(No Model.)

J. O'NEILL.

LOCK FASTENING FOR BOTTOM HOOPS OF MILK CANS.

No. 353,641. Patented Nov. 30, 1886.

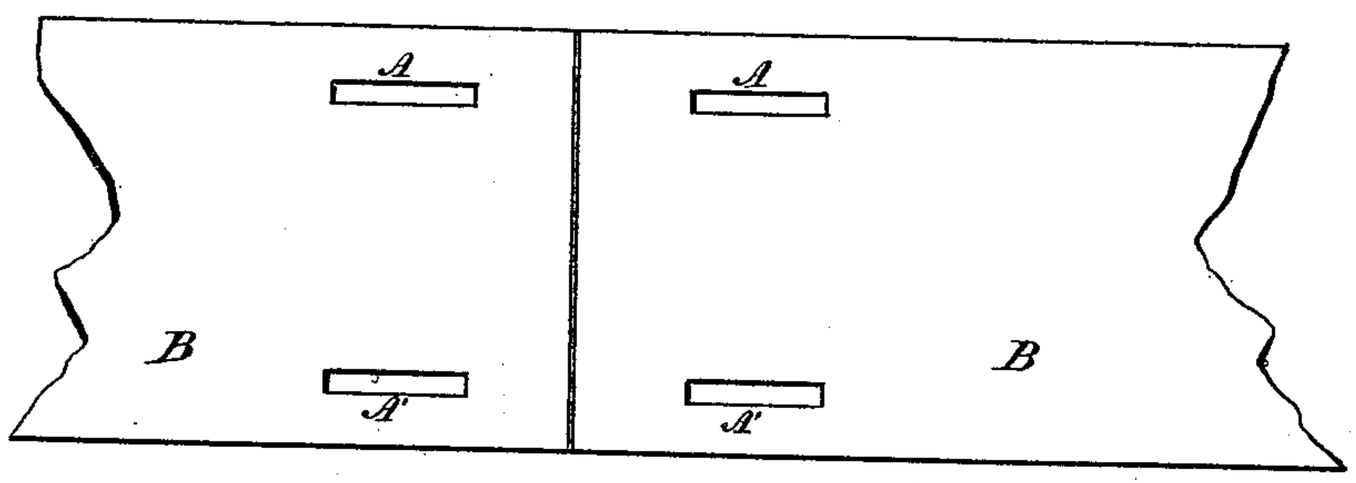


Fig. 1

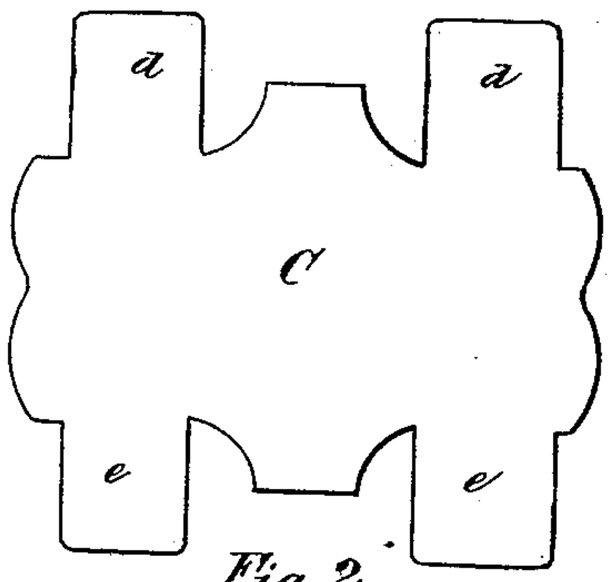


Fig. 2

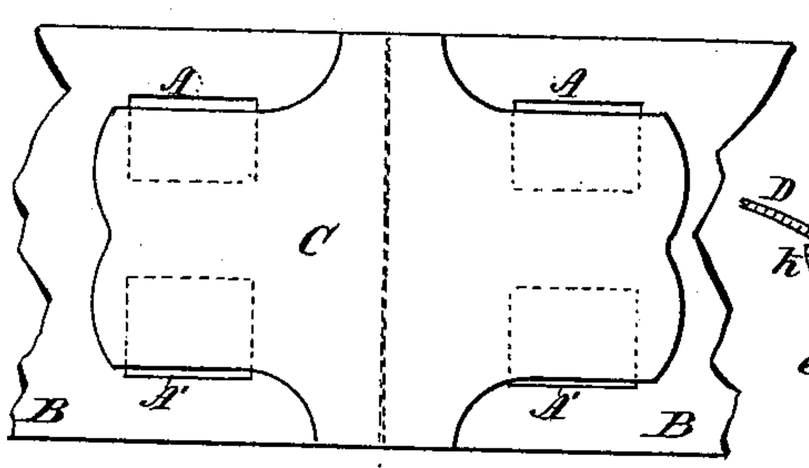


Fig. 3.

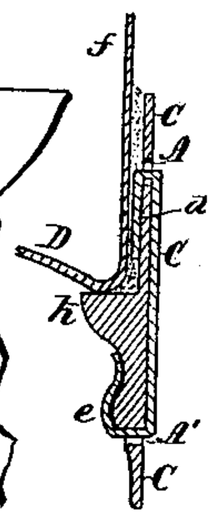
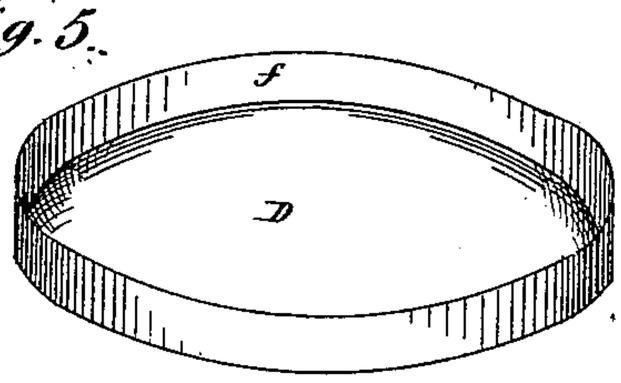


