

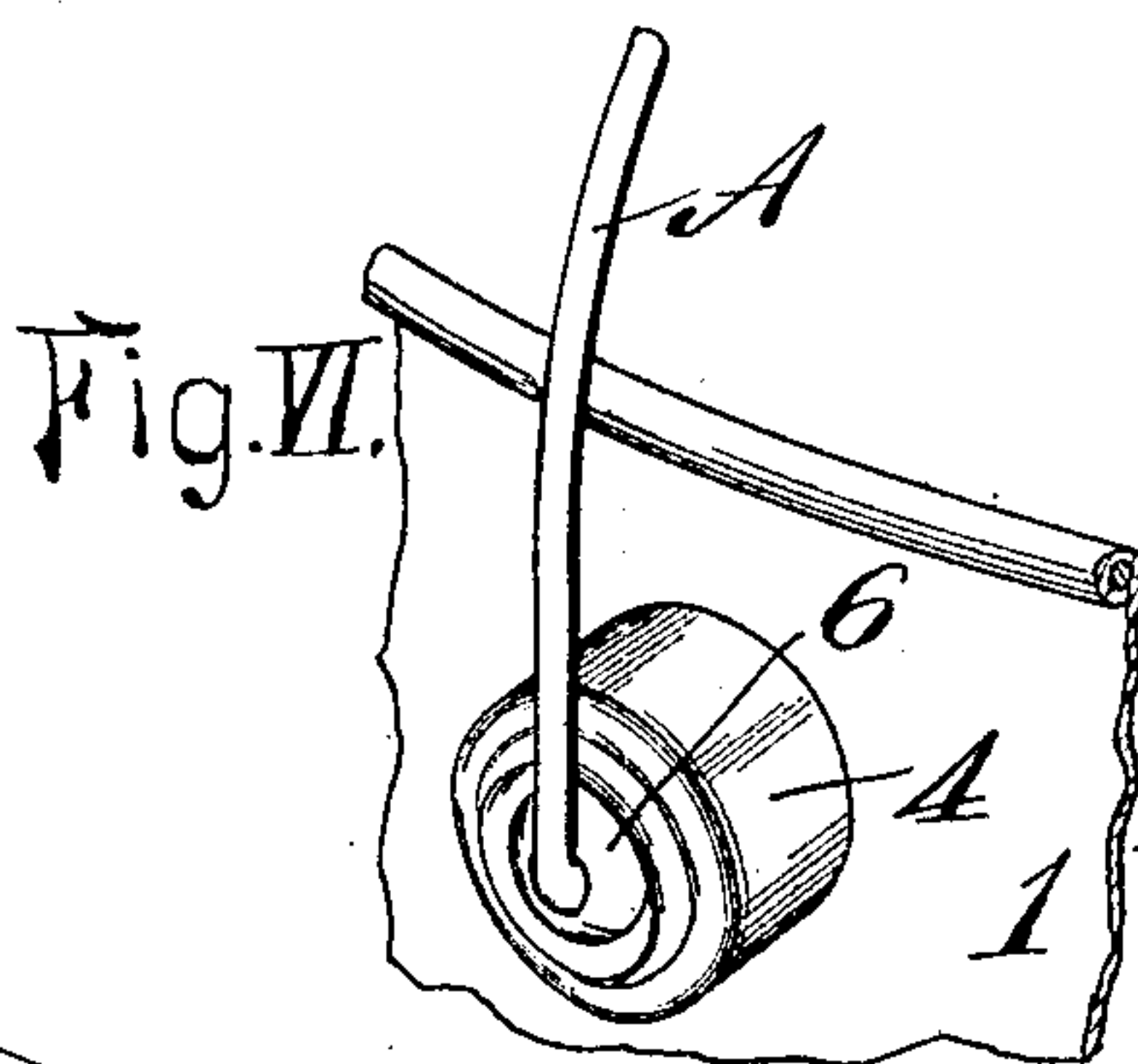
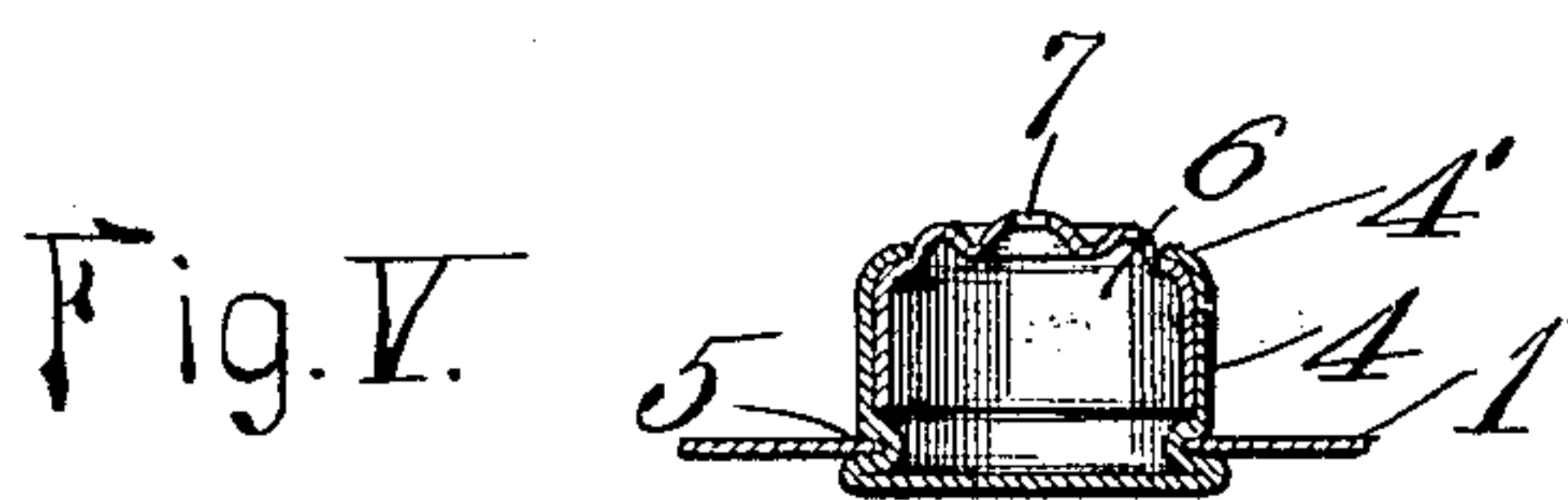
