

No. 700,578.

Patented May 20, 1902.

W. THOMPSON.
END SEAM FOR TIN CANS.

(Application filed Mar. 10, 1902.)

(No Model.)

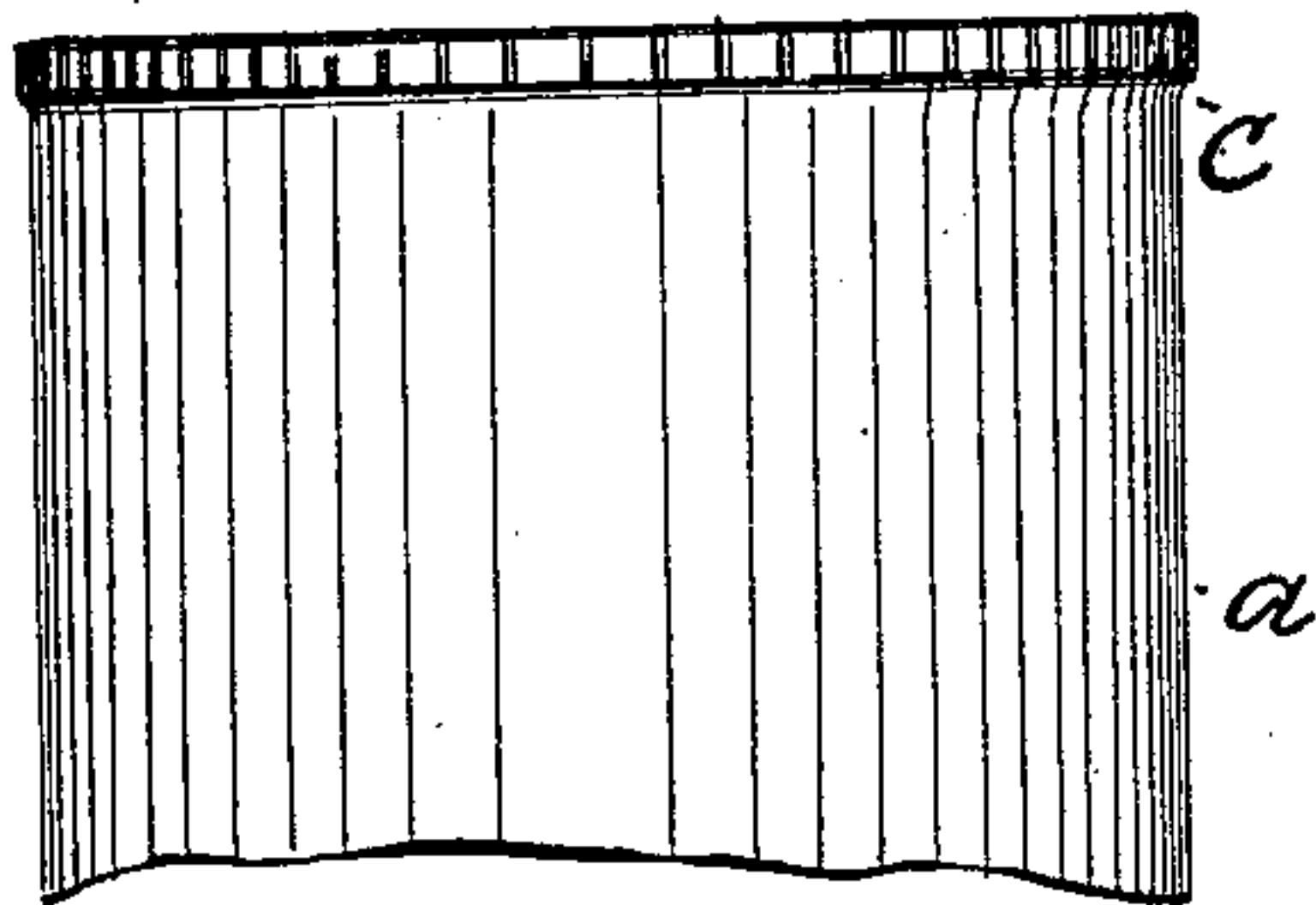


Fig. 1.

