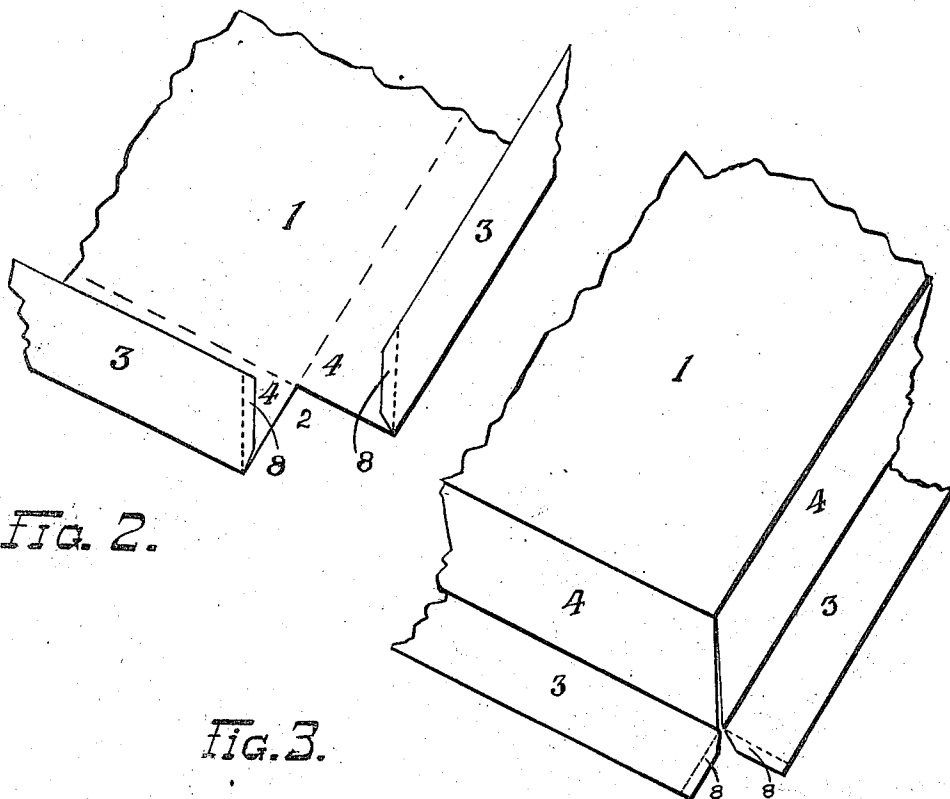
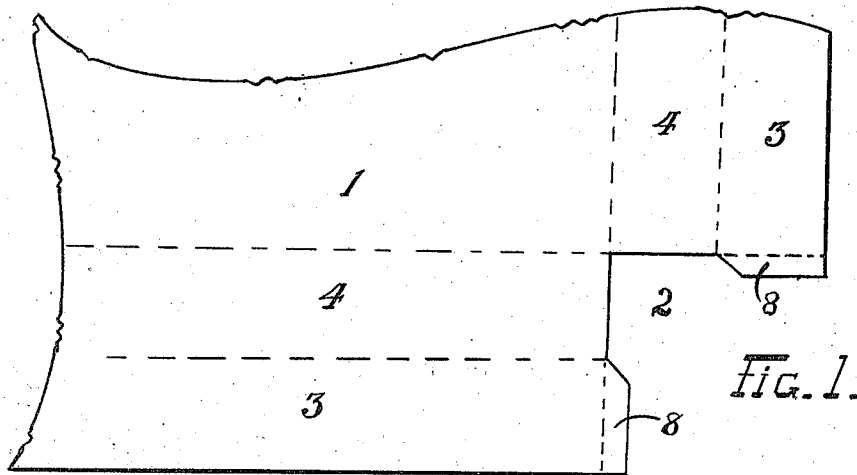


F. F. BENTLEY.
ICE CAN.
APPLICATION FILED JAN. 22, 1912.

1,027,802.

