Oct. 7, 1924. **1,510,552**

M. J. HUBBARD

LABELING MACHINE

Filed Aug. 23, 1923 4 Sheets-Sheet 1

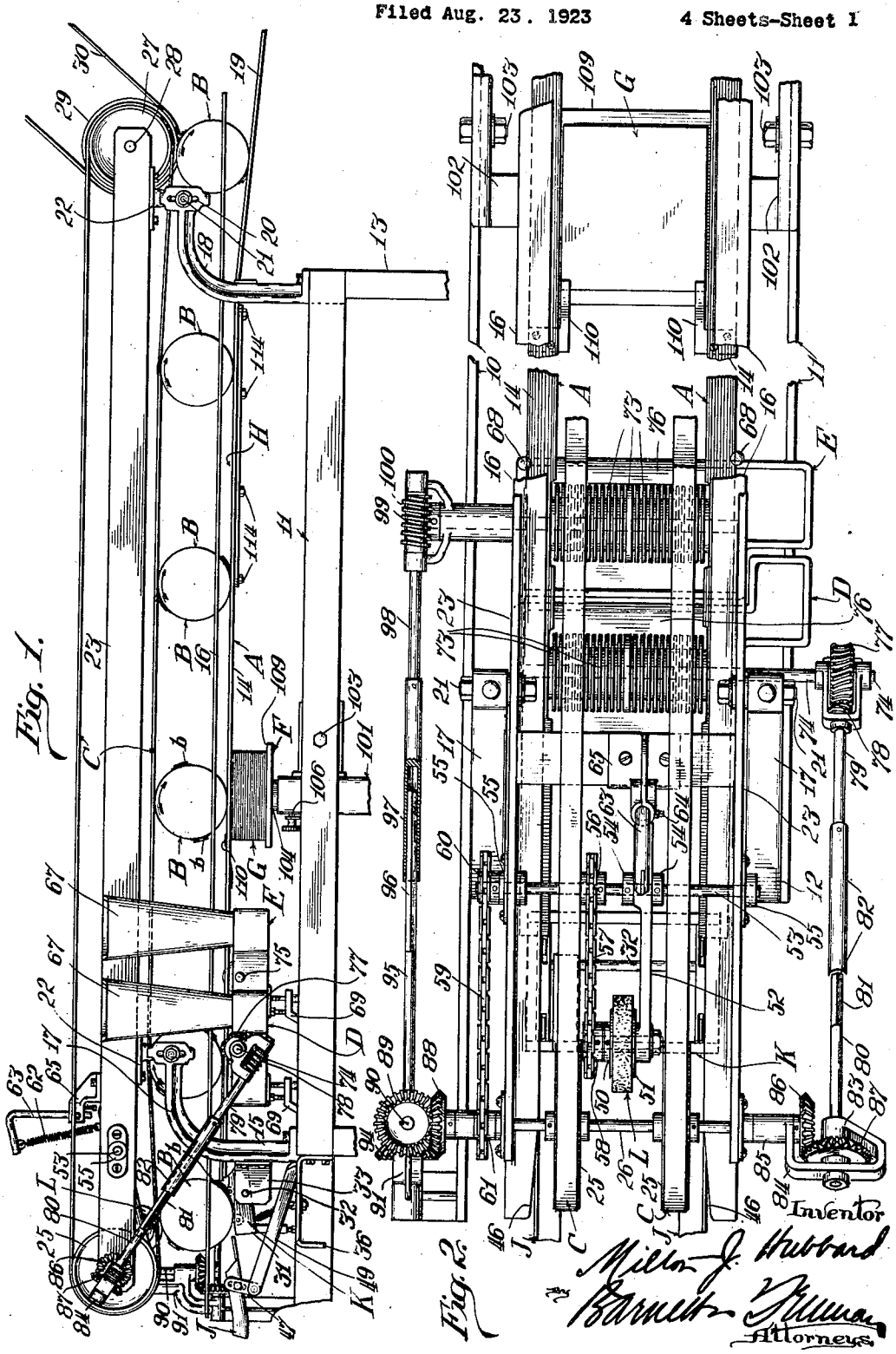


Fig. 1.

Fig. 2.

