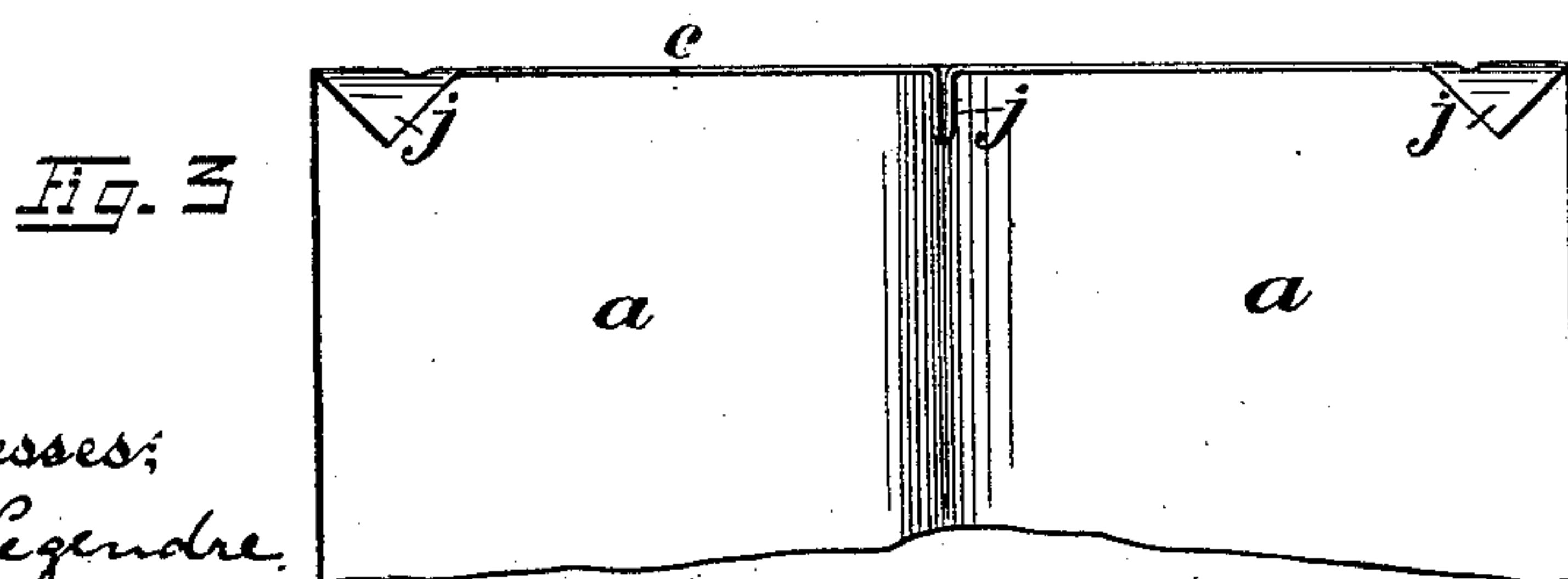
