

W. J. REUTER.
SHEET METAL VESSEL.
APPLICATION FILED DEC. 17, 1909.

957,901.

Patented May 17, 1910.

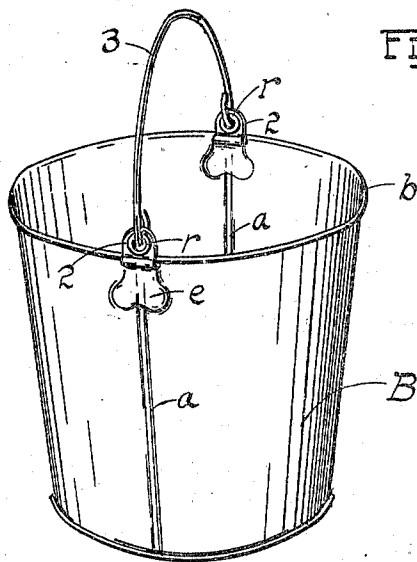


FIG. 1.

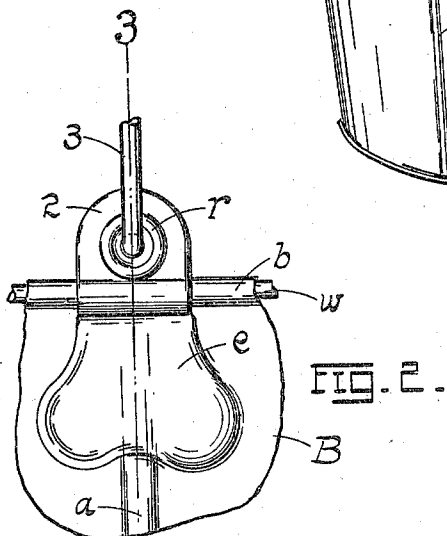


FIG. 2.

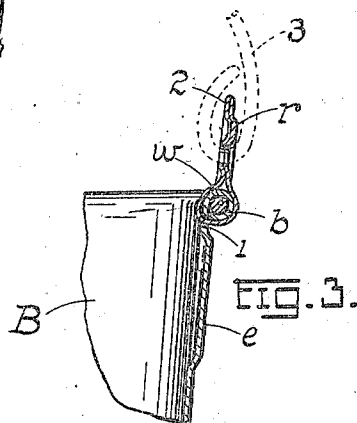


FIG. 3.

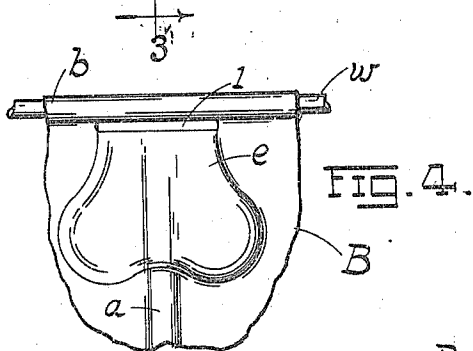


FIG. 4.

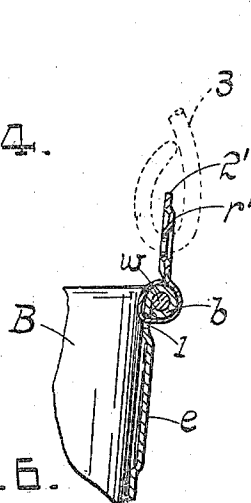


FIG. 6.

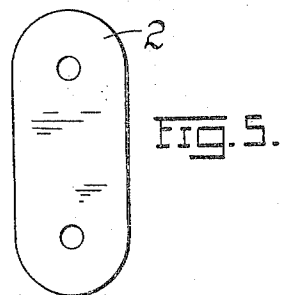


FIG. 5.

WITNESSES:
Harry A. Reimer.
Joseph Michel

INVENTOR.
Wm. J. Reuter.
BY *Emil Hare*
ATTORNEY.

UNITED STATES PATENT OFFICE.

WILLIAM J. REUTER, OF ST. LOUIS, MISSOURI.

SHEET-METAL VESSEL.

957,901.

Specification of Letters Patent.

Patented May 17, 1910.

Application filed December 17, 1909. Serial No. 533,588.

To all whom it may concern:

Be it known that I, WILLIAM J. REUTER, a citizen of the United States, residing at St. Louis, State of Missouri, have invented certain new and useful Improvements in Sheet-Metal Vessels, of which the following is a full, clear, and exact description, reference being had to the accompanying drawings, forming a part hereof.

