

W. H. BRAKENRIDGE.
METHOD OF MANUFACTURING METAL BOXES.
APPLICATION FILED JUNE 19, 1911.

1,026,340.

Patented May 14, 1912.

Fig. 1.

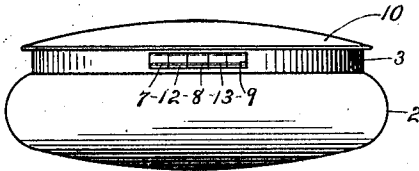


Fig. 5.

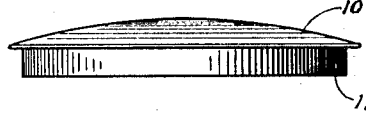


Fig. 2.

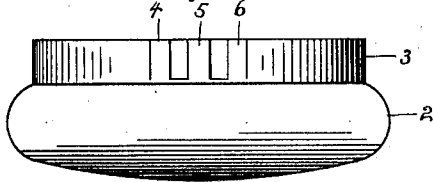


Fig. 6.

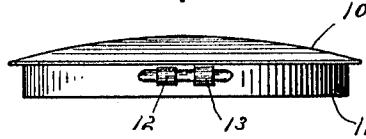


Fig. 3.

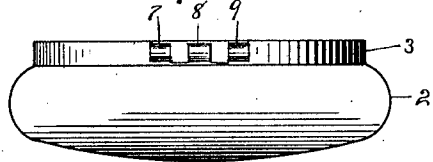


Fig. 7.

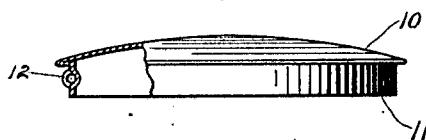


Fig. 4.

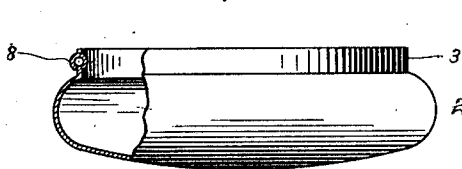
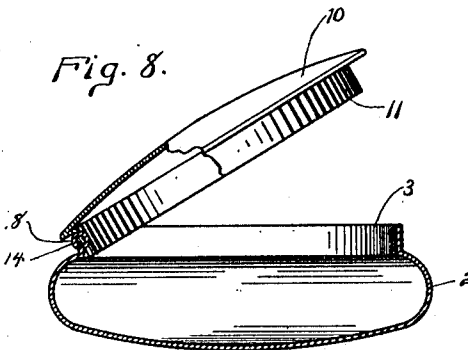


Fig. 8.



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UNITED STATES PATENT OFFICE.

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METHOD OF MANUFACTURING METAL BOXES.

1,026,340.

Specification of Letters Patent.

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To all whom it may concern:

Be it known that I, WILLIAM H. BRAKENRIDGE, a citizen of the United States, residing at Waterbury, in the county of New Haven and State of Connecticut, have invented a new and useful Improvement in Methods of Manufacturing Metal Boxes; and I do hereby declare the following, when taken in connection with the accompanying drawings and the letters of reference marked thereon, to be a full, clear, and exact description of the same, and which said drawings constitute part of this specification, and represent, in—

Figure 1 a side view of a box constructed in accordance with my invention. Fig. 2 shows the box with a deep neck, and this neck vertically slitted. Fig. 3 is a side view showing the fingers rolled and the neck trimmed down. Fig. 4 a view partially in section at right angles to Fig. 3. Fig. 5 a side view of the cover detached. Fig. 6 a side view of the same showing the knuckle joints formed therein. Fig. 7 a side view partially in section. Fig. 8 a sectional view of the box with the cover attached.

This invention relates to an improvement in method of manufacturing metal boxes, and particularly to method of manufacturing small metal boxes commonly known as "vanity" boxes. These boxes comprise a shallow round box, a contracted neck and a comparatively flat top cover which is hinged to the box and provided with a flange which sets within the neck of the box. These boxes are intended to contain powder for ladies' use and it is necessary that the cover fit very tightly.

The object of the invention is an improved method of forming boxes, or particularly hinges therefor and consists in the construction hereinafter described and particularly recited in the claim.

In carrying out my invention, the box 2 with its neck 3 is drawn up from sheet metal,

and the neck is much deeper than required for the finished box. This neck is then slitted vertically to form three fingers 4, 5, and 6, and these fingers are then rolled outward to form hinged knuckles 7, 8 and 9. The upper edge of the remaining portion of the neck is then trimmed down to a point in line with the upper edges of these knuckles as shown in Fig. 3. The cover 10 is struck from sheet metal and has a flange 11 adapted to fit within the neck 3, and this flange is slitted and the metal struck outward to form knuckles 12 and 13 which are adapted to pass between the knuckles 7 and 8, and 8 and 9; and so as to bear upon the neck of the box between the knuckles thereon and a pin 14 is then passed through the knuckles, thus hinging the cover to the box. This construction makes a very tight joint at the hinge and permits the cover to firmly and tightly close the box.

I claim:—

A method of forming metal boxes consisting of drawing the box with a deep tubular neck, slitting the neck from the upper edge inward to form a series of fingers, rolling the fingers outward to form hinged knuckles near the bottom of the neck, trimming the remaining portion of the upper edge of the neck to a line with the upper edges of said knuckles, forming the cover with a flange, forming knuckles in said flange corresponding to the spaces between the knuckles on the neck and so that the knuckles of the cover contact with the neck between the knuckles thereof, and inserting a pin through the knuckles in the cover and box.

In testimony whereof, I have signed this specification in the presence of two subscribing witnesses.

WILLIAM H. BRAKENRIDGE.

Witnesses:

J. S. NEAGLE,

JOHN J. DONAHUE.