

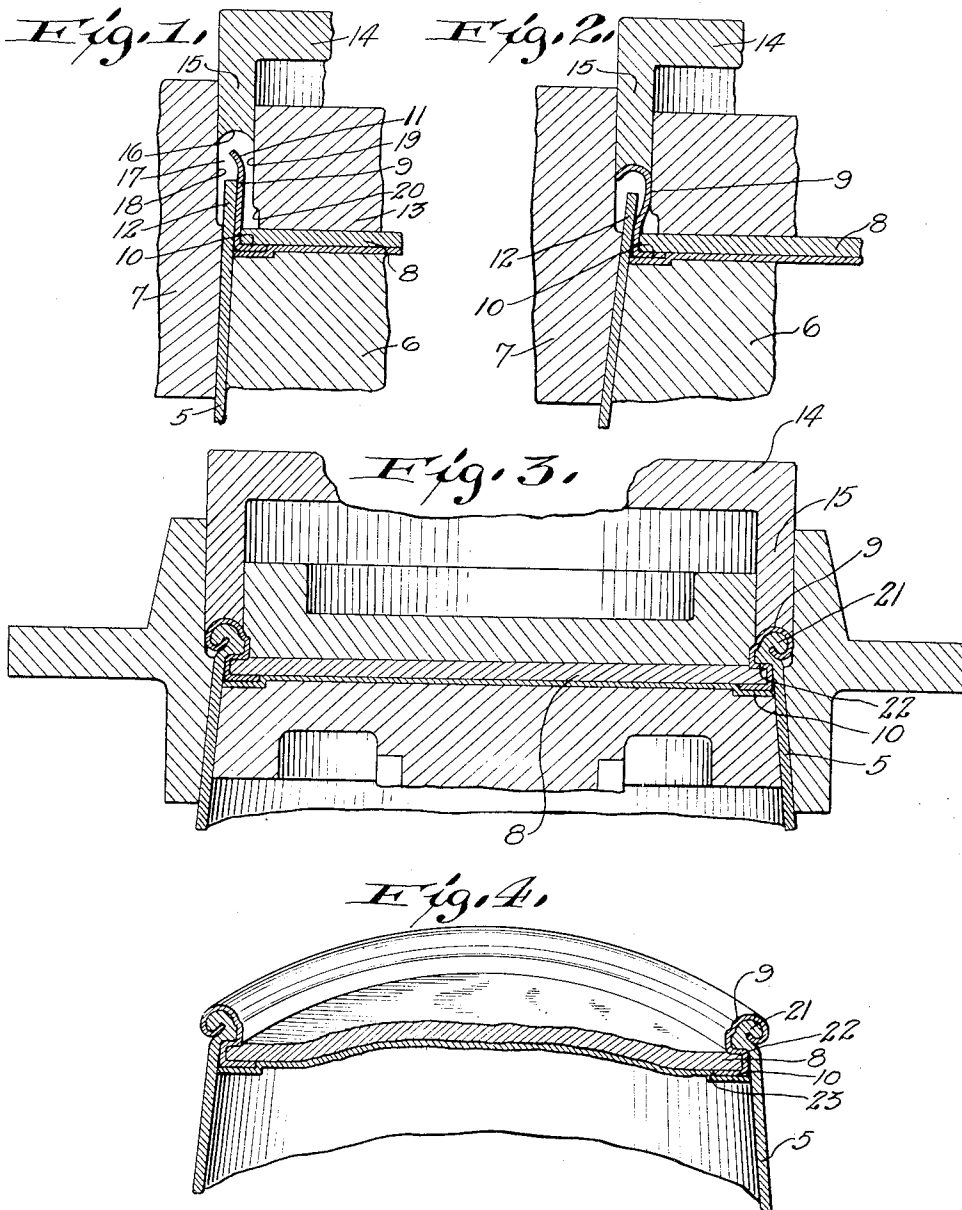
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METHOD OF MAKING CONTAINER CLOSURES

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METHOD OF MAKING CONTAINER CLOSURES.

