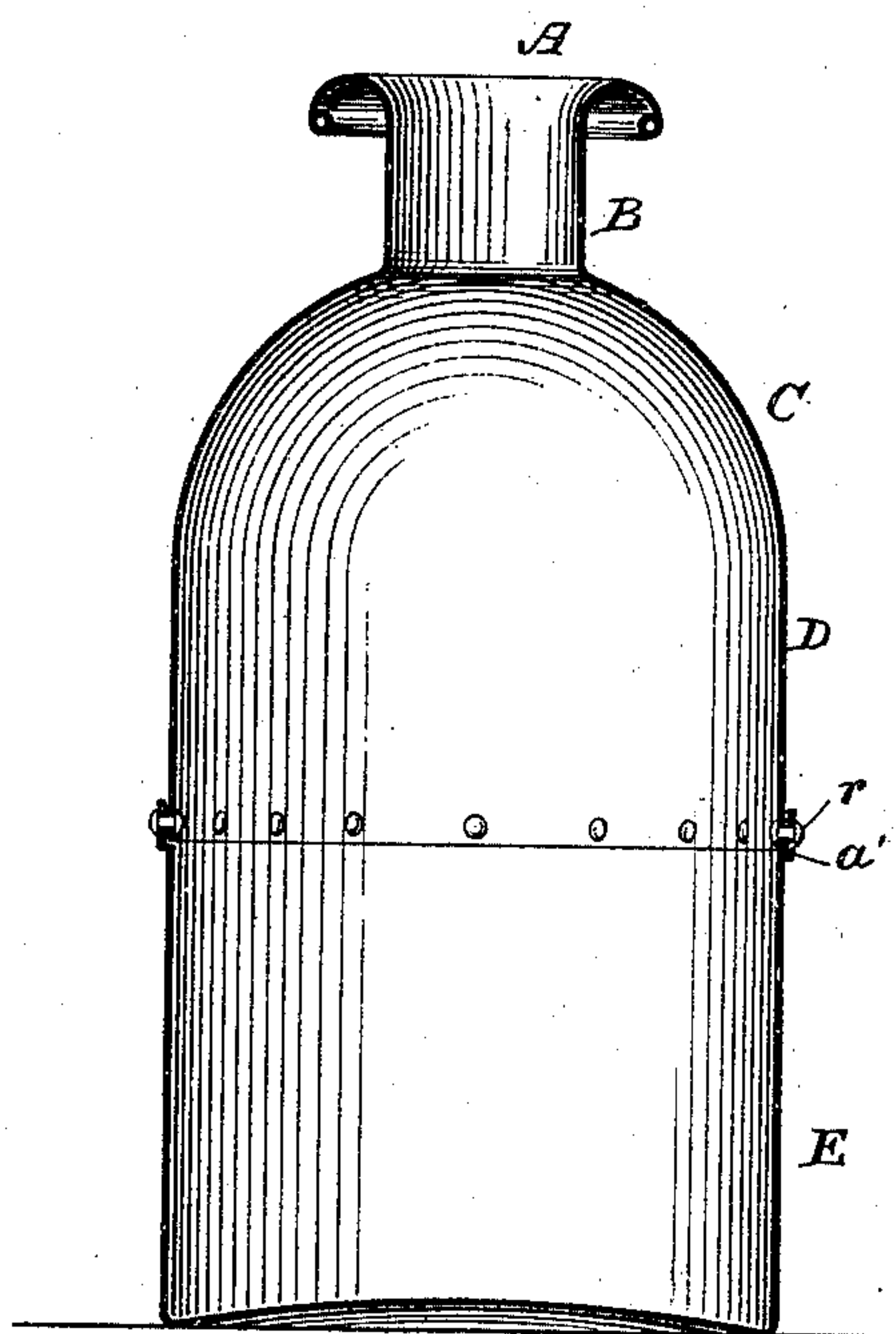


Fig. 2,



Witnesses

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Inventors

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UNITED STATES PATENT OFFICE.

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MILK-CAN.

SPECIFICATION forming part of Letters Patent No. 311,440, dated January 27, 1885.

Application filed August 13, 1884. (No model.)

