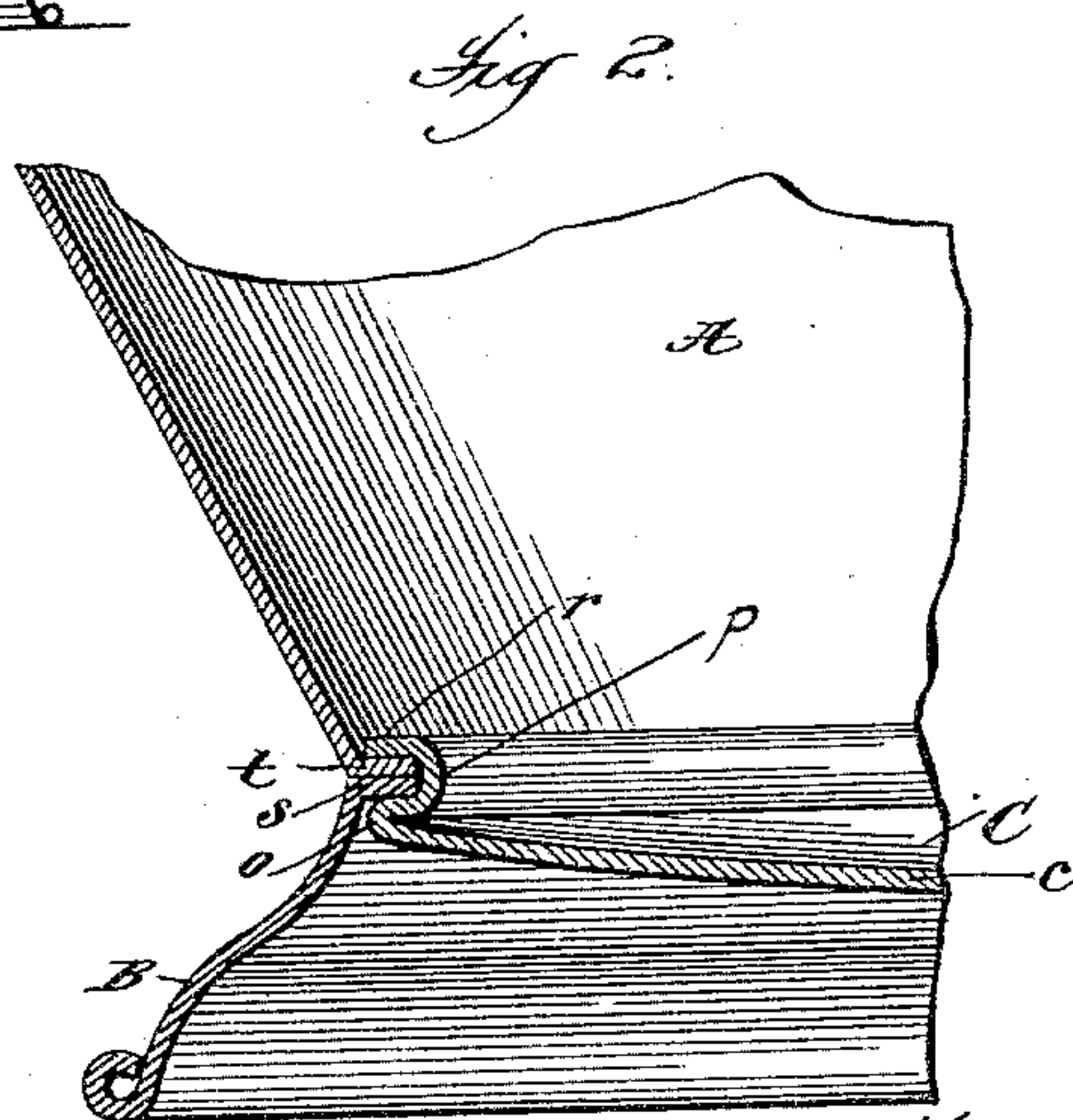
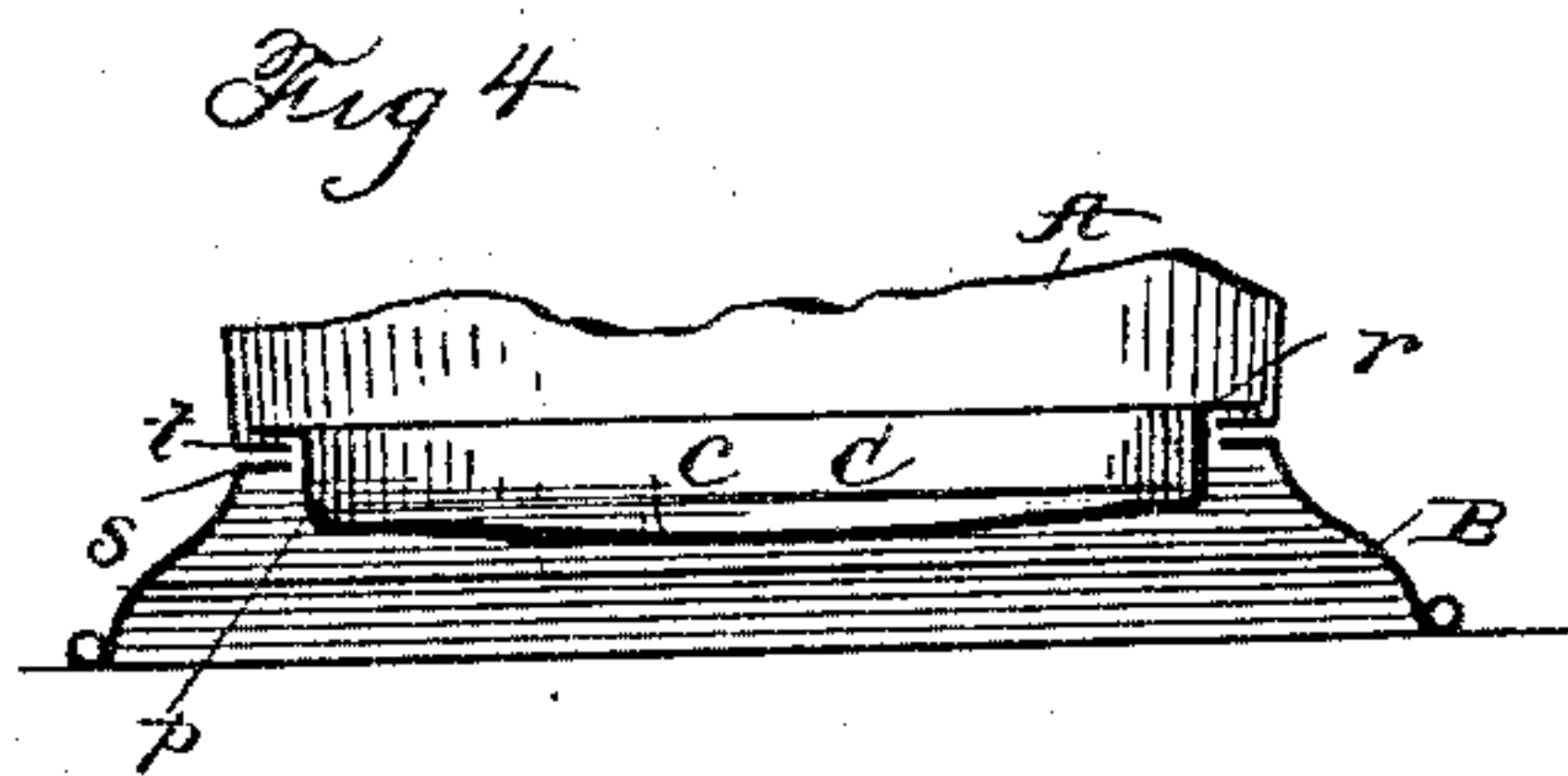
