

No. 673,550.

Patented May 7, 1901.

J. W. WALLACE.
SHEET METAL VESSEL.
(Application filed May 10, 1900.)

(No Model.)

Fig: 1.

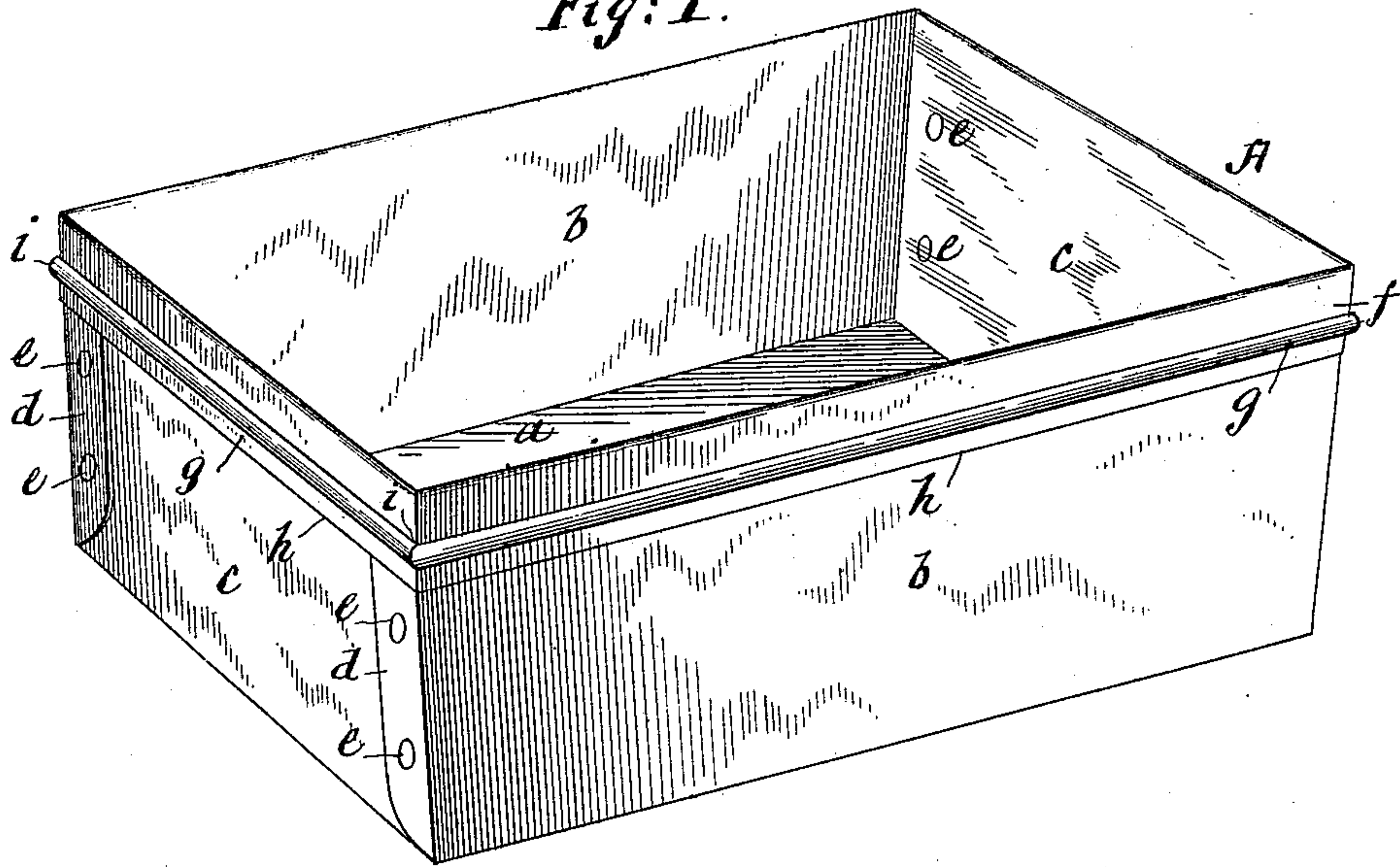
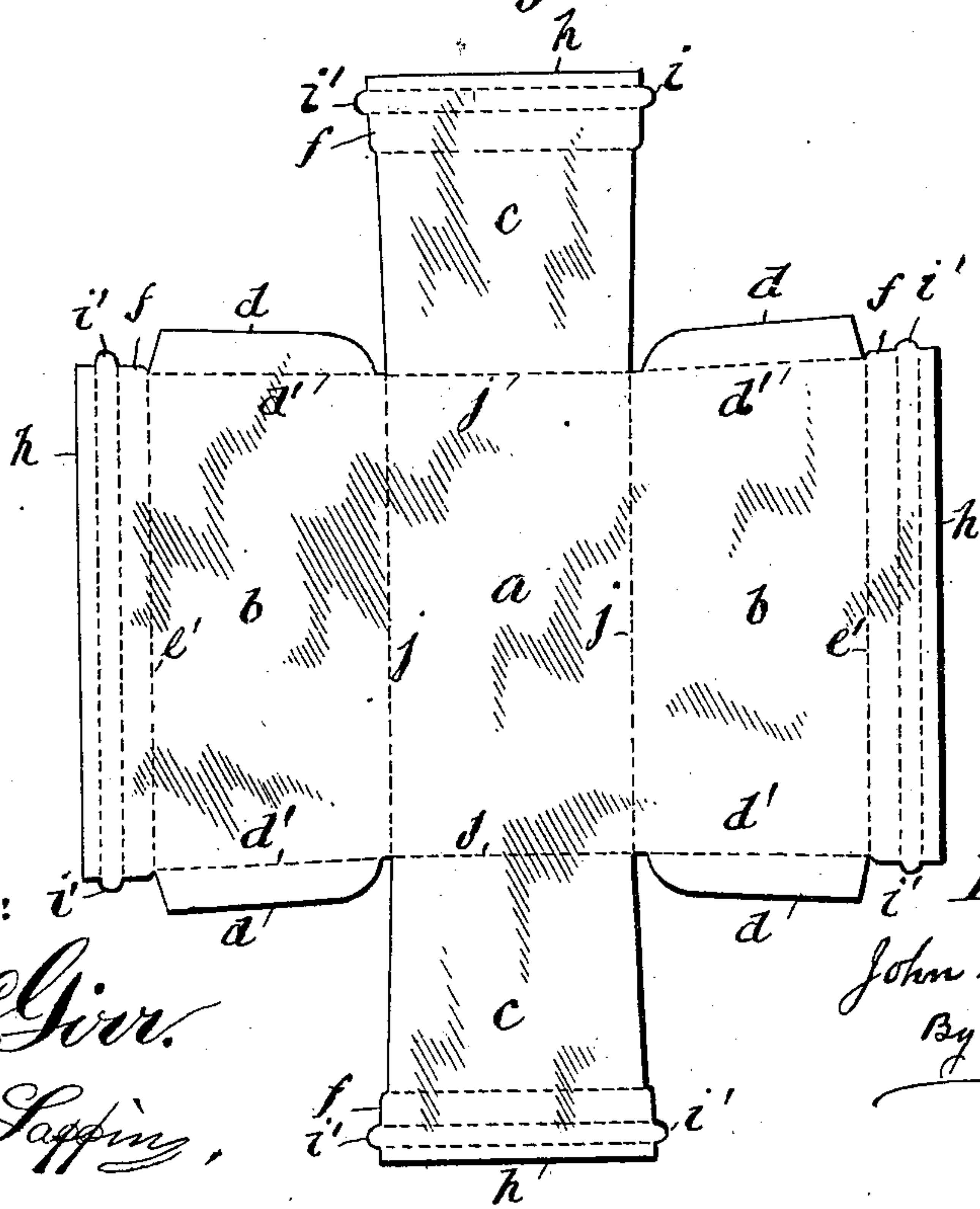


