

S. ROBERTS.
Manufacture of Barrels.

No. 32,340.

Patented May 14, 1861.

Fig. 2.

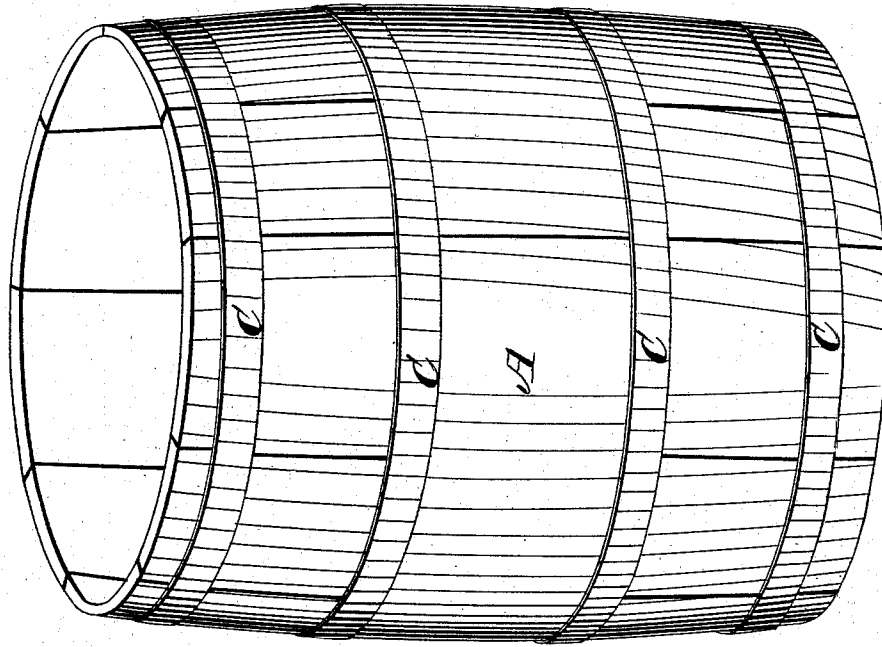
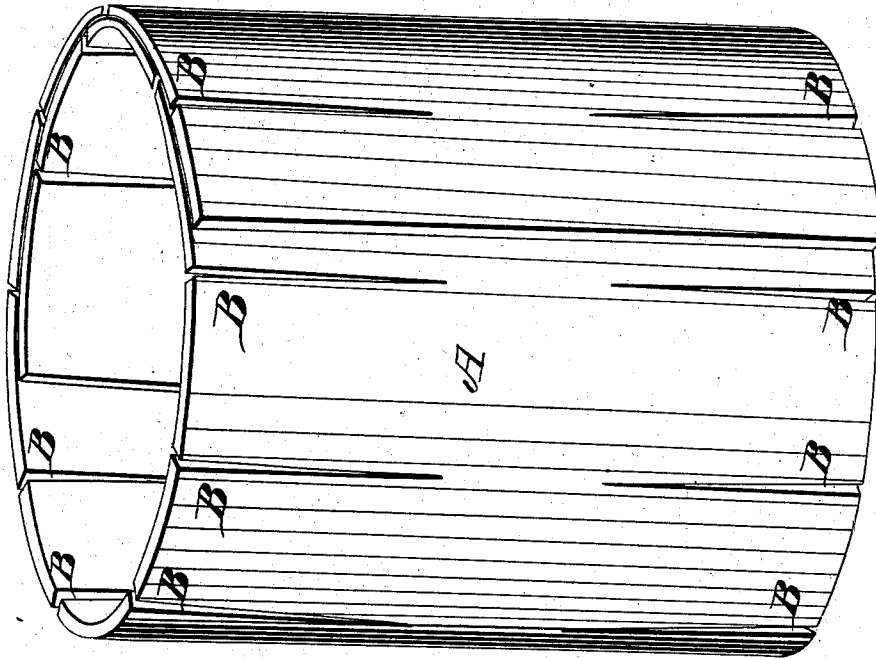


Fig. 1.



UNITED STATES PATENT OFFICE.

S. ROBERTS, OF CLEVELAND, OHIO, ASSIGNOR TO HIMSELF AND ALFRED ADAMS, OF SAME PLACE.

IMPROVED BARREL.

Specification forming part of Letters Patent No. **32,340**, dated May 14, 1861.

To all whom it may concern:

Be it known that I, SHERIDAN ROBERTS, of Cleveland, in the county of Cuyahoga and State of Ohio, have invented new and useful Improvements in Manufacturing Barrels; and I do hereby declare that the following is a full and complete description of the construction and operation of the same, reference being had to the accompanying drawings, making part of this specification, in which—

Figure 1 is a perspective view of the cylinder part of a barrel without the hoops, and Fig. 2 is the same with the hoops driven upon it.

The nature of my improvement relates to the formation of the cylinder portion of barrels from voluted sheets, cut or removed from the surface of solid cylinders, and forming the bulge of the barrel by cutting out or removing gores or wedge-shaped pieces from each end, but leaving the middle third entire, so that by bringing these cut ends again into contact by means of hooping, the cylinder part of the barrel thus formed will have the desired bulge. The volute or cylinder part of the barrel A is cut with a straight knife from the surface of a log having the proper length for the barrel by means of any suitable lathe or engine. A sufficient length of such volute is cut off from the sheet as will be sufficient for a barrel or cask, as seen at A in Figs. 1 and 2.

By means of a circular saw or any other suitable instrument gores or wedge-shaped pieces B are sawed or cut out, as shown in

Fig. 1, and extending about one-third of the entire length toward the center, thus leaving the middle third entire. These gores or wedge-shaped pieces that are thus cut out may range in width at the outer ends from one-fourth of an inch to half an inch, and number from ten to fifteen for each barrel, according to the desired bulge. The gores B, being all sawed or cut as described, the two edges of the sheet or volute are brought into opposition, and the hoops C driven on in the usual manner, by which means the gorse-spaces are closed up and the body or cylinder part of the barrel is thus formed with the desired bulge. If necessary or desirable, and to economize the use of timber, such pieces as are not of themselves sufficient for a barrel may be united to form one, in which case the body of the barrel would be composed of two or more pieces instead of one piece only. The chines are cut after the hoops are driven on, and the barrel-head made and inserted in the usual manner.

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

The making of the cylinder part of barrels of a volute piece or pieces having gore or wedge-shaped pieces cut from each end, as described, for the purpose of forming the proper bulge to the body of the barrel, in the manner herein set forth and described.

SHERIDAN ROBERTS.

Witnesses:

W. H. BURRIDGE,
HENRY VOTH.