Inventor
Milton J. Hubbard
Barnett & Gilman
Attorneys

Oct. 7, 1924. 1,510,552

M. J. HUBBARD

LABELING MACHINE

Filed Aug. 23, 1923 4 Sheets-Sheet 2

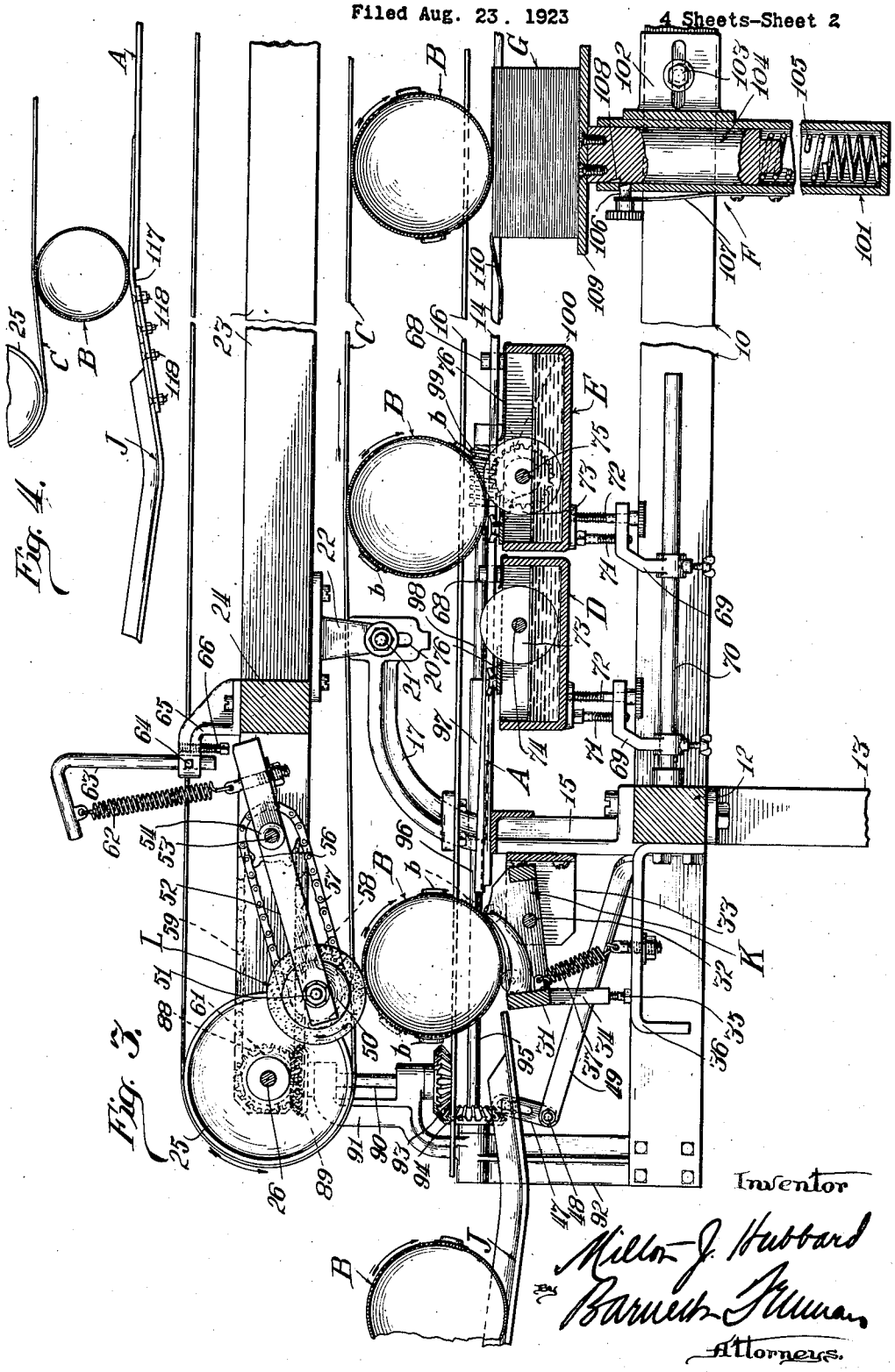


Fig. 4.

Fig. 3.

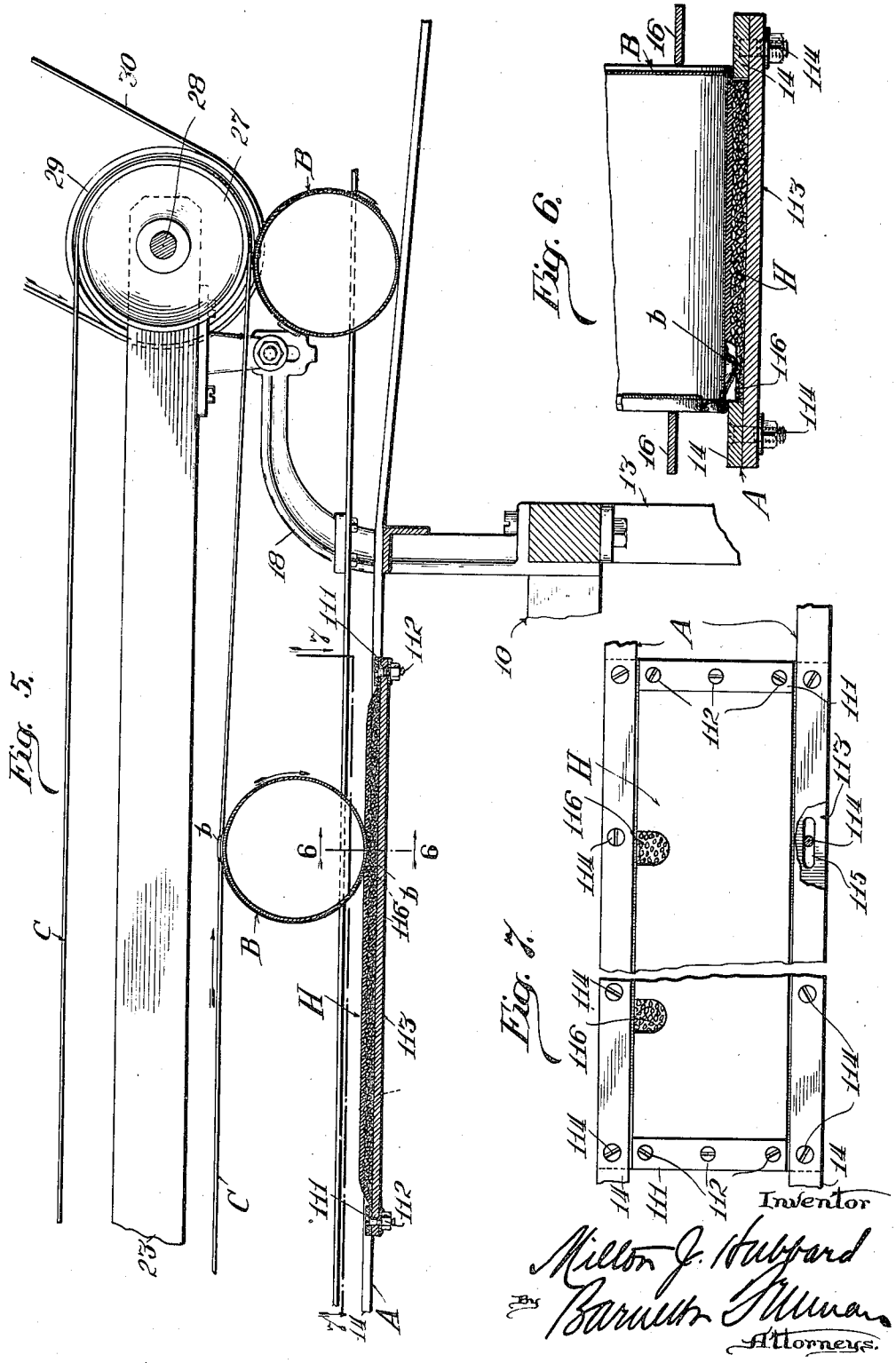
Inventor
Miller J. Hubbard
By Barnett & Fillman
Attorneys.