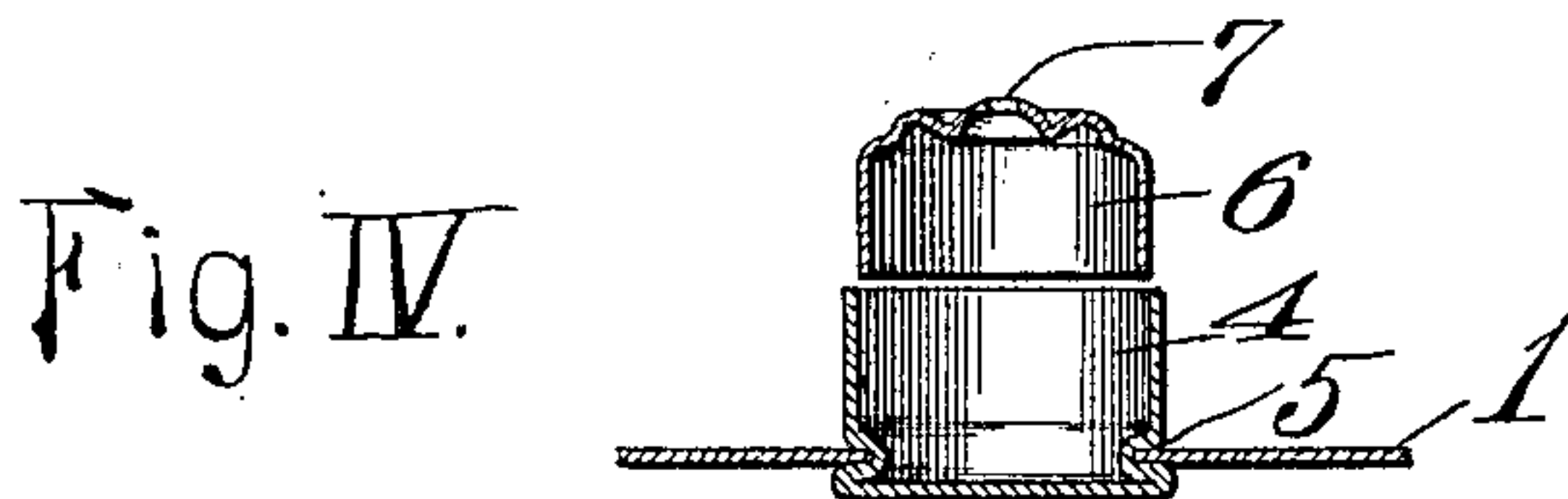
