

J. A. MURRAY.  
WATER BAG.  
APPLICATION FILED JAN. 18, 1911.

998,977.

Patented July 25, 1911.

Fig. 1.

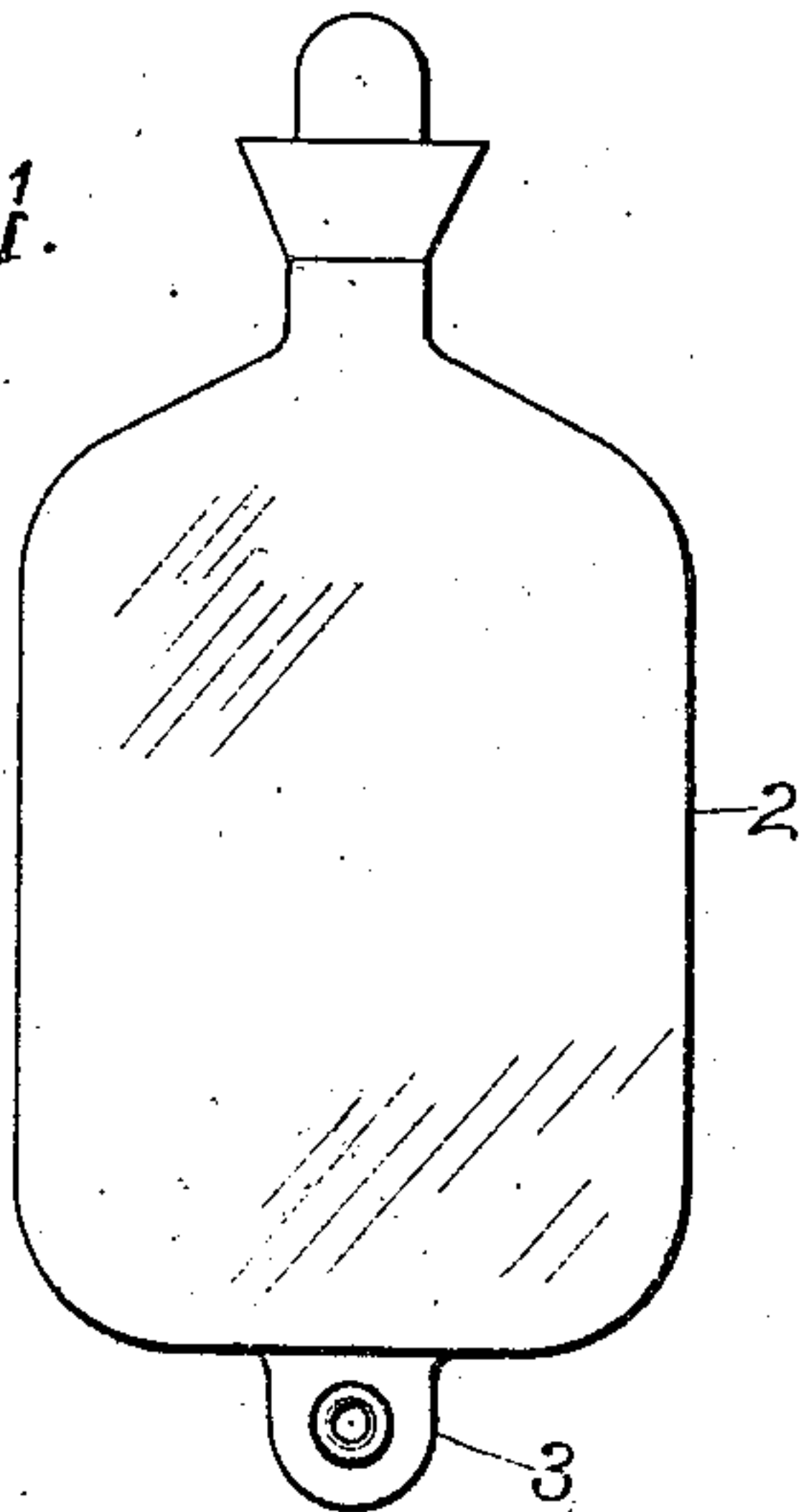


Fig. 2.

