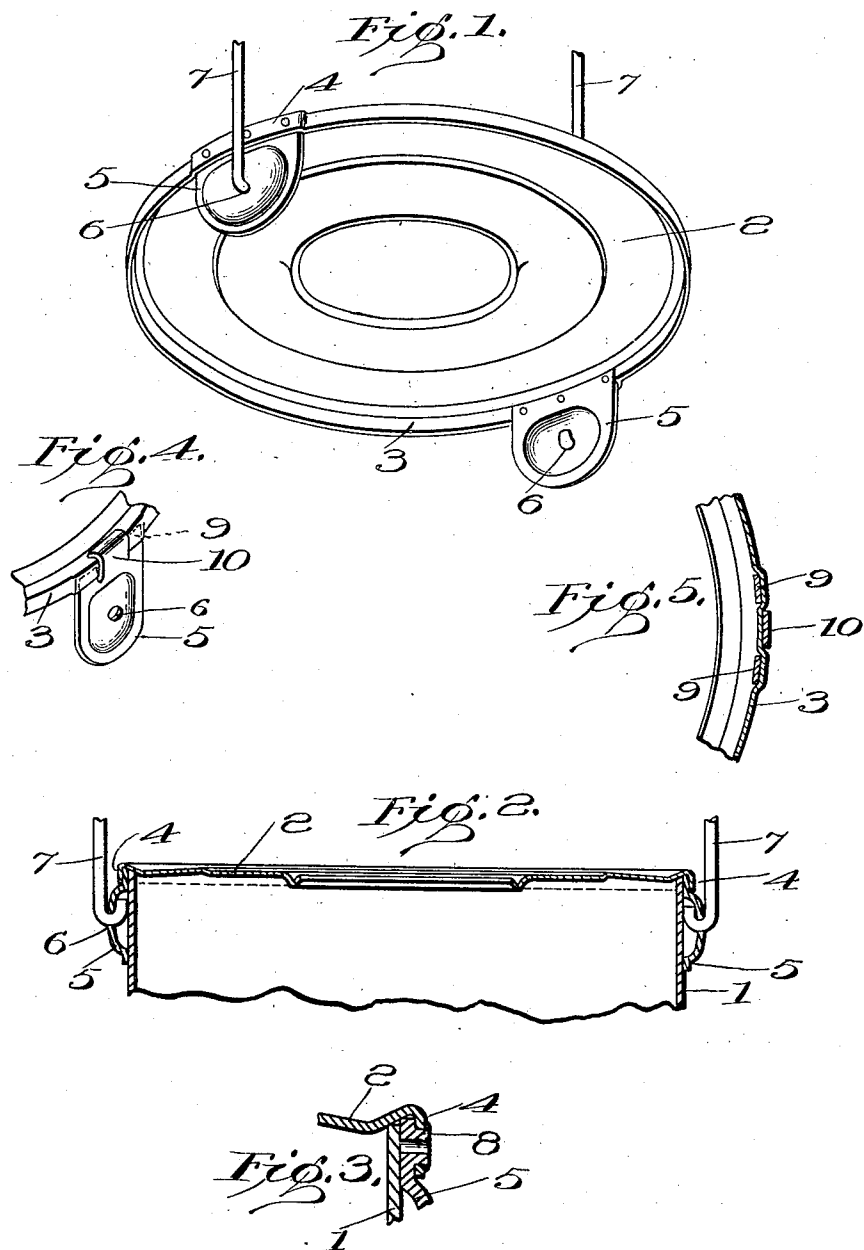


No. 896,026.

PATENTED AUG. 11, 1908.

B. H. LARKIN.
CAN HEAD AND EAR.
APPLICATION FILED APR. 4, 1908.



WITNESSES:
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UNITED STATES PATENT OFFICE.

BERNARD H. LARKIN, OF CHICAGO, ILLINOIS.

CAN HEAD AND EAR.

No. 896,026.

Specification of Letters Patent.

Patented Aug. 11, 1908.

Application filed April 4, 1906. Serial No. 309,768.