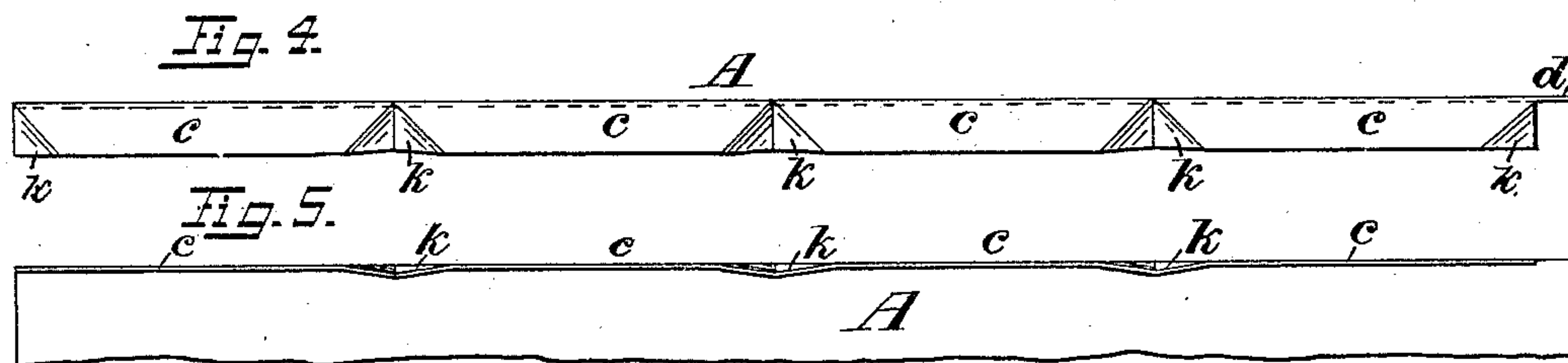
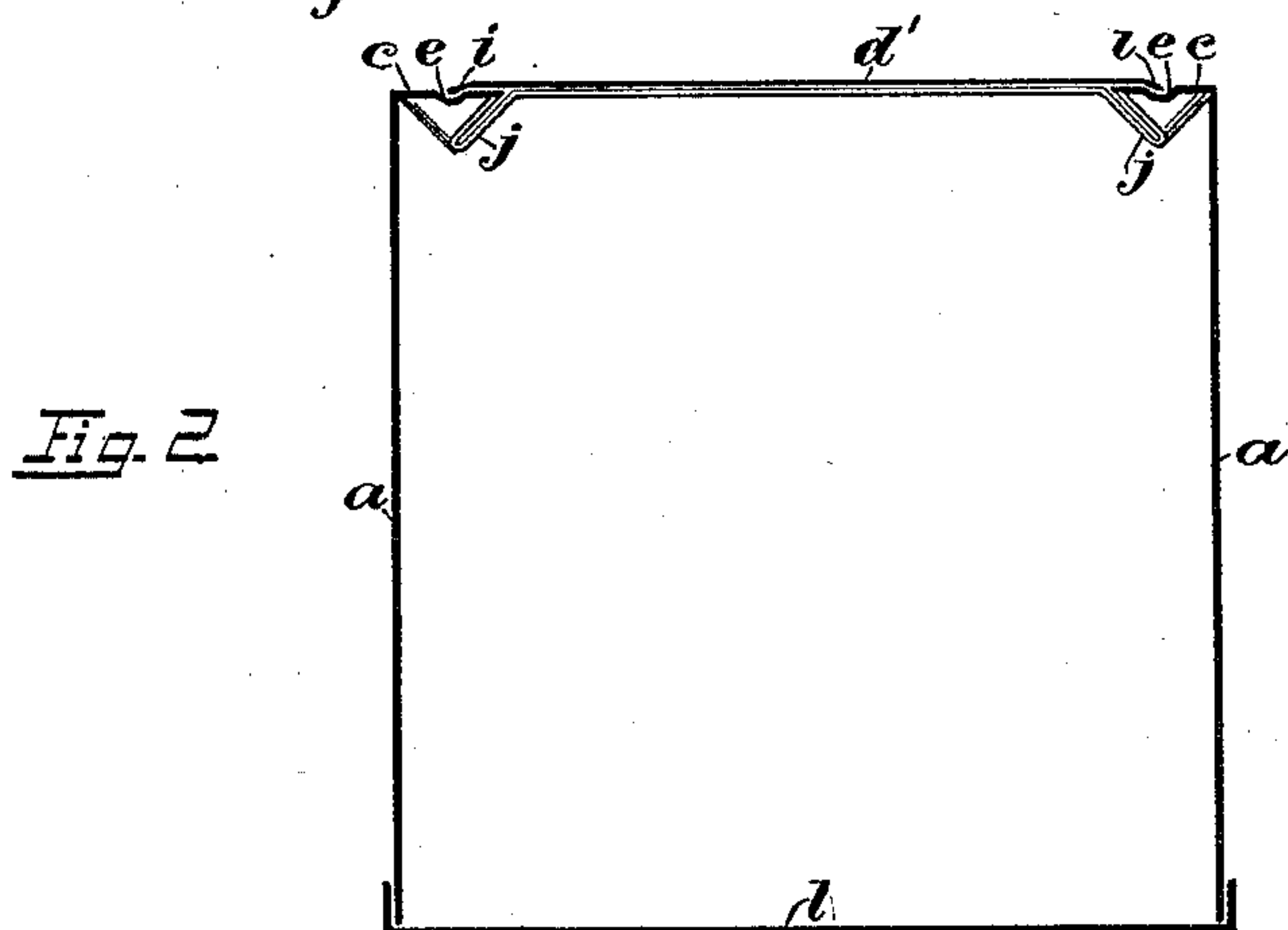
