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PATENTED AUG. 11, 1903.

B. H. LARKIN.

MANUFACTURE OF KEY OPENING TONGUED TEARING STRIP CAN BODIES.

APPLICATION FILED MAR. 21, 1903.

NO MODEL.

Fig. 1

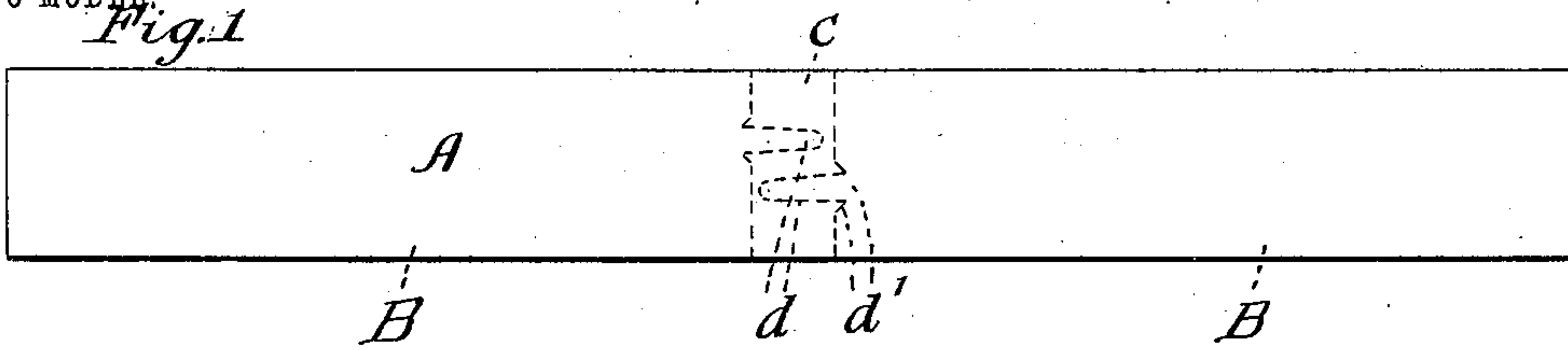


Fig. 2

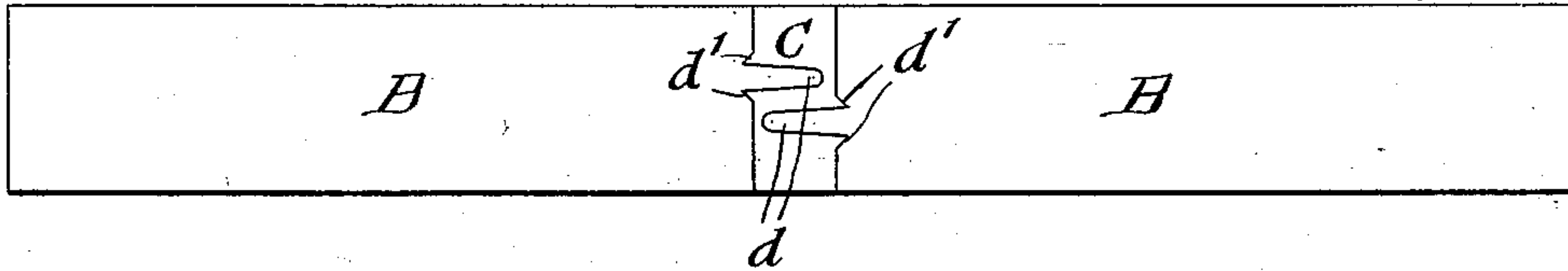


Fig. 3

