

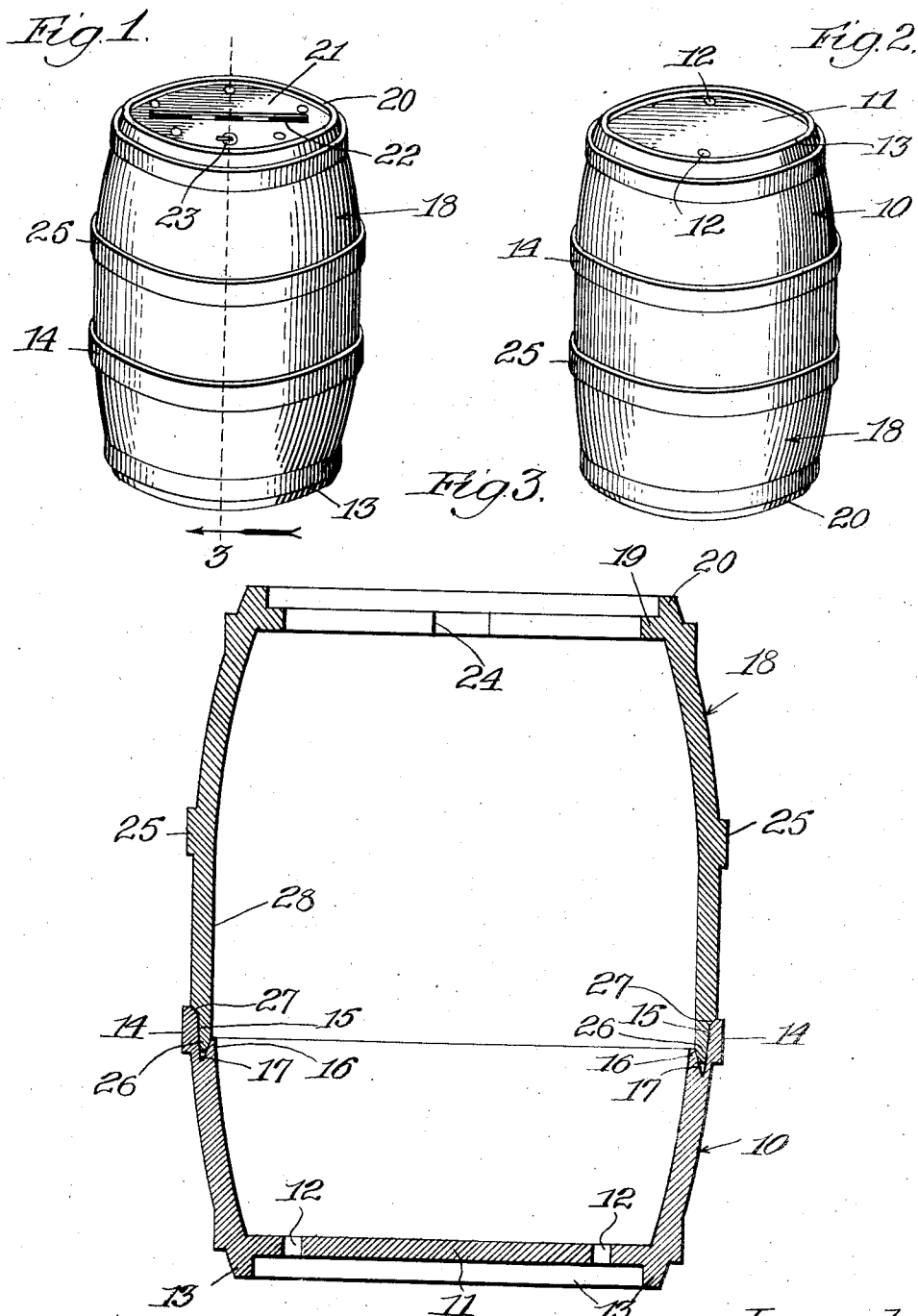
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E. A. ANDERSON

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MOLDED BARREL-SHAPED CONTAINER

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Inventor.
Edward A. Anderson,
By Christon Wiles, Davies, Kersch & Dawson,
Attys.

