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PATENT SPECIFICATION

DRAWINGS ATTACHED

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COMPLETE SPECIFICATION

Improvements in or relating to Containers

We, THE METAL BOX COMPANY LIMITED, a Company incorporated under the laws of Great Britain, of 37, Baker Street, London, W.1, England, do hereby declare the invention, for which we pray that a patent may be granted to us, and the method by which it is to be performed, to be particularly described in and by the following statement:—

This invention relates to containers and in particular to containers having a mouth-ring fitted thereto to define the mouth of the container. Containers of this kind are sometimes used as cans to contain paint and it has been found that some paints react chemically on the cut edges of sheet metal if such edges are located inside the can to be capable of contact with paint in the can.

It is one object of the present invention to provide a mouth-ring for a container, which mouth-ring ensures that no cut edge is located inside the container. Other objects of the invention are to provide a can which can be easily fitted with a lid, and the obtaining, by the initial resilience of the mouth-ring, of a high interference value between the lid and the mouth-ring; the provision of means which determines the maximum extent of entry of the lid into the mouth-ring; the restriction and concealment of leakage of volatile or low surface tension liquids from between the mating surface of the lid and the mouth-ring; the avoidance of obstruction to an implement used for opening a can by prising the lid from the mouth-ring; and the provision of means on the lid to assist location thereof relative to the mouth-ring prior to the lid being finally applied to the can.

It is also well understood in the art that when a mouth-ring is seamed to a can body great care must be taken to avoid distending, stressing, or increasing the diameter of the mouth-ring aperture in a manner such as to disturb the interference fit between the

mouth-ring and a lid which is to effect closing thereof, and it is a further object of the present invention so to design the mouth-ring that distension of the material in seaming the ring to the body does not impair the desired fit between the lid and the mouth-ring aperture.

According to the present invention there is provided a thin metal mouth-ring having a seam-forming flange portion to be seamed to a can body, said flange portion including a can body side-engaging portion connecting the flange portion to a spacer flange which is substantially at right-angles to the body side-engaging portion, a mouth-defining annulus of U-cross-section having limbs substantially parallel to each other and to the body side-engaging portion, one of said limbs being shorter than the other and connected by an arcuate portion to the spacer flange, and a partial curl formed in continuation of the longer limb to overlie the base of the U-section with a part of the curl located in a plane between planes which contain, respectively, the spacer flange and the portion by which the seam-forming flange portion is connected to the body side-engaging portion, the curl also having an edge portion thereof located in close proximity with said arcuate portion.

The invention also comprises a can the mouth of which is defined by a thin metal mouth-ring having a mouth-defining annulus of U-cross section having limbs substantially parallel to each other, one of said limbs being shorter than the other and connected by an arcuate portion with a spacer flange located between the opposite ends of the can body, said spacer flange lying in a plane substantially at right-angles to the sides of the can body and being connected at the end thereof remote from said arcuate portion with a body side-engaging portion of a seam-forming

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flange by which the mouth-ring is end-seamed to the can body, and a partial curl formed in continuation of the longer limb of the U-section annulus to overlie the base of the U-section with a part of the curl located in a plane between planes which contain, respectively, the spacer flange and the portion by which the seam-forming flange portion is connected to the body side-engaging portion, the curl also having an edge portion thereof located in close proximity with said arcuate portion, the arrangement being such as to permit yielding of the longer limb and of the curl during closure of the mouth of the can by a lid having a plug portion adapted frictionally to engage the sides of the can mouth formed by said longer limb.

In order that the invention may be clearly understood some embodiments thereof will now be described, by way of example, with reference to the drawings accompanying the provisional specification and in which:—

Fig. 1 is a top plan of a mouth-ring according to the invention;

Fig. 2 is a section, to an enlarged scale, on line II—II, Fig. 1;

Fig. 3 illustrates, partly in section, a can having fitted thereto a mouth-ring as illustrated in Figs. 1 and 2;

Fig. 4 is a section through the upper portion of a can the mouth of which is closed by a lid, and illustrates the method of removal of the lid from the mouth, and

Fig. 5 is a section through an alternative form of lid.

