

J. GERARD.
Sheet-Metal Vessel.

No. 197,624.

Patented Nov. 27, 1877.

Fig. 1.

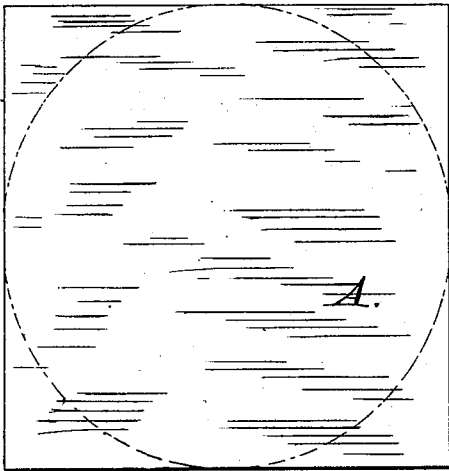
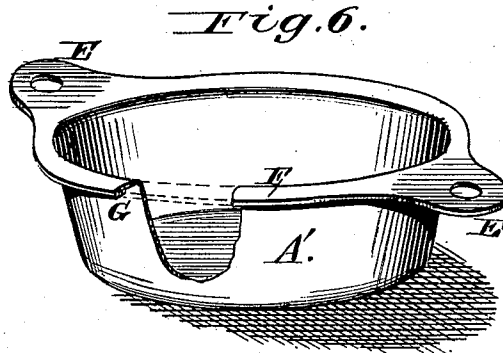
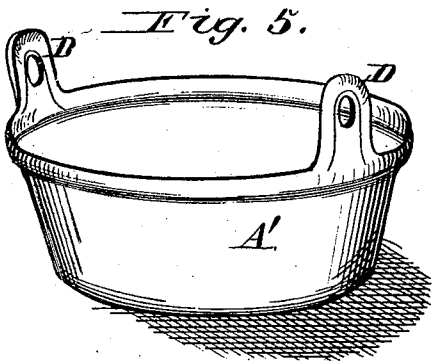
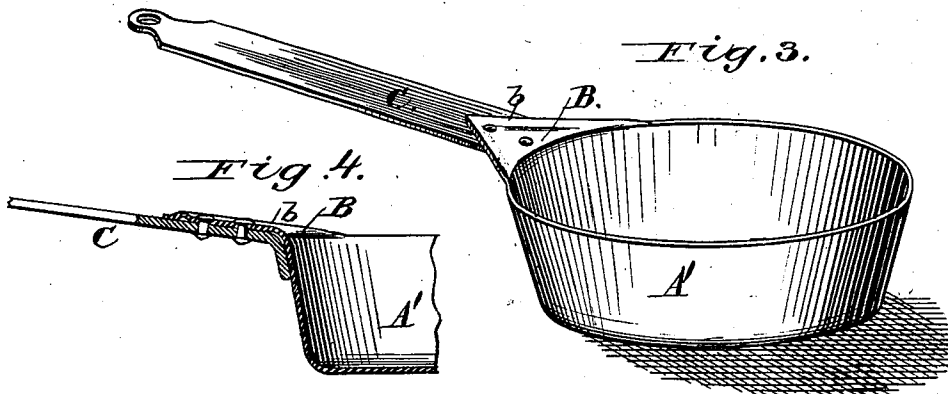
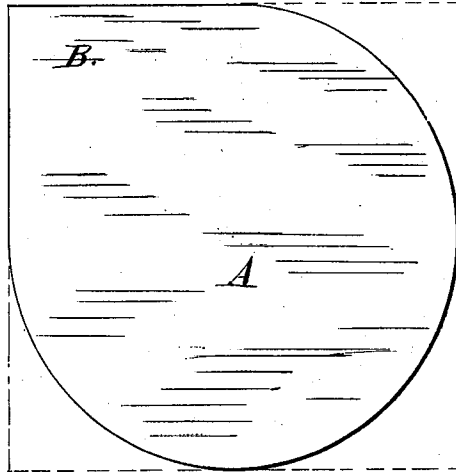


Fig. 2.



Attest:
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UNITED STATES PATENT OFFICE.

JOSEPH GERARD, OF WOODHAVEN, ASSIGNOR TO LALANCE & GROSJEAN MANUFACTURING COMPANY, OF NEW YORK, N. Y.

IMPROVEMENT IN SHEET-METAL VESSELS.

Specification forming part of Letters Patent No. **197,624**, dated November 27, 1877; application filed October 31, 1877.

