July 26, 1927. 1,637,242

A. F. REILLY

METHOD OF PRODUCING THE SHELLS OF METAL BOXES

Filed Nov. 29, 1926 2 Sheets-Sheet 1

Fig. 1.

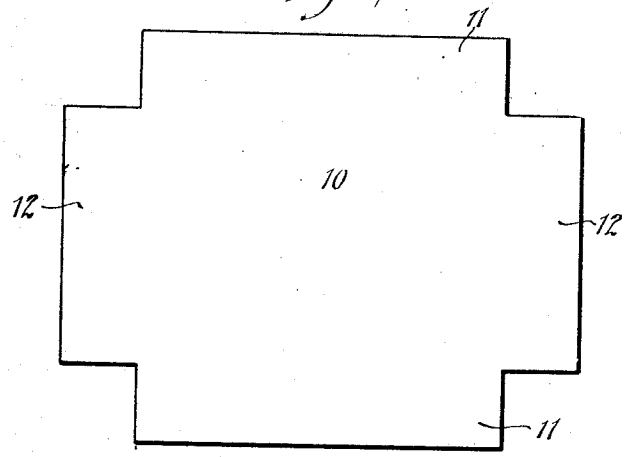



Fig. 2.

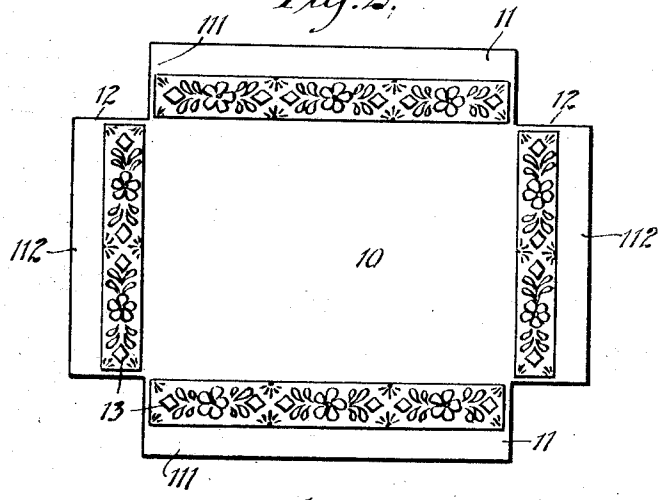
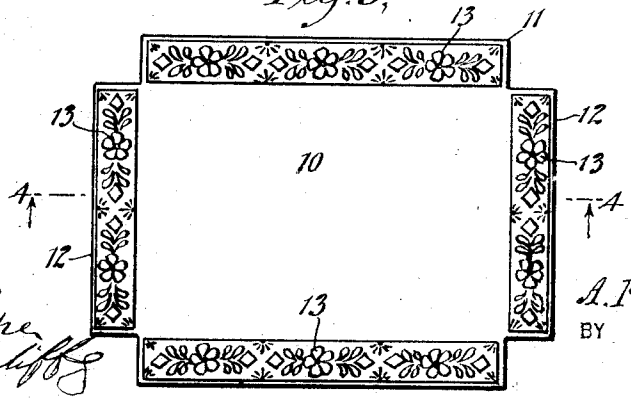



Fig. 3.




WITNESSES

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Fig. 4,

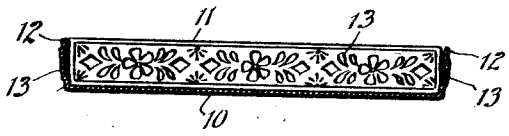



Fig. 5,

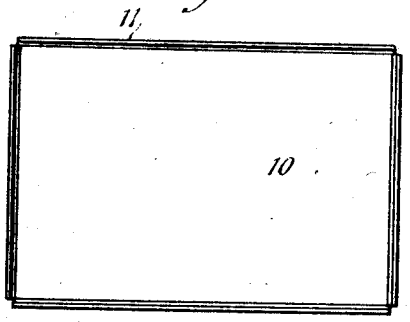
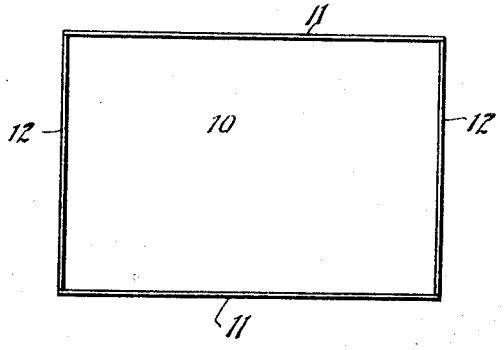



Fig. 6.




