(No Model.) 2 Sheets—Sheet 1.

E. R. PELTIER.

MANUFACTURE OF SARDINE OR LIKE BOXES.

No. 535,855. Patented Mar. 19, 1895.

Fig. 1.

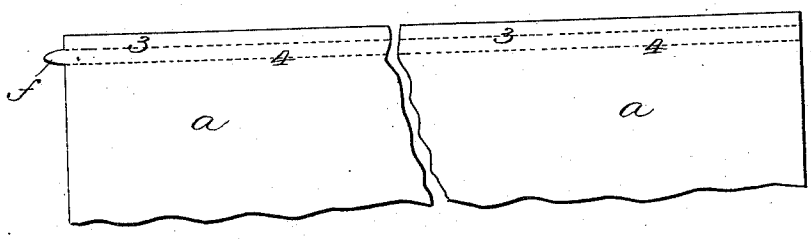


Fig. 2.

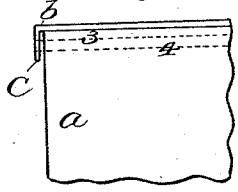
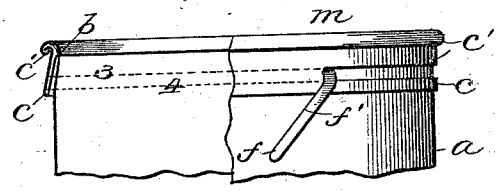


Fig. 3.



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his ATTORNEYS.

(No Model.) 2 Sheets—Sheet 2.

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Fig. 4.

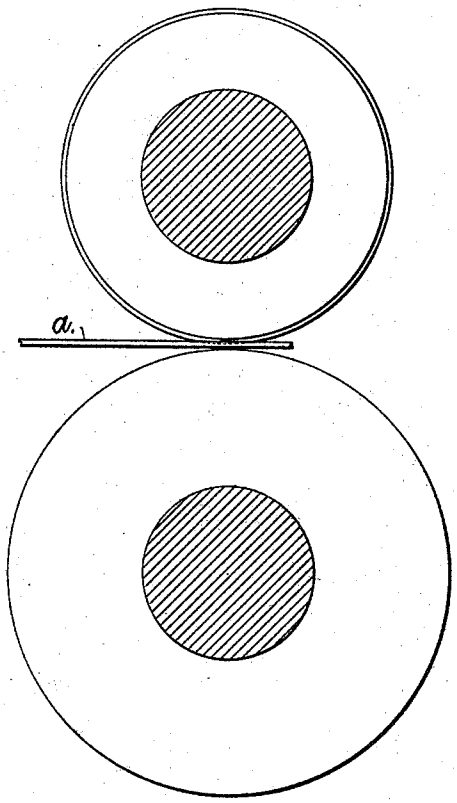
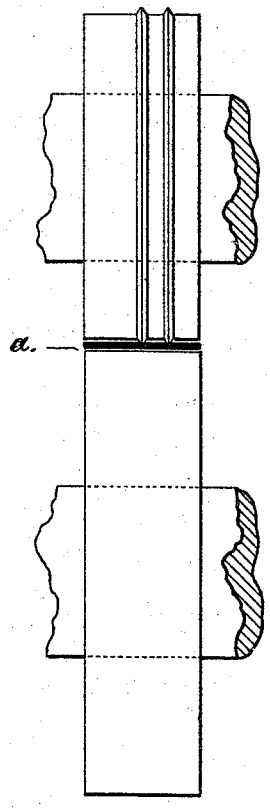


Fig. 5.



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UNITED STATES PATENT OFFICE.

EMILE RENÉ PELTIER, OF PARIS, FRANCE.

MANUFACTURE OF SARDINE OR LIKE BOXES.

SPECIFICATION forming part of Letters Patent No. 535,855, dated March 19, 1895.

Application filed August 17, 1894. Serial No. 520,630. (No model.)

To all whom it may concern:

Be it known that I, EMILE RENÉ PELTIER, a citizen of the Republic of France, residing at Paris, France, have invented new and useful Improvements in Sardine or Like Boxes for the Purpose of Facilitating the Opening of the Same, of which the following is a specification.

My invention relates to improvements in the manufacture of sardine and like boxes, the object being to allow of their being easily and cleanly opened without having to use or to tear away any soldered or applied strip as heretofore required; the strip or part to be removed constituting in my improvement an integral portion of the box itself.

According to my invention I first cut the body of the box from a single piece leaving a small tongue upon the side and at the upper part. I then pass it beneath two wheels which thin the metal at two places throughout the length of such blank extending from the said tongue. These wheels at the same time limit the width of the band to be torn out in order to open the box. I then doubly fold the upper edge of the body of the box, the folds being in reverse directions and effected by means of a suitable machine.

