

(No Model.)

L. STURGES.  
MILK CAN COVER.

No. 546,498.

Patented Sept. 17, 1895.

FIG. 1

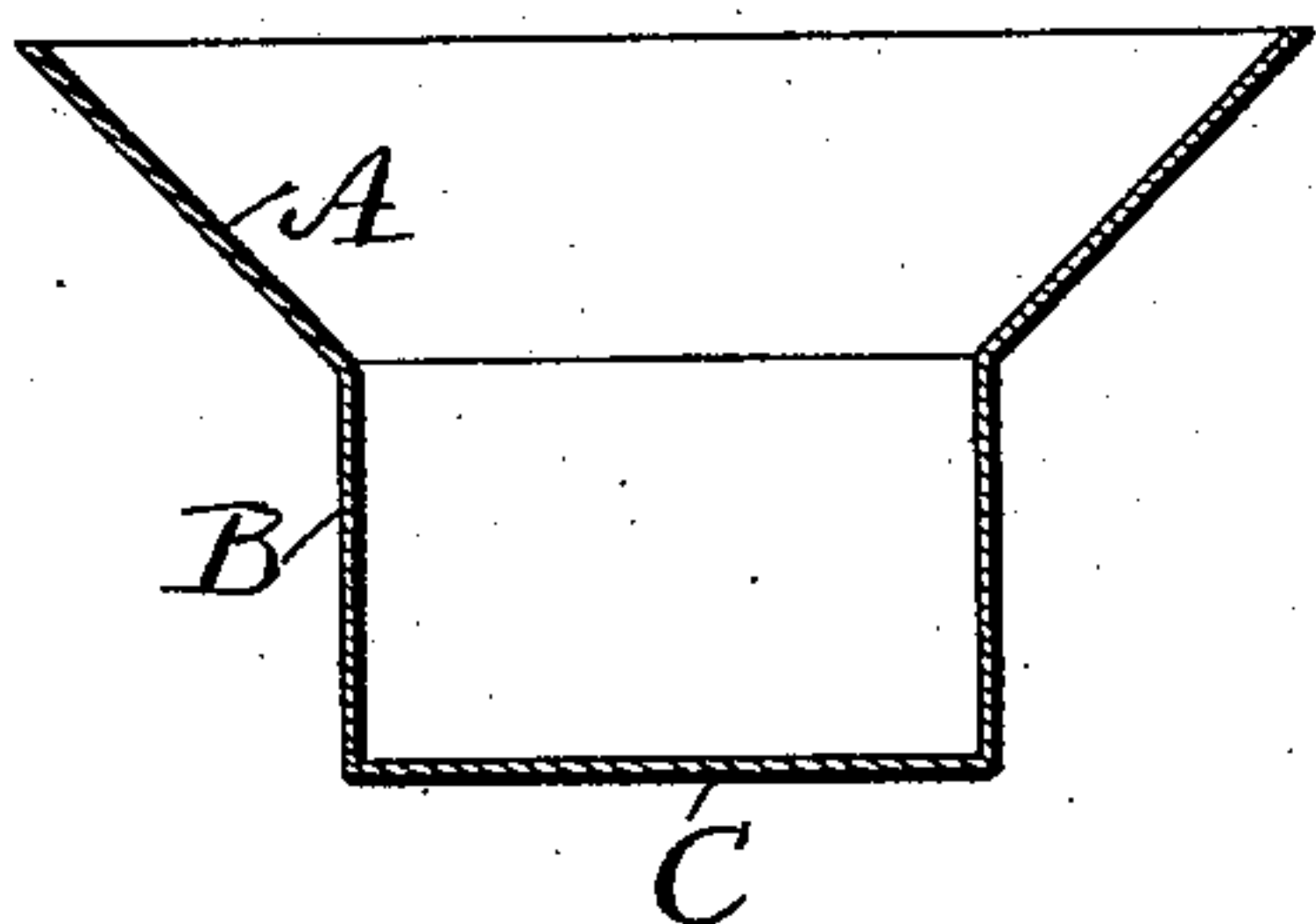


