This invention relates to sheet metal cans or containers and has particular reference to a container having a novel and material-saving end seam construction which permanently and hermetically secures a closure member to the container and which permits of the removal of the closure member so that it may be used as a relosure.

An object of the invention is the provision of an inexpensive key opening can provided with a reclosing feature which may be manufactured at a saving in materials to make it economically attractive for products not now packed in such cans.

Another object is the provision in such a container of a narrow type of tearing strip formed in the body wall of the can in a portion of the end seam joint which may be removed readily to effect a substantial full opening in the top of the can, which, after initially being opened, is reclosable without a reduction in the head space of the can.

Another object is the provision in such a can of an end seam joint formed by overlapped or interfolded flanges of the can body and the can end member, the flange of the body being embedded in a sealing material within the recess of the end member to effect a hermetic seal and the flange of the end member being secured in a recess of the body and having its terminal end bent outwardly in a 'fared' top edge of the end seam for strengthening the seam, thereby forming a permanent joint and providing a handy grip to facilitate the removal of the cover when the tearing strip is removed.

Numerous other objects and advantages of the invention will be apparent as it is better understood from the following description, which, taken in connection with the accompanying drawings, discloses a preferred embodiment thereof.

Referring to the drawing:

Figure 1 is a perspective view of a can or container embodying the present invention;

Fig. 2 is an enlarged fragmentary vertical section of the container top before tearing strip is removed, taken substantially along a plane indicated by the line 2—2 in Fig. 1; and

Fig. 3 is a view similar to Fig. 2 after the can has been opened and showing its cover in position as a reclosure.

As an exemplary embodiment of the present invention the drawing illustrates a sheet metal can or container comprising a tubular body 11 provided with a side seam 12 and having a bot-
body and terminate in the body side seam 12. One end of the tearing strip is formed with a tongue 33 which extends beyond the side seam and is engageable by a key 34 or other suitable tool, for removing the tearing strip in the usual manner.

When the tearing strip 31 is removed from the body outer wall 27, as shown in Fig. 3, the upper portion of this wall 27 together with the body inner flange 28 and the reclosure top 15 still permanently secured to it, may be freely lifted out of the upper end of the body 11, leaving a full open mouth in the body for easy removal of the contents of the can.

To facilitate removal and replacement of the reclosure top 15, the upper portions of the interfolded outer wall 27 and inner flange 28 of the body and the outer flange 22 of the reclosure top, are flared outwardly along a gradual curved line of bend which provides a convenient hand grip and which also reinforces the end seam 16 against separation of its interfolded flange walls. Re-closing of the container replaces the reclosure member 15 in its former position on the body bead 26 (Fig. 3) without reducing the head space of the container.

It is evident upon perusal of the drawing that the present container is produced without requiring an extra part, such as a collar or additional wall folds, in making a permanent end seam. In fact, the seam is formed with one less fold or flange on the outer periphery of the end member 15. This effects substantial savings in the amount of sheet material required for producing such an end seam and thus reduces the cost of tearing strip containers so that they may be used for a greater variety of products.

It is thought that the invention and many of its attendant advantages will be understood from the foregoing description, and it will be apparent that various changes may be made in the form, construction and arrangement of the parts without departing from the spirit and scope of the invention or sacrificing all of its material advantages, the form hereinbefore described being merely a preferred embodiment thereof.

I claim:

1. A hermetically sealed sheet metal container comprising a tubular body having a wall terminating at its outer end in a depending flange spaced inwardly from the body wall, said body having an inwardly extending peripheral bend disposed beneath said flange, an end member seated on said body bead on the interior of the container and secured to said body wall in an end seam, said end member having an annular depending inner wall terminating in an integral upstanding outer flange disposed between and snugly engaging against said body wall and de-

pending body wall flange, a sealing material disposed between the depending inner wall and up-standing outer flange of said end member and embedding therein said depending flange of said body wall to provide a hermetic seal therebetween, and a tearing strip set off by spaced score lines in said body wall adjacent said up-standing end member flange, removal of said strip effecting severance of said end member from the body wall to open the container, said end member being thereafter again supported by said inner peripheral body bead as a reclosure cover without reducing the head space of the container.

2. A hermetically sealed sheet metal reclosure container comprising a tubular body having an inwardly flared wall at an end thereof terminating in a depending flange spaced inwardly from the body wall, said body having an inwardly extending peripheral bead disposed beneath said flange, an end member seated on said body wall on the interior of the container and secured to said body wall in an end seam, said end member having a raised central panel merging into an annular outwardly and downwardly inclined wall portion in turn merging into an annular depending inner wall snugly engaging against said depending body wall flange and terminating in an integral upstanding outer flange, said upstanding end member flange being disposed between and snugly engaging against said body wall and said depending body wall flange, a sealing material disposed in the annular space between the depending inner wall and upstanding end member flange, removal of said strip effecting severance of said end member from the body wall to open the container, said end member being thereafter again supported by said inner peripheral body bead as a reclosure cover without reducing the head space of the container.

STEELAN BIRKLAND.

REFERENCES CITED

The following references are of record in the file of this patent:

UNITED STATES PATENTS

<table>
<thead>
<tr>
<th>Number</th>
<th>Name</th>
<th>Date</th>
</tr>
</thead>
<tbody>
<tr>
<td>797,395</td>
<td>Assmann</td>
<td>Aug. 15, 1905</td>
</tr>
<tr>
<td>1,661,578</td>
<td>Rollason</td>
<td>Mar. 6, 1928</td>
</tr>
<tr>
<td>1,719,581</td>
<td>Bardet</td>
<td>July 2, 1929</td>
</tr>
<tr>
<td>2,072,149</td>
<td>Young</td>
<td>Mar. 2, 1937</td>
</tr>
<tr>
<td>2,391,566</td>
<td>Reese</td>
<td>Oct. 12, 1943</td>
</tr>
<tr>
<td>2,348,750</td>
<td>Peck</td>
<td>May 16, 1944</td>
</tr>
</tbody>
</table>