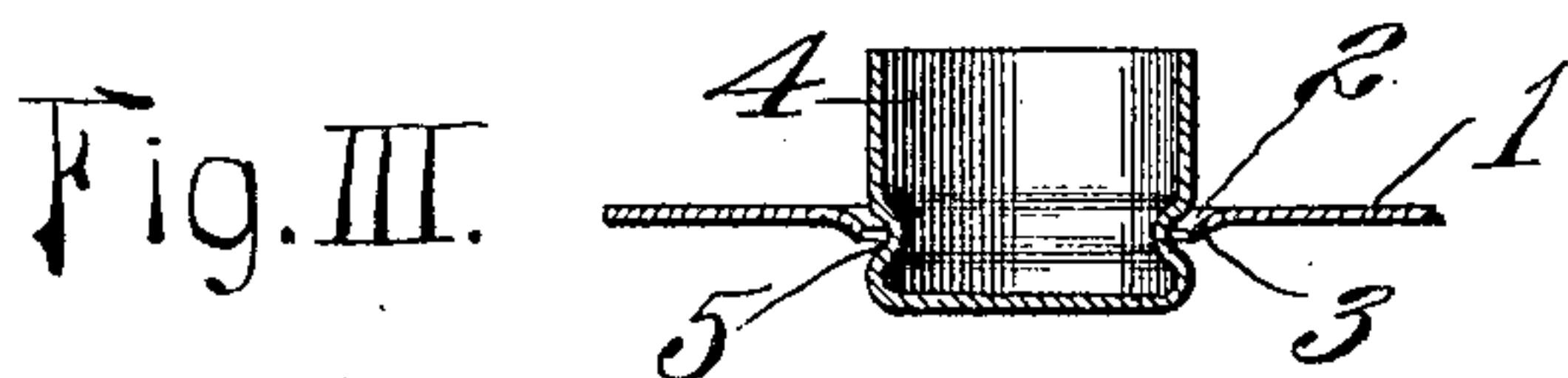
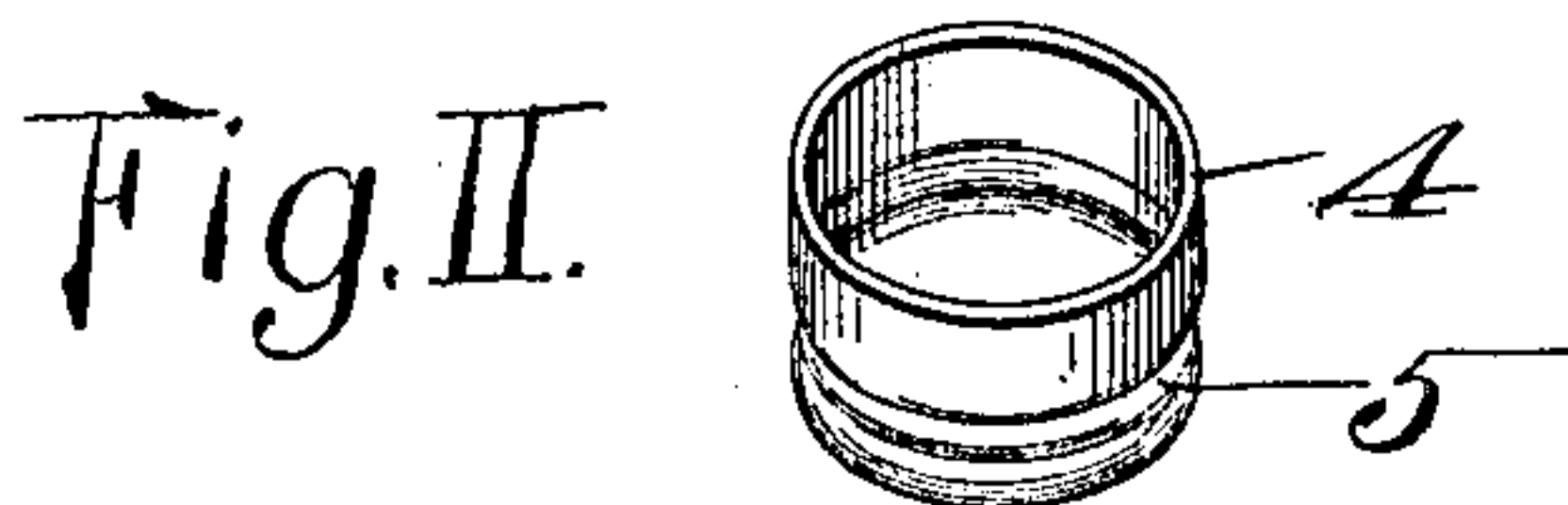
