

No. 868,078.

PATENTED OCT. 15, 1907.

W. A. DUNLAP.
ENAMELED WARE.
APPLICATION FILED AUG. 20, 1906.

FIG. 1.

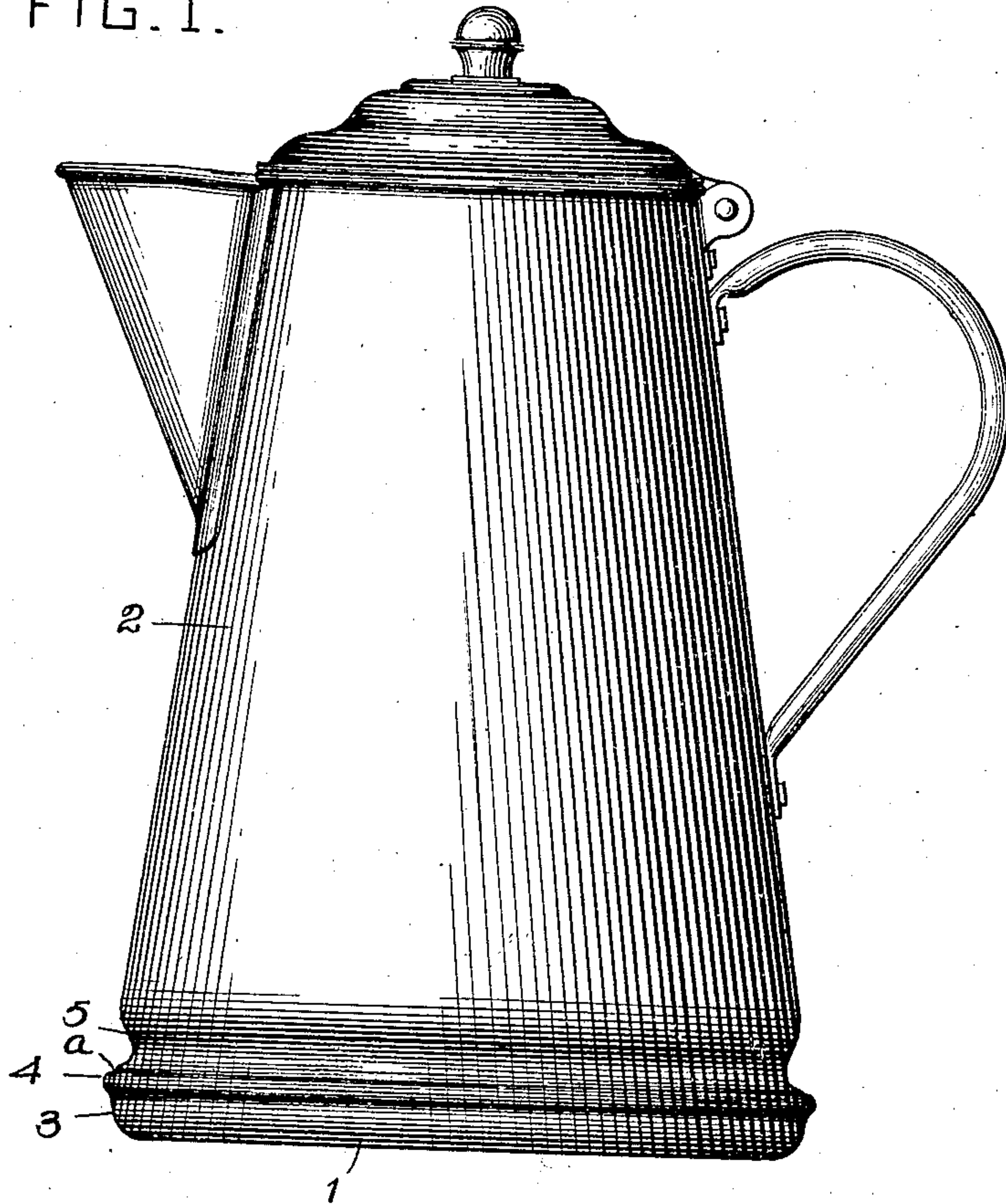


FIG. 2.

