Mar. 27, 1923. 1,449,829

A. MILLER

HANDLED CAN AND METHOD OF MAKING SAME

Filed Dec. 10, 1921

FIG. 1

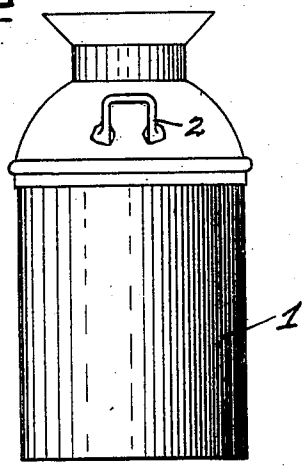


FIG. 2

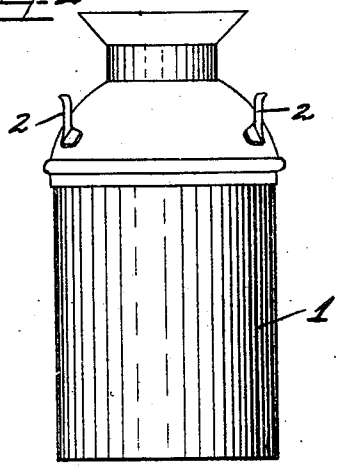


FIG. 3

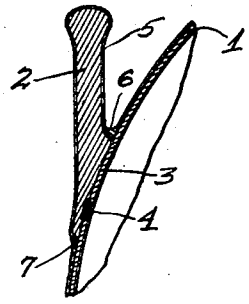


FIG. 4

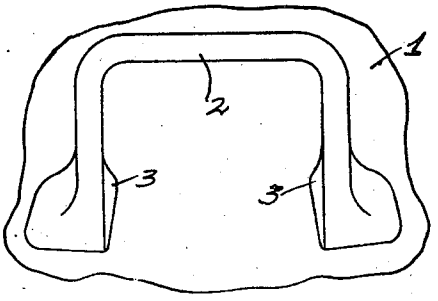
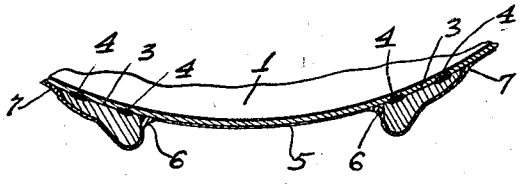


FIG. 5



Witnesses

Rudolph T. Berg.

Charles Fellows Jr.

Inventor

Arthur Miller.

By Charles Fellows Atty

Patented Mar. 27, 1923. 1,449,829

UNITED STATES PATENT OFFICE.

ARTHUR MILLER, OF CHICAGO, ILLINOIS, ASSIGNOR TO SOLAR-STURGES MFG. CO., A CORPORATION OF ILLINOIS.

HANDLED CAN AND METHOD OF MAKING SAME.

Application filed December 10, 1921. Serial No. 521,303.

To all whom it may concern:

Be it known that I, ARTHUR MILLER, a citizen of the United States, and a resident of the city of Chicago, in the county of Cook and State of Illinois, have invented certain new and useful Improvements in Handled Cans and Methods of Making Same; and I do hereby declare that the following is a full, clear, and exact description of the same, reference being had to the accompanying drawings, and to the numerals of reference marked thereon, which form a part of this specification.

This invention relates particularly to milk cans and to a way for fastening the handles to such cans, but is equally applicable to all cases where a metal handle is to be attached to the metal body and the joints must be free from cracks or crevices.

It is an object of this invention to secure a handle to a can in such a way that it is not easily broken off.

It is a further object of this invention to make a joint between a handle and can which shall be plated so as to leave no cracks or other place where dirt might lodge.

Other and further important objects of the invention will be apparent from the disclosures in the drawings and specification.

The invention (in a preferred form) is illustrated in the drawings and hereinafter more fully described.

On the drawings:

Figure 1 is a front view, and Figure 2 a side view of a can to which my invention has been applied.

Figure 3 is an enlarged section through one arm of the handle.

Figure 4 is a view of the handle.

Figure 5 is a section through two ends of the handle.

As shown on the drawings:

The usual milk can 1 is supplied with a pair of handles 2. Each end of each handle is spread out into a foot which is shaped to conform to the surface of the can as shown at 3. The sheet metal wall of the can and the foot of the handle are then united by spot-welding as indicated at 4. Preferably there are two spot-welds at each foot of each handle.

The can and the handle thus united thereto are then coated with metal. This may be done by galvanizing, by dipping in melted metal, by electro-plating, by sherardizing, or by any other method. The coating 5 thus applied will have thickened portions 6 where the foot of the handle and the surface of the can form an acute angle. There will also be slightly thickened portions 7 at the opposite edge of the foot.

The effect of the coating is to completely protect the joint between the handle and the can from any possibility of foreign matter entering therein. The use of spot-welding instead of riveting to hold the handle in place also tends to avoid the presence of any cracks, and thus renders easier the coating of the combined handle and pan with metal.

With a handle so secured and so coated, it is impossible for the milk to create a layer of cheesy deposit around the joint of the handle. Consequently the can is more readily kept clean and is therefore more sanitary.

It is also evident that a can and handle so united and so covered by a coating are protected effectively from rust and that the danger of the handle breaking off due to a weakened joint is lessened.

I am aware that various changes in detail and construction may be resorted to without departing from the spirit of this invention, and I therefore do not purpose limiting the patent granted otherwise than is necessitated by the prior art.

I claim as my invention:

1. The method of attaching a handle to an object which consists in fitting the end of the handle to the surface of the object, uniting it to the object by spot-welding, and coating the united object and handle with a metal.

2. The method of securing a handle to a milk can which consists in fitting the end of the handle to the surface of the can, uniting the surfaces by spot-welding, and coating the can and handle with metal.

3. A can, a handle therefor, spot-welds uniting said handle to said can, and a coating of metal covering the can and handle.

4. A can, a handle therefor, spot-welds uniting said handle to said can, and a coating of metal covering the can and handle, said coating being of extra thickness where the handle and can form an acute angle.

In testimony whereof I have hereunto subscribed my name in the presence of two subscribing witnesses.

ARTHUR MILLER.

Witnesses:
CARLTON HILL,
JAMES M. O'BRIEN.