No. 685,832. Patented Nov. 5, 1901.

W. GENDER.

SHEET METAL VESSEL.

(Application filed Sept. 8, 1897.)

(No Model.)

Fig. 3.

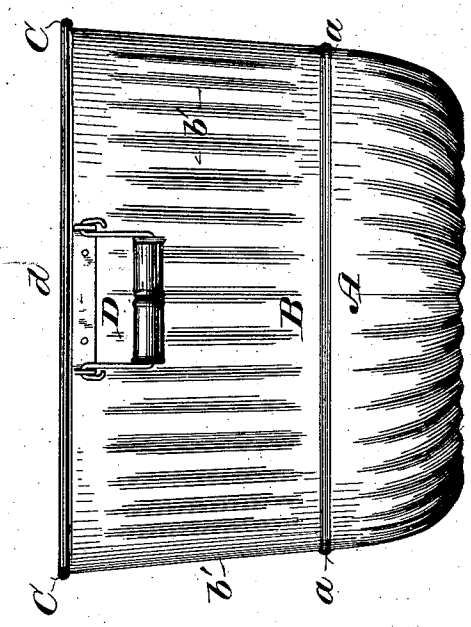


Fig. 2.

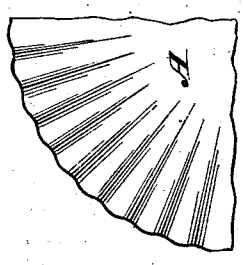
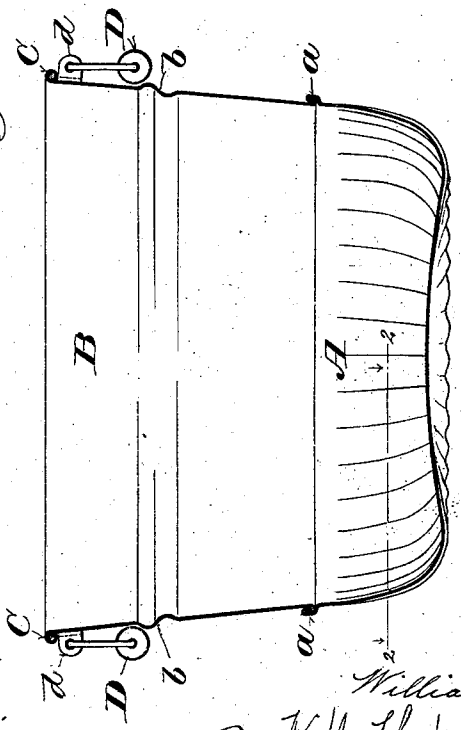


Fig. 1.



Witnesses:
Geo. W. Young.
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UNITED STATES PATENT OFFICE.

WILLIAM GENDER, OF MILWAUKEE, WISCONSIN.

SHEET-METAL VESSEL.

SPECIFICATION forming part of Letters Patent No. 685,832, dated November 5, 1901.

Application filed September 8, 1897. Serial No. 650,912. (No model.)

To all whom it may concern:

Be it known that I, WILLIAM GENDER, of Milwaukee, in the county of Milwaukee and State of Wisconsin, have invented certain new and useful Improvements in Sheet-Metal Vessels; and I do hereby declare that the following is a full, clear, and exact description of the invention, which will enable others skilled in the art to which it pertains to make and use the same, reference being had to the accompanying drawings, and to the letters of reference marked thereon, which form a part of this specification.

The main object of my invention is to produce a light, strong, durable, and inexpensive metallic carrying, measuring, and storing receptacle that may be used for the various purposes of wooden baskets and for other uses requiring a water-tight structure.

It consists in certain novel features of construction, as hereinafter particularly explained, and pointed out in the claims.

In the accompanying drawings like letters designate the same parts in the several figures.

Figure 1 is a medial vertical section of a metallic vessel embodying my improvements. Fig. 2 is a horizontal section on the line 2 2, Fig. 1, of a portion of the bottom; and Fig. 3 is an elevation of a slightly-modified construction.

