

No. 620,235.

Patented Feb. 28, 1899.

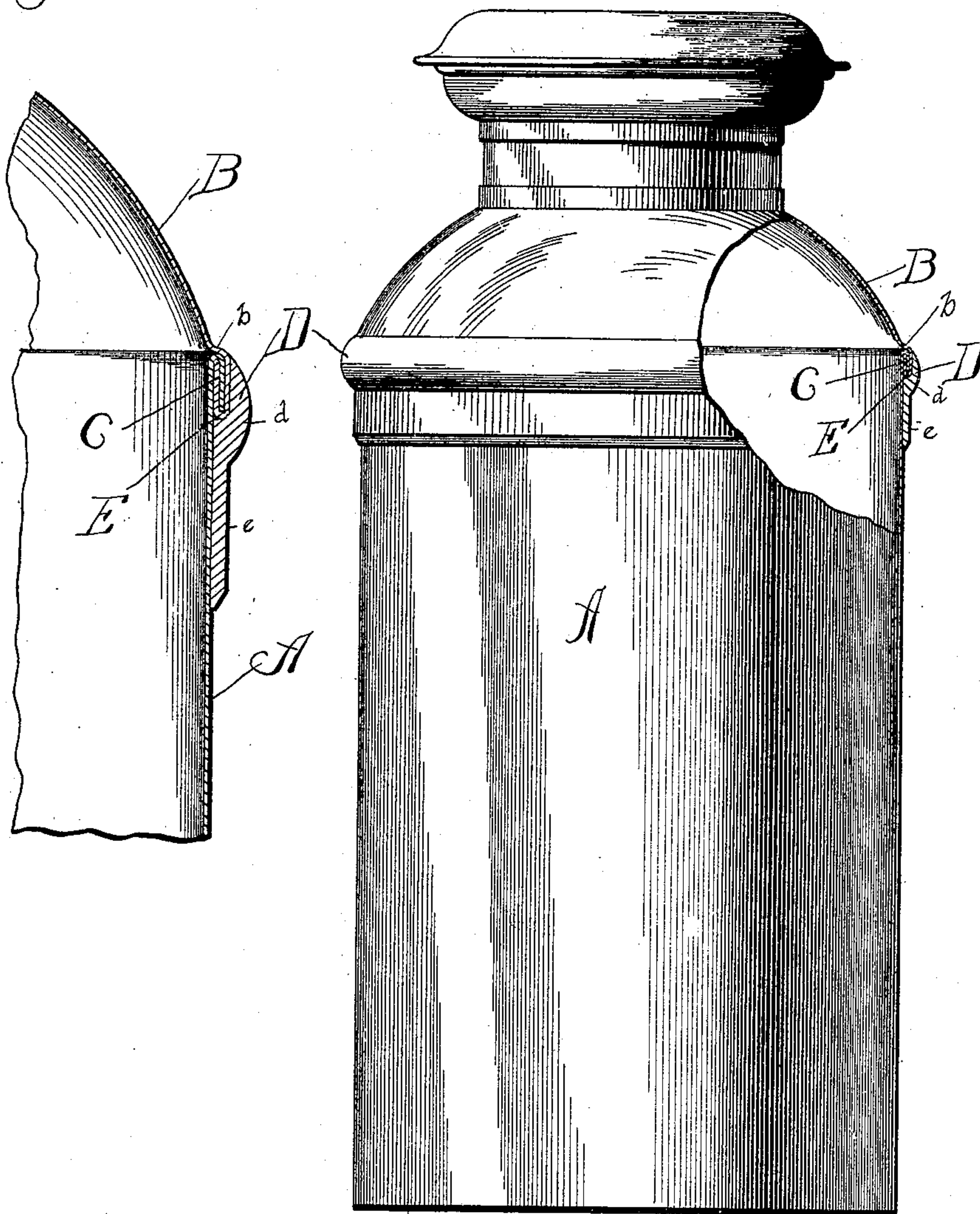
T. W. FORSTER.
METALLIC VESSEL.

(Application filed June 16, 1898.)

(No Model.)

Fig. 2.

Fig. 1.



Witnesses:
J. B. Keir
Baron W. Schumacher

Inventor
Thomas W. Forster
by Josiah McRoberts
his Att'y

UNITED STATES PATENT OFFICE.

