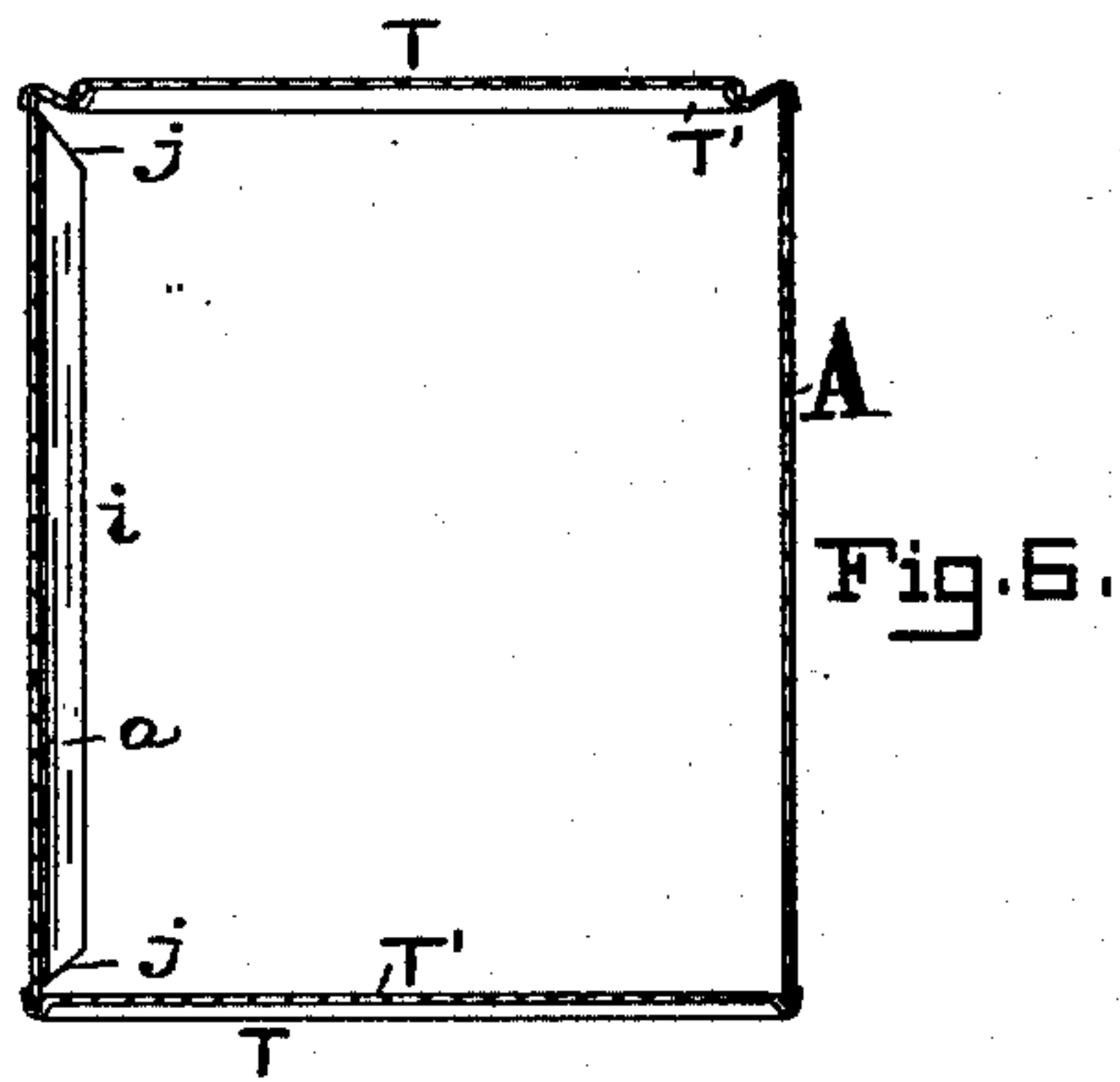
