

(CONVENTION. By one or more persons and/or a Company.)

Form 4

71746/87

601972

COMMONWEALTH OF AUSTRALIA

Patents Act 1952-1969

CONVENTION APPLICATION FOR A PATENT

APPLICATION ACCEPTED AND AMENDMENTS

19-7-90

(1) Here insert (in full) Name of Applicant or Applicants, followed by Address (es).

☒ (1) INTERNATIONAL PAINT public limited company,
We of 18 Hanover Square,
London, W1A 2BB,
England.

(2) Here insert Title of Invention.

hereby apply for the grant of a Patent for an invention entitled: (2)

HEAD SEAM FOR A FAIL

(3) Here insert number(s) of basic application(s)

which is described in the accompanying complete specification. This application is a Convention application and is based on the application numbered (a)
8609458

(4) Here insert Name of basic Country, and basic date or dates

for a patent or similar protection made in (4) United Kingdom
on 17th April, 1986.

FEE STAMP TO VALUE OF
2.80
1.00 ATTACHED
MAIL OFFICER

LODGED AT SUB-OFFICE of address for service is Messrs. Edwd. Waters & Sons, Patent Attorneys,
16 APR 1987 50 Queen Street, Melbourne, Victoria, Australia.
Melbourne

DATED this 14th day of April, 1986



INTERNATIONAL PAINT public limited company.

By: *L. M. W.*

W.F. DANCER

Registered Patent Attorney.

COMMONWEALTH OF AUSTRALIA

Patents Act 1952-1969

DECLARATION IN SUPPORT OF A CONVENTION APPLICATION FOR A PATENT OR PATENT OF ADDITION

(1) Here
insert (in
full) Name of
Company.

In support of the Convention Application made by⁽¹⁾.....
INTERNATIONAL PAINT public limited company.....
18 Hanover Square, London, W1A 2BB, United Kingdom.....
(hereinafter referred to as the applicant) for a Patent

(2) Here
insert title
of Invention.

for an invention entitled:⁽²⁾.....
HEAD SEAM FOR A PAIL.....

(3) Here
insert full Name
and Address,
of Company
official
authorized
to make
declaration.

I,⁽³⁾ Michael Drummond Smith.....
of P.O. Box 16, Foleshill Road, Coventry CV6 5AE,
England.....

do solemnly and sincerely declare as follows:

1. I am authorised by the applicant for the patent
to make this declaration on its behalf.

2. The basic application as defined by Section 141 of the Act was
made in⁽⁴⁾ United Kingdom

on the 17th day of APRIL 1986, by
INTERNATIONAL PAINT public limited company
on the day of 19, by

(4) Here
insert basic
Country or
Countries
followed by
date or dates
and basic
Applicant or
Applicants.

(5) Here
insert (in
full) Name
and Address
of Actual
Inventor or
Inventors.

3.⁽⁵⁾ Joseph Harold Jewitt, of 36 Bracken Close,
Stanley, County Durham, United Kingdom; and
Jack Harley, of 6 Regency Close, Coventry CV3 6QA,
United Kingdom

are the actual inventors of the invention and the facts upon which the applicant
is entitled to make the application are as follow:

The applicant is the assignee of Joseph Harold Jewitt and
Jack Harley

4. The basic application referred to in paragraph 2 of this Declaration
was.....the first application made in a Convention country in
respect of the invention the subject of the application.

DECLARED at Coventry
this 17th day of May, 1990

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(54) Title
HEAD SEAM FOR A PAIL

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(36) Prior Art Documents
GB 2109777
GB 1434839
AU 234284 44186/58 73.2,73.4

(57) Claim

1. A pail body having a pail wall with a longitudinal axis and a curled rim for receiving a lid, the curled rim being in the form of a compound curl formed by pre-curling a rim edge part adjacent to the rim edge of the pail wall outwardly, then in the direction of the longitudinal axis and then inwardly, relative to the pail body to form a pre-curl and cause the said rim edge to lie adjacent the outside of the pail wall, and then further curling the rim to produce a compound curl in which the rim edge part closest to said rim edge of the pre-curl extends in a direction away from the pail wall and is located intermediate an upper and a lower region of the compound curl, said rim edge of the pre-curl being the part thereof that makes the closest approach to the inside surface of the remainder of the compound curl, prior to offering a lid to the pail body.

7. A method of manufacturing a metal pail body having

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a pail wall with a longitudinal axis and a curled rim for receiving a lid, the method comprising the steps of:

- (a) forming a pre-curl on the rim of the pail body by curling a rim edge part adjacent to the rim edge of the pail wall outwardly, then in the direction of said longitudinal axis and then inwardly relative to the pail body to cause the said rim edge to lie adjacent to the outside of the pail body,
- (b) expanding the diameter of the pail body at the rim so that the pail body tapers to become narrower in the direction of the longitudinal axis away from said rim, thereby tightening the pre-curl and reducing the cross-sectional diameter of the pre-curl, and
- (c) performing another curling operation on the rim to produce a compound curl and leave the said rim edge part closest to the rim edge of the pre-curl extending in a direction away from the pail body and located intermediate an upper and a lower region of the compound curl, and in which the said rim edge of the pre-curl is the part that makes the closest approach to an inside surface of the remainder of the compound curl, prior to offering a lid to the pail body.

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Form 10

COMMONWEALTH OF AUSTRALIA

PATENTS ACT 1952-69

COMPLETE SPECIFICATION

(ORIGINAL)

Class

Int. Class

Application Number:
Lodge:

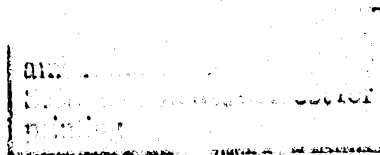
71746/87

Complete Specification Lodged:

Accepted:

Published:

Priority:



Related Art:

Name of Applicant: INTERNATIONAL PAINT public limited company

Address of Applicant: 18 Hanover Square, London W1A 2BB, England.

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Complete Specification for the invention entitled:

HEAD SEAM FOR A PAIL

The following statement is a full description of this invention, including the best method of performing it known to : US

Head Seam for a Pail

Technical Field

This invention relates to a head seam for a pail for the storage and transportation of materials and which is especially useful in the transportation of dangerous goods such as paint. The word "pail" is used in this specification to indicate a cylindrical container closable at one end with a removable lid. Sometimes such a container is called a "drum" although the latter term is more often used to indicate a container having irremovable end closures one of which at least is normally formed with a small opening for filling and/or emptying the container.

Discussion of Prior Art

It is important in transporting materials which are corrosive or flammable that secure packages are used which are not readily susceptible to damage and leakage, for example if they are dropped during loading and unloading. Specifications for packaging have been raised over the years and it can be expected that they will be raised further.

The present invention seeks to provide a head seam for fastening the lid of a pail to the body which is more secure than that at present in use on conventional pails.

