Sept. 6, 1955 G. A. MOORE 2,717,094

PETROLEUM CONTAINERS

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FIG. 2

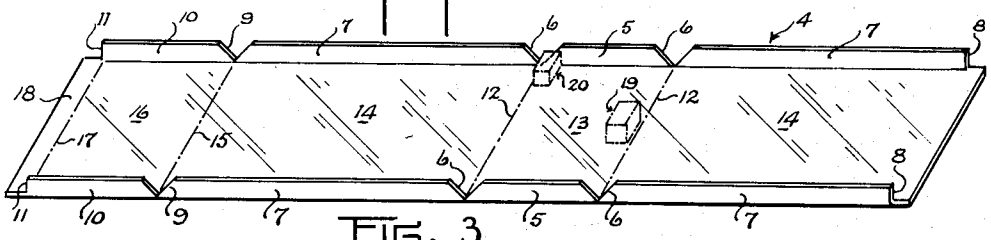


FIG. 3

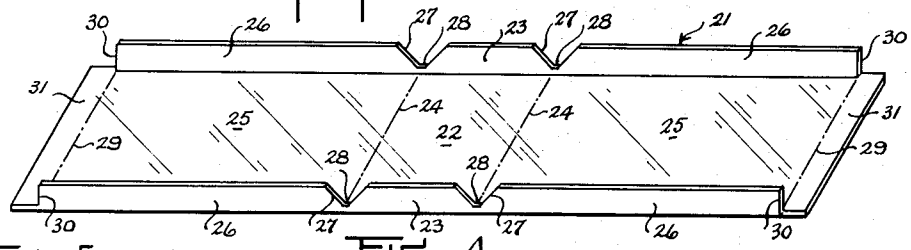


FIG. 5

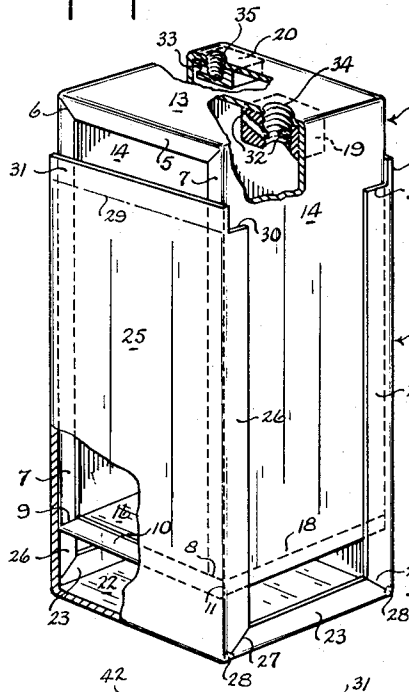


FIG. 4

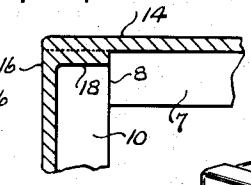


FIG. 6

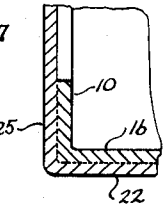


FIG. 1

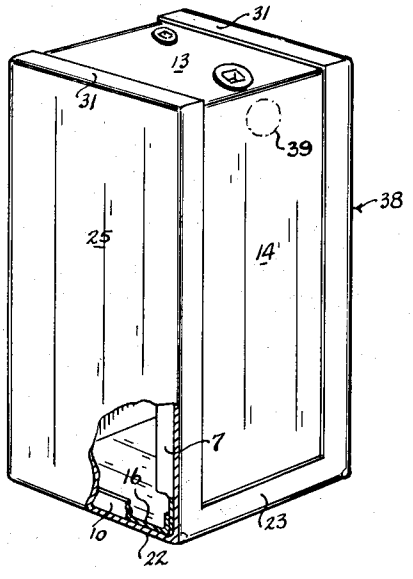
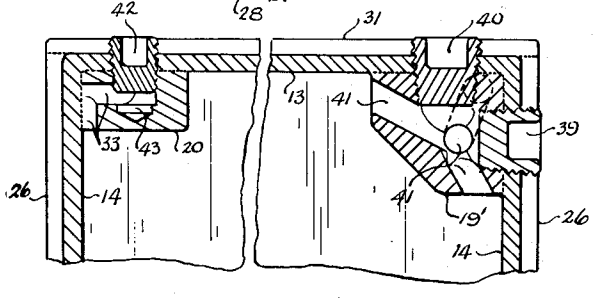


