

Dec. 10, 1940.

C. H. WILD ET AL

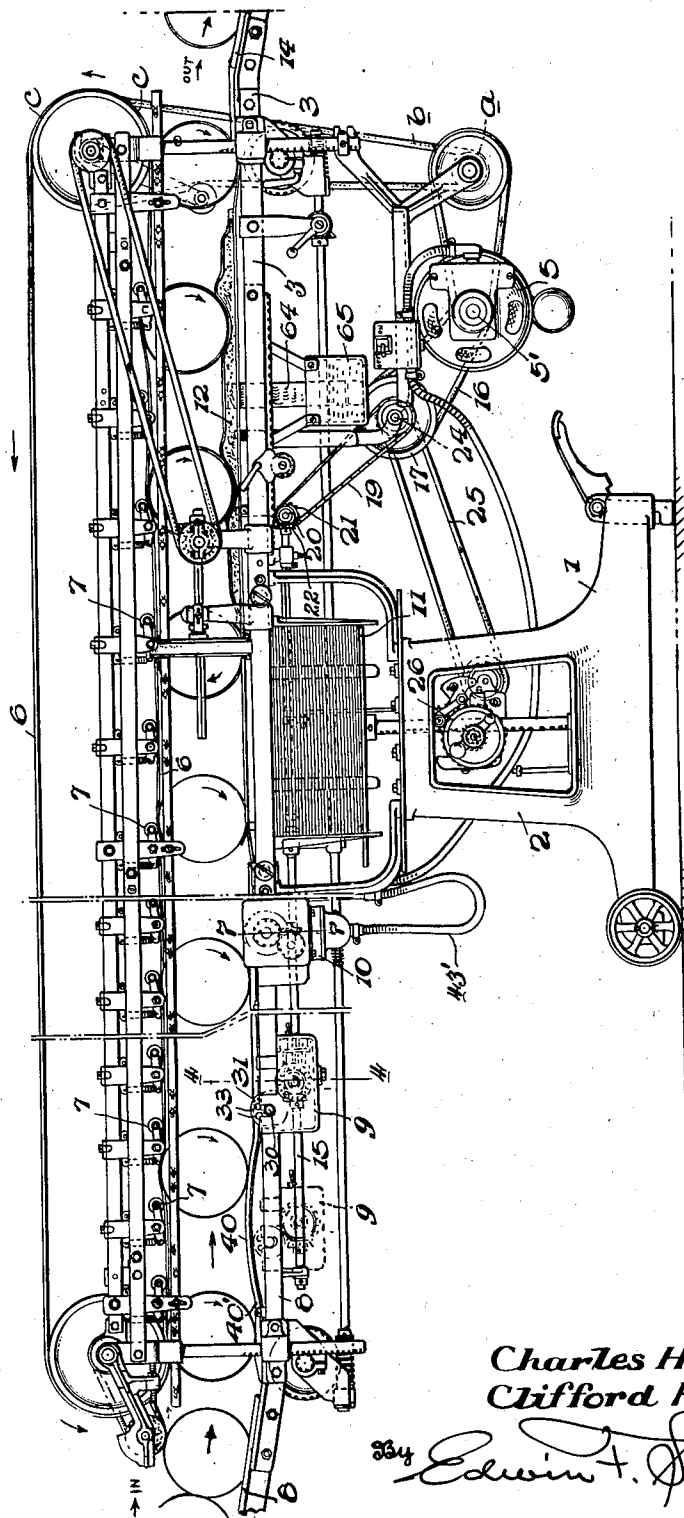
2,224,496

CAN LABELING MACHINE

Filed March 28, 1939

4 Sheets-Sheet 1

FIG. 1.