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MOLDED BARREL-SHAPED CONTAINER

Edward A. Anderson, Chicago, Ill.

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4 Claims. (Cl. 217-72)

This invention relates to a molded barrel container and to the method of forming the same. It will be understood that the method is applicable to other uses.

An object of the invention is to provide a barrel container of molded material without visible seams. A further object is to provide a molded barrel container of simple structure which may be readily formed and with parts thereof joined in integral structure with ribs protecting the joint. A further object is to provide a simple and effective method whereby a molded barrel may be formed on relatively simple dies, the portions of the barrel formed on the dies being readily joined to form an integral construction. Other specific objects and advantages will appear as the specification proceeds.

The invention is illustrated in a preferred embodiment, by the accompanying drawing, in which—

Figure 1 is a perspective view of a barrel embodying my invention; Fig. 2, a perspective view of the barrel with the lower end uppermost; and Fig. 3, an enlarged vertical sectional view.

In the illustration given, 10 designates a lower portion of the barrel formed in one piece and in a suitable mold. The bottom wall 11 may be provided with riveted openings 12 by means of which a plate may be secured to the lower portion of the barrel and within the end flanges 13.

The upper portion of the mold part 10, which is illustrated as less than one-half of the complete barrel, is provided with a rib 14, and inwardly of the rib 14 there is a cutaway portion 15 adapted to receive an inner edge of the barrel portion thereabove. If desired, the wall of the barrel portion 10 may be flared inwardly slightly at 16 so as to provide a trough 17 into which the cement may be poured.

The upper barrel portion 18 is provided at its upper end with inwardly extending flanges 19 and with end flanges 20. Within the recess provided between the flanges 20 may be secured a savings bank plate 21, as shown in Fig. 1, provided with a spring guarded coin slot 22 and with the usual lock 23. In the mold portion shown in Fig. 3, an opening 24 is provided to enable the lock to be inserted below the locking flange 19. Since such structure is well known, a detailed description is not herein given.

The upper portion 18 of the barrel is shown provided at an intermediate point with an integral rib 25 and at its lower end the wall is cut away to provide an inwardly stepped flange or edge 26 adapted to be received within the recess 17

of barrel portion 10. The cutaway shoulder 27 of the upper wall rests upon a similarly cutaway portion of the rib 14.

In the operation of casting the molded barrel, a suitable molding material, such as, for example, the product well known as "Tenite," is introduced in fluid or other suitable form into the proper molds for forming the parts 10 and 18. The material is first heated and then pressed under extremely high pressure into the molds so as to fully occupy the space provided between the molds. Preferably, a single pair of molds, the inner and outer parts, are employed for making the barrel portion 10. With respect to the upper portion 18, a single core mold is employed, but preferably a two-part outer mold is used for forming the spaces opposite the inner core mold. After the molding operation, with respect to portion 18, the outer two-part molds, which meet at their inner edges at the rib 25, may be separated and the inner core then withdrawn. The inner central portion of the mold portion 18, as indicated by the numeral 28, is substantially straight so that the inner core mold may be readily withdrawn.

After the two parts 10 and 18 have been formed, the adjacent inner edge portions are brought together, the flange 26 being received within the trough or recess 17 and cemented therein either by cement or by a solvent. The cement is placed not only within the trough 17, but about the adjacent edges of the touching parts so that the end portion of the barrel part 18 is integrally connected to the upper portion of barrel part 10.

With the structure illustrated, it will be noted that the rib on the outer side effectively conceals the joint, giving the entire barrel the appearance of being cast from a single mold. At the same time, the inner rib 16 serves not only to provide a trough for the cement but provides an overlapping inner reinforcing band or rib. Thus the lower extension of the upper part 18 is secured between a pair of ribs by cement held therebetween.