FIG. 7



INVENTOR.
GEORGE ARLINGTON MOORE

George Arlington Moore

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FIG. 8

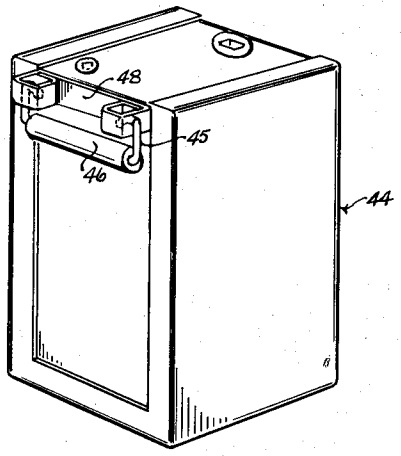


FIG. 11

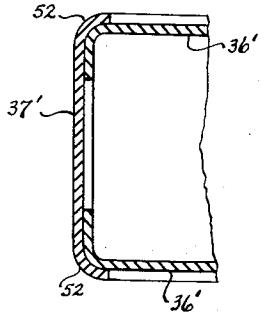


FIG. 10

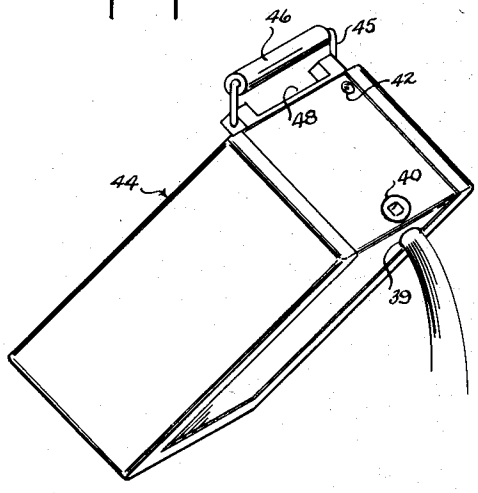
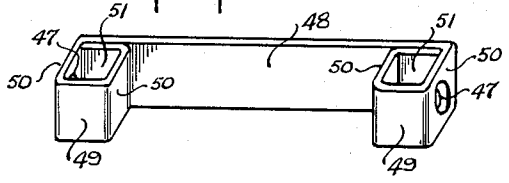


FIG. 9



INVENTOR.
GEORGE ARLINGTON MOORE

George Arlington Moore

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2,717,094

PETROLEUM CONTAINERS

George Arlington Moore, New York, N. Y.

Application May 17, 1952, Serial No. 288,412

17 Claims. (Cl. 220—4)

This invention relates to improvements in containers, more particularly heavy duty containers made of sheet materials such as black plate, soft steel, stainless steel and aluminum. The improved containers may be advantageously made of aluminum-clad steel sheet. The sizes of the containers may range from one to fifty-five gallons' liquid capacity and are especially adapted for petroleum products. The containers are made in such manner as to afford increased pay loads because of relatively light net weight and save space compared with conventional round drum type steel containers.

Conventional round drum type containers made of black plate steel have curved surfaces, the body is cylindrical in shape, the top and bottom heads are of a spherical shape to some degree. The heads of the drums are seamed to the body leaving relatively deep recesses in the container ends in order to provide material for the upright seamed rims around the container ends. The dispensing orifices are constructed in one end in the fashion of a union comprising three parts for the bung and three parts for the vent, such construction being necessary because of the spherical shape of the head wall, the head being formed in a die drawing operation to provide in addition to peripheral flanges a flanged rim around the holes in which to adapt the parts comprising the orifice fittings. When storing or transporting the filled drums, they touch each other tangentially on the chimes which project outwardly of the round body wall of the container, the waste space is therefore thirty five percent when transporting or storing the containers, shock loads subjected to the containers is through tangential points of contact. The inertia effects of such shock may weaken the seams and cause damage even though the heavier types of containers are reinforced with steel chime bracelets. The recesses in the heads of the containers are as much as one and three eighths inches and trap water when exposed out of doors. Five gallon bucket type steel containers are provided with bail handles and to facilitate dispensing, a pouring spout attachment is at times provided to avoid trapping liquid by the interferences caused by the chime around the head of the container. The fifty-five gallon steel drums will require up to approximately eighty pounds of steel.

An object of this invention is to provide a substantially rectangular container having outer and inner overlapping seams.

Another object of this invention is to provide a substantially rectangular container having outer and inner overlapping seams and further provided with a head integral with two side walls, said head being interiorly provided with orifice members.

