

W. T. McCUE.

ICE CAN.

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1,155,751.

Patented Oct. 5, 1915.

Fig. 1.

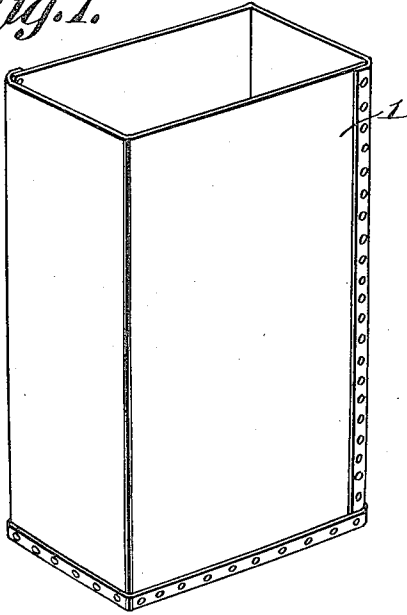


Fig. 2.

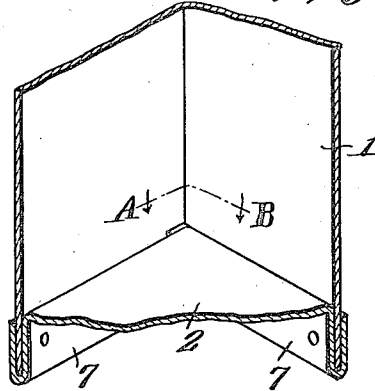


Fig. 3.

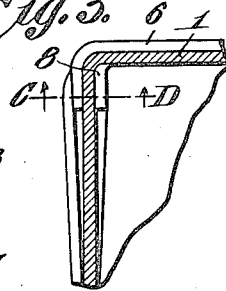


Fig. 6.

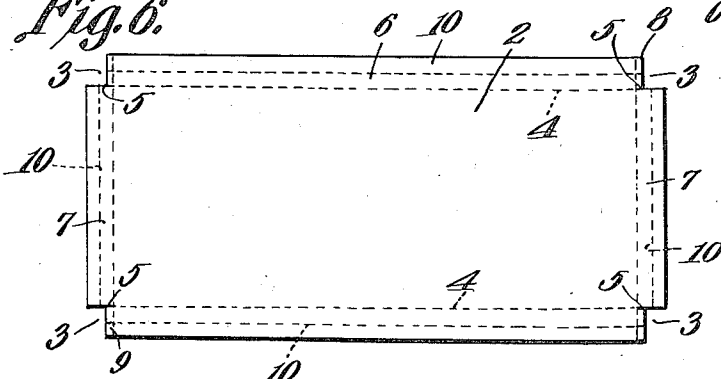


Fig. 4.

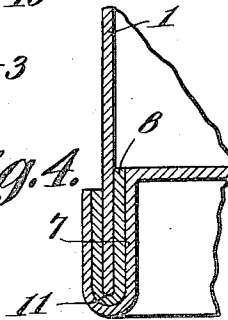
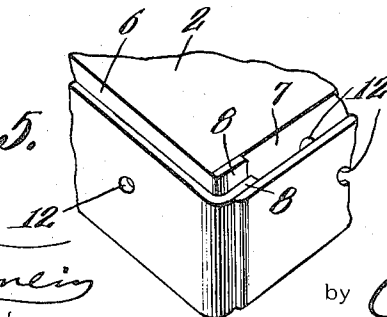


Fig. 5.



Witnesses

J. P. Meier
S. Willard

by

W. T. McCue,
C. A. Snow & Co.
Inventor
Attorneys

UNITED STATES PATENT OFFICE.

WILLIAM T. McCUE, OF PITTSBURGH, PENNSYLVANIA, ASSIGNOR TO PATRICK WALL,
OF PITTSBURGH, PENNSYLVANIA.

ICE-CAN.

1,155,751.

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To all whom it may concern:

Be it known that I, WILLIAM T. McCUE, a subject to the King of England, residing at Pittsburgh, in the county of Allegheny and State of Pennsylvania, have invented a new and useful Ice-Can, (Case B,) of which the following is a specification.

This invention relates to cans of that type used in the manufacture of ice and it has reference more particularly to the bottoms of such cans and to a method of producing the same.

As is well known to those acquainted with the art to which this invention relates, the bottoms of the cans heretofore used have been formed by pressing or drawing the edges thereof downwardly to form a continuous uninterrupted flange on each of said bottoms, or by cutting out the corners of a blank and bending down the edge portions thereof, solder or the like being used to seal the corners and prevent leakage. These forms of can bottoms have been found undesirable either because of the cost of manufacturing the pressed bottoms in different sizes, or because of the weakness of the corners of those bottoms formed of notched and bent blanks.