Oct. 7, 1924. **1,510,552**

M. J. HUBBARD

LABELING MACHINE

Filed Aug. 23, 1923 4 Sheets-Sheet 3



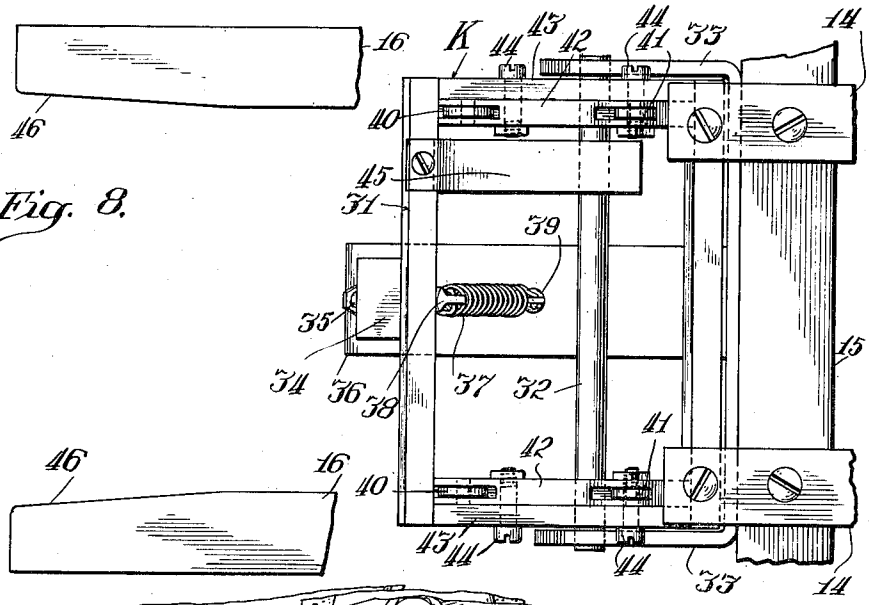
Oct. 7, 1924. 1,510,552

M. J. HUBBARD

LABELING MACHINE

Filed Aug. 23, 1923 4 Sheets-Sheet 4

Fig. 8.



