

J. H. LA FAVE.
METAL BILGE BARREL.
APPLICATION FILED JUNE 1, 1910.

991,327.

Patented May 2, 1911.

2 SHEETS-SHEET 1.

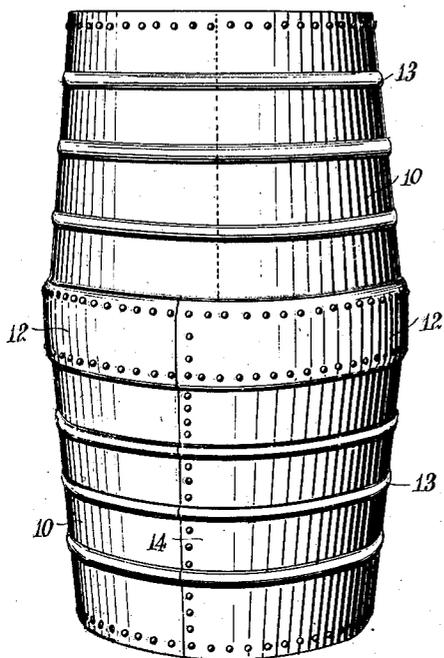


Fig. 1.

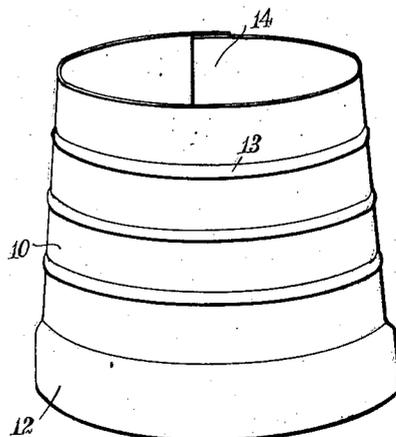


Fig. 2.

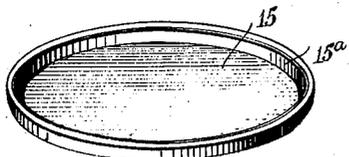


Fig. 4.

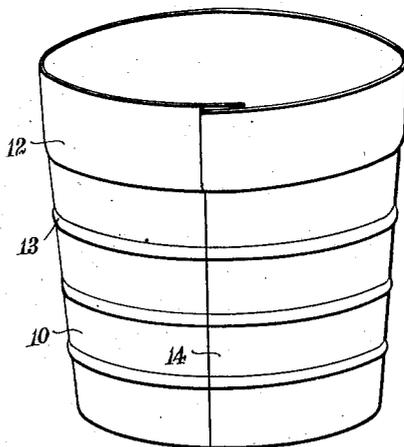


Fig. 3.

WITNESSES:
Benedict
Winters

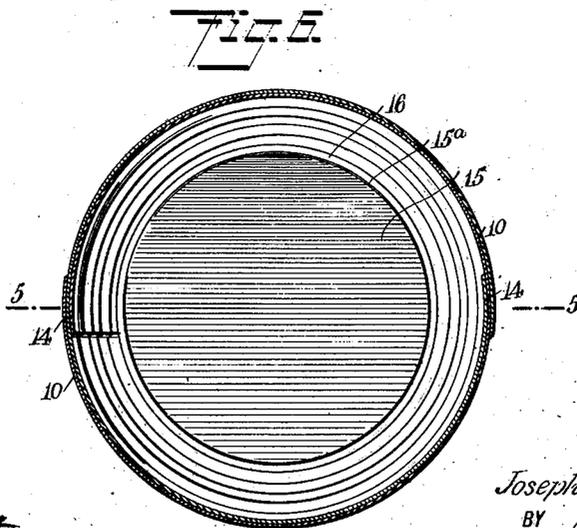
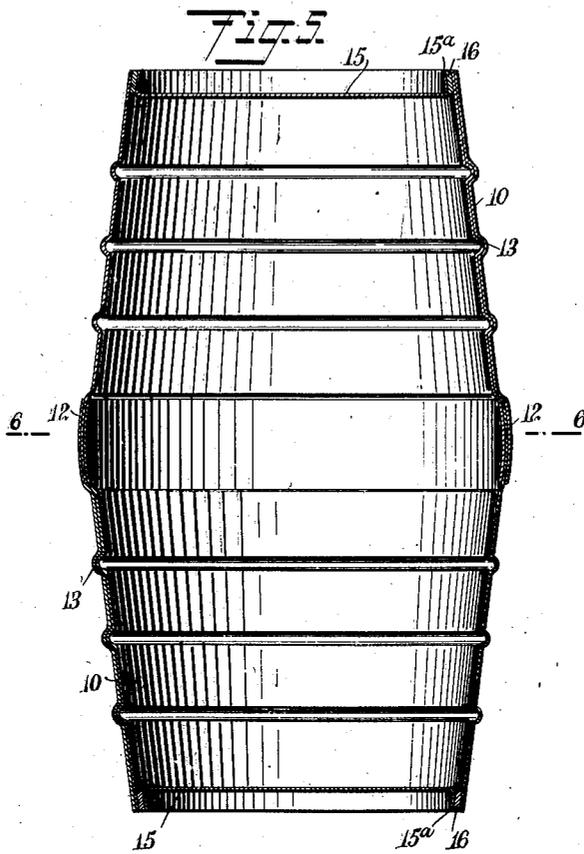
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BY *Munn & Co.*
ATTORNEYS

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2 SHEETS—SHEET 2.