A further object of this invention is to provide a container having an orifice disposed in a body portion integrally united to the inside of the head and also to an adjacent side wall.

A still further object of this invention is to provide a container having a plurality of orifices disposed interiorly in the head and an adjacent side wall, said orifices being

also located in a metal body which is integrally united to said head and said adjacent side wall.

Another object of this invention is to provide a container having a plurality of orifices disposed interiorly in the head and an adjacent side wall of one member, the one member constituting an enclosure for another member into which said one member is assembled and secured, said members constituting the container.

A further object of this invention is to provide a novel handle for efficient dispensing and stacking of the container.

A still further object of the invention is to provide improved containers comprising two flat strips of metal sheet, each strip being shaped in dies to have walls substantially U-shaped constituting male and female parts, said parts having radially shaped corners, the parts being assembled and brazed together at their respective junctions.

These and other objects of the invention will be apparent upon reading the following descriptive disclosure read in conjunction with the illustrative accompanying drawings, wherein:

Fig. 1 is a perspective view of a completed container with a portion of one side wall broken away, parts of the walls being in cross-section,

Fig. 2 is a perspective view of a first flanged strip used in constructing the container,

Fig. 3 is a perspective view of a second flanged strip used in constructing the container,

Fig. 4 is a fragmentary view in cross-section of structurally engaged portions of the first strip.

Fig. 5 is a perspective view of the container assembly in an intermediate stage,

Fig. 6 is a fragmentary view in cross-section of structurally engaged parts of the container,

Fig. 7 is a fragmentary and broken view in cross-section of wall portions of the container provided with vent and dispensing orifices,

Fig. 8 is a perspective view of another completed container provided with a handle,

Fig. 9 is a perspective view of a fitting used for the handle on one wall of the container,

Fig. 10 is a perspective view of the container in dispensing position, and

Fig. 11 is a fragmentary view in cross-section of a modified relation of the walls of the container.

Referring to Figs. 1 to 7 there is illustrated a container (Fig. 1) having generally flat walls of rectangular shape and reinforced at the corners with overlapping wall portions. The bottom of the container has two end walls in contact with one another and reinforced by flanges disposed in the adjacent walls (Fig. 6). The upright junctions of the walls consist of marginally reinforced inner and outer flanges engaged to alternate portions of inner and outer walls of the container. The top end wall is marginally reinforced with overlapping flanges, the end wall being provided with filling and dispensing orifices located in metallic bodies, said bodies being fastened interiorly to the top and adjacent wall of the container (Fig. 7). The container is constructed of two flanged and notched strips of sheet (Figs. 2 and 3), the strips being bent to form male and female parts adapted to be assembled together (Fig. 5). The male part being bent from a blank (Fig. 2) and has two opposing side walls and opposed end walls, one end wall being inwardly flanged and secured to an adjacent side wall, the flanges inwardly framing the open sides. The female part being bent from the strip (Fig. 3) having two opposed side walls and an end wall, the two opposed open sides are framed with inwardly disposed flanges, the ends of the said opposing walls having laterally disposed upstanding opposed flanges.

The male and female parts are assembled together (Fig.

5), the male part being pressed into the female part, the flanges being prepared with well known dope compositions of suitable fluxing materials prior to the assembly. The lateral flanges of the female part are bent to overlap marginally opposed portions of the top end wall of the assembly. All of the flanged junctions of the assembly are securely clamped and heated to the required temperature which welds or brazes the related parts together in seam forming relationship.

Referring to Figs. 8 to 11 there is illustrated a container (Fig. 8) adapted for liquid capacities from one to five gallons, the container being provided with orifice arrangements as illustrated in Fig. 7. An efficient handle is provided at the top of one side wall and adapted to swing freely at least 180 degrees, the handle is disposed at the opposite side of the dispensing orifice (Fig. 10) and due to these relative locations the container will pour liquid efficiently making it unnecessary to use a pouring spout. The flat walls of the container avoids trapping of liquid therefore, during field storage can not collect water. Round drum type containers have recesses in the heads that trap water, and in cold climates the water freezes resulting in detrimental effects.

The handle for the container is anchored in a bent strap (Fig. 9) which is welded or brazed to a side wall of the container, the strap providing a pair of outwardly disposed end portions having flat end walls beneath which the handle hangs by gravity. The outermost part of the handle is flush with the outermost walls of the anchor strap to provide smooth contact with the walls of like containers when grouped together.

