

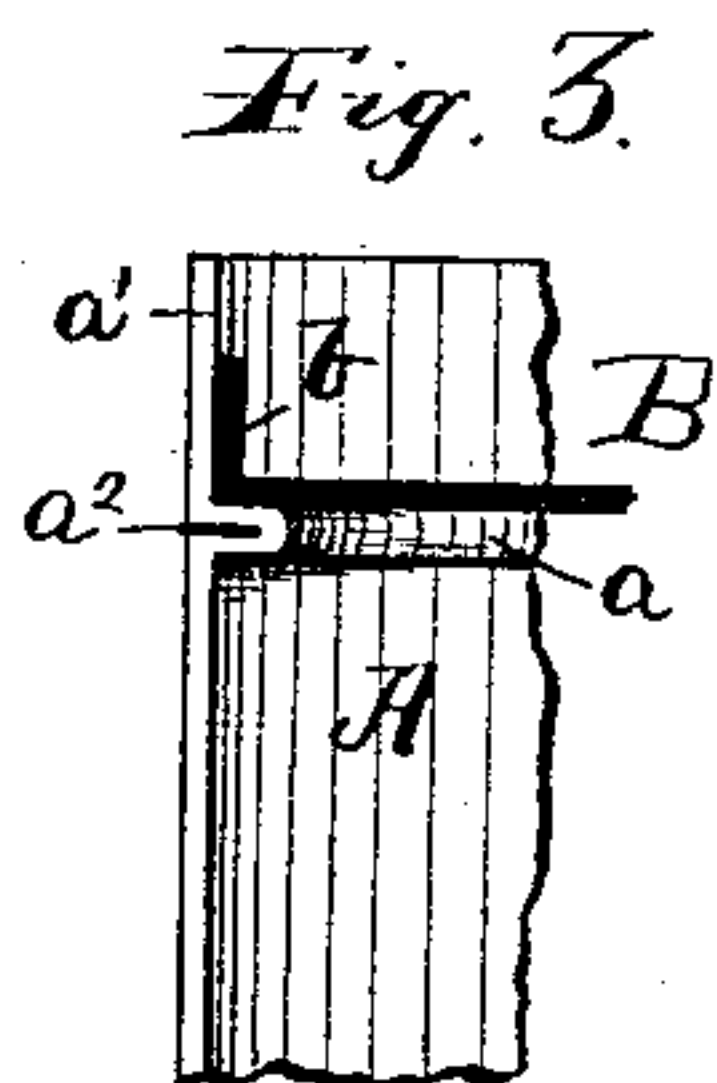