WITNESSES:
Benedict Joffe
W. H. [Signature]

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UNITED STATES PATENT OFFICE.

JOSEPH H. LA FAVE, OF DEFIANCE, OHIO.

METAL BILGE-BARREL.

991,327.

Specification of Letters Patent.

Patented May 2, 1911.

Application filed June 1, 1910. Serial No. 564,354.

To all whom it may concern:

Be it known that I, JOSEPH H. LA FAVE, a citizen of the United States, and a resident of Defiance, in the county of Defiance and State of Ohio, have invented a new and Improved Metal Bilge-Barrel, of which the following is a full, clear, and exact description.

The invention is an improvement in sheet metal barrels, more particularly bilge barrels, and has in view a barrel made up of a number of barrel sections, ordinarily two, which are joined together on a substantially central transverse seam, with the inner end portion of each barrel section partly extending into and partly extending to the outside of the other barrel section at the seam.

Reference is to be had to the accompanying drawings forming a part of this specification, in which similar characters of reference indicate corresponding parts in all the views.

Figure 1 is a perspective view of a metal bilge barrel constructed in accordance with my invention; Fig. 2 is a similar view of one of the sections of the barrel or body; Fig. 3 is a like view of the other section of the barrel body; Fig. 4 is a perspective view of the barrel head; Fig. 5 is a central vertical section of the barrel on the line 5—5 of Fig. 6; and Fig. 6 is a transverse section through the barrel on the line 6—6 of Fig. 5.

The barrel as constructed in accordance with my invention is made of sheet material, such as sheet metal, and of two barrel sections 10, 10, each section being of similar form and construction and has a suitable taper to give the finished barrel the desired bilge. Each barrel section is ordinarily made from a flat blank of sheet metal, which is rolled or otherwise shaped into rounded tapering form, preferably with the enlarged or inner end portion expanded as indicated at 12, and a number of transverse corrugations 13 located between the expanded portion 12 and the chime of the barrel section, as shown in Figs. 2 and 3. The ends of the blank forming each barrel section are brought together and suitably secured, as by rivets, forming the longitudinally-extending seam 14, the lapped portions of the barrel section at the expanded end 12 remaining slightly separated and detached until after the barrel sections are assembled. In forming the seams 14 of the barrel sections, the lapping

of the metal for one section is reverse to the lapping of the metal at the seam of the other section, so that each barrel section may be partly passed within and partly passed to the outside of the other barrel section.

In assembling the two barrel sections, the expanded end portions 12 thereof are telescoped together so that one passes between the lapped portions of the other, and the seams 14 are located at diametrically opposite sides of the barrel. This manner of bringing the two barrel sections together is ordinarily carried out by telescoping them with the disconnected portions of the seams 14 facing each other, and then giving the barrel sections a relative half turn. After the barrel sections are properly located relatively to each other, they are riveted or otherwise secured on the central seam, as shown in Fig. 1. This manner of constructing the barrel permits of its being made with a bilge and relatively strong with regard to simplicity and economy of the construction, the finished barrel being of the same size at each side of the central seam, at which point a portion of each section of the barrel passes within and the remaining portion to the outside of the opposite section.

The head 15 of the barrel is ordinarily formed of sheet metal, as shown in Figs. 4 and 5, the head proper having an upwardly-turned marginal flange 15^a, around which passes a ring 16, constructed to fit within the barrel chime, the head being secured in place by riveting the same through the flange, with the rivets also passing through the ring. The flange 15^a instead of standing vertical to the plane of the head inclines or tapers inwardly in an outward direction, whereby an internal strain on the head tends to bind the flange tighter within the ring.

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

1. A barrel of sheet material having a substantially central transverse seam, with a portion of the barrel at each side of the seam extending part to the inside and part to the outside of the portion of the barrel at the opposite side of the seam.

2. In a bilge barrel, half barrel sections of sheet metal increasing in diameter toward the center, with a circumferential portion of the inner end of each barrel section fitting into and the remaining circumferential portion of the inner end portion extending to

the outside of the inner end of the other barrel section.

3. A sheet metal barrel comprising barrel sections, each having a lapped seam extending along its length, with each barrel section fitting between the lapped portions of the other barrel section.

4. A sheet metal barrel of two barrel sections joined together by a seam located approximately transverse of and intermediate the length of the barrel, each barrel section having a lapped joint extending along its length, with each barrel section extending between the lapped portions of the joint of the other barrel section at the said seam.

5. A bilge barrel of tapering barrel sec-

tions, having a seam located approximately transverse of and intermediate the length of the barrel, each barrel section having an expanded inner end portion, with the expanded inner end portion of one barrel section partly extending within and partly extending to the outside of the expanded portion of the other barrel section at the said seam.

In testimony whereof I have signed my name to this specification in the presence of two subscribing witnesses.

JOSEPH H. LA FAVE.

Witnesses:

E. W. COSTELLO,

JOHN C. VANDENHOEFF.