Conventionally, a head seam for a pail is a five fold double seam. To form such a seam a curl is formed around the outside of the upper rim of the pail and a channel is formed around the periphery of the lid with downwardly directed flanges located at intervals around the lid. A sealing compound is run into the channel on the lid and the lid is clamped onto the curl on the

pail by means of a clamping tool applied to the flanges thus squeezing the channel onto the curl around the periphery of the pail to create a seal.

The present invention provides an improved seam
5 compared with this conventional five fold seam.

Summary of the Invention

According to one aspect of the invention there is provided a pail body having a pail wall with a longitudinal axis and a curled rim for receiving a lid, the curled rim
10 being in the form of a compound curl formed by pre-curling a rim edge part adjacent to the rim edge of the pail wall outwardly, then in the direction of the longitudinal axis and then inwardly, relative to the pail body to form a pre-curl and cause the said rim edge to lie adjacent the
15 outside of the pail wall, and then further curling the rim to produce a compound curl in which the rim edge part closest to said rim edge of the pre-curl extends in a direction away from the pail wall and is located intermediate an upper and a lower region of the compound curl,
20 said rim edge of the pre-curl being the part thereof that makes the closest approach to the inside surface of the remainder of the compound curl, prior to offering a lid to the pail body.

It is advantageous to form the pail body with three
25 circumferential beads in the region of the said curled rim, the three beads comprising a single comparatively shallow bead comparatively close to the said rim with a compound curl and a pair of closely spaced comparatively large beads at a comparatively large distance from the said rim with a
30 compound curl.

According to a further aspect of the invention, a method of manufacturing a metal pail body having a pail wall with a longitudinal axis and a curled rim for receiv-



ing a lid, comprises the steps of:

- 5 (a) forming a pre-curl on the rim of the pail body by curling a rim edge part adjacent to the rim edge of the pail wall outwardly, then in the direction of said longitudinal axis and then inwardly relative to the pail body to cause the said rim edge to lie adjacent to the outside of the pail body,
- 10 (b) expanding the diameter of the pail body at the rim so that the pail body tapers to become narrower in the direction of the longitudinal axis away from said rim, thereby tightening the pre-curl and reducing the cross-sectional diameter of the pre-curl, and
- 15 (c) performing another curling operation on the rim to produce a compound curl and leave the said rim edge part closest to the rim edge of the pre-curl extending in a direction away from the pail body and located intermediate an upper and a lower region of the compound curl, and in which the
- 20 said rim edge of the pre-curl is the part that makes the closest approach to an inside surface of the remainder of the compound curl, prior to offering a lid to the pail body.

25 The invention also includes a method of manufacturing a pail by fitting a lid to the compound curl rim of a pail body made as described above and also includes a pail including a lid so fitted.

30 A further aspect of the invention is the use of a rim-forming line for the manufacture of pail bodies which line comprises stations for carrying out the following operations:



a) an operation for forming the pre-curl on the rim of the pail body,

b) an operation for expanding the pail body so that it tapers to become narrower in the direction away from the said rim, and

c) an operation for carrying out another curling operation on the pre-curl to produce the compound curl.

The rim-forming line can also include one or more stations to form three circumferential beads in the wall of the pail body in the vicinity of the curled rim and comprising a comparatively shallow bead comparatively close to the said curled rim and a pair of closely spaced comparatively large beads at a comparatively large distance from said curved rim.

In the operation of the method to form a pail it is useful to employ a closing tool for applying a lid to a pail body, the closing tool including a downward extension dimensioned to contact a central region of the lid when the closing tool is in use, and also including a central pillar on which are pivoted levers connected by linkages to a spider having a central mounting slidable on the pillar and wherein brackets carried on the mounting pivotally carry arms each connected to an associated closure element pivoted on a base which carries the central pillar and the said downward extension. Preferably, a lid to be applied by the closing tool has at least one annular corrugation outwardly of the said central region in a configuration such that when the said downward extension of the closing tool applies pressure to the said central region of the lid during the closing operation, the material of the lid is urged outwardly at the rim of the pail body.

Desirably when applying a lid to a pail body, the lid has a channel which accommodates the compound curl around



the rim of the pail body and has flanges which are to be clamped beneath the said curl against the wall of the pail body, pressure being applied in a central region of the lid as the flanges are clamped home.

5 Brief description of the Drawings

The invention will be further described, by way of example, with reference to the accompanying drawings in which.-

Figure 1 is a half section through a pail according to the invention showing a lid in a position above the pail body ready for fitting thereto, the left-hand half being in section and the right-hand half being in side elevation,

Figure 2 is a schematic representation of a tool for forming a curl on an upper rim of a pail body and constituting part of a rim-forming line,

Figure 3 is a schematic representation of a tool for expanding the body of a pail which can constitute part of the rim-forming line referred to above,

Figure 4 is a schematic representation of a tool for simultaneously further curling the upper rim of a pail body and forming a bead in the body of a pail, this tool also constituting part of the rim-forming line referred to above,

Figure 5 is a section through the upper rim of a pail body after subjection to a pre-curl operation,

Figure 6 is a section through the upper rim of the pail body shown in Figure 5 after the pail body has been subjected to an expanding operation.



Figure 7 is a section through the upper rim of the pail body shown in Figure 5 after subjection to a second curling operation,

5 Figure 8 is a partial cross-section through a closing tool for applying a lid to the pail body of Figures 1 to 5,

Figure 9 is a view corresponding to Figure 8 showing the closing tool in the closed-up configuration,

10 Figure 10 shows part of the closing tool similar to that of Figures 8 and 9 when the tool is in the closed-up configuration and is applied to a pail body and lid, in use,

Figure 11 is an enlarged section through a completed head seam according to the invention, and

15 Figure 12 is a schematic representation of a rim-forming line for the manufacture of pail bodies in accordance with the invention.

Description of Preferred Embodiments

20 The pail 20 shown in part in Figure 1 has a capacity of 20 litres and its body 21 is made from 27 gauge (0.43 mm thick) mild steel.

The first stage in the manufacture of the pail body 21, in the present case, is a conventional procedure involving rolling to form a cylinder and crush welding to produce a longitudinal seam. Other welding techniques
25 may be used to form this longitudinal seam.

