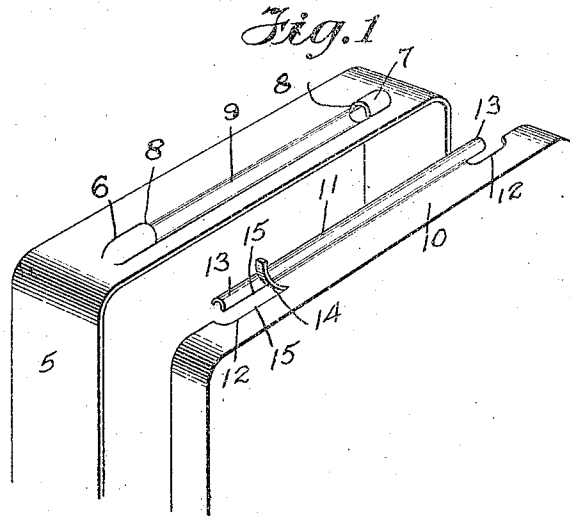
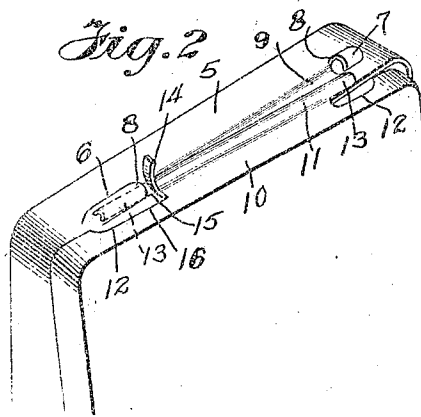
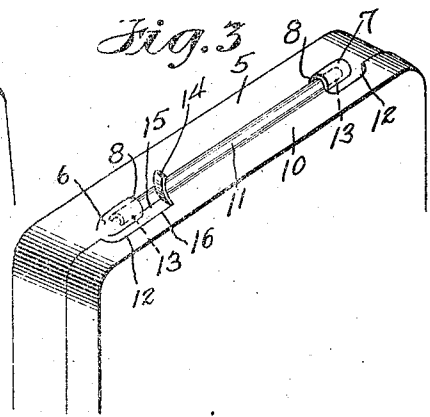
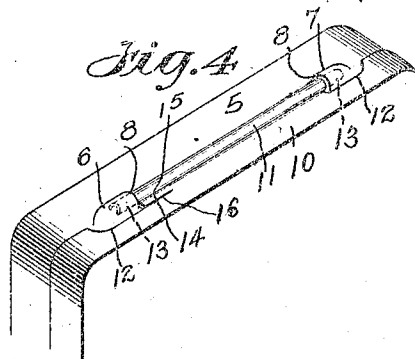


G. W. BERRY.
HINGING OF SHEET METAL RECEPTACLES.
APPLICATION FILED JUNE 4, 1917.

1,235,640.

Patented Aug. 7, 1918.



WITNESS:

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UNITED STATES PATENT OFFICE.

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TO THE WIRELESS HINGE MANUFACTURING COMPANY LIMITED, OF SYDNEY, NEW
SOUTH WALES, AUSTRALIA.

HINGING OF SHEET-METAL RECEPTACLES.

1,235,640.

Specification of Letters Patent.

Patented Aug. 7, 1917.

Original application filed May 11, 1917, Serial No. 167,941. Divided and this application filed June 4, 1917.
Serial No. 172,613.

To all whom it may concern:

Be it known that I, GEORGE WILLIAM BERRY, a subject of the King of England, and a resident of Lorna Doone, Old South Head Road, Rose Bay, in the State of New South Wales, Commonwealth of Australia, have invented certain new and useful Improvements in the Hinging of Sheet-Metal Receptacles, of which the following is a specification.

This invention relates to improvements in the manufacture of covered receptacles in which the cover or lid is hingedly connected to the body of the receptacle, and particularly to receptacles in which the hinge members are formed from and integral with the material of the lids and bodies and pivotally connected without the aid of a wire pintle ordinarily employed for this purpose, the hinge members being formed by passing the lids and bodies successively within the sphere of operation of dies.

It is the object of the invention to provide an improved formation of the hinge members and of hingedly connecting a lid to a body whereby the hinging operation will be simply and economically performed in a highly efficient manner and a strong and durable hinge will result.