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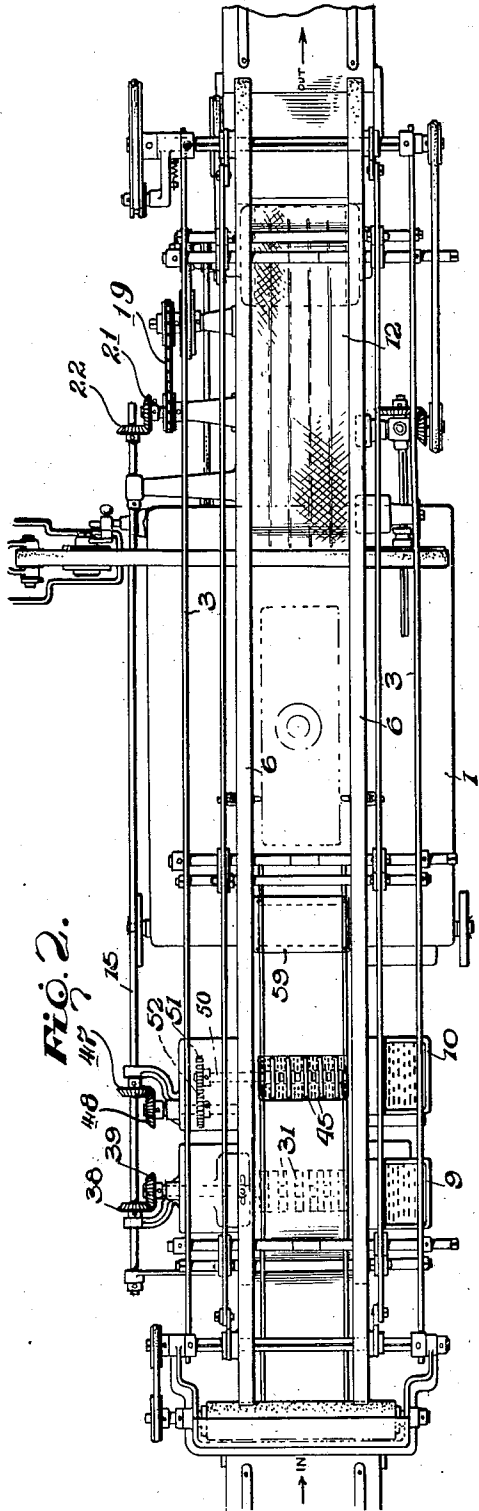
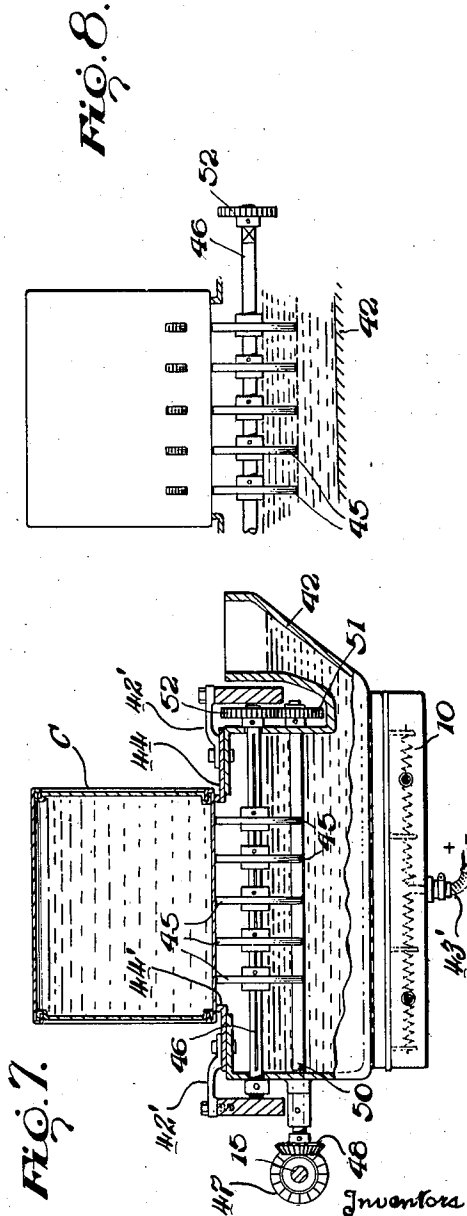
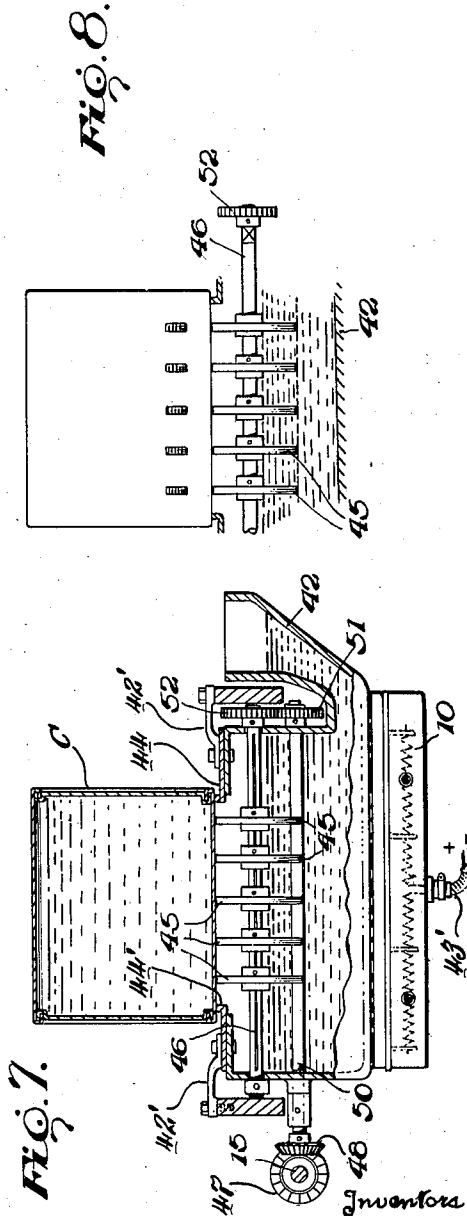
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4 Sheets-Sheet 2



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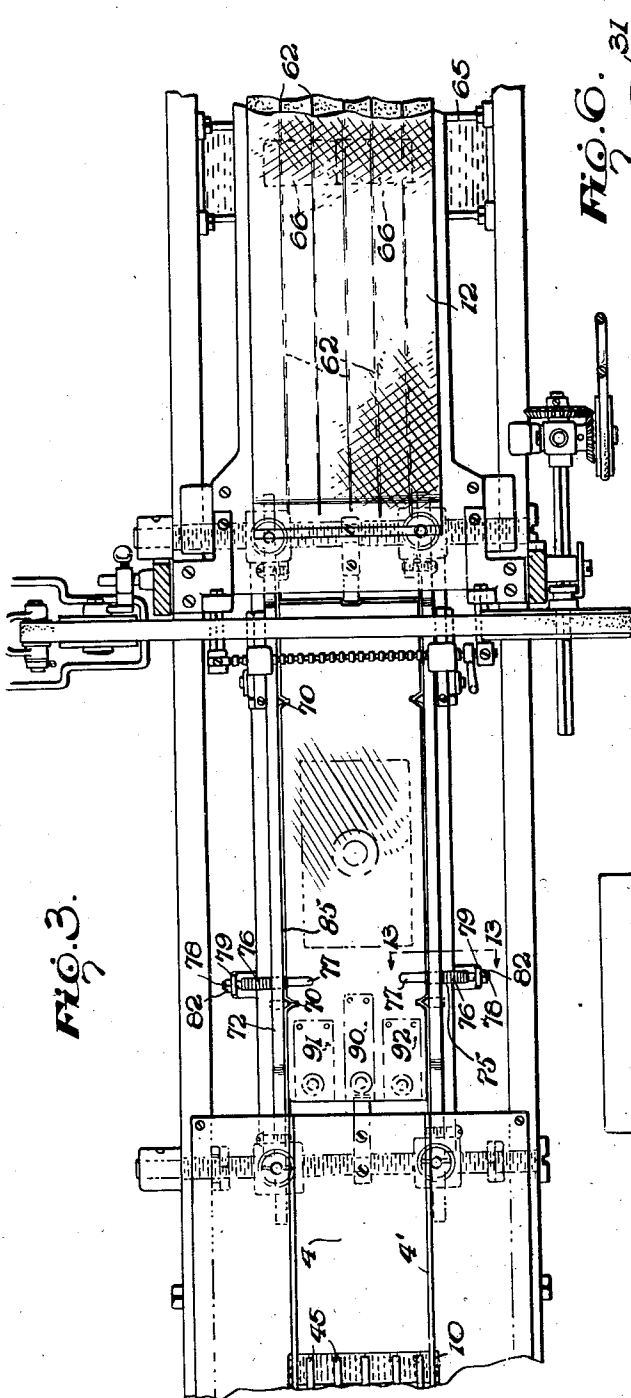
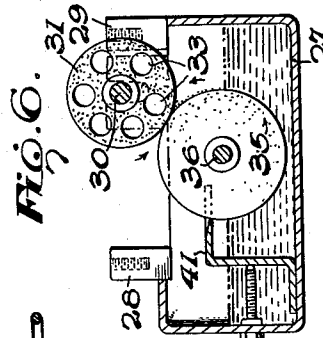
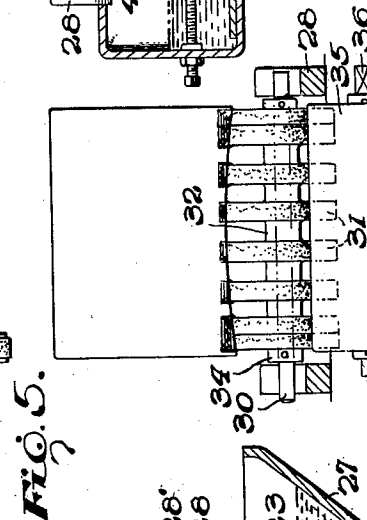
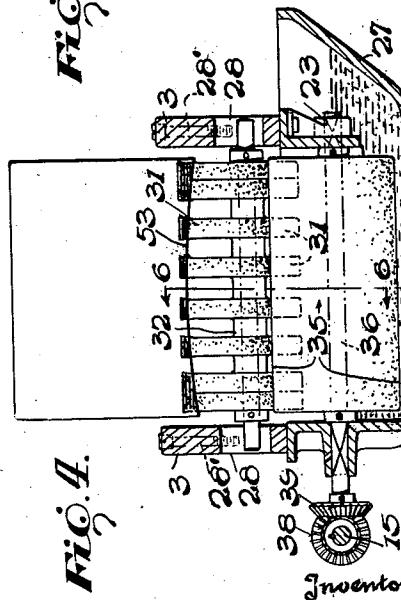
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CAN LABELING MACHINE
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2,224,496

