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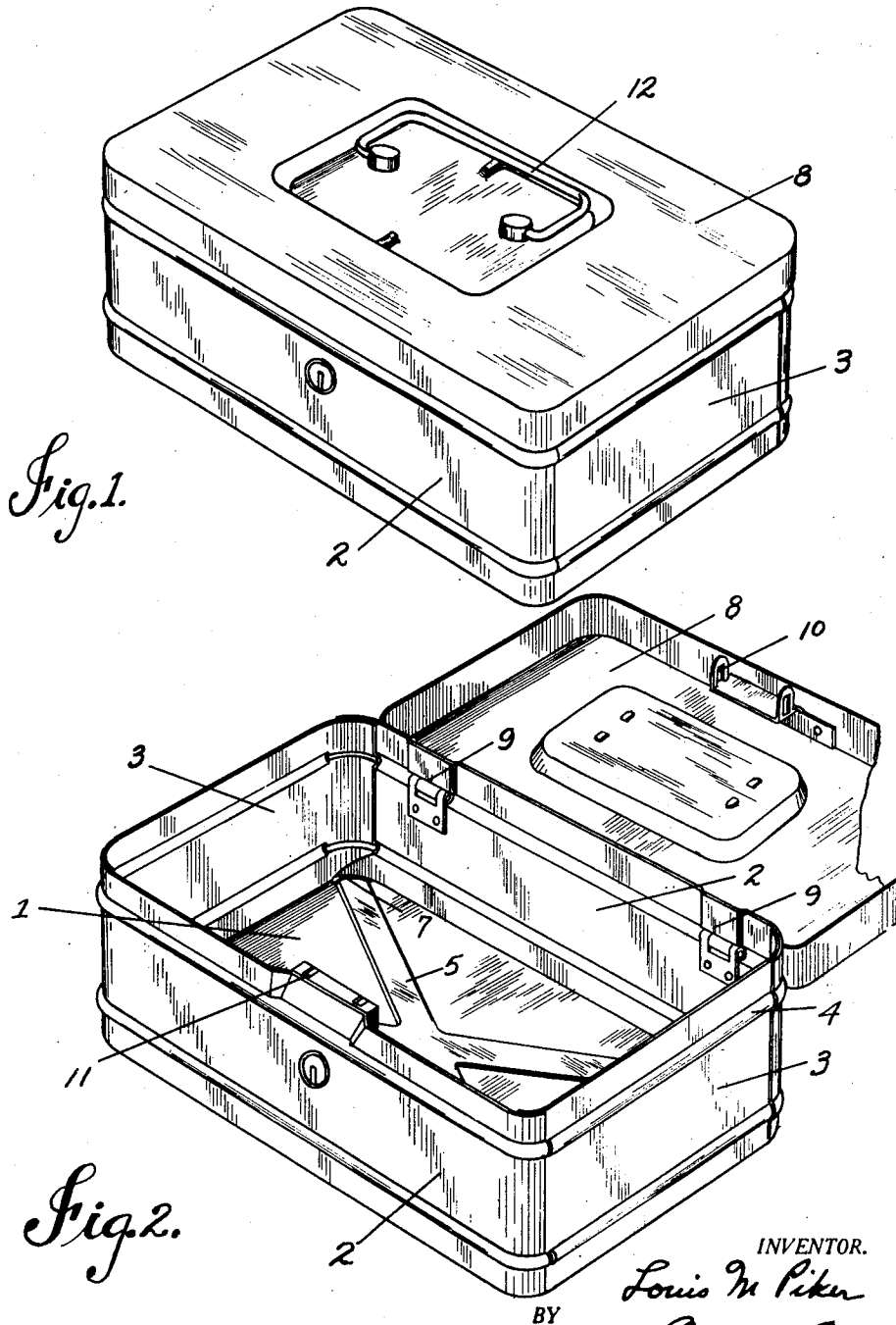
L. M. PIKER

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BLANK FOR AND PROCESS OF MAKING METAL CONTAINERS

Filed Dec. 12, 1930

2 Sheets-Sheet 1



INVENTOR.