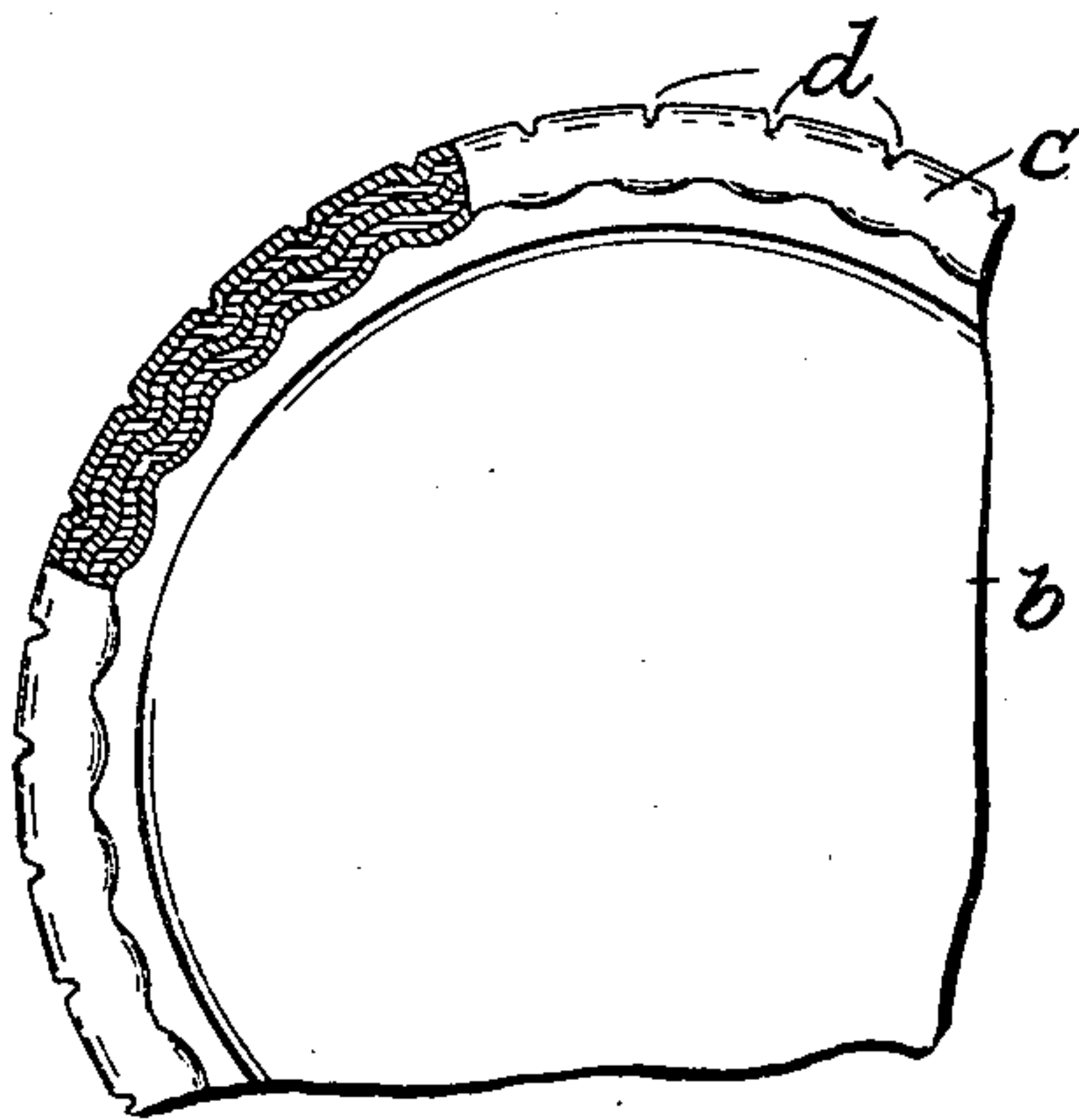


Fig. 2.

