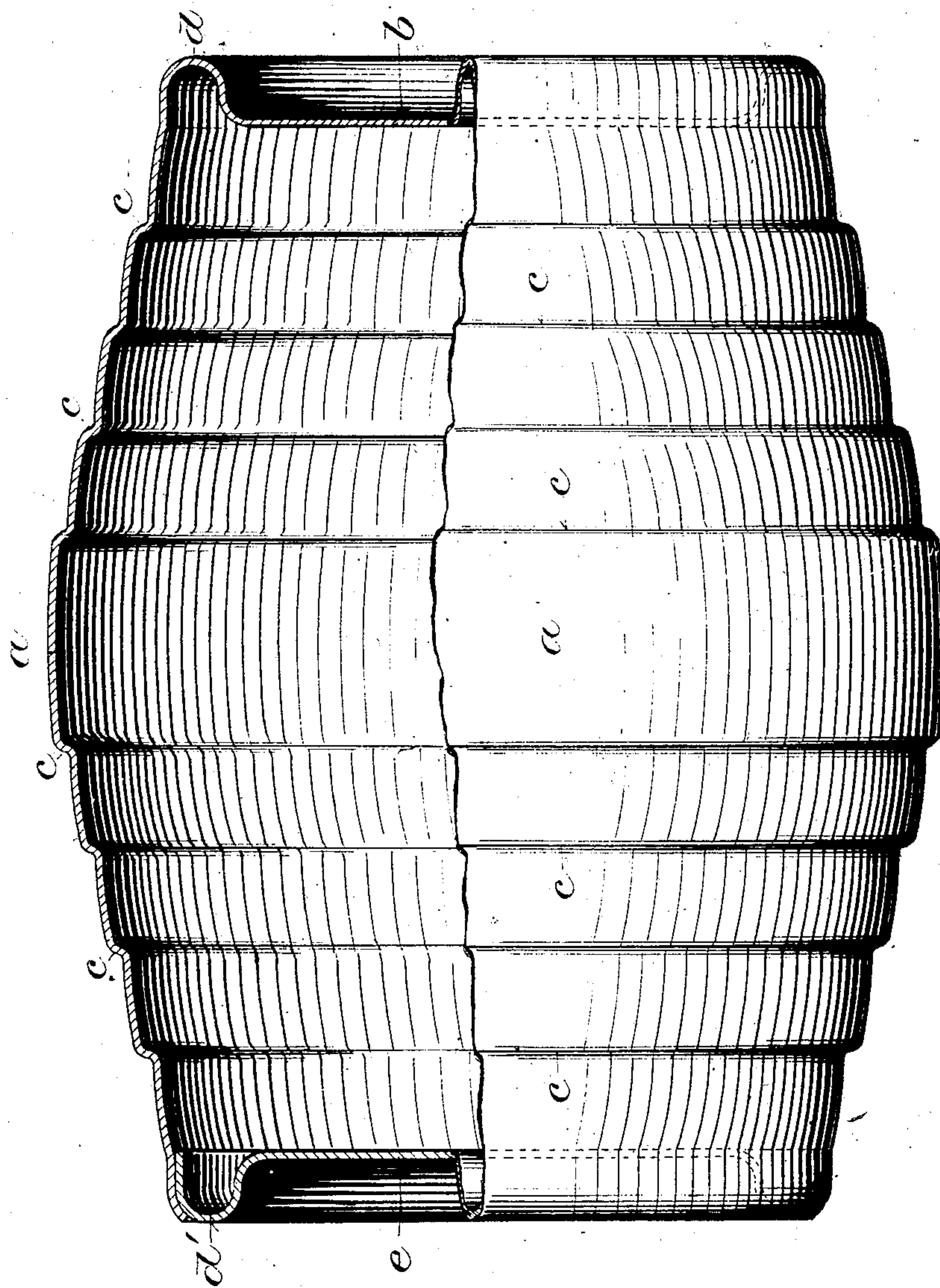


R. H. HACKNEY.
METAL BARREL OR CASK.
APPLICATION FILED NOV. 21, 1906.

919,345.

Patented Apr. 27, 1909.



Witnesses:
Fred Palm.
Chas. L. Coor.

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UNITED STATES PATENT OFFICE.

ROBERT H. HACKNEY, OF MILWAUKEE, WISCONSIN, ASSIGNOR TO PRESSED STEEL TANK COMPANY, OF MILWAUKEE, WISCONSIN, A CORPORATION OF WISCONSIN.

METAL BARREL OR CASK.

No. 919,345.

Specification of Letters Patent.

Patented April 27, 1909.

Application filed November 21, 1906. Serial No. 344,413.

To all whom it may concern:

Be it known that I, ROBERT H. HACKNEY, a citizen of the United States, residing at Milwaukee, in the county of Milwaukee and State of Wisconsin, have invented certain new and useful Improvements in Metal Barrels or Casks, of which the following is a specification, reference being had to the accompanying drawing, forming a part thereof.

10 This invention relates to metal barrels or casks of the class shown and described in United States Letters Patent No. 793,579, issued to me June 27, 1905.

15 The main object of the present invention is to simplify and strengthen the construction and to reduce the weight and cost of barrels or casks of this class.

20 It consists in certain novel features of construction as hereinafter particularly described and pointed out in the claims.

25 The accompanying drawing illustrates partly in side elevation and partly in central longitudinal section, a sheet metal barrel or cask constructed in accordance with the invention.

30 The body *a* of the barrel is formed from sheet steel or other suitable metal by dies or other means integrally with one head *b* and with a bilge and circumferential stiffening corrugations *c*. These corrugations are preferably made step-shaped as shown, to avoid internal pockets or recesses which will retain sediment and render it difficult to thoroughly wash and cleanse the barrel. The head *b* is bent inwardly adjacent to its margin, and forms with the end of the body an outwardly projecting rim or chime *d*.

35 In the open end of the body is fitted a separately formed sheet metal head *e*, which is bent inwardly at and adjacent to its margin to form an outwardly projecting rim or chime *d'* like or similar to that on the head *b*. This head *e* may be secured in the barrel by turning or bending the edge of the body inwardly against it as shown, or in any other

suitable manner. The inward bends in the heads to form the chimes *d* and *d'* are preferably made as shown, on gradual curves, so as to produce comparatively wide open internal recesses in which dirt and sediment will not readily lodge and from which it can be easily removed.

Providing the body of the barrel with step-shaped or shallow corrugations or bends *c* and forming the heads with the chimes *d* and *d'* stiffen and strengthen the structure; admit the use of thinner sheet metal, and correspondingly reduce the weight and cost of the barrel. The body and heads are made without joints or seams and the interior surface of the barrel is such that it can be easily and effectively enameled or provided with a non-corrosive coating and can be easily and thoroughly washed and cleansed.

I claim:

65 1. A barrel or cask having a seamless wrought metal body and head formed in one piece with a bilge and circumferential step-shaped stiffening corrugations in the body, and a separately formed metallic head secured to the open end of the body, substantially as described.

70 2. A barrel or cask having a seamless wrought metal body and head formed in one piece with a bilge and circumferential step-shaped stiffening corrugations in the body, and a separately formed metallic head fitted in the open end of the body, the heads being bent inwardly and forming adjacent to their margins open internal recesses and outwardly projecting rims or chimes, and the edge of the body being bent inwardly over the inserted head and securing it in place, substantially as described.

80 In witness whereof I hereto affix my signature in presence of two witnesses.

ROBERT H. HACKNEY.

Witnesses:

CHAS. L. GOSS,

MAUDE L. EMERY.