June 25, 1929. J. P. WALKER 1,718,322

METALLIC CONTAINER

Filed April 12, 1926

FIG. 1

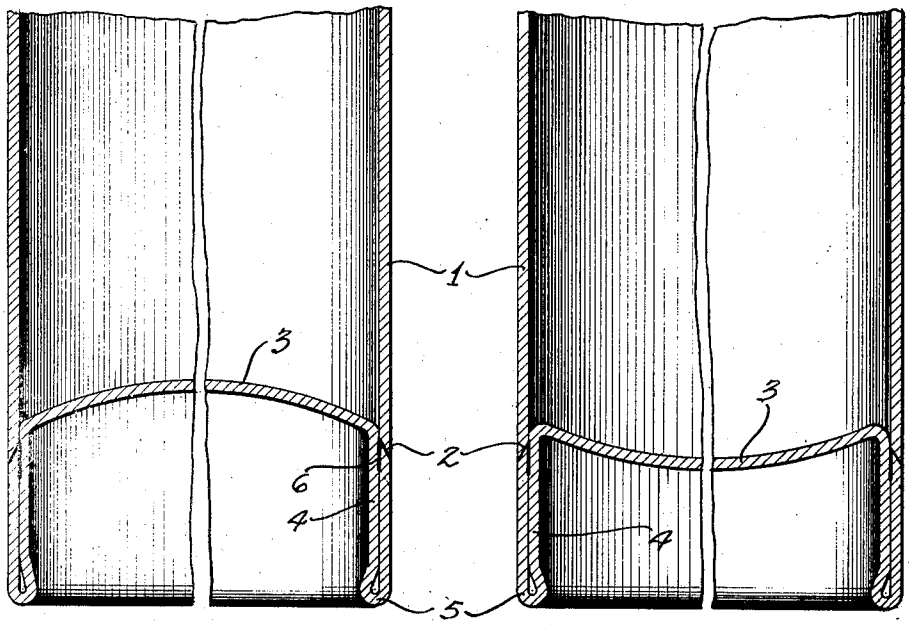
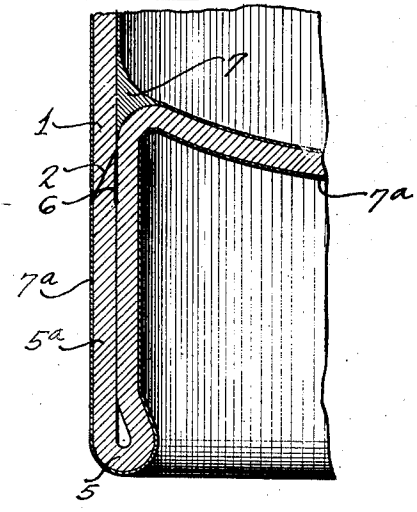


FIG. 2

FIG. 3



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By

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Patented June 25, 1929. 1,718,322

UNITED STATES PATENT OFFICE.

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METALLIC CONTAINER.

Application filed April 12, 1926. Serial No. 101,337.

This invention relates to a metallic container and particularly to a metallic container of an improved type which may be readily made by the general method described in my United States Letters Patent No. 1,556,651, of October 13th, 1925.

It is an important object of this invention to provide a metallic container, such as an ice cream can, wherein the bottom is joined to the body portion in such a manner as to afford a strong, durable and inexpensive construction which is smooth and regular in contour both inside and outside.

Other and further important objects of this invention will be apparent from the disclosures in the specification and accompanying drawings.

The invention (in a preferred form) is illustrated in the drawings and hereinafter more fully described.

On the drawings:

Figure 1 is a fragmentary sectional view illustrating the first step in the construction of a metallic container embodying the principles of this invention.

Figure 2 is a similar view showing the second step in construction.

Figure 3 is an enlarged fragmentary detail vertical section showing the completed joint between the bottom and body portions of the container.

