

J. C. MILLIGAN.

TINNED BLANK.

No. 174,275.

Patented Feb. 29, 1876.

Fig. 1

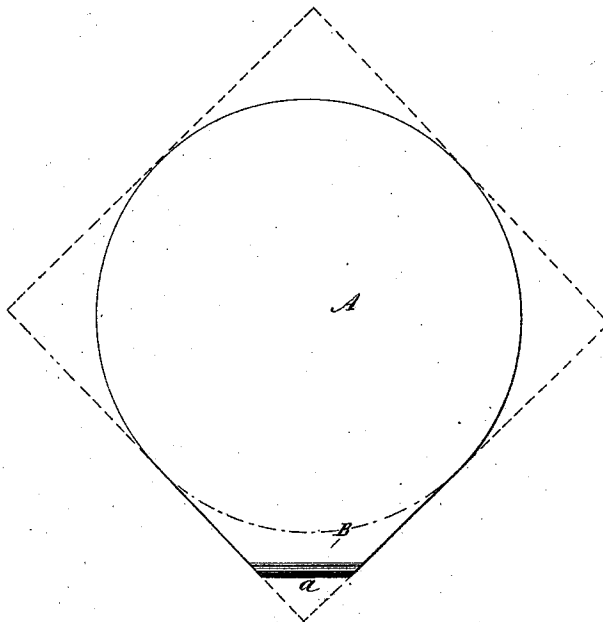


Fig. 2



WITNESSES:

C. Novell
Alex. F. Roberts

INVENTOR:

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UNITED STATES PATENT OFFICE.

JOHN C. MILLIGAN, OF SOUTH ORANGE, NEW JERSEY.

IMPROVEMENT IN TINNED BLANKS.

• Specification forming part of Letters Patent No. **174,275**, dated February 29, 1876; application filed December 16, 1875.

To all whom it may concern:

Be it known that I, JOHN C. MILLIGAN, of South Orange, in the county of Essex and State of New Jersey, have invented new and Improved Tin-Plate Blanks for Stamped Vessels, of which the following is a specification:

My invention consists of a little extension-lip at one part of the edge of a round plate or blank of tin plate; the object of which is to receive the beads of tin that flow to the lower edge, and there solidify on drawing the sheet out of the bath, so that they can be removed from the sheet by cutting off the lip without destroying the symmetry of the blank.

Figure 1 is a plan view, and Fig. 2 is an edge view, of a blank of round form contrived according to my invention.

Similar letters of reference indicate corresponding parts.

It is desirable to prepare round blanks for stamping up into sheet-metal ware at the mills where the sheets are rolled, and before they are trimmed, because the waste from the corners can be worked over again and the tin saved; but in practice it is found, in tinning round sheets, that beads of tin gather at the lower edge when drawing the sheets out of the bath, which greatly interfere with the stamping-dies by the extra thickness of metal which

they make under one part, which cramps and strains the machinery and causes the tin to pucker to such extent as to amount to a serious difficulty.

Therefore, I propose to have each sheet or blank A cut with a projecting lip, B, when trimmed, before tinning for a round blank, and, when tinning the blank, hold it with the lip down, so that the tin flowing down when withdrawing it from the bath will gather thereon, where it can be completely removed from the blank without injury to the shape. This lip is formed of a portion of one corner of the blank, as indicated by the dotted lines, so that it makes no waste of metal.

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

A projecting lip, B, on the edge of a round tin-plate blank, A, arranged to receive the drip of the tin from the bath and to be cut off to remove the same without detriment to the form of the blank, substantially as specified.

JOHN C. MILLIGAN.

Witnesses:

T. B. MOSHER,
A. P. THAYER.