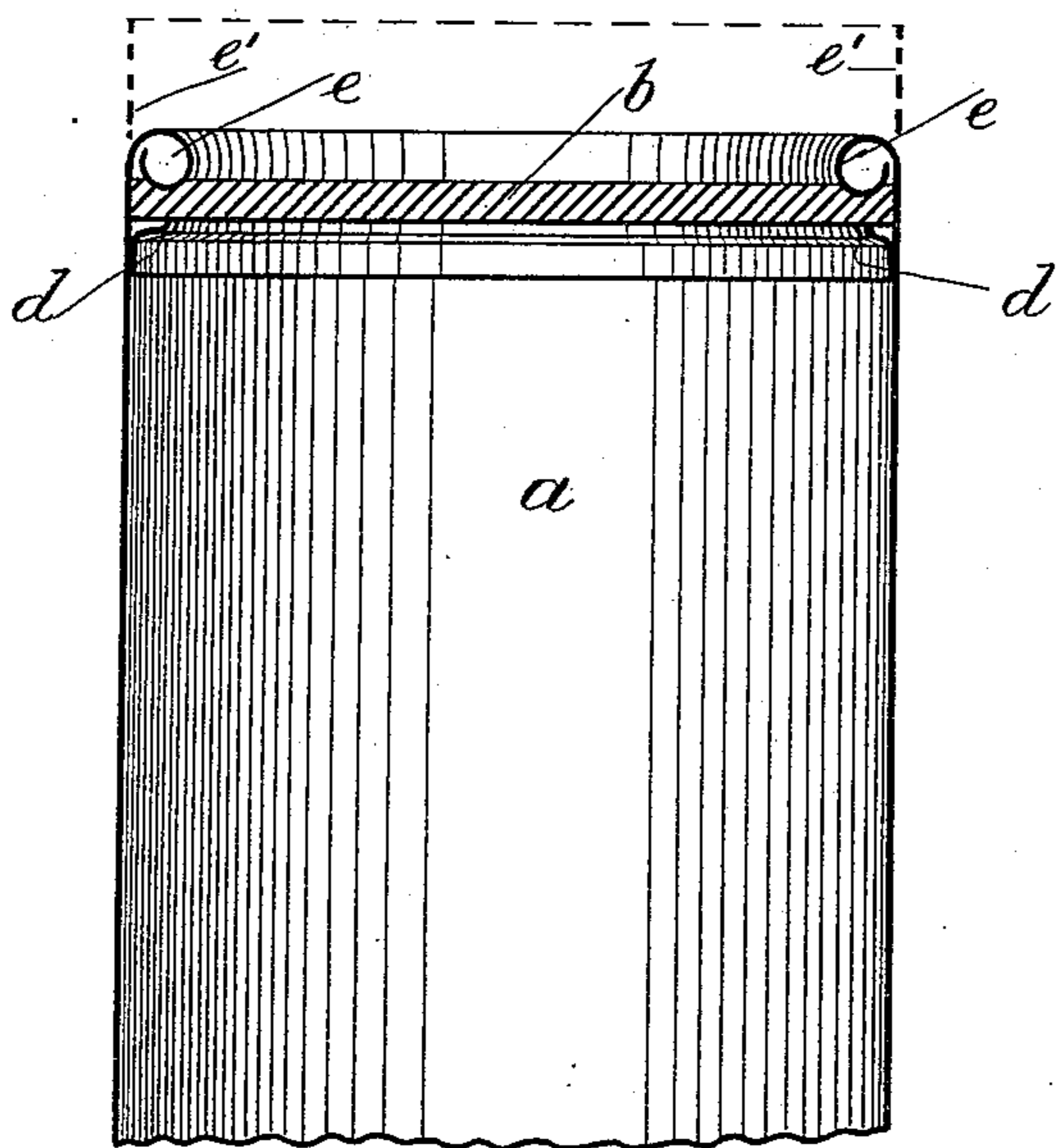


(No Model.)

F. A. WALSH.
SHEET METAL CAN.

No. 333,180.

Patented Dec. 29, 1885.



Witnesses:

T. W. Middleton.
W. E. Poulter.

Inventor:

Francis A. Walsh.
by Herbert W. Jenner.
Attorney.

UNITED STATES PATENT OFFICE.

FRANCIS A. WALSH, OF CHICAGO, ILLINOIS.

SHEET-METAL CAN.

SPECIFICATION forming part of Letters Patent No. 333,180, dated December 29, 1885.

Application filed July 31, 1883. Serial No. 102,456. (No model.)

To all whom it may concern:

Be it known that I, FRANCIS A. WALSH, of Chicago, in the county of Cook and State of Illinois, have invented certain new and useful
5 Improvements in Sheet-Metal Cans; and I hereby declare the following to be a full, clear, and exact description thereof, which will enable others skilled in the art to which my invention relates to make and use the same, reference being had to the accompanying drawings, forming a part of this specification, and to the letters of reference marked thereon.

This invention relates to sheet-metal cans; and it consists in the detailed construction of
15 the same, so that the bodies may be united to the ends without forming double seams or using solder. This form of construction admits of the said ends being made of material other than metal, and enables the cans to be
20 made cheaper and better for many purposes than those in use prior to this invention.

The figure in the drawings represents a sectional elevation taken through the center of a sheet-metal can constructed according to the
25 present invention.

Similar letters of reference indicate corresponding parts.

In the drawings, *a* represents the can-body provided with an internal shoulder, *d*, near
30 the end of it. This shoulder *d* may be formed as a bead from the body of the can; or it may be formed separately and attached thereto, as shown, by being forced into the body; or it may be fastened by solder or by rivets. The
35 cover or ends *b* may be made of wood, paper, felt, leather, mica, glass, metal, or any convenient substance, according to the nature of the contents of the can.

Each cover or end *b* consists of a plain disk
40 of the same diameter as the inside of the can-body, so that it may be placed therein and rest upon the shoulder *d*. The extreme end of the can-body will then project beyond the cover or end *b*, as shown by the dotted lines
45 in the drawings, which part of the can is lettered *e'*. The extent of this projection is regulated according to the thickness and soft-

ness of the material of which the end *b* is made.

When the end is formed of a thick and soft
50 material, the part *e'* will have to be made longer than when the said end is made of a thin and unyielding substance. The length of the part *e'* being duly proportioned, and the end *b* being placed within the can-body,
55 so that it rests upon the shoulder *d*, the part *e'* is turned over by means of suitable machinery until it forms the scroll *e*, which bears tightly down upon the end *b* of the can, and makes a joint with it. When the end *b* is
60 made of soft material, the scroll *e* will be partly pressed into it. The scroll *e* may be turned over more or less upon itself beyond that point where it touches the end *b*, the object in making it a scroll being that this is a form
65 which will sustain a much greater pressure than a simple claw or burr.

When all the said parts are properly proportioned and constructed, the end of the can will be so firmly secured between the scroll
70 and the shoulder that the said can will be able to retain heavy mixed paints and other similar substances without leaking.

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

1. In a sheet-metal can, the combination of a flat disk constituting the head of the can, with a can-body provided with an internal shoulder near its end, and having its extreme
80 end bent over in the form of a scroll, so that the disk is firmly secured between the said shoulder and the said scroll, substantially as and for the purpose set forth.

2. In a sheet-metal can, the combination of
85 the end *b* with the can-body *a*, provided with the internal shoulder, *d*, and with the scroll *e* at its extreme end, substantially as described and shown, and for the purpose set forth.

FRANCIS A. WALSH.

Witnesses:

WM. ZIMMERMAN,
FRANK WILLIAMS.