Within the scope of the present invention, containers of relatively small capacity may be fabricated of strips of sheet in the form of blanks drawn U-shape in dies to form radial corners (Fig. 11). The dies efficiently shape the male and female parts of the container whereby, two sides of the respective parts are open allowing the metal to have freedom in taking the shape desired.

Referring particularly to Fig. 2 there is provided a flanged strip **4** of sheet which may vary in thickness for example, from 0.020 to 0.125 inch and may consist of steel or aluminum, the strip having parallel side flanges disposed in opposing pairs, a pair **5** having triangular shaped notches **6** separating oppositely disposed pairs **7**, one pair ending in vertically disposed edges **8**, the other pair having notches **9** separating a pair **10** which end in vertically disposed edges **11**. The notches **6** and transversely disposed parallel bending lines **12** extending between the apexes of the notches, define a wall area **13** having laterally extended wall areas **14**, the right side wall area extending beyond the edges **8** of the flanges **7**, the left side wall area extending to a transversely disposed bending line **15** extending between the apexes of the notches **9**. A wall area **16** extends outwardly of the bending line **15** to a parallel bending line **17** which is substantially in line with the edges **11** of the side flanges **10**, a lateral flange **18** projects outward of the bending line **17**. The wall area **13** is provided with orifice bodies **19** and **20**, the body **19** being disposed slightly inwards of the bending line **12** and substantially central therewith, the body **20** being disposed inwardly of the opposite bending line **12** and inwardly of the flange **5**. The bodies have drilled holes hereinafter to be described and are fastened to be integral with the wall **13**.

The strip **21** (Fig. 3) consists substantially of the same material as described for the strip **4** (Fig. 2) the thickness however may be increased for added strength if desired. The strip is provided with a central wall area **22** defined with opposed parallel flanges **23** and transversely disposed bending lines **24**. Lateral wall areas **25** extend outwardly from each side of the central area and have opposed parallel side flanges **26** which are separated from the flanges **23** by notches **27** having blunt apexes **28** at the terminals of the transversely disposed parallel lines **24**. The lateral wall areas end at transversely disposed bending lines **29**. The flanges **26** have vertically disposed ends **30** substantially in line with the said bending lines. Laterally disposed end flanges **31** extend outwardly of the bending lines **29**.

The strip **4** (Fig. 2) is bent on the lines **12**, **15** and **17** respectively, forming two opposed end walls and two opposed side walls, the flanges inwardly framing the two open sides, the notches in the flanges forming mitred butt joints adjacent each corner junction of the walls. One end wall (bottom) is formed with a wall area **16** (Fig. 2) the flange **18** being bent on the line **17** to engage the opposite extended portion of the wall area **14** (Fig. 4), the engaging portions being welded or brazed together, the flange **18** being disposed interiorly of the walls. The orifice bodies **19** and **20** are drilled with holes prior to fastening to the wall **13** (Fig. 2). The body **19** (Fig. 5) is drilled with liquid draining holes **32** which are sloped downwardly and disposed in three sides of the said body. The body **20** is drilled with holes **33** disposed close to the end wall **13** and adjacent wall **14**. The main orifice holes may be or not be drilled and tapped with threads prior to the bending and shaping of the part. The walls **14** of the strip **4** are bent at right angles on the lines **12** one wall engaging an opposing wall of the body **19**, the opposite wall **14** and an inner portion of the flange **5** engaging adjacent walls of the body **20**. The wall engaging portions are fastened to become integrally related together.

After forming the part **36** (Fig. 5) constituting the male member of the container assembly, the orifice **34** constituting a bung and orifice **35** constituting a vent, may be drilled and tapped to provide tapering threads for pipe plugs adapted with square shaped wrench holes or if desired, straight threaded holes may be provided for adaptation of flanged plugs using suitable gaskets.

The notched and flanged strip **21** (Fig. 3) is bent substantially U-shape on junction lines **24** forming an end wall **22** and two opposed side walls **25**, the open sides being inwardly framed with flanges **23** and **26** having abutted joints at adjacent corners of the said end wall. The blunt apexes **28** of the triangular shaped notches **27** provide slight projections of excess material which is peened into the corner junctions of the end wall **22** providing reinforcements at the said corner junctions. The laterally disposed end flanges **31** remain upright to facilitate assembly of the container. The gauge of the strip may be heavier than that used for the previously mentioned male part to further increase the strength of the container if desired.

