

No. 782,142.

PATENTED FEB. 7, 1905.

M. J. KENNY.
SHEET METAL ARTICLE.
APPLICATION FILED APR. 4, 1904.

Fig. 1.

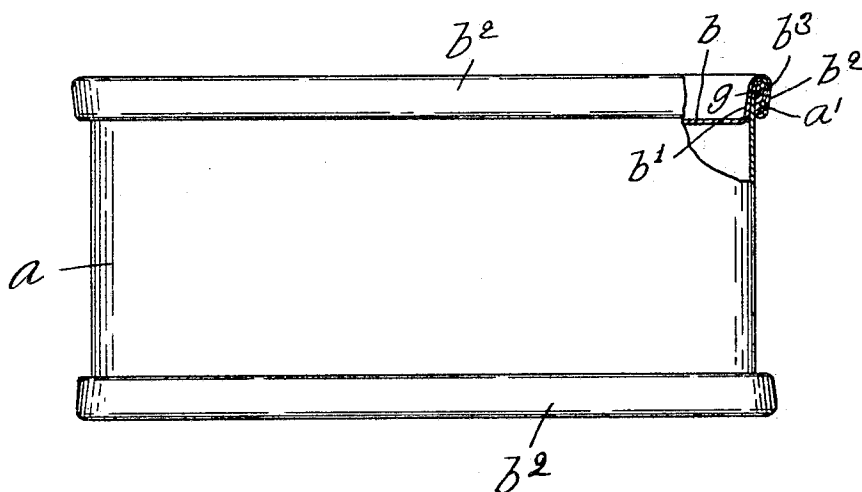
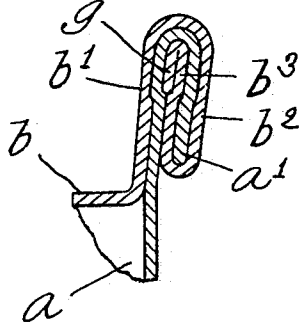


Fig. 2.



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MICHAEL J. KENNY, OF EAST WALPOLE, MASSACHUSETTS.

SHEET-METAL ARTICLE.

SPECIFICATION forming part of Letters Patent No. 782,142, dated February 7, 1905.

Application filed April 4, 1904. Serial No. 201,408.

To all whom it may concern:

Be it known that I, MICHAEL J. KENNY, of East Walpole, county of Norfolk, State of Massachusetts, have invented an Improvement in Sheet-Metal Articles, of which the following description, in connection with the accompanying drawings, is a specification, like characters on the drawings representing like parts.

This invention relates to improvements in the manufacture of sheet-metal articles—as, for instance, boxes, cans, and the like—and has particular reference to the formation of the seam between the body and head or end of the article; and the invention has for its object the novel construction of the seam.

The invention consists in a sheet-metal article having a folded seam and a narrow metallic strip entirely inclosed within the seam formed integral with one of the members of the article. The narrow metallic strip is compressed severely while inclosed within the seam by severely compressing the seam and while serving as a filling-strip acts, by crowding the several inner folds of the seam, to cause all the recesses or crevices to be filled and a hermetically-tight seam to be produced.

Figure 1 shows in side elevation a sheet-metal article embodying this invention. Fig. 2 is an enlarged cross-sectional detail of the seam.

a represents the body of the sheet-metal article, and *b* the head or end. The body *a* has a seaming-flange *a'*, and the head or end *b* has a seaming-flange comprising the folded portions *b'* *b''* *b'''*, which are interlocked in any usual or suitable manner with the seaming-flange *a'* on the body, so as to present what is commonly called a "double-locked" seam. The end of the portion *b'* of the seaming-flange on the head is turned over upon itself a short distance from its edge, and such turned-over portion forms a narrow strip *g*. The strip *g* is designed to serve as a filling-strip, and in order

that it may subserve its intended functions it is entirely concealed within the seam, and when the seam is severely compressed the opposite sides of the seam will occupy smooth parallel planes, and the filling-strip *g*, which is entirely inclosed therein, will be severely compressed and will act to crowd the inner folds of the seam more or less, and thereby cause all recesses or crevices to be filled and a hermetically-tight seam to be produced.

For simplicity of construction and ease of manufacture it is preferred that the filling-strip *g* shall be formed as an integral part of the seaming-flange on the head, although my invention is not so limited. In practice I prefer to manufacture the sheet-metal article in accordance with the method shown in my application for Letters Patent, Serial No. 193,637, filed February 15, 1904; yet it is obvious that it may be otherwise manufactured.

Having thus described my invention, what I claim as new, and desire to secure by Letters Patent, is—

1. A sheet-metal article having a folded seam and a narrow filling-strip entirely inclosed within the seam, which is formed integral with one of the members of the article, and which acts, when the seam is compressed, to crowd the inner folds thereof, substantially as described.

2. A sheet-metal article comprising a body and a head connected by a folded seam, and a narrow filling-strip entirely inclosed within the seam which is formed integral with said head, and which acts, when the seam is compressed, to crowd the inner folds thereof, substantially as described.

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

MICHAEL J. KENNY.

Witnesses:

B. J. NOYES,
H. B. DAVIS.