Referring to the drawings the mouth-ring is made from thin sheet metal, such as tinplate, and is provided with a flange portion 1 adapted to be end-seamed to a can body as illustrated in Figs. 3 and 4. The flange portion includes a can body side-engaging portion 2 which is engaged with the interior of the can body, as illustrated in Figs. 3 and 4. The can body side-engaging portion connects the flange portion to a spacer flange 3 which is substantially at right-angles to the portion 2. The end of the spacer flange which is remote from the portion 2 is connected by an arcuate portion 4 with the extremity of the shorter limb 5 of a mouth-defining annulus of U-cross-section. The limbs of the U-section are substantially parallel with the portion 2 and the longer limb 6 of the mouth-defining annulus has formed in continuation thereof a partial curl 7 which overlies the base 8 of the U-section with a part of the curl located in a plane between planes which contain, respectively, the spacer flange 3 and the portion by which the seam-forming portion 1 is connected to the body side-engaging portion 2. The curl 7 has an edge portion 9 which is located in close proximity with the arcuate portion 4. As shown in the drawings the partial curl is

a half-curl but it may, if desired, be up to about a threequarter curl.

The mouth-ring is end seamed to a can body 10 in known manner, as illustrated in Figs. 3 and 4, and the mouth of the can is closed by a lid having a plug portion 11 which frictionally engages the sides of the mouth as defined by the limb 6 of the mouth-forming annulus. Due to the resiliency of the longer limb 6 and of the partial curl, when the plug portion 11 is inserted into the mouth the limb 6 moves towards the limb 5 to facilitate the insertion of the plug portion 11 into the mouth, and the resiliency of the mouth-defining annulus ensures good frictional engagement between the plug portion 11 and the limb 6. As stated above, the portion 9 of the curl 7 is located in close proximity with the arcuate portion 4, and permits movement of the limb 6 towards the limb 5, but if the portion 9 should engage the arcuate portion 4 movement of the limb 6 towards the limb 5 will still be permitted as the curl will tend slightly to close during the insertion of the plug portion into the mouth.

The inner end of the plug portion 11 is provided with a guide spigot 12, Figs. 4 and 5, which is of lesser diameter than that of the plug portion and is connected with the plug portion by a flat inclined portion 13. The provision of the guide spigot 12 ensures that the inner end of the lid enters the mouth freely during application of the lid to the can, and the flat step facilitates the location of the lid relative to the mouth of the can so that the lid and can are substantially coaxial prior to the application of top pressure to the lid to effect insertion of the plug portion of a lid into the mouth. The outer end of the lid is provided with a curl 14 arranged to overlie the curl 7 provided on the mouth-ring and to co-operate therewith to determine the maximum extent of movement of the plug portion into the mouth of the can.

The lid is so constructed that, as illustrated in Fig. 4, when it is applied to the can by known can closing mechanism the top of the lid does not project above the rim 15 of the can. The distance by which the top of curl 7 is spaced from the plane of rim 15 may, however, be such that when the top of the lid is in the plane of the rim the curl 7 is not engaged by curl 14.

As can be seen from Fig. 4 should the curl 14 be moved into engagement with the curl 7 there will still be a space or gap 17 which will provide a terminal for the escape of volatile or low surface tension liquids between the mating surfaces of parts 6 and 11.

Cans constructed and closed as described with reference to Fig. 4 can be readily opened by the insertion of the edge of a penny or

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other opening implement 18 between the curl 14 and the rim 15 of the cam, the lower edge of the implement resting on the flange portion 3 and being prevented from entering between the arcuate portion 4 and the end portion 9 of the curl 7 due to the close proximity of arcuate portion 4 and portion 9. As can be seen from Fig. 4 the arrangement is such that prior to pressure being exerted on the opening implement, to move it clockwise as viewed in Fig. 4, the implement is disposed at an angle of about 60° in relation to the plane of the top of the container and the arrangement is such that the full mechanical advantage is obtained by the clockwise movement of the opening implement. Due to the spacer flange being located in one plane substantially at right angles to the sides of the can body there is provided a space which permits maximum penetration of the opening implement.

The plug portion of the lid illustrated in Fig. 4 has integral therewith an inverted dish-like portion 19 which is concentric with the sides of the plug portion and which has a diameter less than that of the plug portion. The dish-like portion 19 increases the ullage or head-space in the can. It will be understood that it is not always necessary to provide a maximum ullage or head-space and when this feature is not required the lid illustrated in Fig. 5 may be employed to close the can, the lid of Fig. 5 differing from that of Fig. 4 only in that it is not provided with a dish-like portion 19.