4 Sheets-Sheet 3



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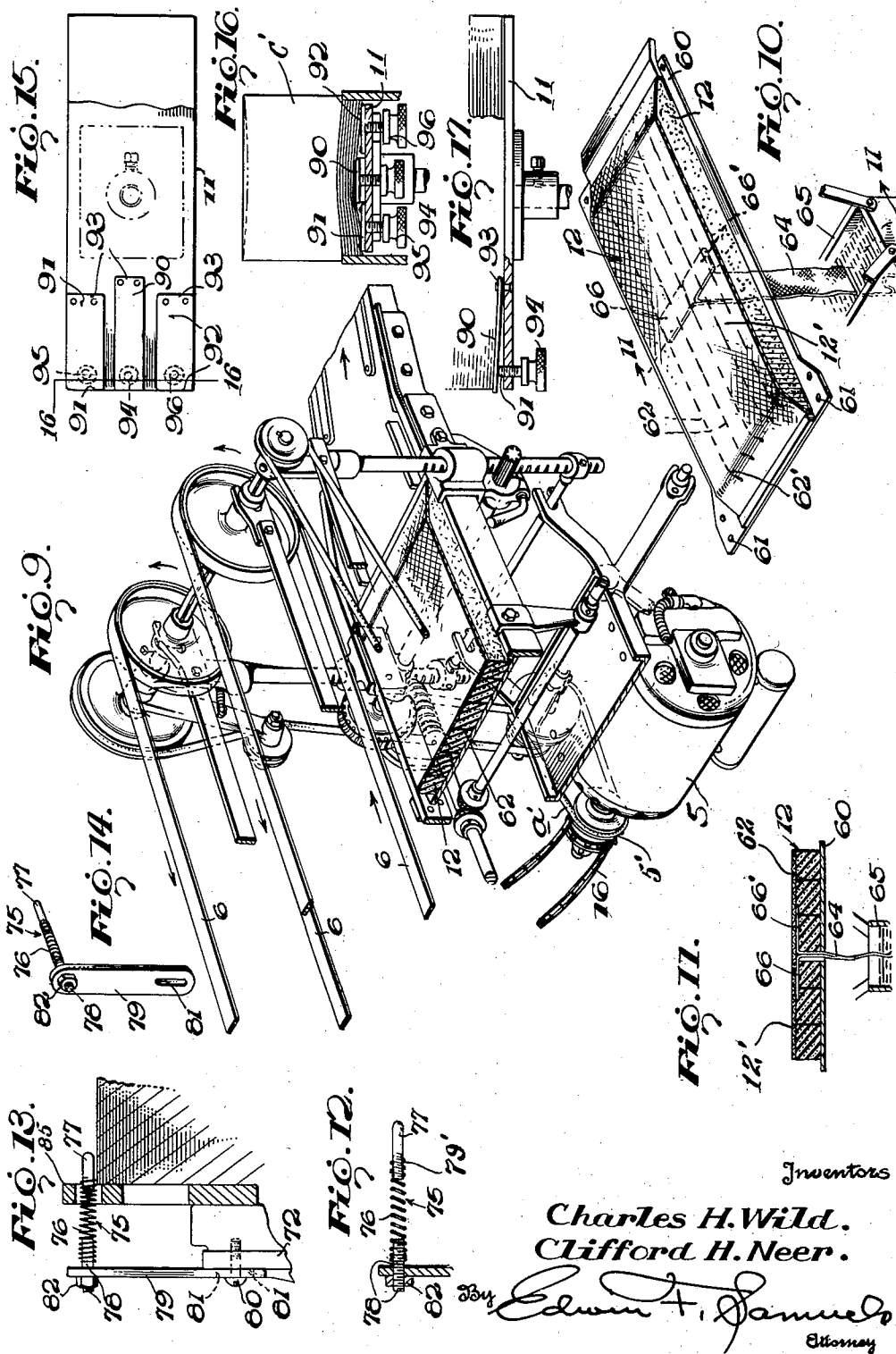
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CAN LABELING MACHINE

Filed March 28, 1939

4 Sheets-Sheet 4



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UNITED STATES PATENT OFFICE

2,224,496

CAN LABELING MACHINE

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Application March 28, 1939, Serial No. 264,516

21 Claims. (Cl. 216—58)

The invention relates to a machine for labeling cans and other cylindrical packages which are passed through the machine by rolling in a substantially horizontal direction, passing in turn over the adhesive applying mechanism for the label and over the label pack and then over the pressing mechanism. In this operation the adhesive is first applied to the cans or packages, the labels are then picked up in turn by the adhesive on the cans or packages, and rolled about the same, the lap ends of the labels are then secured by adhesive from another source, and the labels are finally pressed into close contact with the cans or packages which are thereafter delivered from the machine.

