

No. 848,005.

PATENTED MAR. 26, 1907.

J. BRENZINGER.  
METHOD OF HEADING SHEET METAL CANS.  
APPLICATION FILED MAR. 17, 1906.

*Fig. 1.*

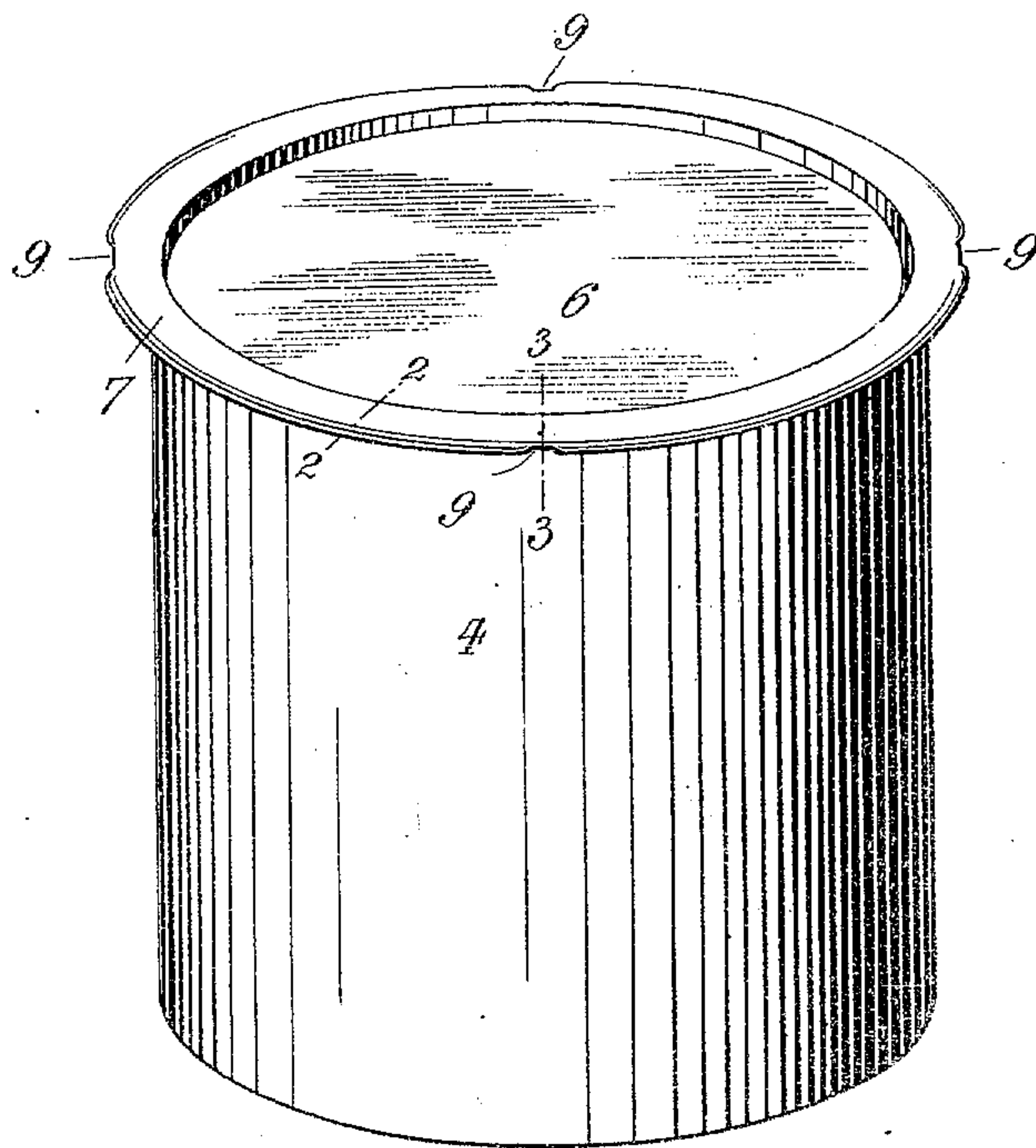
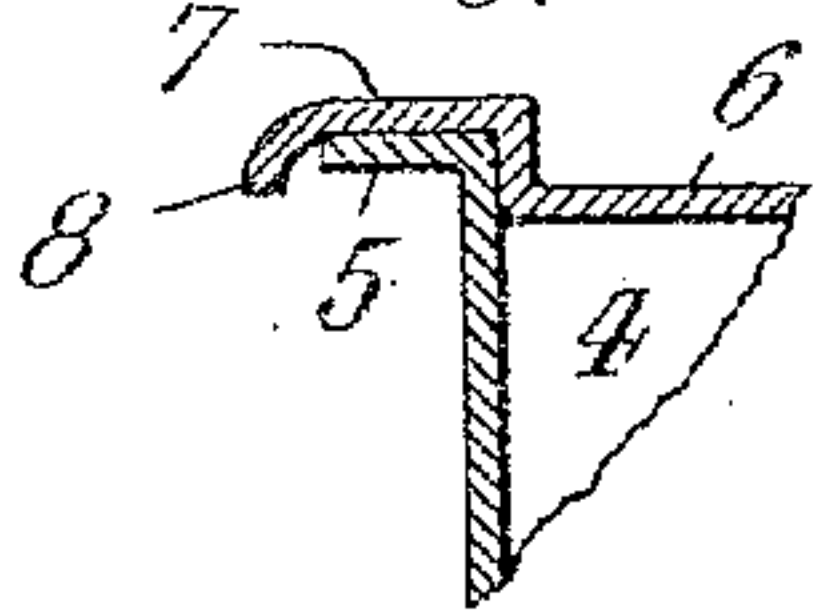
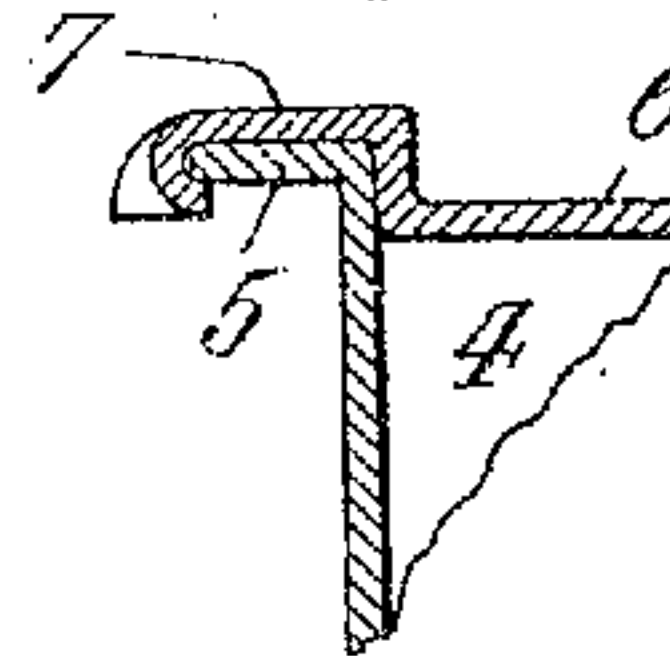


