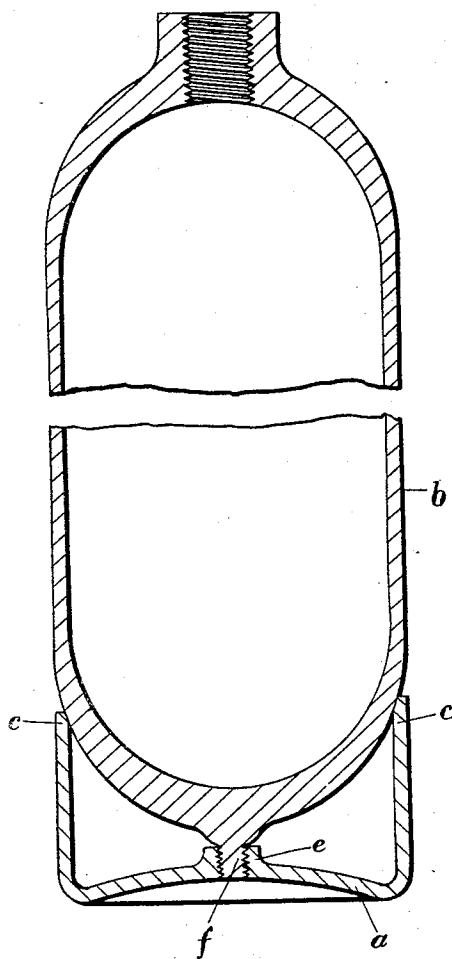


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HOLLOW METAL CONTAINER
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HOLLOW METAL CONTAINER

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This invention relates to gas cylinders and like hollow metal containers which are manufactured from tubular blanks the ends of which are closed down by hammering or equivalent metal working processes which result in a thickened end provided with a projecting pip.

The object of the invention is to provide for a container of this form a base member which is made to fit over the pip and is secured thereby by screwing, riveting, or any other suitable means.

With this and other objects in view the invention consists in the combinations and arrangements hereinafter described in detail and set out in the accompanying claiming clauses.

The base member constructed in accordance with the invention has the advantage of utilizing the projecting pip which otherwise has to be removed or driven back into the metal by forging or equivalent operation and provides a base member of cheap construction which does not interfere with the close stacking of the cylinders for storage purposes and will not interfere with the rolling of the cylinders along their sides when desired.

The accompanying drawing, which illustrates one method of carrying out the invention, shows a longitudinal section through a gas container fitted with a base in accordance with the invention.

The base member *a* can be formed with a stamping and can be of less expensive metal than that necessary to carry the high stresses to which the container *b* itself is subjected, and is preferably externally of cylindrical form its external diameter agreeing with that of the cylinder or container *b*. The upper ends *c* of the base member are preferably so shaped as to bear upon the external surface of the cylinder close to the point at which the reduction in external diameter at the end of the cylinder commences. The bottom of the base may be flat but is preferably upwardly dished as shown, and has a central portion *e* with aperture therein for passing over the pip *f* formed on the end of the cylinder *b*, this central portion being preferably extended in length.

Alternatively, the base may be secured to the pip *f* by riveting the latter over the central portion *e* or in any other desired manner.

I claim:

1. In a hollow metal container for gases under high pressure, the combination of a tubular body member, a projecting pip formed on one end thereof by closing down the tubular body, a base member formed with an opening in which the projecting pip is seated, and means for securing the base member in position on said pip.

2. The combination of a cylindrical, tubular, metal container for gases under high pressure, a base member of circular cross section conforming in external diameter with that of the metal container and provided with a pip seat, a projecting pip formed on one end of the container in closing down the same and seated in the pip seat in the base member, and means for securing said base member to said pip.

3. The combination of a metal cylinder with a hemispherical end, a projecting pip on said end formed in closing down said cylinder, a base member engaging said pip and the cylinder near to the top of the hemispherical end of the latter, and means for securing said base member to the cylinder.

4. A base member for a forged tubular metal container provided with a projecting pip on the end thereof formed in the closing down of said container, said base member comprising a cylindrical, external wall, and a central, upwardly projecting portion provided with a bore of diameter small in relation to that of the external wall and fitting over said projecting pip.

In testimony whereof I affix my signature.

SYDNEY BROWN NICHOLSON HILL.