FIG. 2

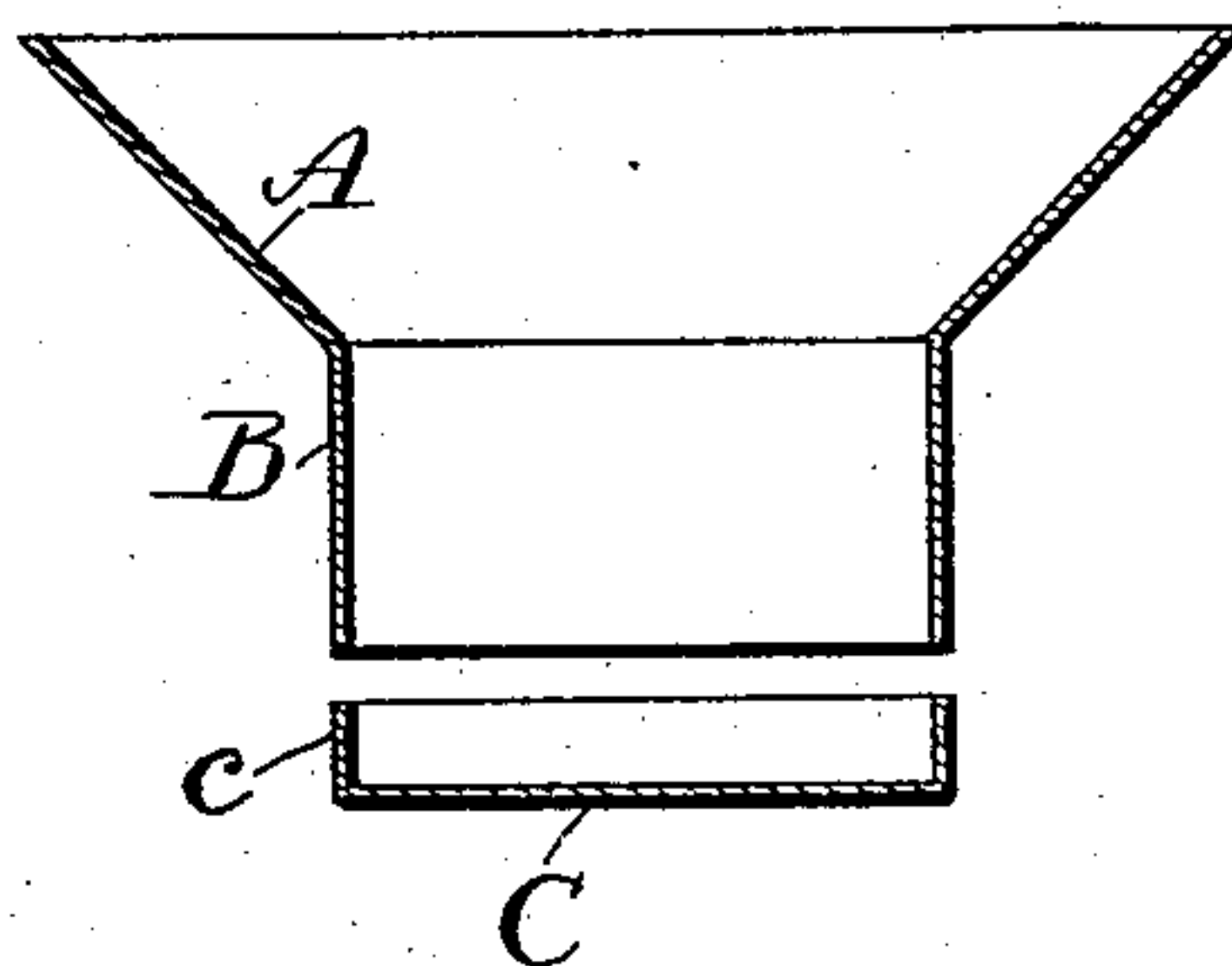