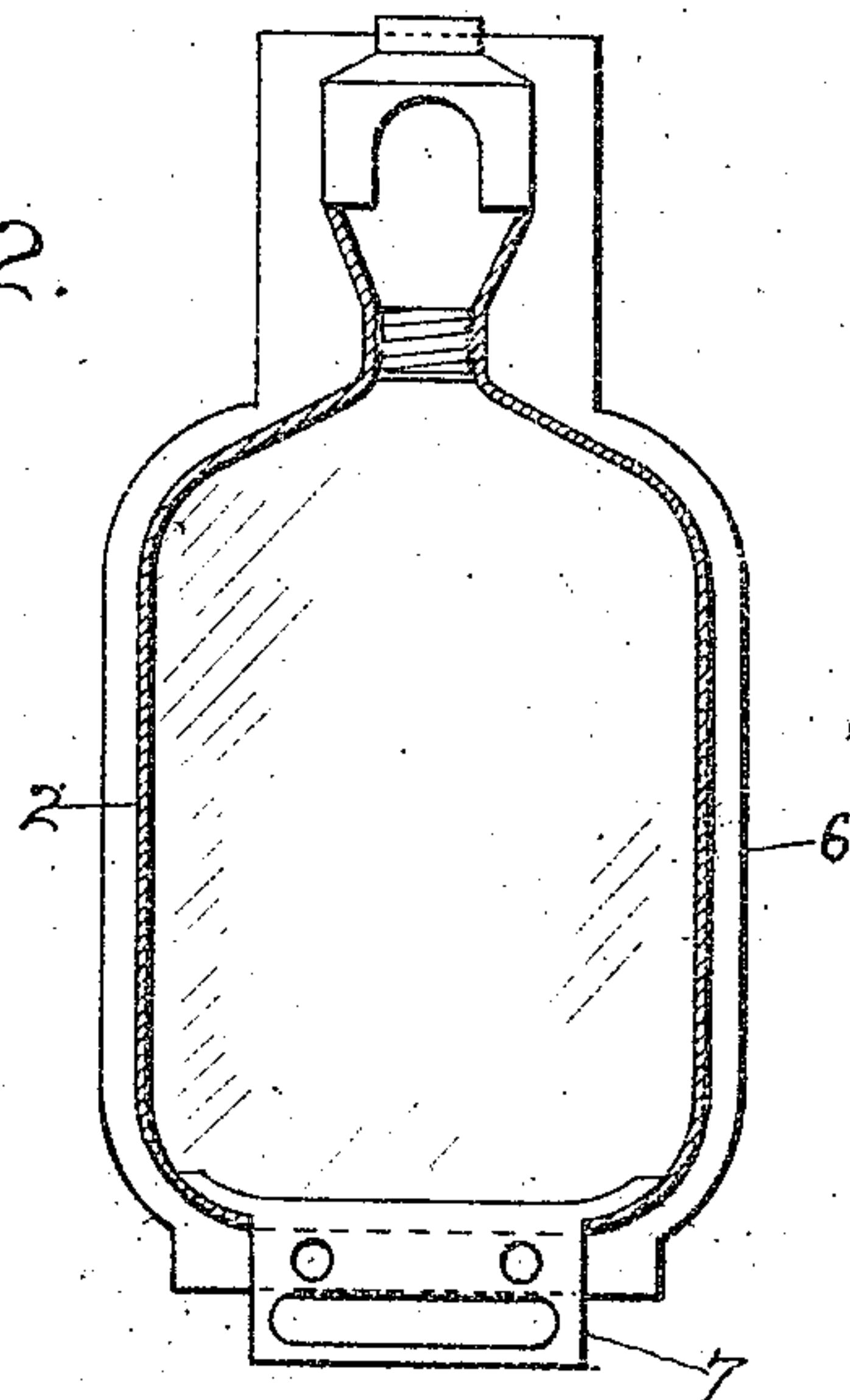


Fig. 4.