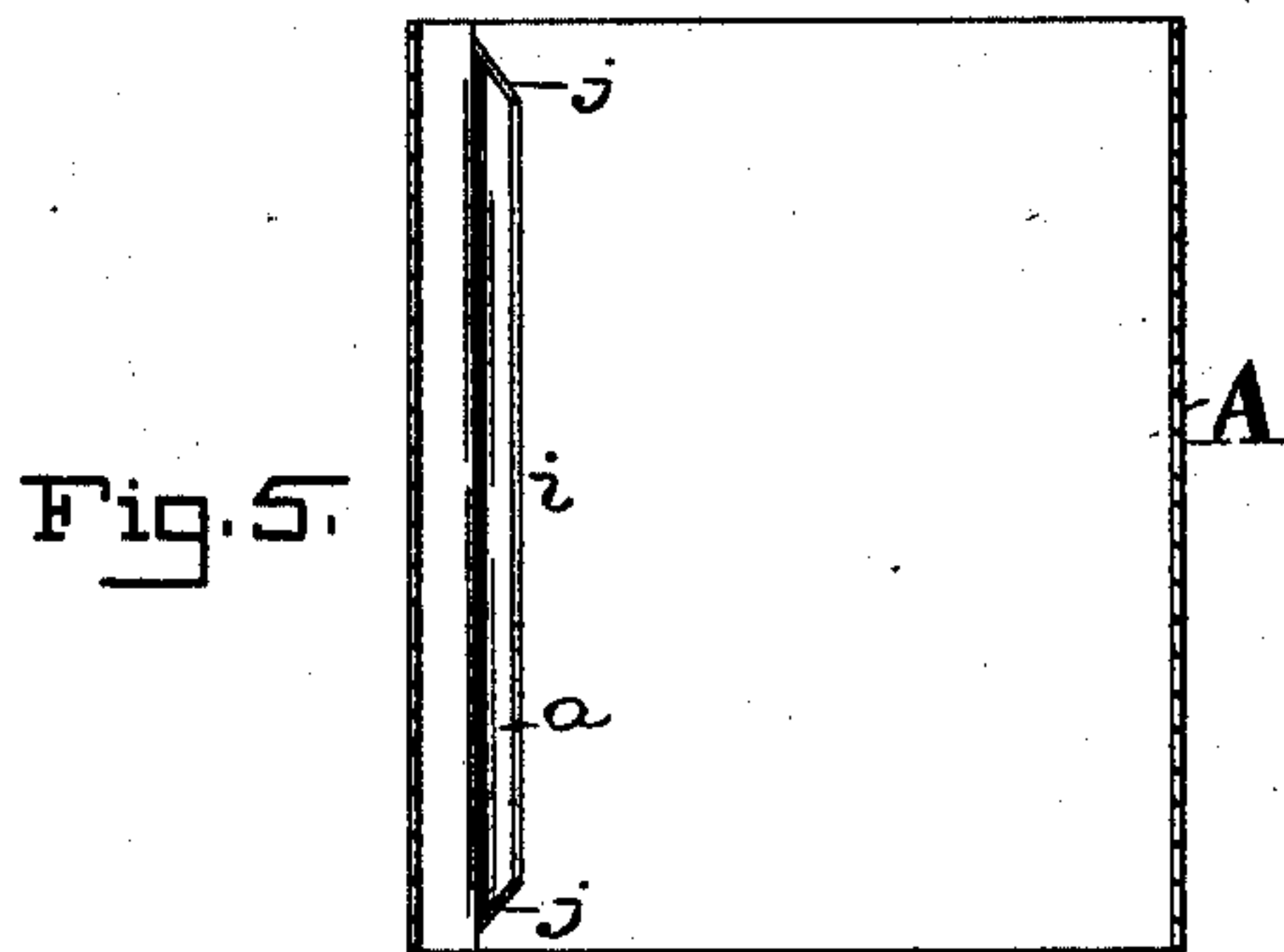