In accordance with the existing practice, cold adhesive or glue is preferred for use in affixing the labels in that it does not deteriorate during the period in which the contents of the cans will be retained therein as packed, i. e., during the life of the package but it is deficient in its adhesive qualities when wet and there is a tendency on the part of the label to slip as it is picked up. Hot adhesive, on the other hand, has been found particularly effective on account of its strong adhesive qualities which are effective at the time of application. Hot adhesive, however, tends to deteriorate and is not wholly satisfactory as a means for permanently affixing the labels on account of the relatively short duration of its effective life.

The present invention has particular advantages in the application of labels as to which for any reason it is found essential that slippage of the label when it is first picked up shall be prevented.

This prevention of slipping is particularly important in the labeling of cans of the bail type which have ears for holding the bails between which the label is located, so it is essential that it be accurately placed. The labels used with the bail type of can are generally short labels applied to one side only but there are other instances of not infrequent occurrence in which with cans not of the bail type using long or short labels where it is considered essential to avoid slippage. In some instances it is desirable in its contribution to prevention of wrinkling and in all instances where accurate placing of the label is desired the present invention is applicable.

In this connection, it may be noted that with the bail type of cans which are used for paint, shortening, motor oil, and various commodities which are retained in and used from the can, the labels are essentially placed between the

ears and there must be no slippage, which requirement has added a considerable percentage to the cost of labeling such cans in the past and has presented an almost insurmountable difficulty to the labeling of bail cans by machine in a satisfactory manner.

In accordance with the present invention, two glue pots or adhesive applying pots are used at the infeed end of the machine for spotting the cans to prepare them for picking up the labels, there being no difficulty on account of slippage at the lap end of the label. These two paste pots or adhesive applying elements are provided with means spaced transversely of the machine for spotting the adhesive on the cans as they roll over the respective adhesive applying units. In the practice of the present invention, one of these units supplies cold adhesive and the other is heated and supplies hot adhesive. Each of these units has an applying device which spaces the spots of adhesive on the can in a direction parallel to the axis and transverse to the feed, i. e., to the can feed, and while the two kinds of adhesive may be otherwise combined in the pickup operation, it is found most satisfactory to place the spotting devices of one adhesive applying unit in line with the spaces between the spotting devices of the other adhesive applying unit so that a single line of alternate spots of two kinds of adhesive is obtained.

Broadly considered the essential principle of this feature of the invention is that there are two pickup applying units and that one of the adhesives as applied by one of the units is of a permanent nature and that the adhesive applied by the other unit is an adhesive which is highly efficient in effecting immediately strong adhesion of the label to the can, overcoming the tendency to slip as the can rolls forwardly and the lap end of the label is curled and secured and the label is pressed in accordance with the well known practice.

The pickup spotting units are made adjustable along the machine and they are fitted with cover plates so that either unit may be used independently of the other and the spacing of the spots may be changed to suit conditions and if desired the application of the adhesive may be made continuous across the entire length of the can in the direction of its axis where but one kind of adhesive is to be used or a different arrangement of the two kinds of adhesive is desired.

Another difficulty encountered in labeling of cans is due to the fact that the majority of cans

containing perishable foodstuffs are vacuum packed and the walls being extremely thin tend to yield to the air pressure causing the cylindrical walls to become concave. These cans are known in the trade as panelled or indented cans and they present difficulties both in applying pickup adhesive and in the pressing of labels into close relation with the can to give satisfactory adhesion and a smooth labeling job.

To provide uniform application of pickup adhesive, the rollers by which the adhesive is applied are, in accordance with the preferred embodiment of the invention, made of highly resilient discs spaced apart to permit them to expand or yield separately to greater extent than a solid roller. In the preferred form shown, these discs are of soft rubber and they are to the best advantage provided with holes distributed about their area and extending through the discs parallel to the axis. The machine also provides means for conforming the pickup ends of the labels to the indented or panelled cans to give attachment to the can extending across the entire end of each label.

The invention also provides means for overcoming the difficulty incident to pressing the labels on panelled cans. For this latter purpose a highly resilient pad is placed in the path of the cans in the area travelled by the cans after the labels have been picked up and rolled about the cans in the position of the usual pressing pad. The pad of the present invention is of extremely resilient rubber preferably sponge rubber and is grooved or slitted to increase its yielding properties and its resiliency, which causes it to enter the indentations or panels described giving a satisfactory labeling jog on the panelled or collapsed can.

It has been found that all the various pressing pads used in the can labeling art, have a tendency to accumulate adhesive which becomes tacky or hard acquiring strong adhesive properties and this accumulated adhesive sticks to the labels and tends to displace them and remove them from the cans.

To overcome this difficulty, the invention provides means for maintaining the surface of the pad which contacts the can in a permanently moist condition which prevents the adhesive which may come in contact with the pad from adhering to the pad.

In the form of the invention shown, this moistening operation is accomplished by means of a wick which deposits water on the surface of the pad, the water is distributed by grooves or slits provided for this and other purposes already described and by the action of the cans over the entire surface of the pad so that it maintains a moist condition to the entire can contacting surface throughout the period of operation.

A still further additional feature of the invention relates to the label feed. The use of knife edges at the sides of the top label of the pad to retain the top label in position is a well known expedient practiced for many years. It has been found, however, that in numerous instances the top label is pierced by one or more of the knife edges and thus becomes released and displaced.