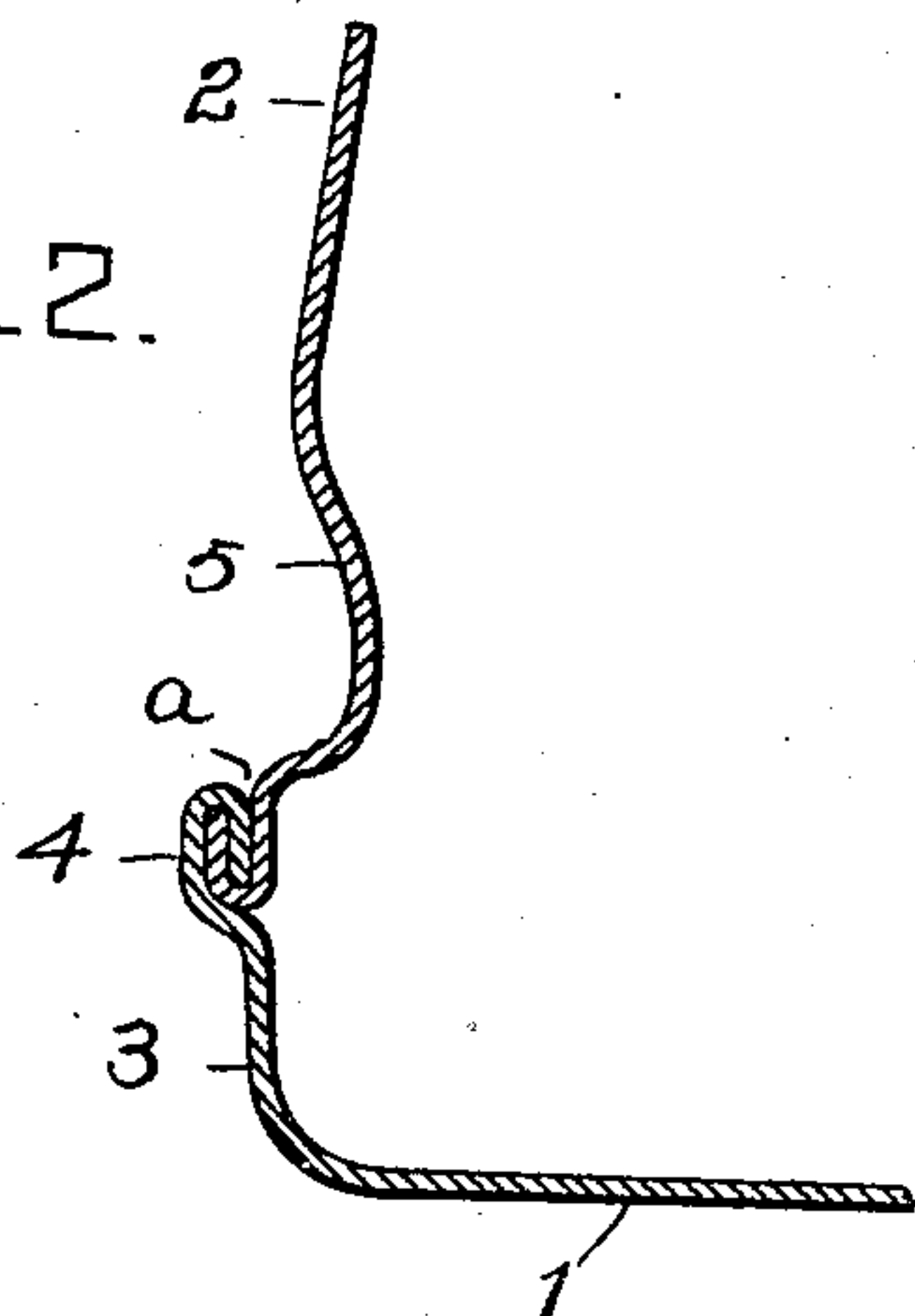