From the foregoing description, and from the drawings, it will be readily understood that by the use of a mouth-ring as described herein no raw or cut edge is presented to the interior of the can, and the mouth-ring is so constructed as to allow for deflection and resiliency of the mouth during the insertion therinto of the plug portion of a lid, thus ensuring the maximum interference between the lid and the mouth without stressing the lid beyond the yield point thereof or causing the plug portion of the lid to be reduced in diameter and rendering it a loose fit in the mouth. Further, by the provision of a spacer flange which lies wholly in one plane there is provided a relatively narrow spacer flange which ensures maximum strength while permitting the use of a strong seaming chuck and ensuring that the portion of U-section is sufficiently isolated from the end seam so that it is not affected by the heavy work of the seaming operation. The provision of the said spacer flange also permits the employment of a mouth aperture of maximum diameter.

WHAT WE CLAIM IS:—

1. A thin metal mouth-ring having a seam-forming flange portion to be seamed to a can body, said flange portion including a can body side-engaging portion connecting the

flange portion to a spacer flange which is substantially at right-angles to the body side-engaging portion, a mouth-defining annulus of U-cross-section having limbs substantially parallel to each other and to the body side-engaging portion, one of said limbs being shorter than the other and connected by an arcuate portion to the spacer flange, and a partial curl formed in continuation of the longer limb to overlie the base of the U-section with a part of the curl located in a plane between planes which contain, respectively, the spacer flange and the portion by which the seam-forming flange portion is connected to the body side-engaging portion, the curl also having an edge portion thereof located in close proximity with said arcuate portion.

2. A can the mouth of which is defined by a thin metal mouth-ring having a mouth-defining annulus of U-cross section having limbs substantially parallel to each other, one of said limbs being shorter than the other and connected by an arcuate portion with a spacer flange located between the opposite ends of the can body, said spacer flange lying in a plane substantially at right-angles to the sides of the can body and being connected at the end thereof remote from said arcuate portion with a body side-engaging portion of a seam-forming flange by which the mouth-ring is end-seamed to the can body, and a partial curl formed in continuation of the longer limb of the U-section annulus to overlie the base of the U-section with a part of the curl located in a plane between planes which contain, respectively, the spacer flange and the portion by which the seam-forming flange portion is connected to the body side-engaging portion, the curl also having an edge portion thereof located in close proximity with said arcuate portion, the arrangement being such as to permit yielding of the longer limb and of the curl during closure of the mouth of the can by a lid having a plug portion adapted frictionally to engage the sides of the can mouth formed by said longer limb.

3. A can according to Claim 2, wherein the mouth is closed by a lid having a plug portion frictionally engaging the sides of the mouth and a guide spigot at the inner end of the plug portion, said spigot being of lesser diameter than that of the plug portion and connected therewith by a flat inclined portion.

4. A can according to Claim 3, wherein the outer end of the lid is provided with a curl to overlie the curl provided on the mouth-ring and to co-operate therewith to determine the maximum extent of movement of the plug portion into the mouth of the can.

5. A can according to Claim 2, or Claim 3, or Claim 4, wherein the plug portion of



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other opening implement 18 between the curl 14 and the rim 15 of the cam, the lower edge of the implement resting on the flange portion 3 and being prevented from entering between the arcuate portion 4 and the end portion 9 of the curl 7 due to the close proximity of arcuate portion 4 and portion 9. As can be seen from Fig. 4 the arrangement is such that prior to pressure being exerted on the opening implement, to move it clockwise as viewed in Fig. 4, the implement is disposed at an angle of about 60° in relation to the plane of the top of the container and the arrangement is such that the full mechanical advantage is obtained by the clockwise movement of the opening implement. Due to the spacer flange being located in one plane substantially at right angles to the sides of the can body there is provided a space which permits maximum penetration of the opening implement.

The plug portion of the lid illustrated in Fig. 4 has integral therewith an inverted dish-like portion 19 which is concentric with the sides of the plug portion and which has a diameter less than that of the plug portion. The dish-like portion 19 increases the ullage or head-space in the can. It will be understood that it is not always necessary to provide a maximum ullage or head-space and when this feature is not required the lid illustrated in Fig. 5 may be employed to close the can, the lid of Fig. 5 differing from that of Fig. 4 only in that it is not provided with a dish-like portion 19.

From the foregoing description, and from the drawings, it will be readily understood that by the use of a mouth-ring as described herein no raw or cut edge is presented to the interior of the can, and the mouth-ring is so constructed as to allow for deflection and resiliency of the mouth during the insertion thereof into the plug portion of a lid, thus ensuring the maximum interference between the lid and the mouth without stressing the lid beyond the yield point thereof or causing the plug portion of the lid to be reduced in diameter and rendering it a loose fit in the mouth. Further, by the provision of a spacer flange which lies wholly in one plane there is provided a relatively narrow spacer flange which ensures maximum strength while permitting the use of a strong seaming chuck and ensuring that the portion of U-section is sufficiently isolated from the end seam so that it is not affected by the heavy work of the seaming operation. The provision of the said spacer flange also permits the employment of a mouth aperture of maximum diameter.

