

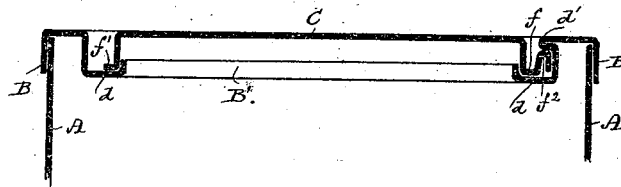
(No Model.)

F. A. WALSH.  
SHEET METAL VESSEL.

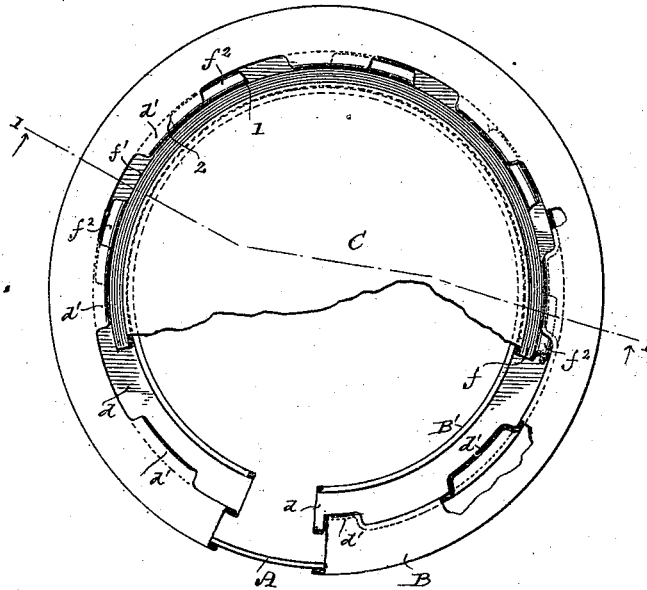
No. 492,074.

Patented Feb. 21, 1893.

*Fig. 1.*



*Fig. 2.*



Witnesses  
Geo. W. Young  
Wm. Klug

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# UNITED STATES PATENT OFFICE.

FRANCIS A. WALSH, OF MILWAUKEE, WISCONSIN.

## SHEET-METAL VESSEL.

SPECIFICATION forming part of Letters Patent No. 492,074, dated February 21, 1893.

Application filed October 17, 1885. Serial No. 180,144. (No model.)

*To all whom it may concern:*

Be it known that I, FRANCIS A. WALSH, of Milwaukee, in the county of Milwaukee, and in the State of Wisconsin, have invented certain new and useful Improvements in Sheet-Metal Vessels; and I do hereby declare that the following is a full, clear, and exact description thereof.

My invention relates to sheet metal vessels, and consists in certain peculiarities of construction, as will be fully set forth hereinafter, and subsequently claimed.

In the drawings, Figure 1 is a vertical section on the line 1—1 of Fig. 2, showing my invention applied to a vessel having a seamless breast. Fig. 2 is a plan view of said vessel, partly broken away.

A is a can body, B is a seamless breast, secured thereto in any suitable manner, and having a well or opening B', into the can.

C is the cover, made preferably of tin. The top of the breast B is provided with an annular channel  $d$ , one side of which is provided with short beads  $d'$ , while the rim of the cover C terminates in an angular flange  $f$ , that is recessed at  $f'$  to form segmental lugs  $f^2$ , which are inclined from the point 1 to the point 2, so that these lugs  $f^2$  form inclined locking ribs, so that when the cover is placed on the breast, and turned, the lugs  $f^2$  will be wedged down, each by a bead  $d'$  above it, and the top will be locked tightly to place. When the cover is formed of tin, these lugs

or ribs  $f^2$  are struck up or channeled from the under side, which makes the said inclined lugs or ribs stiffer.

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

1. The combination with a sheet metal breast, having an annular channel, one wall of which is provided with short beads, of a cover having a rim terminating in an angular flange, having its bearing in said annular channel, and provided with segmental locking lugs engaging with said beads, substantially as set forth.

2. In a sheet metal vessel, the combination of the body with a seamless breast secured thereto, said breast having a well through which the vessel is filled or emptied, and an annular channel, one side of which is provided with short beads, and a cover having a rim terminating in an annular flange recessed to form segmental lugs channeled from the under side whereby they form inclined ribs adapted for engagement with the aforesaid short beads, substantially as set forth.

In testimony that I claim the foregoing I have hereunto set my hand, at Milwaukee, in the county of Milwaukee and State of Wisconsin, in the presence of two witnesses.

FRANCIS A. WALSH

Witnesses:

S. S. STOUT,

H. G. UNDERWOOD.