

Sept. 24, 1935.

T. T. TUCKER

2,015,205

WATER TIGHT METAL CONTAINER, RECEPTACLE AND BOX

Filed May 5, 1934

2 Sheets-Sheet 1

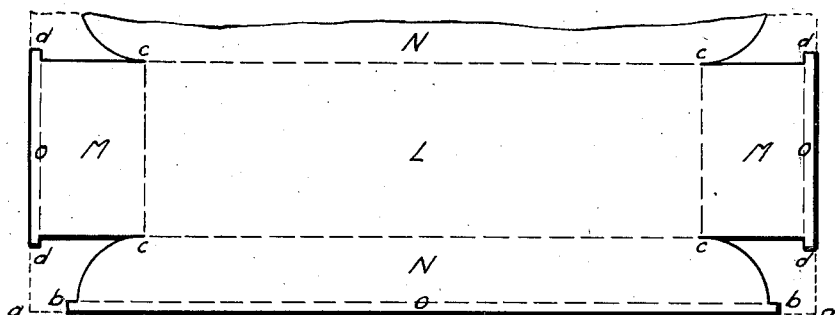


Fig. 1.

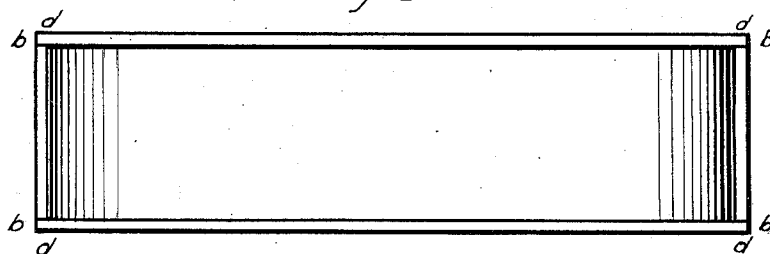


Fig. 2.

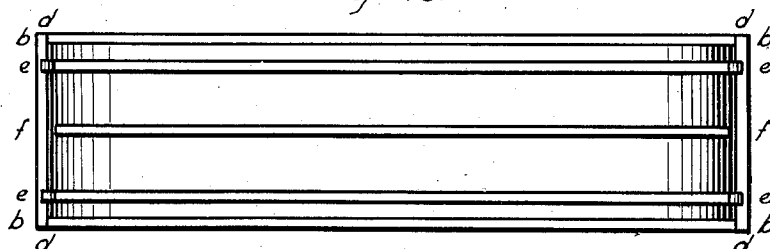


Fig. 3.

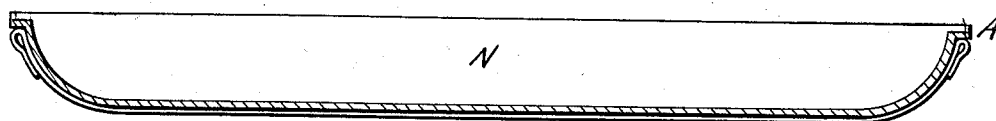


Fig. 4.

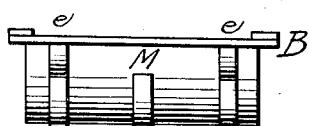


Fig. 5.

INVENTOR  
Thomas T. Tucker.

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2 Sheets-Sheet 2

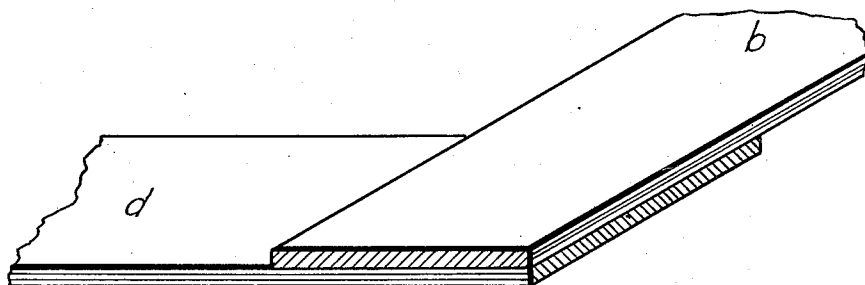


Fig-6.



Fig-7.

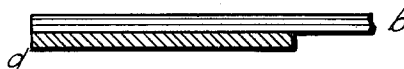


Fig-8.

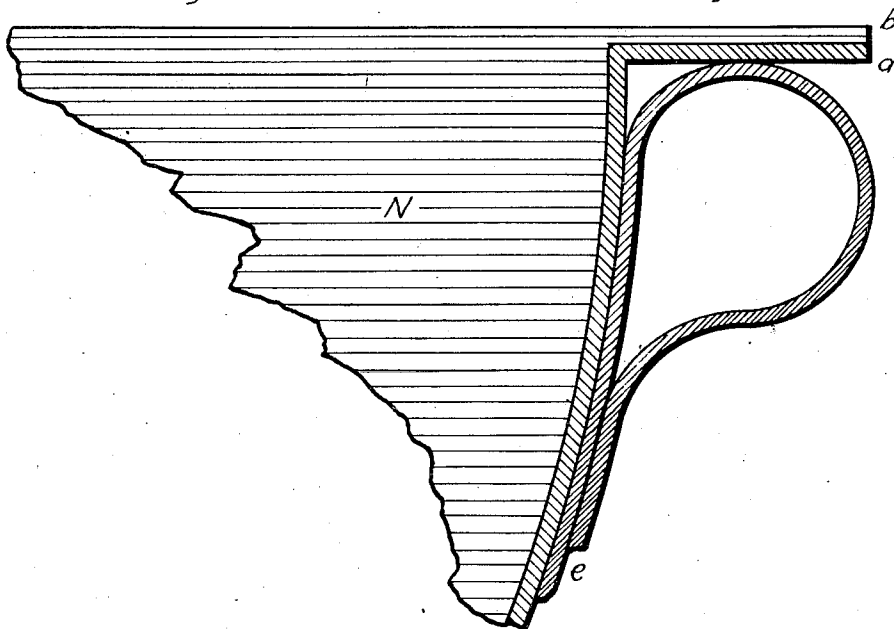


Fig-9.