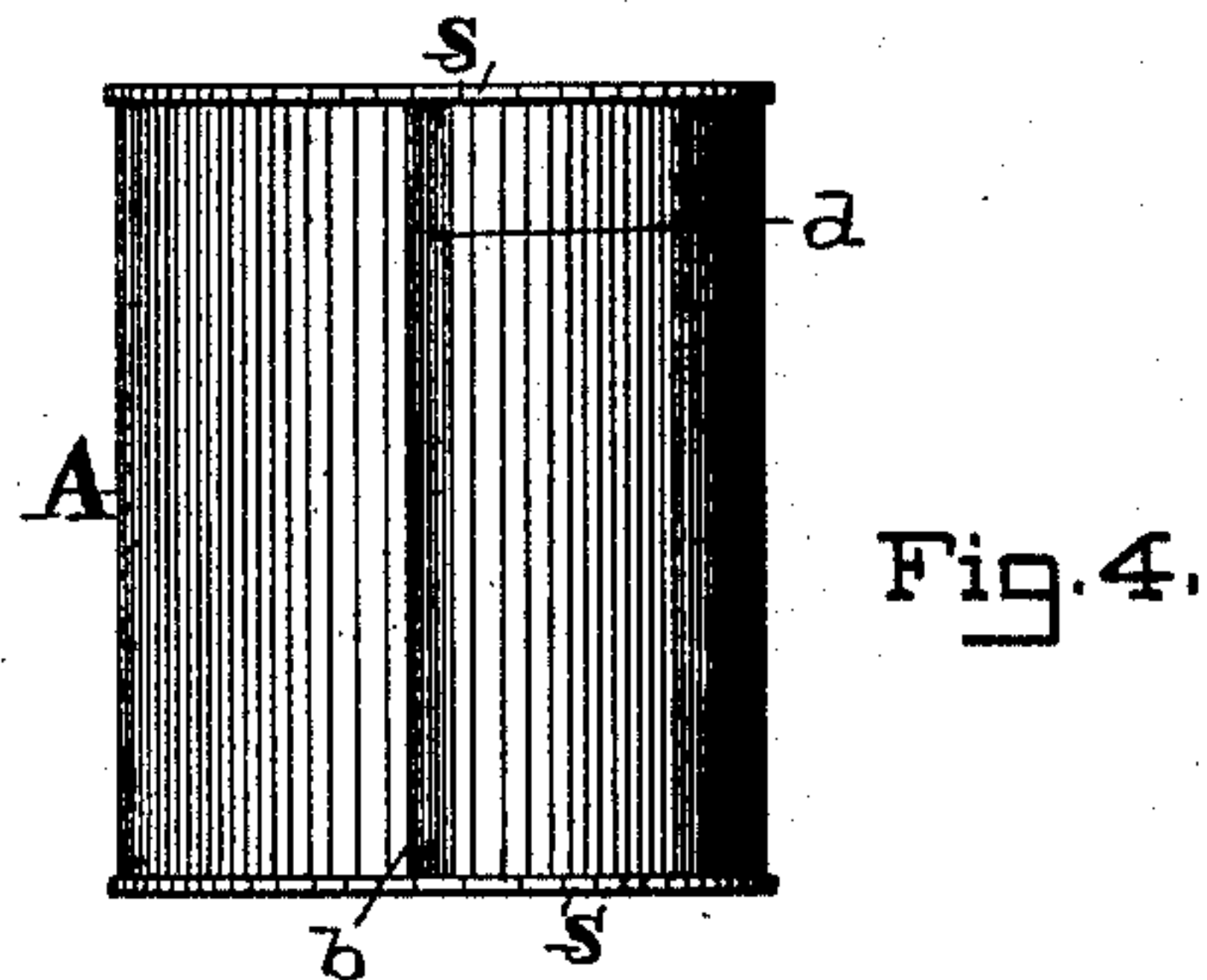
