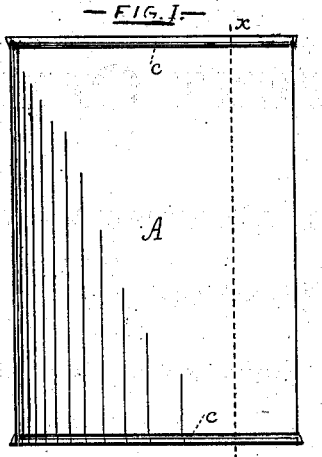
J. W. MILLER & B. COLL.

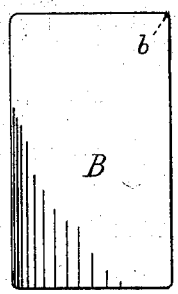
Metal-Can.

No. 198,658. Patented Dec. 25, 1877.

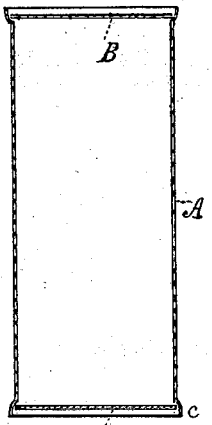
—FIG. I.—



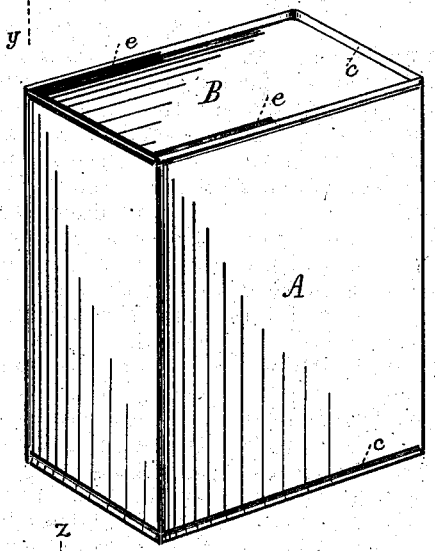
—FIG. VI.—



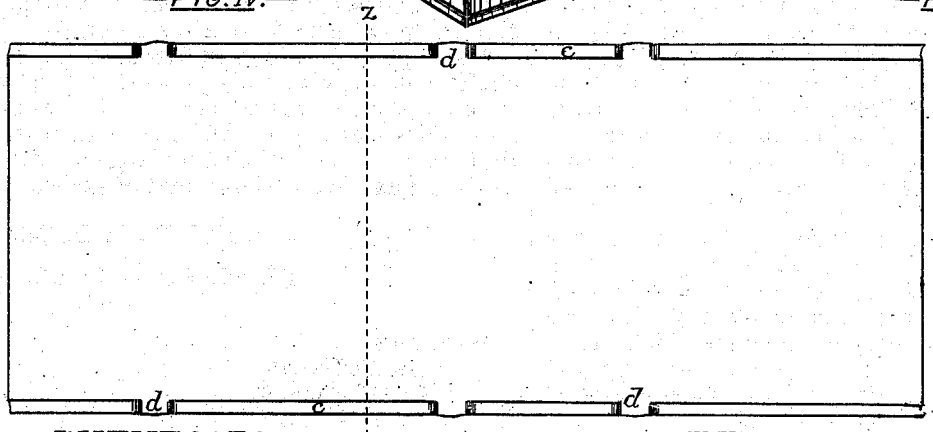
—FIG. II.—



—FIG. III.—



—FIG. IV.—



—FIG. V.—

—WITNESSES:—

Chs. C. Lewis.

Jno R. Speddes

—INVENTORS:—

Joseph W. Miller

Bernard Coll

By their Attorney

Chas. B. Mann

UNITED STATES PATENT OFFICE.

JOSEPH W. MILLER AND BERNARD COLL, OF BALTIMORE, MARYLAND.

IMPROVEMENT IN METAL CANS.

Specification forming part of Letters Patent No. **198,658**, dated December 25, 1877; application filed October 31, 1877.

To all whom it may concern:

Be it known that we, JOSEPH W. MILLER and BERNARD COLL, of Baltimore, in the county of Baltimore and State of Maryland, have invented a new and useful Improvement in Metal Cans, which is fully set forth in the following specification and accompanying drawings, in which—

Figure 1 is a side view of the improved can. Fig. 2 is a section view through *x y*, Fig. 1. Fig. 3 is a perspective view, showing the head partly soldered in. Fig. 4 is a view of the blank from which the body of the can is made. Fig. 5 is a section of same through the line *z z*. Fig. 6 is a view of the head.

Our invention relates to an improvement in that class of square tin cans employed for packing and transporting raw oysters, which usually have V-shaped notches cut at the corners, and the ends bent over on the outside of each head, thus forming flanges, to which the heads are soldered. Defective joints are thus liable to be made at the corners. Our invention overcomes this difficulty, and has other advantages, which will be hereinafter set forth.

Our invention will first be described in connection with the drawing, and then pointed out in claim.

A represents the body of the can; B, the head, the corners *b* of which are clipped off sufficient to permit them to be placed in position. The body is first blanked out, and the flange *c* formed along the edges which are to constitute the ends of the can. At the points where the corners will occur, when the blank is formed into the shape of a square can, the formation of the flanged edge is omitted, as shown at *d*, by which the occurrence of splits in the can-corners is avoided. The can-body is seamed, preferably, at one of the corners, and the heads rest on the seat formed by the flange *c*, and are soldered, as shown at *e*, either by the ordinary soldering-iron or by a gas-jet, the operation of soldering being effected more rapidly and with economy in the use of solder, and with less liability of an imperfect joint, than is attainable by the mode usually employed.

By our formation of can and method of securing the heads the can may be filled after one head has been soldered in, and the top head then placed in position and soldered, thus dispensing entirely with the usual cap, by which an additional saving is effected.

Having described our invention, we claim and desire to secure by Letters Patent—

The improved can herein described, having on the ends the outwardly-projecting flange *c*, stopping short of the corners, forming on the inner sides seats, upon which the heads B rest, the corners of the can being unflanged, the solder being applied as shown and described.

JOSEPH W. MILLER.
his
BERNARD + COLL.
mark.

Witnesses:
CHS. E. LEWIS,
CHAS. B. MANN.