(No Model.)

W. P. CRAGIN.

METHOD OF CONSTRUCTING METAL BUCKETS.

No. 393,144. Patented Nov. 20, 1888.

Fig. 1.

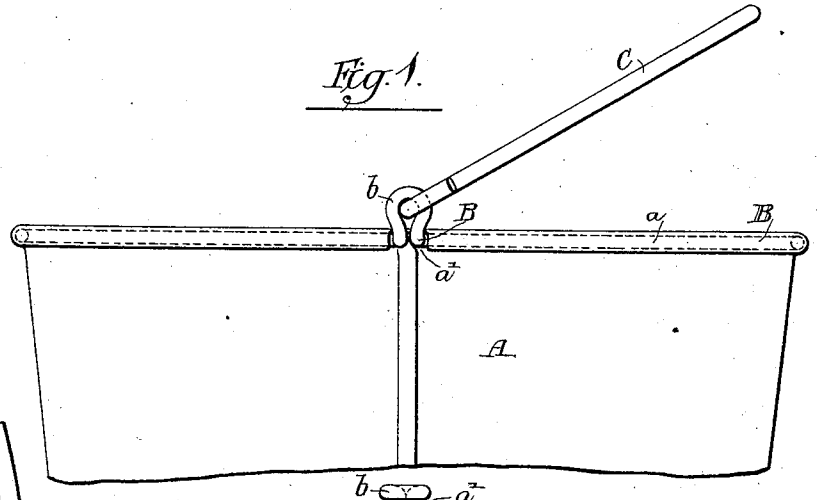


Fig. 3.

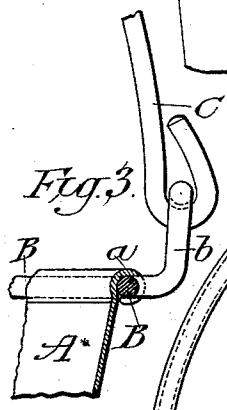


Fig. 2.

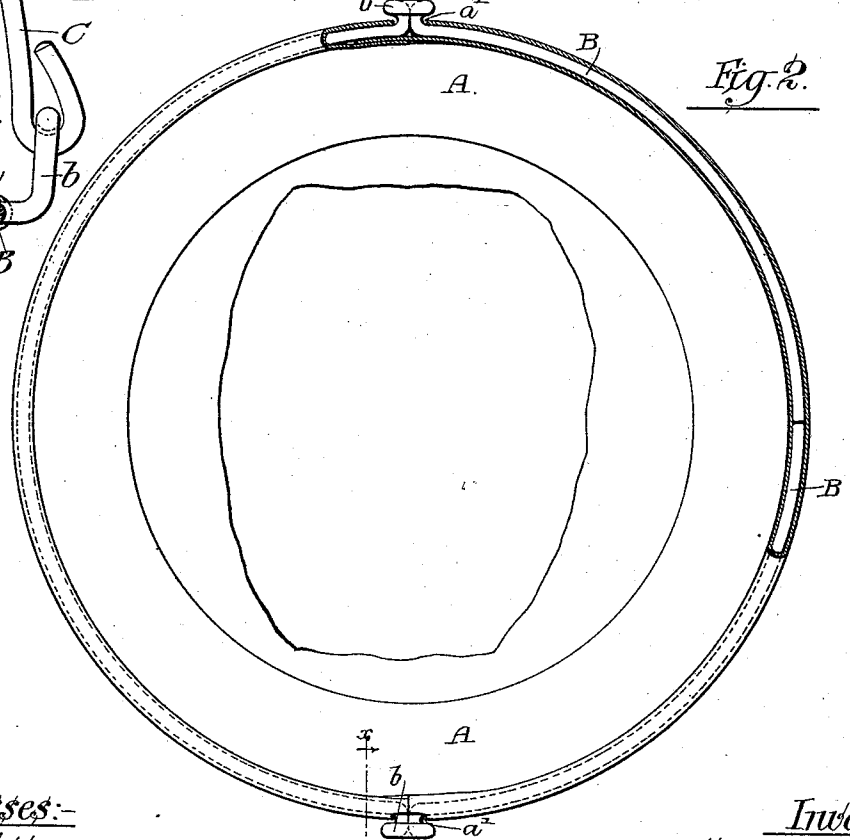
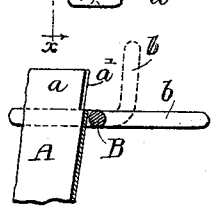


Fig. 4.



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UNITED STATES PATENT OFFICE.

WILLIAM P. CRAGIN, OF CHICAGO, ILLINOIS.

METHOD OF CONSTRUCTING METAL BUCKETS.

SPECIFICATION forming part of Letters Patent No. 393,144, dated November 20, 1888.

Application filed February 6, 1888. Serial No. 263,124. (No model.)

To all whom it may concern:

Be it known that I, WILLIAM P. CRAGIN, of Chicago, in the county of Cook and State of Illinois, have invented certain new and useful Improvements in Methods of Constructing Metal Buckets and Similar Vessels; and I do hereby declare that the following is a full, clear, and exact description thereof, reference being had to the accompanying drawings, and to the letters of reference marked thereon, which form a part of this specification.

This invention relates to an improvement in the construction of metal buckets and similar vessels.

The invention consists, essentially, in the method of constructing the upper rims of sheet-metal buckets and in forming said rims and the ears to which the bail is attached to the bucket practically in one operation.

In the accompanying drawings I have illustrated in Figure 1 a device embodying my invention. Fig. 2 is a plan view thereof, partly in section. Fig. 3 is a vertical section, enlarged, taken on line *x x* of Fig. 2, showing the rim and ear. Fig. 4 is a vertical section of same before the metal edge is turned down to form the rim.

In the drawings the part marked A illustrates an ordinary metal bucket, the upper edge of which is adapted to be turned over and around the strengthening-wire B, the edge *a* being cut away at *a' a'* to permit the loops or ears *b b* to project.

C represents the bail or handle secured in the ears or loops *b b*.

In practice the wire B is wrapped entirely around the bucket horizontally near the top, with the ears or loops *b b* opposite the openings *a' a'*, as illustrated in Fig. 4. The upper edge, *a*, of the bucket is then turned down or curled by a roller or other tool or machine over and around the wire B, forming a rounded and stiffened rim, as illustrated in Fig. 3. The loops or ears *b b* are then bent upward, as shown in said Fig. 4, and the bail C secured thereto.

By placing the wire around the bucket with the loops extending horizontally, as shown, I am enabled to make use of the usual tools or machines in bending the edge *a* over the wire, and thus not only produce a neater, stronger, and better rim than if the edge were turned by hand, but I gain largely in the time consumed in the manufacture of the bucket.

The bucket made as above set forth will commonly be galvanized, thereby affording a more firm and rigid connection between the parts. Such galvanizing is not, however, necessary for the successful practice of my invention.

I claim as my invention—

The method of constructing sheet-metal buckets and similar vessels, which consists in first placing a wire ring around and near the top of the bucket, said ring being provided with loops, then bending or curling the top edge of the bucket around said ring to form a stiffened rim, and finally bending said loops upward to form ears, to which the bail may be secured, substantially as specified.

In testimony that I claim the foregoing as my invention I affix my signature in presence of two witnesses.

WILLIAM P. CRAGIN.

Witnesses:
C. C. POOLE,
M. E. DAYTON.