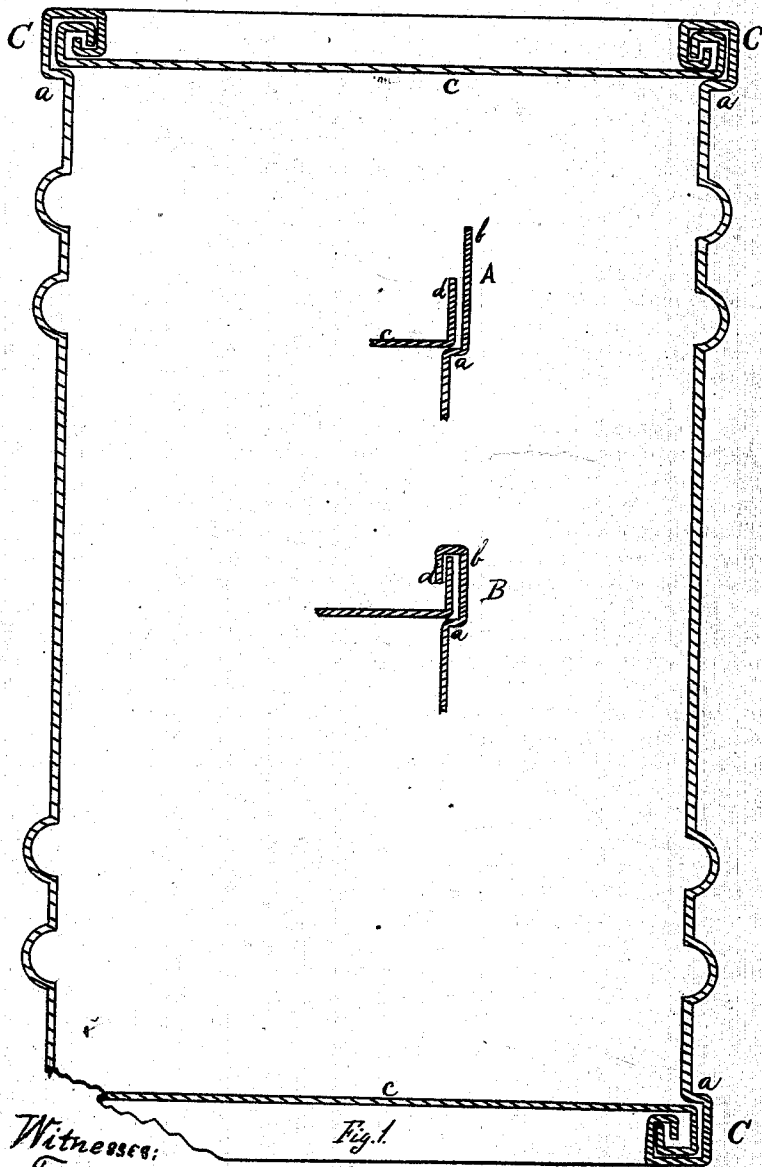


N. TENNEY.
Powder-Kegs.

No. 146,150.

Patented Jan. 6, 1874.



Witnesses:
Frank H. Jordan,
Edwin A. Harker,

Inventor:
Nelson Tenney,
per Wm. Henry Clifford
att'y

UNITED STATES PATENT OFFICE.

NELSON TENNEY, OF PORTLAND, MAINE.

IMPROVEMENT IN POWDER-KEGS.

Specification forming part of Letters Patent No. **146,150**, dated January 6, 1874; application filed November 19, 1873.

To all whom it may concern:

Be it known that I, NELSON TENNEY, of Portland, in the county of Cumberland and State of Maine, have invented certain new and useful Improvements in Powder-Kegs; and I do hereby declare that the following is a full, clear, and exact description thereof, that will enable others skilled in the art to which it appertains to make and use the same, reference being had to the accompanying drawings and to the letters of reference marked thereon, which form a part of this specification.

Figure 1 shows a vertical section of can, illustrating my method of fastening the head, the same being illustrated in an enlarged form.

Same letters show like parts.

My invention has relation to an improved method for uniting the heads of powder and other cans to the side or wall thereof, and has especial reference to the folding of the overlapping portions of the ends and the walls of the can, so as to form what is termed a "double seam."

I do not claim, broadly, the formation of a double seam, because this has been done before, and I am aware that a particular method of effecting this object is described in Letters Patent No. 24,772, July 12, 1859, and I do not claim this particular method.

I first construct the walls or cylindrical part of my can with an outwardly-projecting shoulder at each end, designated by *a*. This extends around the entire circumference. Above this shoulder, and of the same material as the walls of the can, rises the vertical flange *b*. Upon this shoulder *a* I then place the head *c* of the can, which has simply a right-angled flange around its periphery, illustrated at *d*. This flange *d* is, as illustrated, less in width or height than the flange *b*, formed from the walls of the can. The position of the parts when thus first placed together is illustrated at A. The first step in the formation of the seam is illustrated at B, and consists in folding the wider flange *b* down over the top of the nar-

rower one, *d*—in other words, in folding the flange formed from the wall of the can down over the top edge of the flange formed from the can-head. The next step is illustrated at C, where, after a seam has been formed by lapping *b* down over *d*, the flange or projecting edge thus formed is again bent and doubled down upon itself.

Let it be observed that all these motions or bendings of the flanges of both the can and wall, and the can-head, are made inwardly, and the seam is formed on the inner periphery of the can-wall projecting above the can-head.

This is different from Patent No. 24,772, before referred to, and has advantages over the same, to wit, first, the exterior of the can, opposite the point where the head is inserted, is smooth, with the exception of the slight projection or shoulder *a*; second, the recess or the distance of the can-head below the upper edges of the can-wall is obtained with a plain flat head, without the expense of indenting or sinking in the same in concentric circles, as is the case in the patent referred to.

I do not claim a method of double-seaming the heads of cans, shown in W. Hill's Patent No. 108,594, of 1870, which consists in lapping the top of the wall of the can over the flange of the head, and then inclining the two inward at an angle of forty-five degrees.

What I claim as my invention, and desire to secure by Letters Patent, is—

In the formation of a double seam for holding the heads of cans, the combination of the shoulder *a* and head *c* with its flange *d*, the same, when placed together, being bent or folded inwardly, as illustrated at B and C, as described.

In testimony that I claim the foregoing I have hereunto set my hand this 12th day of November, 1873.

NELSON TENNEY.

Witnesses:

FRANK H. JORDAN,
WM. HENRY CLIFFORD.