Fig. 4.

Fig. 5.



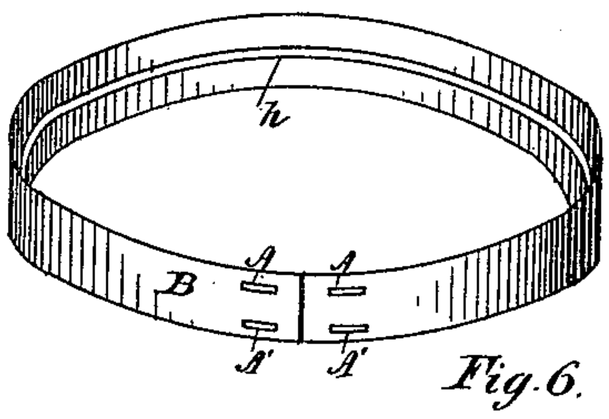


Fig. 6.

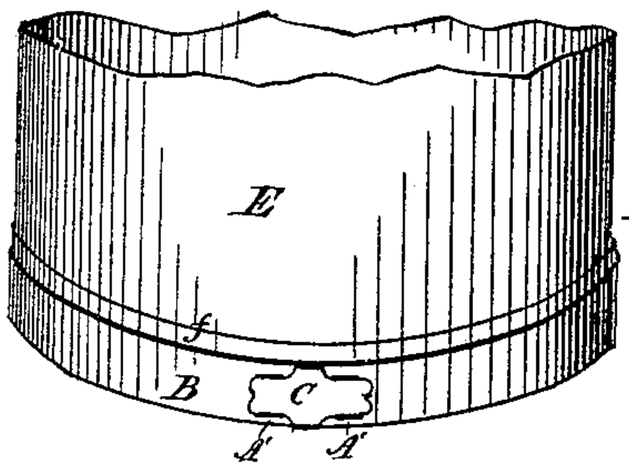


Fig. 7.

Witnesses

A. E. Jones,

William Aches

Inventor

John O'Neill.

By W. Bruce

Att'y

UNITED STATES PATENT OFFICE.

JOHN O'NEILL, OF HAMILTON, ONTARIO, CANADA.

LOCK-FASTENING FOR BOTTOM HOOPS OF MILK-CANS.

