

No. 792,028.

PATENTED JUNE 13, 1905.

L. A. HARKER.
METHOD OF COATING.
APPLICATION FILED SEPT. 3, 1904.

Fig. 1.

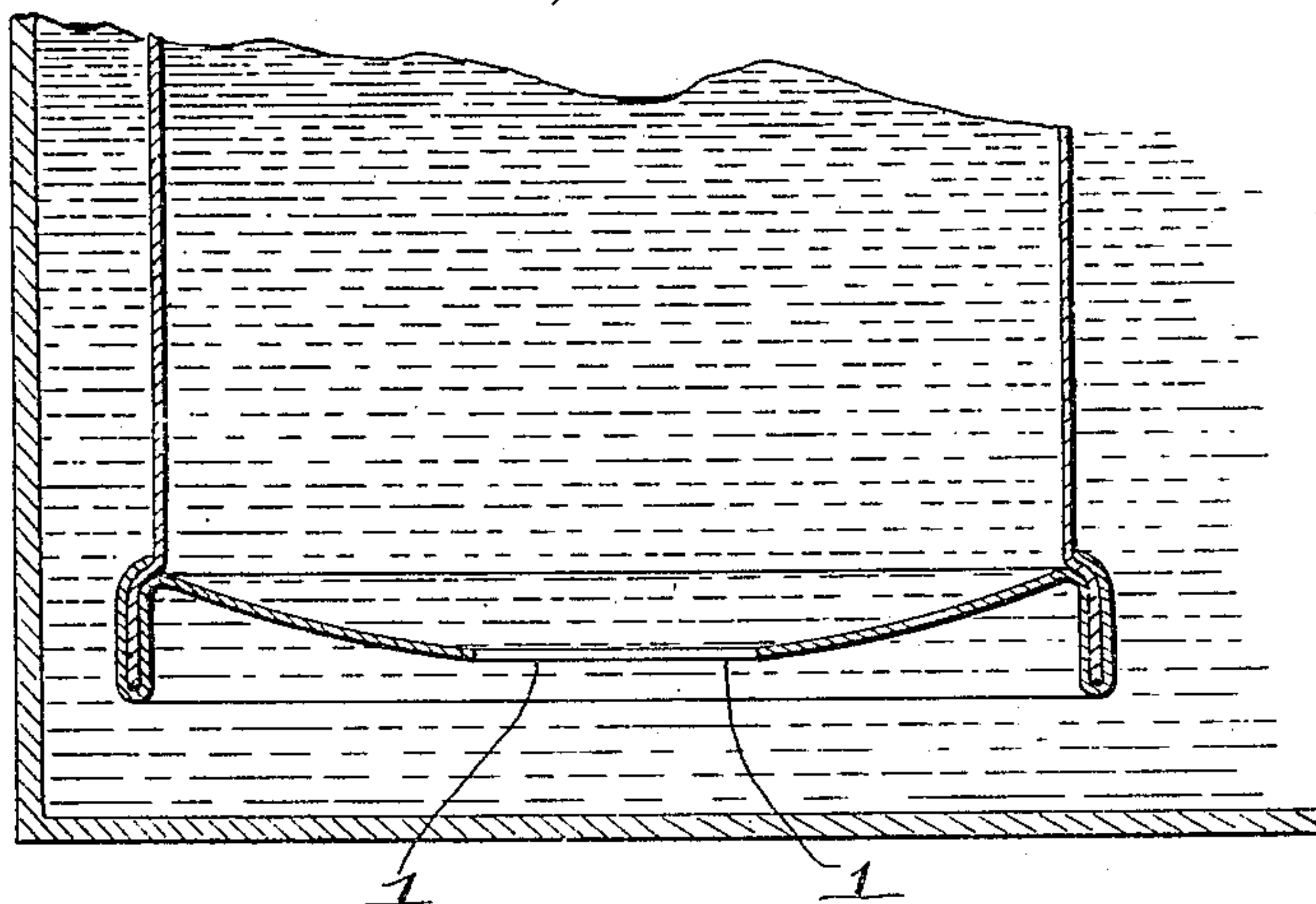


Fig. 2.

