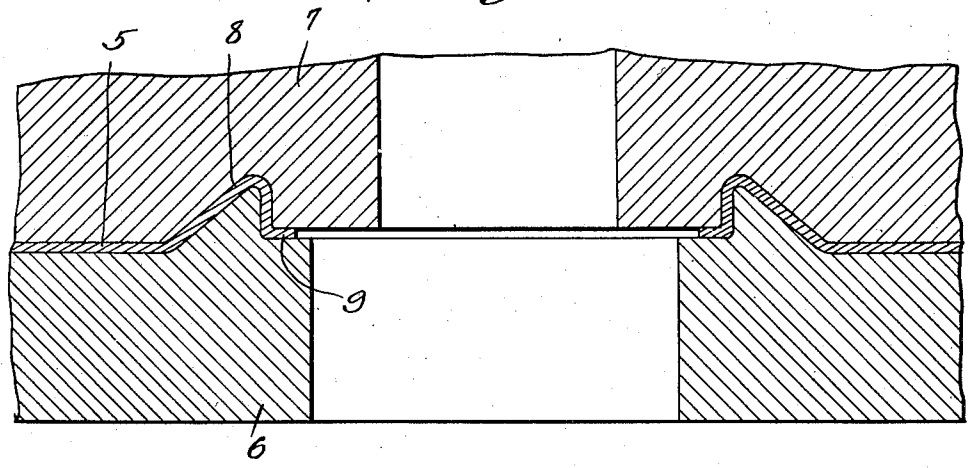
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METHOD OF SECURING BUNGS IN METALLIC CONTAINERS

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Fig. 1.



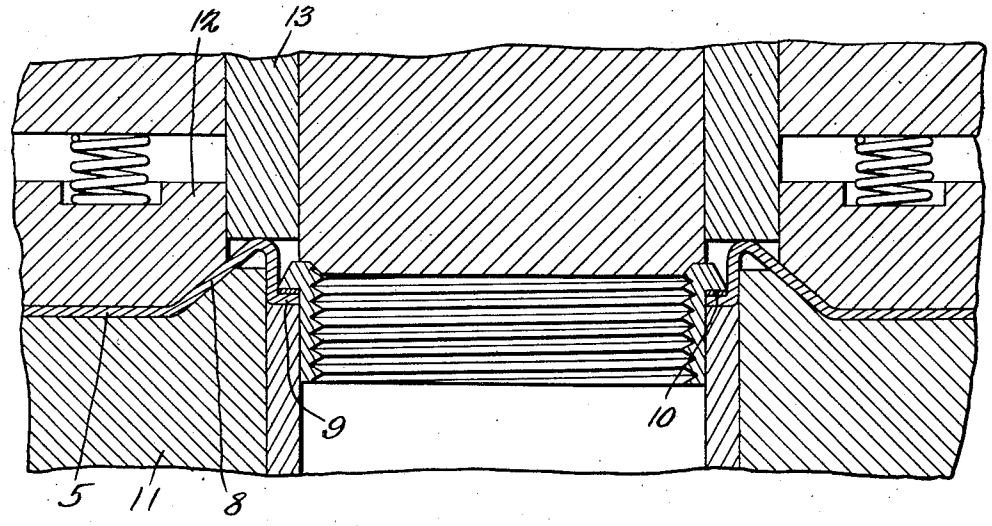


Fig. 2.