The object of this feature of the invention is to provide label holding means by which the top label is held securely till the can rolls over it and easily released as the can picks it up. This holding device has no tendency to pierce the edge of the top label or to release it unintentionally as

already pointed out and at the same time this new device releases the top label freely when picked up and drawn free of the pack by the can. The term can has been used for convenience to denote any package which can be labeled by the well known operation to which the features of this invention relates.

The machine of the invention is of the general type described in the patent to Charles H. Wild, No. 1,619,840 of March 8, 1927.

In the accompanying drawings, we have illustrated a can or similar labeling machine or so much thereof as is necessary to a full comprehension of the construction and operation of the features of the invention and this application to the machine to which the novel features of the invention in the preferred form have been applied for purposes of illustration.

In the drawings:

Fig. 1 is a side elevation of a labeling machine to which the invention is applied for purposes of illustration, the feed of the cans to said machine being from left to right.

Fig. 2 is a diagrammatic top plan view, showing the pickup paste spotting rollers, the top of the label pack, the top of the machine, including the feed belt and co-operating elements, including the various driving mechanisms, being removed for convenience of illustration, being non-essential to this invention.

Fig. 3 is a fragmentary top plan view of the portion of the machine containing the pressing pad and the label pack, drawn to a larger scale.

Fig. 4 is a section on the line 4 4 in Fig. 1 looking to the left and showing the cold adhesive unit including the pot and the applying rollers and an indented can in spotting relation thereto.

Fig. 5 is a view of the rollers removed, a can partly spotted with adhesive being shown in operative relation.

Fig. 6 is a section on the line 6 6 in Fig. 4.

Fig. 7 is a section on the line 7 7 in Fig. 1, looking to the left, showing the hot adhesive pot and the rollers therein and the drive gears, the cover being shown in broken lines.

Fig. 8 is a similar view showing the rollers removed from the pot and a can in spotting relation thereto.

Fig. 9 is a perspective view of the discharge end of the machine.

Fig. 10 is a perspective view of the pad removed showing a moisture applying device of the wick type in connection therewith.

Fig. 11 is a section on the line 11 11 in Fig. 10.

Fig. 12 is an enlarged detail view of the flexible label holding finger, in the nature of a section.

Fig. 13 is a view taken from the line 13 13 in Fig. 3, looking to the right toward the flexible finger which is indicated by reference character 75.

Fig. 14 is a perspective view of finger and bracket.

Fig. 15 is a fragmentary top plan of the label table showing the contour plate.

Fig. 16 is a section through the same looking to the left from line 16 16.

Fig. 17 is a side view partly in section of the label table shown in Figs. 15 and 16.

Referring to the drawings by numerals, each of which is used to indicate the same or similar parts in the different figures, the illustration Fig. 1 shows a can labeling machine, the illustration being to a large extent diagrammatic or distorted for the purpose of exposing portions of the mech-

anism which would otherwise be concealed and difficult to illustrate and understand. The machine as shown includes a base 1, having an upright 2, on which are supported the parallel side bars 3, carrying the ways and guides 4 and 4', which intervene between the operating units, i. e., the pickup adhesive units 9 and 10, the label pack and table 11, and the pressing pad 12, the labeling machine construction in general being well known.

The machine is driven by a motor 5, shown in Fig. 9 which by a series of pulleys drives the can belt 6, by which the cans are propelled along the machine as best shown in Fig. 3, the belt being held in contact with the cans by tension members 7, which is well known in the can labeling art.

Having reference to Fig. 1, the cans are fed to the machine down an inclined track 8, to the left in said figure, coming immediately in contact with the can belt 6, by which the cans are fed forwardly through the machine. Arranged along the path of the cans from left to right in Fig. 1, the drawing shows a cold adhesive applying unit 9 for adhesive of a permanent nature, a hot adhesive applying unit 10 for a quick attaching adhesive, a label table 11, and pressing pad 12. At the end of the machine at the right in Fig. 1, is a discharge chute 14. The adhesive applying mechanism in both the units 9 and 10 is driven from a shaft 15, which is driven from the motor 5. To this end the motor shaft is provided with a pulley 5' which drives a chain 16 which engages a sprocket 17 which, in turn, carries or drives a sprocket 18, which, in turn, drives a chain 19, which, in turn, drives a pulley or sprocket 20, which carries a bevelled gear 21, which, in turn, drives a bevelled gear 22 on the shaft 15. The pulley or sprocket 17 also carries a sprocket 24 which drives a chain 25, which operates the label feed, automatically raising the table 11 with a step by step motion, said automatic feed which may be of any well known type being indicated by reference character 26, a detailed description of this mechanism which belongs to a well known class of mechanisms in this art and which does not relate to the present invention is believed to be unnecessary.

The feed belt 6 is driven from motor 5, see Figs. 1 and 9, by chains or belts *a*, *b*, *c* on suitable sprockets or pulleys *a'*, *b'*, *c'*.

The pickup adhesive applying units are essentially adjustable in the direction of the length of the machine and the position Fig. 1 is indefinite and changeable to meet various conditions as hereinafter described.

The cold adhesive applying unit is shown in detail in Figs. 4, 5 and 6. It comprises an adhesive pot 27 secured to and beneath the side bars 3 in any suitable manner as by means of ears 28 on the pot secured to the side bars in any suitable manner in a series of positions. The adhesive pot 27 also carries at its sides brackets 29 providing bearings for the shaft 30 which carries an adhesive applying agent which for convenience will be termed a roller, which is shown in the form of the invention illustrated, as consisting of a series of soft rubber discs 31. The discs are spaced by a preferred distance by means of collars 32 on said shaft 30; an indefinite number of discs is supplied. If desired, the collars may be omitted forming a solid roller. This may be used in the absence of the hot adhesive applying unit, i. e., when the same is rendered inoperative by placing a cover 59 over it, as here-

inafter described. The spaced discs may be used even under these circumstances if desired and the two kinds of pickup adhesives may be otherwise combined than by spaced, staggered discs. The discs are preferably made of soft highly resilient material, soft rubber being at the present considered the best material. To make them more resilient, as shown in Fig. 6, they may be apertured at 33, any suitable arrangement of apertures being contemplated.