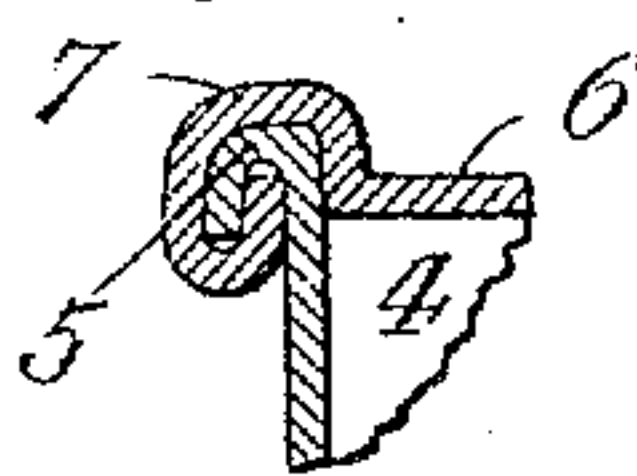
Fig. 2.



*Fig. 3.*



*Fig. 4.*



Witnesses:  
Arthur George.  
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Julius Brenzinger  
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# UNITED STATES PATENT OFFICE.

JULIUS BRENZINGER, OF MOUNT VERNON, NEW YORK, ASSIGNOR TO THE  
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## METHOD OF HEADING SHEET-METAL CANS.

No. 848,005.

Specification of Letters Patent.

Patented March 26, 1907.

Application filed March 17, 1906. Serial No. 306,535.

*To all whom it may concern:*

Be it known that I, JULIUS BRENZINGER, a citizen of the United States, residing at Mount Vernon, Westchester county, State of New York, have invented new and useful Improvements in Methods of Heading Sheet-Metal Cans, of which the following is a specification.

This invention relates to improved means for effecting a preliminary connection between the head and the body of a sheet-metal can before said parts are permanently united by a can heading or seaming machine. Thus any shifting of the head before and during the seaming operation is avoided, spilling is prevented, and the manipulation of the can during the seaming operation is facilitated.

In the accompanying drawing, Figure 1 is a perspective view of a round can headed according to my invention, showing the position of the parts before the seam is turned down. Fig. 2 is an enlarged cross-section on line 2 2, Fig. 1; Fig. 3, a similar section on line 3 3, Fig. 1; and Fig. 4 is a section on line 2 2, Fig. 1, showing the position of the parts after the seam is turned down.

The can-body 4 is flanged, as at 5, while the countersunk cover or head 6 has a flange 7, which is supported upon flange 5 and projects over the same, as at 8. In order to effect the temporary connection desired, the flange 7 is clenched or bent at suitable points, so as to there become interlocked with flange 5, Fig. 3. The points 9 at which the clenching operation takes place should be spaced or distanced from each other, the flange-sections between the clenched points retaining their original shape. In this way the flanges are not dislocated to an extent which would

prevent their subsequent union by the seaming-rollers. After the cover has been temporarily secured to the can-body in the manner described the can is subjected to the action of seaming-rollers, which turn down both flanges 5 and 7 along the entire circumference of the can, including the clenched portions thereof. In the seam thus formed the end of the cover-flange 7 is folded around the can-flange 5, so as to be brought sidewise against the can-body and be interposed between such body and its turned-down flange 5. Thus there is formed a continuous double seam or lock-joint, Fig. 4, which forms a permanent connection between the can and its cover.

The drawing shows the invention applied to a round can clenched at four uniformly-spaced points; but it is evident that the number and relative position of such points may be varied and that the invention may also be applied to angular, oblong, and differently-shaped cans.

What I claim is—

Method of heading sheet-metal cans which consists in placing a flanged cover on a flanged can-body, clenched the cover-flange to the body-flange at spaced points, and then turning down both flanges along their entire circumference, to fold the cover-flange around the can-flange and interpose said cover-flange sidewise between the can-body and the can-flange, substantially as specified.

Signed by me at New York city, (Manhattan,) New York, this 15th day of March, 1906.

JULIUS BRENZINGER.

Witnesses:

WILLIAM SCHULZ,  
FRANK V. BRIESEN.