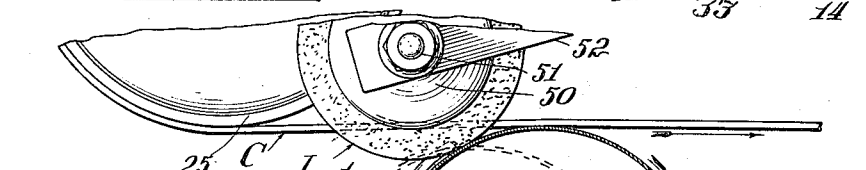
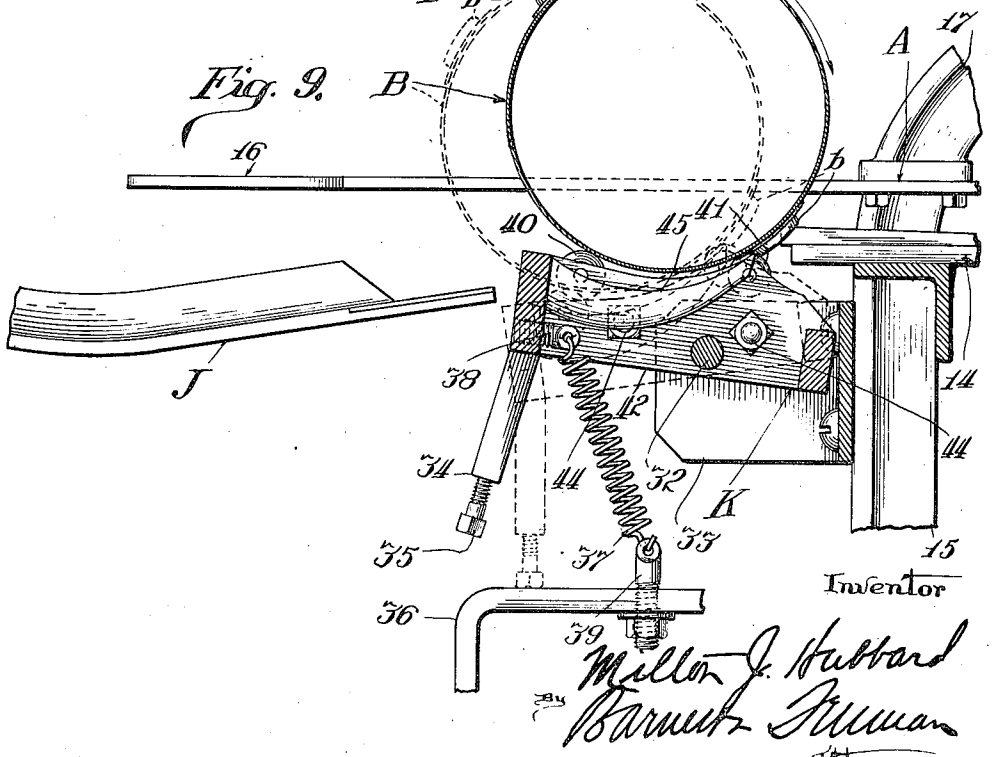


Fig. 9.



Inventor

Milton J. Hubbard

By Barnes & Thurman

Attorneys.

Patented Oct. 7, 1924. 1,510,552

UNITED STATES PATENT OFFICE.

MILTON J. HUBBARD, OF CEDAR RAPIDS, IOWA, ASSIGNOR TO PENICK & FORD, LTD. INCORPORATED, OF CEDAR RAPIDS, IOWA, A CORPORATION OF DELAWARE.

LABELING MACHINE.

Application filed August 23, 1923. Serial No. 658,914.

To all whom it may concern:

Be it known that I, MILTON J. HUBBARD, a citizen of the United States, residing at Cedar Rapids, in the county of Linn and State of Iowa, have invented certain new and useful Improvements in Labeling Machines, of which the following is a specification.

My invention relates to certain improvements in can labeling machines of the type in which the labels are applied to the cans by pasting or gluing while the cans are rolled along a track or runway.

One of the principal objects of the invention is to provide a machine which will label cans of the pail type having projections or "ears" for bails. In labeling pails the label must be placed or "spotted" between the bail ears while with the ordinary can the position of the label circumferentially on the can body is a matter of no importance.

A further object of the invention is to so construct the machine that by certain simple substitutions of detachable parts it may be adapted for labeling ordinary cans without bail ears or cans having ears for bails.

Another object of the invention is to provide new and improved means whereby the paste or glue is first applied to the can body as the latter is moved down the runway, and the can is then caused to move over a stack of labels and pick up one of the labels on the glued surface.

Another object of the invention is to provide means whereby the label, after being applied to the can body, is pressed against the same to insure proper adherence thereto and smooth out wrinkles.

The invention consists in the new and improved constructions, arrangements and devices to be hereinafter described and claimed for carrying out the above stated objects and such other incidental objects as will be referred to in the following description of the preferred embodiment of the invention shown in the accompanying drawings.

In the drawings—

Fig. 1 is a side elevation of the apparatus equipped to handle cans of the pail type.

Fig. 2 is a fragmentary plan view of the front end of the machine, this figure being on a larger scale than Fig. 1.

Fig. 3 is a fragmentary, longitudinal, sectional view of the front end of the machine.

Fig. 4 is a fragmentary elevation, diagrammatic in character, illustrating the adaptation of the machine for handling cans of ordinary type without bail ears.

Fig. 5 is a fragmentary, longitudinal, sectional elevation of the rear end of the machine.

Fig. 6 is a cross sectional view on line 6—6 of Fig. 5 with the scale enlarged.

Fig. 7 is a fragmentary plan view of the resilient pressing pad.

Fig. 8 is a fragmentary sectional plan illustrating the can cradle shown in Figs. 1 and 3, and

Fig. 9 is a longitudinal sectional view of the cradle and associated parts showing the same tilted to deliver the can on the runway.

I will first describe the machine equipped for spot labeling cans having bail ears and thereafter the means for adapting the machine for labeling cans of the ordinary type without ears. Certain of the improvements constituting the invention are adapted to machines for performing the latter operation as well as to machines for spot labeling cans having ears.

Machines have been in use for labeling cans without ears while the cans are rolled over a runway, the handling of the cans in such machines being automatic throughout. For labeling cans having bail ears semi-automatic machines have been used involving a vertically movable table on which the cans are placed, one by one, by hand and removed in the same way, the cans being centered in order to properly locate the labels by positioning the ears between vertical guides. The labeling operation, in a machine of this type, is relatively slow and ordinarily has to be performed on the cans before they are filled, especially if the cans are filled with a liquid hot enough to make the placing of the cans on the table and their removal therefrom inconvenient.

