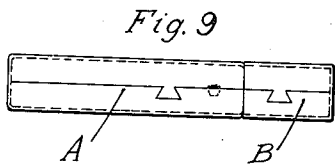
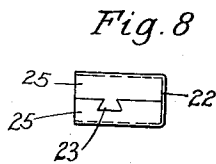
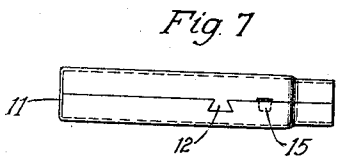
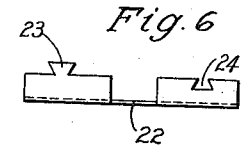
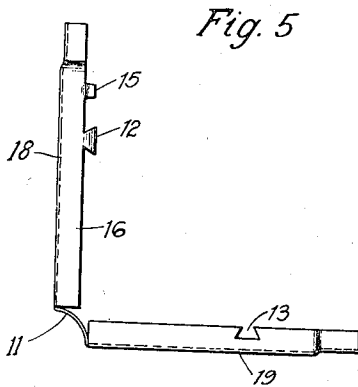
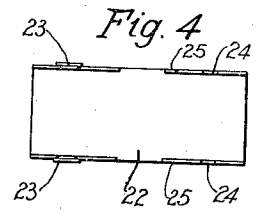
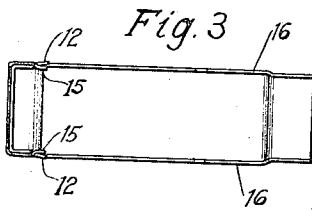
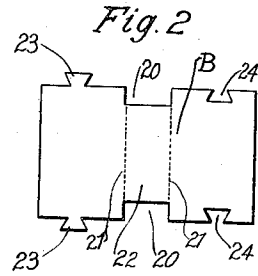
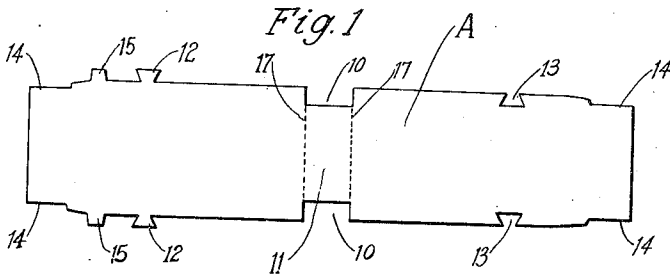


J. C. WAHL AND P. G. JACOBSON.
 METAL BOX.
 APPLICATION FILED DEC. 9, 1921.

1,428,195.

Patented Sept. 5, 1922.



Inventors:
 John C. Wahl
 Peter G. Jacobson
 By / J. M. H. /
 Attorney

UNITED STATES PATENT OFFICE.

JOHN C. WAHL AND PETER G. JACOBSON, OF CHICAGO, ILLINOIS, ASSIGNORS TO THE WAHL COMPANY, OF CHICAGO, ILLINOIS, A CORPORATION OF DELAWARE.

METAL BOX.

Application filed December 9, 1921. Serial No. 521,086.

To all whom it may concern:

Be it known that we, JOHN C. WAHL and PETER G. JACOBSON, citizens of the United States, residing at Chicago, in the county of Cook and State of Illinois, have invented certain new and useful Improvements in Metal Boxes, of which the following is a specification.

Our invention relates to sheet metal boxes, and more particularly to the method of forming the box.

The object of our invention is in the formation of a sheet metal box of strong, durable construction, by a particular method of stamping and bending a blank stamped from sheet metal.

Another object of our invention is the forming, by a novel method, of a small receptacle or box for containing leads used in the conventional mechanical pencil. We do not wish, however, to limit our invention to any particular size of our lead container, inasmuch as our particular method of forming a box is applicable to any sized container.

Other objects of our invention will appear in the following specification in connection with the annexed drawings, in which:—

Fig. 1 shows a blank stamped from a sheet of metal, said blank eventually forming the body portion of the box.

Fig. 2 shows the blank of sheet metal which eventually forms the container cap.

Fig. 3 is a plan view of the blank shown in Fig. 1 after some of the bending actions have taken place.