The discs are held in position on the shaft by nuts 34 or in any suitable manner. Adhesive is applied to the discs 31 on shaft 30 or whatever arrangement may be provided by means of a transfer roller 35, mounted on a shaft 36, which extends through the walls of the adhesive pot 27 on one side as illustrated and is mounted in suitable journal bearings 23 at the other end of said shaft 36, said shaft bearings being supported therein in accordance with the usual practice. The coating of adhesive on the transfer roller 35 is maintained uniform and of a minimum thickness by means of a scraper 41 of a type well known in the art.

In the form of the invention shown, the transfer roller 35 is driven and it not only applies the adhesive to the discs 31 but drives the adhesive roller or discs 31'. The shaft 36 carrying the transfer roller 35 is driven by a bevelled gear 38 splined to and sliding on and driven by the shaft 15 which drives bevelled gear 39 on the shaft 36. Gears 38 and 39 are connected together by a suitable bracket and gear 38 may be slid along the shaft 15 when the adhesive unit is moved, the unit 9 being adjustably secured to the side bars 3 in various positions of adjustment in any suitable manner as by screws 28', Fig. 4. Fig. 1 shows a cover plate 40 beneath which the cold adhesive pot 27 may be located when the hot adhesive only is to be used. The plate 40 is removably secured to side bars 3 by means of screws 40' or in any suitable manner.

The provision of spaced resilient rubber or equally resilient rollers in the manner described is particularly important not only in that it provides for alternate spotting of hot and cold or other quick and permanent adhesives in the manner outlined in the preamble but these rollers being highly resilient conform to the surface of the panelled cans spotting the adhesive with the desired degree of uniformity without regard to the shape which the cans may assume.

In accordance with the practice which has been followed, the spots of adhesive formed by the cold adhesive applying unit may be from an inch to an inch and a quarter or even an inch and a half in length, the exact size of the spots not being material.

Referring now to Figs. 7 and 8, which may be considered in connection with Fig. 3 and other figures as Figs. 1 and 2. The hot adhesive applying unit 10 comprises an adhesive pot 42 for hot adhesive both kinds of adhesive being supplied under different brands. The pot is in practice provided with a heating unit 43, indicated in Fig. 7 and Fig. 1, as supplied with current by way of a cable 43'. The hot adhesive pot 42 is supplied with a top wall 44 which is open at 44' at the center through which opening the adhesive applying means shown in the form of discs 45 are exposed for contact with the cans. These discs 45 may be of metal or any suitable material and they are mounted on a shaft 46 which extends across the pot having bearings in the walls of the same. The discs 45 dip in the adhesive therein

which adhesive being heated is kept in a liquid condition and can be handled in this way. The shaft 46 is driven by bevel gears 47 and 48, see Fig. 7, the gear 47 being on the shaft 15. The adhesive pot 42 is adjustable longitudinally of the machine. For this purpose, the driving gears 47 and 48 as well as the gears 38 and 39 are connected by a suitable bracket 47'. The gear 47 is slidable along the shaft 15 and both gears move adjustably with pot 42. The adhesive pot 42 has brackets 42' whereby it is adjustably supported on the side bars 3.

At this point it may be noted that the shaft 46 is not driven directly from the gears 47 and 48. The latter gear is mounted on a second shaft 50 which carries a gear 51, which drives a gear 52 on the disc driving shaft 46.

The machine also includes a removable cover plate 59, which may be secured to the side guide 4 in any suitable manner. This plate shields the adhesive from any droppings of dirt and the like when the hot adhesive unit is not in use and carries the cans over this pot without contact with the adhesive applying discs under the same circumstances.

It is of advantage in applying the pickup adhesives of two kinds in the manner above described that the hot adhesive applying discs 45 are spaced along the shaft 46 and are placed opposite, i. e., in line with the spaces 53, see Fig. 4, between the discs 31 of the cold adhesive unit. In this way alternating spots in the same line are provided by the co-operative action of the two adhesive units. To this end it may be noted that for convenience in illustration, the machine in Fig. 3 has been broken away between the adhesive units, also between the adhesive unit 10 and the label table 11, making the relation of the two pickup applying units and the label pack indefinite. In the operation of the machine, due to the rolling of the cans along the ways passing them through the machine, it is desirable in order to bring the two sets of adhesive spots substantially in line that the adhesive units 9 and 10 be spaced by a distance which is approximately the circumference of the cans being labeled, and further that the adhesive unit 10 be spaced from the adjacent or infeed end of the label pack or from the point on the top label to be engaged by the spotted area of the can by a similar distance. Thus in rolling through the machine a can first encounters the cold adhesive applying unit and when it has made a complete revolution it encounters the hot adhesive applying unit forming at the first unit a line or a series of cold adhesive spots and at the second unit a line or a series of hot adhesive spots which are located in the spaces in the line of cold spots obtained in the first unit. On a still further revolution these spots come in contact with the end portion of the top label whereby the can picks up and carries it forward rolling it about the can.

When the can having a label wound around it in this way and secured as to its pickup end by means of adhesive obtained from the units 9 and 10, or from one of them as may be elected, it rolls forwardly and comes in contact with or rolls over the pressing pad 12. This pad is an important feature of the present invention either separately from or combined with the features described, particularly the flexible discs for applying adhesive. The pad is shown in plan in Fig. 3, and in perspective and in section in Fig. 9. In Fig. 10 it is shown in perspective, and as cut away on a

transverse plane in Fig. 11 being shown in section on the line 11-11 in Fig. 10.

The pressing pad 12 is mounted on a suitable support 60 which is adapted to be secured to and between the side frames in any suitable manner, ears 61 with suitable perforations being shown in Fig. 10 for this purpose. The pad in the preferred form of the invention is composed of sponge rubber and is slitted or grooved longitudinally or in accordance with any desired pattern, the slits or grooves being shown at 62 in Figs. 10 and 11 and also in Fig. 9, the pad grooved or slitted in this way comprises strips of sponge rubber or similar material which are highly resilient and yield to the best advantage conforming in all instances to the contour of the surfaces of the panelled or indented cans and likewise conforming to the surface of any can which it may be desired to label.