To all whom it may concern:

Be it known that I, JOSEPH GERARD, of Woodhaven, in the county of Queens and State of New York, have invented certain new and useful Improvements in Sheet-Metal Vessels, of which the following is a specification:

This invention relates to certain improvements in the construction of that class of sheet-metal vessels and utensils which are stamped or spun up out of a blank of sheet metal; and its object is to prevent the waste that occurs in the formation of the blanks as heretofore constructed, and provide said vessels or utensils with a strong and durable base for the attachment of the handles, or with bail-ears or handles, or a lip or spout, formed in one piece with the body of the vessel or utensil, as more fully hereinafter set forth.

In the drawing, Figure 1 is a view representing the rectangular sheet of metal from which the circular blanks are ordinarily cut in the construction of vessels of this class. Fig. 2 represents a view illustrating one form of my improved blank, in which one of the corners of the sheet is left intact. Fig. 3 represents a view of a culinary or other vessel or utensil constructed from said blank; Fig. 4, a sectional view of the same. Fig. 5 represents a modification of my invention, showing a vessel formed from a blank having two of the corners left intact, said corners serving as the bail-ears of the vessel; and Fig. 6 represents a perspective view of the vessel in which said intact corners are bent outwardly, forming the handles of said vessel.

In the construction of this class of vessels and utensils as ordinarily practiced, a rectangular sheet of metal is taken, and from it is cut a circular blank, as shown in dotted lines in Fig. 1, and this blank is then stamped or spun up into proper form. This method of constructing the blank causes considerable waste of material at the corners of the rectangular sheet. Such waste material has sometimes been utilized in the construction of smaller articles; but the pieces are of such peculiar shape as to be incapable of application to but a limited variety of purposes.

By my invention a large portion of this waste is obviated; and my invention consists in con-

structing a blank leaving one or more of said corners intact, which, when the said blank is spun up into proper shape, form a base for the handle, or form the bail-ears or handles of said vessel or utensil, as more fully hereinafter set forth.

Referring to the drawings, the letter A represents a rectangular piece of sheet metal similar to that usually employed, and the dotted lines represent the inscribed circle. Instead of cutting away all of the corners of said sheet, as usually employed, in carrying out my invention one or more of said corners are left intact, Fig. 2 representing my improved blank, showing one of the corners intact. In this form the blank is then struck or spun up as usual, forming a vessel, A', and the intact corner is bent over, as shown in Figs. 3 and 4, forming a base, B, for the attachment of the handle C of the vessel, which is secured by rivets or otherwise. The top of the vessel is then trimmed off and finished, as usual.

In order to increase the rigidity of the bent-over portion forming the base B for the handle, a raised corrugated flange, *b*, may be formed around its edge, as shown.

In the modification shown in Figs. 5 and 6, the blank is constructed with the diagonally-opposite corners intact or curved or shaped out at each side, so that when the blank is stamped or spun up, forming the vessel A', said corners will form the ears D or handles E, as may be desired, the corners, in the first-mentioned instance, being extended upwardly above the edge of the vessel, and beaded or corrugated around the edges to impart strength to said ears, as shown in Fig. 5, in the last-mentioned instance said corners being bent over at each side, the upper edge of the vessel being similarly bent over outwardly, forming a rim, E, of which the handles are a continuation. Both the rim and the handle may be finished with a wire bead, or in any other desired manner.

In case all four corners are left intact, one may be formed into a lip or spout, one into a handle, and two, opposite each other, may be bail-ears.

I am aware that a blank for a sheet-metal vessel and its handle have been stamped out

of one rectangular sheet; but the part of the blank from which the handle was formed projected toward the center of one side of the rectangular sheet, and consequently the sheet had to be in one direction as long as the diameter of body of blank, plus the length of the handle, while in the other direction—that of its width—the sheet had the dimension of the diameter of the blank.

By forming the handle part of the blank from one or more corners, I save the additional extent of the sheet required in the old mode.

What I claim, and desire to secure by Letters Patent, is—

The method of forming a blank for a struck-up or spun sheet-metal vessel, substantially as herein described, the same consisting in cutting the said blank from a rectangular sheet, one or more corners of said sheet being left intact to form the handle or handles, base for a handle, a spout or lip, or bail-ears, substantially as set forth.

In testimony that I claim the foregoing I have hereunto set my hand in the presence of the subscribing witnesses.

JOSEPH GERARD.

Witnesses:

BENJ. F. EVERITT,
WM. HENGSTENBERG.