No. 877,321. PATENTED JAN. 21, 1908.

J. H. W. GEBLER.

PROCESS OF MANUFACTURING SHEET IRON VESSELS.

APPLICATION FILED DEC. 20, 1905.

Fig. 1.

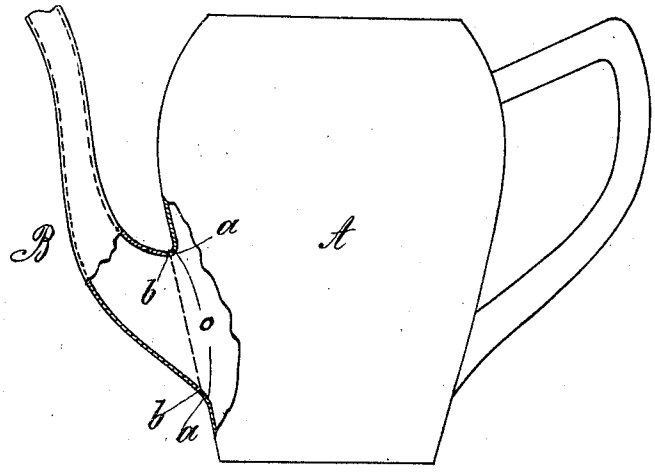


Fig. 2.

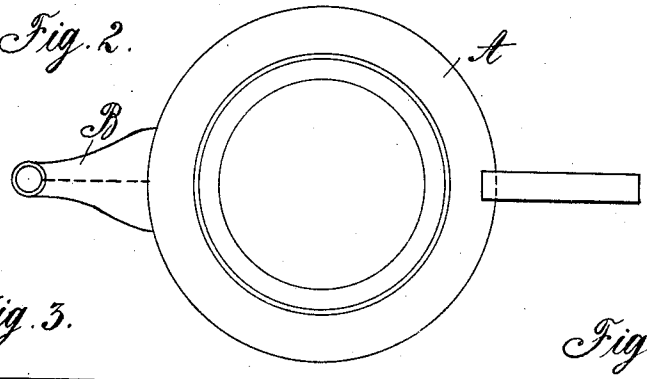


Fig. 3.

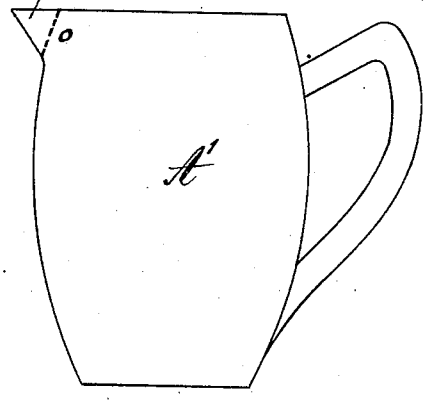
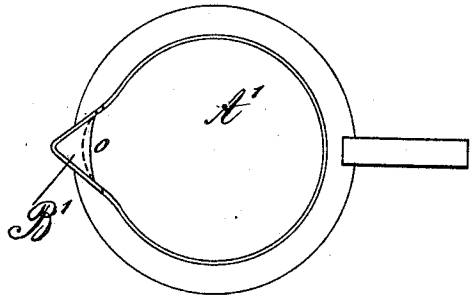


Fig. 4.



Witnesses:

Inventor:

UNITED STATES PATENT OFFICE.

JOHANN HERMANN WALTER GEBLER, OF PIRNA, GERMANY.

PROCESS OF MANUFACTURING SHEET-IRON VESSELS.

No. 877,321. Specification of Letters Patent. Patented Jan. 21, 1908.

Application filed December 20, 1905. Serial No. 292,609.

To all whom it may concern:

Be it known that I, JOHANN HERMANN WALTER GEBLER, a citizen of the Empire of Germany, residing in Pirna, in the Kingdom of Saxony and Empire of Germany, have invented certain new and useful Improvements in Processes of Manufacturing Sheet-Iron Vessels, of which the following is a specification.

This invention relates to the manufacture of sheet-iron vessels provided with spouts which are united thereto by means of the oxyhydrogen flame, so that no protruding seams are formed, and the invention relates more specifically to the manufacture of sheet-iron vessels which are to be coated by enamel.

The object of this invention is to form the connection between sheet-metal vessels and spouts in such a manner that no projecting seams, either towards the inside or outside, are formed and that they have the appearance as if they were made from one integral piece of sheet-metal, whereby not only the appearance of the vessels is greatly improved, but also the disadvantages connected with the enameling of the same are entirely obviated.

The novel features of the process will be hereinafter described and claimed.

In the accompanying drawings, Figure 1 represents a side-elevation of a sheet-iron vessel, showing its connection with its spout, Fig. 2 is a plan-view of Fig. 1, Fig. 3 is a side-elevation of a sheet-iron vessel with a lip-shaped spout, and Fig. 4 is a plan-view of Fig. 3.

Similar letters of reference indicate corresponding parts in the different figures of the drawings.

Referring to the drawings, A represents a sheet-metal vessel which is drawn in one integral piece by any known process. At the point where the spout B is to be attached to the vessel an opening *o* is formed, which corresponds in size and shape to the shape of the lower end of the spout to be joined thereto. The edge *a*, *a* of the opening *o* is slightly bent up so that it fits exactly to the adjacent edge *b* of the spout B. The edges *a*, *a* and *b*, *b* are placed in abutment with each other and united by subjecting them to the influence of the oxyhydrogen flame. The edges are thereby united by a seamless weld-joint, without any projection or unevenness, for the reason that the wall of the vessel A is welded directly, and without any joint visible to the eye, to the body of the spout B. The dotted line in Fig. 1 denotes the weld-joint between the vessel A and spout B, and the dotted lines in Figs. 3 and 4 denote the lip-shaped spout B^1, which is united by a seamless weld-joint, in the same manner, to the body of the vessel A^1, the body being provided, in this case, with a recess at its upper edge, to the edges of which recess the lip-spout is welded. After the joint has been formed in the manner described, the vessel is enameled.

The advantages of the improved sheet-iron vessels are, firstly, that the spouts are attached to the same by a weld-joint, without difficulty, by the well-known oxyhydrogen flame; secondly, that by the weld-joint between the vessel and spout a smooth and pleasing appearance is imparted to the vessels after they are enameled; thirdly, that by the seamless connection of vessels and spouts a new, durable and attractive line of hollow enameled-ware is obtained.

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

The process of manufacturing sheet-iron vessels, which consists in bending up the edge of the opening in the body of the vessel to which the spout is to be applied, placing the edge of the spout against the edge of said opening and in direct alinement therewith, uniting the parts by subjecting them to the action of an oxyhydrogen flame, and then enameling the vessel.

In testimony, that I claim the foregoing as my invention, I have signed my name in presence of two subscribing witnesses.

JOHANN HERMANN WALTER GEBLER.

Witnesses:

CARL GREIERT,

PAUL ARRAS.