

No. 750,394.

PATENTED JAN. 26, 1904.

H. S. REYNOLDS.

METHOD OF MAKING METAL BARRELS OR LIKE STRUCTURES.

APPLICATION FILED MAY 28, 1903.

NO MODEL.

Fig. I.

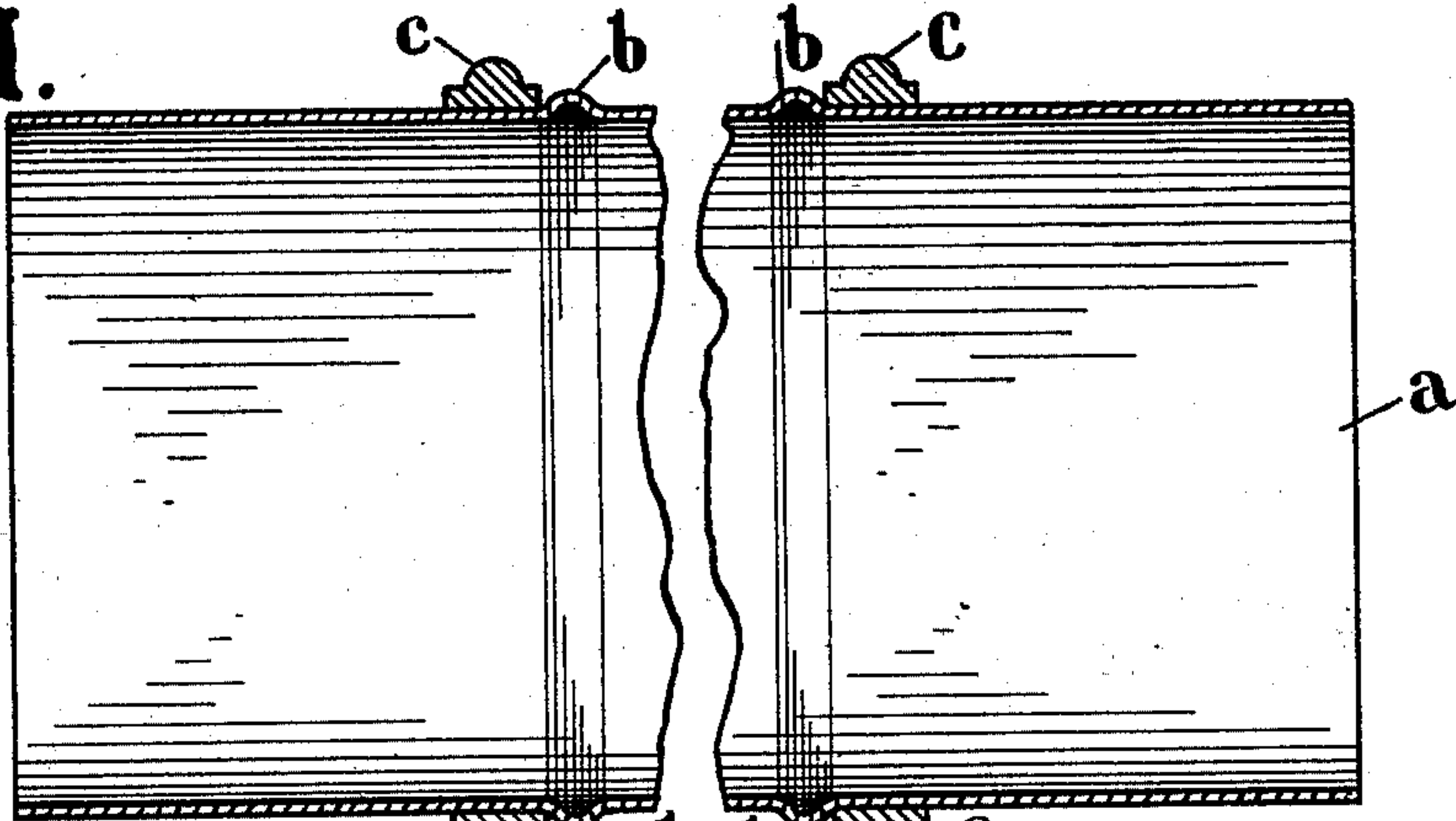


Fig. II.