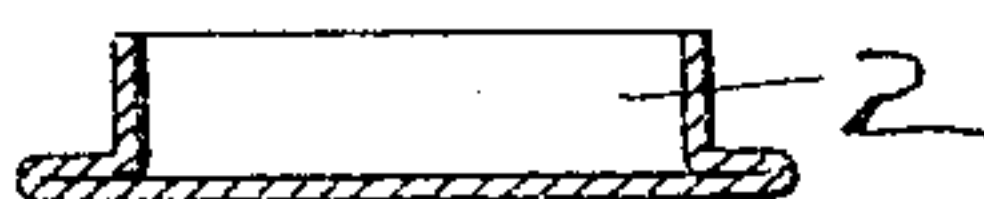
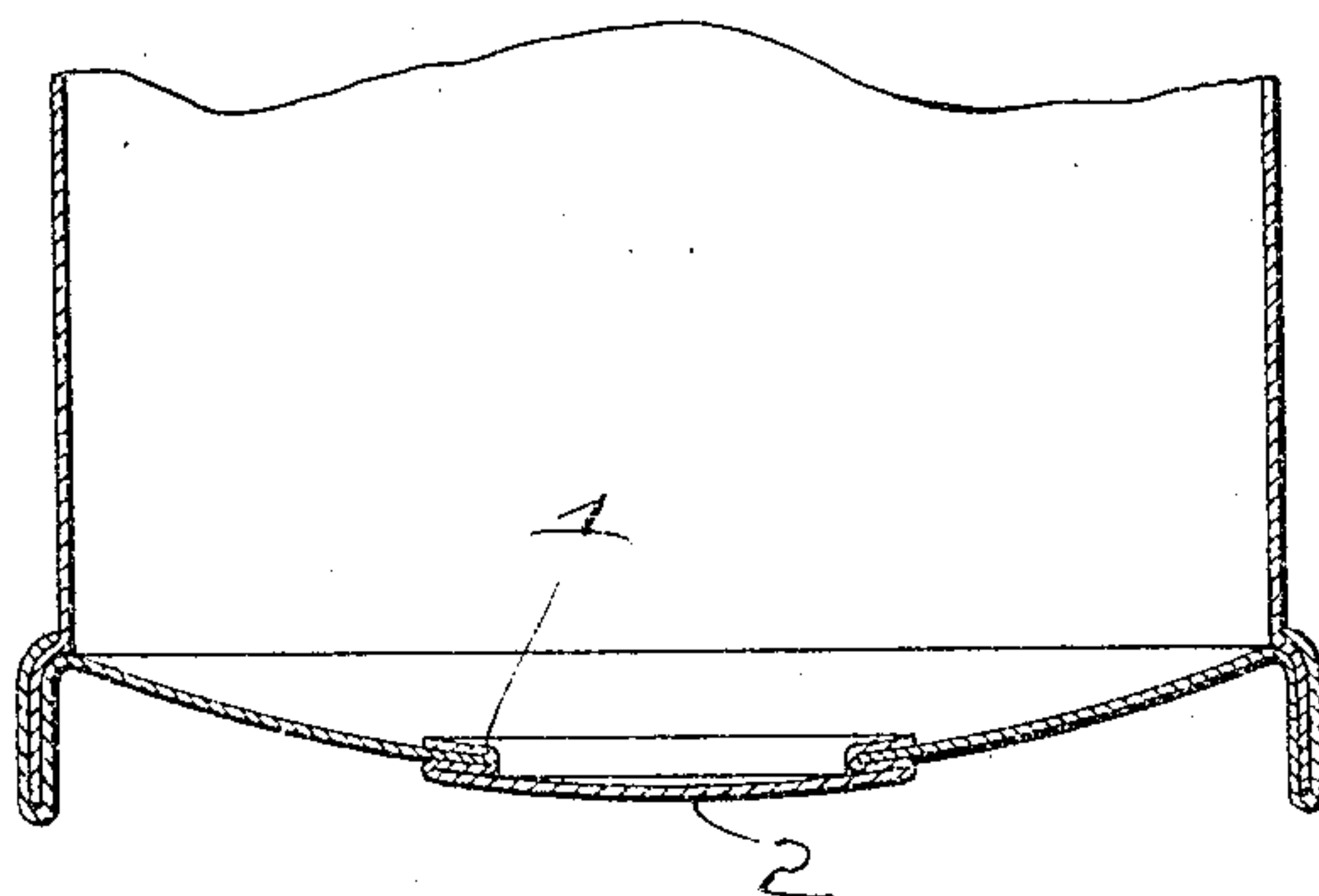


Fig. 3.