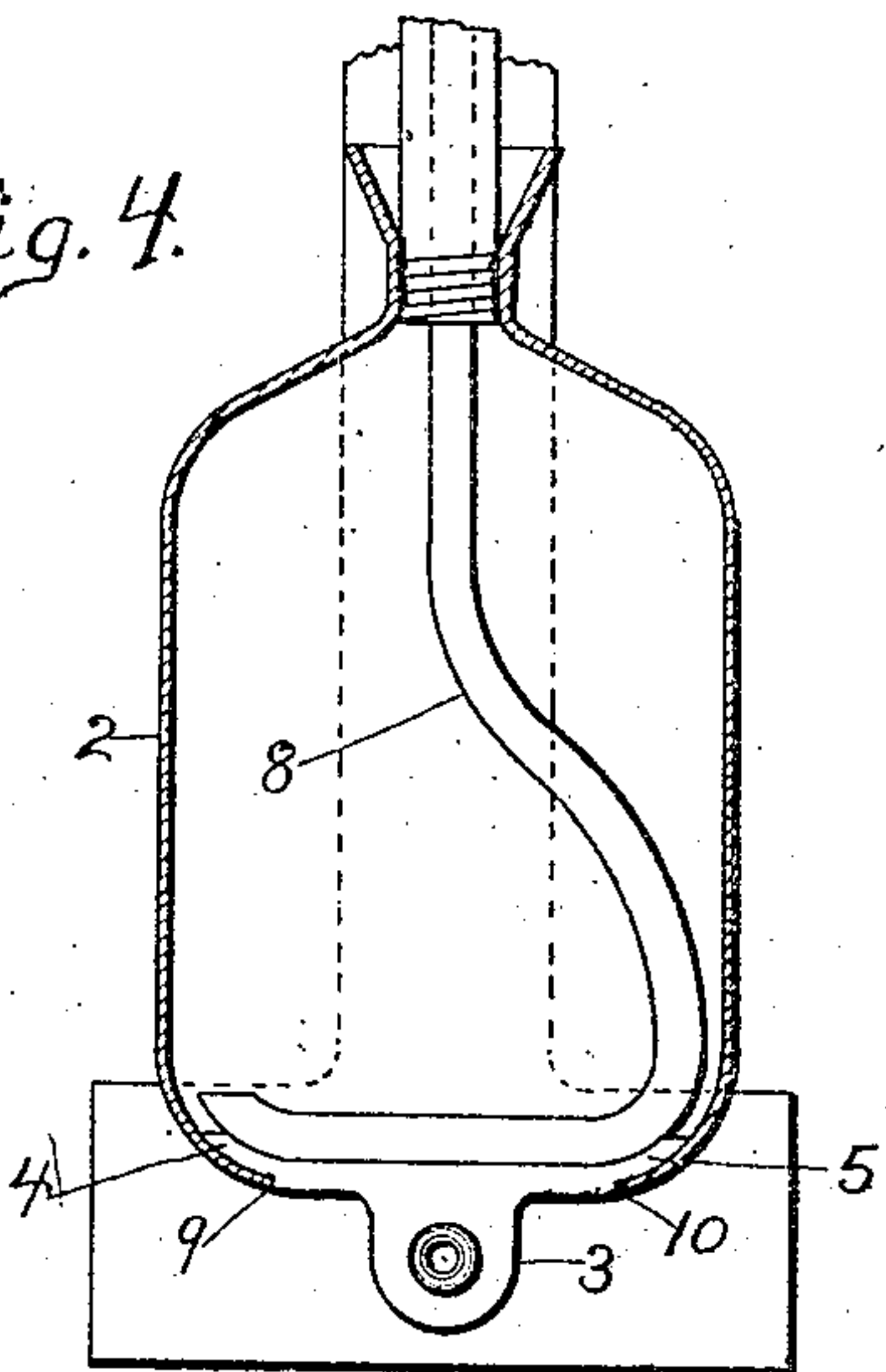
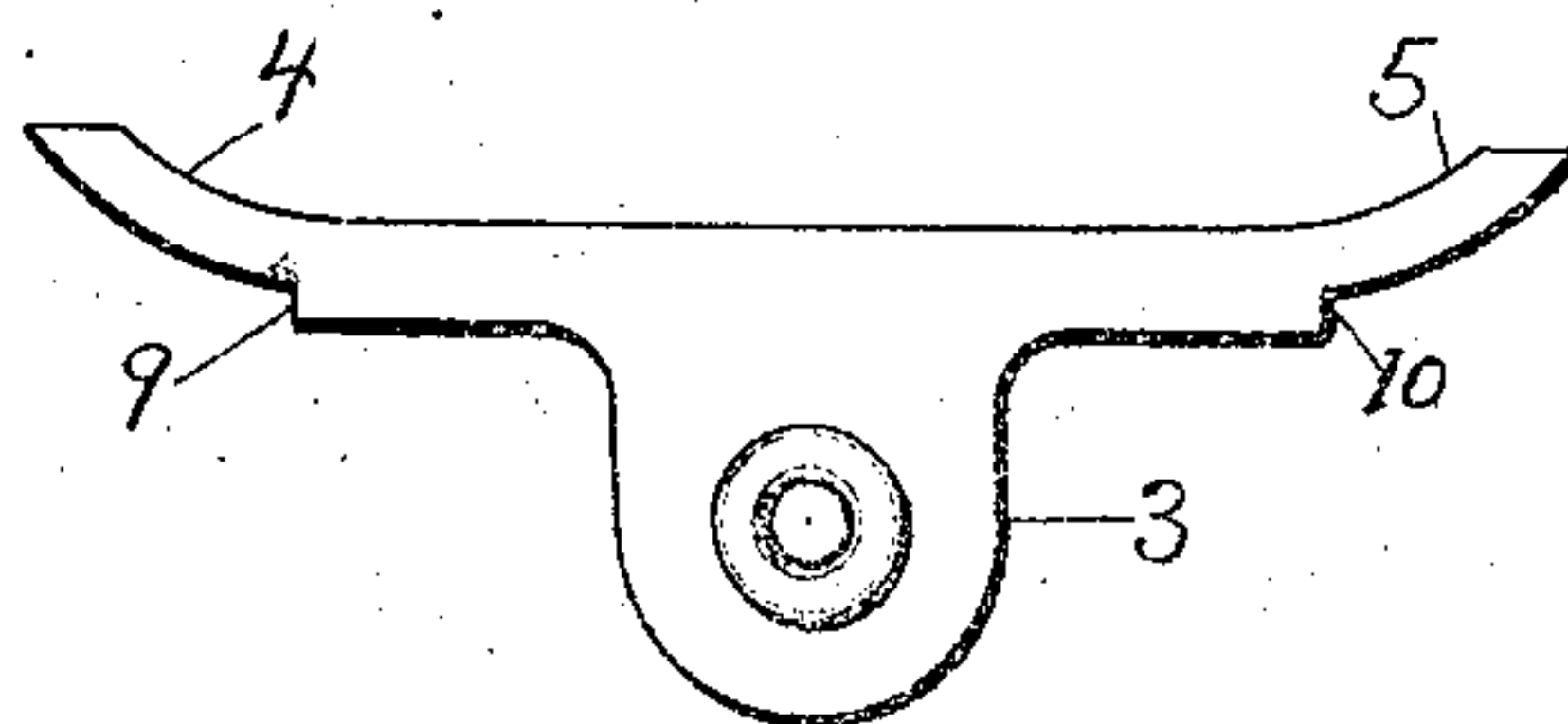


