(No Model.)

E. NORTON.

SHEET METAL CAN.

No. 264,099. Patented Sept. 12, 1882.

Fig. 1.

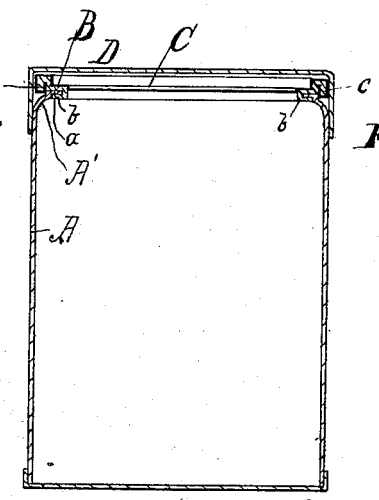


Fig. 2.

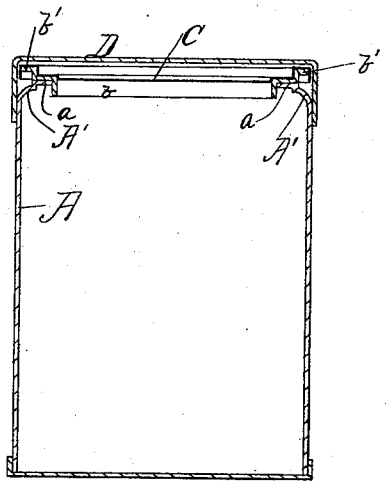
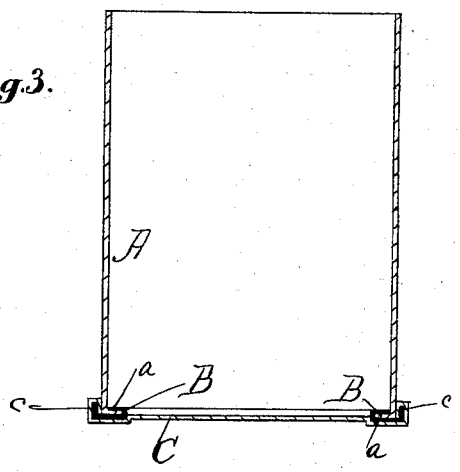


Fig. 3.



Witnesses:

J. Everett Brown

Wm. W. Munday.

Inventor:

Edwin Norton.

per Munday Evarts & Adcock

his Attorneys:

UNITED STATES PATENT OFFICE.

EDWIN NORTON, OF CHICAGO, ILLINOIS.

SHEET-METAL CAN.

SPECIFICATION forming part of Letters Patent No. 264,099, dated September 12, 1882.

Application filed August 7, 1882. (No model.)

To all whom it may concern:

Be it known that I, EDWIN NORTON, of Chicago, county of Cook, and State of Illinois, have invented certain new and useful Improvements in Sheet-Metal Cans, of which the following is a specification.

My invention relates to improvements in that class of sheet-metal cans wherein the cap or cover is united to the body of the can without the use of solder by what is commonly known as a "double seam," and the same relates more particularly to improvements on the can heretofore patented to me by Letters Patent of the United States, No. 255,012, under date of March 14, 1882.

The object of the present improvement, which is adapted more especially for large cans, is to provide a stronger can, and thus produce the effect of a wired pail or can, and at the same time unite the seamless flange to the can-body by a firm interlocked soldered seam in such way that there will be no danger of the subsequent action of the double-seaming rollers in uniting the cover to the seamless flange breaking or disturbing such soldered seam, and thereby causing a leak in the can; and the present invention consists in turning an interior flange or shoulder on the can-body, over which the interior edge of the seamless flange is folded and soldered, thus forming on the can-body an interior right-angle strengthening-flange composed of three thicknesses of the sheet metal soldered together, and thus producing a can almost, if not quite, as strong as if it were wired at the top like a pail, while the exterior edge of the seamless flange constitutes an element of the double seam by which the cover is united to the can-body. Where an inner cover made of "taggers" tin or thin sheet metal is used in connection with a slip-cover I turn a shoulder on the top of the can, so that the exterior double seam will fall within the line of the can-body, and thus permit the slip-cover to fit over it the same as if no inner cover were used. By uniting the seamless flange in this way to the can-body all danger of the double-seaming rollers disturbing the soldered seam which unites the seamless flange to the can-body will also be obviated.

In the accompanying drawings, which form a part of this specification, and in which similar letters of reference indicate like parts, Figure 1 is a central vertical section of my improved can. Fig. 2 is a similar view, showing the can before the inner cover is double seamed on; and Fig. 3 shows a modification where no slip-cover is designed to be used.

In the drawings, A represents the can-body, which is provided with an interior flange or shoulder, *a*. B is a seamless flange, the inner edges, *b*, of which is folded over and soldered to the flange *a* on the can-body, thus forming a solid interior right-angle flange composed of three thicknesses of the tin soldered together. The exterior edge, *b'*, of the seamless flange is united by a double seam, *c*, to the thin cover C, which is shown in black lines in Figs. 1 and 2. The top of the can-body A is turned in, as shown at A', so that the double seam *c* will fall within the circumference of the can-body, and thus permit the slip-cover D to fit over it in the ordinary manner. Of course it will be understood that the double seam *c* is formed without solder, and ordinarily after the can is filled.

In the form shown in Fig. 3 the interior shoulder A' is not used, as only a single cover or cap, C, is employed, and in Fig. 3 the seamless flange B is shown in black lines.

I claim—

1. The combination, with the can-body provided with an interior shoulder, *a*, of a seamless flange, B, having its inner edge, *b*, folded over and soldered to said interior shoulder, *a*, and its outer edge, *b'*, folded, with cover C, into a double seam, substantially as specified.

2. The combination, with a can-body, A, having its top turned in, a seamless flange, B, united to the can-body, a thin inner cover, C, united to said seamless flange by a double seam inside the exterior circumference of the can-body, and a slip-cover, D, adapted to fit on the can-body over said seam, substantially as specified.

EDWIN NORTON.

Witnesses:
HENRY M. NORTON,
HENRY F. AKIN.