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# UNITED STATES PATENT OFFICE.

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## METHOD OF PRODUCING THE SHELLS OF METAL BOXES.

Application filed November 29, 1926. Serial No. 151,493.

My invention relates to the shells or bodies of metal boxes or cases and more particularly in practice is employed in the production of shells of vanity cases.

The general object of my invention is to produce shells of vanity cases from sheet metal by stamping or drawing the metal, a shell in which the miter will be perfect when the front is brought to final shape and soldered or brazed.

The invention especially has for a purpose to incorporate an ornamental design in the sides of the box or shell and carry out the co-ordinated operations in a manner to prevent the stamping of the design from distorting the members of the blank embodying the design.

The nature of my invention and its distinguishing features and advantages will clearly appear as the description proceeds.

Reference is to be had to the accompanying drawings forming a part of this specification, it being understood that the drawings are merely illustrative of one example of the invention.

Figure 1 is a plan view of the blank resulting from the first operation in producing a shell for a vanity case in accordance with my method;

Figure 2 is a plan view of the blank shown in Figure 1 after pressing a design in the flanges or wings representing the opposite sides and the opposite ends of the blank;

Figure 3 is a plan view showing the blank after the removal of the surplus material of the side and end members, said removal being produced by the third operation and following the stamping of the design;

Figure 4 is a longitudinal, vertical section of the shell after the sides and ends have been bent up to positions to receive the solder;

Figure 5 is a plan view of the shell in the condition shown in Figure 4;

Figure 6 is a plan view of the shell in completed form after bending up the side and end members and after the application of the soldering iron or torch to the shell at the angles, following the application of the solder.

In the several figures the numeral 10 indicates the central panel of the blank which forms the bottom of the shell. The numeral 11 indicates the side flanges or wings to form the opposite sides of the shell and the numeral 12 indicates the end flanges or wings to constitute the end members of the shell.

The blank shown in Figure 1 is produced by stamping the same from sheet metal. In Figure 2 the numeral 13 indicates ornamental panels or zones on the side members 11 and end members 12. It will be observed from said Figure 2 that the ornamental panels 13 are adjacent the inner edges of the side members 11 and end members 12, leaving surplus zones 111 and 112 on the side members and end members, respectively and laterally outward of the ornamental panels 13.

It is important, in obtaining accuracy in the form and dimensions of the members 11 and 12 in the final, finished article shown in Figure 6, that the distortion of the blank more or less by the operation of producing the ornamental design, be recognized. The stamping of the ornamental design in the metal prior to removal of the surplus metal insures that the production of the members 11 and 12 with the ornamental design embodied therein results in their being minus all surplus material, insures accuracy in the shape and dimensions of the members 11 and 12 and enables the finished article of Figure 6 to be brought to perfection.

The final step of soldering following the placing of solder at the angles of the shell is in practice carried out manually with the aid of pliers. The adjacent ends of the side and the end members of the shell are held in the proper relation until the solder sweating or brazing has been performed.

The foregoing description explains my novel method when the shell is produced by stamping, as distinguished from drawing the shell into form.

What I claim is:

1. In a method of producing shells for vanity cases and similar articles, the steps of producing from sheet material a blank presenting panels along the edges thereof producing ornamental zones on said panels inward of the outer edges of the panels, removing the surplus material laterally outward of said ornamental zones and then bending up the said panels.

2. In a method of producing shells for

vanity cases and similar articles the steps of producing from sheet material a blank presenting panels along the edges thereof, producing ornamental zones on said panels inward of the outer edges of said panels, removing the surplus material laterally outward of said ornamental zones, bending up the said panels into nearly a closed relation between adjacent panels, placing solder on the bent-up article at the angles thereof, further bending the panels inwardly to bring their opposed edges into closed relation, and finally causing the solder to unite said opposed edges.

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