The assembly of the container (Fig. 5) consists of inserting the pre-shaped male part **36** into the female part **37**, the bottom end wall **16** of the male part opposing the end wall **22** of the female part providing a double wall bottom from which four side walls and a top wall closure are provided to form the container. The framing flanges of the male part engage marginal portions of the opposing inner walls of the female part, the framing flanges of the female part engage marginal portions of the exterior opposing walls of the male part. The lateral flanges **31** extending upwardly on the ends of the opposing walls **25** are bent on the junction lines **29** to overlap marginal portions of the top end wall **13**. The ends **30** of the flanges **26** are substantially covered by the overlapping flanges **31**. The wall engaging flanges are treated with suitable fluxing compositions prior to assembly with which to braze or weld the said engaging parts together. One suitable method may be employed whereby, the flanges of the assembly are tightly clamped, the assembly passing through a heated oven having an elevated temperature which is below the molten stage of the metal which welds the related parts together.

The completed container **38** (Fig. 1) may be adapted with an alternative dispensing orifice **39** (bung) disposed in the upper part of an adjacent side wall, the orifice

body 19' (Fig. 7) being adapted for drilling and thread tapping in both the end wall and adjacent wall of the container which supports the orifice body. The plugged orifice 40 in the end wall is adapted for both filling and dispensing, the adjacent plugged orifice 39 is adapted for convenient dispensing from one side wall of the container as illustrated in Fig. 10. Draining holes 41 are provided in the orifice body (Fig. 7) suitably arranged to completely scavenge liquid through either orifice. The plugged orifice 42 provides a vent for the container when using either dispensing orifice. The vent provides a trap 43 for foreign matter when the plug is removed.

The containers when filled with fifty-five gallons of liquid will weigh several hundred pounds and are subjected to dropping tests that are quite severe, the container therefore is provided with a reinforced double bottom (Fig. 6) with opposed flanges 5 welded to marginal portions of the inner walls 25 and transversely disposed opposing flanges 23 welded to base portions of the exterior opposing walls 14 the corners of which have peened reinforcements. The upright side wall corner junctions of the container are reinforced in the same manner as described for the bottom flanges. The top end wall is reinforced with opposed overlapping flanges 31. The inner orifice bodies are reinforced by being welded or brazed in corner wall portions formed by two adjacent walls of the container.

The container when made of aluminum is especially adapted for use of highly volatile liquids such as high octane fuel, solvents and like liquids. The container will have relatively lower vapor pressures especially when the container is subjected to field storage, the aluminum walls will reflect the heat of sun rays. The relative net weight of the container compared with steel will be reduced about sixty percent, aluminum being basically one third the weight of steel. The occupancy space of the container is reduced about thirty or more percent as compared with round drum type containers. The aluminum containers may be anodized or sprayed with anodic oxide coatings which will harden the surfaces of the walls. Spray materials may be pigmented with color tones. The salvage scrap value of the aluminum containers when discarded is approximately up to eighteen cents per pound.

The container may be economically made of black steel or stainless steel, the latter material being advantageously employed in making containers that are required to hold acids of various kinds.

The containers may be fabricated of composite sheet material which consists of a sheet of steel, clad with sheets of aluminum, the steel being the core and the aluminum the exterior walls. The steel adds strength to the container and the aluminum prevents the steel from rusting also reducing the weight of the sheet as compared with solid steel. The aluminum characteristic of reflecting heat-rays materially reduces internal vapor pressures of volatile liquids when stored in the containers.

When fabricating the heavy duty containers of relatively heavy sheet, the extending lateral flanges 31 on the female part 37 (Fig. 5) may be bent prior to assembly if desired. In assembling the container the opposing walls 25 are sprung outwardly sufficient to allow the male part 36 to enter between the opposing edges of the flanges after which the opposing walls are closed inwardly, the pre-bent opposing flanges overlapping side marginal portions of the top end wall 13 of the inserted male part.

Referring to Fig. 8 a container 44 is provided to have liquid capacities ranging from one to five gallons. The container is made substantially in accordance with the descriptions given hereinbefore. The sheet material used to construct the container may however vary in thickness from 0.010 to 0.062 inch. When employing the relatively lighter weight sheet, the seams of the container may be secured by being welded or by making use of seam bonding resin curing adhesive.

