

No. 781,778.

PATENTED FEB. 7, 1905.

H. E. LEPPERT.
BOX.
APPLICATION FILED NOV. 21, 1904.

Fig. 1.

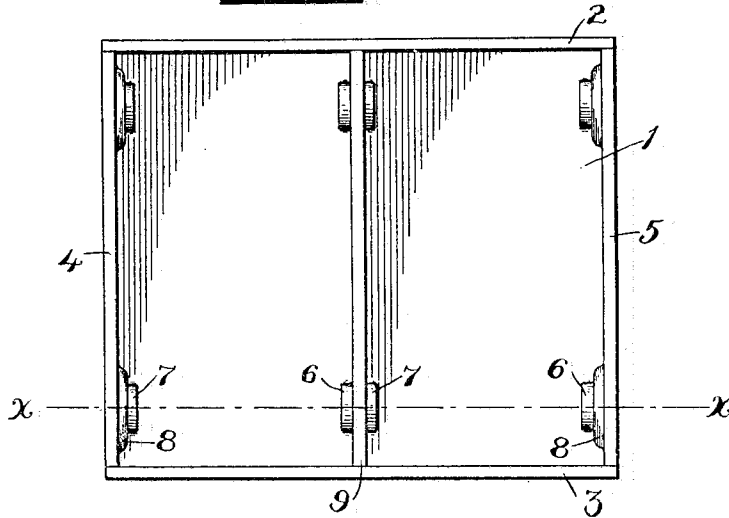


Fig. 2.

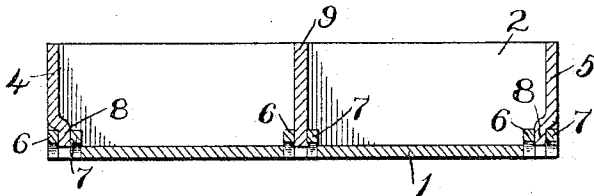
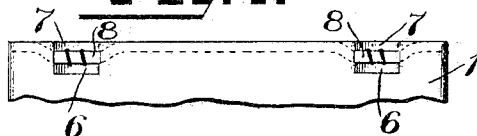


Fig. 3.



Fig. 4.



Witnesses
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UNITED STATES PATENT OFFICE.

HENRY E. LEPPERT, OF NEW BRITAIN, CONNECTICUT, ASSIGNOR TO THE HART MANUFACTURING COMPANY, OF HARTFORD, CONNECTICUT, A CORPORATION OF NEW JERSEY.

BOX.

SPECIFICATION forming part of Letters Patent No. 781,778, dated February 7, 1905.

Application filed November 21, 1904. Serial No. 233,608.

To all whom it may concern:

Be it known that I, HENRY E. LEPPERT, a citizen of the United States, residing at New Britain, in the county of Hartford, State of Connecticut, have invented certain new and useful Improvements in Boxes, of which the following is a full, clear, and exact description.

My invention relates to improvements in metallic boxes, the main object being to improve and simplify the construction of the same.

Figure 1 is a plan view of a box constructed to embody my invention with the cover removed. Fig. 2 is a section on the line X X, Fig. 1. Fig. 3 is an end elevation. Fig. 4 is a view of the under side of the end shown in Fig. 3.

1 is the bottom of the box. 2 3 are the sides thereof. 4 5 are the end pieces, the same being secured to the bottom 1 in the following manner: Adjacent to the end edges of the bottom 1 certain portions of the metal are struck up or arched, as best seen in Fig. 3. In the preferred form the highest part of the arch of each struck-up portion stands slightly above the plane of the inner surface of the bottom 1. Each of these struck-up portions is then grooved or slotted to a depth sufficient to penetrate the metal, so as to form the double arches 6 7. The plain edge of each end piece is then indented or set in, as at 8, so as to register with the struck-up portions in the bottom 1. These indented portions 8 are caused to project into and through the slots in the bottom plate 1. (See Figs. 2 and 4.) It is then merely necessary to upset the metal at the edge of each end plate where it projects through the bottom plate, and thus produces, in effect, a riveted joint with no portion of the rivet-head projecting below the lower plane of the bottom 1. The end pieces 4 5 are thus securely anchored to said bottom 1 and furnish a substantial and economical method of fastening. Because of the offset portions 8 of the end pieces a broad base is given thereto, which securely supports the same upon the upper surface of the bottom 1,

preventing lateral deflection. 9 is a partition which, if desired, may be provided in the box thus formed. This partition may be secured to the bottom in the same manner as the end pieces, the center struck-up portions furnishing the same double arch 6 and 7, as seen in Figs. 1 and 2, to receive the edge of the partition 9. Obviously the partition 9 need not be provided with the offset portions 8 shown at the edge of each end piece, although of course such arrangement might be availed of. The presence of the arches 6 and 7 on opposite sides of the end pieces and the partition prevents lateral displacement of said parts. I have shown the side wings 2 3 of the box as formed integrally with the bottom 1. Obviously that method of forming and attaching the side wings is immaterial.

This invention consists, broadly, in the unique method of attaching two plates together at an angle by means of a rivet integral with one part the head of which will not stand above the outer surface of the other part.

What I claim is—

1. In a box or the like, two plates arranged at an angle to each other and means of connection between said plates comprising a struck-up slotted portion in one plate, the edge of the other plate projecting into and through the slot of said struck-up portion and expanded or headed below the same to secure said parts together.

2. In a box or the like, two plates arranged at an angle to each other and means of connection between said plates comprising a struck-up slotted portion in one plate, the edge of the other plate being offset laterally, said offset portion projecting into and through the slot of said struck-up portion and expanded or headed below the same to secure said parts together.

Signed at Hartford, Connecticut, this 18th day of November, 1904.

HENRY E. LEPPERT.

Witnesses:

G. W. HART,
H. A. HART.