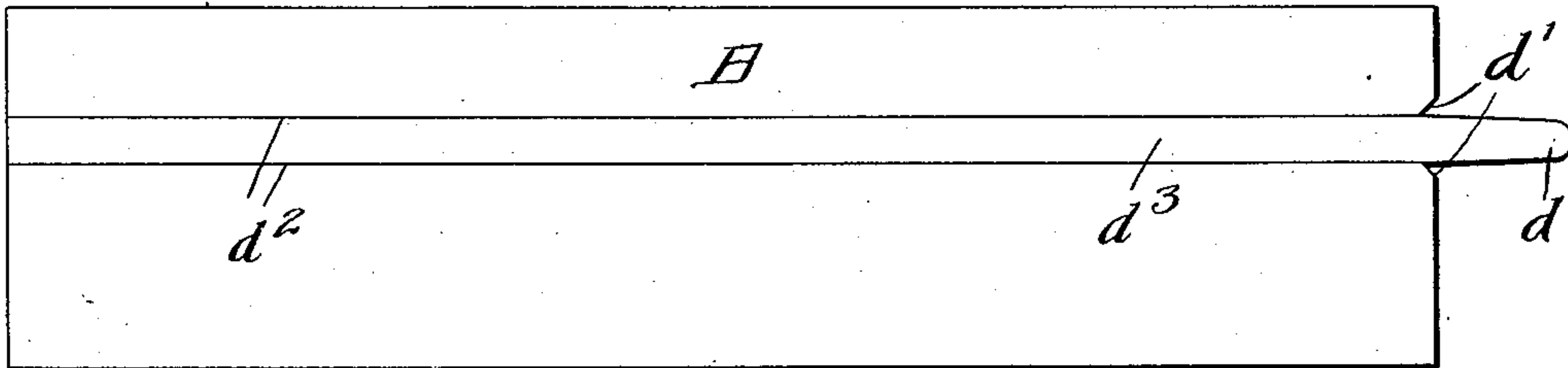
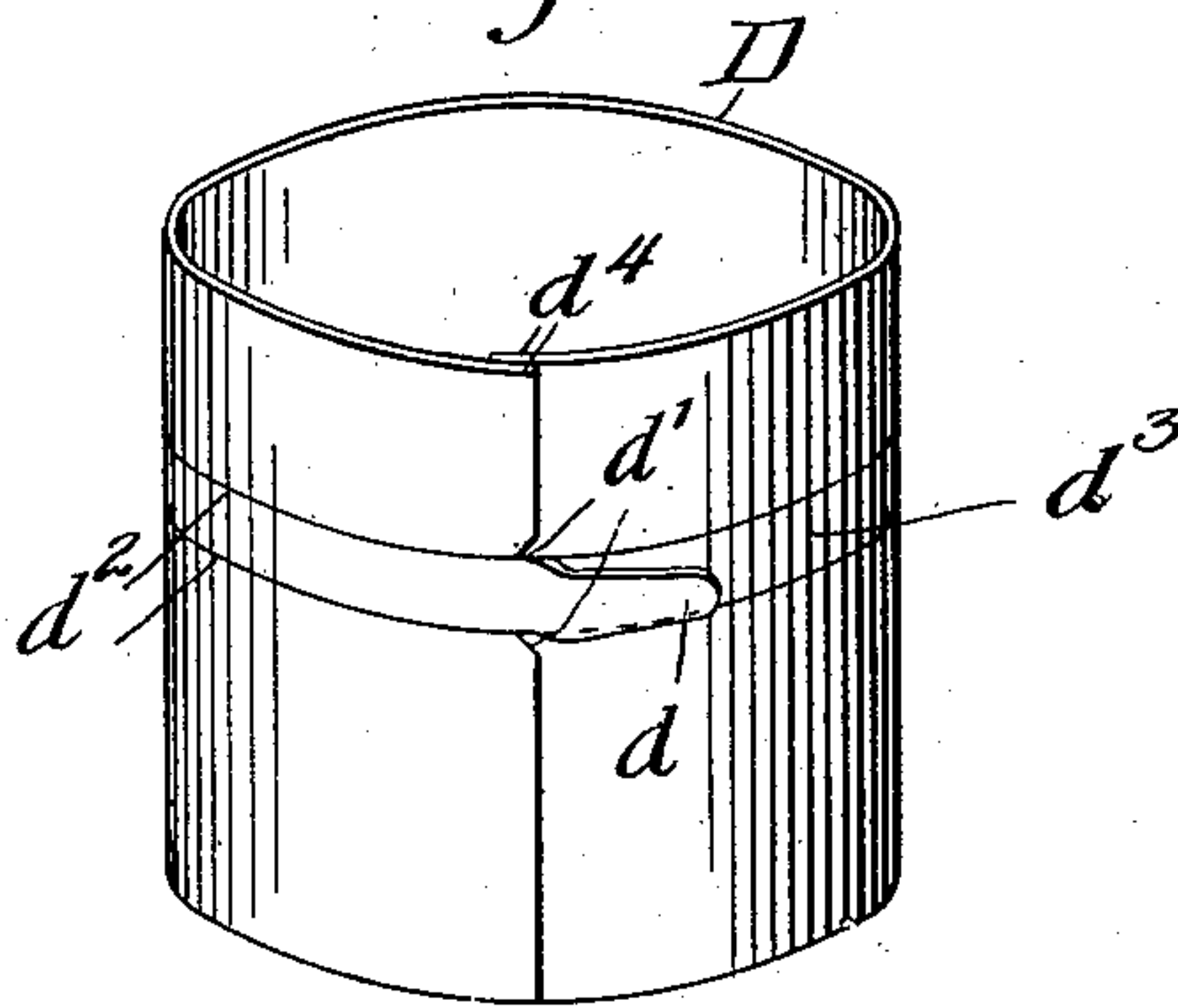


Fig. 4



Witnesses:

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# UNITED STATES PATENT OFFICE.

BERNARD H. LARKIN, OF MAYWOOD, ILLINOIS, ASSIGNOR TO AMERICAN CAN COMPANY, OF JERSEY CITY, NEW JERSEY, A CORPORATION OF NEW JERSEY.