One of the principal objects of my invention is to improve the automatic type of labeling machine heretofore used for cans without ears—the type of machine, that is, which pastes the labels on the cans while the cans are rolled over a runway—so that the machine will be capable of spot labeling cans with bail ears, thereby making it possible to label cans of this type after the cans have been filled, with a hot liquid, for

example, and at a higher rate of speed than has been heretofore possible and by operations which are wholly automatic.

Referring first to Fig. 1 of the drawings, A designates a runway over which the cans B are rolled by means of a pair of endless belts C, C. D, E are glue applying devices located under the runway for applying glue to the cans, F a labeling device supporting a pile of labels G which are picked up one by one as the cans are rolled along this part of the runway, and H is a resilient pad over which the cans are rolled, after being labeled, for the purpose of smoothing the labels and insuring their adherence to the cans. J is a feed track over which the cans are fed by gravity into the labeling machine. K is a tilting cradle at the entrance of runway A adapted to receive the cans, one by one, and L is a roller for rotating the can in the cradle until one of its ears *b* comes into contact with a stop finger on the cradle whereupon the cradle is tilted and the can delivered to runway A with its ears in such angular position that when the can is rolled by belts C first over the gluing devices and then over the label stack the glue and the label will be applied in the proper position on the can body between the ears.

The apparatus is supported upon a pair of longitudinal frame members 10, 11 (Fig. 2) connected by suitable cross pieces, one of which is indicated at 12 (Fig. 3), and supported on legs 13. The runway strips 14, 14 are carried on uprights supported by the frame cross pieces, one of these uprights being shown at 15 (Fig. 3). The runway comprises also guide strips 16 which are fastened to brackets 17, 18 for supporting the frame which carries the endless belts C. The runway strips 14 have downwardly inclined portions 19 at the rear or delivery end of the machine.

The brackets 17, 18 are slotted, as indicated at 20, for bolts 21 by means of which castings 22 on the under side of the belt supporting frame members 23 are adjustably connected to the brackets. The belt supporting frame comprises additionally cross members, one of which is indicated at 24 (Fig. 3). The belts C extend around a pair of pulleys 25 on a shaft 26 journaled in the frame members 23 at the head end of the machine, and around a similar pair of pulleys 27 on a drive shaft 28 journaled in the frame members 23 at the discharge end of the machine, shaft 28 being provided with a driving pulley 29 for a driving belt 30 (Figs. 1 and 5). The cradle K consists of a rectangular frame 31 pivoted on a rod 32 which is fixed between brackets 33 on the supporting member 15 The cradle is provided with a stop finger 34 provided at the bottom with an adjustable stop screw 35 adapted to bear upon a bracket 36 fixed to the cross piece 12 of the main frame. A coiled tension spring 37 extends between a lug 38 on the cradle and a stud 39 on bracket 36. The cradle is provided on opposite sides with pairs of rollers 40, 41 which are mounted in slotted roller carriers 42 secured to the side members 43 of the cradle frame 31 by bolts 44. At one side of the frame is a curved, upwardly projecting stop finger 45 arranged so that as a can is rotated in the cradle one of its ears *b* is brought to bear against the inner and upper end of the stop finger.

The guide members 16 project over and beyond the cradle, as indicated in Fig. 8, and are tapered, as indicated at 46, so as to guide the cans from the feeding track F into the cradle. The end of the feeding track J is adjustably supported by a slotted link 47 clamped by bolt 48 to a bracket 49 secured to the cross piece 12 (Fig. 3).

The roller L, for rotating the cans in the cradle, is secured to a sleeve 50 which turns on a stub shaft 51 fixed to an arm 52 held loosely on a shaft 53 between collars 54 fixed to the shaft, the shaft turning in bearings 55 on the belt frame members 23. Fixed to shaft 53 is a sprocket wheel 56 around which extends a chain 57 which engages a sprocket wheel 58 on the sleeve 50. Shaft 53 is driven by a chain 59 extending over sprockets 60 and 61 on shafts 53 and 26 respectively. A tension spring 62 is fastened to the lever 52 and to the forwardly projecting end of a bent rod 63 clamped adjustably by bolt 64 to a bracket 65 on the cross member 24 of the belt frame. 66 is an adjustable stop screw for the end of arm 52. The glue receptacles D and E are arranged under the runway and are provided with upstanding feeding founts 67. Each of these receptacles is provided with a clip 68 which hooks over the edge of one of the runway strips 14, the other end of the receptacle being supported by a bracket 69 adjustable longitudinally on a rod 70 secured to the cross piece 12 of the main frame, the receptacle being engaged by two set screws 71, 72 arranged so that the receptacle may be leveled. Arranged within each receptacle is a glue applying roller consisting of a plurality of spaced discs 73 on a revoluble shaft, 74 designating the roller shaft in receptacle D and 75 the shaft in receptacle E. The discs project through removable cover plates 76 to points somewhat above the level of the runway strips 14.