FIG. 3

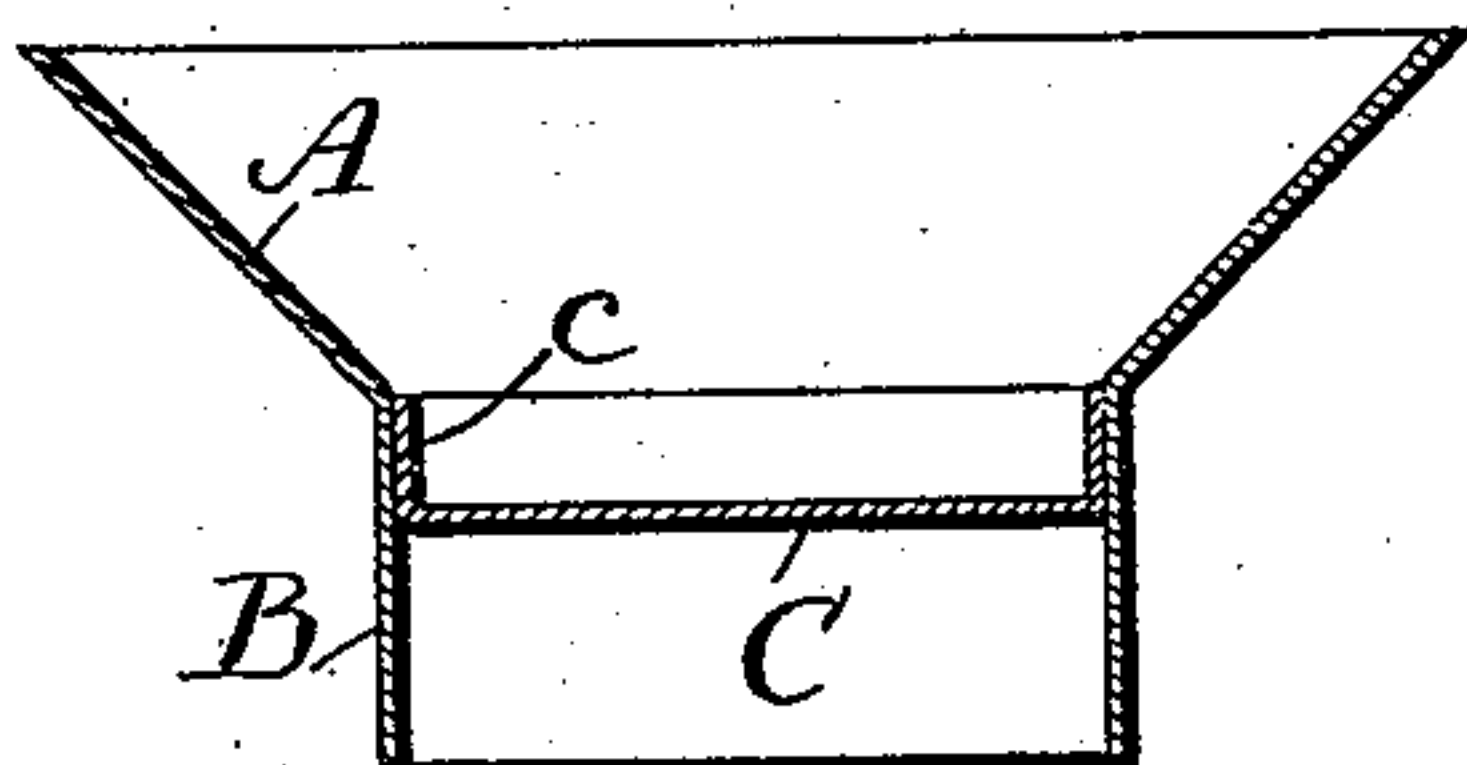


FIG. 4