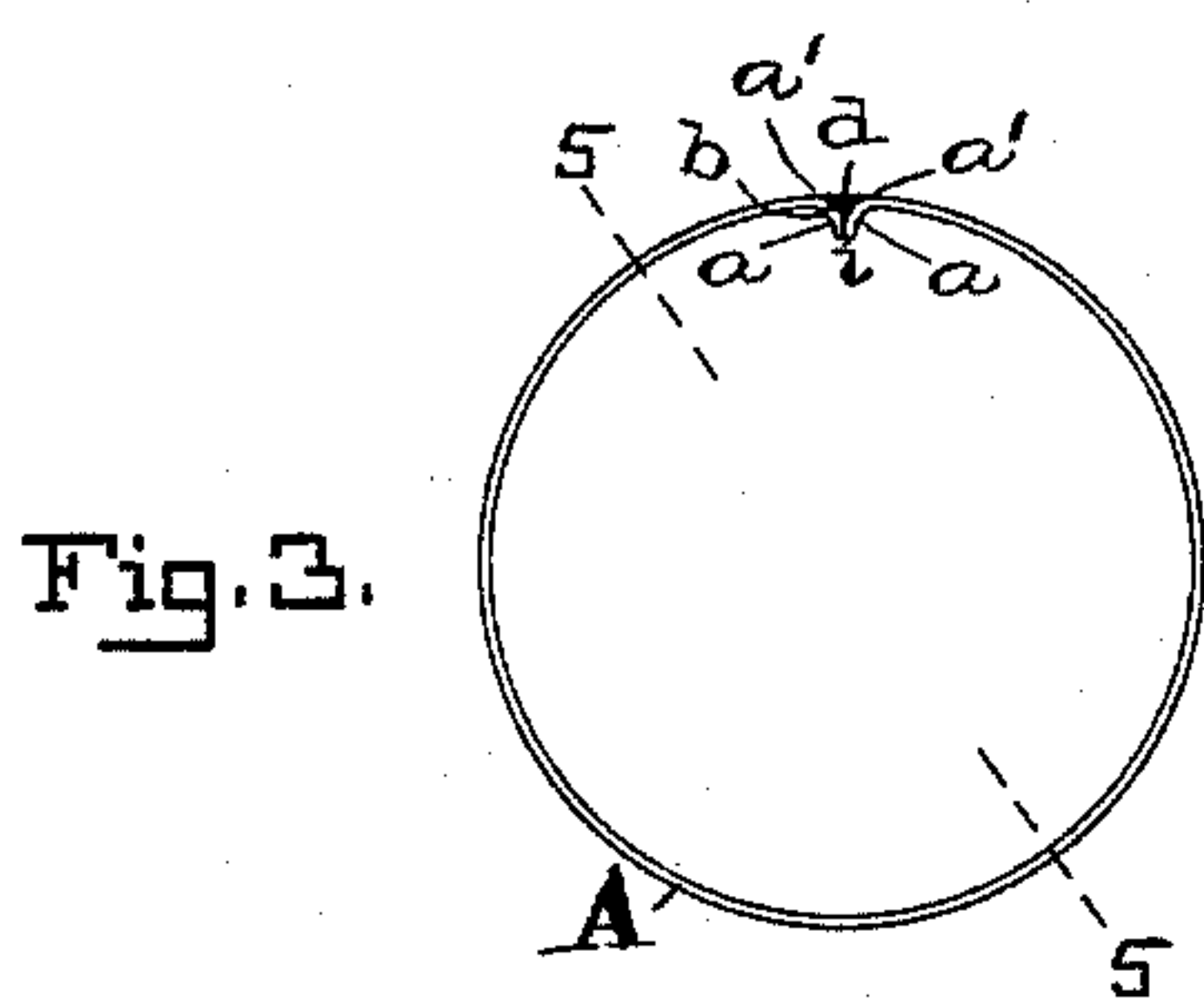