As shown on the drawings:

The reference numeral 1 indicates the cylindrical body portion of a metallic ice cream can or similar container. As will be noted, the lower edge of said body portion 1 is scarfed or bevelled as at 2 and a bottom portion 3, which is initially upwardly dished as shown in Figure 1, is telescopically engaged inside the lower end of said body portion. Said bottom portion 3 is provided with a depending flange 4 which is reversely bent at 5 to form a rounded bottom support. Said reversely bent portion extends upwardly as at 5^a contiguous to the flange 4 and is scarfed at its upper edge to form a smooth joint with the scarfed edge 2 of the body portion 1. The bottom and body portions are secured together preferably by electric welding as indicated by the heavy line 6, this welded portion extending entirely around the container and, of course, being of any desired width to properly secure said portions together.

After the bottom and body portions have thus been secured in the manner previously referred to, the upwardly dished bottom portion 3 is forced into the downwardly dished position indicated in Figures 2 and 3 by a method such as shown in by aforesaid Patent No. 1,556,651.

The container is preferably dipped in a coating of metal such as molten tin or the like, prior to effecting the latter operation so that when the bottom porting is bulged as dished downwardly, a fillet 7 of said metal is unable to rise higher than would otherwise be the case, which makes the inside of the can in effect seamless. The entire can or container, both inside and outside, is covered with this coating of protective metal, such as tin, and the protective coating thus applied is designated in Figure 3 of the drawings by the reference numeral 7^a. It will thus be apparent that the structure provided by this invention has smooth exterior and interior surfaces which are sanitary and which give the effect of an entirely seamless structure.

By providing the rounded portion 5 at the beginning of the reversely bent portion 5^a, a smooth durable bottom support for a container is afforded, and by providing a smooth joint at the scarfed edges of the body portion 1 and the upwardly extending part 5^a of the reversely bent portion, it is possible to provide an ice cream can having an entirely smooth exterior which facilitates the withdrawal thereof from an ice chest in which it may be packed entirely surrounded by ice.

The construction which I have provided is durable, neat in appearance, and may be economically manufactured.

I am aware that numerous details of construction may be varied through a wide range without departing from the principles of this invention, and I therefore do not purpose limiting the patent granted, otherwise than necessitated by the prior art.

I claim as my invention:

1. The method of making a container which consists in forming in an open-ended sheet metal body a sheet metal bottom folded on itself with the exterior layer of the bottom of the same diameter as the external diameter of the body and shorter than the full length of the bottom, bringing the bottom and body members together and then welding the upper extremity of said exterior layer to the lower extremity of said body.

2. The method of making a container which consists in forming in an open-ended sheet

metal body a sheet metal bottom having a depending annular portion partially telescoped within the body and folded on itself with the exterior layer of the same diameter as the external diameter of the body and shorter than the telescoped portion, and then joining the upper extremity of the exterior layer to the lower extremity of the body.

3. The method of making a container which consists in forming a sheet metal bottom member of two portions, one being of less diameter and longer than the other, making an open-ended sheet metal body, telescopically inserting the longer of said portions within the open-ended sheet metal body until the upper extremity of the other portion abuts the lower extremity of said body, and then joining both portions to said body.

4. A container including a sheet metal body, and a sheet metal bottom formed to define two portions, one of which is of less diameter and of greater length than the other, said portion of the bottom of least diameter being inserted within the body and the portion of greatest diameter abutting the lower extremity of the body at the upper extremity of said portion of greatest diameter, said portion of greatest diameter being joined to said body.

5. A container including a sheet metal body, and a sheet metal bottom formed to define two portions, one of which is of less diameter and of greater length than the other, said portion of the bottom of least diameter being inserted within the body and the portion of greatest diameter abutting the lower extremity of the body at the upper extremity of said portion of greatest diameter, said portion of greatest diameter being welded to said body.

6. A container including a sheet metal body, and a sheet metal bottom having a depending annular portion partially telescoped within the body and folded on itself with the exterior layer of the same diameter as the external diameter of the body, the upper extremity of said external layer abutting the lower extremity of the body and being joined thereto.

7. A container including a sheet metal body, and a sheet metal bottom formed to define two portions, one of which is of less diameter and of greater length than the other, said portion of the bottom of least diameter being inserted within the body and the portion of greatest diameter abutting the lower extremity of the body at the upper extremity of the portion of greatest diameter, said portions being joined to said body.

In testimony whereof I have hereunto subscribed by name.

JAMES P. WALKER.