The pail body 21 is then transferred to a rim-forming line (see Figure 12) which is conventional in respect



of the means for transporting the pail bodies and, in general terms, in respect of the means for forming them, but is novel in that it comprises stations for carrying out the following operations:

- 5 (a) a pre-curling operation (at station E),
- (b) an expansion of the pail body (at station F),
- (c) a second curling operation together with formation of a bead in the pail body, (at station G), and
- 10 (d) formation of two more beads in the pail body (at station H)

The conventional transporting means for the pail bodies in a rim-forming line according to the invention are shown only schematically at J in Figure 12 and can be of any convenient design. The pre-curling tool of station E is shown in Figure 2. The pre-curling tool comprises, in the present case, a table 22 mounted on a hydraulic ram 23 below a tool head 24 (alternatively a mechanically-operated tool may be used). The cylindrical pail body 21 is delivered by the transporting means (not shown) to the table 22 so that its lower rim (not shown) stands on the table 22. The upper rim 26 is located below the groove 27 in the tool head 24. At this stage the upper rim 26 extends straight up and is undeformed. The hydraulic ram 23 then raises the table 22 pushing the rim edge 28 (Figure 5) of the rim 26 of the pail body 21 into the groove 27 and causing the rim edge part adjacent to the rim edge 28 to curl round beneath an upper region 29 of the pre-curl 30 shown in Figure 5 and to extend towards a pail wall 33. This pre-curling operation is conventional per se in that it is similar, in principle, to curling operations carried out in producing the known five-fold seam but the use of a pre-curling operation is not conventional. The pre-curl 30, in the present instance has a diameter in the vertical direction (dimension A in Figure 5) of 4.5 mm.



After the pre-curling operation illustrated in Figure 5, the pail body 21 is transported to an expanding tool making up station F of the rim-forming line shown schematically in Figure 12. The expanding tool is shown at 34 in Figure 3 and is per se conventional. It operates by means of a set of fingers 35 which are inserted in the pail body 21 and which are mounted so that they can be splayed outwards at the top by introduction between them of a conical wedge 36 under the influence of a hydraulic ram (not shown). In the present instance, the expanding tool 34 imparts to the pail body 21 the shape of the frustum of a cone having a diameter of 270mm at the bottom and 280mm at the top, that is, the pail body is expanded so that it tapers to become narrower in the direction away from the rim 26 and pre-curl 30. The effect of this deformation of the pail body is to reduce the dimension λ of the pre-curl 30 to 4.0mm and bring the rim edge 28 close to or even in contact with the pail wall 33. This condition of the pre-curl 30 is shown in Figure 6. Figures 5 and 6 also illustrate the reduction of an oblique diameter B of the pre-curl 30 from 4.5mm in Figure 5 to 4.0mm in Figure 6.

The next station G on the rim-forming line is shown in Figure 4. This station operates on the pail wall 33 as well as on the rim 26 of the pail body. A table 37 to support the pail body 21 is mounted on a hydraulic ram 38 beneath a bead-forming tool 39 and a tool head 40. The bead-forming tool is per se conventional and comprises segments 43 mounted so that they can be moved apart by introduction between them of a conical wedge 44 carried by a hydraulic ram (not shown).

A pail body having a pre-curl 30 and transported to the table 37 is raised by upward movement of the table 37 under the influence of the hydraulic ram 38 pressing the pre-curl 30 into a groove 45 in the tool head 40.



This operation produces a compound curl 46 by curling the already pre-curved pail rim 26. The result is shown in Figure 7 where the rim edge part adjacent to the rim edge 28 is shown extending away from the pail wall 33 and is located intermediate an upper region 47 of the compound curl 46 extending away from the pail wall on its outside and a lower region 48 of the compound curl extending from the outer periphery of the upper region 47 towards the pail wall. The rim edge part extends from the inner periphery of the said lower region 48 away from the pail wall 33 to leave the rim edge 28 of the pre-curl 30 as the part thereof which makes the closest approach to the inside surface of the remainder of the compound curl 46 (see Figure 7). The lower region 48 at least partly comprises the upper region 29 of the pre-curl 30 (Figures 5 and 6). The diameter C of the compound curl 46 is, in the present instance, 7.5mm and an inner part 49 of the compound curl is spaced from the pail wall 33 by a distance (D) of 2.1mm. The rim edge 28 is still located close to or in contact with the inner surface of the compound curl near an outer part 50 of the compound curl which is furthest from the pail wall 33.

After formation of the compound curl 46 and while the pail body is still in station G, the bead-forming tool 39 is operated by the conical wedge 44 which moves the segments 43 outwards so that ridges 53, one of which is formed on each segment, are pressed into the pail wall 33 thus forming in it a lower bead 54 (Figure 1).

The pail body is next transported to a further work station H at which a second bead forming tool (not shown) having two series of bead-forming ridges similar to the ridges 53 is operated to form an upper bead 55 (Figure 1) and a middle bead 56.

In the present instance, the highest point of the upper bead 55 (in relation to the pail wall 33) is located 25mm below the upper region 47 of the compound curl 46 and has a height from the pail wall 33 of 1.5mm. The distance from the upper region 47 to the centre of the

valley between the middle bead 56 and the lower bead 54 is 85mm. The lower bead 54 has a height of 7.5mm and the middle bead 56 has a height of 7.0mm. The bead arrangement is thus a pair of comparatively large closely spaced beads at a comparatively large distance from the compound curl 46 at the upper rim of the pail body and a relatively shallow bead comparatively close to the compound curl.

The beads play a part in protecting the head seam of the present pail if the pail is dropped, as will be described below, and their position and size are important factors in achieving such protection. The upper bead 55 is preferably located no less than 20mm and no more than 35mm from the upper region 47 and preferably has a height from the pail wall 33 of from 1mm to 3mm. The high points of the middle and lower beads are located, on the pail body shown in Figure 1, 77mm and 94mm respectively from the upper region 47 and the spacing apart of these beads is thus 17mm. This spacing is preferably from 12mm to 20mm. The centre of the valley between the middle and lower beads is preferably located from 80mm to 90mm from the upper region 47.

To complete the pail body ready for the reception of a lid, the bottom of the pail must be secured to the lower rim of the pail wall. This may be carried out on the same forming line as used to produce the compound curl at the upper rim 26 of the pail body and is preferably done in such a way as to produce a bottom seam of a similar standard to the head seam which, as will be described below, can be produced using the compound curl described above.

Fitting of the lid 73 to complete the pail 20 is carried out after filling the pail. As shown in Figure 1, the lid 73 has a channel 74 formed around its periphery and at regular intervals, closely spaced, around the lid are downwardly directed flanges 75. The channel

74 is partly filled with a sealing compound 76 (preferably a synthetic rubber) which is run into the channel (with the lid inverted) in liquid state and caused or allowed to solidify to a degree such that it can still flow under pressure to form a seal. Preferably, the meniscus of the sealing compound 76 in the channel 74 is concave producing a more even distribution of the sealing compound in the head seam than would otherwise be the case. This can be achieved either by choice of a sealing compound with a suitable surface tension in relation to the metal of the lid 73 or by deforming the surface of the sealing compound at a suitable stage during its solidification.

To apply the lid 73 to the pail body 21, the lid is placed on the upper rim 26 of the pail body 21 so that the compound curl 46 is located in the channel 74. A closing tool 80 as shown in Figures 8 and 9 is then used to clamp the lid 73 onto the pail body 21 and thus complete the head seam between the pail body 21 and the lid 73.