SPECIFICATION forming part of Letters Patent No. 353,641, dated November 30, 1886.

Application filed October 9, 1886. Serial No. 215,776. (No model.)

To all whom it may concern:

Be it known that I, JOHN O'NEILL, of the city of Hamilton, in the county of Wentworth, Province of Ontario, Dominion of Canada, tinner, have invented a certain new and useful Lock-Fastening for the Bottom Hoop of Milk-Cans; and I do hereby declare that the following is a full, clear, and exact description of the construction and operation of the same.

Heretofore the ends of the bottom hoop of heavy railroad, cheese-factory, and delivery milk-cans have been welded at their junction, which is found to be objectionable, inasmuch as they are liable to break at the welded portion, and also the hoop may not fit the bottom exact, and the latter has to be drawn out to fit the hoop, involving much tedious delay in the manufacture, besides other objections not necessary to mention.

My invention relates to the construction of a lock or fastening for the bottom hoop of milk-cans, by which the said bottom hoop is free from the above objections, is strong and durable, easily manufactured and fitted, and presents a more neat and finished appearance.

The invention consists in the combination, with a milk-can having a flanged bottom, of a rolled sheet-metal bottom hoop or band having two horizontal slots or openings at each end, and provided internally with a longitudinal ogee molding, and a metal lock-plate having two upper and two lower wings or projections, which are inserted in the openings in the said band or hoop, and the top wings bent over and clinched on the back or inside of the band, and the under ones bent upward and similarly clinched tightly. The bottom of the can, which is made with an upward-projecting flange, is set into the hoop or band and made to rest on the projecting ogee molding on the inside center of the band or hoop, and securely soldered thereto. The body of the milk-can is then set on the bottom, with the flange aforesaid surrounding it on the outside, and the two firmly soldered together, the whole forming a strong, durable, and well-finished milk-can.

By reference to the drawings forming part of this specification, it will be seen that Figure 1 represents a partial view of the bottom hoop with its ends placed together. Fig. 2 is a view of the lock-plate with its upper and lower wings extended. Fig. 3 is a view of a portion of the bottom hoop with the lock-plate securing the ends of said hoop together. Fig. 4 is a vertical section of the can-bottom, hoop, and lock-plate. Fig. 5 is a perspective view of the bottom of a milk-can. Fig. 6 is a perspective view of the bottom hoop bent to a circular form, but not fastened. Fig. 7 represents the lower portion of a milk-can, showing the bottom hoop locked.

By reference to Fig. 1, A A represent upper horizontal slots in the bottom hoop, B B, and A′ A′ similar lower horizontal slots in the said hoop.

C, Fig. 2, is the lock-plate, stamped out in the form shown, with two top projections or wings, *d d*, one on each side of the center, respectively, and two lower ones, *e e*, similarly constructed.

Fig. 3 represents the projections *d d* and *e e* inserted in the openings A A A′ A′, and clinched on the inner side of the bottom band B, as shown by dotted lines.

D, Fig. 5, represents the bottom of the milk-can provided with an upward flange, *f*, and made to rest on the projecting molding *h*, after the hoop B is locked with the fastening C. The lowest portion of the body of the milk-can E is set on the bottom D, on the inside of the flange *f*, as shown at Fig. 7, and firmly soldered thereto. The same figure shows the bottom hoop locked, with the lock-plate C complete.

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

1. The combination, with the bottom hoop, B, having horizontal end slots, A A′, and provided internally with a longitudinal ogee molding, *h*, of the lock-plate C, having upper wings, *d d*, and lower wings, *e e*, substantially as described.

2. The combination, with a flanged milk-can bottom, D, of the hoop B, provided with end slots, A A′, and having an internal longitudinal molding, *h*, and the lock-plate C, hav-

ing upper and lower wings or projections, *d e*, to engage the slots in said hoop, substantially as described.

3. The combination of the bottom D, with its flange *f*, the bottom hoop, B, with projection *h*, the lock-plate C, with its projections *d d e e*, all arranged and constructed substantially as and for the purpose specified.

Dated at Hamilton, Ontario, this 15th day of March, A. D. 1886.

JOHN O'NEILL.

In presence of—
J. POTTER,
WM. BRUCE.