Patented May 28, 1912.

2 SHEETS—SHEET 1.



WITNESSES:

J. B. Cole.
A. Voorhes

INVENTOR
Frank F. Bentley
BY Geo. W. Upton.
Attorney

F. F. BENTLEY.

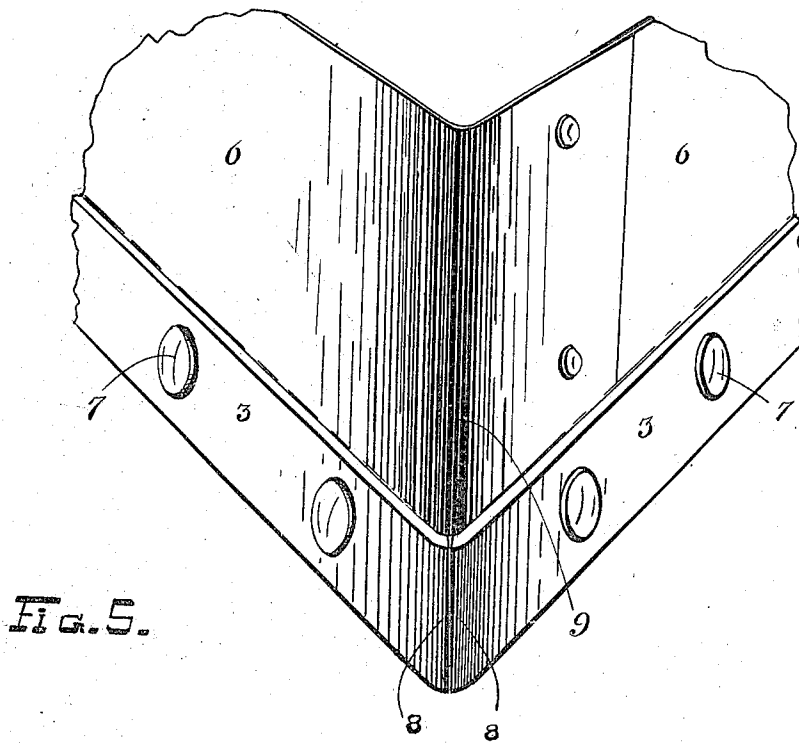
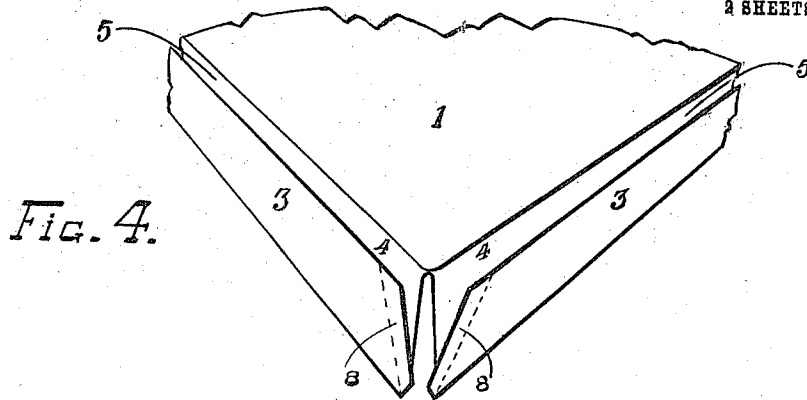
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UNITED STATES PATENT OFFICE.

FRANK F. BENTLEY, OF WARREN, OHIO.

ICE-CAN.

1,027,802.

Specification of Letters Patent.

Patented May 28, 1912.

Application filed January 22, 1912. Serial No. 672,537.

To all whom it may concern:

Be it known that I, FRANK F. BENTLEY, a citizen of the United States of America, residing at Warren, in the county of Trumbull and State of Ohio, have invented certain new and useful Improvements in Ice-Cans, of which the following is a specification.