In the structure shown, there is a trough formed between the ribs 16 and 14. If desired, however, this trough may be omitted and the joint made by simply cementing the inner end portion 15 to the upper back portion of the rib 14. I prefer, however, the structure shown because it provides a trough for holding the cement, thus insuring perfect cementing of the joined parts while at the same time providing two parallel ribs which reinforce the joint.

It will be understood that the same joint formed behind the rib 14, might, if desired, be formed behind the rib 25, the upper portion of the bar-

rel above the rib 25 being formed in one piece and the remaining lower portion of the barrel formed in one piece. There may be considerable variation in such points of joining.

While I have shown the barrel formed of two parts, it will be understood that a larger number of parts may be used, joints being provided similar to those illustrated between the portion 26 and the upper end portion of part 10.

By the method shown, it will be noted that a substantially integral molded barrel is produced with an enlarged central portion and narrowing end portions while at the same time employing straight or simple molds. At the same time, the barrel retains its true form, with the ribs disposed on opposite sides of the central portion thereof and at least one of the ribs providing a concealment for the joint, and one of the pair of ribs for protecting the joint.

While in the foregoing description, I have specified certain details of structure and certain detailed steps in the method of construction and assembly, it will be understood that those skilled in the art may readily vary such details without departing from the spirit of my invention.

I claim:

1. A molded barrel-shaped container formed of two parts, one of said parts constituting substantially one-third of the barrel and the other part constituting substantially two-thirds, an integral rib carried by one of said parts adjacent the junction thereof with the other part, said other part having the mating end portion reduced, the portion of the barrel to the inside of said rib being cut away to provide a recess and a trough receiving the adjacent portion of the other barrel part, said adjacent portion being received entirely within said recess and trough to provide a smooth inner surface for said barrel, and cement sealing said parts together and concealed by said rib.

2. A molded barrel-shaped container, consisting of two parts united by a single joint, one of said parts having a reduced end portion, an integral rib carried by the other of said parts adjacent said joint, said rib extending radially from said barrel and having a recess at the inner side thereof, an annular rib at the inner side of said recess extending upwardly to form with said first-mentioned rib a trough, said recess and

trough receiving the reduced end portion of the other part, and cement in said trough uniting said parts and said joint and concealed by said rib, said rib providing a thickness at the joint portion greater than the thickness at the adjacent barrel portion parts.

3. A molded barrel-shaped container comprising a larger molded barrel part having a straight inner central portion and an inwardly curved inner end portion, and a smaller molded barrel part having an inner inwardly curved end portion, at least one of said parts being provided with an integral annular rib adjacent the junction with the other part, said rib extending radially from said barrel and having a recess at the inner side thereof, an annular rib at the inner side of said recess and spaced inwardly from said first-mentioned rib, said ribs forming between them a trough at the base of said recess, the other barrel part having the mating end portion reduced, said recess receiving the reduced end portion of the other barrel part, and cement in said trough uniting said parts, the joint between the parts being concealed by said first-mentioned rib, said ribs providing a thickness at the joint portion greater than the thickness of the adjacent barrel portion parts.

4. A molded barrel-shaped container, consisting of a larger molded part having a cylindrical inner portion and an inwardly-curved inner end portion, and a smaller barrel part having an inwardly-curved inner end portion, said parts being joined together in a joint extending transversely of the longitudinal axis of the barrel, at least one of said parts being provided at said joint with an outwardly extending rib peripherally of the barrel which rib is shaped as an integral hoop, said last named part having an integral upwardly extending annular wall portion at the inner side of and spaced from the rib providing therewith a trough-like recess, said wall portion terminating short of the plane of the outer end of the rib, the other part having a reduced end portion entirely received within said trough-like recess, said rib and end portion received within said recess having a combined thickness greater than that of the barrel wall, and cement in said trough securing said end portion within said recess and concealed by said rib.

EDWARD A. ANDERSON.