

G. W. WEBER.
SEAMLESS OR DRAWN SHEET METAL CAN.
APPLICATION FILED JUNE 21, 1907.

932,597.

Patented Aug. 31, 1909.

Fig. 1

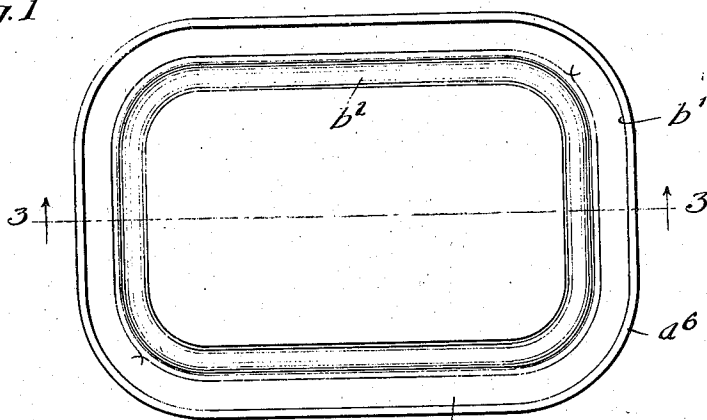


Fig. 2

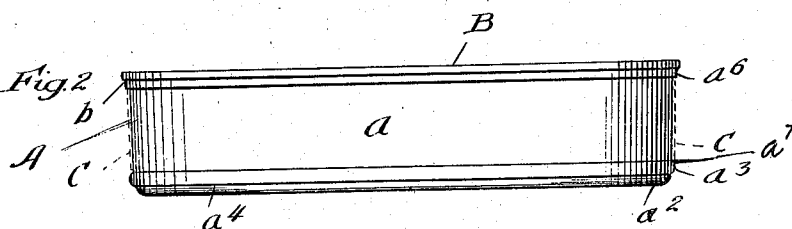
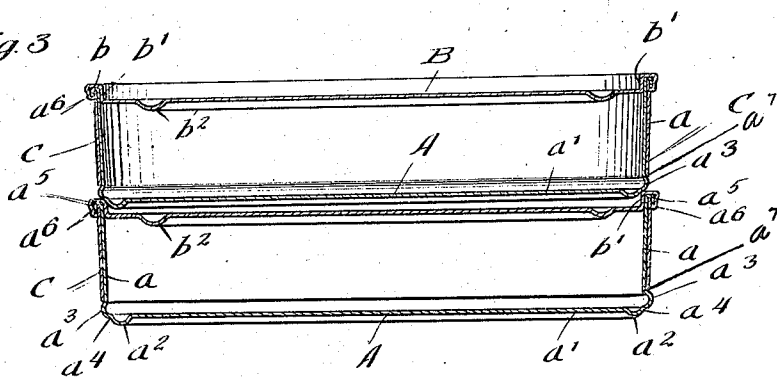


Fig. 3



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UNITED STATES PATENT OFFICE.

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SEAMLESS OR DRAWN SHEET-METAL CAN.

932,597.

Specification of Letters Patent.

Patented Aug. 31, 1909.

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To all whom it may concern:

Be it known that I, GEORGE W. WEBER, a citizen of the United States, residing in New York, in the county of New York and State of New York, have invented a new and useful Improvement in Seamless or Drawn Sheet-Metal Cans, of which the following is a specification.

My invention relates to improvements in the construction of seamless or drawn cans.

Heretofore in the practical manufacture and use of seamless or drawn cans of rectangular or other shapes, such as are commonly used for preserving sardines and other articles, and in which the body and bottom head of the can are in one piece or integral with each other, the lower rounded corner of the can which unites the slightly tapering body with the integral bottom head is materially thinned and weakened by the drawing operation, and rendered liable to denting, fracture or other injury; and great difficulty has heretofore been experienced in keeping the labels from slipping off the body owing to the taper shape of the drawn body and the lack of any shoulder at the bottom end of the body to keep the label in place, a difficulty which is accentuated by the unavoidable greasy surface of the body from the sardines or other fish put up in the cans; and the drawing operation also disturbs or roughens the tin coat surface of the can body and destroys its bright tin luster so that the body of the can not only cannot be practically covered by the label as before stated, but cannot be successfully or practically decorated, and the can as a whole presents a somewhat cheap and unsightly appearance which militates against its use, especially for the finer qualities of goods, owing to the taper shape and unbalanced form of the can as a whole, and to the lack of any efficient decoration or labeling of its body.