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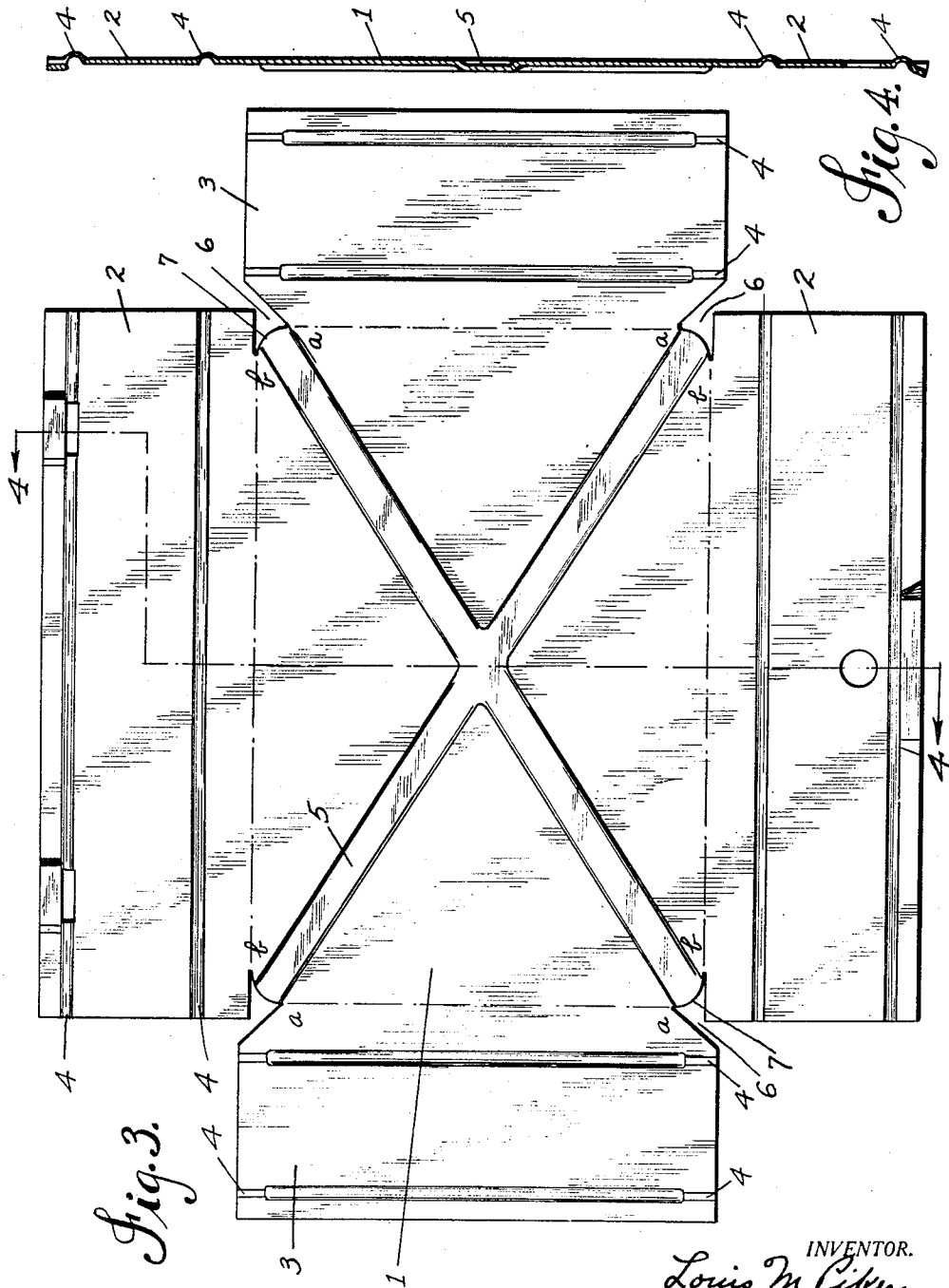
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LOUIS M. PIKER, OF HAMILTON, OHIO

BLANK FOR AND PROCESS OF MAKING METAL CONTAINERS

Application filed December 12, 1930. Serial No. 501,904.

My invention relates to the manufacture of metal boxes with hinged lids, and particularly to the corner construction of such boxes.