One of the objects of the present invention is to avoid all of the objections heretofore mentioned by providing a bottom having the advantages and none of the disadvantages of a bottom shaped by bending and one shaped by pressing or drawing.

A further object is to provide a bottom having means whereby it can be easily attached to the walls of the can and whereby the can is strengthened at the bottom and rendered less liable to break open at the corners when subjected to rough usage.

With the foregoing and other objects in view the invention consists in certain novel steps in the method of producing the can bottoms and in certain novel details of construction and arrangement of parts herein-after described and claimed, it being understood that changes in the precise embodiment of the invention herein disclosed, can be made within the scope of what is claimed, without departing from the spirit of the invention.

In the accompanying drawings the preferred form of the invention has been shown.

In said drawings, Figure 1 is a perspective view of a can having the present im-

provements combined therewith. Fig. 2 is a perspective view of one corner portion of the can. Fig. 3 is a horizontal section through one corner portion of the can, said section being taken approximately on the line A—B Fig. 2. Fig. 4 is a section on line C—D Fig. 3. Fig. 5 is a perspective view of one corner portion of the bottom of the can. Fig. 6 is a detail view of the blank from which the bottom of the can is shaped.

Referring to the figures by characters of reference 1 designates the body of the can, the same being formed of one or more sheets of metal riveted or otherwise secured together along their vertical edges. The bottom of the can is formed in a single blank of sheet metal, indicated at 2 and having its corners cut away as shown at 3. The said blank is adapted to be bent along the dotted lines shown at 4 in Fig. 6, these dotted lines extending to the inner ends of short incisions 5 which are parallel with the long sides of the blank and extend to the notches or cut out portions 3. When the blank is bent along the lines 4, depending side and end flanges 6 and 7 are produced, the flanges 6 terminating in wings 8 adapted to be bent at right angles along the dotted lines 9 so as to lap the ends of the flanges 7. All of the flanges 6 and 7 are adapted to be bent upwardly along the intermediate lines 10 and a continuous exterior channel 11 is thus formed by folding the flanges 6 and 7. The wings 8 are welded to the ends of the flanges 7 so that said flanges 6 and 7 thus extend continuously and uninterruptedly around the bottom. The lapping portions of the flanges 7 and wings 8 have been clearly indicated in Figs. 2, 3, 4 and 5. After these lapping portions have been welded, the outer faces thereof are dressed with a file or the like so as to present a smooth surface. After the flanges have thus been lapped and welded together, the lower edges of the connected sheets 1 are inserted into the continuous channel 11 formed by the folded flanges 6 and 7 and holes 12 are bored transversely through the interfitting portions of the flanges and walls and rivets are inserted through these holes and headed. Thus the parts are held together securely and leakage therebetween is prevented. As the flanges 6 and 7 are welded together at their ends and form a continuous unbroken channel for the reception of the lower edges of the walls, it

will be apparent that the can is considerably reinforced at its corners and is thus better able to withstand the rough usage to which it is ordinarily subjected than is a can in which the flanges abut at their ends and are held by solder or are left disconnected.

By providing the bottom with a continuous channel 11 for the reception of the lower edges of the walls of the can, the final operation of dipping the bottom portion of the can in molten solder is rendered more effective inasmuch as the molten solder will be received in the channel and will not drain therefrom. Thus absolute sealing of the bottom of the can is insured.

What is claimed is:—

1. An ice can including a sheet metal bottom having edge flanges each forming a channel, the inner and outer walls of each channel having their ends lapping the inner and outer walls of the next adjoining channel whereby a continuous uninterrupted solder retaining channel is formed around

the bottom, and walls extending into and secured within the continuous channel.

2. An ice can including a sheet metal bottom having edge flanges each forming a channel, the inner and outer walls of each channel having their ends lapping the inner and outer walls of the next adjoining channel whereby a continuous lap is provided along said walls and under the channels and a continuous uninterrupted solder retaining channel is formed around the bottom, the lapped portions of the walls constituting means for preventing leakage of solder during the dipping of the can, and walls extending into and secured within the continuous channel.

In testimony that I claim the foregoing as my own, I have hereto affixed my signature in the presence of two witnesses.

WILLIAM T. McCUE.

Witnesses:

GEO. A. YOUNG,
JAS. P. WALL.