THOMAS W. FORSTER, OF DETROIT, MICHIGAN.

METALLIC VESSEL.

SPECIFICATION forming part of Letters Patent No. 620,235, dated February 28, 1899.

Application filed June 16, 1898. Serial No. 683,660. (No model.)

To all whom it may concern:

Be it known that I, THOMAS W. FORSTER, a citizen of the United States, residing at Detroit, in the county of Wayne and State of Michigan, have invented a new and useful Metallic Vessel, of which the following is a specification.

My invention relates to metallic vessels, and particularly to that class of milk-cans which have a protecting hoop or band upon the outside at the point where they are most liable to be struck and dented in handling.

The object of my invention is to provide certain improvements in vessels of this description, which object I accomplish as illustrated in the drawings and as hereinafter set forth.

Heretofore in this class of devices it has been found difficult to provide a construction that will present a perfectly smooth interior finish along the line of union of the breast and body and at the same time present a sufficient bearing for the hoop or band, so that the latter will not readily become detached. Thus if the breast and body be united by an inwardly-turned seam or by a seam in which the folds are substantially horizontal a shoulder is formed where milk will lodge and soon render the can foul and unfit for use. If, on the other hand, the seam be made by turning the folds outwardly, a space is left between the hoop and body when the parts are assembled that must be filled with solder or the hoop will not have a bearing of sufficient width to make it permanent and it will soon become loose, destroying the usefulness of the can. To fill this space with solder consumes much time and is laborious. By my improved construction all of these objections are obviated and the inside of the can is perfectly smooth, affording no lodgment for milk to foul the can, while the hoop is permanently held in place without the aid of solder.

Referring to the drawings, in which the same reference-letter indicates the same part in each view, Figure 1 is a side view of a milk-can, illustrating my improvement, parts being broken away to show the hoop, breast, and body, partly in section; and Fig. 2 is a sectional detail view.

In the drawings the reference-letter A in-

dicates the body of the can, which is made of a suitable sheet of steel.

The letter B indicates the can-breast, also of steel and made in the usual form adapted for this class of devices. The body and breast are united by a seam C. This seam is formed by interlocking the edges of the breast and body in the usual manner known to the art. The seam is external or outwardly projecting as distinguished from an internal seam. Hence no shoulder is formed on the inside of the can to become foul, and as the offset *b* of the breast is approximately the width of the bend of the body A the inside finish is smooth.

The letter D indicates the hoop or band, which forms a joint-protector and bumper and which is of wrought-iron. It is composed of the body *d* and the skirt *e*. The body *d* has a suitably-shaped preferably round exterior face, forming the bumper portion, and a shouldered or cut-away interior face. The skirt *e* has flat sides, the inner side being extended in the same plane as the inner face of the body *d*, and its outer face is beveled at the lower end. When the breast and body of the can have been united by the seam *c*, as above set forth, the ring D is then heated to a suitable temperature and slipped over the body A from beneath until the shoulder E of the ring comes in contact with the shoulder formed by the outwardly-turned seam. It is then allowed to cool, during which process it shrinks sufficiently to tightly and securely grip the body of the can and the seam C. In making this ring or hoop D the cut-away portion is made of the proper size to fit the shoulder formed by the seam uniting the body and breast, so that when the parts are finally assembled the exterior rounded face of the body of the ring forms practically a continuation of the offset *b* of the breast. The parts thus assembled are immersed in a tinning-bath. The metal closes all openings between the ring and the can and also between the breast and the body along their line of union. The beveled edge of the skirt *e* permits the metal of the tinning-bath to make a much smoother joint and finish at this point and avoids all appearances of a shoulder.

In prior constructions it was usual after

the can had been tinned to run solder into the joint made by the upper bent edge of the body and the offset *b* in order to make a tight joint. It has been found that by using the shouldered band or hoop *D* the parts are so firmly united as to render the use of solder unnecessary. The metal of the tinning-bath effectually closes the joint and also gives an unbroken perfectly smooth finish to the inside of the can.

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

The combination, with a metallic vessel having an external lapped seam forming an offset to provide a smooth interior finish, of a joint-protecting band having its edge cut away to fit the seam, and an integral bumper forming a continuation of the offset, substantially as described.

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

THOMAS W. FORSTER.

Witnesses:

JOHN F. BREEN,
ADA J. BLACK.