A handle is provided for the container which consists of a suitable wire rod 45 over which a roller sleeve 46 is centrally disposed, the extending portions of the rod being bent upwardly at two sides of the sleeve and further bent in hooked shaped ends anchored in holes 47 (Fig. 9) of the bent formed strap 48 which is welded, brazed or otherwise fastened to a top portion of one side wall of the container. The above strap consists of two looped ends having walls 49 outwardly disposed and two opposed adjacent side walls 50, the outer side wall of each loop having rod anchoring holes 47 therein. The looped portions terminate with flanged portions 51 disposed within the opposing walls 50, the portions being fastened to the main wall of the strap.

The dispensing orifice 39 illustrated in Fig. 7 may be employed in the container 44. The container when lifted off its base with the handle 46 will tilt, the handle serving a fulcrum means for tilting the container by gravity, and further if desired by simple assistance. The pouring (Fig. 10) from the container is efficient, the stream of liquid making its exit through an upper portion of a smooth sloping wall precluding any possible interference to clean and orderly dispensing from the container. The filling of the container may be facilitated by using the orifice 40.

Fig. 11 illustrates a modification in the construction of the container, the male part 36' and female part 37' being shaped in a set of male and female drawing dies forming the walls of the container with radial corners 52, each part having substantially two opposed open sides allowing freedom of the metal to work and form the end wall and two opposed side walls having circular shaped side framing flanges, the shaped parts being assembled together and secured in the manner hereinbefore described.

I claim:

1. In a container having top and side walls meeting at corner portions, which comprises an orifice body member being secured to interior portions of the walls of the container and disposed in corner portions of said wall, said member having an orifice in alignment with an orifice through said top wall, and another orifice in alignment with an orifice through said side wall of the container adjacent the first mentioned orifice, said orifice aligned through the top wall being adapted for filling said container with intended contents and the other orifice aligned through the side wall being adapted for dispensing said contents of the container.

2. In a heavy duty container made of aluminum sheet having four enclosure side walls of horizontal square cross section and two opposed enclosure end walls, which comprises an orifice body being secured upon interior surface portions of top and side walls of said enclosure walls that meet at corner portions of the container structure, said orifice body being fitted in said corner portion with surface sides thereof being secured upon a surface portion of both an end wall and side wall, the body having an orifice in alignment with an orifice through said top wall, and another orifice in alignment with an orifice through said side wall, both of said aligned orifices through each wall being threaded for adaptation of a removable threaded plug to be engaged in each of said orifices, said body providing means to accommodate and secure said plugs to be substantially flush at their respective outer ends with exterior surfaces of adjacent wall portions of said container.

3. In a container according to claim 2 wherein said orifice body is provided with other holes disposed within the body having outlets through interior wall portions thereof that are freely exposed within the interior of the container, said holes connecting with each of said threaded orifices, said other holes being arranged to channel flow of liquid alternately through either of said orifices in and out of said container including means for thorough scavenge draining of liquid from the container.

4. In a container according to claim 2 wherein another orifice body member is provided and secured in an interior portion of an opposite top and side wall meeting corner of the container structure, said body member having a threaded vertical hole in alignment with a threaded hole through said top wall adapted for fitting a threaded plug, the body having a horizontal hole making connection into a lower inner portion of said threaded hole and another vertical offset hole portion connected into said horizontal hole, the offset hole having outlet through the bottom wall of the body exposed in the interior of the container, said arrangement of orifice body constituting a safety air escape vent and dirt trap in the container structure to facilitate use of said filling and dispensing orifices.

5. In a container made of aluminum sheet and formed of an assembly of two pre-shaped structural elements formed of said sheet, one of the elements having integral top and side walls meeting at corner portions, comprising an aluminum orifice body housing member having right angular wall surface sides bonded upon interior corresponding surface sides of said corner forming walls, of said elements, said bonded housing member providing rigid reinforcement of said corner portion of wall structure, the housing having a series of holes with outlets through walls thereof freely exposed within the interior of the assembled container including communications with a threaded orifice in alignment with an orifice through said top wall, and another threaded orifice in alignment with an orifice through said side wall, each orifice being adapted to be used alternatively for filling and dispensing purposes of the container, each orifice having adaptation means for being sealed liquid tight.

6. In a container as set forth in claim 5 wherein a safety escape vent is provided in another body housing member being bonded upon interior surfaces of the opposite top and side wall meeting corner portions of the container structure, said vent being constituted by a threaded hole in alignment with a threaded hole through said top wall, the vent threaded hole communicating through other hole portions provided in the housing, which hole portions provide an outlet through a wall portion thereof exposed in the interior of said container out of alignment with said threaded hole.