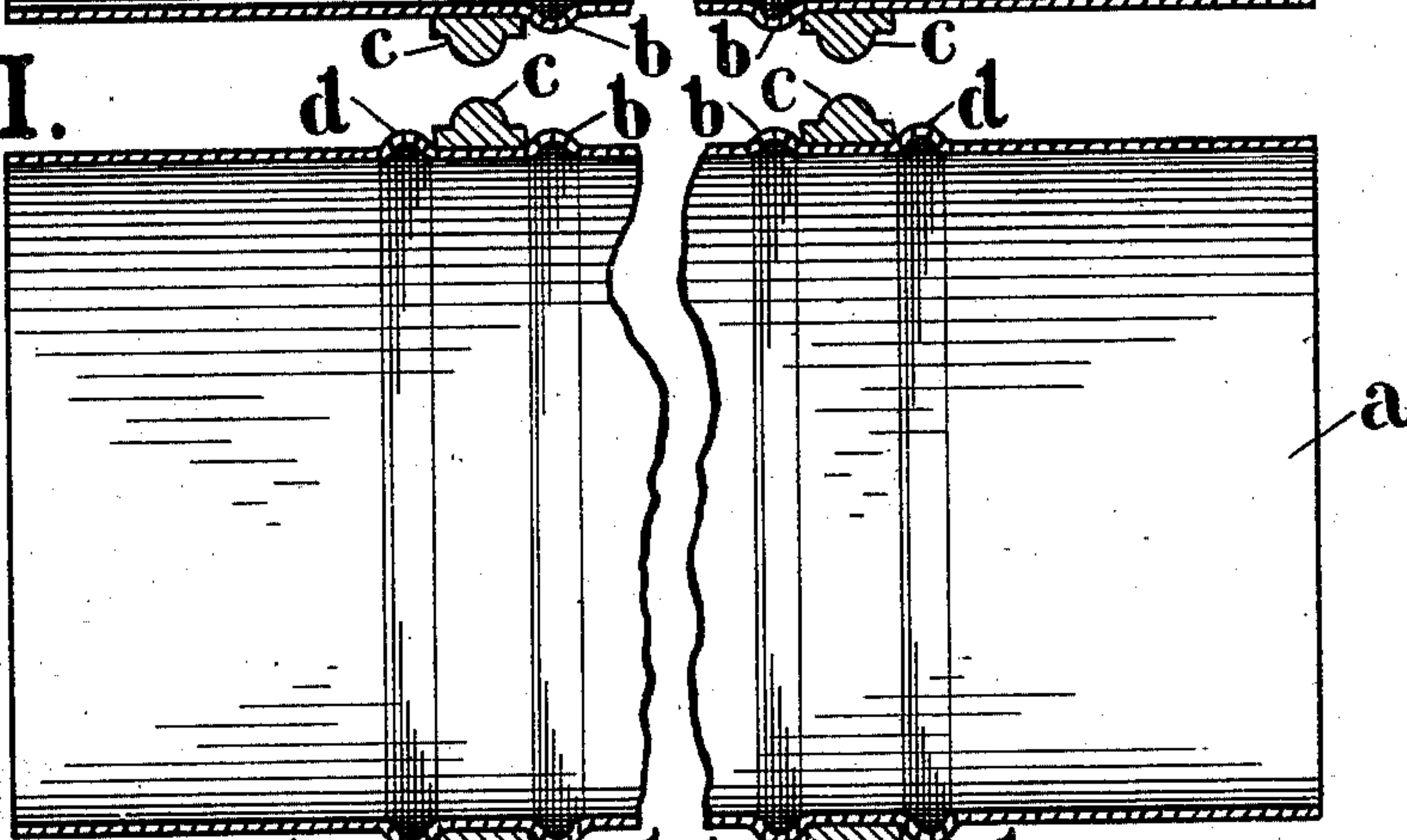
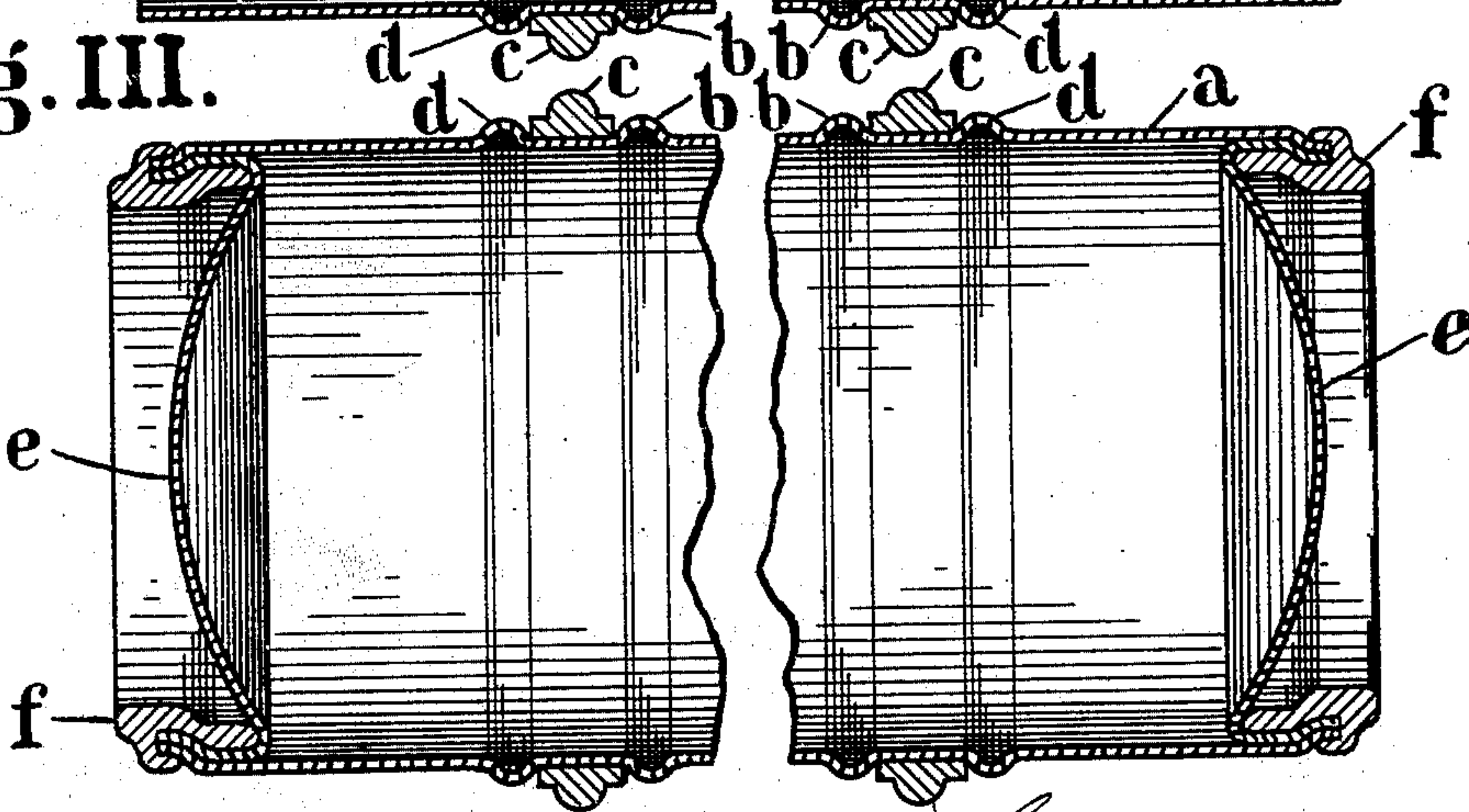