The closing tool 80 comprises a central pillar 81 on which are pivoted two levers 82 connected by linkages 83 to a spider 84 having a central collar 85 slidable on the pillar 81. Extending radially outwardly from the collar 85 at closely spaced intervals are brackets 86. Only two brackets 86 are shown in Figures 8 and 9 and the linkages 83 are connected to these but each bracket 86 has pivotally secured to it an arm 87 and each arm 87 is pivotally connected to an associated closure element 88. Each closure element 88 is pivotally mounted on a lug (not visible in Figures 8 and 9) on a circular base 89 which carries the pillar 81.

In using the closing tool 80, the operator places the tool centrally on the lid 73 already located on the pail body 21 so that each of the closure elements

is opposite a respective one of the flanges 75. The operator then presses down on the levers 82 moving the spider 84 downwardly on the pillar 81 and causing hooked ends 90 of the closure elements 88 to engage the flanges 75 as shown in Figure 10 (which shows the compound curl 46 partly deformed) thus deforming them around the compound curl 46 and forming a head seam as shown in Figure 11.

The closing tool 80 is similar to previous closing tools but differs in that its base 89 is formed with a downward extension 92 which is dimensioned to contact the lid 73 when the tool is in use (see Figure 10). The lid 73 is formed with two annular corrugations 93 and the contact between the lid 73 and the extension 92 takes place in a central region of the lid inwardly of the corrugations 93 and in this instance between the lid and an annular bead 94 on the extension 92. The base 89 of the closing tool 80 is different from that of a conventional closing tool for head seams in this respect in that the base of the conventional tool does not have a downward extension such as the extension 92 and the peripheral region of the base contacts the bottom part of the channel 74. The action of the closing tool 80 in forming the head seam thus differs from the conventional closing action and the presence of the corrugations 93 in the lid 73 assist in this action, in that when the annular bead 94 on the base 89 presses down the centre part of the lid, an outward movement of the metal of the lid is produced in the region of the upper rim 26 of the pail body 21. This has the effect of pushing extra metal into the head seam which assists in the formation of a tighter, more resilient seam less susceptible to opening up on impact if the pail is dropped. The outward movement may be explained by the downward pressure of the closing tool 80 on a central region of the lid 73 producing a tendency at least for the inner corrugation, with a downwardly directed depression 93, to

to straighten out and occupy a greater horizontal distance.

It is believed that a single corrugation 93 in the lid 73 will assist in this action but it is preferred to have two corrugations to obtain the desired effect.

5 Three corrugations may be desirable in some cases.

A head seam made as set out in the example described above will satisfy drop tests and pressure tests when filled with liquid which are superior to those survivable by conventional five fold seams.

10 It is usual to weld to the pail body at some stage during manufacture a pair of ears for reception of a wire handle. In the example described above, the ears may be located between the upper (55) and middle (56) beads.

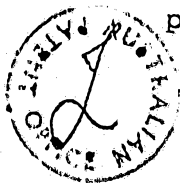
15 The three beads in the pail wall described in the above example of the invention serve, if the pail is dropped, to provide regions where distortion of the pail wall can occur, reducing the degree of distortion of the head seam so that the head seam is less likely to leak. If the pail drops on its side, the beads partly collapse accommodating the handle of the pail which is thus less likely to puncture the pail wall. The lower bead 54 serves as a nesting device when one pail is inserted in another and also absorbs surge pressures created in liquid in the pail when the pail is dropped on its side, thus reducing the risk of these pressures affecting the head seam. When the pail is dropped onto its lid, the upper bead allows the pail wall to deform outwardly, permitting the lid to move down into the pail body, thus protecting the head seam. The outward deformation, or bulge, of the pail body at the upper bead usually presses against the head seam and assists in holding the lid in position.

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In the head seam in the example of the invention, described above, the sealing compound 76 (Figure 11) is spread throughout, or substantially throughout, the space between a base 98 of the channel 74 and the upper region 47 of the compound curl 46. Further, the base 98 follows the general line of the curve of the upper region 47 although at a greater radius and there is general conformity between the deformed channel 74 and flange 75 of the lid and the associated parts of the compound curl 46. In fact the channel 74 and the flange 75 are in close contact with the outer part 50 and lower region 48 of the compound curl and the pail wall 33, lid wall 99 (the inside of the channel 74) and each flange 75 are parallel and close to one another or in contact throughout the whole or substantially the whole of the length of each flange 75. Additionally, the upper region 47 is supported by a region 100 of the pre-curl (originally the lower region of the pre-curl 30) which is in contact with it over a substantial distance. This support which adds to the strength of the compound curl and the tightness (comparatively small cross-wise dimensions) of the compound curl enable the lid to be clamped onto it securely and the compound curl yet retains sufficient resilience to maintain a clamping action on the associated parts of the lid. In particular, an inner region 101 of the lower region 48 of the compound curl is straight and obliquely inclined in Figure 11 and is urged against an adjacent part 102 of the wall of the channel 74 of the lid thus tending to trap the part 102 and the associated flange 75, which lie at an acute angle, against the pail wall 33. In fact, therefore, as shown in Figure 11, the inner region 101 of the lower region 48 of the compound curl 46 lies at the same acute angle to the pail body 21 as the angle between the part 102 of the wall of the channel 74 and each flange 75. Further, as also shown in Figure 11, the rim edge part adjacent to the rim edge 28 is further curled by the operation of clamping the lid 73 in place, by crimping home the flanges 75, so that the rim



edge part extends in a direction downwardly in the Figure and generally towards the pail body 21. Before clamping the lid 73 onto the pail body 21, the smaller pre-curl 30 formed by the lower region 48 and the rim edge part 28, and, as shown in Figure 7, constituting an inner curl of the compound curl 26 is spaced below, and thus the rim edge part is spaced below, the upper region 47 of the compound curl. In clamping on the lid, the region 100 (Figure 11) of the rim edge part is brought into supporting engagement with the upper region 47, as described above.



CLAIMS

1. A pail body having a pail wall with a longitudinal axis and a curled rim for receiving a lid, the curled rim being in the form of a compound curl formed by pre-curling a rim edge part adjacent to the rim edge of the pail wall outwardly, then in the direction of the longitudinal axis and then inwardly, relative to the pail body to form a pre-curl and cause the said rim edge to lie adjacent the outside of the pail wall, and then further curling the rim to produce a compound curl in which the rim edge part closest to said rim edge of the pre-curl extends in a direction away from the pail wall and is located intermediate an upper and a lower region of the compound curl, said rim edge of the pre-curl being the part thereof that makes the closest approach to the inside surface of the remainder of the compound curl, prior to offering a lid to the pail body.

2. A pail body according to claim 1, wherein an inner part of the compound curl including the inner periphery of the said lower region is spaced from the pail wall.