7. In a rectangular container for liquids formed of metal sheet having top and side walls meeting at corner portions, which comprises an orifice body member having wall portions secured to interior surface portions of said corner forming walls, said member having an orifice in alignment with an orifice through said top wall, and another orifice in alignment with an orifice through said side wall, the opposite side wall opposed to the side wall having one of said orifices being provided with a flat metal strap being welded upon an upper exterior margin of said opposite end wall, the strap having opposed bent end portions providing square loops having outwardly spaced flat end sides parallel with the welded portion including a hole through each side wall portion of the loops transverse of said flat ends, said holes engaging end portions of a swinger handle with which the container may be lifted and tilted from a suspended corner end constituting a fulcrum point for the container to dispense its contents through the orifice provided in said opposing side wall and thereby afford means to pour contents from the container free from liquid fouling any part of the container structure adjacent said orifice.

8. In a rectangular container as set forth in claim 7 wherein the flat offset wall ends of said loops of the handle support provide flat abutment surfaces upon which to orderly stack or compactly group like containers together without interference of said handle, which handle hangs from said loops inwardly of said offset wall ends thereof.

9. In a rectangular liquid dispensing container formed of rigid sheet having in combination a twin orifice arrangement at one top corner end of the container and a swinger handle provided at the opposite top corner end thereof to provide means for clean dispensing of container contents, which comprises top and side wall portions of the container structure that meet at said one corner end having an orifice body member secured in the interior of said corner wall portion, said member having an orifice in alignment with an orifice through said top wall adjacent said corner through which to fill said container and, another orifice in alignment with an orifice through said side wall adjacent said top corner end through which to dispense filled contents from the container, the opposite side wall of the container adjacent the top corner end thereof, being provided with a secured swinger handle arrangement with means that provides a swinging fulcrum point from said top corner end that may be suspended from said handle when lifted to tilt the container and pour contents from said orifice in the opposing side wall without liquid fouling interference by the adjacent top corner end of the container structure.

10. In a rigid liquid carry container constructed of an assembly of two pre-shaped wall forming elements, one of the elements being provided with a twin orifice structure prior to embodiment in said assembly, which comprises top and side walls of said element meeting at corner portions having an orifice body member secured upon wall surface portions thereof so that right angle exterior surface sides of said body member are secured upon right angle interior surface sides of said meeting walls, said member having a series of body holes through opposite surface sides to sides secured that connect with two orifices disposed at right angles to each other through secured sides, one orifice being in alignment with an orifice through said top wall, and another orifice in alignment with an orifice through said side wall, said orifice alignments being tapped with suitable threads to engage threaded plugs, said element affording accessibility to said body member for construction and threading by having open sides transverse of said side walls, after said two elements are assembled together to complete said container, said orifice structure providing means with which to fill and dispense intended liquid contents of the container while being in either vertical or horizontal position by making alternate use of said twin orifices.

11. In a container formed of metal sheet having top and side walls meeting at corner portions of the container structure comprising a metal body reinforcing member being welded upon interior surface portions of said corner meeting walls, said body member and attached wall portions thereof being provided with a threaded orifice disposed inwardly and downwardly through said top wall and into a portion of said body member, another threaded orifice being disposed inwardly and horizontally through said side wall and into a lower portion of said body member, the horizontal disposed orifice therein being spaced downwardly of the surface plane of said top wall so that the vertically disposed orifice may have sufficient depth of threads to be engaged with a removable threaded plug that may be used to seal the orifice and not project outwardly beyond the exterior of adjacent walls, said horizontal orifice being adapted to also engage with a duplicate threaded plug, each said orifice having outlet means provided through free wall sides of the orifice body member that are exposed within the interior of said container.

12. A container formed of a male enclosure and a female enclosure assembled together in seam forming relationship, which comprises said male enclosure having a pair of side walls meeting at corner portions of a top end wall forming closure of the container, a body member being provided that is disposed and secured upon interior surface portions of one side wall and end wall adjacent said meeting corner of the male enclosure, and prior to the assembly of said male enclosure with said female enclosure, said end wall corner meeting portion having a vertical orifice in alignment with an orifice provided in said

body member, said side wall corner meeting portion having a horizontal orifice in alignment with an orifice provided in said body member, an upper exterior marginal surface of the opposite side wall to said one side wall, being provided with a strap secured swinger handle, the strap portion of said handle being fastened to said upper exterior marginal surface prior to the assembly of said male and female enclosures, and after the male and female enclosures are assembled together in seam forming relationship to form said container, said vertical orifice providing means through which to fill said container with intended product, and said horizontal orifice providing means with which to cleanly dispense said product from the container, said swinger handle providing fulcrum means with which the container may be lifted and be tilted so that said side wall through which the horizontal orifice passes will slope away from the flow of the dispensing product.

