

(No Model.)

C. J. HAUCK, Jr.
OILER.

No. 509,309.

Patented Nov. 21, 1893.

Fig. 1.

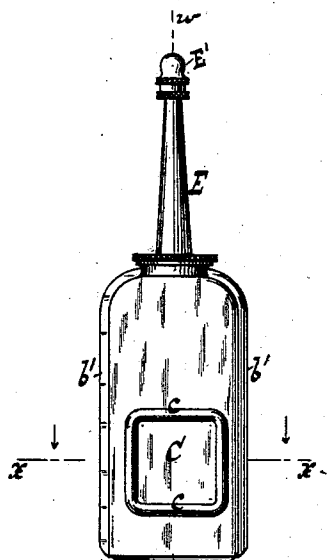


Fig. 2.

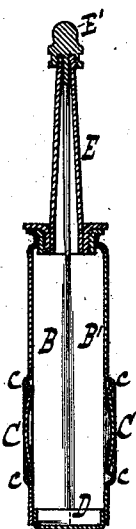


Fig. 3.

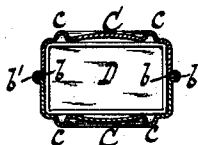


Fig. 7.

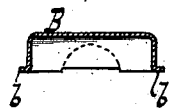


Fig. 8.



Fig. 4.

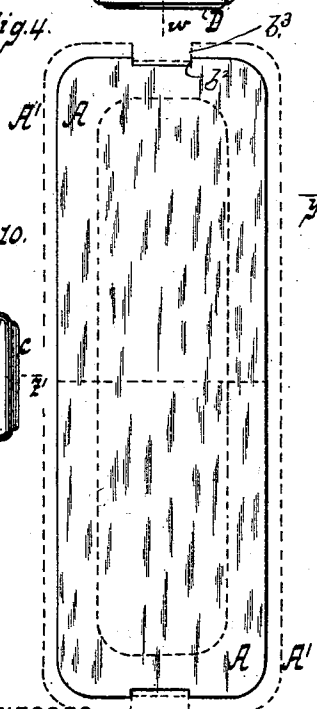


Fig. 5.

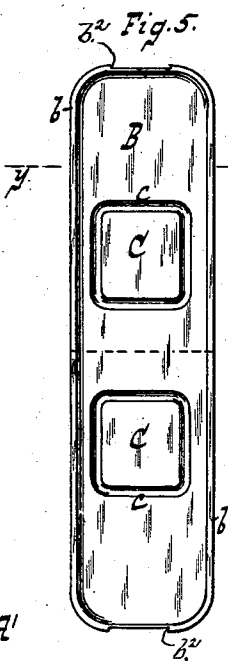


Fig. 6.

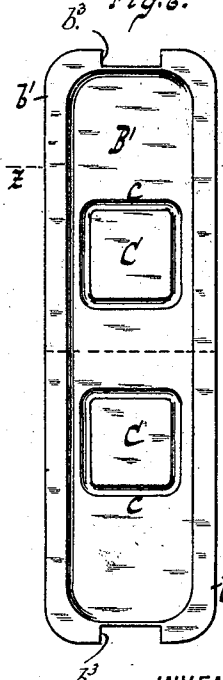


Fig. 9.

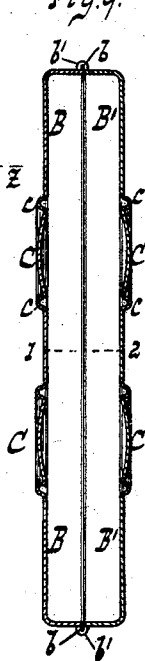
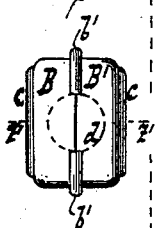


Fig. 10.



WITNESSES:

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OILER.

SPECIFICATION forming part of Letters Patent No. 509,309, dated November 21, 1893.

Application filed August 3, 1892. Serial No. 482,267. (No model.)

To all whom it may concern:

Be it known that I, CHARLES J. HAUCK, JR., a citizen of the United States, residing at Brooklyn, in the county of Kings and State of New York, have invented new and useful Improvements in Oilers, of which the following is a specification.