3. A pail body according to claim 2, wherein the said lower region and the said rim edge part constitute a smaller pre-curl within the compound curl, the rim edge part being spaced below the said upper region so that in clamping on the lid, some part of the said rim edge part is brought into supporting engagement with the said upper region.

4. A pail body according to any one of the preceding claims having three circumferential beads in the pail body in the vicinity of the said curled rim, the three beads comprising a single comparatively shallow bead comparatively close to the said rim with a compound curl and a pair of closely spaced comparatively large beads at a comparatively



large distance from the said rim with a compound curl.

5. A pail body according to claim 4 wherein the shallow bead is located no less than 20 mm and no more than 35 mm from the said upper region of the compound curl and has a height from the pail wall of from 1 mm to 3 mm.

6. A pail body according to claim 4 or 5 wherein the spacing apart of the high points of the large beads is from 12 mm to 20 mm and the centre of the valley between the large beads is located from 80 mm to 90 mm from the said upper region.

7. A method of manufacturing a metal pail body having a pail wall with a longitudinal axis and a curled rim for receiving a lid, the method comprising the steps of:

(a) forming a pre-curl on the rim of the pail body by curling a rim edge part adjacent to the rim edge of the pail wall outwardly, then in the direction of said longitudinal axis and then inwardly relative to the pail body to cause the said rim edge to lie adjacent to the outside of the pail body,

(b) expanding the diameter of the pail body at the rim so that the pail body tapers to become narrower in the direction of the longitudinal axis away from said rim, thereby tightening the pre-curl and reducing the cross-sectional diameter of the pre-curl, and

(c) performing another curling operation on the rim to produce a compound curl and leave the said rim edge part closest to the rim edge of the pre-curl extending in a direction away from the pail body and located intermediate an upper and a lower region of the compound curl, and in which the



said rim edge of the pre-curl is the part that makes the closest approach to an inside surface of the remainder of the compound curl, prior to offering a lid to the pail body.

5 8. A method according to claim 7, including performing the said another curling operation so as to produce a compound curl wherein an inner part of the compound curl including the inner periphery of the said lower region is spaced from the pail wall.

10 9. A method according to claim 7, including performing the said another curling operation so as to produce a compound curl wherein the said rim edge part closest to the rim edge is spaced below the said upper region.

15 10. A method of manufacturing a pail including the step of applying to a pail body as claimed in any one of claims 1 to 6 or to a pail body produced by the method claimed in any one of claims 7 to 9 a lid comprising a channel and applying the lid so that the said compound curl is located in the channel and subsequently clamping the lid
20 onto the pail body by deforming downwardly extending flanges on the lid around the compound curl so that the channel is in close contact with an outer part and the said lower region of the compound curl, and each flange is in close contact with part of the said lower region and with
25 an upper part of the pail wall, and each flange and an adjacent part of the channel lie at an acute angle to one another and are trapped between the compound curl and the pail wall.

30 11. A method of manufacturing a pail including the step set out in claim 10, wherein, in deforming the said flanges, an inner region of the lower region of the compound curl is deformed so as to be straight and obliquely inclined to the pail wall and is urged against an adjacent part of the wall of the channel, and the said rim edge part



of the compound curl is further curled so as to extend in a direction towards the pail body.

12. A pail whenever manufactured by the method claimed in claim 10 or 11.

5 13. In the operation of the method of any one of claims 7 to 12, the use of a rim-forming line for the manufacture of pail bodies comprising stations for carrying out the following operations:

- 10 a) an operation for forming the pre-curl on the rim of the pail body,
- b) an operation for expanding the pail body so that it tapers to become narrower in the direction away from the said rim, and
- 15 c) an operation for carrying out another curling operation on the said rim to produce the compound curl.

14. A rim-forming line according to claim 13 also including at least one station for forming three circumferential beads in the pail body in the vicinity of the said curled rim, and comprising a comparatively shallow bead comparatively close to the said curled rim and a pair of closely spaced comparatively large beads at a comparatively large distance from said curled rim.

20

25 15. In the operation of the method of claim 10, the use of a closing tool for applying a lid to a pail body, the closing tool including a base having a downward extension dimensioned to contact a central region of the said lid, when the closing tool is in use, and also including, carried by the base, a central pillar on which are pivoted levers connected by linkages to a spider having a central mounting slidable on the pillar and wherein brackets



carried on the mounting pivotally carry arms each connected to an associated closure element pivoted on the base.

16. A method according to claim 10 or claim 11, wherein the lid has a channel which accommodates the curl
5 around the rim of the pail body and has flanges which are to be clamped beneath the said curl against the wall of the pail body, and wherein pressure is applied in a central region of the lid as the flanges are clamped home.

17. A pail body having a lid applied by the method
10 claimed in claim 16.

18. A pail body according to claim 1 having a compound curl substantially as hereinbefore described with reference to Figures 5, 6 and 7 of the accompanying drawings.

15 19. A method of manufacturing a pail body according to claim 7, substantially as hereinbefore described with reference to Figures 1 to 7 of the accompanying drawings.

20. A pail having a lid applied to a pail body according to claim 18 in the manner hereinbefore described
20 with reference to Figure 11 of the accompanying drawings.



around the rim of the pail body and has flanges which
are to be clamped beneath the said curl against the wall
of the pail body, and wherein pressure is applied in
a central region of the lid as the flanges are clamped
5 home.

17. A pail body having a lid applied by the method
claimed in claim 16.

18. A pail body having a compound curl substantially
as hereinbefore described with reference to Figures 5,
10 6 and 7 of the accompanying drawings.

19. A method of manufacturing a pail body substant-
ially as hereinbefore described with reference to Figures
1 to 7 of the accompanying drawings.

20. A pail having a lid applied to a body of the
15 pail in the manner hereinbefore described with reference
to Figure 11 of the accompanying drawings.

21. A rim-forming line for the production of pail
bodies substantially as hereinbefore described with refer-
ence to Figures 12, 2, 3 and 4 of the accompanying
20 drawings.