A further important feature of the invention 20 as to the pad resides in means for maintaining a continued supply of moisture to the surface of the pad during the operation of the machine whereby accumulations and hardening or partial hardening and consequent tackiness of any adhesive which may come in contact with the pad is prevented, the presence of the moisture in fact practically prevents the adhesive from becoming attached to the pad, thus overcoming an important difficulty due to the accumulation and 30 drying of adhesive on the pad which causes the labels to adhere to the pad and pull off from the can.

The means for supplying moisture to the surface of the pad in the present machine has taken 35 the form of a wick or wicks 64 which dip at their lower ends into a reservoir 65 and are passed upwardly through a suitable aperture in the center of the pad which is shown as of double thickness and is split at the top into two arms or bands shown as projecting laterally along the top surface of the pad, said arms or bands being indicated by reference characters 66 66'. Any suitable means for maintaining a full supply of water to the surface of the pad may be used. A gauze casing 12' may be employed to distribute the water. 45

It is of particular importance in connection with supplying moisture to the pad that it serves to wet the label on the side opposite the adhesive 50 whereby both sides of the label are uniformly moistened, and dry with substantial uniformity preventing curling.

The flexible rollers for pickup adhesive and the highly resilient pad have particular application to the affixing of labels to indented or collapsed or concave cans. A further provision of the invention having particular application to the labeling of such cans resides in means for causing the pickup ends of the labels in the pack to conform to the contour of the cans which are thus indented whereby close adhesion of the labels at this point is attained, it being understood that great difficulty has been encountered at this point in the operation of labeling such 65 cans on account of the concavity of the cans and the failure of the labels to contact at the transverse centers of their pickup ends and the consequent failure of the labels to closely adhere at their pickup ends so that the machine labeling 70 of such cans has not been satisfactory.

For this purpose comparatively thin packs of labels which may be about two inches in thickness are generally used.

In Fig. 3 we have shown in plan, and in Figs. 75

15, 16, and 17, we have shown in detail, in plan, end elevation, and side elevation respectively a label table equipped with a vertically adjustable center plate 90 which is a novel feature of the present invention. The plates 90, plates 91, 92 not being part of the invention, are of thin metal, preferably about forty one-thousandths of an inch thick, and they are riveted to the table at their rear ends at 93. The front ends of these plates, i. e., the ends adjacent the infeed end of the machine are supported by set screws or thumb screws 94, 95 and 96 respectively, which are threaded upwardly through table 11.

The center plate 90 is shown in Fig. 16 as adjusted upwardly to a satisfactory operative position for the indented can c' which is shown rolling over the pack. This adjustment causes the labels, including the top label, to bend upwardly at the transverse center of the pick up end and by proper adjustment of set screw 94 conformation of the pickup ends of the labels to the contour of the cans being labeled is attained. Plates 91 and 92 may be adjusted to give a different contour to the labels.

Fig. 3 shows the label pack in top plan and in connection therewith it shows the knives 70 in the usual form in which they have become a fixture in this art. Difficulty has been encountered with these knives because of their tendency at times to cut through the top labels of the pack, and when thus cut, the labels are released and become displaced and are irregularly affixed on the cans, giving a defective labeling operation.

In accordance with the present invention, the knives have been supplemented by fingers 77, these fingers are shown in detail in Figs. 12 and 13, being supported, in the form of the invention shown, on the label guide plate 72 or any suitable support at the sides of the label pack.

The resilient finger assemblies 75, in the form shown, are provided with helical springs 76, and comprise rounded fingers or finger ends 77, the springs being supported by studs 78. The stud 78 is threaded at its outer end. This end is threadedly engaged in the spring 76, and the finger ends 77 are likewise threaded as to their shanks at 79' and the threaded portion is threadedly engaged within the spring at the outer end of the latter. The finger assemblies 75 are secured to upright brackets there being two of these fingers, in the form of the machine shown, one adjacent each front knife, i. e., corresponding to the corner portions of the top label. Each said bracket is indicated by reference character 79, the brackets are secured to the label guide casing 72 by means of screws 80, each of which engages a slot 81 in the plate or bracket 79, thus providing for vertical adjustment of the brackets and the fingers 75 in accordance with the height of the label pack. Each finger 75 is secured to its bracket 79 in a suitable manner as threading the stud 78 through the bracket and securing it by means of a lock nut 82, and the fingers extend through suitable holes in label pack guide plates 85.

The flexible fingers 75 overlying the top label of the pack provide a yielding engagement which holds the label and prevents the release of the same when it is cut by the knife and yields freely upwardly when the label is withdrawn by the can in the pickup operation. It will be understood that any suitable type of flexible finger may be substituted for the form shown though the details described and illustrated are of importance

as defining a highly satisfactory type of finger for this purpose.

The operation of the machine has been fully described in the preamble and in the description of the drawings.

The words can and cylindrical package, as used herein are applied alternatively and without distinction to cans or other packages capable of being advanced by rolling, thus passing in operative relation with the various elements of the machine.

We have thus described a machine embodying the invention in the preferred form, the description being specific and in detail in order that the manner of constructing, applying, operating and using the invention may be fully understood, however, while the preferred form has been described specifically and in detail, numerous variations and changes of design are contemplated within the spirit of this disclosure and the specific terms herein are used in a descriptive rather than in a limiting sense, the scope of the invention being defined in the claims.

What we claim as new and desire to secure by Letters Patent is:

1. In a machine for labeling cylindrical packages, the same being of the type in which the packages are passed through the machine by rolling along a predetermined path, and which machine is provided with a support for a label pack in pick up relation to said path, means in the path of the packages and beneath the same in advance of said label support comprising a hot adhesive applying unit and a cold adhesive applying unit, spaced means in each unit the means in the respective units being staggered for applying adhesive from said units to the passing packages providing alternate areas of hot and cold adhesive arranged along the can or package in parallelism with the axis.

2. In a can labeling machine, the combination of hot and cold adhesive applying units, said adhesive applying units having paste applying rollers each comprising a series of spaced discs, the discs in the respective units being spaced and alternately placed whereby they are adapted to apply to each package alternate spots of the hot and cold adhesive.

