

L. B. BENTON.
MANUFACTURE OF FLOATS.

No. 172,956.

Patented Feb. 1, 1876.

Fig. 1.

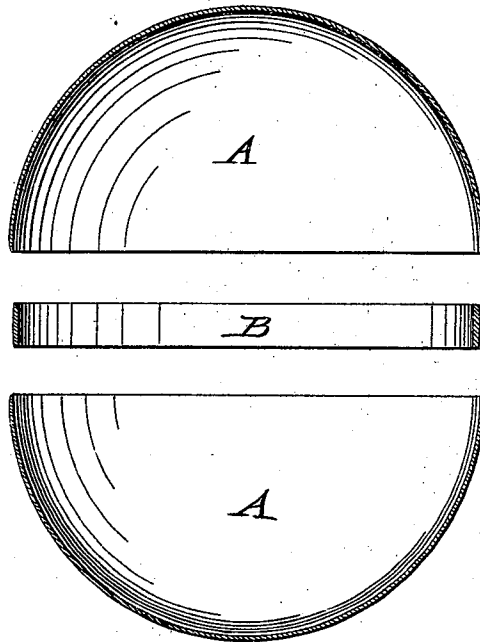
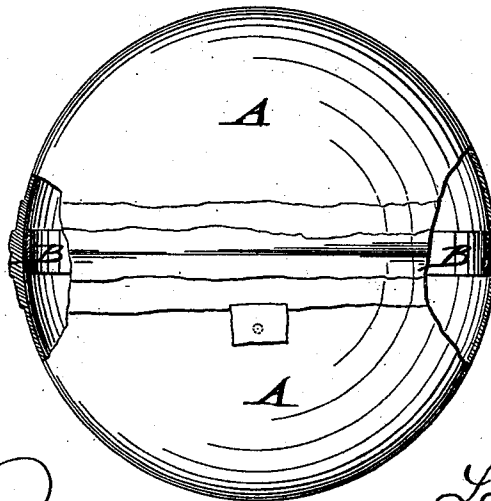


Fig. 2.



WITNESSES:

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LINN B. BENTON, OF MILWAUKEE, WISCONSIN.

IMPROVEMENT IN THE MANUFACTURE OF FLOATS.

Specification forming part of Letters Patent No. **172,956**, dated February 1, 1876; application filed November 27, 1875.

To all whom it may concern:

Be it known that I, LINN BOYD BENTON, of Milwaukee, in the county of Milwaukee and State of Wisconsin, have invented a new and Improved Float, of which the following is a specification:

In the accompanying drawing, Figure 1 represents a vertical central section of my improved float, with parts detached to show construction; and Fig. 2 is a side view, with parts broken out to show connection of hemispheres.

Similar letters of reference indicate corresponding parts.

My invention has reference to an improved float that is spun of copper and joined in a perfect manner; and the invention consists of two hollow hemispheres of spun copper, fitted on a circular band, and soldered together in a galvanic solution.

In the drawing, A A are two hollow hemispheres, which are spun up out of copper of suitable thickness, so as to be capable to withstand the pressure to which the float is exposed. The hemispheres A are connected at their circumference by being slipped on a circular band or ring, B, that is slightly turned or beveled toward the edges, to correspond to the curvature of the hemispheres, which are joined at the center line of the band, forming a closely-fitting and neat joint therewith. The edges of the hemispheres are also slightly beveled at the outside, as shown in Fig. 1, to bind intimately on the band B when being driven thereon. The float is then hung in a galvanic copper solution, and a perfect joint made by the filling up with copper of the beveled edges of the hemispheres. The float is then taken

out of the solution, and the quantity of solution at the interior removed by boring two small holes into the float and blowing the solution out. The holes are then plugged, and the plug-holes covered with a thin layer of copper by placing the float again in the solution, so as to preclude completely any chance of leakage around the plugs. A second layer may also be deposited over the joint to secure the strong and perfect connection of the parts.

The band serves mainly the purpose of connecting the spun hemispheres, and admit of their being hung in the solution for soldering without taking the temper out of the copper.

A float so made is capable of resisting a large pressure without leaking or bursting, and thus a superior mode of constructing floats for various purposes is formed.

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

1. A float made of spun hemispheres forced on a beveled connecting band or ring, and soldered at the joint, substantially in the manner and for the purpose set forth.

2. The method herein described of connecting the copper spun hemispheres of a float without taking the temper out of the metal, consisting in forcing them on a beveled connecting band or ring, soldering the joint in a galvanic copper solution, and removing the solution from the interior of the float, substantially as specified.

LINN BOYD BENTON.

Witnesses:

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