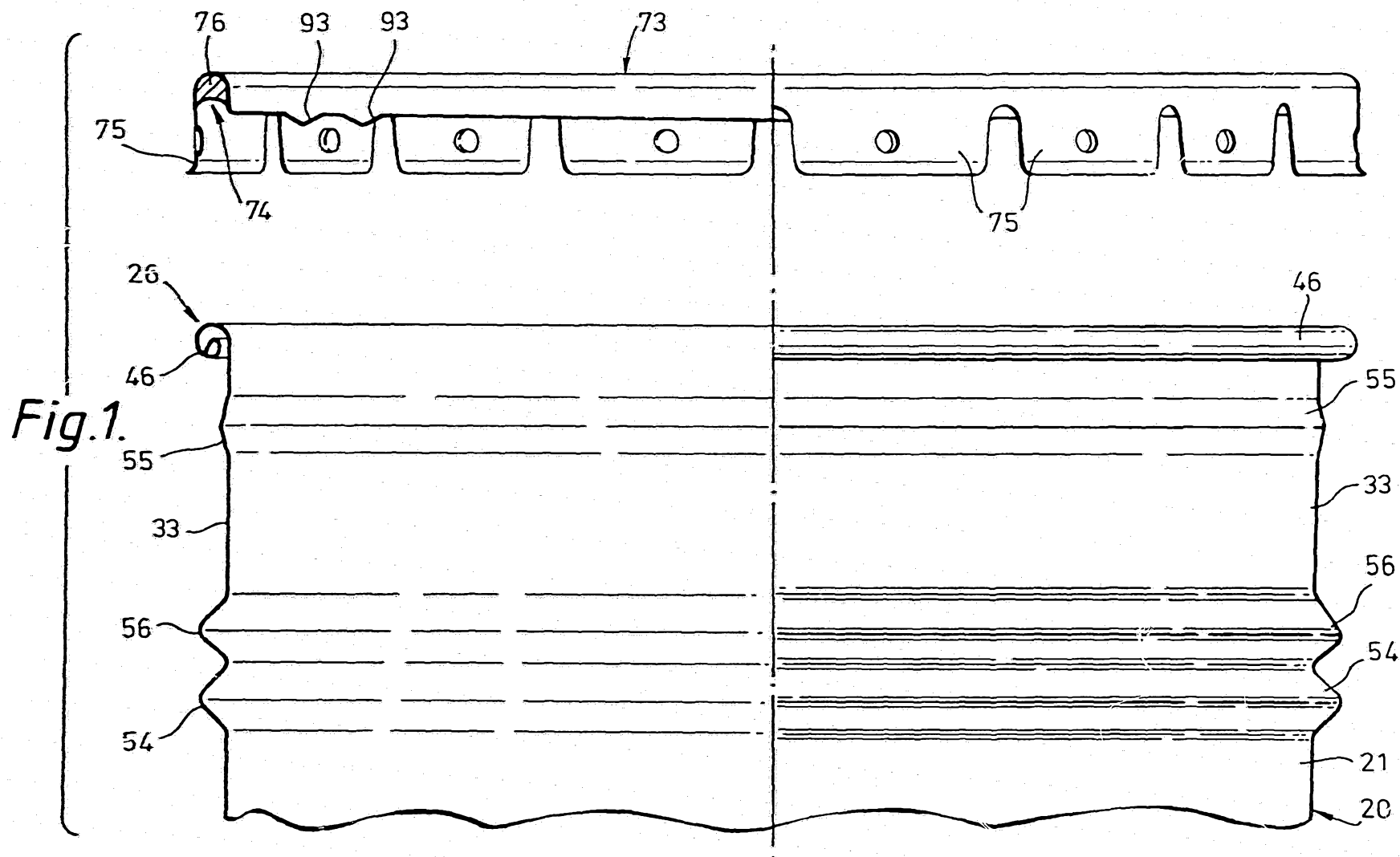
22. A closing tool for applying a lid to a pail
body as claimed in claim 1, the tool being substantially
as hereinbefore described with reference to Figures 8
and 9 and operating in the manner illustrated in Figure
25 ~~10 of the accompanying drawings.~~

~~DATED THIS 14th day of April, 1987~~

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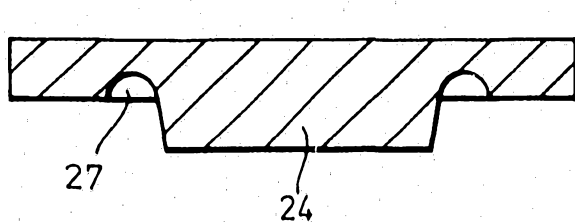


Fig. 2.

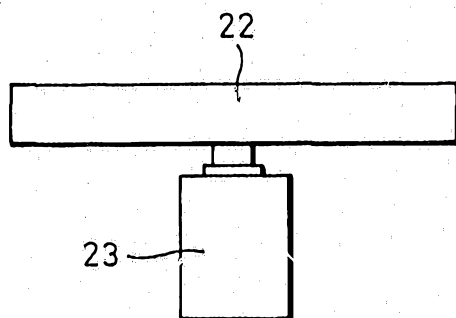


Fig. 3.

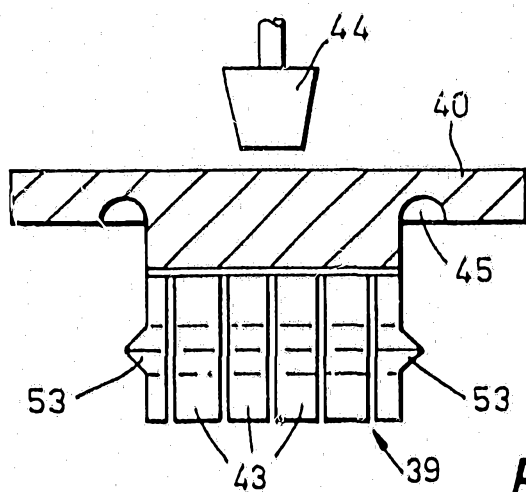
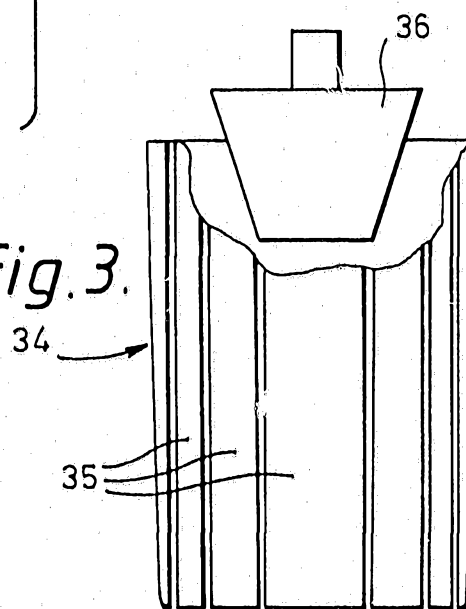
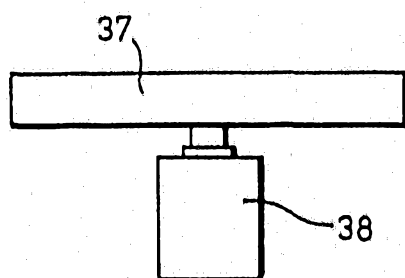


Fig. 4.



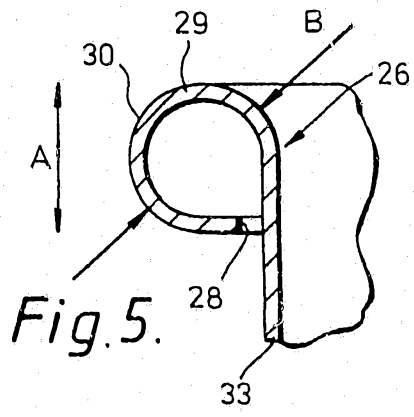


Fig. 5.