WITNESSES

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LEWIS A. HARKER, OF CINCINNATI, OHIO, ASSIGNOR TO THE SAFETY CAN COMPANY, OF CINCINNATI, OHIO.

METHOD OF COATING.

SPECIFICATION forming part of Letters Patent No. 792,028, dated June 13, 1905.

Application filed September 3, 1904. Serial No. 223,280.

To all whom it may concern:

Be it known that I, LEWIS A. HARKER, a resident of Cincinnati, in the county of Hamilton and State of Ohio, have invented certain new and useful Improvements in Methods of Coating; and I do hereby declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it appertains to make and use the same.

My invention relates to an improved method of coating, the object of the invention being to provide an improved method of coating cans and the like receptacles, which will result in locating the greatest portion of the coating material where it is most needed to protect the receptacles; and it consists in certain novel steps in the method, as will be more fully hereinafter described, and pointed out in the claims.

In the accompanying drawings, Figure 1 is a view in section illustrating the carrying out of my method. Fig. 2 is a view of the bottom can-closure, and Fig. 3 is a view of the completed can after the method is carried out.

In the manufacture of cans, particularly for use as garbage-cans, they are ordinarily composed of black steel and when assembled are coated with zinc, or what is known as "galvanizing." In dipping or submerging them in the hot bath of zinc they are put into the metal open end first, the same as dipping water with a bucket. When the can is wholly submerged and turned over, so that the molten zinc will entirely coat it, it is withdrawn gradually, bottom end first—that is, in an inverted position—so that the molten metal will flow out of its interior. This has a great tendency to draw the coating from the bottom and sides, leaving a comparatively thin coating in the bottom and along the lower portion of the sides. The "drip," as it is called, is at that portion

of the can which last leaves the bath, which in this case is the top or open end of the can. I have found in actual use that the weak portion of these garbage-cans is at the base at a point just above the bottom. Here is where they give out first, and the cause is that the fluids from the garbage attack the can, as they lie at this point therein. To overcome this as much as possible, I propose to coat the can in such a manner as to withdraw it from the bath bottom end last, the position of the can when being withdrawn being in its upright position, as shown in Fig. 1. To do this, I stamp out a circle of metal in the bottom, preferably about three inches in diameter. In other words, I make a three-inch hole 1 in the center of the bottom, which is at the lowest point. This hole in the bottom permits the can to be withdrawn from the tank in an upright position, the molten metal running out of the can through this hole. In this way I secure at the base of the can a very heavy coating of zinc, both on the interior and exterior, and at the same time the metal remains in the joints formed by the union of the bottom to the cylinder portion. After the can is thus dipped I close the hole left in the bottom by inserting a metal cap 2, the edge of which after insertion is crimped outwardly and pressed against the edge of the hole in the bottom. After the plug or cap is thus inserted and pressed against the bottom it is made watertight by soldering.

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

1. The herein-described method, consisting in immersing a receptacle having a bottom provided with an opening in a bath of coating material, and withdrawing said receptacle bottom downward from the bath.

2. The herein-described method, consisting in providing an opening in the bottom of

a receptacle submerging the receptacle in a bath of coating material, then drawing the receptacle with its bottom end downward from said bath and then closing the opening
5 in the bottom of the receptacle.

3. The herein-described method, consisting in first providing an opening in the bottom of a can, then submerging the can in molten zinc, then drawing the can bottom

end downward from the molten zinc, then 10 securing a closure in the opening in the can.

In testimony whereof I have signed this specification in the presence of two subscribing witnesses.

LEWIS A. HARKER.

Witnesses:

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JONAS B. FRENTIL.