3. In a machine for labeling cylindrical packages, the machine being of the type in which the packages are rolled through the machine on a predetermined path, and in which there is a label support in operative relation to said path, two pickup adhesive spotting units in the path of the packages, and in advance of said label pack, the adhesive spotting units being adapted to apply respectively a permanent and a quick acting adhesive one said unit having means for retaining and applying a slow setting permanent adhesive and the other said unit having means for retaining and applying a quick acting adhesive.

4. In a can labeling machine for cylindrical cans to be fed by rolling and adapted to label collapsed and indented cans, a roller for applying pickup adhesive to the cans, the same consisting of a plurality of resilient discs and means for securing the same in spaced relation on the roller shaft.

5. In a can labeling machine for cylindrical cans to be fed by rolling and adapted to label collapsed and indented cans, a roller for applying pickup adhesive, the same consisting of resilient discs and means for securing the same in spaced relation on the adhesive applying roller shaft,

said resilient discs being apertured to give them the maximum of resiliency.

6. In a can labeling machine of the type in which the cans are rolled through the machine over the labels, a roller for applying pickup adhesive; the said roller consisting of a plurality of resilient discs and a support therefor and means for securing the same in spaced relation on the support, said resilient discs being apertured to give them the maximum of resiliency, the same being in combination with a soft rubber pad comprised of strips of this material.

7. In a machine for labeling cans, in which the cans are rolled through the machine, a label pressing pad in the path of the cans beyond the point of label application, the pad being composed of sponge rubber having the surface in a plurality of separate sections to give increased yielding and resilient properties.

8. In a machine of the can rolling pickup type for labeling cans, in which there is a support for a label pack, a pressing pad of rubber like material, beyond the label pack, and means for supplying moisture to the surface of the pad continuously in the operation of the machine to prevent the accumulation of adhesive thereon and serving to wet the label on the side opposite the adhesive.

9. In a machine of the can rolling pickup type for labeling cans, in which there is a support for a label pack, a label pressing pad beyond the label pack the same having a wick with a source of moisture connected to the wick, the wick being connected oppositely to said source to the upper surface of the pad, for supplying moisture to the surface of the pad continuously in the operation of the machine.

10. In a can labeling machine of the can rolling pickup type, in which there is a support for a label pack in the path of the cans, a label pressing pad in the path of the cans beyond the label pack, and means for continually moistening the surface of the pad throughout the operation of the machine.

11. In a can labeling machine of the can rolling label pickup type described, in which there is a support for a label pack in the path of the cans, of a pickup paste applying roller composed of soft yielding resilient material adapted to conform to the surfaces of irregularly shaped and non-cylindrical cans.

12. In a can labeling machine of the can rolling label pickup type, the same having a support for presenting labels, a label pressing pad, beyond the point of presentation of the labels and means for continually moistening the surface of the pad throughout the operation.

13. A label table for a can labeling machine of the can rolling label pickup type, means for holding the labels in position on this table comprising resiliently mounted fingers and means whereby said fingers are supported above the table at the sides of the same and adapted to extend over the top label of the pack near the front end of the table.

14. A label table for a machine for labeling cans, the same being of the can rolling label pickup type, and means for holding the labels in position on the table comprising resilient fingers and means whereby said fingers are supported at the sides of the table and spaced above the same and adapted to extend over the top label of the pack, said fingers each comprising spring means and a finger end supported on one end

of the spring and a stud supporting the other end of the spring.

15. A label table for a machine for labeling cans, the machine being of the type in which the cans are presented by rolling through the machine and over a label pack on the table, said table having means for holding the labels in position on this table comprising flexible fingers and means whereby said fingers are supported at the sides of the table and spaced above the same, said fingers being adapted to extend over the top label of the pack, said fingers each comprising a spring, and a finger end supported on one end of the spring and means supporting the other end of the spring, the finger end being threaded into the spring the intermediate portions of the spring being free to flex whereby it yields upwardly as new labels are inserted in the pack and follows the top label downwardly as the labels are withdrawn.

16. In a label table for a machine for labeling cans, the said machine being of the can rolling, label pickup type flexible fingers, means whereby said fingers are supported at the sides of the label pack and spaced above the table and adapted to extend over the top label of the pack, each of said fingers comprising a spring, and stationary means supporting the other end of the spring, the finger being threaded into one end of the spring, and the stud being threaded into the other end of the spring.

17. The method of labeling cylindrical packages which consists in rolling them along a predetermined path, presenting a quick acting and a permanent adhesive to said cans, partially coating a pickup area of each said package with each said adhesive and presenting a label pack in the path of said packages beyond the point of coating with said adhesive and in pickup relation to the path of the package.

18. The method of labeling cylindrical packages which are rolled in pickup relation with a label pack which comprises applying a pickup area of quick adhesive and an adjacent pickup area of permanent adhesive.

19. In a machine for labeling cylindrical packages of the type in which the cans are rolled through the machine and there is a support for a label pack in the path of the packages, two pickup adhesive applying units in the path of the packages at the front end of the machine, the adhesive applying units being adapted to apply respectively a hot and a cold adhesive and being mounted for adjustment in the direction of the length of the runway and means operable at the will of the operator for covering each pickup adhesive unit rendering it inoperative whereby either unit may be employed to the exclusion of the other.

20. In a machine for labeling cylindrical cans or packages, the same being of the type in which the cans are advanced by rolling and in which there is a label support for a pack of labels in the path of the cans, pickup adhesive applying means at the front end of the runway adapted to apply adhesive to indented cans, the label table having at its pickup end, near the lateral center, adjustable means for elevating the lateral centers of the pickup ends of the labels and means for completing the attachment of the labels to the cans.

21. In a machine for labeling cylindrical packages, the same being of the type in which the packages are advanced by rolling and in which

there is a support for labels in the path of the packages, two pickup adhesive applying units in the path of the packages at the front end of the machine, the adhesive applying units being adapted to apply respectively a hot and a cold adhesive and being mounted for adjustment in the direction of the length of the runway and means op-

erable at the will of the operator for rendering each of the adhesive applying units inoperative whereby either unit may be employed to the exclusion of the other.

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