My invention has relation to improvements in sheet-metal vessels; and it consists in the novel details of construction more fully set forth in the specification and pointed out in the claims.

In the drawings, Figure 1 is a perspective showing my invention applied to an ordinary sheet-metal bucket; Fig. 2 is an enlarged outside elevation of the bail-securing clip and portion of the bail; Fig. 3 is a vertical section on the line 3—3 of Fig. 2; Fig. 4 is an enlarged outside elevation of the upper edge of the vessel showing slot for the reception of the clip; Fig. 5 is a plan of the blank from which the clip is formed; and Fig. 6 is a sectional detail on the order of Fig. 3 showing a modified form of clip.

The object of my invention is to provide sheet-metal vessels with means for securing the bail or handle thereto without the use of rivets, and without the waste incidental to the use of metal from which the ears carrying the bail are stamped.

A further object is to remove the objectionable rivet heads which detract more or less from the appearance of the vessel.

The advantages of the present invention will be at once apparent from a detailed description thereof which is as follows:—

Referring to the drawings, B, represents a conventional sheet-metal bucket of galvanized metal, granite ware or the like, in the present instance with sides formed of two sections united along the seams *a* as well understood in the art. The upper edge of the vessel is provided with a wire *w* with the metal folded thereover, thereby forming a stiffening bead *b* though this bead may be formed by a mere rolling back of the edge of the metal without any actual wire. The presence of the wire however insures greater stiffness for the edge and is to be preferred for vessels subjected to considerable handling. In order to provide for the gradual disappearance of the seam *a* at the top of the vessel, I preferably press the wall about the upper end of the seam outwardly

thereby forming an embossed lobe *e* disposed symmetrically on either side of the seam, and serving to stiffen the metal about the seam at that point. At the upper edge of the lobe *e* and immediately beneath the bead *b* I punch an elongated slot 1 through which is inserted a sheet metal clip 2 subsequently folded about the bead and the folds pressed together, the ends of the bail 3 being pivotally and loosely inserted through the folded portions of the clip in the same manner as is now resorted to in attaching a bail to the ears usually riveted to the sides of the vessel.

The clips 2 may be made of ordinary scraps, so that the expense of stamping specially improvised ears to be riveted to the vessel is dispensed with, and the labor of riveting is eliminated. When the folded portions of the clip are pressed together, the die forms a circular stiffening rib *r* about the opening which receives the bail wire, this rib securely binding the folded portions against separation, the parts thus brought together being further cemented after the vessel has been dipped in the galvanizing or other bath by which the metal is to be protected. As formed, the folded clip 2 appears to be a continuation or extension of the lobe *e*, so that the whole forms a very attractive appearance.

It is of course not necessary that the clip 2 should be doubled on itself to form the carrier for the bail; and in Fig. 6 I show a clip 2' provided with a circular rib *r'* and having one end inserted through the slot 1, and then folded directly over the bead or wire of the bucket. The latter construction is sufficient for light buckets not subjected to special abuse, a heavy bucket requiring a clip doubled on itself as shown.

Having described my invention what I claim is:—

1. A vessel provided with diametrically disposed openings contiguous and parallel to the upper edge of the vessel, clips inserted through said openings and folded about and projecting above the edge of the vessel, and a bail having its ends passed through the clips and secured thereto.

2. A sheet metal vessel provided with an upper stiffening bead, and having diametrically opposite slots cut in the sides immediately under and parallel to the bead, clips passed through the slots and folded about and projecting above the bead, and a bail having its ends coupled to the clips.

3. A sheet metal vessel provided with an upper stiffening bead, and having diametrically opposite slots cut in the sides immediately under and parallel to the bead, clips
5 passed through the slots and folded about and projecting above the bead and doubled, the doubled ends being provided with registering openings for the passage of the ends of a bail, and having a stiffening rib formed
10 about said registering openings.

4. A sheet metal vessel having sides formed of two sections seamed at points diametrically opposite one another and having

embossed lobes at the upper ends of the seams, a stiffening bead at the upper edge
15 of the vessel, a pair of clips inserted through openings cut lengthwise of the bead between the lobes and bead and folded about the bead, and a bail having its ends hinged to the clips above the bead.

In testimony whereof I affix my signature,
20 in presence of two witnesses.

WILLIAM J. REUTER.

Witnesses:

EMIL STAREK,

JOS. A. MICHEL.