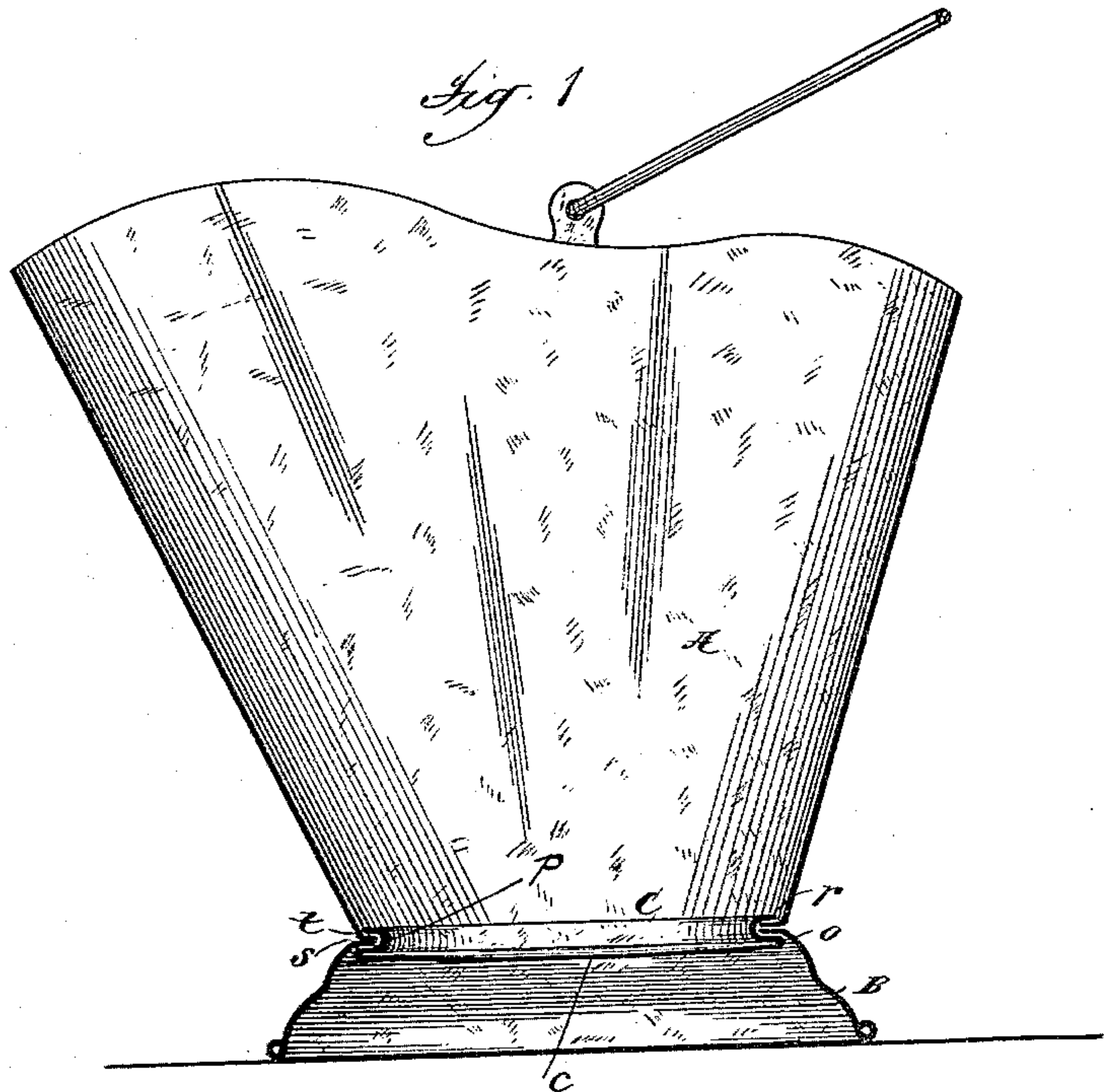


