

(No Model.)

2 Sheets—Sheet 1.

R. L. BROWN.
FILE CASE.

No. 498,926.

Patented June 6, 1893.

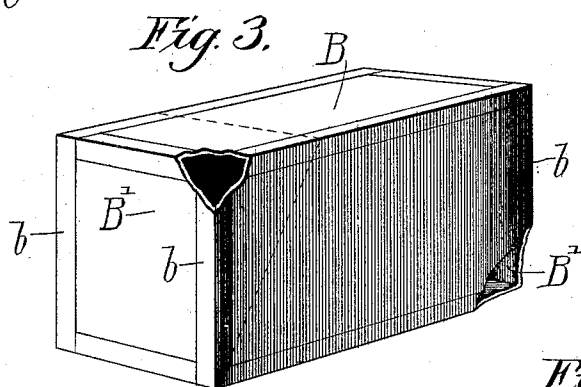
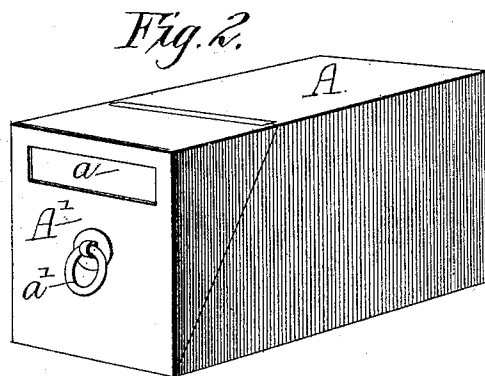
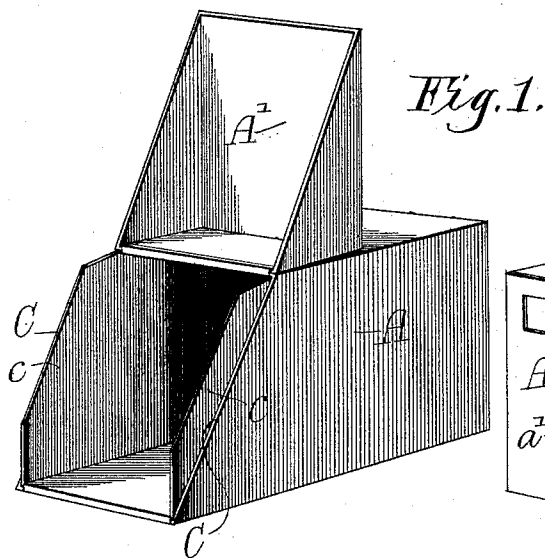


Fig. 5.

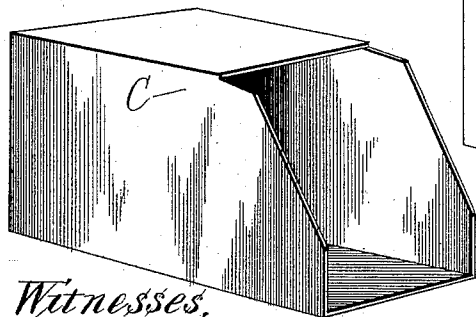
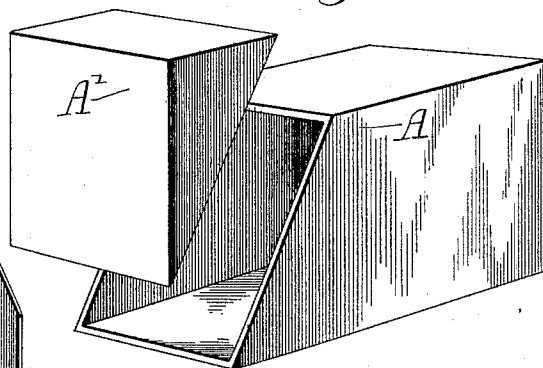


Fig. 4.



Witnesses.

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Fig. 6.

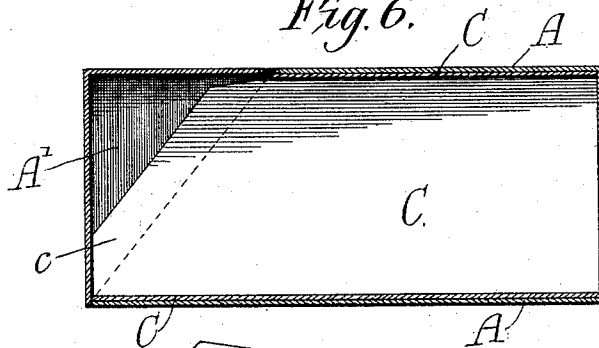


Fig. 7.