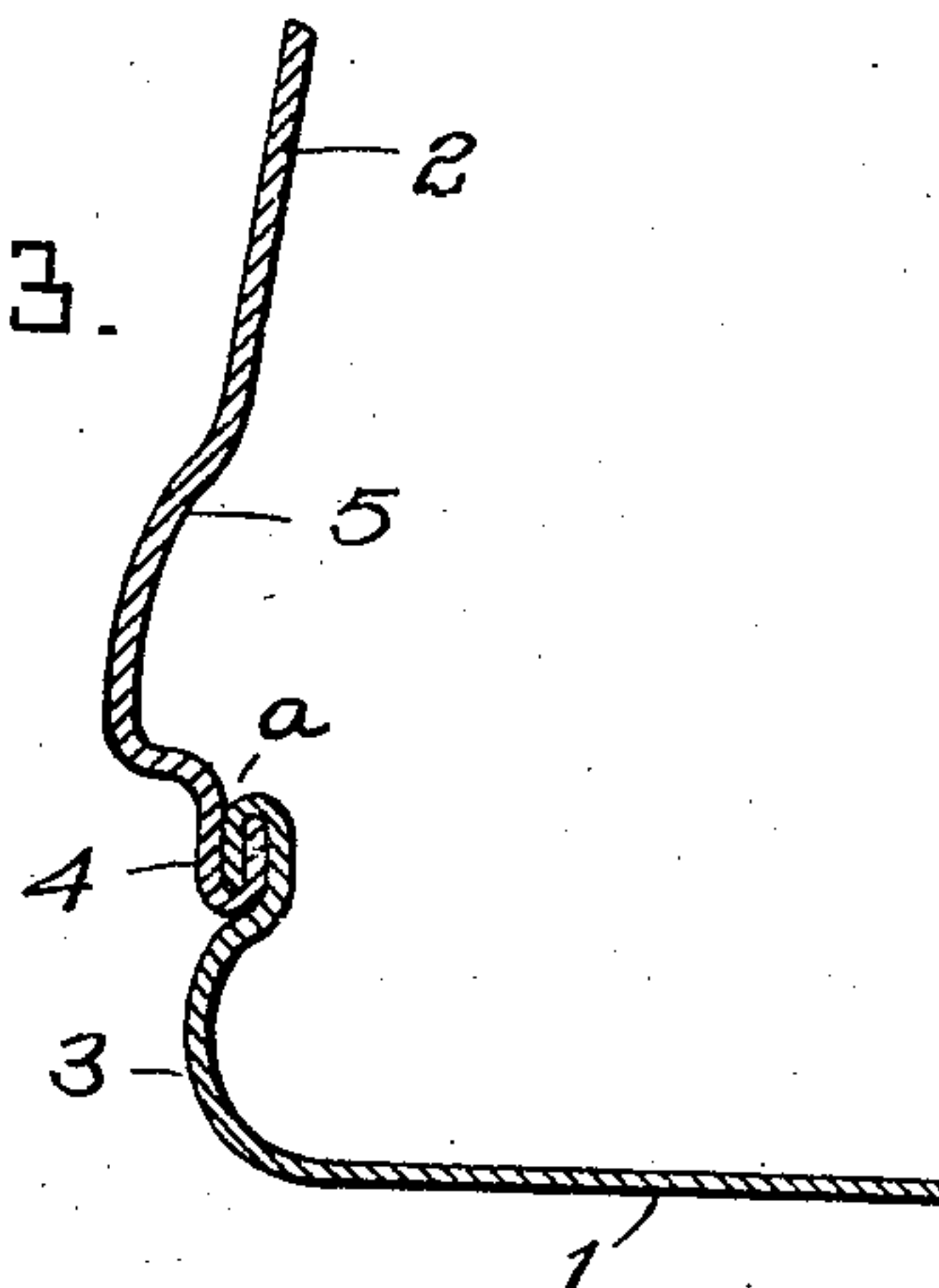