Shaft 74 is driven from shaft 26 by the following mechanism: 77 is a worm pinion on shaft 74 meshed by a worm 78 on one member 79 of a two-part telescopic shaft, the other member 80 of which has a portion 81 square in cross section which projects into a correspondingly formed socket 82 on the

shaft section 79. Shaft section 80 turns in a bearing 83 on a bracket 84 having a hub 85 loosely supported on shaft 26. The end of shaft 26 has fixed thereto a bevel gear 86 meshing with a bevel gear 87 on the shaft section 80.

The shaft 75 to which the glue applying discs in receptacle E are fixed, is driven from the other end of shaft 26 by the following mechanism: 88 is a beveled gear on shaft 26 meshing with a bevel gear 89 on a shaft 90 rotating in bearings in a bracket 91 carried on an upright support 92 secured to the end of the main frame member 10. On the lower end of shaft 90 is a bevel gear 93 meshing with a bevel gear 94 on one section 95 of a telescopic shaft which has a portion 96 square in cross section adapted to be slidingly engaged by a socket member 97 on shaft section 98 carrying a worm 99 which meshes with a worm gear 100 on shaft 75.

The device F for supporting the labels G may be of any desired construction. I have shown in the drawings a simple form of device constructed as follows: 101 is a cylinder provided with slotted brackets 102 for adjustably engaging the frame members 10, 11, screws 103 securing the device in the set position. 104 is a plunger arranged in cylinder 101 on a coiled spring 105. The cylinder is perforated for a latch 106 on spring 107 secured to the side of the cylinder, the latch being adapted to engage a notch 108 in the side of the plunger when the device is being loaded. Secured to the top of the plunger is a table 109 for a stack of the labels G. Springs 110 on the runway strips 14 bear upon the forward edge of the stack of labels.

The pressing and smoothing pad H is composed preferably of some resilient material such as sponge rubber which is secured by binding strips 111 and bolts 112 to a metal plate 113 which is fastened by bolts 114 to the runway strips 14, the plate being slotted, as indicated at 115, for the bolts. The pad H is formed on one side with recesses 116 properly spaced to receive the ears *b* of the cans.

Summary of operation: The cans B are moved by gravity, for example, along the feed track J and enter, one by one, the cradle K. As a can enters the cradle it is rotated by roller L in the direction indicated by the adjacent arrow in Fig. 3 until one of the ears *b* is brought to bear against the end of stop finger 45. The can is supported on rollers 40, 41 so that it turns freely in the cradle. When the ear *b* comes into contact with the stop finger the end of the cradle adjacent the runway A tilts downwardly, the other end tilting upwardly, so that roller L forces the can into the runway. It is now engaged by belt C and is rolled along the runway between the guiding strips 16, the ears *b* revolving in the space between the runway strips 14 quite close to one of these strips. The can, in moving down the runway, is obliged to roll in succession over the glue applying rollers in receptacles D and E, the glue receptacles being so positioned that glue is applied to the can body in two places adjacent or symmetrical with respect to the bail ears, respectively. The adjustability of the glue applying devices toward and away from each other adapts the machine for labels of different widths, measured on the circumference of the can. The gluing rollers are rotated constantly from shaft 26 which is driven by belt C and the latter by driving belt 30. The glue is brought up to the surface of the can from the receptacles on the edges of discs 73 and in the spaces between the discs.

The can is then rolled over the stack of labels G and during this operation picks up a label which is glued to the can at its opposite edges. The can is then rolled over the pad H so as to smooth out any wrinkles there may be in the label and press the glued portions of the labels against the can. The can is then discharged from the machine over the inclined portion 19 of the runway.

To adapt the machine for cans without bail ears the cradle K is removed and the arm 52 recessed so as to lift roller L out of the path of the cans. The lever 52 may be held in the raised position by proper adjustment of rod 63. An extension piece 117 (Fig. 4) is secured by bolts 118 to the end of feed track J, this extension piece reaching to the runway A. The cans from the feed track J will pass over the extension 117 and be engaged directly by the belt C.

While the machine has been described and will be claimed as a can labeling machine, it is obvious that it might be employed for labeling any cylindrical receptacle or body and the claims are to be so interpreted. While the invention has been shown and described in a preferred embodiment, I intend to cover by patent all modifications within the scope of the appended claims.

I claim:

1. In a machine for labeling cans having projections on their cylindrical surfaces, the combination of a runway, means for moving the cans along said runway, label applying means arranged to apply labels to the cans as the latter are moved along the runway, a cradle at the entrance of the runway to receive the cans successively provided with a stop adapted to be engaged by the projections on the cans, and means for rotating the cans in the cradle.

2. In a machine for labeling cans having projections on their cylindrical surfaces, the combination of a runway, means for moving the cans along said runway, label applying

means arranged to apply labels to the cans as the latter are moved along the runway, a cradle at the entrance of the runway to receive the cans successively provided with can supporting rollers and with a stop adapted to be engaged by the projections on said cans, and means for rotating the cans in the cradle.

3. In a machine for labeling cans having projections on their cylindrical surfaces, the combination of a runway, means for moving the cans along said runway, label applying means arranged to apply labels to the cans as the latter are moved along the runway, a tilting cradle at the entrance of the runway to receive the cans successively, provided with a stop to be engaged by the projections on the cans, and means for rotating said cans in the cradle and for tilting the cradle to deliver the cans to the runway.