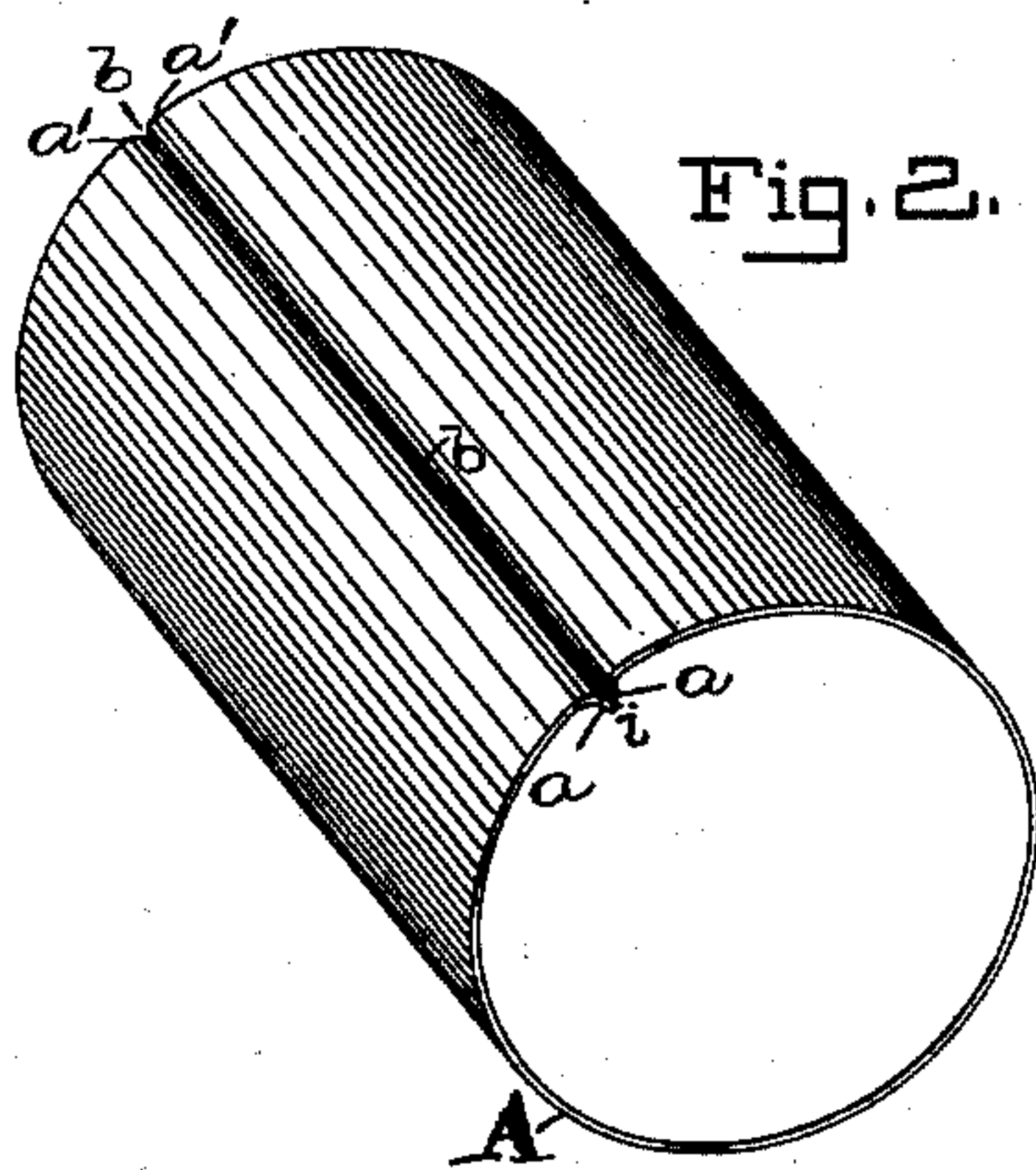
