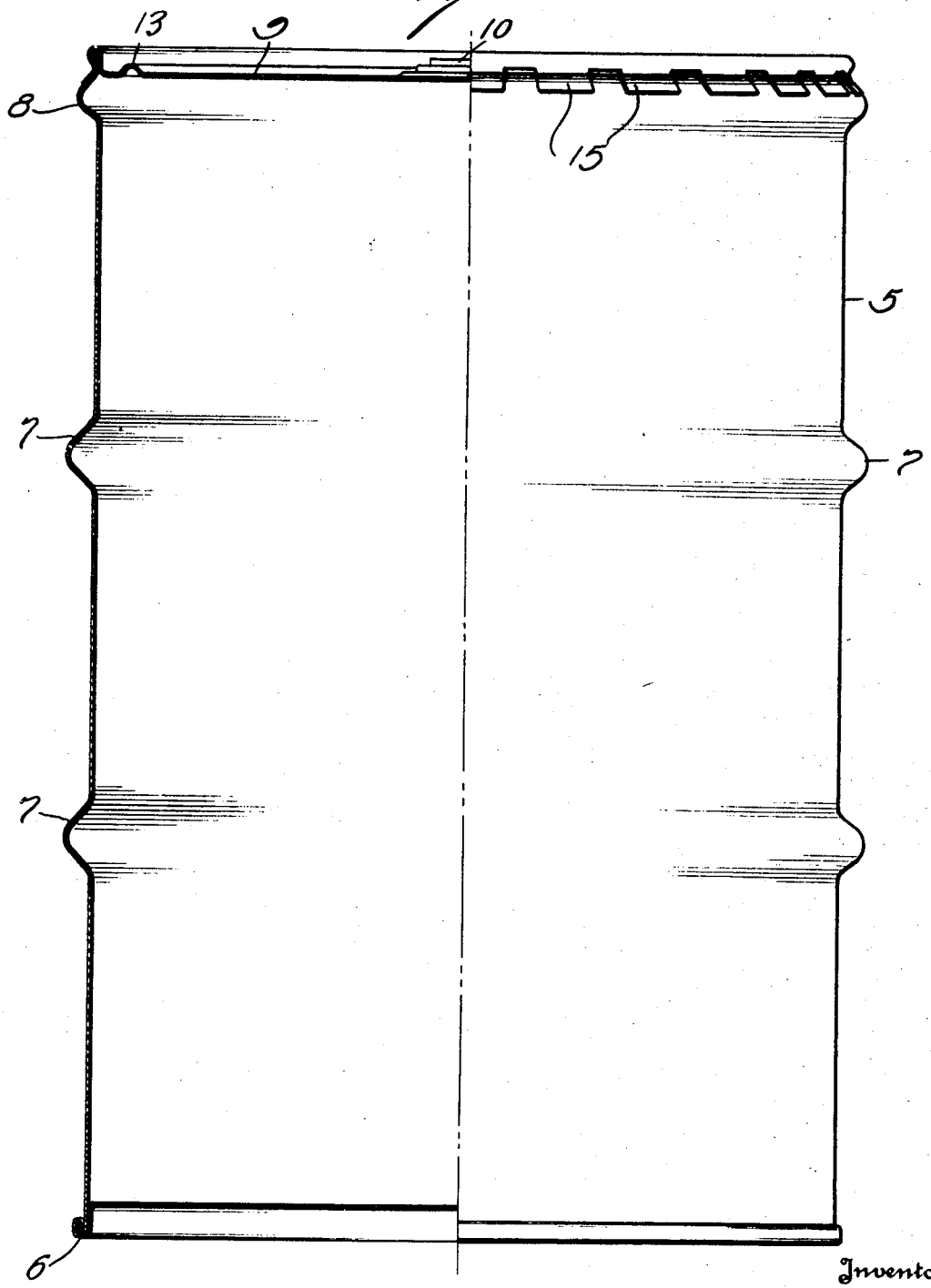
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METHOD OF MAKING SHIPPING DRUMS

Filed March 22, 1929 2 Sheets-Sheet 1

Fig. 1.