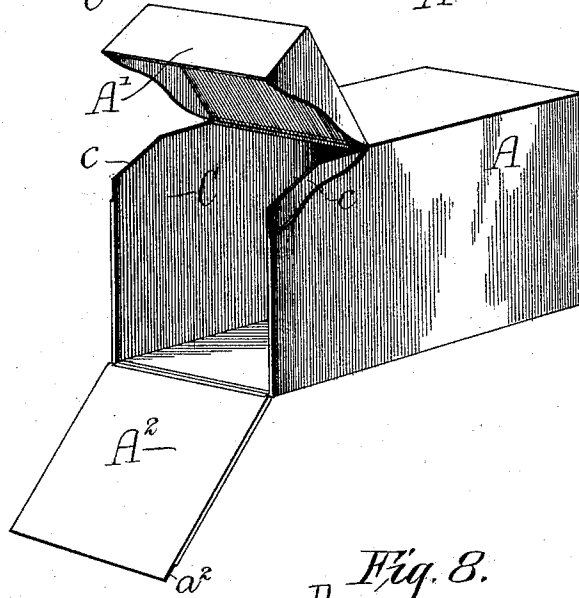


Fig. 8.

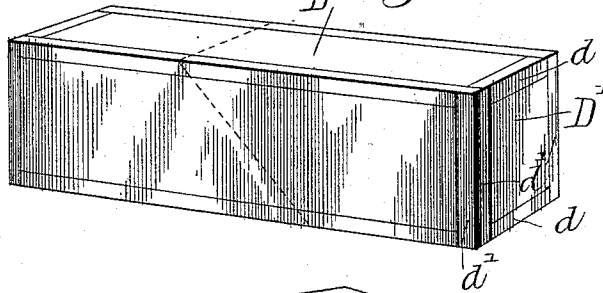
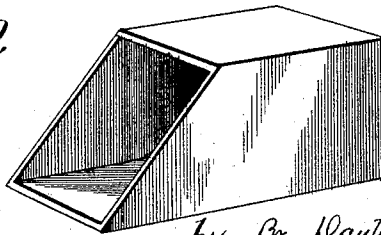


Fig. 9.



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UNITED STATES PATENT OFFICE.

REUBEN L. BROWN, OF CHICAGO, ILLINOIS.

FILE-CASE.

SPECIFICATION forming part of Letters Patent No. 498,926, dated June 6, 1893.

Application filed August 22, 1892. Serial No. 443,690. (No model.)

To all whom it may concern:

Be it known that I, REUBEN L. BROWN, of Chicago, in the county of Cook and State of Illinois, have invented certain new and useful
5 Improvements in File-Cases; and I do hereby declare that the following is a full, clear, and exact description thereof, reference being had to the accompanying drawings, and to the letters of reference marked thereon, which form
10 a part of this specification.

This invention relates to an improved method or process of making paper or straw board file cases, of the type known as pigeon hole boxes, and other similar receptacles, as for in-
15 stance, file cases or cases therefor having inclined or curved open ends.

The object of the invention is to provide a construction which shall secure economy of time and labor in the manufacture of such
20 articles.

The invention consists in the matters hereinafter described and set forth in the appended claims.

Heretofore file cases of this type have been
25 made by first cutting out a blank of proper shape to make a file case of desired size, folding or bending said blank into tubular form and securing an end wall therein. In case caps or covers are desired, they are similarly
30 made from separate pieces of material. This method involves the cutting of the material of which the file cases are made into irregularly shaped blanks and necessitates a separate operation of folding and the insertion of
35 the end piece for each box or file case and for each cap or cover. Flanges for guiding and supporting the cover in position have been formed by attaching separate pieces of material to the sides of the file case so as to project
40 and form the flanges desired.

In carrying out my invention a tube is made of sufficient length to form two open-ended file cases or one file case and its cover, and end walls are then secured in said tube by
45 means of stay-strips or otherwise and thereafter the tube is cut into two parts so as to leave the severed ends of any desired shape. The guide flanges are formed by making a second tube of shape and size to fit closely
50 within the file case proper and of such length that the end margins of the side walls thereof

will project beyond the sides of the file case and in such manner as to form guides of a shape and size desired.

In the accompanying drawings a series of
55 file cases and blanks is shown which fully illustrate the features of manufacture comprising the invention.