My invention relates to improvements in the construction of ice cans of that class in which the side walls of the can are united to its bottom by an external folded seam; and the objects of my improvements are to strengthen the bottom corners of the can and to reduce the number of constructive operations and, thereby, the manufacturing cost and selling price of ice cans.

I am aware that cylindrical tanks and casks have been successfully made by stamping a circular bottom with seamless turned up outer walls to form receiving pockets for the end of the cylindrical side wall. For compactness in shipping, both the ice cans and the ice made in them, however, it is desirable and practically a commercial necessity to make the cans nearly parallelepiped in form, with quadrilateral faces and ends. To form a quadrilateral bottom with folded up edges has necessitated the slitting of the corners of the metal plate, thereby making the lower corners of the cans the weakest parts, whereas they should be the strongest parts of the can.

I have devised a way to provide the necessary metal to make the corners of the can's bottom equally as strong as the rest of the can, without additional construction cost.

I attain these objects and results by the mechanism illustrated in the accompanying drawing, in which:—

Figure 1, is a plan of one corner of a rectangular sheet of metal. Fig. 2, is a perspective of the same after the first operation. Fig. 3 is a perspective of the same after the second operation. Fig. 4 is a perspective from the same point of view after the third operation and Fig. 5 is a perspective of a lower corner of the completed ice can, broken away.

Similar characters refer to similar parts throughout the several views.

A sheet of metal, 1, is placed under a suitable blanking die which makes an in-

cision, 2, at each corner of the sheet. A forming die then bends up the leaves 3, 3, as shown in Fig. 2. Another die turns down the strips 4, 4, carrying with them the leaves 3, 3 as shown in Fig. 3. The leaves 3, 3, are then bent upward, as shown in Fig. 4, forming pockets, 5, 5 Fig. 4, and the four walls 6, 6 of the ice can, are seated in said pockets. Thereupon the strips 4, 4, and the leaves 3, 3 are hammered or pressed tightly against the walls 6, 6, and held by rivets 7, 7. The tongues 8, 8 are then pressed tightly together so as to clasp the corner, 9, of the ice can walls 6, 6; with the result that the four corners of the bottom of the ice can are completely metal covered, and the vacuities necessarily left at said corners, prior to my invention, are avoided. The walls, 6, 6; leaves 3, 3; edges 4, 4 and tongues 8, 8 are then soldered together with a resulting can having as much metal at its lower corners as at any other place or places.

I claim:—

1. In a vessel, the combination of a body of rectangular cross section, and a rectangular sheet bottom portion, said sheet cut away at the corners, and the side portions intermediate thereof folded upon themselves to provide retaining means for the end wall of the vessel body, and providing a vessel supporting rim, and the edges of said cut away corners meeting when said side portions are folded, substantially as described.

2. In a sheet metal vessel, the combination of a sheet metal body of rectangular cross section, and a rectangular sheet metal bottom portion, said bottom sheet cut away at the corners, and the side portions intermediate thereof folded along double parallel lines to provide inner and outer flanges, said flanges being folded and providing a channel to receive the end wall of the vessel body, and providing a vessel supporting rim, and the adjacent edges of said flanges meeting and forming a closed seam, substantially as described.

3. In a sheet metal vessel, the combination of a rectangular sheet metal body, and a rectangular sheet metal bottom portion, said bottom sheet cut away at the corners, and the side portions intermediate thereof folded along double parallel lines to pro-

vide inner and outer flanges, said outer flanges provided with integral tongues at the ends thereof, said flanges providing a channel to receive the end wall of the vessel body, and providing a vessel supporting rim, the adjacent edges of said inner flanges meeting on one side of the vessel body and the adjacent pairs of tongues of the outer

flanges meeting on the outer side of said vessel body, substantially as described. 10

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

FRANK F. BENTLEY.

Witnesses:

HELEN FLODEN,
J. B. COLE.

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