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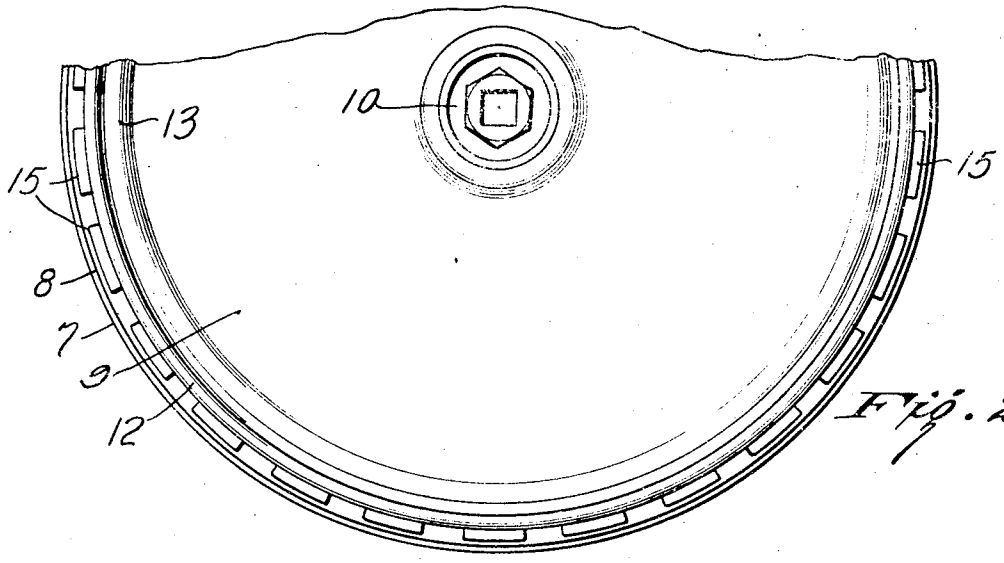


Fig. 2.

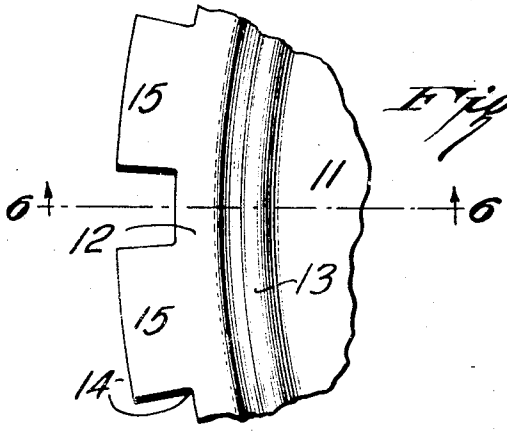


Fig. 5.

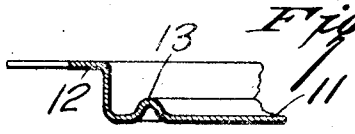


Fig. 6.

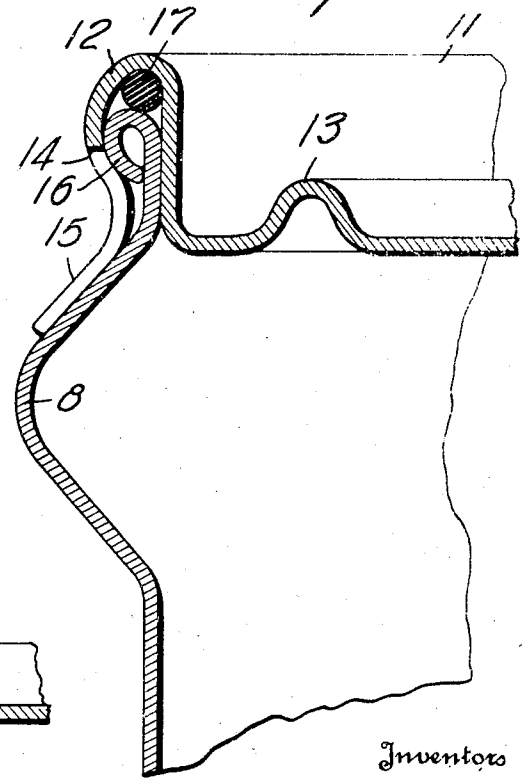


Fig. 3.

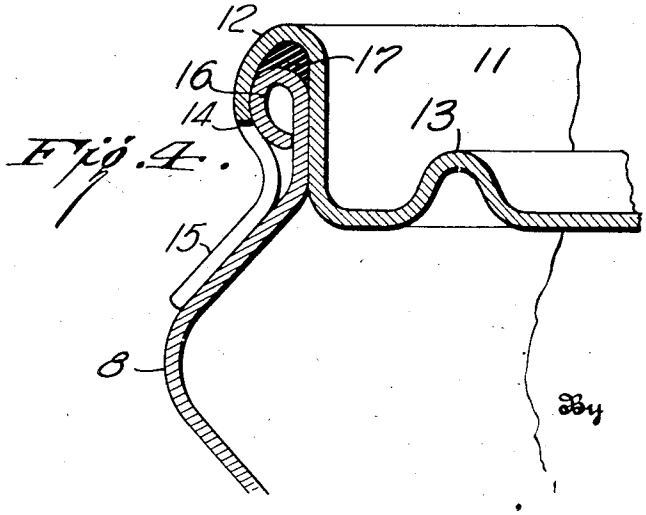


Fig. 4.

