L. O. BROWN.

METALLIC VESSEL.

APPLICATION FILED OCT. 9, 1908.

1,037,202. Patented Sept. 3, 1912.

Fig. 1

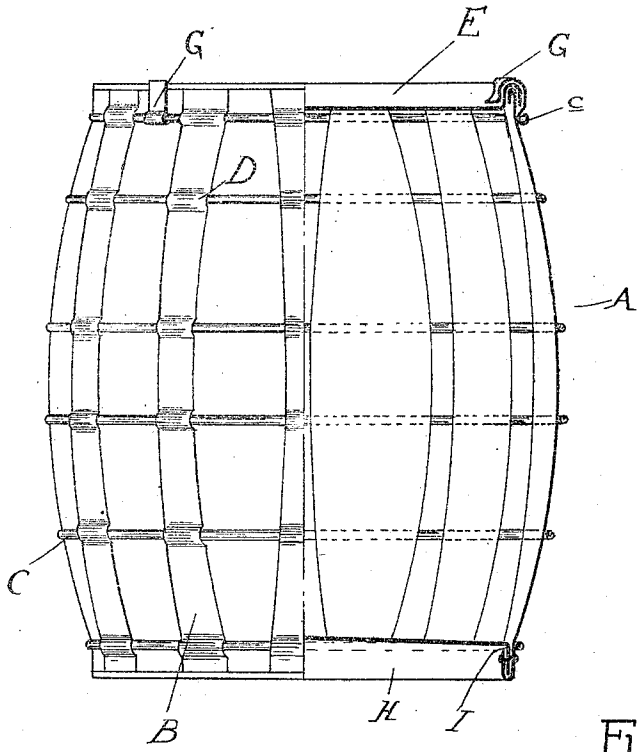


Fig. 4

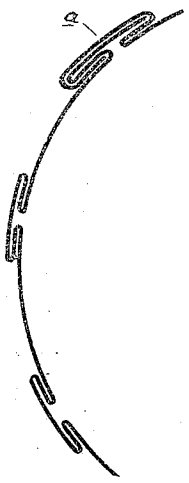


Fig. 2.

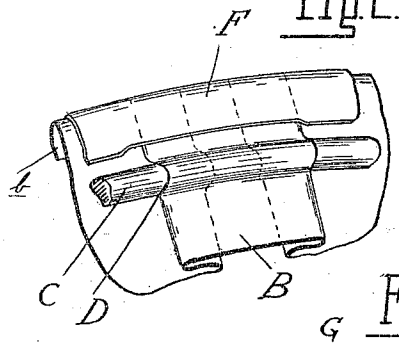
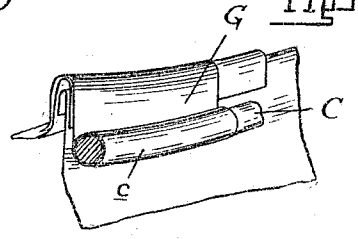


Fig. 3.



Witnesses

W. L. Ford

J. F. Belknap

Inventor

Louis O. Brown

By Whittemore, Hulbert & Whittemore

Attys

UNITED STATES PATENT OFFICE.

LOUIS O. BROWN, OF TOLEDO, OHIO, ASSIGNOR TO THE METALLIC BARREL COMPANY, OF CHICAGO, ILLINOIS, A CORPORATION OF MAINE.

METALLIC VESSEL.

1,037,202. Specification of Letters Patent. **Patented Sept. 3, 1912.**

Application filed October 9, 1908. Serial No. 456,993.

To all whom it may concern:

Be it known that I, LOUIS O. BROWN, a citizen of the United States of America, residing at Toledo, in the county of Lucas and State of Ohio, have invented certain new and useful Improvements in Metallic Vessels, of which the following is a specification, reference being had therein to the accompanying drawings.

The invention relates particularly to metallic barrels, and consists in the novel construction of the barrel, in the formation and manner of attachment of the head; and, further, in the novel and peculiar combination of the various parts, and in certain details of construction as will be more fully hereinafter set forth.

In the drawings,—Figure 1 is a view in elevation and vertical section of a barrel constructed in accordance with my invention; Figs. 2 and 3 are enlarged sectional perspective views, showing the construction of the body and the novel formation and manner of attachment of the head thereto; Fig. 4 is a partial cross section through the barrel body.

In the drawings thus briefly described, A represents the body of the barrel,—which is in this particular instance of the bilged type,—formed from a single piece of sheet metal, the meeting edges of which are connected by a lock-seam, as *a*. The extremities of the body are preferably cylindrical in form, and are return-bent, forming double-ply chines, as *b*.

For the purpose of strengthening the body, it is crimped longitudinally to form a circumferential series of folds, and these folds in turn are flattened to form box-plait ribs, as indicated by the reference-letter B, the plaits extending throughout the length of the barrel from chine to chine, as plainly shown in Fig. 1. To further strengthen the body construction, I preferably provide hoops, as C, made of wire, which encircle the body as shown and extend through transverse hollow ribs, as D, crimped in the box plaits, which serve to prevent endwise movement of the hoops.

A head, as E, is provided for the barrel adapted to be detachably connected to the body. The head, as shown, is provided with a trough-shaped peripheral section F which engages the reinforced chine and is held in place upon the chine by a plurality of clips, as G, the clips being anchored to the body in such manner as to be readily detached therefrom, and overhanging the head flange as shown. Preferably, the clips are secured to the upper hoop intermediate the folds of the body by turning the lower portion of the clip upwardly about the hoop in the manner indicated by the reference-letter *c*. As thus formed, the engaging portion *c* of the clip may be bent downwardly out of engagement with the hoop, thus permitting the head to be removed from the barrel when desired.

The opposite end of the body may be headed in the manner as described, but I preferably rivet the head in. A head, as H, is employed, provided with an outwardly extending flange I, the latter being secured by rivets within the reinforced chine, as illustrated.

It will be obvious from the construction of the barrel as set forth that the body may be of the bilged type described, or may be cylindrical in form. If a bilge is formed, the folds are crimped in such manner as to increase in width from the barrel center to each end, the excess of metal forming the folds at the ends giving the desired contour to the barrel body.

What I claim as my invention is,—

1. A metallic barrel body crimped lengthwise to form a series of longitudinal box-plait folds positioned exteriorly of the body and extending uninterruptedly from end to end thereof, each fold at intervals along its length being spaced from the body to form hollow transverse ribs, the hoops for the body extending through the ribs and held thereby against displacement.

2. A metallic barrel body crimped lengthwise to form a series of longitudinal box-plait folds positioned exteriorly of the body and extending uninterruptedly from end to end thereof, each fold at intervals along its length being spaced from the body to form hollow transverse ribs, the hoops for the body extending through the ribs and held thereby against displacement, and head retaining clips anchored upon portions of the end hoops of the body intermediate adjacent folds.

In testimony whereof I affix my signature in presence of two witnesses.

LOUIS O. BROWN.

Witnesses:
JAS. T. CROOKS,
MARY J. CROOKS.

Copies of this patent may be obtained for five cents each, by addressing the "Commissioner of Patents. Washington, D. C."