4. In a machine for labeling cans having projections on their cylindrical surfaces, the combination of a runway, a belt for rolling the cans along the runway, label applying means for applying labels to the cans as they are run along the runway, a cradle at the entrance of the runway having a stop adapted to be engaged by the projections on the cans, a roller to bear on the cans, and means for revolving the rollers so as to rotate the cans in the cradle.

5. In a machine for labeling cans having projections on their cylindrical surfaces, the combination of a runway, a belt for rolling the cans along the runway, label applying means for applying labels to the cans as they are run along the runway, a cradle at the entrance of the runway having a stop adapted to be engaged by the projections on the cans, a spring pressed roller to bear on the cans, and means for revolving the rollers so as to rotate the cans in the cradle.

6. In a machine for labeling cans having projections on their cylindrical surfaces, the combination of a runway, a belt for rolling the cans along the runway, label applying means for applying labels to the cans as they are run along the runway, a cradle at the entrance of the runway having a stop adapted to be engaged by the projections on the cans, a roller to bear on said cans, a pivoted arm carrying said roller, means for driving the roller, and a spring associated with said arm tending to force the roller against the cans.

7. In a machine for labeling cans having projections on their cylindrical surfaces, the combination of a runway, a belt for rolling the cans along the runway, label applying means for applying labels to the cans as they are run along the runway, a cradle at the entrance of the runway having a stop adapted to be engaged by the projections on the cans, a roller to bear on said cans, a pivoted arm carrying said roller, means for driving the roller, a spring associated with said arm tending to force the roller against the cans, and a stop for limiting the downward movement of the lever and roller.

8. In a machine for labeling cans having projections on their cylindrical surfaces, the combination of a runway, a belt for rolling the cans along the runway, label applying means for applying labels to the cans as they are run along the runway, a cradle at the entrance of the runway having a stop adapted to be engaged by the projections on the cans, a roller to bear on said cans, a pivoted arm carrying said roller, means for driving the roller, a spring associated with said arm tending to force the roller against the cans, and means for adjusting the tension of said spring.

9. In a machine for labeling cans having projections on their cylindrical surfaces, the combination of a runway, means for moving the cans along said runway, label applying means arranged to apply labels to the cans as the latter are moved along the runway, a cradle at the entrance of the runway to receive the cans successively, adapted to be tilted downwardly toward the runway and provided with a stop to be engaged by the projections on the cans, and means for rotating the cans in the cradle and tilting the cradle to deliver the cans to the runway.

10. In a machine for labeling cans having projections on their cylindrical surfaces, the combination of a runway, means for moving the cans along said runway, label applying means arranged to apply labels to the cans as the latter are moved along the runway, a cradle at the entrance of the runway to receive the cans successively, adapted to be tilted downwardly toward the runway and provided with a stop to be engaged by the projections on the cans, a roller for rotating the cans in the cradle and tilting the cradle to deliver the cans to the runway, and a yielding support for the roller.

11. In a machine for labeling cans having projections on their cylindrical surfaces, the combination of a runway, means for moving the cans along said runway, label applying means arranged to apply labels to the cans as the latter are moved along the runway, a cradle at the entrance of the runway to receive the cans successively, adapted to be tilted downwardly toward the runway and provided with a stop to be engaged by the projections on the cans, a roller for rotating the cans in the cradle and tilting the cradle to deliver the cans to the runway, a pivoted arm carrying the roller, and a spring which tends to press the roller against the cans.

12. In a machine for labeling cans hav-

ing projections on their cylindrical surfaces, the combination of a runway, a pair of endless belts for rolling the cans along said runway, label applying means arranged to apply labels to the cans as the latter are moved along the runway, and a cradle at the entrance of the runway to receive the cans successively, provided with a stop to be engaged by the projections on the cans, and a roller arranged between said belts for rotating the cans in the cradle.

13. In a machine for labeling cans having projections on their cylindrical surfaces, the combination of a runway, a pair of endless belts for rolling the cans along said runway, label applying means arranged to apply labels to the cans as the latter are moved along the runway, a cradle at the entrance of the runway to receive the cans successively, provided with a stop to be engaged by the projections on the cans, and a roller on a pivoted arm arranged between said belts for rotating the cans in the cradle.

14. In a machine for labeling cans provided with bail ears, the combination of a runway, means for rolling cans along said runway, a glue applying device located on the runway for applying glue to the cans, a label applying device located on the runway for applying labels to the glued surfaces of the cans, a cradle at the entrance of the runway to receive the cans successively, said cradle having a stop, and means for rotating the cans in said cradle until said ears engage said stop.

15. In a machine for labeling cans provided with bail ears, the combination of a runway, means for rolling cans along said runway, a glue applying device located on the runway for applying glue to the cans, a label applying device located on the runway for applying labels to the glued surfaces of the cans, a cradle at the entrance of the runway to receive the cans successively, said cradle having a stop, a roller for rotating the cans in the cradle, and a yielding arm carrying said roller.

16. In a machine for labeling cans having bail ears, the combination of a runway, means for applying labels to the cans as the cans move along the runway, a pair of belts for forwarding the cans through the runway, shafts at each end of said machine, pulleys on said shafts for said belts, means for driving one of said shafts, a tilting cradle at the entrance of the runway having a stop, an arm pivoted between said belts, a roller on said arm to bear against and rotate the cans until the ears engage said stop, and means for driving said roller from one of said shafts.