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UNITED STATES PATENT OFFICE

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METHOD OF MAKING SHIPPING DRUMS

Edgar E. Shanor and Carl W. Mardersteck, Sharon, Pa., assignors to The Petroleum Iron Works Company, Sharon, Pa., a corporation of Ohio

Application March 22, 1929, Serial No. 349,177

1 Claim. (Cl. 113—121)

The invention relates to drums mainly intended for the storage and shipment of vaseline and other greases and of the type in which the grease is poured hot into the drum through an opening in the head and is removed when required in a more or less solid or jelly form by detachment of the head.

Objects of the invention are to provide for applying both permanent and removable heads simultaneously thereby saving the cost of independent heading operations; to provide a removable head which will stand abuse and rough handling about as well as the double seamed bottom; to provide a removable head which will leave an opening the full diameter of the drum or shell; to provide a head capable of ready removal under authorized circumstances and which can be used over and over again and which will serve as a tell-tale of tampering or unauthorized attempts at removal; and to provide a drum or shell definitely reinforced or strengthened in consonance with the improved head.

With such and other objects in view, the nature, characteristic features and scope of the invention will more readily be understood from the following description taken in connection with the accompanying drawings, forming a part hereof, wherein

Figure 1 is a sectional-elevational view of the improved drum.

Fig. 2 is a top view.

Fig. 3 is a sectional detail, showing the relation of the parts with the head in place, but before the application of pressure to flatten the gasket and complete the sealing.

Fig. 4 is a similar view with the parts in sealed relation.

Fig. 5 is a sectional detail of the lipped periphery of the head.

Fig. 6 is a section on line 6—6 of Fig. 5.

According to the present improvements the drum body or shell 5 may have the double seamed bottom head or closure 6 and strengthening beads 7, as usual. Departing from the usual practice, there is provided at the top of the drum an additional external bead 8, which not only insures greater strength, but also cooperates in the seating and sealing of the improved head 9. It will be observed that the beaded top of the drum does not infringe upon the confines thereof so that when the head 9 is removed it leaves an opening the full diameter of the drum.

Head 9 has the usual plugged filling opening 10 and comprises a dish section 11 for telescopic fit in the beaded end of the drum and a marginal rim or flange 12 to be secured externally of said end. The dish section 11 is formed in proximity with its riser with a raised rib or bead 13 to impart rigidity and strength.

The marginal lip or flange 12 is recessed at spaced intervals, as at 14, to provide resilient tongues 15, the arrangement being such that there is no severance of metal beyond the limits of the beaded end of the drum such as would militate against the eventual proper sealing thereof. Otherwise stated the recesses 13 stop short of the top of the drum, the end of which is rolled or curled as at 16. A gasket 17 introduced between the rolled end 16 and the marginal lip of the head 9 completes the assembly.

It will be apparent to those skilled in the art that with the described construction and arrangement of parts, the open head problem is simplified and fluid tight heading of both ends of the drum can be effected at one operation. Under such operation, which might be with the conventional double seaming rolls, the bottom head is affixed in the usual or under any approved practice, and double seaming rolls are availed of to bend the tongues 15 against the upper flare of the terminal stiffening rib. It may here be remarked that said upper flare is not only useful in the heading operation, but that it also facilitates the use of a special tool for lifting the tongues in the authorized removal of the head. Before the tongue bending operation, the gasket 17 having been introduced between the rolled margin of the drum and the head, is subjected to pressure, such as pressure applied between the chuck of the machine and the head, for the purpose and with the result of altering its cross-section from that indicated in Fig. 3 to substantially that indicated in Fig. 4, or in short to put it in condition for vacuum sealing.

Having described our invention, we claim:

Method of inserting concurrently the permanent and removable heads of a drum, which consists in providing a drum body having a series of stiffening ribs whereof one is a terminal rib which is offset from the body and constitutes an abutment for a metal working operation, providing permanent and removable heads for the body, the removable head having a stiffening rib to resist excess flexure when acted upon by heading instrumentalities and having a sealing rim with spaced lugs, double seaming the permanent head to the body, and concurrently forcing the spaced lugs of the sealing rim into engaging relation with the abutment.

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