Fig. III.



WITNESSES:

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BY *[Signature]* ATTORNEYS.



# UNITED STATES PATENT OFFICE.

HENRY S. REYNOLDS, OF BROOKLYN, NEW YORK, ASSIGNOR TO IRON CLAD MANUFACTURING COMPANY, OF BROOKLYN, NEW YORK, A CORPORATION OF NEW YORK.

## METHOD OF MAKING METAL BARRELS OR LIKE STRUCTURES.

SPECIFICATION forming part of Letters Patent No. 750,394, dated January 26, 1904.

Application filed May 28, 1903. Serial No. 159,080. (No model.)

*To all whom it may concern:*

Be it known that I, HENRY S. REYNOLDS, a citizen of the United States, residing in Brooklyn, county of Kings, and State of New York, have invented certain new and useful Improvements in the Methods of Making Metal Barrels or Like Structures, of which the following is a specification.

My invention relates to a method of making metal barrels and like structures; and it consists in the method hereinafter set forth and claimed.

The object of my invention is to produce a method of producing metal barrels or other receptacles by which the hoop or hoops can be securely maintained in place on the barrel structure.

In the accompanying drawings I have shown in diagrammatic detail the several steps in the formation of the barrel. It will be understood that the drawings are illustrative merely and are for the purpose of clearly disclosing the invention.

In the drawings, Figure I shows the first step of the process; Fig. II, the second step of the process; and Fig. III shows the barrel in completed form, it being understood, however, that the barrel may be otherwise heated or finished.

In the drawings, *a* indicates a suitable metal cylinder having at one or more points in its length a bead or projection *b*, thrown outward in the body of the metal.

*c* represents metallic hoops, which are heated and shrunk on the cylinder either before or after the formation of the bead or projection *b*, although for the purposes of manufacture the bead *b* is preferably thrown up before the hoops are shrunk on the cylinder. After the hoops are placed on the cylinder,

as shown in Fig. I, another bead or projection *d* is thrown up on the side of the hoop opposite to that on which *b* is located, so as to effectually lock the hoops *c* into place.

A suitable head *e* is preferably seated at each end of the tubular or cylindrical portion *a* of the barrel and held in place by a suitable end ring *f*.

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

1. The herein-described process of forming metal barrels or like structures comprising the throwing up of integral projections from the tubular portion of the barrel and shrinking a metallic hoop on said tubular portion in such manner as to be locked in place by the said tubular projections.

2. The herein-described process of forming a metal barrel or like structure comprising the throwing up of a projection or bead *b* from the tubular portion of the structure, thereupon shrinking a hoop *c* upon the said tubular portion of the barrel *a* and thereupon throwing up a bead or projection *d* on the side of the hoop opposite to the side upon which the bead or projection is located.

3. The herein-described process of forming a metal barrel comprising the throwing up of a plurality of beads from the cylindrical portion thereof and shrinking upon the said cylindrical portion a hoop *c* of greater height than the beads or projections, whereby the hoop will be efficiently locked in place substantially as described and for the purposes set forth.

HENRY S. REYNOLDS.

Witnesses:

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