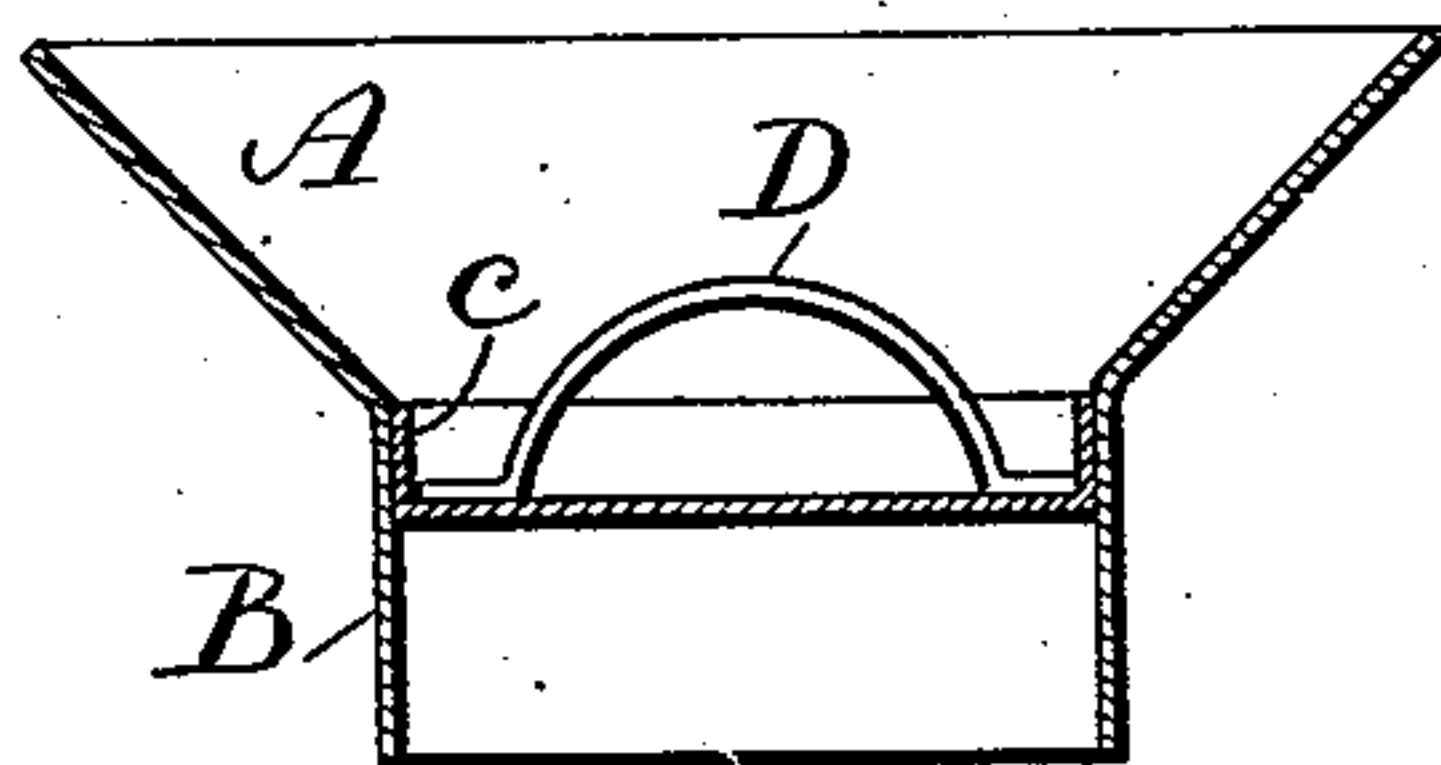


FIG. 5