FIG. 3.



WITNESSES:
J. Herbert Bradley.
Charles Barnett.

INVENTOR
William A. Dunlap,
by Christy & Christy, Attys

UNITED STATES PATENT OFFICE.

WILLIAM A. DUNLAP, OF PITTSBURG, PENNSYLVANIA.

ENAMELED WARE.

No. 868,078.

Specification of Letters Patent.

Patented Oct. 15, 1907.

Application filed August 20, 1906. Serial No. 331,335.

To all whom it may concern:

Be it known that I, WILLIAM A. DUNLAP, residing at Pittsburg, in the county of Allegheny and State of Pennsylvania, a citizen of the United States, have invented or discovered certain new and useful Improvements in Enameled Ware, of which improvements the following is a specification.

The invention described herein relates to certain improvements in the manufacture of enameled ware.

10 In the manufacture of coffee pots and other vessels having the bottom and body portions secured together by a seam, great difficulty is encountered in securing an unbroken coating or surface of enamel over the seam. Without advancing any theory as to the cause of these
15 breaks or cracks in the surface, I have found that if the portion of the body of the above and adjacent to the seam be given a greater pitch or inclination, so that there will be a retardation in the downward flow of the liquid enamel at and adjacent to the seam, and that
20 the seam will tend to dam up the enamel, an even unbroken surface will be produced.

The invention is hereinafter more fully described and claimed.

25 In the accompanying drawing forming a part of this specification, Figure 1 is a side elevation of a coffee pot embodying my improvement; Fig. 2 is a sectional view on an enlarged scale illustrating my improvement; and Fig. 3 is a similar view illustrating a modification.

30 While in the practice of my invention the bottom can be seamed directly to the body 2 as is well known in the art, it is preferred to form the bottom with an upturned flange 3, which has its edge secured to the lower edge of the body, by the seam 4, formed in the usual or suitable manner known in the art. The portion 5 of the
35 body above and adjacent to the seam 4, is swaged or bent to form a ledge or retarding portion at an angle to the general surface of the body 2. By reference to Figs. 2 and 3, it will be seen that the ledge terminates

with the seam which preferably forms a peripheral dam or obstruction to the flow of enamel down along the vessel, and the enamel will be slightly backed up allowing it to penetrate the seam. 40

In the construction shown in Figs. 1 and 2, the ledge forms a portion of the exterior surface of the vessel, and in the formation of their exterior ledge the wall is bent inwardly producing a bead or inward projection overhanging the seam. The bead or overhanging projection will conceal any imperfections in the enamel covering the seam. The imperfections or cracks heretofore mentioned occur in the second coating and do not expose the metal surface, and hence while unsightly do not detract from usefulness of the vessel. 45 50

I claim herein as my invention:

1. A vessel having in combination body and bottom portions secured together with the joint between said parts opening upwardly, the portions of the body above and adjacent to the plane of connection being bent to form an angle to the axis of the body, greater than the angle of the body to said axes, whereby the flow of enamel is retarded and permitted to fill the joint. 55 60

2. A vessel having in combination body and bottom portions secured together, the portion of the body above and adjacent to the plane of connection bent to form an angle to the axis of the body greater than the angle of the body to said axis whereby the flow of enamel is retarded at the point of junction of the body and bottom portions so as to completely cover the joint between said parts. 65

3. A vessel having in combination body and bottom portions seamed together, the portion of the body above and adjacent to the seam being bent to form a horizontal or approximately horizontal ledge whereby the flow of enamel is retarded and permitted to fill the seam connecting the body and bottom portions. 70

4. A vessel having in combination a body and a bottom provided with a flange, seamed to the body, the body having an inwardly projecting bead overhanging the seam. 75

In testimony whereof, I have hereunto set my hand.

WILLIAM A. DUNLAP.

Witnesses:

J. M. CORBOY,

J. HERBERT BRADLEY.