J. W. SMITH.

Milk-Can.

No. 165,768. Patented July 20, 1875.

Fig. 1.

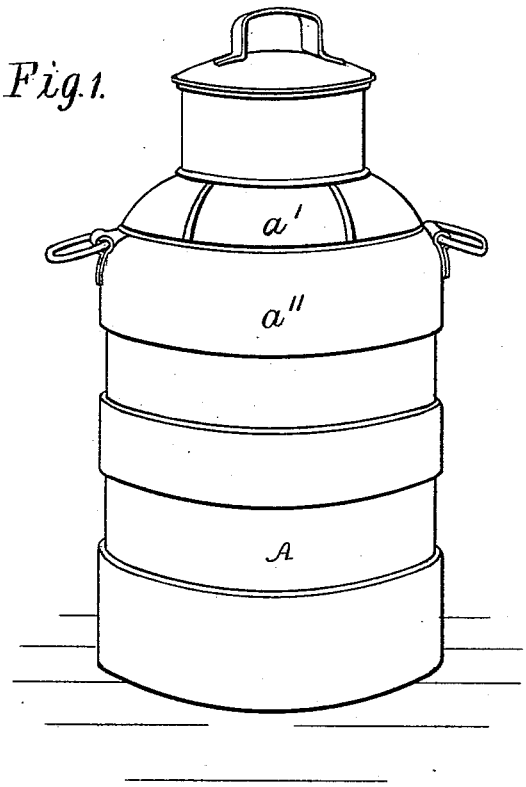
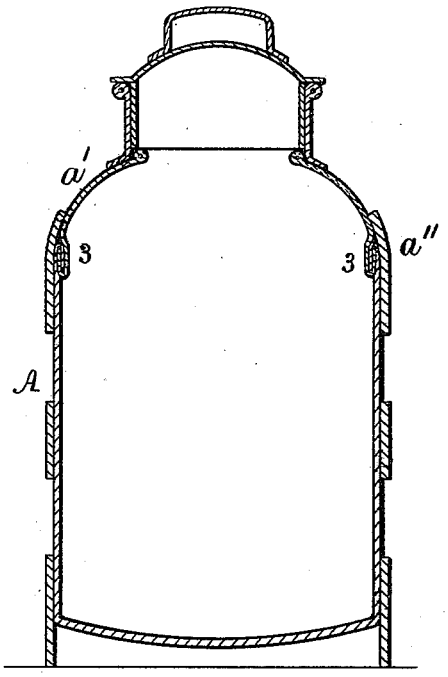



Fig. 2.




Witnesses:

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# UNITED STATES PATENT OFFICE.

JAY W. SMITH, OF PHILADELPHIA, PENNSYLVANIA.

## IMPROVEMENT IN MILK-CANS.

Specification forming part of Letters Patent No. **165,768**, dated July 20, 1875; application filed June 9, 1875.

*To all whom it may concern:*

Be it known that I, JAY W. SMITH, of the city of Philadelphia, in the State of Pennsylvania, have invented an Improvement in Milk-Cans, of which the following is a specification:

The object of my invention is to prevent any separation of the lap-joint or connection between the cylindrical body of a milk-can and the hemispherical top or shoulder of the same from the upper edge of the surrounding band; and this I accomplish by curving inward the upper edge of the band, so that, when applied, the curved portion will correspond with and fit down closely over onto the lap-joint and the lower portion of the hemispherical top of the can, the said band being made about one-third wider than heretofore, and, of course, soldered fast in the usual manner, as will be fully and clearly described herein, with reference to the accompanying drawing, in which—

Figure 1 is a perspective view of the improved milk-can, and Fig. 2 a central vertical section of the same.

The cylindrical body A and the hemispherical top $a'$ of the can are constructed and seamed together, as heretofore; but, instead of constructing the upper band $a''$ in the simple cylindrical form, and soldering it fast, so that its upper edge will be in the same line with the upper edge of the seam 3 of the can, as heretofore, I cut the band about one-third wider than heretofore, and then contract the upper third thereof by giving it an inward curve, to correspond with and fit accurately down onto the lower portion of the hemispherical top $a'$, and solder it fast in that position, substantially as represented in the drawing.

There are several modes used by sheet-metal workers for curving inwardly, and therefore contracting, one end of a sheet-metal cylinder, as, for instance, by swaging-machines, by stamping-dies, and by drawing in by a hammer, all of which are well known. I prefer the hammering mode, and, after the cylindrical hoop or band has its two ends soldered together, I slip it over the horizontally-projecting arm of a solid metal bearing, which serves as an anvil, the end of said arm being rounded off to suit the intended curve of the band, and, by means of a smooth-faced hammer, gradually turn inward the edge of the band, and consequently contract it, until it will fit accurately upon the curved shoulders or breast of the can, as shown in the drawing.

In order to make the band $a''$ fit, with its entire inner surface, against the outer surface of the body A and top $a'$, I cause the lap-joint 3 to project on the inner side of the can. (See Fig. 2.)

From the rough handling to which milk-cans are subject, during the loading, transmission, and unloading into, by, and from steam-cars, they are subject to frequent leakage and loss of milk through cracks or openings produced at the seam 3 by the separation of the soldered joints thereof, by the impact of one can against another, and also in the operation of emptying a full can into an empty one by tilting, a slight impact from accident or carelessness causing a leak-opening in the joint just above the ordinary cylindrical ring—the vulnerable point in the can. But it will be readily understood without any further description that, by my invention of the covering curvature of the upper edge of the top band $a''$, whereby the lap-joint 3 is entirely covered and protected against being opened by the ordinary rough knocking about of the cans against each other, as before explained, the object sought—*i. e.*, the preservation of the cans from the injury specified—will be effectually obtained, and at a very trifling additional cost.

I claim as my invention—

The combination, with the body A and its hemispherical top $a'$ and joint 3, of the band $a''$, provided with the curved inwardly-contracted upper edge, substantially as and for the purpose hereinbefore set forth and described.

JAY W. SMITH.

Witnesses:
BENJ. MORISON,
WM. H. MORISON.