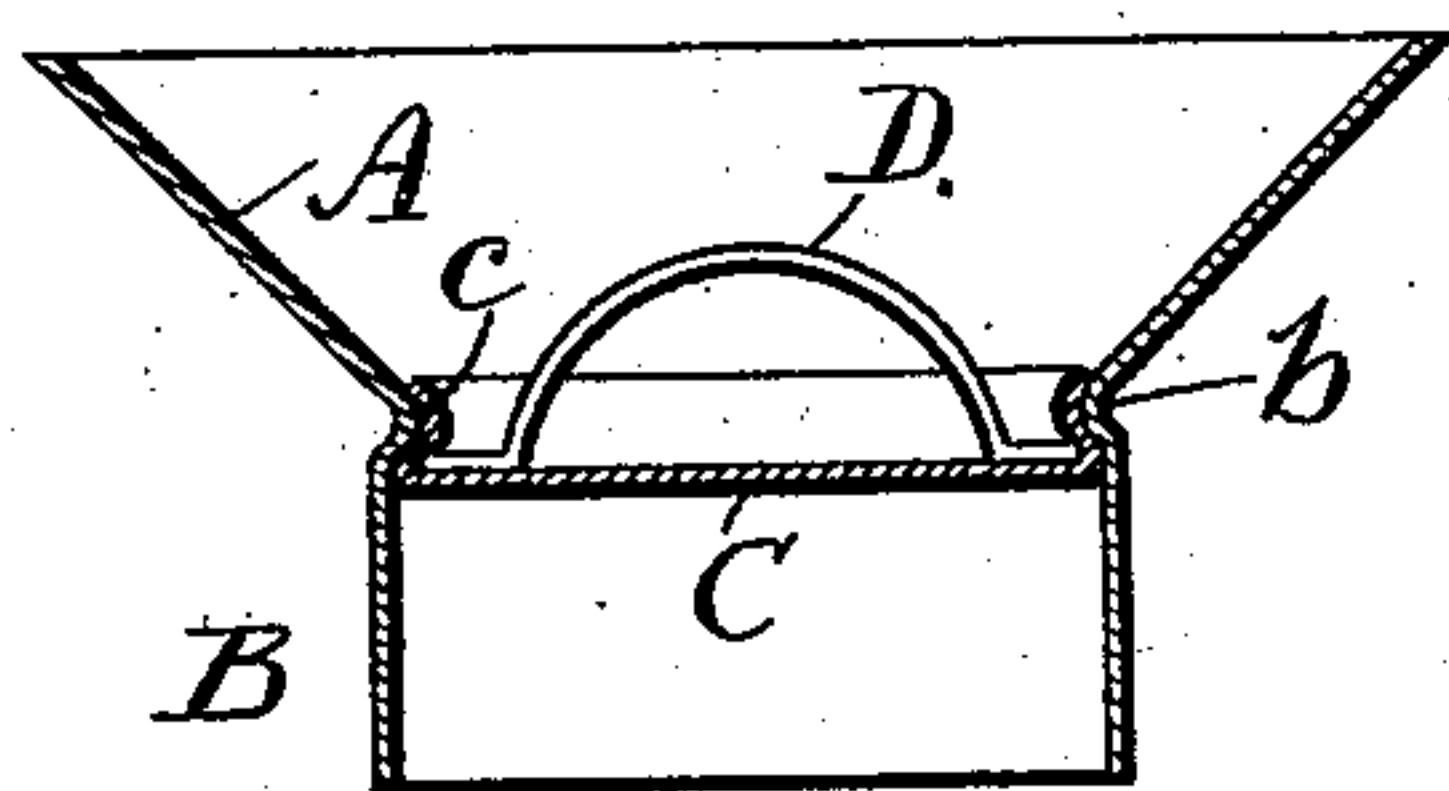
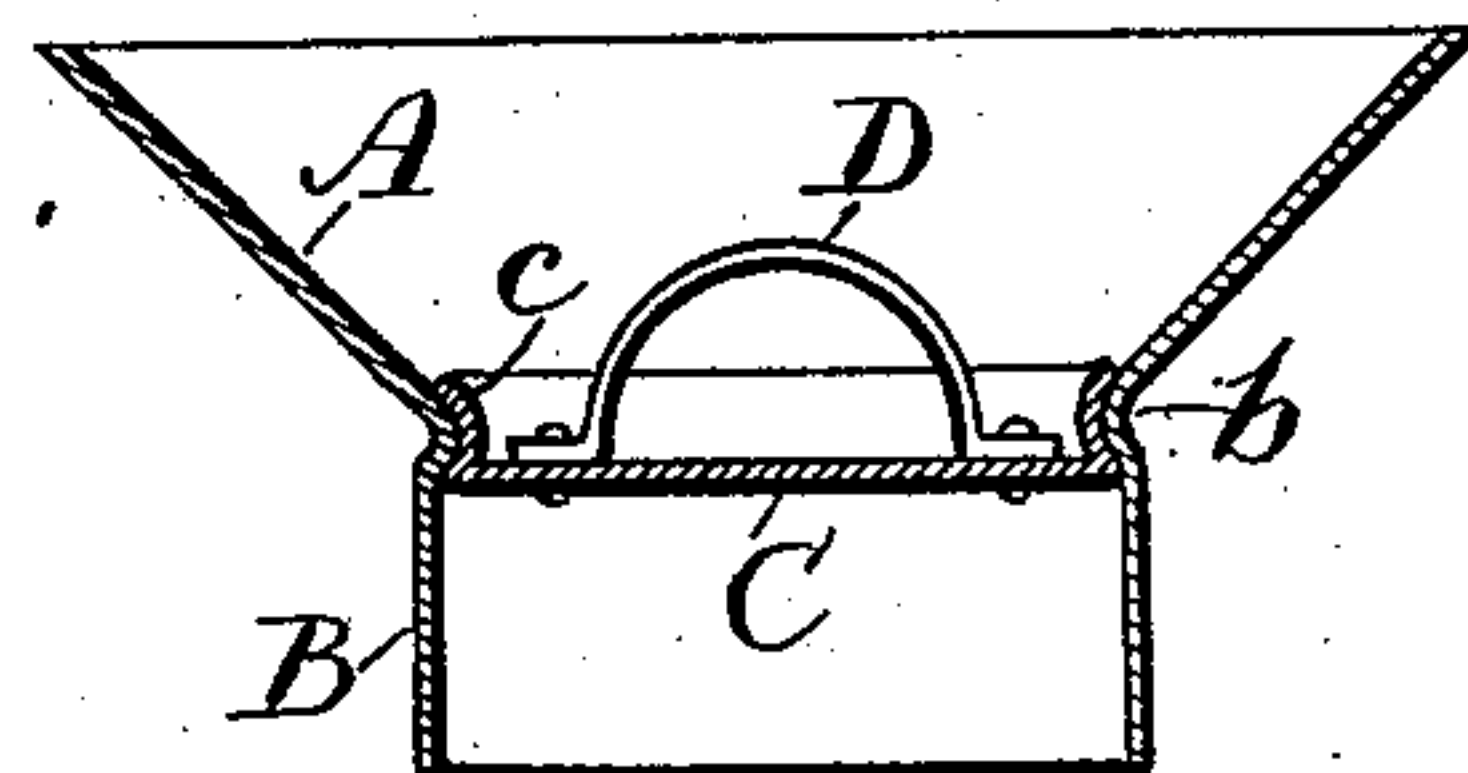