Fig: 2.



Witnesses: *J. B. McGirr.*
Samuel Lapping,

Inventor:
John W. Wallace
By *H. A. West*
Attorney.

UNITED STATES PATENT OFFICE.

JOHN W. WALLACE, OF BROOKLYN, NEW YORK.

SHEET-METAL VESSEL.

SPECIFICATION forming part of Letters Patent No. 673,550, dated May 7, 1901.

Application filed May 10, 1900. Serial No. 16,165. (No model.)

To all whom it may concern:

Be it known that I, JOHN W. WALLACE, a citizen of the United States, and a resident of 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 specification.

My invention relates to the manufacture of vessels made of sheet metal, (mainly tin,) the same being designed more particularly for use as ice-cream bricks or boxes, the object of the invention being to produce cheaply, mainly by means of dies, strong, rigid, and substantial tin vessels whose margins and seams excluded dirt, wash-water, &c., enabling the vessel to be kept perfectly clean and free from rust.

As before stated, my invention is designed mainly for packing ice-cream, wherein cleanliness of the vessel and freedom from rust are of first importance.

In the accompanying drawings, to which reference is made and which form a part of this specification, Figure 1 is a perspective view of my new and improved sheet-metal vessel, and Fig. 2 is a plan view of the single-piece blank of which the vessel is made.

A represents the vessel, having the bottom *a*, side walls *b b*, and end walls *c c*. The side walls *b b* are formed with marginal flaps or flanges *d d*, which in the completed vessel fold or lap against the end walls *c c*, where they are secured, preferably by rivets *e e*, and reinforce the corners. The upper edges of the side and end walls are formed with folded-back stiffening-strips *f f*, each one of which is formed with a bead *g*, which stiffens the folded-back portions *f f*. Below each bead *f* is formed a narrow and flat flange *h*, which is made to fit flat and snug against the surfaces of the side and end walls. The ends of the beads *g g* are beveled or mitered, as shown at *i i*, to match, as shown in Fig. 1.

The blank shown in Fig. 2 when in flat condition shows the side pieces *b b* and end pieces *c c* scored at *j* for the bottom corners of the vessel. The flaps or flanges *d d* are shown scored at *d' d'* to form the upright corners of the vessel, and these flaps or flanges terminate at the top of the vessel, or, in other

words, they extend to the score-lines *e' e'*, which indicate the lines of folding back the portions *f f*, so that when the portions *f f* of the end walls are folded back they will overlap the upper ends of the flaps or flanges *d d*, and thus make three thicknesses of metal at the upper corners of the box.

The letters *i' i'* represent curved lips or projections in the blank, which when the beads *g* are struck up form the miters *i i*.

The blank being stamped out in a blanking-die, the next operation is to strike up the beads *g g* and the flaps *d d*. Then the side and end walls are bent up along the lines *j* to upright position. The portions *f f* are then folded down, those on the end pieces *c c* of the vessel being folded over and down upon the upper ends of the corner-flaps *d d*, thus bracing and stiffening the corners of the vessel. The rivets *e e* are then inserted and headed down, and then finally the whole vessel is immersed in a bath of molten solder or tin, which closes all of the joints and seams in the vessel, so that no openings are left for moisture or dirt of any kind to get beneath any joint, corner, or overlapped portion of the vessel. The flanges or cleats *h h* below the beads *g* being soldered flat against the side walls of the vessel not only exclude all possible entrance of water or dirt from the beads *g g*, but they brace the beads and the body of the vessel, so that the vessel is not only easily kept perfectly clean and free from rust, but the same is given great rigidity and strength.

Instead of forming the flanges *d* on the edges of the side walls it is obvious that they may be formed on the edges of the end walls, if desired, without departing from my invention.

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

1. A sheet-metal vessel comprising a bottom and end and side walls, the edges of said walls being reinforced by a turned-back portion *f*, having a bead *g* and a flat flange *h* below the said bead, substantially as described.

2. A blank for sheet-metal vessels, the same

being shaped to form the bottom and the end
and side walls of the vessel, the outer edges
of the said walls being formed with the fold-
ing portions *f* and the edges of the said side
5 walls being formed with the flanges *d* which
are separated from the bottom portion of the
blank and extend to the folding-line of the

said folding portions *f*, substantially as de-
scribed.

JOHN W. WALLACE.

Witnesses:

H. A. WEST,
SAMUEL LAPPIN.