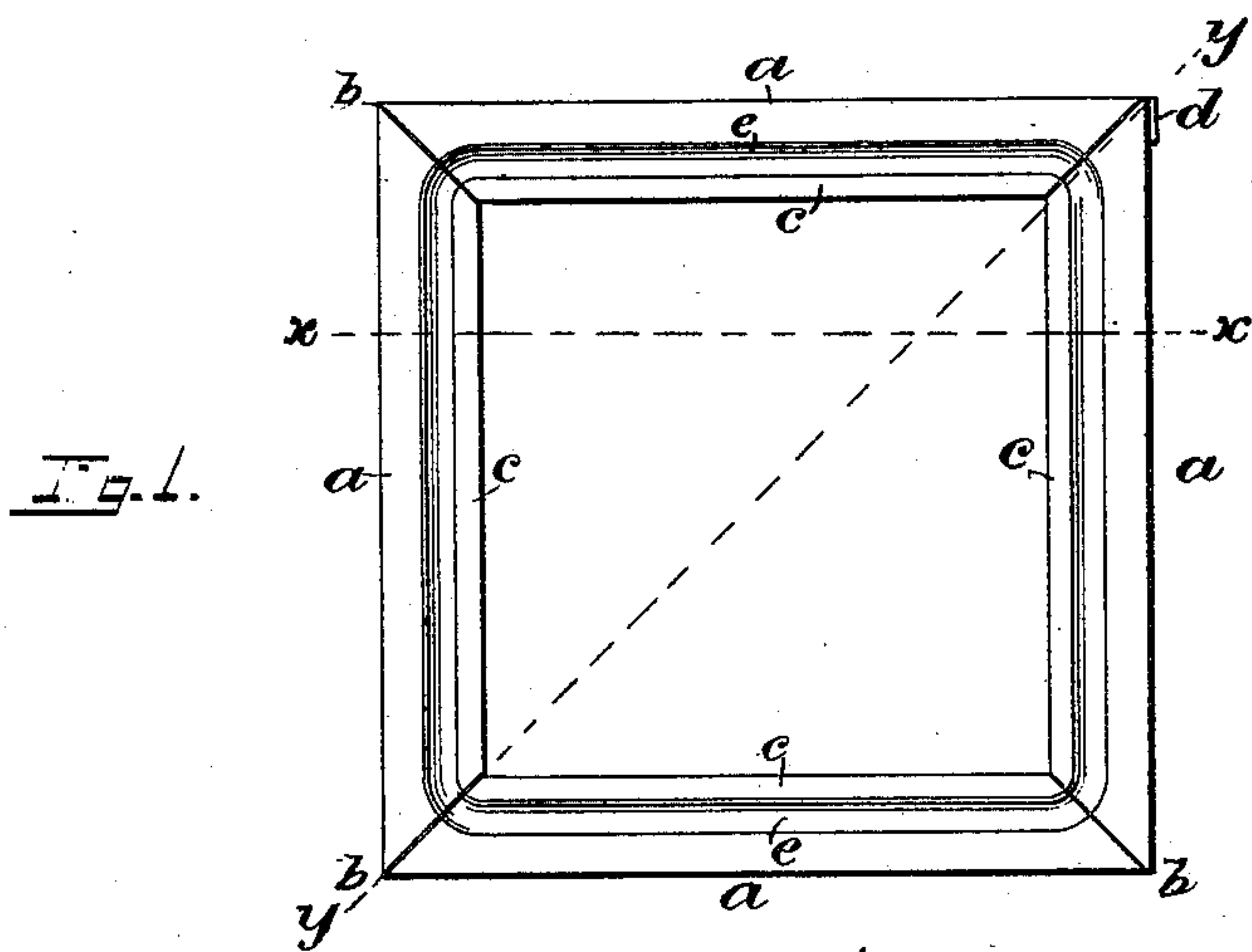