To all whom it may concern:

Be it known that we, JOHN C. MILLIGAN and JULES CHAUMONT, citizens of the United States, residing, respectively, in Brooklyn, in the county of Kings, and in Woodhaven, in the county of Queens, and State of New York, have jointly invented certain new and useful Improvements in Milk-Cans, of which the following is a specification.

10 In the successive improvements which have been made in the manufacture of milk-cans from sheet metal the desired object has been to make the article of the fewest possible pieces, whereby the greatest strength and durability
15 are attained, and whereby the can is most easily and with greater certainty kept clean.

Although cans have been made for some time having the lower portion of the body, with the bottom, in one solid piece without
20 seam, yet, so far as we are aware, the upper portion of the body, on account of the peculiar shape which it is desirable to give it, has heretofore always been made in at least two pieces.

25 We have succeeded in producing a can of sheet metal in which the upper portion of the body, with the breast, neck, and mouth, are all made from a single piece of sheet metal, and when this is joined to the lower portion
30 of the body, which, with the bottom of the can, is also made in a single piece, forms a milk-can more perfect than has heretofore been made, inasmuch as there is but a single joint in the complete vessel, and that at a place
35 where perfect cleanliness is most easily maintained.

The accompanying drawings show two forms of our improved can, they being the principal forms now in general use, in each case the entire upper portion being made from a single
40 piece of sheet metal without seam and joined to the lower portion, also formed of a single piece by a single joint approximately in the middle of the can. In each case A represents
45 the mouth of the can; B, the neck or collar; C, the breast; D, the upper main portion of the can, and E the lower main portion. The joint is preferably made by enlarging the edge of one of the portions of the can to an extent
50 just sufficient to allow the edge of the other portions to enter it. In the case of Figure 1

the lower edge of the upper portion of the can is enlarged, as shown at *a*, and the upper edge of the lower portion is set within the hoop or projection thus formed, and preferably secured by the rivets *r*, so as to firmly fasten
55 the two together. The joint shown in Fig. 2 is of the same nature, except that the enlarged portion *a'* is made upon the lower part of the body, and the edge of the upper part
60 of the body is inserted therein. It is evident that the enlarged portion *a*, which practically forms a hoop around the can at the joint, might be a separate piece, by means of which
65 the two portions of the body might be fastened by a double row of rivets; but the form of joint shown in the drawings is preferable.

The essential feature of our invention is forming the entire upper portion, as described, in one single piece, thereby doing away with
70 any joint in that part of the can, one such joint at least having been heretofore invariably used to attain the required shape in the manufacture of these articles. The advantages are cheapness, strength, and greater
75 cleanliness.

In the manufacture of these cans suitable pieces of heavy iron or steel are taken, which may or may not be tinned, and are stamped by means of dies and presses into cylinders
80 of the required size for the two main portions of the vessel. The bottom portion is left by the dies in approximately, or in some cases exactly of the shape shown in the drawings. The upper portion, however, is placed, after
85 stamping, in a spinning-lathe, and by means of suitable mandrels and other appliances is forced gradually into the shape shown in the drawings—that is, the several forms shown at C, B, and A are given to the cylinder by
90 the peculiar spinning machinery employed. Heretofore the form of the breast C and a portion of the neck or collar has been produced, but not the mouth A, or any portion of the main body D, except separately.

We claim as our invention—

1. The mouth, collar, breast, and a portion of the main body of a milk-can, all formed together of one piece of sheet metal without
100 seam, substantially as described.

2. The concave or bell-shaped mouth, together with the collar, breast, and a portion

of the main body of a milk-can, all formed together of one piece of sheet metal without seam, substantially as described.

3. As a new article of manufacture, a milk-
5 can in which the concave or bell-shaped mouth, together with the collar or neck and breast and a portion of the main body, is formed from a single piece of sheet metal, the remaining
10 portion of the body, with the bottom, also being formed from a single piece of sheet metal, and the two portions joined by a hoop formed on one of said portions, in the manner substantially as described.

4. The mouth A, collar B, breast C, and main
portion D, all formed from a single piece of 15
metal, in combination with the lower portion, E, being united thereto by means substantially
as described.

In testimony whereof we have hereunto subscribed our names this 12th day of August, 20
A. D. 1884.

JOHN C. MILLIGAN.
JULES CHAUMONT.

Witnesses:

JAMES COCHRAN,
W. E. MAYNARD.