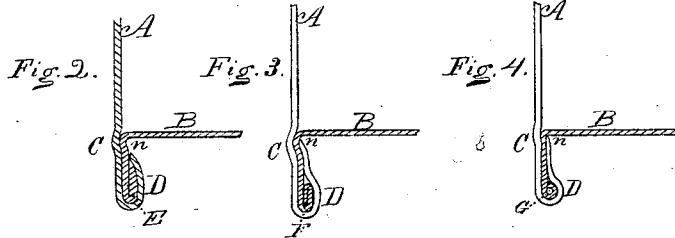
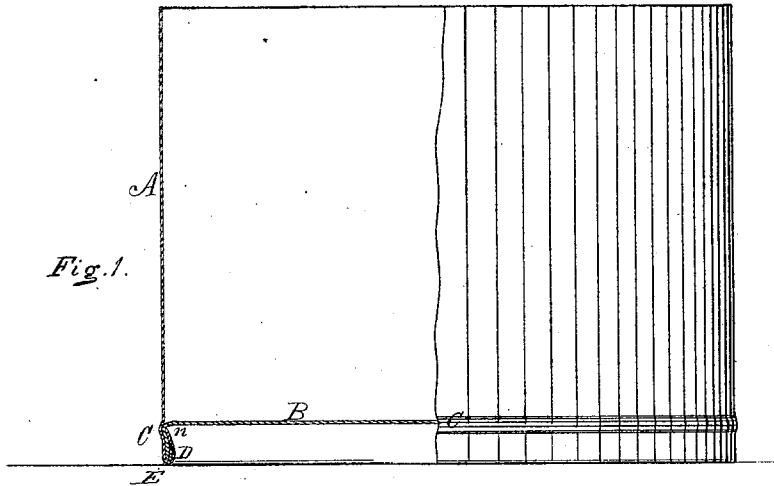


W. C. BRUSON.

Bottoming Sheet-Metal Ware.

No. 132,895.

Patented Nov. 12, 1872.



Witnesses

E. J. Chapin
E. J. Chapin

Inventor

Willard C. Bruson

UNITED STATES PATENT OFFICE.

WILLARD C. BRUSON, OF CHICAGO, ILLINOIS.

IMPROVEMENT IN BOTTOMING SHEET-METAL WARE.

Specification forming part of Letters Patent No. 132,895, dated November 12, 1872.

To all whom it may concern:

Be it known that I, WILLARD C. BRUSON, of Chicago, in the county of Cook and State of Illinois, have invented a new and useful Improvement in Bottoming Sheet-Metal Ware, of which the following is a specification:

The nature of the present invention consists in enlarging or increasing the thickness of the lower part of the flange of the bottoms of sheet-metal ware, so that when it is clamped between the doubled edge of the lower part of the body of such ware the bottom will be held firmly in place, requiring no solder when dry cans or dry packing-boxes are made, and in stretching the bottom so as to make it very solid and firm, as the whole is hereinafter fully described and shown.

In the drawing, Figure 1 is a vertical sectional elevation of a can provided with a bottom secured according to my improvement. Figs. 2, 3, and 4 are enlarged views of the device, Figs. 3 and 4 being modifications of Figs. 1 and 2.

A represents the body of a can, and B the bottom. This bottom, as shown at Figs. 1 and 2, is provided with a downwardly-projecting flange, whose lower part is made double, as shown at E, by bending the lower part of the flange inward or upward and pressing or rolling it down flat against its adjoining part. The lower part or body A of the can is turned inward and upward, as shown at D, to receive the enlarged part E, and after the latter has

been placed between A and B the upper or top part is rolled so as to form a bead, C, and so as to fit closely into the concave *n*. The entire labor is now done by suitable machinery, and if the several parts are constructed as described the bottom B cannot be removed by any ordinary wear or tear; and if the can is used for dry packing no solder is required; but if liquids are to be held a small amount of solder is to be put on the inside angle. The tool which forms the bead C stretches the bottom B and makes it very firm and strong. Fig. 3 represents the lower part of the flange of bottom enlarged by three thicknesses instead of two; and Fig. 4 shows the flange enlarged by means of a wire, G, held in place by having the sheet metal bent around it. Any one figure is considered an equivalent of the others.

In this method not only a large amount of solder can be saved, but a can is provided with a stronger bottom rim to serve as a support, while the bottom is stretched so as not to sag.

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

The enlarged flange E or its equivalent, constructed and combined with the body A, as described.

WILLARD C. BRUSON.

Witnesses:

G. L. CHAPIN,
E. J. CHAPIN.