

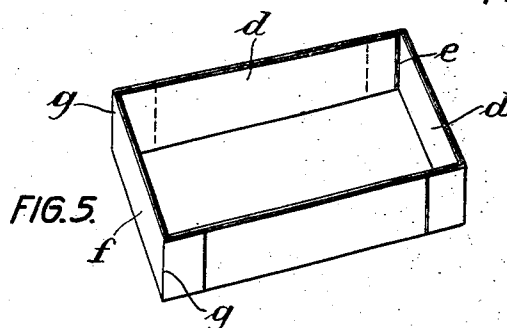
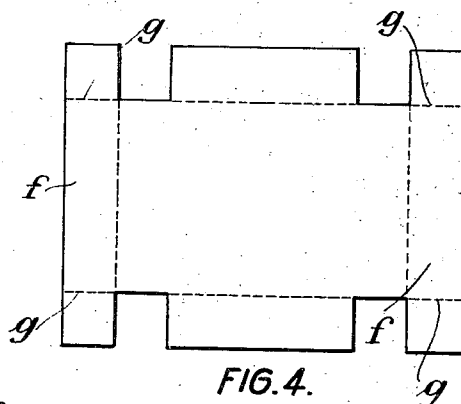
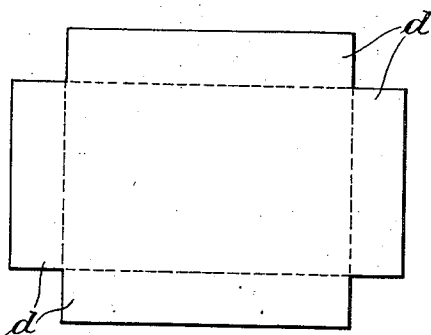
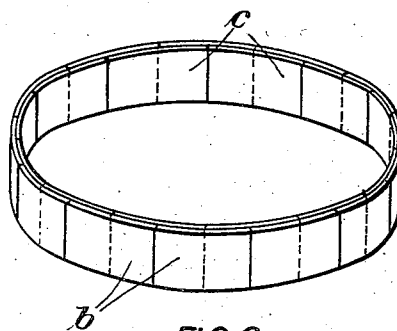
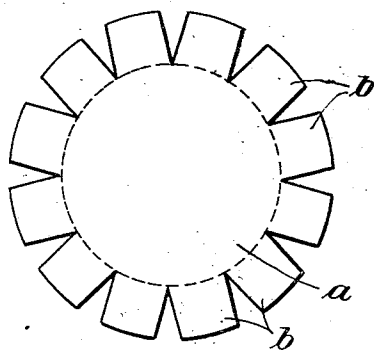
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METHOD OF MANUFACTURING CONTAINERS

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METHOD OF MANUFACTURING CONTAINERS

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Containers such as boxes or the like are often manufactured by a plate, for example, a piece of paste board being first appropriately cut so that tongues are formed on it which when suitably bent form, for instance the side walls of the box. The tongues forming the side walls of the box usually overlap and are connected together, for example by clips, such as are used for books. Such containers are not very durable.

The invention relates to a method of manufacturing containers such as boxes or the like, in which for one box or better for one part of a box (bottom part) not one but two plates are used. According to the invention the two plates are first appropriately cut, that is provided with tongues for the side walls of the container, then the tongues are bent into the shape of the container and finally the work pieces are placed one within the other, in such a manner that the tongues of one plate cover the joints of the other plate after which the two work pieces are joined together, for example by gluing in a press. With such a method it is possible to make, not only paste board, but also wood veneer, in the containers for example, boxes or the like in an advantageous manner.

The method according to the invention is described with reference to the accompanying drawing. In the drawing

Fig. 1 is a plan of a plate like work piece, cut ready for treatment (development of a part of the container).

Fig. 2 is a perspective view of a part of a container for example, lower part of a round box.

Figs. 3 and 4 are developments of the work pieces for the lower part of a rectangular container.

Fig. 5 is a perspective view of the lower part of a rectangular container.

The invention will be described first with reference to a round container. First of all two plates are so cut that round work pieces are obtained with a middle part *a* and lateral tongues *b*. The tongues *b* are then bent, for example, at right angles to the middle part *a*; the work pieces therefore receive the shape of a container, as is shown in Fig. 2. The

work pieces in the shape of containers are then placed one inside the other so that the tongues *b* of the outer work piece cover the joints *c* of the inner work piece, and the tongues of the inner work piece cover the joints of the outer work piece. The two work pieces are then joined together in a suitable manner. It is particularly advantageous to glue them together in a press. Wood veneer can then be used for making the container and the containers are especially durable. Of course it is at once possible to glue three or more work pieces together instead of two work pieces. The number of work pieces to be glued together depends on the strength of the container to be made.

For manufacturing rectangular containers the work pieces are not made similar but are cut, as shown in Figs. 3 and 4. The joints which are formed for example when the tongues *d* of the work piece shown in Fig. 3 at the corners *e* are embraced and closed by the tongues *f* of the parts *g*.

The tongues on the work pieces according to Figs. 3 and 4 may also be of other shape. Their shape depends entirely on the container to be made.

It should be mentioned that it is not absolutely necessary to effect the bending of the tongues by a separate operation. It is possible to bend the tongues when the work pieces are placed in the press. In this case either all the tongues or only a part of them, for example only the tongues of one work piece can be bent.

What I claim is:

1. A method of manufacturing containers such as boxes or the like, by forming a plurality of intermediate work pieces of about equal sizes, consisting of round wood veneer plates with a round middle part and a plurality of narrow and star-shaped arranged tongues cut from the said middle part, bending the tongues at right angles into the shape of the container, placing the intermediate work pieces one within the other, turning the two intermediate work pieces relatively to each other so that the tongues of one intermediate work piece cover the joints of the other inter-

mediate work piece and permanently connecting the intermediate work pieces together.

2. A method of manufacturing containers such as boxes or the like, by forming a plurality of intermediate work pieces of about equal sizes, consisting of round wood veneer plates with a round middle part and a plurality of narrow and star-shaped arranged tongues cut from the said middle part, centering the intermediate work pieces on one another, turning the intermediate work pieces relatively to each other so that the tongues of one intermediate work piece cover the joints of the other intermediate work piece, bending the tongues at right angles in a press and permanently uniting the intermediate work pieces by gluing them in a press.

In testimony whereof I have signed my name to this specification.

WILHELM LELL.