(No Model.)

F. A. ASSMANN.  
SHEET METAL CAN.

No. 451,355.

Patented Apr. 28, 1891.



Witnesses;  
L. N. Legendre.  
George Barry.

Inventor.  
Frank A. Assmann  
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Brown & Seward

# UNITED STATES PATENT OFFICE.

FRANZ A. ASSMANN, OF EAST ORANGE, NEW JERSEY.

## SHEET-METAL CAN.

SPECIFICATION forming part of Letters Patent No. 451,355, dated April 28, 1891.

Application filed February 5, 1891. Serial No. 380,311. (No model.)

*To all whom it may concern:*

Be it known that I, FRANZ A. ASSMANN, of East Orange, in the county of Essex and State of New Jersey, have invented a new and useful Improvement in Sheet-Metal Cans and other Vessels, of which the following is a specification, reference being had to the accompanying drawings.

This invention relates to cans and other vessels of sheet metal of polygonal form.

I will first describe my improvement in detail with reference to the drawings, and afterward point out its novelty in a claim.

Figure 1 represents a top view of a can embodying my invention, with the cover removed; Fig. 2, a vertical section in the line  $x x$  of Fig. 1 of the complete can and cover; and Fig. 3 a vertical section in the line  $y y$  of Fig. 1 of the upper part of the can without the cover. Figs. 4 and 5 are diagrams illustrating the method of making the body and part of the head of the can.

Similar letters of reference designate corresponding parts in all the figures.

In the example of my invention represented the polygonal side walls  $a$  of the can are made of a single plate of metal A, bent to form the corners or angles  $b$ , and one end of the plate is lapped over the other end at one corner or angle, as shown at  $d$  in Fig. 1, and soldered thereto to complete that corner or angle. The upper part of the plate is turned inward at a right angle, as shown in Figs. 1 and 2, to form an integral internal marginal flange  $c$ , which constitutes part of the head of the can, to which the cover  $d'$ , which completes the head, is to be secured by soldering. The said flange is represented as having formed in it a slight depression or channel  $e$ , and the cover (see Fig. 2) as having its edges  $i$  turned slightly downward to enter said channel, and thereby insure the proper placing of the cover and facilitate the soldering. The said flange  $c$  has provided in it corner-braces  $j$ , which at all the corners except  $d$ , where the ends of the plate are joined, are seamless and formed by gathering in the marginal portion of the plate of which the flanges  $c$  are formed. At the corner  $d$  there must of course be a seam in the brace  $j$ .

I will now explain, with reference to Figs. 4 and 5, the method of forming the side  $a$ , flange  $c$ , and corner-braces  $j$ . Fig. 4 represents a top view of the plate A, having the upper margin turned in to form the flange  $c$ , but not yet bent to form the sides of the can. Fig. 5 represents an inner face view of the upper part of said plate corresponding with Fig. 4. In order to facilitate the gathering in of those portions of the turned-in margin or flange  $c$  of the plate A which come opposite the corners or angles  $b$ , and which are to form the seamless corner-braces  $j$ , I produce in the said portions, with a suitable tool, before bending the plate to form the polygonal body or side walls  $a$ , a series of shallow angular depressions  $k$ , and then the act of bending the plate to form the said body or walls will gather or fold in the so depressed portions to form the said braces  $j$ . The gathers or folds thus produced may be afterward squeezed flat by means of a pair of pliers or other instrument. The channel  $e$  may be formed by a die after the plate A has been bent to form the walls and flanges and the cover  $d'$  soldered, and before the bottom  $l$  of the can is put on. The bottom may be fitted and put on in any known or suitable manner. By this construction of the can I obtain a very stiff flange around the upper part of the can and very strong upper corners compared with other cans having an upper internal flange integral with the sides and in which the necessary displacement of the metal at the corners of the flange has been effected by cutting it out and removing it altogether, and, moreover, I am enabled to more easily and securely solder the corners.

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

A sheet-metal vessel having its walls of polygonal form and in which one plate, constituting side walls, has its margin turned inward to form an integral flange and gathered in at the angles between the side walls to form seamless corner-braces in said flange, substantially as herein set forth.

FRANZ A. ASSMANN.

Witnesses:

FREDK. HAYNES,  
L. M. EGBERT.