

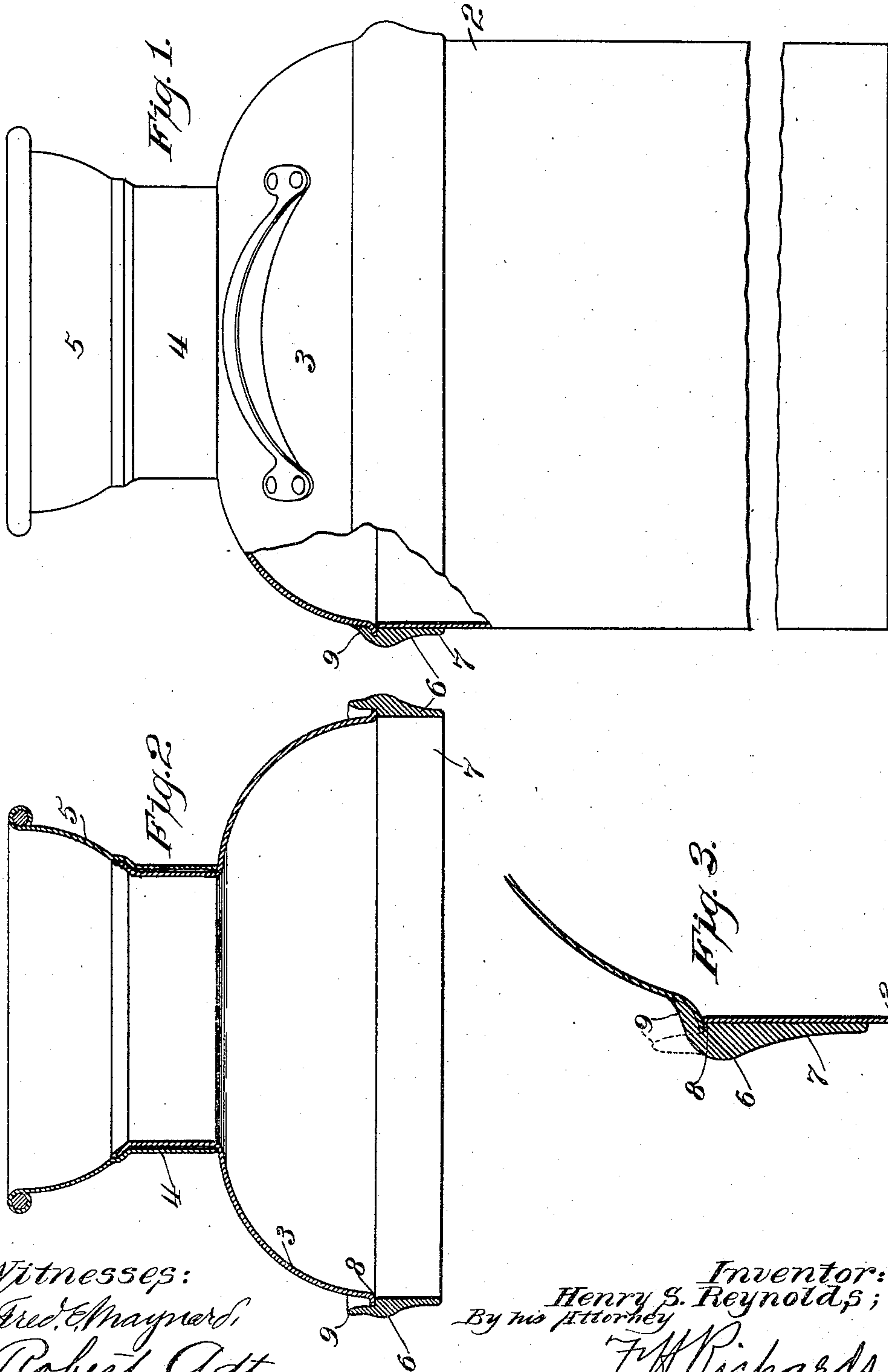
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H. S. REYNOLDS.
MILK CAN.

APPLICATION FILED SEPT. 26, 1903.

NO MODEL.



Witnesses:
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UNITED STATES PATENT OFFICE.

HENRY S. REYNOLDS, OF NEW YORK, N. Y.

MILK-CAN.

SPECIFICATION forming part of Letters Patent No. 773,163, dated October 25, 1904.

Application filed September 26, 1903. Serial No. 174,742. (No model.)

To all whom it may concern:

Be it known that I, HENRY S. REYNOLDS, a citizen of the United States, residing in the city of New York, borough of Brooklyn, in the county of Kings and State of New York, have invented certain new and useful Improvements in Milk-Cans, of which the following is a specification.

This invention relates to milk-cans, the primary object of the invention being to provide improved means for fastening the breasts and cylinders or body of milk-cans together without the necessity of overlapping one part by the other.

In the drawings accompanying and forming part of this specification, Figure 1 is a view of one form of milk-can, showing in section the present improvement. Fig. 2 is a sectional view of the breast and hoop assembled in readiness to be firmly united; and Fig. 3 is a detailed enlarged view of this improvement, showing the two positions of the clamping-flange.

Similar characters of reference indicate like parts throughout the several figures of the drawings.