(No Model.)

H. S. REYNOLDS.  
SHEET METAL VESSEL.

No. 401,211.

Patented Apr. 9, 1889.



Attest:  
Geo. H. Botts  
E. Everett Ellis

Inventor:

Henry S. Reynolds

*Fig. 3*  
By Ernest C. Webb Atty:



# UNITED STATES PATENT OFFICE.

HENRY S. REYNOLDS, OF BROOKLYN, NEW YORK.

## SHEET-METAL VESSEL.

SPECIFICATION forming part of Letters Patent No. 401,211, dated April 9, 1889.

Application filed July 9, 1888. Serial No. 279,474. (No model.)

### *To all whom it may concern:*

Be it known that I, HENRY S. REYNOLDS, a citizen of the United States, residing at Brooklyn, in the county of Kings and State of New York, have invented certain new and useful Improvements in Sheet-Metal Vessels, of which the following is a full, clear, and exact description.

My invention relates to an improvement in sheet-metal vessels—such as coal-hods, pails, &c.—the object being to unite the body, foot, and bottom of a vessel of this character in a simple, rapid, and economical manner, at the same time making a strong and durable joint.

The invention consists in a vessel having a body and a foot, each provided with an inturned flange, and a cup-shaped bottom piece formed from sheet metal, and with an outwardly-projecting rim-flange, which is superposed upon the inturned flange of the body, and with sides between its rim-flange and bottom proper, which are upset or crimped to form a flange to confine the flanges of the foot and body between the rim-flange and this last-formed flange, substantially as hereinafter set forth and claimed.

In the drawings, Figure 1 is a central vertical section of a coal-hod constructed in accordance with my improvement. Fig. 2 is a broken central vertical section of the same, enlarged. Fig. 3 is a view of the dished bottom before its application to the coal-hod; Fig. 4, a central vertical section of the lower part of a chamber-pail, showing the arrangement of parts before the final stamping.

The prevailing characteristics of my invention are common to all articles of the class to which my improvement is applied, and therefore the letters of reference describing particular parts of the devices illustrated may also be understood to apply to corresponding parts of all other articles of a similar nature.

A represents the body portion, having the turned-in flange *t* at its lower end.

B represents the foot portion, having the turned-in flange *s* at its upper end.

C represents the dished bottom, having the outwardly-projecting flange *r* and dished portion *c*, leaving the vertical sides *p*.

The parts A, B, and C are separately constructed, and the flanges and other characteristics are provided in the usual manner. The parts are thereupon adjusted to one another, as illustrated in Fig. 4—that is to say, the body and foot portions A and C are so adjusted together that their flanges will coincide, and the dished bottom is set into the circular space, so that its flange shall rest on the flange of the body portion. Pressure is thereupon applied in the usual way and the dished bottom forced upward and outward, forming the additional flange *o*, thus providing two flanges, *r* and *o*, between which the rims *s* and *t* are secured and the body, foot, and bottom so united rigidly and firmly.

What I claim is—

The body A, having the flange *t*, foot B, having the flange *s*, and the bottom C, having the dished bottom *c*, the sides *p*, rising therefrom, and the outturned flange *r* at the upper edge of the sides, and the flange *o* beneath the flanges of the body and foot, the said flanges *r* and *o* embracing the flanges of the body and foot above the dished bottom, and thus uniting the body and foot and securing the bottom in place, substantially as described.

In testimony whereof I have hereunto set my hand this 25th day of June, A. D. 1888.

HENRY S. REYNOLDS.

Witnesses:

THORNE S. WALLING,  
FREDK. CARRAGAN.