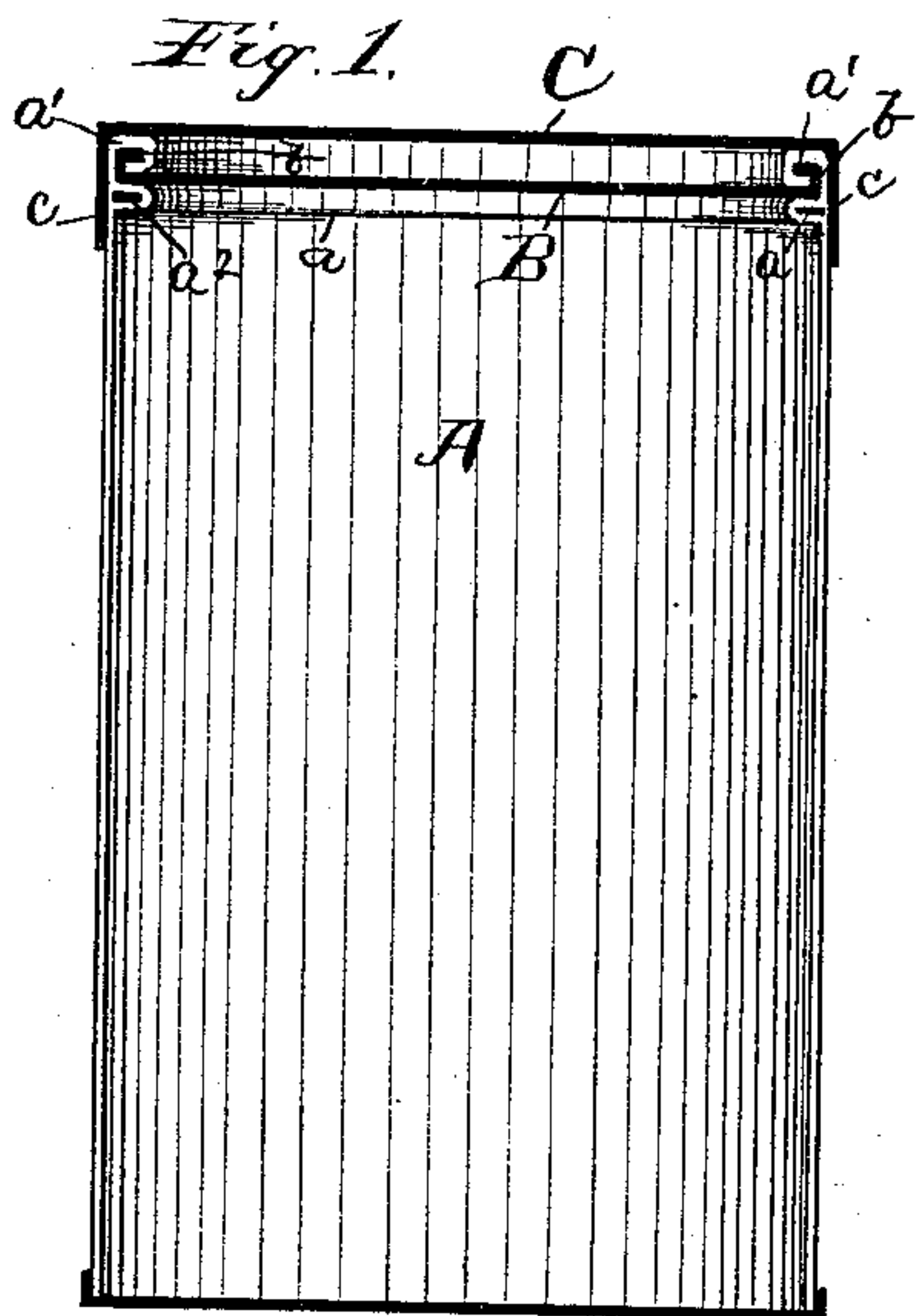
(No Model.)

