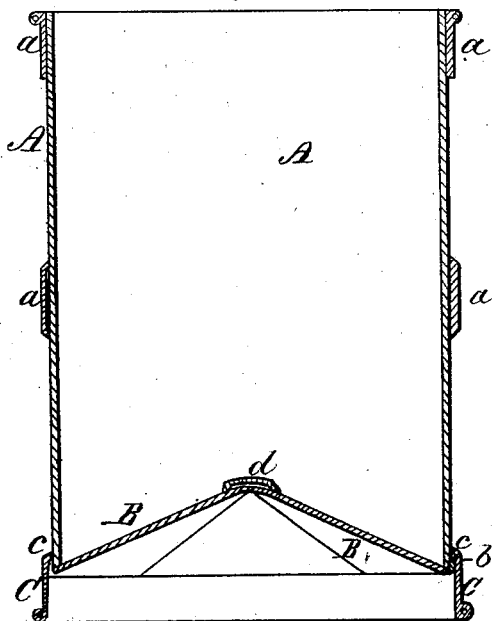


*H. W. Millar,*

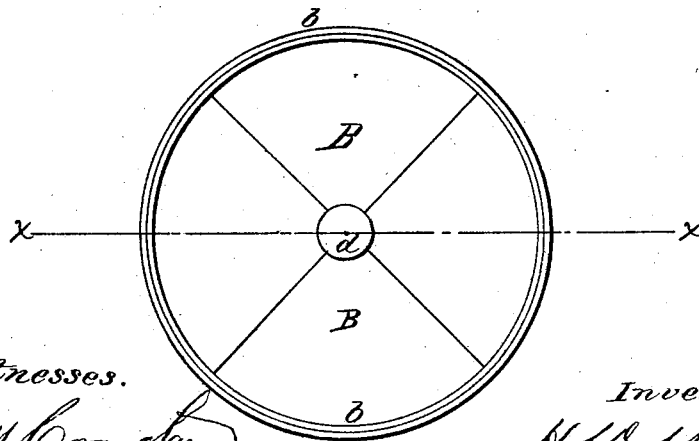
*Making Metal Cans, &c.*

*N<sup>o</sup> 50,022. Patented Sep. 19, 1865.*

*Fig. 1.*



*Fig. 2.*



*Witnesses.*

*J. M. Cornington*  
*E. L. Giff*

*Inventor.*

*H. W. Millar*  
*By Munn & Co*  
*attys*

# UNITED STATES PATENT OFFICE.

HENRY W. MILLAR, OF UTICA, NEW YORK.

## IMPROVEMENT IN THE CONSTRUCTION OF CANS.

Specification forming part of Letters Patent No. 50,022, dated September 19, 1865.

*To all whom it may concern:*

Be it known that I, HENRY W. MILLAR, of Utica, in the county of Oneida and State of New York, have invented a new and Improved Bottom for Cans, Pails, &c.; and I do hereby declare that the following is a full, clear, and exact description thereof, which will enable others skilled in the art to make and use the same, reference being had to the accompanying drawings, forming part of this specification, in which—

Figure 1 is a longitudinal vertical section of a can with its bottom constructed according to my invention, taken in the line *x x*, Fig. 2. Fig. 2 is a view of the bottom when looking into the can.

Similar letters of reference indicate like parts.

My invention consists in constructing a bottom for a can, pail, or other metallic vessel in a conical form, or in the form of a frustum of a cone, its apex or point extending upward into the can, so as to strengthen the resisting-power of the bottom, and also, when it may be desirable, to afford a better opportunity for drawing off the entire contents of the can by faucet or the like.

To enable others to fully understand my invention, I will proceed to describe it.

A represents the body of a milk-can constructed in the ordinary way, *a a* being strips soldered around the same for the purpose of strengthening it and protecting it against injury, as usual.

To form the bottom, I take several triangular pieces of metal, B, and solder or otherwise join their edges together, so that when they are thus joined they will present the form of a cone, with seams running from the base to the apex. The edges, which constitute the base of this cone-shaped bottom, are then turned upward, so as to form a flange or rim, *b*, capable of just lapping over the outside of the bottom or lower portion of the body A, as shown clearly in Fig. 1. These two pieces—the conical bottom B and body A—are then joined together by soldering or in any suitable manner. I then secure to this the rim C, which is to form the pedestal of the can, its flange *c* extending up above the rim *b* and resting against the body A of the can. Applying the pedestal

in this way strengthens the parts at this point and makes a better joint.

Over the apex of the cone-shaped bottom B, there is soldered or secured a cap, *d*, which more effectually protects the same against rust and consequent leakage.

Making the bottom of a can in this manner greatly strengthens the resisting power of the bottom. In cans made with flat or nearly flat bottoms, the tendency of the weight of fluid they contain is to bulge the bottoms downward near the center, which necessarily draws inward the sides of the can and tends to loosen the joints where the said bottoms are fastened to the sides.

With a bottom made according to my invention this disadvantage is obviated, for the reason that a weight resting upon it causes it to operate on the principle of the arch; but there is no liability of straining outward the sides of the can, for the reason that the bottom edges of said sides are confined by the rim C on the base of the said conical bottom B. The parts thus secured are held firmly together and remain in perfect condition so long as the material of which they are composed lasts.

I purpose also making these bottoms in the form of the frustum of a cone, the points being bent inward and soldered together or otherwise secured together, or actually cut off and a cap or plate placed over the top or opening.

A can constructed in this way, with a conical bottom affords a better opportunity for entirely drawing off its contents when it is desirable to use a cock or faucet, which may be inserted at the lowest part, and thus completely drain the can, as can be readily understood, and this is a desirable feature in stationary cans used for containing oil, molasses, &c.

What I claim as my invention, and desire to secure by Letters Patent, is—

Constructing the bottom and securing the same to the body of the can in the manner shown and described.

The above specification of my invention signed by me this 31st day of March, 1865.

HENRY W. MILLAR.

Witnesses:

DEXTER GILLMORE,  
MICHAEL CLARK.