Nov. 8, 1927. 1,648,718

L. D. BUHL

METALLIC CONTAINER CONSTRUCTION

Filed Dec. 15, 1922

Fig. 1.

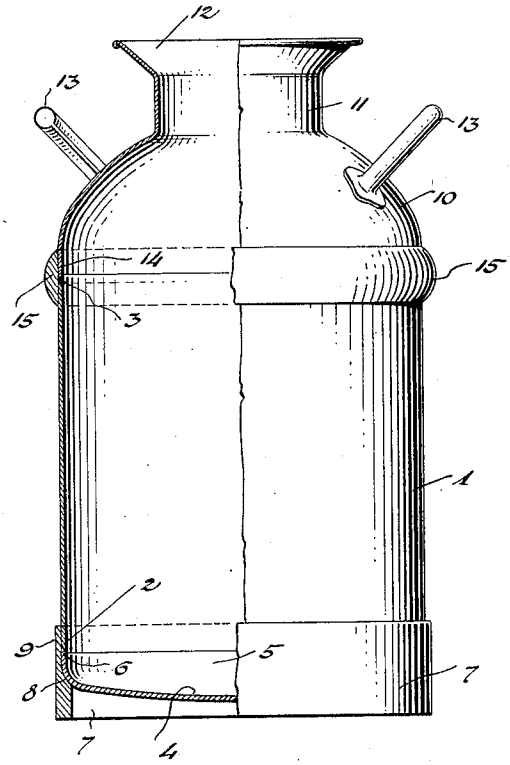


Fig. 2.

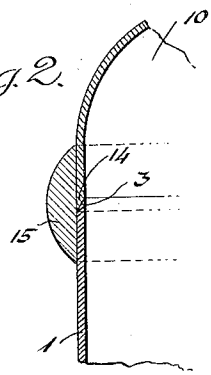
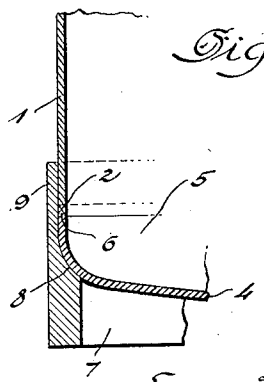


Fig. 3.



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UNITED STATES PATENT OFFICE.

LAWRENCE D. BUHL, OF DETROIT, MICHIGAN.

METALLIC CONTAINER CONSTRUCTION.

Application filed December 15, 1922. Serial No. 607,084.

This invention relates to metallic containers, as milk cans, ice cream packers and other receptacles composed of two or more parts connected together to provide a strong, durable and sanitary receptacle.

My invention aims to connect receptacle parts by scarf joints and reinforced joints in a manner that precludes leakage, insures sanitation at such joints, and protection against fracture and for those parts of the receptacle subjected to blows while handling the receptacle. As an example of such receptacle I make a milk can from a cylindrical body, a bottom piece, and a top piece or breast having the usual neck mouth and handles. These parts are placed in abutting relation and joined by scarf joints surrounded by reinforcing connecting rings or bands which are welded, continuously or at intervals, to the parts of the milk can to positively close scarf joints and insure a non-leakable and durable connection at such joints.

My invention will be hereinafter more fully described by aid of the drawing, wherein

Figure 1 is a side elevation of a milk can, partly broken away and partly in vertical section;

Fig. 2 is an enlarged detail sectional view of an upper portion of the can, and

Fig. 3 is a similar view of the lower portion of the can.

In the drawing, the reference numeral 1 denotes a cylindrical can body or shell having its ends provided with annular beveled edges 2 and 3, said edges being beveled outwardly from the outer wall of the can body to the extreme ends thereof, consequently the bevel or taper at one end of the can body is the reverse of the bevel or taper at the opposite end of the can body and each represents a member of a scarf joint for adjacent can parts.

4 denotes a dished or cupped can bottom having its annular wall 5 inwardly beveled or tapered, as at 6, from the outer surface of the wall to the inner surface thereof, so that it may be placed in abutting relation with the beveled lower edge 2 of the can body 1.

7 denotes a bottom ring or band having the upper half of its inner wall cut away or shaped to provide a seat 8 and an end wall 9 of less thickness than the bottom wall of the ring or band. The inner diameter of the wall 9 corresponds to the outer diameter of the can body 1 and the wall 5 of the can bottom 4 so that the can bottom 4 may be placed on the annular seat 8 with the can body 1 on the can bottom and the edges 2 and 6 meeting at the middle portion of the wall 9. With the parts in this relation the scarf joint between the can body 1 and the can bottom 4 is outwardly braced by the wall 9, and the ring or band can be welded, either in spots or by a continuous weld, to the can body 1 and the can bottom 4.

10 denotes a can top or breast having the usual neck 11, mouth 12, and handles 13. The lower annular edge of the can breast 10 is provided with a bevel or taper 14 for abutting relation with the upper beveled edge 3 of the can body 1 and surrounding the adjoining edges of these can parts is a reinforcing ring or band 15 welded to the outer walls of the can body 1 and the can breast 10, either continuously or in spots, with the outer wall of the ring or band 15 convex or rounded to ward off blows that it may receive.

The can parts 1, 4 and 10 are tinned prior to being assembled and when heat and pressure are applied at the scarf joints of the can the tinning between the bands 9 and 15 and the can parts produces a perfect seal for the scarf joints. After effecting such connections the entire inner surface of the can may be re-tinned to insure a smooth and sanitary interior finish for the can.

The preferred form of joint has been shown and described for the can parts, but such others may be employed as fall within the scope of the appended claim.

What I claim is:—

A receptacle comprising a cylindrical body having its lower end beveled inwardly and downwardly from the outer wall of said body to the inner wall thereof, a bottom piece having curved marginal portions terminating in an annular beveled edge fitted over the beveled end of said body so that the inner and outer walls of said body are flush with the inner and outer walls of said bottom piece, and a bottom ring inclosing the

joint formed by the edges of said body and bottom piece, said bottom ring having a relatively thin wall extending above the joint and a relatively thick wall extending under the bottom piece to form a concave seat for the curved marginal portions of said bottom piece, said bottom ring having its relatively thick wall approximately half the depth of the bottom ring and of such thickness as to provide a substantial seat connection that may receive any end thrust on said bottom ring.

In testimony whereof I affix my signature

LAWRENCE D. BUHL.