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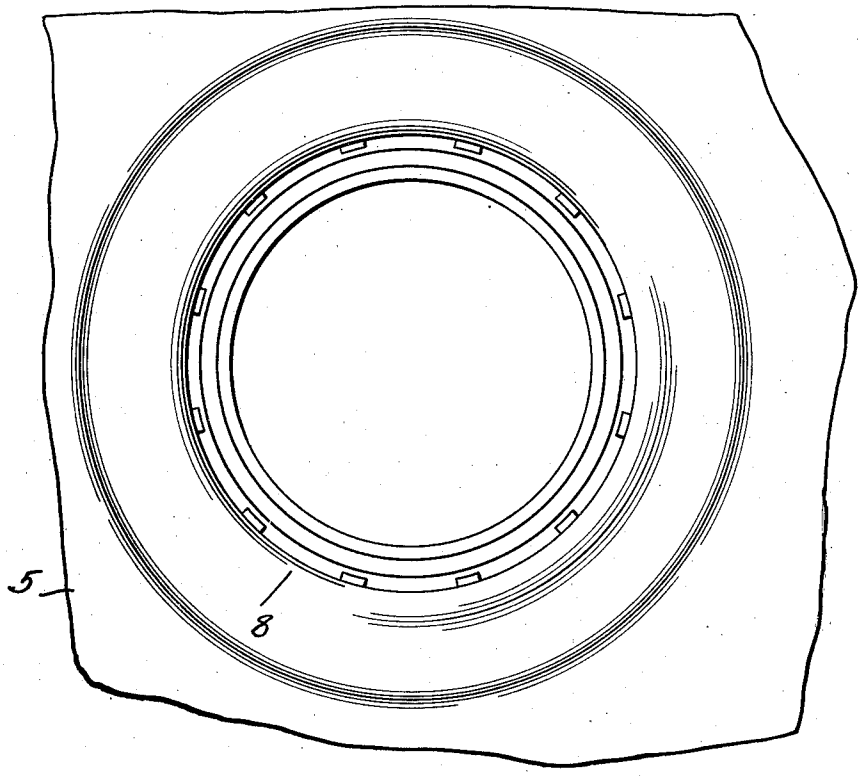


Fig. 3.

Fig. 4.

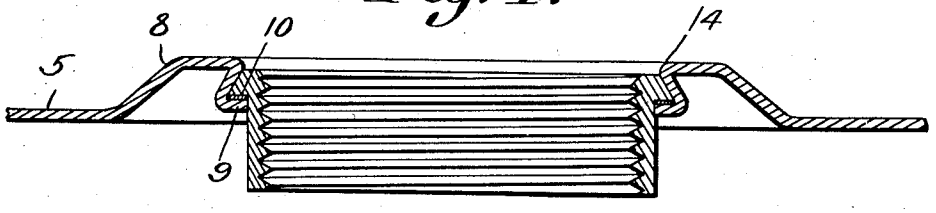
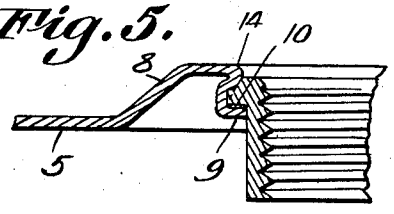


Fig. 5.



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UNITED STATES PATENT OFFICE

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METHOD OF SECURING BUNGS IN METALLIC CONTAINERS

Leon Moore Bell, Portsmouth, Ohio

Application February 1, 1933, Serial No. 654,727

4 Claims. (Cl. 29—148.2)

The present invention has reference to a method of securing bushings or sputs, forming a part of metallic barrels or drums, designed for shipping liquids, in position.

The primary object of the invention is to provide a method by means of which the sput may be positioned and secured, by pressing or rolling the metal of the barrel, over the outer upper edge of the bushing or sput without spinning the metal, insuring a close fit between the metal of the container and sput, and eliminating internal crevices or grooves, in which the material shipped in the container, could collect.

A further object of the invention is to produce a sput wherein the entire inner surface of the sput may be lacquered, so that the container or drum may be used in shipping edible foods.

With the foregoing and other objects in view, which will appear as the description proceeds, the invention resides in the combination and arrangement of parts and in the details of construction hereinafter described and claimed, it being understood that changes in the precise embodiment of the invention herein disclosed, may be made within the scope of what is claimed, without departing from the spirit of the invention.

Referring to the drawings:

Figure 1 is a sectional view through the forming machine employed in pressing a portion of the drum or container outwardly, adjacent to the opening thereof.