The object of my invention is to provide an improved construction of drawn or seamless can which will obviate or overcome the difficulties heretofore experienced.

My invention consists in a drawn can having its slightly tapering body provided with a peripheral bead near its lower end, which serves not only to materially stiffen and strengthen the thinned and weakened lower corner of the can, but also forms an external shoulder to hold the label in place, so that the body of the can can be readily and success-

fully labeled, and which also serves to substantially overcome the unbalanced or tapering appearance of the can as a whole and to make it appear as a can with a straight body, and which marginal bead also forms a nesting shoulder so that the cans can be readily nested one on top of another; the portion of the can body below the peripheral bead of one can fitting within the countersunk cover of the can below it when the cans are nested together.

In the accompanying drawing forming a part of this specification, Figure 1 is a plan view of a drawn can embodying my invention. Fig. 2 is a side elevation. Fig. 3 is a section on line 3—3 of Fig. 1, and showing also a plurality of cans nested together.

In the drawing, A represents the seamless or drawn body and bottom of the can, the same being made in one piece by suitable drawing dies. The body portion *a* is of the necessary slightly tapering form required for facilitating the drawing operation and the practical manufacture of the cans in this way. The bottom portion *a'* of the can is provided with a marginal bead *a''* which may be and preferably is formed by the drawing dies in the drawing operation. The slightly tapering body portion *a* is furnished at its lower or bottom head end *a'* with a peripheral bead *a''*, which is formed in the body of the vessel by a separate beading operation after the can is drawn. The seamless or drawn body and bottom A also has a tapering or flaring corner portion *a'* connecting the body bead *a''* and bottom bead *a'*. The seamless or drawn body and bottom A has at its upper end a seaming flange *a'* which is folded into a double seam *a'* with the seaming flange *b* of the countersunk cover B. The countersunk wall *b'* of the cover B fits within the upper end or mouth of the body portion *a* and the cover B is also preferably furnished with an inwardly projecting bead *b''*. The slightly tapering portion *a'* of the body *a* below the externally projecting peripheral bead *a''* is adapted to fit within the countersink of the cover B, as clearly indicated in Fig. 2, so that the cans will snugly nest, one on top of another. The externally projecting peripheral bead *a''* thus forms an external shoulder to engage the upper end of the adjacent can when the cans are nested together.

As illustrated in the drawing, the can is of a rectangular form, such as is commonly

used for sardines. My improved drawn can may, however, be made of other shapes and used for preserving any articles desired.

C represents the label applied to the body of the can, and fitting between the upper external shoulder formed by the seam a^2 and the lower external shoulder on the body formed by the peripheral bead a^3 , and which shoulders serve to hold the label in place and prevent it from slipping off the can. The externally projecting peripheral bead or shoulder a^3 at the lower end of the rectangular body of the can also serves to protect the label surface of the cans from marring or injury by preventing other cans from rubbing against and disfiguring the label when piled or boxed together for shipment.

I claim:—

1. A drawn can having an integral bottom head and body and an external peripheral seam shoulder at the upper end of its body, and an externally and laterally projecting peripheral bead at the lower end of its body above said bottom head, in combination with a label held in place by said shoulders, substantially as specified.

2. A seamless drawn can having an integral bottom head and body and its body provided at its bottom head end with an externally and laterally projecting peripheral bead above said bottom head, substantially as specified.

3. A seamless drawn can having an integral bottom head and body and its body pro-

vided at its bottom head end with an externally and laterally projecting peripheral bead, and its integral bottom portion provided with an externally and downwardly projecting marginal bead, substantially as specified.

4. A seamless drawn can having an integral bottom head and body and its body provided at its bottom head end with an externally and laterally projecting peripheral bead, and its integral bottom portion provided with an externally and downwardly projecting marginal bead, said can having a tapering portion uniting said beads on the body portion and bottom portion, substantially as specified.

5. A seamless drawn can having an integral bottom head and body and its body provided at its bottom head end with an externally and laterally projecting peripheral bead, and its integral bottom portion provided with an externally and downwardly projecting marginal bead, said can having a tapering portion uniting said beads on the body portion and bottom portion, said can having a countersunk cover with which the beaded body and bottom portion of the can is adapted to nest when a plurality of cans are placed one on top of each other, substantially as specified.

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