For many reasons in the manufacture of boxes it is desirable that the corners be rounded so that in the use of the boxes the edges will not cause indentations and marks on articles with which they may come in contact.

As far as I am advised, metal containers and boxes in which the corners are perceptibly rounded or rounded enough to give the desirable qualities of rounded corner boxes, a fairly high grade of metal must be used and the boxes are drawn, which is a metal treating operation which is well known in the art.

It is an object of my invention to provide a one piece stamped and pressed metal box which has well rounded corners, and in which, due to the dieing out of the blank from which the container is formed, there is no waste of metal and the corners are very strong due to an overlapped reinforcement.

It is further my object to provide a metallic box which will be exceedingly cheap to construct, which may be made from cheap grades of sheet metal, and which will have all the ruggedness and the neat appearance of more expensive containers.

The above objects and other objects to which reference will be made in the ensuing disclosure I accomplish by that combination and arrangement of parts of which I have shown a preferred modification.

Referring to the drawings:

Figure 1 is a perspective view of a metal box of preferred construction with the lid closed.

Figure 2 is a perspective view of the box shown in Figure 1 with the lid open.

Figure 3 is a plan view of the stamped out blank which is pressed into shape to form the complete box illustrated in Figures 1 and 2.

Figure 4 is a sectional view taken along the lines 4—4 of the blank shown in Figure 3.

Referring first to the blank, I have shown

a sheet of metal having a main portion 1 which forms the bottom of the box and with side wall portions 2 and end wall portions 3. Ribs 4 for purposes of reinforcing the side and end walls are pressed into the walls extending across the walls in the direction of their length.

The bottom 1 of the blank has diagonally extending ribs 5 which are pressed into the said bottom wall ordinarily when the blank is originally stamped out.

It will be noted that the overall length of the side and end walls extends out beyond the lines *a—c* and *b—b* which form the bottom edges of the end and side walls of the container.

A triangular shaped cut out portion 6 allows the sides and ends of the container to be bent up at right angles to the bottom and then pressed around the curved corner 7 of the bottom of the blank into overlapping relation as clearly indicated in Figure 2.

The lid 8 illustrated is drawn from a sheet of metal and is secured with hinges 9 to the container in the usual manner.

A latch 10 which engages a lock 11 is also indicated, and I have further shown a pivoted bail 12 which acts as a handle for the box.

The particular size and shape of the metal container illustrated has no particular advantageous features connected therewith, as my invention is particularly directed toward the rounded corner walls of the container.

Not only is the process by which I cut out the portion 6 from the blank so that the end and side walls may overlap in a curved formation novel, as far as I am aware, in a stamped and pressed box, but a box having overlapped reinforced rounded corners also in thought to be novel.

Having thus described my invention, what I claim is new and desire to secure by Letters Patent is:

1. A blank for a metal container having a portion for forming the bottom of the container with side and end portions formed integrally with said first noted portion, the corners of said first noted portion being cut away and having a rounded edge whereby the side and end walls may be pressed into

positions upstanding from the first noted portion, with overlapped ends of the side and end portions pressed around into a curved formation corresponding with the curved end edges of the said first noted portion, said blank having indented ribs extending longitudinally of the side and end portions so that the indented portions will register when they are pressed around in a curved corner formation.

2. A blank for a metal container having a portion for forming the bottom of the container with side and end portions formed integrally with said first noted portion, the corners of said first noted portion being cut away and having a rounded edge whereby the side and end walls may be pressed into positions upstanding from the first noted portion, with overlapped ends of the side and end portions pressed around into a curved formation corresponding with the curved end edges of the said first noted portion, said side and end portions being of greater length and width respectively than the length and width of the first noted portion.

3. In the art of manufacturing rectangular metal containers the steps in the manufacture thereof which consist in cutting and stamping a blank from a sheet of metal with a bottom having rounded corners, with sides and ends of greater length and width than the sides and ends of the bottom, then pressing up the side and end walls and overlapping the ends of the side and end walls to conform to the shape of the corners of the bottom, and during the stamping of the container indenting ribs in the side and end walls, which ribs register when the ends of the side and end walls are overlapped.

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