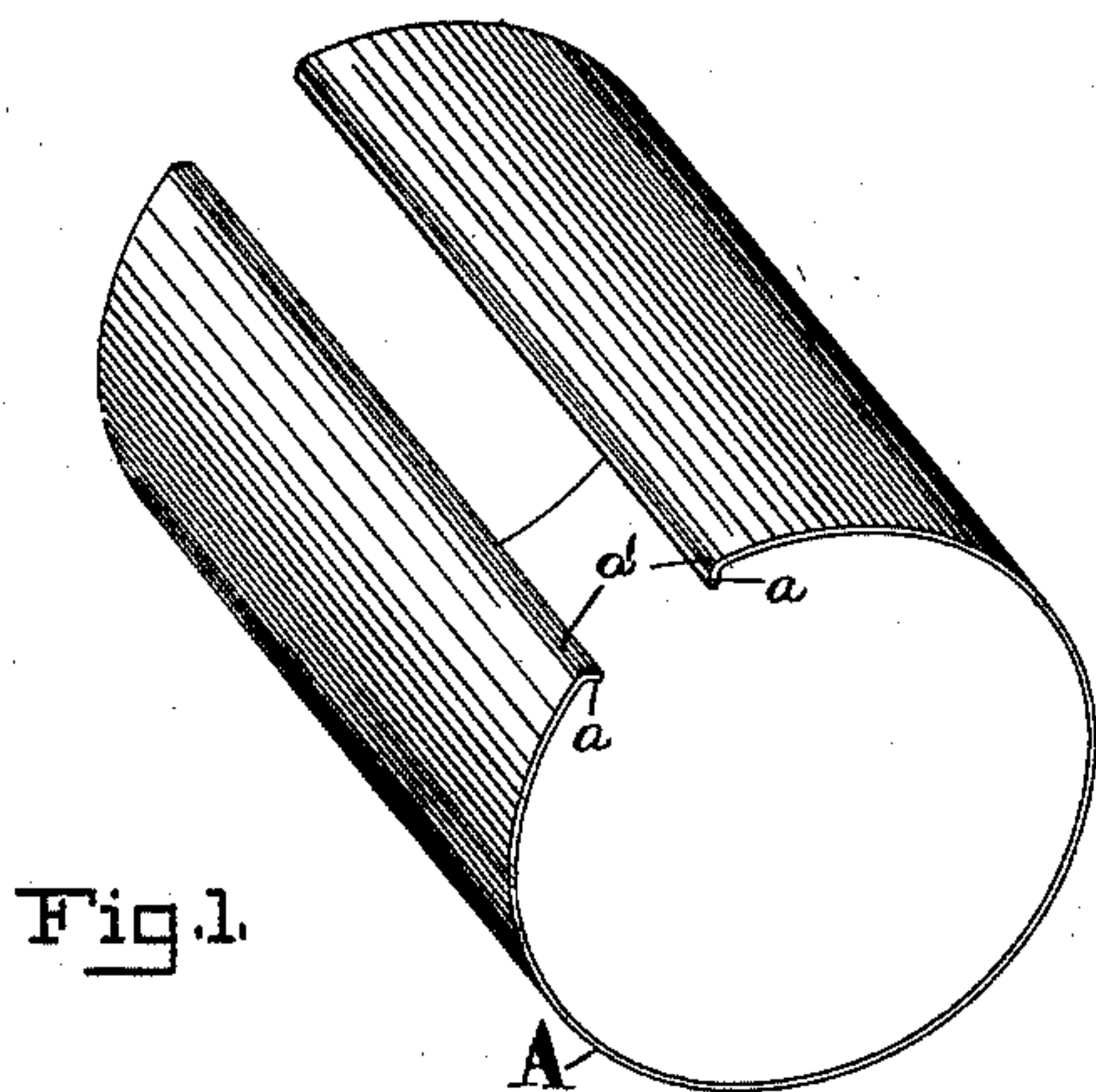