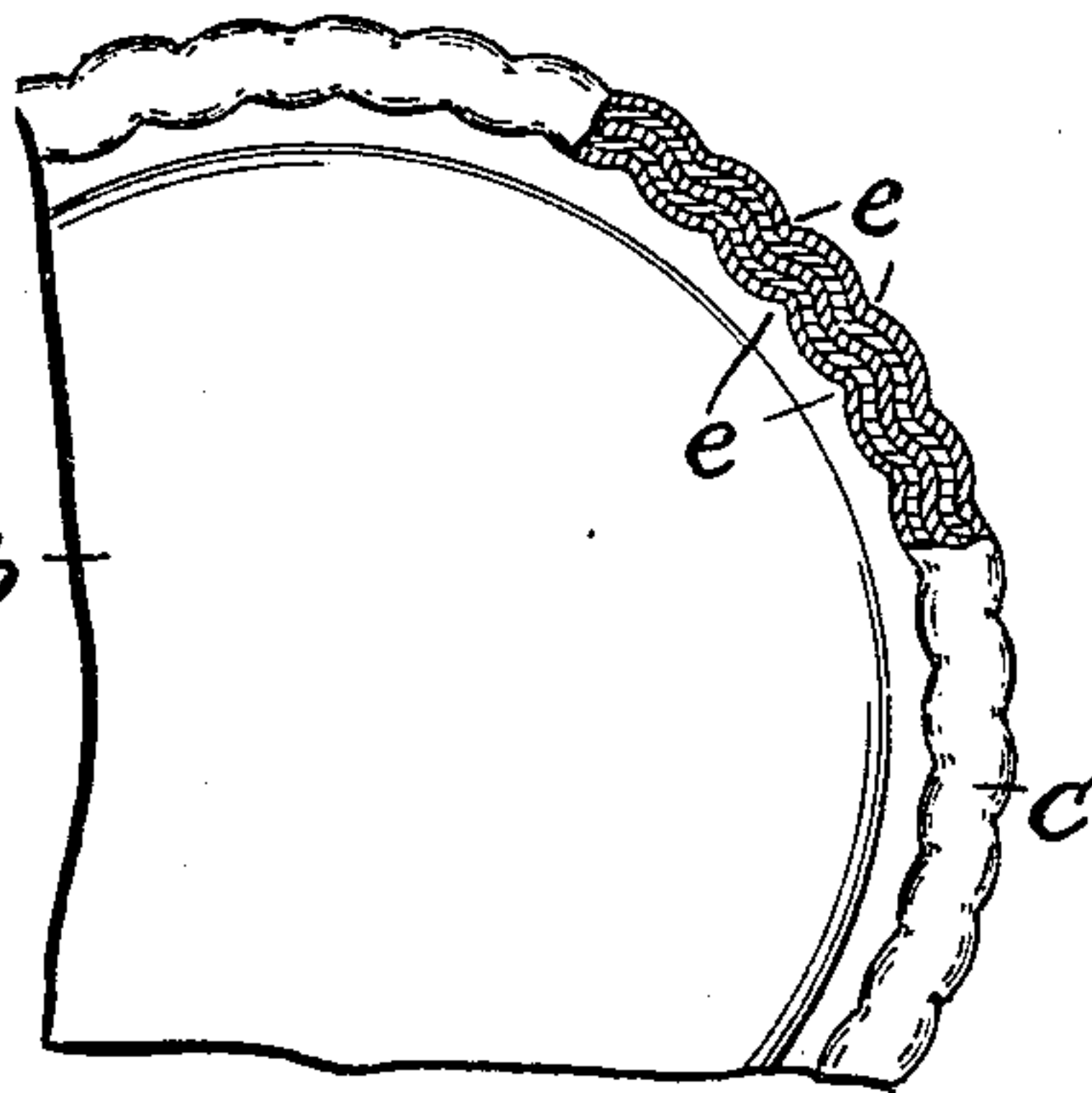


Fig. 3.