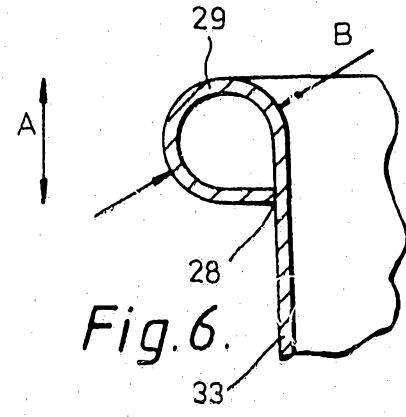


Fig. 6.

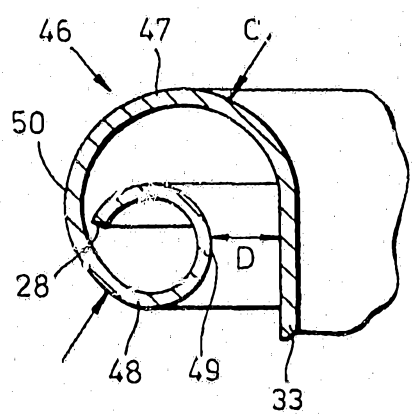


Fig. 7.

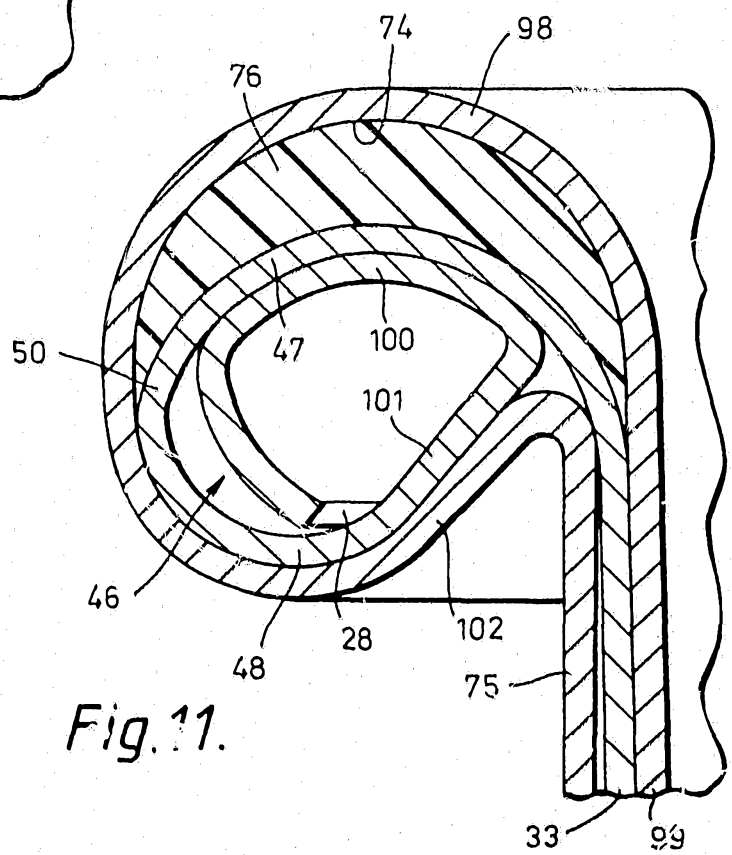


Fig. 11.

Fig. 8.