(No Model.)

I. H. TAYLOR.
SHEET METAL CAN BODY.

No. 483,660.

Patented Oct. 4, 1892.



WITNESSES:

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ISAIAH H. TAYLOR, OF BALTIMORE, MARYLAND.

SHEET-METAL CAN-BODY.

SPECIFICATION forming part of Letters Patent No. 483,660, dated October 4, 1892.

Application filed August 6, 1891. Serial No. 401,859. (No model.)

To all whom it may concern:

Be it known that I, ISAIAH H. TAYLOR, a citizen of the United States, residing at Baltimore city, in the State of Maryland, have invented certain new and useful Improvements in Sheet-Metal Can-Bodies, of which the following is a specification.

This invention relates to an improved sheet-metal can-body; and the object is to provide a better side seam than the lap-seam now universally employed.

To this end the invention may be said to consist in the novel features of construction hereinafter described and claimed.

The invention is illustrated in the accompanying drawings, in which—

Figure 1 represents a perspective view of the curled body-blank ready to be formed into a can-body; Fig. 2, a perspective view of the formed cylinder; Fig. 3, an end view of the same soldered; Fig. 4, an exterior view of a completed can with an ordinary slip top and bottom; Fig. 5, a section of a can-body prepared for a top and bottom, which have central portions fitting tight inside the cylinder or can-body; Fig. 6, a section of a completed can of the latter type.

The body-blank A, after being curled in the usual way by passing through rollers, has its end edges turned or bent in substantially at right angles to the said blank by some suitable means—such as a die and plunger—forming flanges *a*, which extend the length of the can-body. In forming the body only the extreme outer edges of these inturned flanges are brought together, as illustrated in Fig. 2. The corners *a'* where the sheet metal is bent to form the flanges are not sharp, but somewhat rounded, and it will be observed that an exterior substantially -V-shaped groove or channel *b* is consequently formed between said flanges.

The can-body is held on the soldering-machine by suitable jaws or clamping devices within said body, which clasp the flanges *a* and hold their edges together, and a strip of wire solder is laid in the groove *b*. The can-body now passes under suitable burners, which melt the solder *d* in the groove and cause it to effectually close the seam and secure the flanges *a* together.

The advantages of this improved seam are

as follows: A uniformity in the size of the bodies is effected, for the cylinder is formed by abutting the two flanges *a* and holding them together, and hence there can be no slipping, as may occur with the present lap-seam. The inturned flanges when together form on the inner side of the can-body a longitudinal rib *i*, which serves to greatly strengthen the body, and when filled cans are undergoing the cooking process this rib offers a resistance to the opening of the seam. Soldering of the seam is accomplished with better effect, because the clamping mechanism is within the can-body and the exterior is left entirely free. The seam is thus in full view, and hence can be closed effectually and no leaks left. A leak in this form of seam must extend from the bottom, where the edges of the flanges are in contact, to the top of the solder and would be clearly perceptible, as will be obvious. No soldering-tools are necessary in closing the seam, as seen from the previous description of the manner of accomplishing this. The solder is simply laid in the channel of the seam and the can passed beneath suitable burners, which melt the solder in the seam. The seam is much stronger than the ordinary lap-seam. Compression of the can-body simply forces the flanges *a* against each other and does not tend to open the seam, whereas with the lap-seam such compression will tend to open the seam, as is obvious.

In completing the can the ordinary slip top and bottom S may be applied the same as to any common can-body without the rib *i* interfering in any way, and the finished can appears as shown in Fig. 4. If, however, the can is to be made with a top and bottom such as T, Fig. 6, the central portions T' of which fit inside the cylinder, then the flanges *a*, forming the rib *i*, are cut off on a slant at the ends, as shown at *j*, Fig. 5, to allow the top and bottom to be fitted into the can-body, as represented in Fig. 6.

I have hereinbefore stated that the soldering may be done by simply subjecting the seam to flame. It will be obvious that this may also be accomplished in the usual way by use of a soldering-tool.

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

A can-body having its confronting or adjacent edges bent inward to form flanges, the extreme outer or tip edges of which flanges touch with each other, and thereby form a
5 trough or substantially-V-shaped groove longitudinally along the can-body between said flanges, and a filling of solder in the groove extending from the bottom of the trough substantially out to the exterior of the can,

whereby a uniformity of exterior is secured, 10 substantially as set forth.

In testimony whereof I affix my signature in the presence of two witnesses.

ISAIAH H. TAYLOR.

Witnesses:

JNO. T. MADDOX,
F. H. ABBES.