INVENTOR

Thomas T. Tucker.

## UNITED STATES PATENT OFFICE

2,015,205

WATER TIGHT METAL CONTAINER,  
RECEPTACLE, AND BOX

Thomas T. Tucker, Atlanta, Ga.

Application May 5, 1934, Serial No. 724,119

2 Claims. (Cl. 220—94)

The invention relates to the improvement of water tight containers, receptacles and boxes which are built of sheet metal and more especially to those built of heavy gauge sheets and metal plates; and the objects of the improvements are first, to minimize construction joints; second, to simplify construction; third, to construct from one piece of metal; fourth, to reinforce and stiffen where the strain is greatest; fifth, to make as light in weight as possible; sixth, to insure quick and easy cleaning; seventh, to facilitate handling.

My invention relates broadly to all water tight containers, receptacles and boxes having a bottom and four walls (2 end walls and 2 side walls) which are built of metal, and more particularly to those which are constructed from one piece of metal, especially where the end walls are curved upwardly and outwardly from the bottom and where one or more of the walls terminate in outward flanges, and to the attachment of metal straps to such metal containers, receptacles and boxes.

One form of my invention is illustrated in the two accompanying sheets of drawings, in which Figure 1 is a plan view of the sheet of metal or metal plate before bending to shape; Figure 2, a plan view after bending to shape; Figure 3, a bottom view after bending to shape and showing one arrangement of attaching metal straps; Figure 4, a side view after bending to shape; Figure 5, an end view after bending to shape; Figure 6, a diagonal view of superimposed flanges at point B; Figure 7, an end view of superimposed flanges at point B; Figure 8, a side view of superimposed flanges at point B; Figure 9, a cross section taken at A to show manner of looping metal straps.

By referring to Figure 1, it will be noted that a single piece of sheet metal or metal plate  $a-a$  is cut in any manner along the solid lines  $bcd-dcb-bcd-dcb$  to form a blank from which, if divided into sections, L will become the bottom; M, the two end walls; N, the two side walls; and O, the flanges of the metal container, receptacle or box.

Sections N, are then bent upward along broken lines  $c-c$  to form the two sides. Next, sections M, are bent upward from broken lines  $c-c$  and in such manner that the plane surfaces, or short axis, of sections M, along the solid lines  $c-d$ , shall become curved, such curve to fit snugly against the curve already cut along solid lines  $c-b$ , and thus to form the end walls of the metal container, receptacle or box.

The flanges O, are next bent outwardly and

the projecting ends  $b$ , are superimposed upon the projecting ends  $d$ , as is admirably shown in large size Figure 6. Also, large size drawings of this superimposing of flanges is shown in end view Figure 7, and side view Figure 8.

It is then, after bending to shape, that the construction joints are welded, soldered or otherwise made fast along lines  $c-bd$  and the superimposed flanges along their lines of contact. A plan view, after the four walls and flanges are bent to shape and placed in position is shown in Figure 2.

It is understood of course that this sequence of operation is only for convenience of explanation for the same results may be accomplished thru other sequences and it is essential only that the completed product shall be as detailed herein and/or illustrated in the accompanying drawings.

In order to facilitate handling of large or heavy metal containers, receptacles and boxes one or more metal straps may be spot welded, soldered or otherwise attached to the same, and one location of such straps is parallel to the long axis as is shown in bottom view Figure 3. Such metal straps may have one or more ends looped as is distinctly shown in large size section Figure 9.

Referring again to bottom view Figure 3, it will be noted that I have here, and in end view Figure 5, shown straps  $e-e$  to be looped at both ends and strap  $f-f$  not looped at either end. But, the looping of the ends of straps is purely optional and none, one, any or all ends of straps may be or may not be thus looped. It is to be understood that these metal straps are not required by my invention in order to make the same complete, as the metal container, receptacle or box as invented by me may be successfully used with or without the metal straps.

It will be noted that my invention admirably simplifies the construction of water tight containers, receptacles and boxes formed from one piece of metal to such an extent that only four joints are required to be welded, soldered or otherwise made fast. The flange amply reinforces and stiffens the four walls and the superimposing of the ends of these flanges after they have been properly welded, soldered or otherwise made fast, fixes the construction joints permanently and rigidly in place. Thus, all excess weight is eliminated and the handling of large or heavy metal containers, receptacles and boxes is facilitated by attaching metal straps. Quick and easy cleaning is assured by the two upward curving end walls and the natural curves caused by bending of metal to this design.

I am aware that prior to my invention containers, receptacles and boxes have been built from one piece of metal. I therefore do not claim such construction broadly; but:

5 I do claim:

1. A container of sheet material comprising a bottom, side and end walls, said side and end walls being provided with outstanding marginal flanges, laterally spaced reinforcing straps secured to and extending along the bottom and end walls of the container, certain of said straps

terminating immediately beneath the flanges of the end walls, in loops forming at each end of the container a pair of handles.

2. A sheet metal container having bottom, side and end walls, said side and end walls being provided with outstanding marginal flanges, and said end walls being curved, and reinforcing straps extending along the bottom and end walls of the container and terminating in loops immediately beneath the flanges of the end walls. 5 10

THOMAS T. TUCKER.