13. In a container adapted for commercial transportation and storage of liquid products, the container being of rectangular shape having side walls arranged in opposing pairs and being secured together in seam forming relationship, one of which pair of side walls having an integral portion thereof that forms an end wall, said one pair of side walls and said end wall meeting at top corner portions of the container structure, an orifice body unit member being provided and having exterior surface portions thereof secured upon a portion of the interior surface of one side wall corner meeting portion of said one opposing pair and a portion of said end wall, one of said end wall corner meeting portions being provided with substantially a vertical orifice that is disposed through said end wall and being positioned substantially in alignment with an orifice that is provided in said secured body unit member, the side wall corner meeting portion adjacent said vertically aligned orifices being provided with a substantially horizontal orifice that is disposed through said side wall and being positioned substantially in alignment with an orifice that is provided in said secured body unit member, the body of said orifice unit member being completely disposed in the interior of said corner meeting portions of the container, said vertical and horizontal orifices in said unit member being provided with threaded means with which to open and close said container for purposes of filling and dispensing of intended liquid contents thereof through said vertical and/or horizontal orifice, which orifices may be used alternately for said filling and dispensing purposes.

14. In a container adapted for handling commercial liquids having a side wall and an integral portion thereof that forms an end wall, said side wall and end wall meeting at a corner portion of the container enclosure wall structure, which comprises a filling and dispensing orifice arrangement being provided in a body member that is disposed and secured upon interior surface portions of said side wall and end wall, the extremities of said body member being confined within the interior of said container, said orifice arrangement comprising a vertical orifice being provided through said end wall and being in alignment with an orifice that is provided in said body member, and a horizontal orifice being provided through said side wall and being in alignment with an orifice that is provided in said body member, said orifices being positioned adjacent each other in said meeting corner portion, said orifices being threaded for adaptation of opening and closing means so that the vertical aligned orifices and horizontal aligned orifices of said arrangement may be used alternately for purposes of filling and dispensing the intended liquid contents of said container.

15. In a container as set forth in claim 14 wherein the container is provided with a swinger handle, said handle being pivoted in a rigid support that is secured upon an upper exterior marginal surface of the side wall that is opposed to said side wall having the horizontal aligned orifices, the swinger handle providing fulcrum means from which the filled container, when being lifted by use of said handle, will swing automatically to an inclined position so that said liquid content will pour outwardly through the side wall having the horizontal aligned orifices, the side wall portion that is disposed below said orifices being caused to tilt away from the gravity stream of liquid while being dispensed from said container.

16. In a container formed of metal sheet having side walls and an end wall meeting at top corner portions of the container structure, which comprises an orifice housing member, the body of which member being of substantially rectangular form, said housing member being secured upon interior surface portions of a side wall and end wall meeting corner portion, the body of said housing member being completely disposed within the interior of the enclosure walls of the container, said end wall meeting corner portion being provided with a through orifice, which orifice is in alignment with an orifice that is provided through the body cross section of said secured housing member, said aligned orifices being provided with threaded means with which to close and open said container for filling and dispensing intended contents thereof, said secured body member being provided with drainage holes therein, which holes communicate with said aligned orifices, said holes providing means through which said contents of the container may be substantially scavenged therefrom.

17. In a container for handling commercial liquids and being formed of metal sheet and having a body wall and an end wall, said container being provided with an orifice construction which comprises a flangeless orifice body member of the container structure that is provided and the orifice body having exterior surface portions thereof being secured upon interior surface portions of the body wall and the end wall of said container structure, which body wall and end wall meet at top corner portions thereof upon which said orifice body member is secured, the orifice body member being completely disposed inwardly of its attached surface portions to the side and end wall interior surface portions, said end wall meeting corner portion of the container being provided with an orifice in alignment with a closeable orifice that is provided in said attached body member, said body wall meeting corner portion of the container being provided with an orifice in alignment with a closeable orifice that is provided in said attached member, said aligned orifices providing means through which to facilitate alternate selective use thereof to either fill or dispense intended contents of the container through either of said orifices according to the imposed position taken by said container at the time of filling and/or dispensing of said contents thereof.

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