Figure 2 is a sectional view through the machine employed in rolling or pressing the enlargement of the container, over the upper edges of the sput.

Figure 3 is a plan view thereof.

Figure 4 is a sectional view through a container and sput secured by the pressing method, embodying this invention.

Figure 5 is a fragmental sectional view through the sput and container taken at a point through one of the enlargements of the sput.

Referring to the drawings in detail, the reference character 5 designates the body portion or container, which is formed with an aperture or opening for the reception of the bushing or sput in which the usual plug is positioned.

A machine is now provided which embodies a stationary former 6 and a movable former 7, into which the body portion or container is positioned in such a way that the formers will act on the body portion or container, at a point adjacent to the aperture or opening thereof. When the machine is operated, the metallic drum or container is pressed outwardly as at 8 adjacent to the sput opening, providing an enlargement, and an inwardly extended annular flange 9.

By this pressing operation, the sput opening is formed, and the sput to be secured to the container is dropped into the opening, with the annular shoulder 10 of the sput resting on the shoulder, as clearly shown by the drawings.

With the sput in this position, the sput and the container or the sput support are now transferred to a machine which embodies a stationary circular clamping member 11, and a movable circular clamping member 12, which clamping members have inclined surfaces corresponding to the inclined surfaces of the enlargement of the drum or container, the inclined surfaces of the clamps, cooperating in gripping and holding the metal of the container or support, at points adjacent to the opening, as shown by Figure 2 of the drawings.

The stationary clamp 11 is of a length so that a space is provided between the upper edge thereof, and the inner surface of the enlargement, of the container or support, formed during the pressing operation, thereby providing a surplus of material above the sput, to be engaged by the circular presser foot of the machine in which the container or body portion, and the sput, are now clamped.

This circular presser foot is indicated by the numeral 13, and when this presser foot is moved downwardly over the upper edge of the enlargement, formed by the first step of the method, and pressure is brought to bear thereon, the presser foot acts to roll or press that portion of the enlargement of the container adjacent to the sput opening, over the upper edge of the sput, as shown at 14 in Figures 4 and 5 of the drawings, thereby securely locking the sput within the sput opening.

Thus it will be seen that when a sput is positioned by the method embodied in this invention, the metal of the container or drum in which the sput is positioned, is rolled over the upper edge of the sput, from a point exteriorally of the sput, eliminating crevices or grooves on the inner surface of the container, in which material shipped in the container, may collect.

It is further pointed out that when drums or containers of this character are employed in shipping edibles, the inner surface of the sput may be entirely coated or lacquered, to prevent the material of the container, contacting with the metallic wall thereof.

Having thus described the invention what is claimed is:

1. The method of securing metallic sputs in metallic drums, consisting in forming an opening in a drum, bending the metal of the drum outwardly at the opening, bending the edge of the drum at the opening inwardly and laterally, placing a sput on the laterally extended portion of the drum, and finally rolling the outwardly bent portion of the drum over the outer edge of the sput and into engagement with the sput.

2. The method of securing metallic bung bushings for metallic drums, consisting in forming an opening in a drum, bending the drum outwardly at a point adjacent to the opening, bending the outwardly bent portion inwardly and laterally providing an annular shoulder, positioning a bushing on the annular shoulder so that a portion of the outwardly bent portion of the drum lies in a position above the bushing, and finally rolling that portion of the drum extended above the bushing, into engagement with the outer surface of the bushing.

3. The method of securing metallic sputs in metallic drums, consisting in forming an opening in a drum, bending the metal of the drum outwardly and downwardly adjacent to the opening, and forming an inwardly extended annular flange at the opening, placing a sput on the flange and within the opening of the drum, and finally rolling the metal of the drum over the outer edge of the sput.

4. The method of securing metallic sputs in metallic drums, consisting in forming an opening in a drum, bending the metal of the drum adjacent to the opening providing an inwardly extended annular flange at the opening, placing a sput on the flange and within the opening of the drum, and finally rolling the metal of the drum over the outer edge of the sput.

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