17. In a machine for labeling cans having bail ears, the combination of a runway, means for applying labels to the cans as the cans move along the runway, a pair of belts for forwarding the cans through the runway, shafts at each end of said machine, pulleys on said shafts for said belts, means for driving one of said shafts, a tilting cradle at the entrance of the runway having a stop, an arm pivoted between said belts, a roller on said arm to bear against and rotate the cans until the ears engage said stop, means for driving said roller from one of said shafts, and a spring which tends to press said roller against the cans.

18. In a machine for labeling cans having bail ears, the combination of a runway, means for applying labels to the cans as the cans move along the runway, a pair of belts for forwarding the cans through the runway, shafts at each end of said machine, pulleys on said shafts for said belts, means for driving one of said shafts, a tilting cradle at the entrance of the runway having a stop, an arm pivoted between said belts, a roller on said arm to bear against and rotate the cans until the ears engage said stop, means for driving said roller from one of said shafts, and a spring which tends to hold down the end of the cradle remote from the runway.

19. In a machine for labeling cans having bail ears, the combination of a runway, means for applying labels to the cans as the cans move along the runway, a pair of belts for forwarding the cans through the runway, shafts at each end of said machine, pulleys on said shafts for said belts, means for driving one of said shafts, a tilting cradle at the entrance of the runway having a stop, an arm pivoted between said belts, a roller on said arm to bear against and rotate the cans until the ears engage said stop, means for driving said roller from one of said shafts, a spring which tends to hold down the end of the cradle remote from the runway, and a spring which tends to force said roller against the cans.

20. In a machine for labeling cans having bail ears, the combination of a runway, a pair of belts for forwarding the cans along the runway, a cradle which rocks forwardly and downwardly at the entrance of the runway having a stop projection against which the ears of the cans are moved by rotation of the can in the cradle, a lever pivoted between said belts provided with a roller to bear against the cans in the cradle, means for driving said roller so as to rotate the cans in the cradle and deliver the same to said runway, a glue applying device positioned on said runway, and a label applying device on the runway at a point beyond the glue applying device.

21. In a machine for labeling cans having bail ears, the combination of a runway, a pair of belts for forwarding the cans along the runway, a cradle which rocks forwardly

and downwardly at the entrance of the runway having a stop projection against which the ears of the cans are moved by rotation of the can in the cradle, a lever pivoted between said belts provided with a roller to bear against the cans in the cradle, means for driving said roller so as to rotate the cans in the cradle and deliver the same to said runway, a glue applying device positioned on said runway, a label applying device on the runway at a point beyond the glue applying device, and a resilient pad over which the labeled cans are rolled to press the labels against the cans.

22. In a machine for labeling cans having bail ears, the combination of a runway, a pair of belts for forwarding the cans along the runway, a cradle which rocks forwardly and downwardly at the entrance of the runway having a stop projection against which the ears of the cans are moved by rotation of the can in the cradle, a lever pivoted between said belts provided with a roller to bear against the cans in the cradle, means for driving said roller so as to rotate the cans in the cradle and deliver the same to said runway, a glue applying device positioned on said runway, a label applying device on the runway at a point beyond the glue applying device, and a resilient pad over which the labeled cans are rolled to press the labels against the cans, said pad being provided with recesses for said cars.

23. In a machine for labeling cans having bail ears, the combination of a runway, a pair of belts for forwarding the cans along the runway, a cradle which rocks forwardly and downwardly at the entrance of the runway having a stop projection against which the ears of the cans are moved by rotation of the cans in the cradle, a lever pivoted between said belts provided with a roller to bear against the cans in the cradle, means for driving said roller so as to rotate the cans in the cradle and deliver the same to said runway, a glue applying device, comprising two rollers for applying glue in spaced strips to the can bodies, positioned on said runway, a label applying device on the runway at a point beyond the glue applying device, and a resilient pad over which the labeled cans are rolled to press the labels against the cans, said pad being provided with recesses for said ears.

24. In a machine for labeling cans having bail ears, the combination of a runway, a pair of belts for forwarding the cans along the runway, a cradle which rocks forwardly and downwardly at the entrance of the runway having a stop projection against which the ears of the cans are moved by rotation of the cans in the cradle, a lever pivoted between said belts provided with a roller to bear against the cans in the cradle, means for driving said roller so as to rotate the cans in the cradle and deliver the same to said runway, a glue applying device, comprising two rollers for applying glue in spaced strips to the can bodies, positioned on said runway, a label applying device on the runway at a point beyond the glue applying device, a resilient pad over which the labeled cans are rolled to press the labels against the cans, said pad being provided with recesses for said ears, means for adjusting said rollers to and from each other, and means for adjusting the position of the labeling device on the runway.

25. In a machine for labeling cans having bail ears, the combination of a runway, a pair of belts for forwarding the cans along the runway, a cradle which rocks forwardly and downwardly at the entrance of the runway having a stop projection against which the ears of the cans are moved by rotation of the cans in the cradle, a lever pivoted between said belts provided with a roller to bear against the cans in the cradle, means for driving said roller so as to rotate the cans in the cradle and deliver the same to said runway, a glue applying device comprising two rollers each of which consists of separate spaced discs for applying glue to the can bodies at two places thereon, and a label applying device on the runway at a point beyond the glue applying device.

MILTON J. HUBBARD