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The invention relates to fibre container closures, and more particularly to the method of making the same.

The object of the invention is to provide
5 a method of attaching the head to the siding of the container by a sheet-metal band which is initially provided with an inwardly extending flange disposed adjacent
10 the extended edge of the siding, is subject to pressure within a confined space whereby the band is bent down into a flange against the other side of the head and is thence
15 the siding into crimping engagement therewith so that a band of simple initial form may be used.

The invention further consists in the method hereinafter set forth, and more particularly defined by claims at the conclusion
20 hereof.

In the drawings, Fig. 1 is a detail sectional view of the parts as initially positioned in the forming apparatus;

25 Fig. 2 is a similar view, showing an intermediate position of the parts;

Fig. 3 is a similar view showing the parts in finished form;

30 Fig. 4 is a perspective view of the closure, parts being broken away and parts being shown in section.

In the drawings the numeral 5 designates the fibre tubing forming the siding of the body or cover of a container. This siding
35 is either of pressed pulp or a number of wrappings of paper or fibre sheets, and is placed on an anvil or internal expanding chuck 6 shaped to fit the inner side thereof, and with the head, hereinafter described,
40 in place, is clamped to the chuck 6 by a contractible chuck 7 of any suitable construction, which grips the outside of the tubing or siding adjacent the chuck 6.

A closure or head 8 of fibre, either of
45 pressed pulp or a number of layers of paper or fibre sheets shaped to fit within the adjacent inner side of the siding, is carried by and fits within a metal band 9 of thin sheet-steel or other suitable sheet-metal.

50 The band 9 is formed from a strip or sheet of sheet-metal which is formed with a flange 10 at one edge and a slightly curved outer edge 11. The band thus formed has

the head inserted within it so that it abuts against the flange 10 and when thus assembled it is placed within the siding, as shown
55 in Fig. 1, so that a part 12 of the siding projects above the head and, with the chuck 7 applied, a cylindrical plunger 13 is moved down to clamp the head and band between
60 it and the chuck 6.

Another plunger 14, having an annular part 15 provided with a curved forming-edge 16, works in the space 17 between the
65 chuck 7 and the plunger 13.

This space 17 is further defined by an annular surface 18 of the chuck 7 and the straight side 19 and annular recess at the head end of the plunger 13.

As the plunger 14 moves down it first
70 bends over the outer edge 11 of the band and throws the portion of the band between this edge and the head away from the part 12, as shown in Fig. 2, and thereafter further movement of said plunger forces the
75 edge 11 of said band and the outer edge portion of the siding into a beaded edge 21, and at the same time a part 22 of said band is pressed down over the head 8 by reason
80 of the recess 20 so that the head is clamped between the flange formed by the part 22 and the flange 10, as shown in Fig. 3.

In those instances where it is not desired to have metal come in contact with the contents of the container, a fibre or paper
85 facing disk 23 is secured to the head and projects over the flange 10.

What I claim as my invention is:—

1. The method of forming a container closure in which the head fits within a metal
90 band having a flange abutting against the inner side of the head which consists in positioning the head with its band within the siding of the container so that a part
95 of the siding extends above the head, clamping said siding adjacent the head, the head and the flange portion of the band against movement, and with the parts thus clamped
100 bending in a confined space that portion of the band and siding near the head over the head and the outer end portions of the siding and band into a beaded edge adjacent the head.

2. The method of forming a container closure in which the head is clamped
105 between spaced flanges of a metal band and

the band is clamped to the siding which consists in seating the head against a flange initially formed in the siding and positioning these parts within the siding of the container and then subjecting these parts to a pressing operation to form the other head-engaging flange of the band and clamp the head between said flanges and simultaneously roll the outer parts of the band and siding, by pressure applied within a confined space, into crimping engagement with the siding. 10

In testimony whereof, I affix my signature.

EDWIN F. HULBERT.