The present improvement is particularly adapted to that form of milk-cans known to the trade as a "Western" can, one of the peculiarities of which is that such can is provided with a very strong breast-hoop. In the preferred form thereof herein shown and described the cylinder or body 2 of the can, the breast 3, the neck 4, and the bowl 5 may be of the usual or any suitable construction.

The breast-hoop 6 comprises a depending or hoop portion 7, into which the body 2 is fitted and secured in any suitable manner—as, for instance, by soldering—and the interiorly-located shoulder 8, terminating in a flange 9, which flange is adapted to be forced down upon the edge of that part of the structure which is to be clamped between the opposing faces of the shoulder and flange. In the structure shown the flange is shown forced down upon the edge of the breast, which is spun outwardly for this purpose, such edge thus being clamped between the opposing faces of the shoulder and the flange, the inner face of the flange conforming to the curvature of the

spun-out portion of the breast. By this means the breast and body of the can are firmly and rigidly united in a durable manner without the necessity of overlapping any part of the breast or body of the can one by the other.

By this improved fastening-hoop I am able to produce milk-cans, especially those hereinbefore referred to, at much less cost than heretofore, since by doing away with the overlapping of the body by the breast a material saving in the amount of metal necessary to form the breast is obtained, as well as considerable saving in the time and labor necessary to form such breast as compared with cans ordinarily constructed, while at the same time a much better and more sanitary joint is obtained than heretofore.

By reference to Fig. 3 it will be seen that the breast portion of the can may be made substantially dome-shaped and that were it not for the outwardly-turned free edge of such dome, which constitutes the flange 8, the outside of the breast would be of less diameter than the inside of the cylinder or body portion, and it will also be seen that in such figure the outwardly-projecting free-edged flange 8 projects beyond the outer wall of the cylinder at its free edge and that the shoulder formed by such flange overhangs the cavity of such cylinder or body portion and that after the weldable flange 9 has been welded or pressed down into its finished position such flange also inwardly overhangs the cavity of the cylinder at the portion adjacent to the inner wall of the can. Such flange thereby not only constitutes a lock for the parts, but also reinforces the bend in the breast, which is made to produce the flange, and carries the support for such breast to a point remote from the joint proper between the breast and cylinder and from the free edge of the flange, which is clamped between the surfaces of the flange and shoulder of the hoop, thus removing the region of flexure from the region of the clamp or joint, which will safeguard the joint and prevent the loosening thereof by blows or vibration.

The hoop is usually made of a good grade of malleable iron or other ductile material adapted for the purpose, and the flange is

preferably forced down by what is commercially known as the "cold-weld" process.

While the invention has been described in connection with milk-cans and is particularly adapted for uniting the breast and body of such cans, it is understood that I do not limit myself thereto and that the improvement is equally applicable to other structures and to other portions of the can, and the claims are to be read with this understanding.

Having thus described my invention, I claim—

1. A milk-can comprising a sheet-metal breast having an outwardly-spun portion or flange at its lower edge, and a sheet-metal cylindrical body, and a comparatively massive hoop exteriorly encircling said body and provided with an internal circumferential shoulder and a weldable flange, between which the spun-out flange of the breast is clamped by pressing such flange thereto, said hoop uniting the breast and body with each other with the edge of the body extending to the inner wall of the breast at the spun-out flange thereof only.

2. In a milk-can the combination with a sheet-metal breast portion and a sheet-metal body portion, the breast portion having an outwardly-projecting edge transversely disposed to the edge of the body portion, a hoop surrounding the adjacent edges of said members and having a portion to overlie the body and a portion transversely disposed to its main portion to overlie the breast at its outwardly-turned edge and lock the same against displacement and to hold the edge of the body in juxtaposition to the transversely-disposed outward projection of the breast and the inner wall of the breast in such projection covering the said edge of the body.

3. A milk-can comprising a breast having its free edge turned or spun outward, a body and a hoop having a circumferential shoulder and a weldable flange and exteriorly encircling said body, the outwardly-turned edge of the breast only being clamped between the op-

posing surfaces formed by the weldable flange and the circumferential shoulder.

4. A milk-can comprising a breast having its free edge turned or spun outward, a body and a hoop having a circumferential shoulder and a weldable flange and exteriorly encircling said body, the outwardly-turned edge of the breast only being clamped between the opposing surfaces formed by the weldable flange and the circumferential shoulder, the said weldable flange overlapping an appreciable portion of the breast between the inner surfaces of the body-wall, so that the breast is protected beyond the point where its inner surface is engaged by the circumferential shoulder or free edge of the body.

5. A milk-can comprising a breast member, a body member and a hoop, having a circumferential shoulder and a weldable flange, said hoop exteriorly encircling one of said members, the other of said members having its free edge turned or spun outward, such turned or spun-out end only being clamped between the opposing surfaces formed by said circumferential shoulder and weldable flange.

6. A milk-can comprising a breast having its free edge turned or spun outward and a hoop having a body portion provided with a cylindrical inner wall and circumferential shoulder and a weldable flange, and exteriorly encircling said body below its free edge, the spun-out end of the breast only being clamped between the opposing surfaces of the hoop formed by the circumferential shoulder and weldable flange after the flange has been pressed into position, such hoop thereby uniting said body and breast by clamping the edge of the breast between opposing walls while only overlapping the wall of the body, the free edge of which is adjacent to the inner surface of the spun-out portion of the breast.

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