## MANUFACTURE OF KEY-OPENING TONGUED-TEARING-STRIP CAN-BODIES.

SPECIFICATION forming part of Letters Patent No. 735,783, dated August 11, 1903.

Application filed March 21, 1903. Serial No. 148,987. (No model.)

*To all whom it may concern:*

Be it known that I, BERNARD H. LARKIN, a citizen of the United States, residing in Maywood, in the county of Cook and State of Illinois, have invented a new and useful Improvement in the Manufacture of Key-Opening Tongued-Tearing-Strip Can-Bodies, of which the following is a specification.

My invention relates to improvements in the method or process of manufacturing key-opening tongued-tearing-strip can-bodies.

Heretofore in the manufacture of key-opening tongued-tearing-strip can-bodies it has been customary to first cut the tin-plate into can-body blanks long enough to form the can-body and the projecting tongue of the tearing-strip and then cut away from the end of the blank the surplus stock at each side of the tongue, so as to leave the tongue projecting, as required, and then make the scores or weakened lines at the sides of the tearing-strip to form the blank into a can-body and solder the side seam thereof.

The object of my invention is to provide a method or process by means of which the amount of scrap or waste produced in the manufacture of tongued-tearing-strip can-bodies may be greatly reduced.

My invention consists in the means I employ to practically accomplish this object or result—that is to say, it consists in first cutting from a sheet of tin-plate a double can-body blank, a blank equaling in length two can-bodies and one tongue, and, second, in dividing this double-length blank into two can-body blanks and simultaneously forming two projecting tongues by cutting out from the middle portion of the double blank an intervening piece of scrap out of which both of the two tongues are formed, the tongues being staggered in respect to each other, thus producing two blanks, each having a projecting tongue. The two tongued can-body blanks are then scored and formed into can-bodies in the usual manner. By this means one-half of the scrap or waste heretofore ordinarily produced is saved, and the labor and expense are also reduced, as the tongues are formed on both blanks by one and the same operation.

To enable my invention to be more clearly

and readily understood by those skilled in the art, I have in the accompanying drawings, which form a part of this specification, illustrated the successive steps or stages of the manufacture of can-bodies by my invention.

In said drawings, Figure 1 represents the double can-body blank into which the sheet of tin-plate is cut as the first step of my method or process. Fig. 2 illustrates the second step by which the double can-body blank is divided into two single can-body blanks each provided with a projecting tongue by cutting out from the middle portion of the double blank a single piece of scrap out of which both tongues are formed, one staggered in respect to the other, the top edge of the double blank in part forming the top edge of one of the single can-body blanks and the bottom edge of the other. Fig. 3 shows one of the can-body blanks after it has been scored or provided with weakened lines to mark off the tearing-strip, and Fig. 4 the same formed into a can-body.

In the drawings, A represents a double can-body blank into which the sheet of tin-plate is cut as the first step, this blank equaling in length two can-bodies and one tongue. BB are the two single can-bodies formed from this double blank A by cutting out of its middle portion the single piece of scrap C and simultaneously forming a tongue  $d$  on each of the can-body blanks B. The dies which cut out the piece of scrap C also at the same time form the notches  $d'$  at each side of each tongue  $d$ . The separate can-body blanks B, each having a projecting tongue  $d$ , are next scored or provided with weakened lines  $d^2$ , which mark off the tearing-strip  $d^3$ , and then the same are formed into can-bodies D and the side seams  $d^4$  thereof soldered in the usual manner.

I claim—

1. The improved method or process of manufacturing key-opening tongued-tearing-strip can-bodies, consisting in first making a double can-body blank, and then dividing the same into two single can-bodies each having a projecting tongue by cutting out from the middle portion of the blank a single piece of scrap from which both tongues of the two can-body blanks are formed, one tongue being left inte-



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gral with each can-body blank and both  
 tongues being cut out of the waste middle  
 scrap piece at the same time said waste mid-  
 dle scrap piece is cut from between the two can-  
 body blanks and finally scoring the can-body  
 blanks thus produced and forming them into  
 can-bodies, substantially as specified.

2. The method or process of manufacturing  
 key-opening tongued-tearing-strip can-bodies,  
 consisting in first producing a double can-body  
 blank, and then forming from the middle por-  
 tion of the double blank in staggered position  
 in respect to each other two tongues, and di-  
 viding the double blank into two single can-

body blanks having each a projecting tongue  
 thereon, one tongue being left integral with  
 each can-body blank and both tongues being  
 cut out of the waste middle scrap piece at the  
 same time said waste middle scrap piece is cut  
 from between the two can-body blanks and  
 finally scoring the single blanks thus produced  
 and forming them into can-bodies, substan-  
 tially as specified.

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Witnesses:

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 WILLA MINNICH.