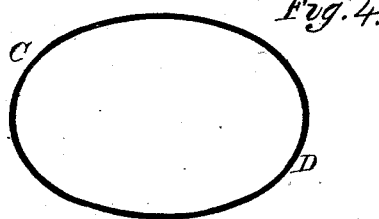
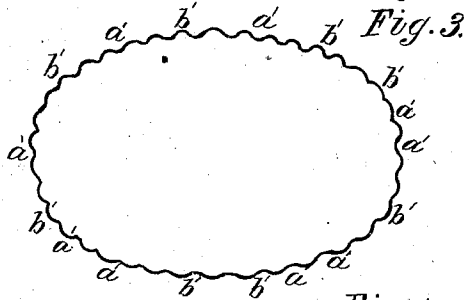
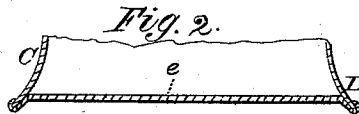
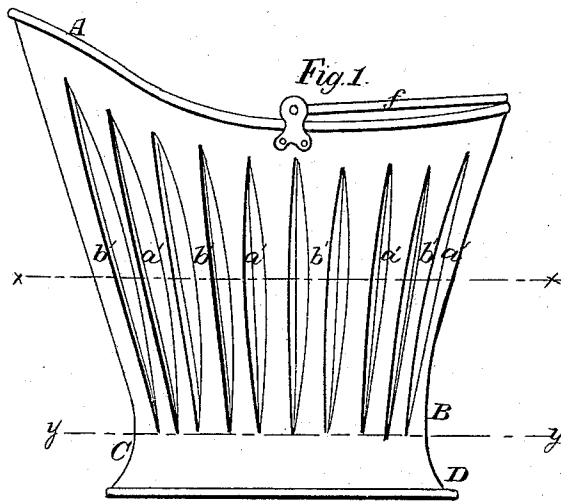


J. FALLOWS.
Coal Scuttle.

No. 70,427.

Patented Nov. 5, 1867.



Witnesses-

*Jas. C. Managan
 Joseph H. Stewart*

Inventor

James Fallows

United States Patent Office.

JAMES FALLOWS, OF PHILADELPHIA, PENNSYLVANIA, ASSIGNOR TO
PORTER & BOOTH, OF THE SAME PLACE.

Letters Patent No. 70,427, dated November 5, 1867.

IMPROVEMENT IN THE CONSTRUCTION OF SHEET-METAL BUCKETS.

The Schedule referred to in these Letters Patent and making part of the same.

TO ALL WHOM IT MAY CONCERN:

Be it known that I, JAMES FALLOWS, of the city of Philadelphia, in the State of Pennsylvania, have invented a new and useful Improvement in the Manufacture of Sheet-Metal Buckets and other vessels having flared or flanged bases; and I do hereby declare that the following is a full, clear, and exact description of the construction of the same, reference being had to the accompanying drawings, making a part of this specification, in which—

Figure 1 is a side elevation of a coal-bucket or hod.

Figure 2, a vertical diametral section of the base of the same; and

Figures 3 and 4, horizontal sections, respectively, on the dotted lines *x* and *y* of fig. 1—

Like letters of reference indicating the same parts when in the different figures.

The object of my improvement is to lessen the cost of manufacturing sheet-metal vessels requiring flanged or flared bases, and at the same time to increase the strength and rigidity of their bodies.

My invention consists in producing the flanged or flared base of a coal-bucket, or other sheet-metal vessel requiring a flared base, by corrugating the plates of which the body of the vessel is formed, so as to cause the lower portions of the same to be thrown obliquely outward by the operation, in such a manner as to produce the flared base required, substantially as hereinafter described and set forth.

Referring to the drawings, A B is the body of a sheet-metal coal-bucket, as improved, and C D the flared base of the same. The body A B and the base C D are both formed together of the same piece or pieces of sheet metal, the flaring form being given by making the corrugations or wrinkles *a' b'* in that portion of the said plate or plates which goes to form the body of the vessel, (see fig. 1.) The corrugations *a' b'*, figs. 1 and 3, are produced by compressing the sheets of metal which are to form the vessel between appropriate dies constructed for the purpose, and so also as to keep the flaring portion C D even and uniform or free from wrinkles, (see figs. 1 and 4.) The corrugated sheets of metal are then united together at their side edges in the usual well-known manner of uniting sheet-metal plates, there being two or three sheets generally required to complete the circumference of the vessel. The bottom plate *e* is then attached by overlapping its edge upon the edge of the base, substantially as shown in fig. 2, and the upper edge of the vessel then wired, and finally finished by attaching the bail *f*, if a bucket, as heretofore.

It will be seen that the producing of the corrugations *a' b'* will necessarily contract the sheet metal at the parts, in a direction across them, and thus cause the plain part C D below them to flare outward, and that the latter will be readily curved, by the closing of the dies, into a uniform and even shape, substantially as shown in fig. 1, whilst the corrugations *a' b'* will greatly stiffen the body A B, and that therefore the necessity of riveting a flanged or flared base to a separately formed body, as heretofore, is avoided, and a stronger and better article produced from the same material, and at less expense.

Having thus fully described my improvement, what I claim as new, and desire to secure by Letters Patent, is confined to the following, viz:

I claim producing the flared or flanged base of a sheet-metal vessel requiring such a base, by corrugating the sheet metal of the body of the vessel, substantially as described and set forth.

JAS. FALLOWS.

Witnesses:

JAS. I. FLANAGER,

JOSEPH W. STEWART.