With my method of manufacture no solder is employed either inside or between the folds and the portion of the box body to be stripped or torn out is not touched by the solder at any point and thereby the tearing or stripping is facilitated.

To enable my invention to be fully understood I will now describe the same by reference to the accompanying drawings, in which—

Figure 1 is a view of the blank cut out to form the body of the box. Fig. 2 represents in section the body of the box after having been folded and refolded. Fig. 3 represents one of the methods of fixing the cover upon boxes of my manufacture in order to facilitate the opening of the same. Fig. 4 is a side view, and Fig. 5 a front view with two rollers adapted for thinning the metal in two parallel lines.

a is the blank for forming the body of the box, which blank is submitted to the action of two wheels which serve to thin the metal on two parallel lines to weaken the same to enable the strip of metal between the said lines to be readily torn out. The blank having been thinned as described is doubly folded as shown at *b* and *c*, Fig. 2, below the thinned portion. The thinning is effected at the top of the blank about one or two millimeters from the part where the folding is to take place and this position of the thinning is very important from the point of view of the manufacture of these easily opened boxes and allows of producing an advantageous and practical result which could not be obtained if the folding were effected upon one of the thin lines as in the latter case rents or apertures, which would destroy the hermetic closing of the box and occasion great loss in manufacture, might be produced. This tearing being effected beneath the edge of the cover and consequently below the level of the top of the box and requiring moreover only a very slight force to be exerted to tear the strip which is not soldered at any point, there is no fear of a person cutting himself or herself or of spilling the oil or other liquid contained in the said box.

As shown in Fig. 3 of the drawings, there remains at the point *c'*, after the band or strip *f'* has been torn, about two or three millimeters of the outer fold *c*, which by means of an outer bulge or crimp thereon as shown, engages with and adheres to an outer bulge or crimp on the disk cover *m*, and which allows, when once the strip has been completely removed, of covering the box when required while the contents are being consumed. To facilitate the application of the cover (after having removed it) if it is desired to again close the box to prevent the contents from deteriorating after the removal of the strip, or even to make use of it for other purposes when it is empty, the upper part of the body of the box *a* and of the fold *b* is slightly bulged outward so that when it is desired to replace the cover it is necessary to somewhat force it down which causes it to be held down in place even when turning the box upside down, and consequently closes it hermetically. The bottom of the box is applied in the usual manger. In the said figure the folds are shown projecting for the sake of clearness but in practice they are embedded in the body of the box which to this end is slightly bent inward.

It will now be seen that in making the box, I make no cut or actual incision around its body tending to weaken it; that the upper portion of such body beneath the strip and from which it is to be torn away, is actually stronger than other parts, consisting in fact of two thicknesses of the metal, and which remain even after the outer fold has been severed at the upper line of the strip, leaving the upper part of such fold held tightly by the now removable cover, and serving as a cylindrical rim for the same.

I claim—

1. A sardine or like metal box, the body of which has its upper part doubly folded or retroverted, its outer fold having a projecting tongue integral therewith and also adapted to form the flange of the cover, and having also two parallel lines thinned or reduced in such outer fold and extended from such tongue and whereby upon opening the can, said flange is reduced in its width, substantially as shown and described.

2. A metal box having its upper portion doubled downward and then doubled upward to project its outer fold beyond the first bend or double, the upper edge of such outer fold having an outward crimp or curve engaging with an inward curve or crimp on a disk cover plate, the body of the box being provided with a tongue for tearing away a strip from the outer fold, and leaving the metal which was above said strip, as a rim crimped on the cover.

3. A metal box having the double fold at its top closed together without soldering, and having the described thinned lines and the projecting tongue in the outer fold, such outer fold projecting above these thinned lines and outwardly bulged or crimped, and serving to engage with a cap piece or cover also outwardly bulged or crimped, the downward or first bend of the body presenting a rounded or smooth edge when the box shall have been opened by the tearing away of the thinned strip from the body of the box.

4. A sardine or like box, having the tongue, the thinned parallel lines, and the double folding beneath the same as shown and described, and having a cover clinging by means of a fold to the upper part of the outer fold of the box, and whereby when the thinned part is torn away a portion of the body of the box remains connected to and forming a rim for the cover.

In witness whereof I, the said EMILE RENÉ PELTIER, have hereunto set my hand.

EMILE RENÉ PELTIER.

Witnesses:

ADOLPHE CHENAULT,

CLYDE SHROPSHIRE.