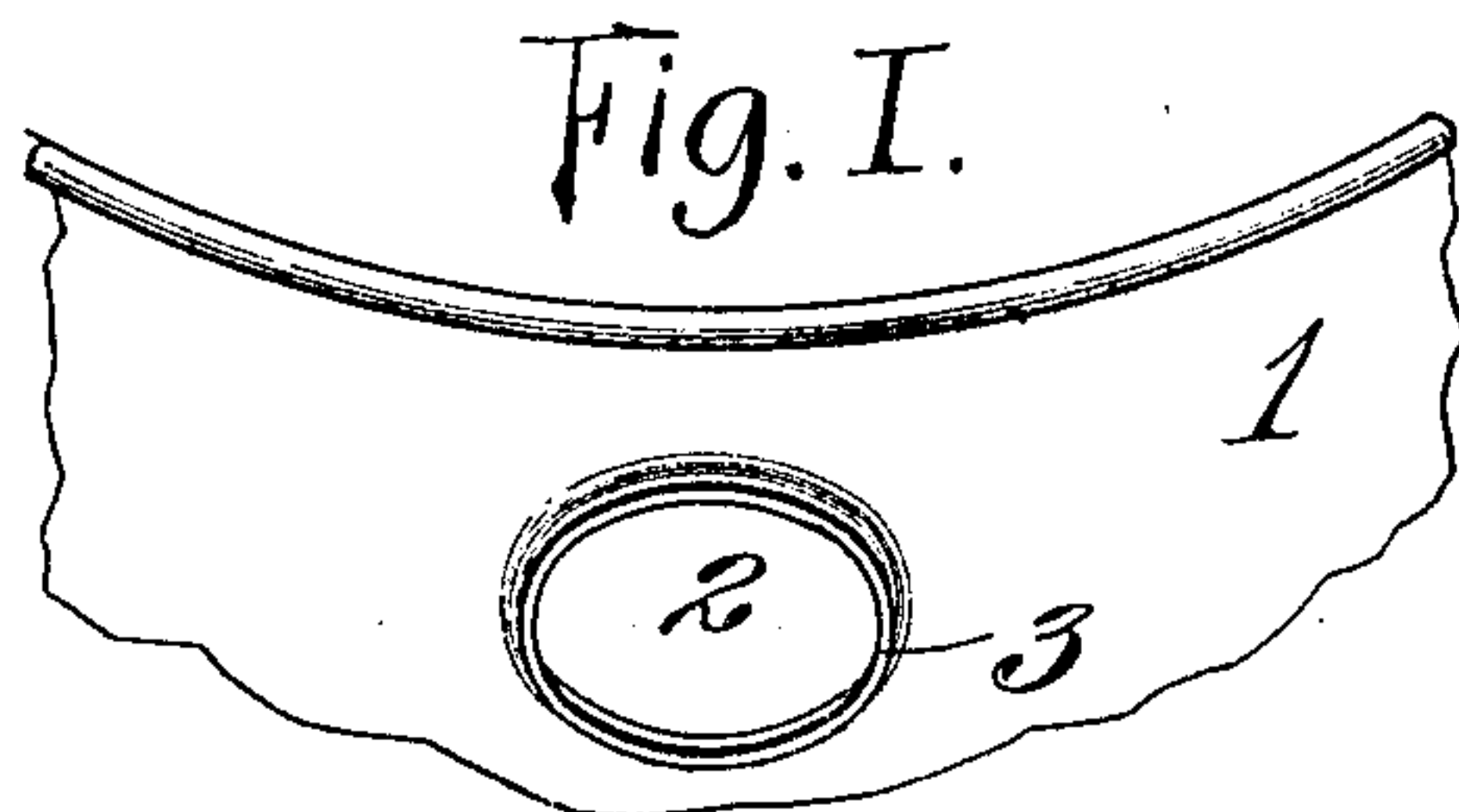
F. WESTERBECK.