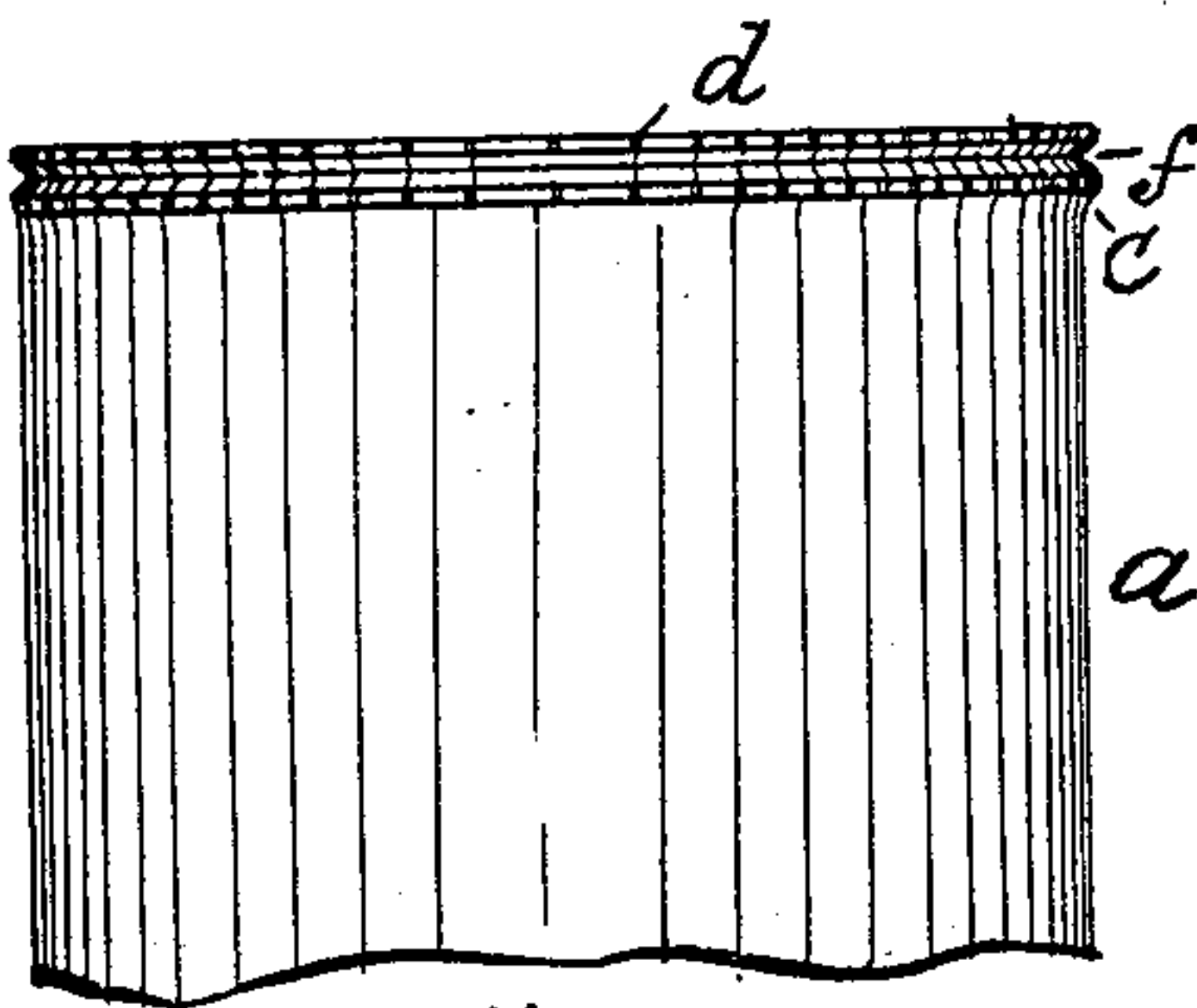


Fig. 4.