E. NORTON.

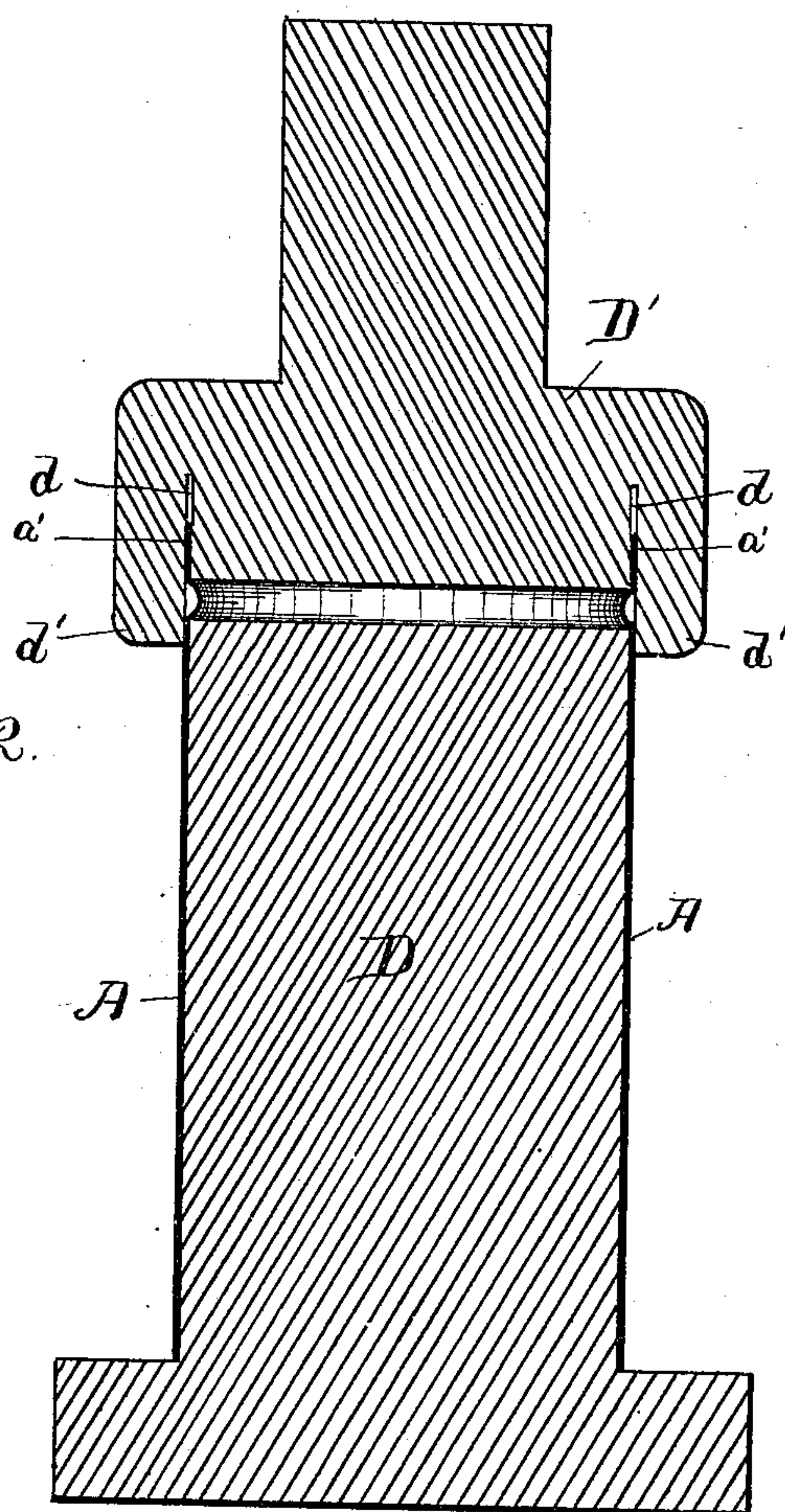
PAINT CAN.

No. 338,767.

Patented Mar. 30, 1886.



*Fig. 2.*



Witnesses:

Lew. G. Curtis.  
A. M. Munday.

Inventor:

Edwin Norton

By Munday, Evarts, & Adcock  
his Attorneys:



# UNITED STATES PATENT OFFICE.

EDWIN NORTON, OF CHICAGO, ILLINOIS, ASSIGNOR TO HIMSELF AND  
OLIVER W. NORTON, OF SAME PLACE.

## PAINT-CAN.

SPECIFICATION forming part of Letters Patent No. 338,767, dated March 30, 1886.

Application filed January 25, 1886. Serial No. 189,650. (No model.)

*To all whom it may concern:*

Be it known that I, EDWIN NORTON, a citizen of the United States, residing in Chicago, in the county of Cook and State of Illinois, have invented a new and useful Improvement in Paint-Cans, of which the following is a specification.

The object of my invention is to provide a paint-can of simple and cheap construction, which may be securely closed without the use of solder after the can is filled, by a seam folded or formed upon the top of the can, so that the ordinary slip-cover may fit snugly over the same.

The invention relates more particularly to certain improvements upon the paint-can heretofore patented to me in Letters Patent of the United States, No. 298,018, of May 6, 1884. In said patent the can-body is provided with an inturned flange at its top edge, over which is folded one flange or edge of a seamless ring, the upper flange of which ring is seamed with the flange of the can-head.

The design of the present invention is to produce a can of somewhat cheaper construction, which will supply certain demands equally well with the somewhat more expensive can shown in said patent, and wherein a seamless ring is employed.

