

C. STORER.

Manufacture of Boxes.

No. 133,496.

Patented Nov. 26, 1872.

FIG. 1

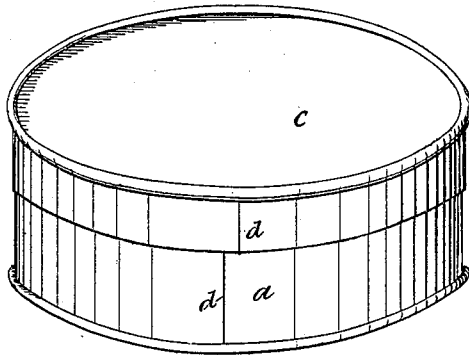


FIG. 2.

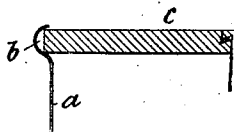


FIG. 3

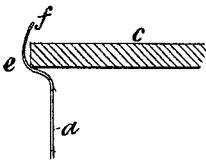
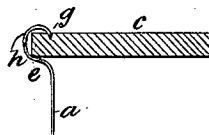


FIG. 4.



Witnesses

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## IMPROVEMENT IN THE MANUFACTURE OF BOXES.

Specification forming part of Letters Patent No. 133,496, dated November 26, 1872.

*To all whom it may concern:*

Be it known that I, CHARLES STORER, of the city of Montreal, in the district of Montreal, in the Province of Quebec, Canada, have invented new and useful Improvements on the Manufacture of Boxes composed of Tin and Wood, &c.; and I do hereby declare that the following is a full, clear, and exact description of the same, reference being had to the annexed drawing, where—

Figure 1 represents a perspective view of box; Fig. 2 represents a detail view, old method; Fig. 3 represents a detail view, new method; and Fig. 4 represents a detail view, finished.

This invention has reference to the construction of boxes of a cylindrical form with flat ends. These have their cylindrical portions made of tin or other thin sheet metal, while the top and bottom are made of wood, cardboard, &c. The object of the present invention is to form a closer-fitting joint between the wood or card-board and the tin, and thus adapt them better to the purposes for which they are at present employed.

In the drawing, similar letters of reference indicate like parts.

It may be well here to explain the present mode of manufacturing these boxes, the better to illustrate my improved method.

The tin cut to form the cylindrical parts *a* of the box is, in the method now employed, first taken and its edge bent with a pair of grooving-rollers, forming the recess *b*. This is then placed around the wooden top or bottom *c* of the box and its ends brought together, (the length of the strip *a* being cut in the first place to give its ends the required amount of overlap.) They are then soldered—the outer end *d* upon the inner one. This gives the form of joint around the top and bottom shown in Fig. 2, which is formed by the bearing of the edges of *c* in the recess *b*.

In my improved method the strip of tin, which has been cut to the proper dimensions for the size of the box required, is first bent to form a cylinder of the required size to correspond with *a* in the drawing. Its ends, which overlap, are now soldered together, leaving a plain cylinder. I now introduce the edge of this cylinder into a “beading-machine” to give it the double bend *e* shown in Fig. 3. The top or bottom, as the case may be, is now put in place. The whole is then chucked in a lathe, and—with a grooved wheel similar to that used for milling the edges of thumb-screws, &c., only that in the present instance the wheel is made quite smooth in the groove; or with any suitable burnishing-tool—the end *f* in Fig. 3 is laid down and turned over to the form *g* in Fig. 4, where it will be seen that the extremity is embedded in the top or bottom *c*. By this not only is a joint formed at *g*, but the other side of *c* is pressed against the opposite side of the recess *b*, forming a second joint, *h*, at that point.

By means of the method described a box is produced which is far superior to those constructed in the ordinary manner. As the edge of the metal is embedded in the wood it follows that a perfectly-tight joint is formed, and a smooth and perfect finish is given to the parts.

Having now described my invention, what I claim is as follows:

As a new article of manufacture, the box described, consisting of the band *a*, provided with the double bend *e* and edge *g*, the latter being embedded in the top or bottom *c*, substantially as described.

Montreal, 10th day of August, A. D. 1872.

CHARLES STORER.

Signed in presence of—

CHARLES G. C. SIMPSON,  
FRAS. HY. REYNOLDS.