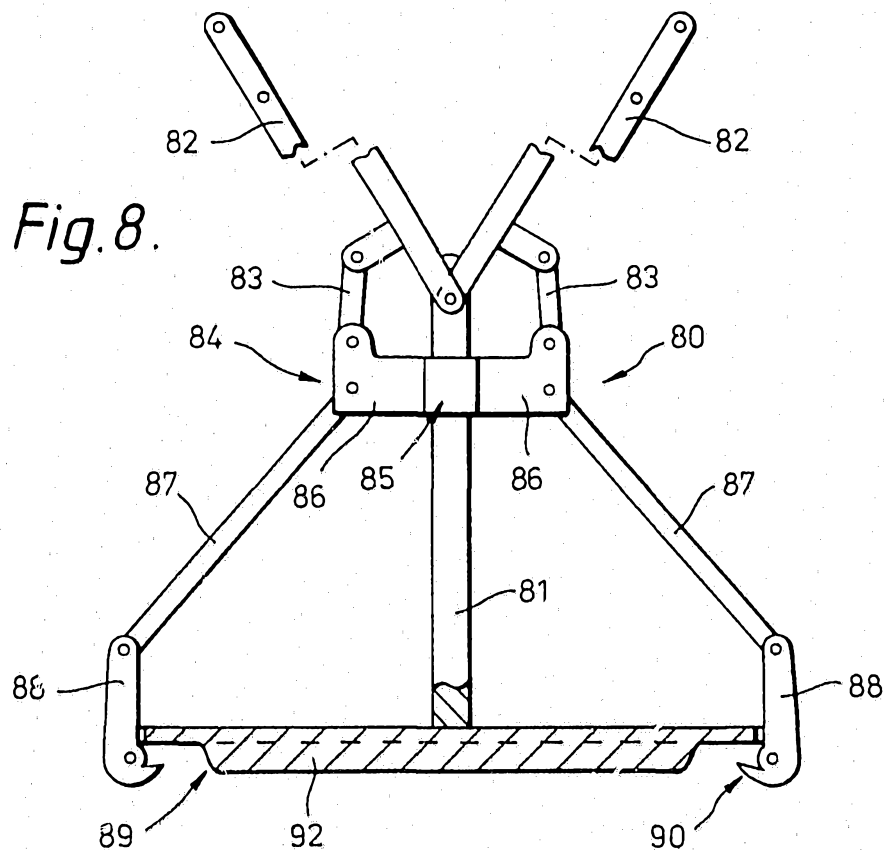
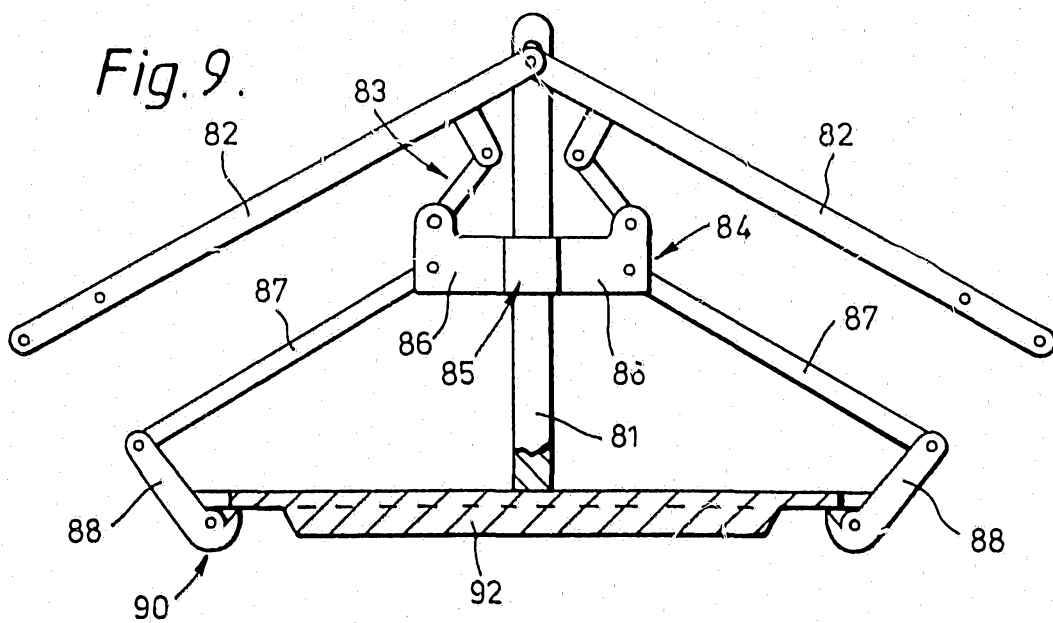
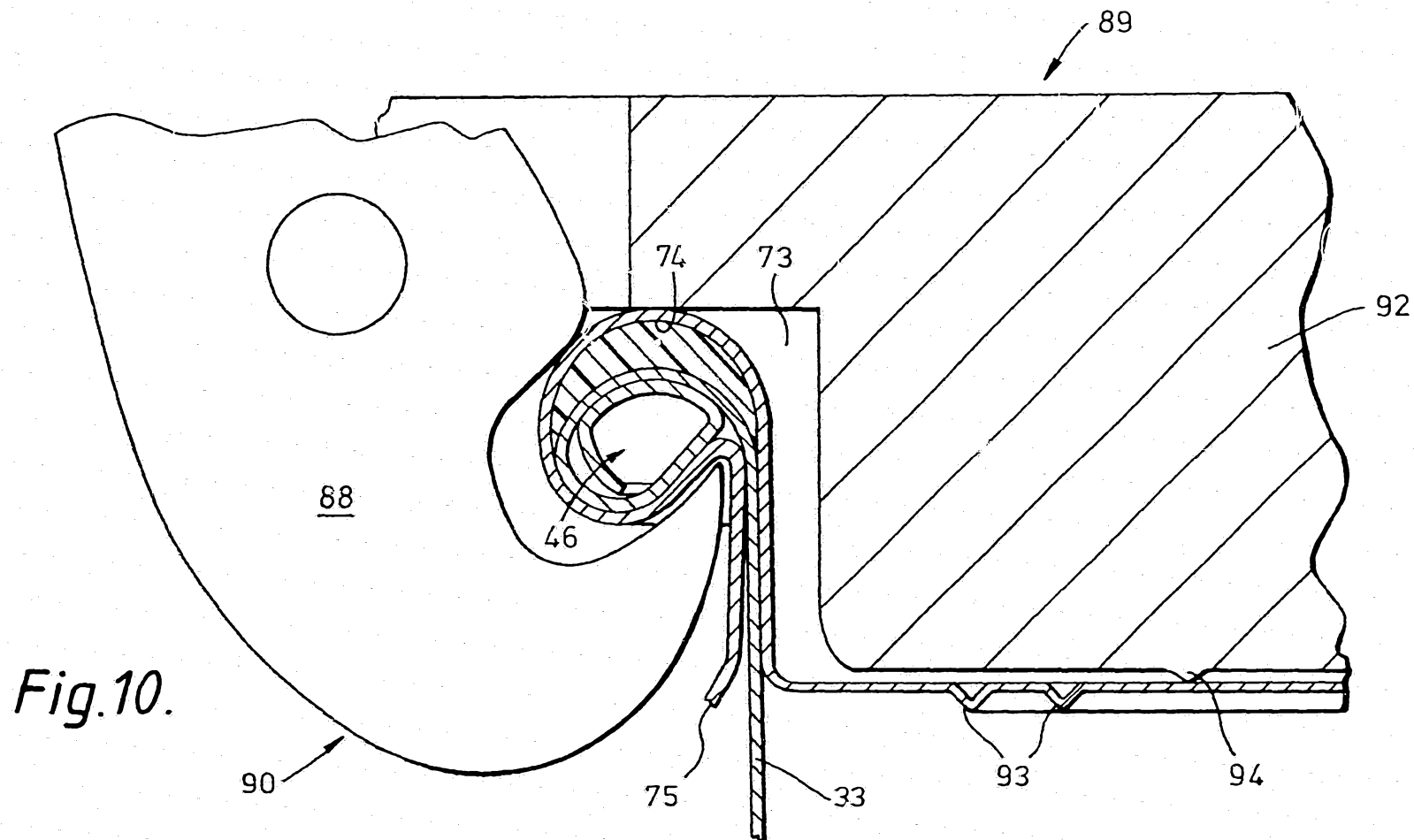


Fig. 9.





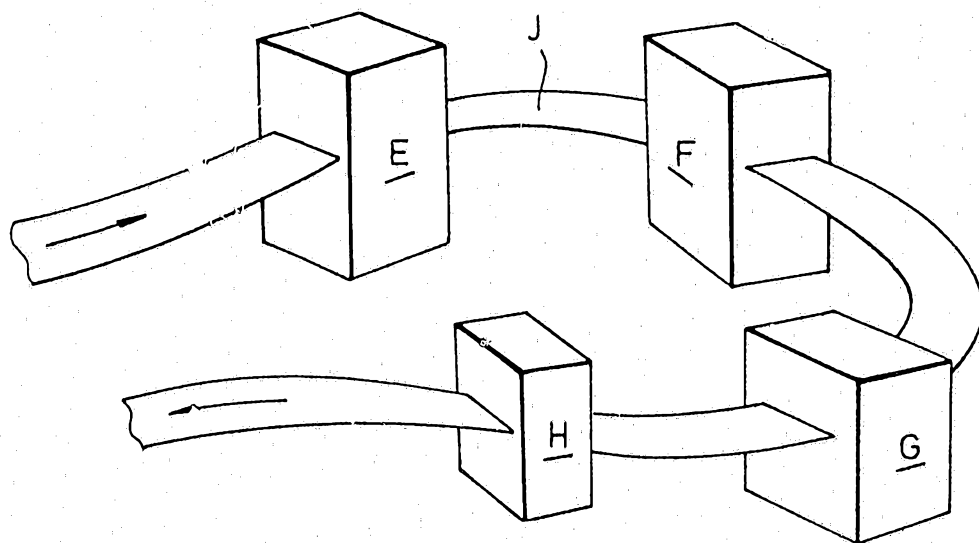


Fig.12.