FIG. 6



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Inventor:  
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By his attorney,  
Gibbs & Hopkins

# UNITED STATES PATENT OFFICE.

LEE STURGES, OF CHICAGO, ILLINOIS, ASSIGNOR TO THE CHICAGO STAMPING COMPANY, OF SAME PLACE.

## MILK-CAN COVER.

SPECIFICATION forming part of Letters Patent No. 546,498, dated September 17, 1895.

Application filed January 2, 1895. Serial No. 533,606. (No model.)

*To all whom it may concern:*

Be it known that I, LEE STURGES, a citizen of the United States, residing at Chicago, in the county of Cook and State of Illinois, have  
5 invented certain new and useful Improvements in Covers for Milk-Cans and in the Method of Making Them, of which the following is a specification, reference being had to the accompanying drawings, which are  
10 made a part hereof, and in which—

Figures 1 to 5, inclusive, are sections showing the cover at five successive stages, Fig. 5 showing it completed. Fig. 6 is a section of a cover embodying some features of the invention.  
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One object of the invention is to provide a cover which shall be stronger, more durable, and superior in other respects to covers as heretofore constructed; and another object of  
20 the invention is to provide a method by which the improved cover may be made with the least possible waste of material and at a minimum cost; and to these ends the invention consists in the features of novelty that  
25 are particularly pointed out in the claims hereinafter.

The completed cover, as shown in Fig. 5, has a flaring portion A and a cylindrical portion B that are integral, a diaphragm C, located in the cylindrical portion, and having  
30 a marginal flange c, bent to embrace a bead b on the interior of the cylindrical portion, and a handle D, the ends of which project beneath the bent margin c of the diaphragm.

The method of making this cover is as follows: The sheet-metal blank is drawn by dies to the form shown in Fig. 1, where A represents the flaring portion, B the cylindrical portion, and C the diaphragm. The next  
40 step in the process is to sever the neck a short distance from the diaphragm, leaving a portion of the cylindrical portion on the diaphragm to form the flange c, as shown in Fig. 2.

The diaphragm and its flange are then redrawn to reduce its external diameter sufficiently to allow it to be forced into the cylindrical portion, as shown in Fig. 3, this being the next step in the process. The handle D is then put upon top of the diaphragm,  
50 with its ends touching or close to the flange,

and the flange and cylinder are then subjected to the action of beading-rolls to form the bead b and at the same time bend the flange c over it.

If desired, the handle may be secured without confining its ends beneath the bead, as shown in Fig. 6.

What I claim is—

1. A cover for milk cans having a seamless flaring portion, a seamless cylindrical portion  
60 integral therewith, a bead on the interior of the cylindrical portion, a diaphragm closing the cylindrical portion and having a marginal flange embracing said bead, and a handle having ends projecting beneath the bent  
65 flange of the diaphragm, substantially as set forth.

2. The method of making covers for milk cans which consists in drawing the blank to a form having a flaring portion, a cylindrical  
70 portion, and a diaphragm closing the end of the cylindrical portion, then severing the diaphragm from the cylindrical portion and then securing the diaphragm in the cylindrical portion so as to close it, substantially as  
75 set forth.

3. The method of making covers for milk cans which consists in drawing the blank to a form having a flaring portion, a cylindrical portion and a diaphragm closing the end of  
80 the cylindrical portion, then severing the diaphragm from the cylindrical portion and then securing the diaphragm in the cylindrical portion, above the bottom thereof, substantially as set forth.  
85

4. The method of making covers for milk cans which consists in drawing the blank to a form having a flaring portion, a cylindrical portion and a diaphragm closing the cylindrical  
90 portion, severing the cylindrical portion some distance from the diaphragm, leaving said diaphragm with a marginal flange, redrawing the diaphragm to reduce its diameter to less than the interior diameter of the cylindrical portion, and securing the dia-  
95 phragm in the cylindrical portion, substantially as set forth.

5. The method of making covers for milk cans, which consists in drawing the blank to a form having a flaring portion, a cylindrical  
100



portion, and a diaphragm closing the cylindrical portion, severing the cylindrical portion some distance from the diaphragm, leaving said diaphragm with a marginal flange, re-  
5 drawing the diaphragm to reduce its diameter to less than the interior diameter of the cylindrical portion, inserting the diaphragm in the cylindrical portion and beading the cylindrical portion and the flange of the diaphragm to secure the diaphragm in place, 10 substantially as set forth.

LEE STURGES.

Witnesses:

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J. HALPENNY.