Fig. 3.



Witnesses,  
M. P. Nichols.  
C. L. Weed

Inventor  
James A. Murray  
by Seymour T. Carr  
Frederic C. Carr  
Attys

# UNITED STATES PATENT OFFICE.

JAMES A. MURRAY, OF NEW HAVEN, CONNECTICUT, ASSIGNOR OF ONE-HALF TO  
JEREMIAH L. MAHONEY, OF NEW HAVEN, CONNECTICUT.

## WATER-BAG.

998,977.

Specification of Letters Patent.

Patented July 25, 1911.

Application filed January 18, 1911. Serial No. 603,299.

To all whom it may concern:

Be it known that I, JAMES A. MURRAY, a citizen of the United States, residing at New Haven, in the county of New Haven and State of Connecticut, have invented a new and useful Improvement in Water-Bags; and I do hereby declare the following when taken in connection with the accompanying drawings and the letters of reference marked thereon, to be a full, clear, and exact description of the same, and which said drawings constitute part of this specification, and represent, in—

Figure 1 a side view of a water bag or bottle constructed in accordance with my invention. Fig. 2 a sectional view illustrating the manner of forming the bag or bottle with a slot in its lower edge. Fig. 3 a plan view of the eye-member detached. Fig. 4 a sectional view showing the manner of uniting the eye-member to the body-member.

This invention relates to an improvement in water bags, the object of the invention being to form a rubber water bag or bottle in a simple manner and so as to produce a strong bottle by reinforcing the bag or bottle at the bottom where the greatest strain comes; and the invention consists in the construction as hereinafter described and particularly recited in the claim.

The water bag or bottle 2 when completed is of substantially the usual form. These bottles are provided with a suspending loop or eye 3, and in carrying out my invention I form this loop or eye 3 integral

with outwardly projecting arms 4 and 5 corresponding in form and size to the lower edge of the bag or bottle. The bag or bottle 2 is formed in a mold 6 in which the core 7 is placed to form a slot in the bottom of the bag. When the bag is thus formed the core 7 is removed, and the arms 4, 5 of the loop 3 are inserted through this opening and pressed against the bottom of the bag by a wire former 8 which is pressed downward so as to force the arms 4, 5 against the inner face of the bottom of the bag or bottle, and the underside of the arms are formed with shoulders 9, 10 which closely fit the slot formed by the core 7 and the parts being subjected to pressure and heat will unite the loop or eye with the bottle, thus firmly closing the bottom and reinforcing the same.

I claim:—

A hot water bag or bottle comprising a body formed with a slot in its lower edge and an eye portion fitting said slot and completing the edge of the bottle and formed with outwardly extending arms which extend into the bag at opposite ends of the slot and reinforce the lower edge of the bottle.

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

JAMES A. MURRAY.

Witnesses:

FREDERIC C. EARLE,  
CLARA L. WEED.