WITNESSES:

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BY

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UNITED STATES PATENT OFFICE.

WALTER THOMPSON, OF TORONTO, CANADA, ASSIGNOR, BY MESNE ASSIGNMENTS, TO THE PACKERS' SANITARY CAN COMPANY, OF PATERSON, NEW JERSEY, A CORPORATION OF NEW JERSEY.

END SEAM FOR TIN CANS.

SPECIFICATION forming part of Letters Patent No. 700,578, dated May 20, 1902.

Application filed March 10, 1902. Serial No. 97,478. (No model.)

To all whom it may concern:

Be it known that I, WALTER THOMPSON, a subject of the King of England, residing at Toronto, in the Province of Ontario, Canada, have invented a certain new and useful Improvement in End Seams for Tin Cans; and I do hereby declare the following to be a full, clear, and exact description of the same.

This invention relates to the manufacture of sheet-metal cans and other similar receptacles having their heads secured to their body portions by means of solderless joints. It is common to form the joints at the point indicated in cans of this nature by bending the edge portions of the can body and head back upon themselves in the form of a roll, and it is to this kind of construction of sheet-metal vessels that my invention has especial reference.

The invention has for its object the forming of the joint referred to in such manner as to strengthen the same not only by way of adding stability and firmness thereto, and thereby to the end portion of the vessel, but by way of rendering said joint as perfectly leak-proof as possible.

Referring to the accompanying drawings, wherein my invention is fully illustrated, Figure 1 is a side view of a portion of a can embodying my invention. Fig. 2 is a top plan view showing a portion of the bead produced in forming the joint in section; and Figs. 3 and 4 illustrate modifications of my invention, Fig. 3 being a top plan view and Fig. 4 a side view.

In said drawings, *a* is the can-body, and *b* its head, the same having their edge portions bent back upon each other two or more times, thereby producing the usual bead or flange *c*. As shown in the drawings, Figs. 1 and 4, it is preferred that this bead or flange have a greater diameter than the can-body, (which may be done by expanding the metal in forming the bead,) so that said flange or bead will protect the can. This bead or flange should

have appreciable width. In the bead or flange thus produced is formed a series of, preferably, regularly-spaced indentations *d*, which are elongated and extend, by preference, longitudinally of the can. These indentations probably give the best results where they are deep furrow-like channels, as shown in Fig. 2. In this case, a suitable tool being used on the inside of the flange to resist inward pressure of the tool which forms the indentations *d* and being disposed so that it acts opposite the intervals between said indentations, the result will be to produce a wave-like effect in the inside layer of the joint; but said indentations may be shallow, as at *e* in Fig. 3. In this case the flange has indentations *e* substantially alike on the inside and outside thereof, said indentations, however, alternating.

In Fig. 4, with a view to rendering the joint in the highest degree leak-proof, the flange *c* is formed with a continuous or annular channel *f*, as well as with the indentations.

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

1. A sheet-metal vessel having the edge portions of its head and body bent back upon themselves to produce an annular roll-like flange, said flange being provided with substantially transverse spaced indentations, substantially as described.

2. A sheet-metal vessel having an annular flange and bead forming the end portion thereof, said flange and bead being provided with substantially transverse indentations, substantially as described.

In witness whereof I have hereunto set my hand in presence of two witnesses.

WALTER THOMPSON.

Witnesses:

ALFRED GARTNER,

JOHN W. STEWARD.