

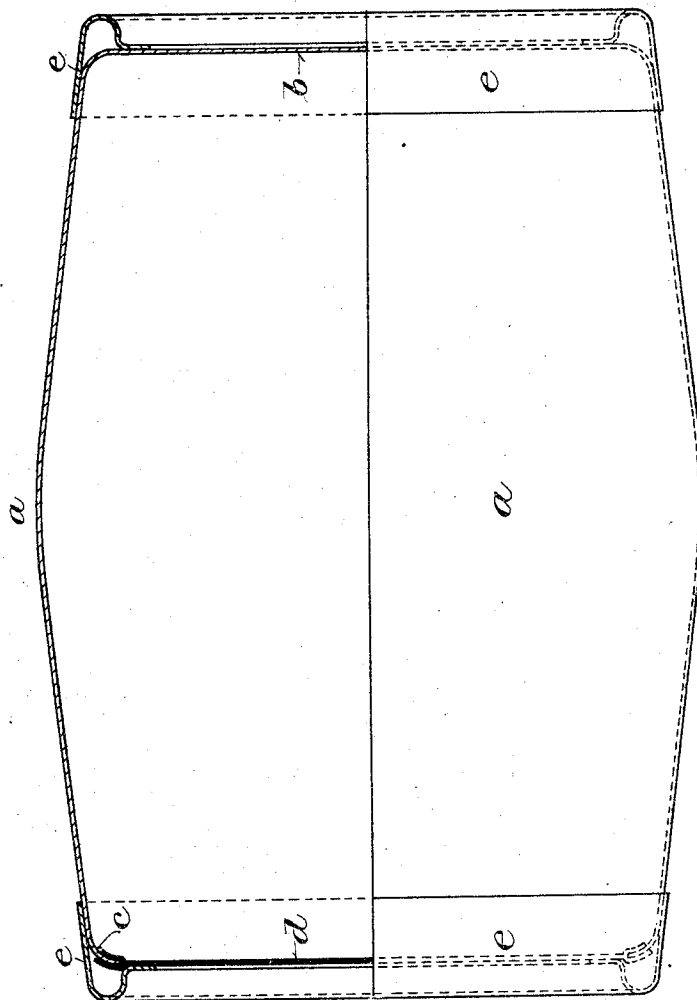
No. 793,579.

PATENTED JUNE 27, 1905.

R. H. HACKNEY.

METAL BARREL.

APPLICATION FILED SEPT. 18, 1902.



Witnesses:

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UNITED STATES PATENT OFFICE.

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PRESSED STEEL TANK COMPANY, OF MILWAUKEE, WISCONSIN,
A CORPORATION OF WISCONSIN.

METAL BARREL.

SPECIFICATION forming part of Letters Patent No. 793,579, dated June 27, 1905.

Application filed September 18, 1902. Serial No. 123,872.

To all whom it may concern:

Be it known that I, ROBERT H. HACKNEY, a citizen of the United States, residing at Milwaukee, in the county of Milwaukee and State of Wisconsin, have invented certain new and useful Improvements in Metal Barrels, of which the following is a specification, reference being had to the accompanying drawing, forming a part thereof.

The object of this invention is to produce a light, strong, and durable metallic barrel or keg with a smooth interior that will not catch and hold sediment and that can be easily and thoroughly cleaned.

The invention consists in certain novel features of construction and in the arrangement and combinations of parts hereinafter particularly set forth and claimed.

The accompanying drawing shows, partly in side elevation and partly in central longitudinal section, a barrel embodying the aforesaid invention.

The body *a* of the barrel, formed by dies or other suitable means integrally with one of the heads *b* without seam or joint from a single blank or steel plate, is primarily made cylindrical. The proper taper to produce the bilge is given by suitable dies to that part of the body next to the closed end or head, while the other part of the body next to the open end remains cylindrical and of a diameter equal to the diameter of the barrel at the bilge. The metal of the body is then compressed or drawn in gradually by means of suitable dies from the center toward the open end to produce a taper corresponding with that from the center toward the head *b*, and thus complete the bilge. The edge of the body next to its open end is then preferably bent or flanged inward, as shown at *c*, for the attachment thereto of the separately-formed head *d*. The bilge or the required taper therefor in *e* of the body may, however, be produced by spinning or rolling.

The foregoing operations, performed in the order above mentioned substantially as explained, admit of forming the body with a bilge at or near the middle and a head at one end in one piece, without seams, joints, or cor-

rugations. The head *d* is preferably forged at its periphery with a groove or fold in which the inturned edge *c* of the body is inserted and secured. The groove in the head *d* is primarily made or left sufficiently open to receive the inturned edge *c* of the body. The head is then placed in a cup-shaped or other suitable contracting-die, and the open end of the body is forced into this die, which turns the edge of the body into the groove in the head, closing the groove at the same time.

To reinforce the barrel at the ends, to cover and protect the joint between the body and head *d*, and to avoid internal grooves or pockets which catch and retain sediment and dirt, the barrel is provided with annular bands *ee*, which are preferably drawn, pressed, or otherwise formed from sheet metal, to fit over the ends of the body and to project therefrom beyond the heads, against which they have an inturned bearing. The parts of these bands projecting beyond the heads of the barrel form annular rims or flanges corresponding with and serving the purpose of the chimes of ordinary wooden barrels.

By the construction herein shown and described a very strong, light, and durable receptacle is produced, suitable for all the purposes for which ordinary barrels are made and used.

The barrel may be provided with metal bung-bushings like or similar to those used in wooden barrels, and, if desired, the body may be further reinforced and protected by bands applied thereto between the end bands or chime-pieces *e*.

One great advantage of the construction herein shown and described is that it presents a smooth surface inside of the barrel, and thereby avoids catching and retaining sediment and dirt and facilitates cleaning.

Various modifications in minor details of construction may be made within the principle and intended scope of the invention.

I claim—

1. A barrel having a seamless wrought-metal body with a bilge and a head formed in one piece without seam, joint or corrugation, and a separately-formed metallic head joined to an

inturned edge of the body at the end opposite the integral head, substantially as described.

2. A barrel comprising a seamless wrought-metal body formed in one piece with a bilge and with an inturned edge at one end, and a metallic head having a groove in its periphery in which the inturned edge of the body is inserted and secured, substantially as described.

3. A barrel having a seamless wrought-metal body formed in one piece with a bilge, metallic heads and separately-formed metallic chimes overlapping the body at the ends and projecting parallel with the body beyond the heads against which they are bent back, the ends of the body being turned inwardly across the internal recesses in the chimes to meet the

heads and close said recesses, substantially as described.

4. A barrel having a seamless wrought-metal body formed in one piece with a bilge and with an inturned edge at one end, a metallic head joined to the inturned edge of the body and a metallic chime secured to the head and body over the joint between them, substantially as described.

In witness whereof I hereto affix my signature in presence of two witnesses.

ROBERT H. HACKNEY.

Witnesses:

CHAS. L. GOSS,
ALICE E. GOSS.