In the drawing accompanying and forming a part of this specification, Figure 1 is a perspective view of a lid and body having hinge members formed thereon constructed in accordance with the present invention; and

Figs. 2, 3 and 4 are perspective views showing the successive steps of hingedly connecting the lid and receptacle.

Similar characters of reference designate like parts throughout the different views of the drawing.

In the embodiment of the invention shown in the drawing the body 5 of the receptacle is formed with bulbs or seats 6, 7, these bulbs being formed on that part of the receptacle which is to constitute the back. The bulbs are formed by passing the body over dies which press out the bulbs on the back thereof with the inner ends 8 of the bulbs open by slitting the material of the body at said ends of the bulbs and the outer ends of the bulbs are nicely rounded off as

clearly shown in the drawing. The body between the bulbs is pressed slightly inward by forming a depression or groove substantially to semi-circular shape in cross section, as shown at 9, this depression being formed by the same die that forms the bulbs.

The rim of the lid 10 is formed of greater depth at that part which is to constitute the back than at the front and ends of the rim, this depending portion being longitudinally creased or folded by dies to substantially U-shape in cross section, as shown at 11. After the crease 11 has been formed the portions 12 of the rim at and above the ends of the crease are cut away to form hinge pintles 13 to be embraced by the bulbs 6, 7. At the end of one of the cut away portions 12 there is formed a raised tongue 14 by making incisions 15, 16 parallel to the crease 11 and bending outward the material between said incisions. These incisions and the bending outward of the tongue 14 may be done on a separate die or simultaneously with cutting away the portions 12 to form the pintles 13.

The raising of the tongue 14 on the lid forms an extended pintle and in connecting the lid to the body the extended pintle is passed into the open end of the bulb 6 as far as it will go and then the pintle at the opposite end of the crease 11 is passed into the open end of the other bulb 7. The lid is then moved to its correct position on the body and the tongue 14 is pressed back to its original position which operation can be performed by dies, when the lid will be securely and hingedly connected to the body.

The present application is a division of my co-pending application filed May 11, 1917, and bearing the Serial No. 167,941.

Having thus described my invention, I claim:

1. The herein described improvement in the manufacture of hinges and hingedly connecting the lid and body of a receptacle, consisting in forming bulbs with the inner end open on the back of the body, forming a crease along a part of the edge of the lid, forming the ends of said crease into pintles, making incisions parallel with the crease adjacent one end and opening outward the material between the incisions to form a tongue, inserting the pintles formed at the

ends of the crease into the open ends of the bulbs, and then bending the tongue adjacent the end of the crease inward.

2. The herein described improvement in the manufacture of hinges and hingedly connecting a body and a rimmed lid having a depending rear portion of a receptacle, consisting in forming bulbs with the inner ends open on the back of the body, forming a crease along the lower edge of the depending portion of the lid rim, cutting away portions of the lid rim at the ends of the crease to form pintles, bending a tongue outward from the lid rim contiguous to one of the pintles to form an extended pintle, inserting the pintles into the open ends of the bulbs, and bending the tongue inward.

3. The herein described improvement in the manufacture of hinges and hingedly connecting the lids and bodies of sheet metal receptacles, consisting in forming bulbs with open inner ends on the back of a body, forming a groove in the body between the bulbs, forming a rimmed lid having a depending rear portion with a crease along the lower edge of said depending portion, forming hinge pintles on the lid by cutting away portions above the crease, making incisions parallel with the crease and bending outwardly the metal between the incisions to extend the length of one

of the pintles, inserting the extended pintle beneath its bulb on the body and then placing the opposite pintle in line with and into the other bulb, and then closing inwardly the tongue on the lid.

4. The herein described method of assembling the lid and body of a box, which consists in first providing a seat in one of said parts, and then in providing a pintle on the other part for engagement in said seat, then in displacing a portion of said other part to expose a portion of the length of one end of the pintle, placing the said exposed length of said end of the pintle in its said seat, and finally in restoring the displaced portion to a position holding the pintle against displacement from its seat.

5. The herein described method of assembling the lid and body of a box, which consists in first providing a seat in one of said parts and then in providing a pintle on the other part for engagement in said seat, then in forming incisions adjacent the pintle to form a tongue, bending the tongue to have its free end extend outwardly, placing the pintle in its said seat and finally in rebending the tongue to its original position to hold the pintle against displacement from its said seat.

GEORGE WILLIAM BERRY