In the present invention the interior support or shoulder which supports the head and resists the pressure of the seaming-rollers while the seam is being folded is formed by making an interior annular fold in the can-body a slight distance from the top of the same, so as to leave a flange on the can-body above this interior fold or shoulder, which flange may be folded into a double or other seam with the flange of the can-head. This annular fold or shoulder is formed by first making an inturned annular bead in the can-body, when the can-body is placed on a suitable horn, and a punch applied having an annular groove to receive the flange or edge of the can-body which projects above the bead, and then, upon pressure being applied, the stock in the bead is pressed into a flat fold or shoulder. As this operation may tend to crack the stock at the fold or shoulder and thus produce leaks, I roll the end of the can through

a solder bath, or apply solder to the fold in any suitable manner, and thus securely unite the parts of the fold together. By thus soldering together the parts of the fold the same is also strengthened and adds materially to the stiffness and rigidity of the can produced by this annular shoulder. After the interior shoulder is thus formed the bottom end or head of the can is soldered in place, and then after the can is filled its upper head is seamed to the upwardly-projecting flange on the can-body above this interior shoulder by a suitably rolled or folded seam, preferably by what is known as a "double seam."

In the accompanying drawings, which form a part of this specification, and in which similar letters of reference indicate like parts. Figure 1 is a central vertical section of a can embodying my invention. Fig. 2 is a similar sectional view of the can-body after the annular bead or groove is formed therein and before said bead is folded or pressed into the annular fold or shoulder, and showing, also, a suitable form of horn and punch for this purpose. Fig. 3 is a similar view of the can-body after the inner shoulder has been formed, ready for the application of the head.

In said drawings, A represents the can-body provided with an interior annular fold, *a*, in its stock, formed by pressing an interior annular bead into said form.

*a'* is an upwardly-projecting flange above the annular interior fold or shoulder *a*, which flange is folded, with the flange *b* of the head B, into a suitable folded or rolled seam, preferably a double seam, as shown in Fig. 1.

C represents a slip-cover having a depending flange, *c*, which fits over the end of the can in the ordinary manner. Solder *a*<sup>2</sup> should be applied on the outside of the can-body at the crevice or joint between the parts of the fold *a*, so as to securely unite the parts together, and thereby give additional stiffness and rigidity to the annular fold or shoulder *a*, which stiffens the upper end of the can. This solder will also close any cracks or leaks which might possibly be produced by the operation of pressing the bead into such fold. The head B should preferably be made of thin stock, so as to be readily cut or removed. The



slip-cover C serves to protect this inner head, B, and also to close the can after the head has been once cut out.

5 D represents a horn, and D' a punch having an annular groove, *d*, to receive the upper flange or edge of the can-body. The annular rim or shoulder *d'* of the punch D', should project below the bead in the can-body, as shown in Fig. 2, so as to retain the can-body  
10 in shape below the bead when the punch is forced down.

The size and form of the bead may be varied without departing from my invention, as well the degree or extent to which its walls are  
15 forced together to form the fold or shoulder *a*. It is this interior fold or shoulder, *a*, which supports the head B and resists the action of the seaming tools or rollers when the flange *b* of the head B and the flange *a'* of the can-  
20 body are being folded inwardly to form the seam on top of the can. The outer wall or edge of the seam is thus formed on a line with the wall of the can-body, so that the slip-cover C has a secure and snug fit over the same.

I claim—

1. The combination, with the can-body hav- 25  
ing an interior shoulder consisting of an interior annular fold, *a*, in the stock of the can-body, the parts of said fold being pressed together and provided with a flange, *a'*, above 30  
said annular shoulder, of a head, B, having an upwardly-projecting flange, *b*, turned down and folded, with the flange on said can-body, into a seam, substantially as specified.

2. The combination, with can-body A, hav- 35  
ing an interior annular fold, *a*, in its stock, the parts of said fold being closed together and the joint or crevice between the parts of said fold being soldered together, and provided with an upwardly-projecting flange, *a'*, of a 40  
head, B, having an upwardly-projecting flange, *b*, turned down and secured with the flange on said can-body, substantially as specified.

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Witnesses:

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