Fig. 4 is a plan view of the blank shown in Fig. 2, after a single operation has occurred.

Fig. 5 is a side elevation of the blank shown in Fig. 3.

Fig. 6 is a side elevation of the blank shown in Fig. 4.

Fig. 7 is a side elevation of the body portion of the container, when the method of forming has been completed.

Fig. 8 is a side elevation of the cap portion, after all the bending operations have been completed.

Fig. 9 is a side elevation of the body portion with the cap attached thereto.

Referring to the drawings, (A) denotes generally the blank which is stamped from a sheet of metal and which forms the body portion of our lead container. Intermediate the ends of this blank (A), portions 10 have been cut away, with the result that after

several bending operations, to be later described, on the dotted lines shown in Figure 1, the portion 11, eventually becomes the bottom of the completed box. At 12, on either side of the blank are shown wedge-shaped projections, formed to engage similar shaped notches 13, stamped in the blank. The outer ends of the blank are cut away as at 14, in order that when the container is finally completed, it will have a bottle-neck appearance, as shown in Figure 7, and this portion which is cut away will form a seat for the cap. Lugs 15, adjacent the projections 12, are stamped on the blank and eventually act as an additional binding element in the final clamping operation. In Figure 1, the flat blank is shown, but in Figure 3, the same blank is shown in plan after the sides 16 have been bent at approximately right-angles thereto, and the blank (A) bent upon the dotted lines 17, shown in Figure 1. This figure also shows the box with its two sections, or rather, two faces 18 and 19, at right-angles to each other, preparatory to the final clamping action, which will complete the body portion of the container. In Figure 3 are shown the projections 12, flaring slightly outward from the sides 16. Also the lugs 15 are shown projecting slightly inside of the side portions 16. The same bending operation that shaped the blank as shown in Figure 3, also produced the outward and inward flaring of the projections 12, and lugs 15, respectively. In Figure 7 the completed body portion of the box is shown with the front and rear sections 18 and 19, clamped together, the lugs 15 projecting within the sides of the section 19, and the wedge-shaped projections 12, clamped into their corresponding notches 13.

The cap portion of the box is formed in a manner similar to that of the body portions. The blank (B) has the cut-away portions 20, intermediate its ends, with a similar result attained as in blank (A), that when said blank is bent upon the dotted lines 21, the portion 22, will form the bottom of the cap. Wedge-shaped projections 23 are stamped on one side of the blank, with similar shaped notches 24 on the other side. In Figure 4 is shown blank (B) with the sides 25 bent at approximately right-angles to the body, but with the wedge-shaped projections 23 flared slightly outward. In Figure 8 the completed cap is shown, the

blank as shown in Figure 4, having, by one operation been formed into the completed cap, with the projections 23 mating with their receiving notches 24.

5 It may be seen that in the method of forming the cap, there is one less bending operation, in that the blank after having its sides bent at right-angles thereto, is then, in one operation, formed into the completed
10 cap.

What we claim is:

1. The method of forming a sheet-metal box, comprising, stamping a blank with engagement members, receiving notches and
15 binding lugs therein, then striking a substantial portion of the blank at either side at right-angles thereto, to form the sides of the blank, then bending the blank medially upon two parallel lines to form a bottom
20 portion, and finally clamping the opposed sections together with the engagement members fitting into the receiving notches, and the binding lugs lying within the box.

2. The method of forming a sheet-metal
25 box, comprising, stamping a blank with engagement members, receiving notches, and

binding lugs therein, then striking a substantial portion of the blank at either side at right-angles thereto, with the engagement members and binding lugs flared slightly
30 outwardly and inwardly respectively, then bending the blank medially upon two parallel lines to form a bottom portion, and finally clamping the opposed sections together with the engagement members fitting within the
35 corresponding notches.

3. The method of forming a sheet-metal box, comprising, stamping a blank with intermediate cut-out portions and also engagement members, notches, and binding lugs
40 therein, then striking a substantial portion of the blank at either side at right-angles thereto, to form the sides of the blank, then bending the blank medially upon two
45 parallel lines to form a bottom portion, and finally clamping the opposed sections together with the engagement members fitting within the corresponding notches.

In witness whereof we have subscribed our names.

JOHN C. WAHL.
PETER G. JACOBSON.