Figures 1 and 2 are perspective views of a file case having a hinged end or cover. Fig. 60
3 is a perspective view of a blank or tube adapted to form such a file case. Fig. 4 is a perspective view of the same box, the end having been cut off to form a cap or cover therefor. Fig. 5 is a perspective view of the
65 blank for forming the guide flanges. Fig. 6 is a vertical longitudinal section of the file case shown in Figs. 1 and 2. Fig. 7 is a perspective view of a modified form of said file case. Fig. 8 is a perspective view of a blank
70 adapted to form two open-ended file cases; end walls having been inserted therein prior to dividing it. Fig. 9 is a perspective view of an open-ended file formed by dividing the blank shown in Fig. 8 on the dotted line shown
75 in that figure.

To first describe the method of making the form of file case shown in Figs. 1 and 2: This box consists of the file case proper, A, and a cap or cover, A'. Instead of being made sepa-
80 rately and of different pieces of material in the manner heretofore common, a single tube, B, similar to that shown in Fig. 3, is made from one piece of material, and head or end walls B', B', are then inserted into the ends
85 of said tube, being secured therein by stay strips, b b, or in any other approved way. Preferably also, the corners of the blank will be strengthened or reinforced by stay-strips, b' secured thereto in a familiar manner. The
90 blank thus formed is then cut or divided obliquely as indicated by the dotted line shown in said Fig. 3, thus forming the body A of a file case and of a cover A' therefor (Fig. 4). Said cover is thereafter hinged to the file case
95 in any approved manner. In the form of file case above referred to guide flanges, C, are present for holding in place the cover when closed. These guide flanges C are formed by the projecting margins of the side
100 walls of a tube C, of such size that it may be inserted within the body A of the file case,

One end of said tube C is cut so that its side walls will project beyond its top and bottom walls, and the side walls are made of such length that when the tube is inserted within the file case A the projecting ends of the side walls will extend beyond the sides of said file case to form the flanges *c c* which may be made of any desired form by suitably shaping the projecting ends of the side walls at the time of cutting the same. The tube C will commonly be secured within the body of the file by adhesive substance applied to one of the parts before the tube is slipped into the body of the file.

The file case blanks or bodies made as set forth may be finished in any desired manner; as shown they are covered with paper or cloth. Card holders are secured to the front or exposed end thereof, provided with an opening, *a*, for exposing a label, and a ring or handle *a'* is secured to the front thereof in the usual manner.

The modified form of the file case shown in Fig. 7 is constructed in all respects in the same manner as that just described. It comprises a similar file case A; hinged cover A'; and an internal tube, C, having projecting side walls forming guide flanges, *c c*. In this form of the file case however, the tube or blank is cut across the upper edge of the front end and an end flap, A², is formed by cutting out the end wall of the blank which is below the cover and hinging the same to the bottom of said case; said flap being held in its closed position by means of the hinged cap which is adapted to project below and engage the upper edge of a flange or ledge *a'* formed on the said end piece by securing an additional thickness or layer of straw-board to the inner surface of the flap, which additional thickness or layer extends beyond or above the end or free edge of the flap in the manner shown. Said cap will retain the end piece in position to close the end of the file case and when the cap is raised the end piece will drop down so as to expose the papers contained in said case. By this improved method of construction I am enabled to so cut the blank that the joint between the cap and the file case proper at the side of the box will be curved, as seen in Fig. 7, or of any other desired shape, while leaving the guide flanges *c* straight or of any other de-

sired or preferred shape, thereby giving an ornamental finish to the file case.

Figs. 8 and 9 illustrate the method of constructing the ordinary open ended form of file case. The first step in the construction of such cases according to my improved method is the formation of a tube or blank, D, from a single piece of suitable material, usually straw-board; the blank being made of proper length to form two file cases. End walls or heads D' are then inserted in the open ends of the blanks and secured by stay-strips, *d*, other stay-strips, *d'*, being preferably applied to the corners of the tube to strengthen and render more stiff the joints thereof. The closed tube thus formed is then divided along the dotted line shown in the drawings, so as to form the bodies of two cases of the same size and shape; the form shown in Fig. 9 being a common one. These cases have no covers and no guide flanges.

It is obvious from the foregoing description that the principle involved in the manufacture of these file cases according to my improved method is the same whether a covered or an open-ended file case is constructed.

I claim—

1. The herein described method of making file cases, consisting in forming an open ended tube of proper length to form two file cases or a file case and its cover, then securing heads or end walls in both ends of said tube, and thereafter dividing said tube so as to form a file case and its cover or two file cases, substantially as described.

2. The herein described method of making file cases, consisting in forming an open ended tube of proper length to form a file case and its cover, then securing heads or end walls in both ends of said tube, then severing a part of the closed blank thus formed to constitute a cover, and thereafter inserting into said file case a closely fitting tube the side walls of which project beyond the sides of the file case and form the flanges thereon, substantially as described.

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

REUBEN L. BROWN.

Witnesses:

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G. W. HIGGINS, Jr.