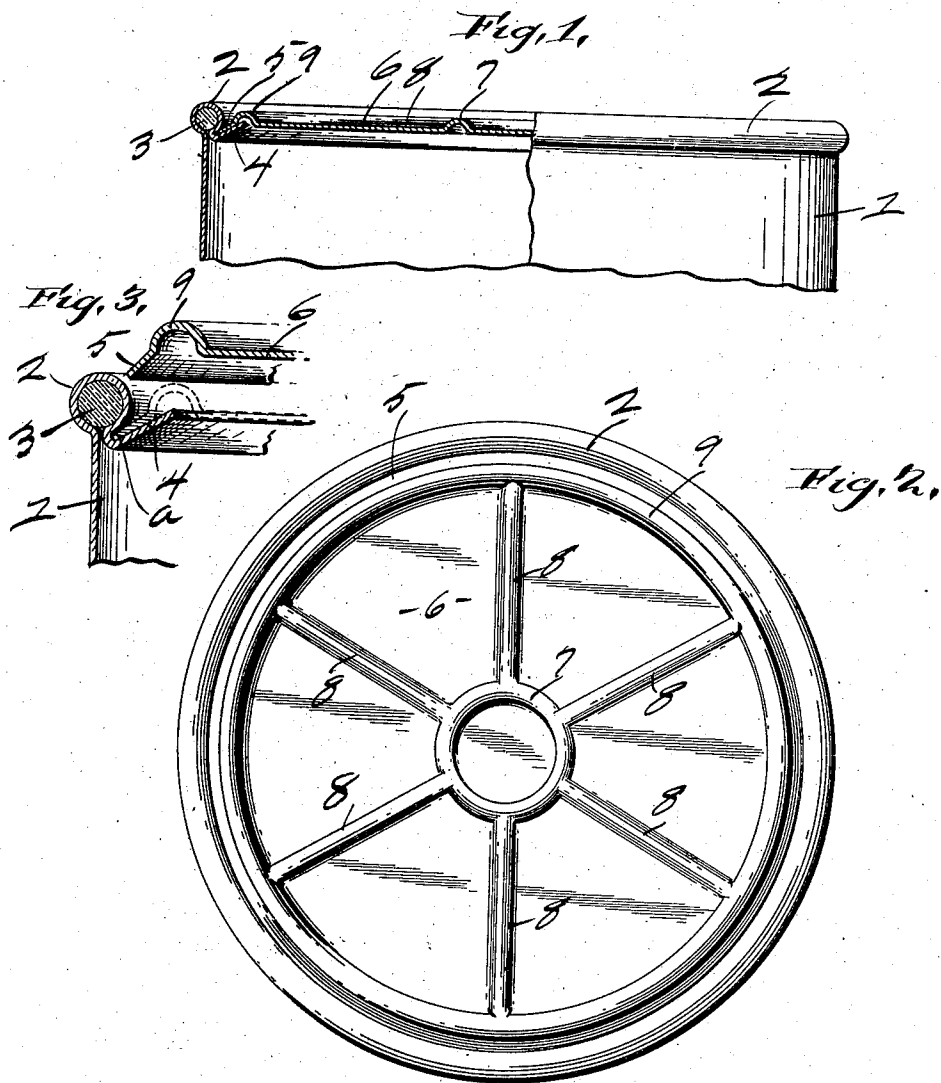


F. E. FIRTH.
METAL BARREL.
APPLICATION FILED MAR. 2, 1908.

975,342.

Patented Nov. 8, 1910.



Witnesses,

J. L. Dick.
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Inventor,

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att'y.

UNITED STATES PATENT OFFICE.

FRANKLIN E. FIRTH, OF TOLEDO, OHIO, ASSIGNOR OF ONE-THIRD TO HENRY C. ROEMER AND ONE-THIRD TO AUGUSTUS RASOR, BOTH OF TOLEDO, OHIO.

METAL BARREL.

975,342.

Specification of Letters Patent.

Patented Nov. 8, 1910.

Application filed March 2, 1908. Serial No. 418,780.

To all whom it may concern:

Be it known that I, FRANKLIN E. FIRTH, of Toledo, county of Lucas, and State of Ohio, have invented certain new and useful Improvements in Metal Barrels; and I do hereby declare that the following is a full, clear, and exact description thereof, which will enable others skilled in the art to which it appertains to make and use the same, reference being had to the accompanying drawings, and to the figures of reference marked thereon, which form part of this specification.

This invention has reference to metal barrels adapted for shipping and storing oil or other liquids.

The invention has particular reference to simplified and improved means for securing the head to the body of a barrel, the cost of manufacture being extremely low owing to the ease with which the barrel is assembled and the facility with which it is brazed to render it liquid tight.

In carrying out my invention, I employ the novel combination, arrangement and the details of construction hereinafter shown, described and specifically claimed.

In the accompanying drawings, Figure 1 is an elevation in half vertical section of one end of a barrel embodying my improved construction; Fig. 2 is a plan view of my barrel with the head in position; Fig. 3 is an enlarged sectional detail of the barrel chime, showing the annular channel underlying the same. In this view the head is shown elevated above the barrel prior to being placed in position.

The body 1 of the barrel is constructed of metal, preferably sheet steel, and the margins are rolled into a substantially circular tube 2 forming a chime, the preferred construction being to roll the margin upon a ring or rod 3. The edges 4 of the margins 2 are disposed on the inner side of the body and these edges are directed inwardly at an inclination to the body, as shown, to provide a ledge or annular channel *a* which underlies the rolled chime and receives the inclined margin 5 of the sheet metal head 6. This channel is also adapted to receive and hold the spelter employed in brazing the head upon the body. The head, as shown, may be provided with a central circular corrugation 7 and with radial corrugations 8,

although these are not essential to the invention. Within the inclined outer margin 5 the head is provided with a circular corrugation 9 the concave under side of which is adapted to receive the inturned edge 4 of the body when the head is in position.

As illustrated in Fig. 3, in which the head is shown separated from the body prior to being assembled, the margin 5 of the head when formed up is made at a greater angle to the horizontal than the edge 4 of the body, this being done to reduce the diameter of the head and permit it to readily pass through or within the chime. The outer margin of the head is then rolled or subjected to pressure from without which will cause its inclined margin to flatten slightly and conform to the shape or inclination of the inturned edge 4, the extreme outer edge of the head being forced into the angle between the edge 4 and the rolled chime. The head being now held firmly in place, the joint between the head and the body is brazed or welded. Where brazing is resorted to, the heat may be applied wholly on the outside and the channel *a* serves admirably to hold the spelter, very little of which will be required to render the barrel liquid tight.

The barrel may be assembled and brazed with great ease and at a low cost of manufacture.

Having described my invention what I claim and desire to secure by Letters Patent, is—

The combination with a sheet metal body having a tubular margin, the free edge thereof extending from a point under the tubular margin inwardly and upwardly forming an inclined annular shoulder, and an annular channel under the tubular margin at the junction of said tubular and inclined portion, of a sheet metal head having its edge extending downwardly to enter the channel under the tubular margin, the said head having a corrugation concentric to the tubular margin and adjacent thereto.

In testimony, that I claim the foregoing as my own I affix my signature, in presence of two witnesses.

FRANKLIN E. FIRTH.

Witnesses:

B. H. ANDERSON,
CARL H. KELLER.