BAIL EAR.

APPLICATION FILED APR. 1, 1907.

913,335.

Patented Feb. 23, 1909.



Attest  
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# UNITED STATES PATENT OFFICE.

FREDERICK WESTERBECK, OF ST. LOUIS, MISSOURI.

## BAIL-EAR.

No. 913,335.

Specification of Letters Patent.

Patented Feb. 23, 1909.

Application filed April 1, 1907. Serial No. 365,773.

*To all whom it may concern:*

Be it known that I, FREDERICK WESTERBECK, a citizen of the United States of America, residing at the city of St. Louis, in the State of Missouri, have invented certain new and useful Improvements in Bail-Ears, of which the following is a full, clear, and exact description, reference being had to the accompanying drawing, forming part of this specification.

My invention relates to an improved bail ear for sheet metal pails or buckets and it has for its object to provide an ear of this kind which is rigidly secured to the vessel with which it is to be used without the employment of solder or any means of attachment other than that entering into the vessel and its ear.

Figure I is a perspective view of a fragment of the upper end of a pail or bucket with the inwardly spread ear receiving opening therein for the reception of the ear base cup. Fig. II is a perspective view of the ear base cup. Fig. III is a section taken through the wall of the vessel at the location of the inwardly spread ear receiving opening and the ear base cup with said ear base cup shown in unclamped position in said inwardly spread ear receiving opening. Fig. IV is a similar view to Fig. III with the ear base cup shown clamped to the wall of the vessel and the bail receiving cup shown in position ready to enter the ear base cup. Fig. V is a similar view to Fig. III with the bail receiving cup shown secured in the ear base cup. Fig. VI is a perspective view of a fragment of the upper end of the vessel with my completed bail ear attached thereto.

1 designates a fragment of a sheet metal vessel containing a bail ear receiving opening 2. The edge of the portion of the wall surrounding said opening is inwardly spread or bent out of line with said wall to produce an annular flaring flange 3.

4 designates an ear base cup that is provided with an annular groove 5 located between the ends of the ear base cup. The diameter of this ear base cup, aside from the annular groove therein, is approximately the same as the internal diameter of the annular flaring flange 3 in its flared condition in or-

der that the ear base cup may be inserted into the ear receiving opening 2 for the edge of the annular flaring flange 3 to enter into the annular groove in the ear base cup, as seen in Fig. III. After the ear base cup has been introduced into said ear receiving opening pressure is applied to the ear base cup in a direction longitudinally thereof with the result that the flaring flange 3 of the vessel wall is straightened into the plane with the wall and the edge of the wall surrounding the ear receiving opening 2 is firmly embedded and clamped between inner and outer walls of the annular groove 5 of the ear base cup, as seen in Fig. IV. It is to be observed that by straightening the annular flaring flange 3 from its flaring condition into line with the wall of the vessel said annular flaring flange becomes obliterated and the diameter of the ear receiving opening 2 being rendered approximately the same as the diameter of the ear base cup at its exterior and at the base of the annular groove 5 therein. The edge of the metal surrounding the ear receiving opening 2 is therefore caused to fit snugly into the compressed ear base cup within the annular groove 5 as a consequence of which the ear base cup is rigidly secured to the body of the vessel.

6 designates a bail receiving cup in the outwardly projecting corrugated bottom of which is an aperture 7 for the reception of a bail, such as that shown in part in Fig. VI designated by the letter A. The bail receiving cup is inserted, open end first, into the ear base cup 4 so that it is sleeved or telescoped within the ear base cup and snugly fitted therein. After the bail receiving cup is inserted into the ear base cup the outer edge of the ear base cup is turned over onto the outer end of the bail receiving cup to produce a binding flange 4', as seen in Fig. V, that serves to retain the bail receiving cup in the ear base cup with its inner end or edge resting against the bead at the interior of the ear base cup that is produced, due to the formation of the annular groove 5 at the exterior of said ear base cup.

I claim:

The combination, with a sheet metal vessel having a bail ear receiving opening in its



wall; of a bail ear consisting of an ear base  
cup provided with an imperforate base with-  
in the wall, an annular groove at its inner  
end fitting the edge of the receiving opening,  
5 and an inbent flange at its outer end, and a  
bail receiving cup provided with a straight  
sleeve fitting in the ear base cup and a shoul-

der at its outer end against which the inbent  
flange is fitted, and an outwardly projecting  
corrugated bottom having a bail aperture.

FREDERICK WESTERBECK.

In presence of—

BLANCHE HOGAN,  
LILY ROST.