

G. W. Bentley,

Metal Box.

N^o 47,676.

Patented May 9, 1865.

Fig. 3.



Fig. 2.

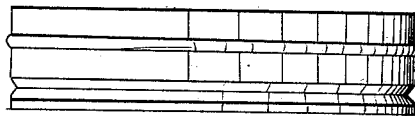
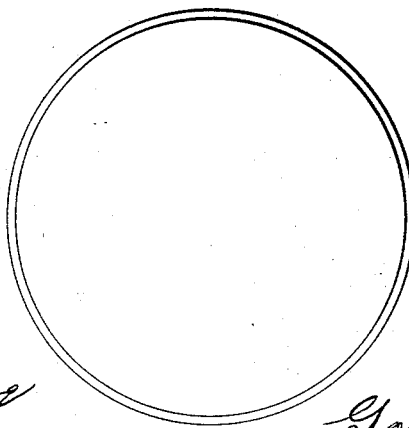


Fig. 1.



Witnesses:
Geo. H. Redding
Edward Line

Inventor:
Gorey W. Bentley

UNITED STATES PATENT OFFICE.

GEORGE W. BENTLEY, OF NEW YORK, N. Y., ASSIGNOR TO HIMSELF, AND
CHAS. S. HINE, OF SAME PLACE.

IMPROVEMENT IN THE MANUFACTURE OF BLACKING-BOXES.

Specification forming part of Letters Patent No. 47,676, dated May 9, 1865.

To all whom it may concern:

Be it known that I, GEORGE W. BENTLEY, of the city, county, and State of New York, have invented, made, and applied to use certain new and useful improvements in the manufacture of boxes and other cases composed of tin or other sheet metal, with heads of wood or other suitable material, for the purpose of filling with blacking or other oily or semi-fluid substances that require boxes for packing; and I do declare the following to be a full, clear, and correct description of the same, reference being had to the accompanying drawings, making part of this specification, and to the letters of reference marked thereon, in which—

Figure 1 is a top view of the box, showing the head with the marginal rim of metal securing the head in position. Fig. 2, a section of the box without the cover, showing its exterior form, and the head of wood or other suitable material; Fig. 3, a section of the cover, showing its exterior form.

The nature of my invention consists, (a,) in turning in at a true right angle, all round, a portion of the hoop or soldered strip, to form a seat or shoulder to receive the head, of wood or other suitable material, when inserted from the inside; (b,) in inserting the head, of wood or other suitable material, within the hoop or soldered strip, and creasing the strip of metal, for the purpose of holding the head in position; (c,) in the production of a new and improved article of manufacture in a box or case, made substantially as hereinafter described.

To enable those skilled in the art to make and use my invention, I will proceed to describe the same.

I cut out strips of tin, or other sheet metal, of the exact length and breadth for the size and form of the box to be made, and run them through a "beading-machine," by which they are rolled into hoop form, and at the same time a bead or stop is formed for the cover when put on the box. The strips now have their ends accurately joined by solder or otherwise. One of the hoops or soldered strips is now placed in a machine constructed for the purpose, (for which I have applied for Letters Patent,) and by its operation a certain

portion of the metal is turned in all round in a true right angle to form a seat or shoulder to receive the head, of wood or other suitable material. The hoop or soldered strip is now removed from the machine, and the head, of wood or other suitable material, is inserted from the inside of the hoop or soldered strip. The changes having been made in the machine, as indicated in the specification descriptive of the same, the box thus far formed is placed upon the machine, by which a crease is made upon the box or metallic portion of the same, by means of which the head, of wood or other suitable material, is firmly held in place, and a perfect and secure joint is made between the metal and the head, of wood or other suitable material. The cover of the box or case is formed in precisely the same way, the stop alone excepted, as the cover, when placed upon the box, rests against that.

Boxes or cases thus made possess the following advantages: The heads are held in more firmly and provided with a better joint than by any other process, the boxes are more uniform in thickness and size than those made by other modes of manufacture, and will therefore pack in quantities more compactly and safely for transportation than those less perfect in these respects, and any inequalities in the thickness of the head of wood are thrown upon the inside of the box, thus allowing the box to set perfectly level when being filled, which is advantageous.

Other forms and sizes of boxes and cases for packing larger quantities and other substances of similar qualities can be made by the process just described.

I am fully aware of the patent granted Horace Thayer, and am also aware that my present invention differs, essentially, from that patented by him, as fully shown in the specification descriptive of my improved machine for this purpose.

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

1. In the manufacture of boxes or cases formed of tin or sheet metal with heads of wood or other suitable material, turning in at a right angle, all round, a portion of the metal

to form a seat or shoulder for the end, of wood or other suitable material, inserted within the metal after said seat or shoulder has been formed.

2. Inserting the heads, of wood or other suitable material, within the strips of metal previously soldered, and provided with the

seats, as shown, and creasing the metal, for the purposes described.

GEORGE W. BENTLEY.

Witnesses:

GEO. H. REDDING,
EDWARD HINE.