This invention relates to certain improvements in the manufacture of sheet metal vessels of that class which are provided with one or more elastic sections and are chiefly known as oilers.

The improvements which constitute my invention are pointed out in the following specification and claims and illustrated in the accompanying drawings in which—

Figure 1 is a face view of my oiler. Fig. 2 is a transverse vertical section in the plane *ww* Fig. 1. Fig. 3 is a horizontal section in the plane *xx* Fig. 1. Fig. 4 is a face view showing the blank for one half in full lines and the blank for the other half in dotted lines. Fig. 5 is a top view of the trough shaped portion which is made from the blank shown in Fig. 4 in full lines. Fig. 6 is a top view of the trough shaped portion which is made from the blank shown in Fig. 4 in dotted lines. Fig. 7 is a transverse section in the plane *yy* Fig. 5. Fig. 8 is a transverse section in the plane *zz* Fig. 6. Fig. 9 is a longitudinal section in the plane *z'z'* Fig. 10, showing the two trough shaped portions after they have been united. Fig. 10 is an end view of the same.

In the drawings the letter A designates the blank shown in full lines in Fig. 4 for the trough shaped part B (Figs. 5 and 7) and the letter A' designates the blank (shown in dotted lines in Fig. 4) for the trough shaped part B' (Figs. 6 and 8). The trough shaped part B which is struck up from the blank A is provided with two elastic sections C and with a narrow flange *b*, a portion of which is cut away at the ends as at *b*² and the trough shaped part B' is also provided with two elastic sections C and with a broad flange B' which is also partly cut away at the ends as at *b*³. The elastic sections C are surrounded by beads *c* (Figs. 1, 3 and 9) and they are formed in striking up the blanks for the purpose of forming the trough shaped parts B B'. The trough shaped parts B B' are united

by placing them against each other (Fig. 9) and bending the wide flange *b'* of the part B' over the narrow flange *b* of the part B. The hollow body thus formed is cut through transversely in the line 1—2 (Fig. 9) and thereby two bodies are obtained which are open at one and closed at the opposite end. The open end of each of these bodies is closed by a separate cup-shaped bottom piece D (Fig. 2) which is struck up with an upwardly projecting flange fitting closely into the open end of such body so that after this bottom has been inserted into one of the bodies, it can be readily secured in position by means of solder or otherwise. In the closed end of each of said bodies is then formed an opening *d* indicated in dotted lines in Fig. 10 for the reception of the spout E, which may be provided with a removable and replaceable cup E'. From this description it will be readily understood, that by following my method the manufacture of oilers with two elastic side sections is greatly facilitated. According to the old method of manufacture the bodies of the oilers are made from drawn tubes and the elastic side sections are struck up separate from the bodies of the oiler and attached to the same by soldering. According to my method the elastic side sections are struck up integral with the sides of the oiler so that the labor of securing said elastic sections in position is saved and the oilers when finished are superior in durability and finish. Furthermore by striking up the trough shaped parts B B' of sufficient length for two oilers I am enabled to manufacture my oilers very rapidly, the labor required for forming and inserting the bottoms D being comparatively trifling.

My oilers when finished can be readily distinguished by the beads *b' b'* (Figs. 1 and 10) which extend from the narrow sides of the bottom D up over the sides of the oiler and over its top to the inner end of the spout E. These beads materially increase the durability of my oilers.

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

1. An oiler, consisting of two similar halves B and B' formed integral with the elastic sections C and provided respectively with the flanges *b* and *b'* having cut away end por-

tions b^2 and b^3 , and one of which is engaged with the other, and a bottom piece D inserted between and attached to said similar halves, substantially as described.

- 5 2. An oiler, consisting of two elongated similar halves formed integral with elastic side sections and provided respectively with longitudinal edge flanges b and b' which extend around the ends of the halves and one
10 of which is bent over and engaged with the other, said flanges being cut away to accom-

modate the spout or nozzle of the oiler, and a bottom piece D secured to said similar halves, substantially as described.

In testimony whereof I have hereunto set 15 my hand in the presence of two subscribing witnesses.

CHARLES J. HAUCK, JR.

Witnesses:

WM. C. HAUFF,

E. F. KASTENHUBER.