The vessel or receptacle, which as a whole resembles in size and shape and is designed to serve the purpose of an ordinary bushel-basket, is composed of a radially-corrugated cup-shaped sheet-metal bottom A and a sheet-metal top or side section B, joined at its lower edge to the edge of the bottom by interlocking folds, forming a water-tight seam or joint *a*.

The bottom A is preferably made of one piece of metal without seam or joint and is preferably concaved on the under side, so that it will stand or rest squarely or firmly upon the margin only of its base. It is made of thin light sheet-steel or other suitable metal, the radial corrugations rendering it stiff and firm and facilitating its formation into cup shape without breaking or tearing the metal. The top section B is also made of thin light sheet metal and is formed, as shown in Fig. 1, with horizontal beading or fluting *b*, or, as shown in Fig. 3, with vertical fluting or corrugations *b'* to make it stiff and firm. Around its upper edge it is rolled over a wire to form a finishing and stiffening rim C.

The vessel is provided on opposite sides, at or near the top, with drop-handles D for lifting and carrying it. These bail-shaped handles, being pivotally attached to outwardly-bent perforated ears on metal bands *d*, which are riveted to the outside of the vessel just below the rim C, fall when not in use loosely at its sides out of the way, as shown in the drawings.

The vessel is preferably made of sheet-steel, and after the parts or sections are formed, assembled, and joined it is galvanized to prevent its rusting and to give it a neat and attractive finish. By the construction of the bottom and the manner of joining the component sections of the vessel, hereinbefore described, I am enabled to produce a light strong durable vessel at a comparatively small cost.

I am aware that vessels of this character have been stamped or drawn in a single piece; but this mode of construction involves a number of cupping and drawing operations and necessitates the employment of quite thick and heavy metal to withstand the great strain to which it is subjected by such operations without tearing or breaking, so that the weight of the finished article and its cost practically preclude its general use for ordinary purposes. I am also aware that vessels of this character have been made in sections, the side or body being vertically fluted or corrugated and joined to the outer edge of a substantially flat bottom or a bottom which is concave on the under side only, thus bringing the seam between the sections to the base on which the vessel stands or rests, where it is exposed to abrasion and dampness and is apt to soon become weak and leaky by reason of wear and rust.

By my improved construction the seam between the bottom and side or top sections is carried up above the base, where it is not exposed to wear and to moisture and is not lia-

ble to rust, and that portion of the bottom on which the vessel rests or stands is without seam or joint.

I claim—

1. As a new article of manufacture, a carrying, measuring and storing vessel consisting of a seamless corrugated sheet-metal cup-shaped bottom, and a separately-formed sheet-metal side or top section joined to the top edge of the cup-shaped bottom by a seam above the base of the bottom, substantially as described.

2. As an article of manufacture, a carrying, measuring and storing vessel consisting of a seamless cup-shaped bottom having its sides and a portion of its bottom corrugated, the bottom being concaved centrally on the under side and having its central portion non-corrugated, and a separately-formed sheet-metal side or top section joined to the top edge of the cup-shaped bottom by a seam above the base of the bottom, substantially as described.

3. As an article of manufacture, a carrying, measuring and storing vessel consisting of a seamless radially-corrugated cup-shaped bottom, and a separately-formed corrugated sheet-metal side or top joined to the top edge of the cup-shaped bottom by a seam above the base of the bottom, substantially as described.

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

WILLIAM GENDER.

Witnesses:
ALOIS MURAWSKY,
CHAS. L. GOSS.

Correction in Letters Patent No. 685,832.

It is hereby certified that the name of the patentee in Letters Patent No. 685,832, granted November 5, 1901, for an improvement in "Sheet-Metal Vessels," was erroneously written and printed "William Gender," whereas said name should have been written and printed *William Geuder;* and that the said Letters Patent should be read with this correction therein that the same may conform to the record of the case in the Patent Office.

Signed, countersigned, and sealed this 19th day of November, A. D., 1901.

[SEAL.]

F. L. CAMPBELL,
Assistant Secretary of the Interior.

Countersigned:

F. I. ALLEN,
Commissioner of Patents.