To all whom it may concern:

Be it known that I, BERNARD H. LARKIN, citizen of the United States, residing at the city of Chicago, in the county of Cook and State of Illinois, have invented new and useful Improvements in Can Heads and Ears, of which the following is a specification.

My invention relates to the covers and bail ears of sheet metal cans, and consists in a new and improved construction, whereby economy in manufacture and other improved results are obtained.

It has been found desirable in the manufacture of cans to stamp or cut the head and the ears as a single piece from the sheet, that they may be secured in one operation to the body, but this involved an expensive die and waste of material, particularly in the case of large cans, and the making of the ears and the head of the same thickness of metal. I obtain all the advantages of a unitary can head and ears, to be secured on the body at one operation, by cutting from the tin-plate as separate pieces the head and the two ears and then securing the ears in proper position on the head.

Desirable forms of my invention are shown in the drawing herewith, in which the reference numerals of the description indicate the corresponding parts in all the figures.

Figure 1 is a perspective view of the integral head and attached ears, ready to be soldered on the body. Fig. 2 is a cross section of Fig. 1. The position of the bail is indicated in said figures. Fig. 3 is an enlarged section showing a desirable means for securing the ears to the head. Figs. 4 and 5 show in perspective and in horizontal section another means for securing the ears.

In the figures, 1 indicates the can body and 2 the head, top, cover or ring, having the down turned flange 3 to fit around the margin of the body. This flange is offset on opposite sides at 4, corresponding to the thickness of the ear 5, whereby the flange and the ears, arranged in such countersunk portions, may be fitted snugly to the edge of the can body and there soldered in place simultaneously with the head and by the same soldering operation. These ears are preferably dishd, and perforated at 6, to receive the hooks on the ends of the bail 7, and are secured to the head, at one operation, by a suitable mechanism, whereby, for instance, as shown in Figs. 1 and 3, a portion 8 of the ear, resembling a bushing, is forced through

a perforation formed in the flange and upset. The integral head and ears are then soldered, as a single article, to the body.

In the construction shown in Figs. 4 and 5, the ear is provided with two inner lips 9 9, which fit within the head flange and with an outer lip 10, which is arranged without the flange to hook over the upper surface of the head, as best shown in Fig. 4. The flange is correspondingly offset as best shown in Fig. 5. By this construction the blanks for the heads can be stamped close together from the tin-plate with little waste, and the smaller ear blanks, very advantageously from the plates within or between the larger head blanks. Or, when desirable, the ears can be made of a different thickness, and, therefore of a different strength, from the head. Sometimes it is desired to make the ears of a different weight plate from that used in the head or cover and often to make them heavier to sustain the heavy weight, it being understood that generally the greater strain comes on the ears and much less on the head, so that the latter may be of light metal.

The form of my invention may be varied and it may be applied to pails and other vessels as well as to cans.

To set forth the further economy of this invention, particularly relating to the use of sheet metal for the heads or covers, a smaller blank or disk can be used, this material being a remnant in the ordinary manufacture of the different diameters of cans. This economy can be more clearly understood by reference to my Patent No. 704,261 of July 8, 1902. In my present invention, I also produce an ear which is better formed and which lies more snugly against the curved wall of the can; the combined head and ears are therefore more easily and firmly secured on the can.

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

1. As a new article of manufacture, the combined head and bail-ears for a sheet metal can, said head having a peripheral flange, and said ears being oppositely secured on the head by a lip arranged within the flange and lips arranged without the flange.

2. As a new article of manufacture, the combined head and bail-ears for a sheet metal can, said head having a peripheral

down-turned flange offset to receive lips on the ears, and said ears being formed of separate pieces of metal, and secured to the head periphery by two lips arranged within the flange and a single lip arranged without the flange and hooking over the top.

3. As a new article of manufacture, the combined head and bail-ears for a sheet metal can, said head having a peripheral flange, and said ears being positively se-

cured on the head by portions arranged within the flange and without the flange, said portions engaging the flange between them.

In testimony whereof I have signed my name to this specification in the presence of 15 two subscribing witnesses.

BERNARD H. LARKIN.

Witnesses:

DAVID BREDO,
J. C. TALIAFERRO.