D. Croak,

Sheet-Metal Boxes.

No. 50,226. Patented Oct. 3, 1865.

Fig. 1.

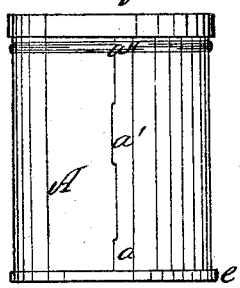


Fig. 2

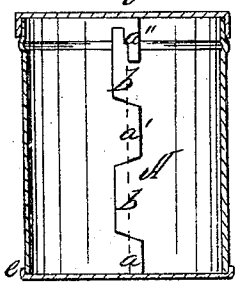
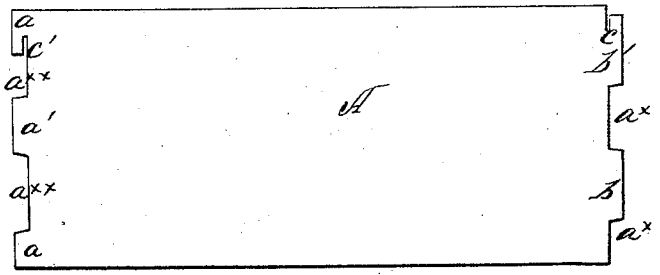


Fig. 3.



Witnesses:
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UNITED STATES PATENT OFFICE.

DANIEL CROAK, OF MILWAUKEE, WISCONSIN.

IMPROVEMENT IN CONSTRUCTION OF SHEET-METAL BOXES.

Specification forming part of Letters Patent No. **50,226**, dated October 3, 1865.

To all whom it may concern:

Be it known that I, DANIEL CROAK, of Milwaukee, in the county of Milwaukee and State of Wisconsin, have invented a new and useful Improvement in the Construction of Sheet-Metal Boxes or Cans; and I do hereby declare that the following is a full, clear, and exact description thereof, which will enable those skilled in the art to make and use the same, reference being had to the accompanying drawings, forming part of this specification, in which—

Figure 1 is an external view of my invention; Fig. 2, a vertical central section of the same; Fig. 3, a view of the metal strip of which the body of the box is composed formed or cut ready for bending.

Similar letters of reference indicate corresponding parts.

This invention relates to a new and improved mode of constructing sheet-metal boxes or cans; and it consists in a novel manner of forming the seam, as herein shown and described.

The body of the box or can is composed of a piece of sheet metal, A, cut out of the proper dimensions and notched at each end, as shown at $a^{\times}$ $a^{\times\times}$, to form three projections or lips, a a' a'', at one end, and two, b b', at the other end, the lips a a' at one end being in line with the notches $a^{\times}$ at the opposite end, and the lips b b' in line with the notches $a^{\times\times}$, the notches and lips corresponding in dimensions, so that the latter, when the sheet-metal plate A is bent in cylindrical form, may fit into the former, as shown clearly in Fig. 2.

The upper lip or projection, b', at one end of the plate A is slotted vertically from its upper edge down, as shown at c, while the upper lip or projection, a'', at the opposite end of the box is slotted vertically from its lower edge up, as shown at c'. These notches, when the plate A is bent in cylindrical form, are locked together, forming a joint at the upper end of the box (see Fig. 2) which cannot spread apart. This joint is essential at the upper part of the box, as the seam would otherwise spread apart at that point when the cover or lid B is removed. At the lower end of the box no such joint is required, as the bottom, d, being connected to the lower edge of A by a flanged seam, e, keeps the lower part of the seam closed. A seam thus formed requires no solder for boxes or cans designed for holding dry articles. For moist or wet articles the seam may be soldered.

By this improvement the manufacture of sheet-metal boxes or cans will be greatly facilitated, no hammering being required, and a neat joint obtained.

I claim as new and desire to secure by Letters Patent—

The constructing of sheet-metal boxes or cans with a seam composed of lips or projections and notches at the ends of the plate forming the body of the box or can, and also with slots, in order to form a locked joint, substantially as shown and described.

DANIEL CROAK.

Witnesses:

MATTHEW FREINE,

WILLIAM POLLARD.