WHAT WE CLAIM IS:—

1. A thin metal mouth-ring having a seam-forming flange portion to be seamed to a can body, said flange portion including a can body side-engaging portion connecting the

flange portion to a spacer flange which is substantially at right-angles to the body side-engaging portion, a mouth-defining annulus of U-cross-section having limbs substantially parallel to each other and to the body side-engaging portion, one of said limbs being shorter than the other and connected by an arcuate portion to the spacer flange, and a partial curl formed in continuation of the longer limb to overlie the base of the U-section with a part of the curl located in a plane between planes which contain, respectively, the spacer flange and the portion by which the seam-forming flange portion is connected to the body side-engaging portion, the curl also having an edge portion thereof located in close proximity with said arcuate portion.

2. A can the mouth of which is defined by a thin metal mouth-ring having a mouth-defining annulus of U-cross section having limbs substantially parallel to each other, one of said limbs being shorter than the other and connected by an arcuate portion with a spacer flange located between the opposite ends of the can body, said spacer flange lying in a plane substantially at right-angles to the sides of the can body and being connected at the end thereof remote from said arcuate portion with a body side-engaging portion of a seam-forming flange by which the mouth-ring is end-seamed to the can body, and a partial curl formed in continuation of the longer limb of the U-section annulus to overlie the base of the U-section with a part of the curl located in a plane between planes which contain, respectively, the spacer flange and the portion by which the seam-forming flange portion is connected to the body side-engaging portion, the curl also having an edge portion thereof located in close proximity with said arcuate portion, the arrangement being such as to permit yielding of the longer limb and of the curl during closure of the mouth of the can by a lid having a plug portion adapted frictionally to engage the sides of the can mouth formed by said longer limb.

3. A can according to Claim 2, wherein the mouth is closed by a lid having a plug portion frictionally engaging the sides of the mouth and a guide spigot at the inner end of the plug portion, said spigot being of lesser diameter than that of the plug portion and connected therewith by a flat inclined portion.

4. A can according to Claim 3, wherein the outer end of the lid is provided with a curl to overlie the curl provided on the mouth-ring and to co-operate therewith to determine the maximum extent of movement of the plug portion into the mouth of the can.

5. A can according to Claim 2, or Claim 3, or Claim 4, wherein the plug portion of



the lid has integral therewith an inverted dish-like portion concentric with the sides of the plug portion and having a diameter of less than that of the plug portion.

5 6. A mouth-ring for a can, substantially as herein described with reference to Figs. 1 and 2 of the drawings accompanying the provisional specification.

10 7. A can substantially as herein described with reference to Fig. 3 of the drawings

accompanying the provisional specification.

8. A can according to Claim 7, fitted with a lid substantially as herein described with reference to Fig. 4 of the drawings accompanying the provisional specification. 15

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PROVISIONAL SPECIFICATION

Improvements in or relating to Containers 15

We, THE METAL BOX COMPANY LIMITED, a Company incorporated under the laws of Great Britain, of 37, Baker Street, London, W.1, England, do hereby declare this invention to be described in the following statement:— 20

This invention relates to containers and in particular to containers having a mouth-ring fitted thereto to define the mouth of the container. Containers of this kind are sometimes used as cans to contain paint and it has been found that some paints react chemically on the cut edges of sheet metal if such edges are located inside the can to be capable of contact with paint in the can. 25

It is one object of the present invention to provide a mouth-ring for a container, which mouth-ring ensures that no cut edge is located inside the container. Other objects of the invention are to provide a can which can be easily fitted with a lid, and the obtaining, by the initial resilience of the mouth ring, of a high interference value between the lid and the mouth ring; the provision of means which determines the maximum extent of entry of the lid into the mouth ring; the restriction and concealment of leakage of volatile or low surface tension liquids from between the mating surfaces of the lid and the mouth-ring; the avoidance of obstruction to an implement used for opening a can by prising the lid from the mouth-ring; and the provision of means on the lid to assist location thereof relative to the mouth ring prior to the lid being finally applied to the can. 30

According to the present invention there is provided a thin metal mouth-ring having a flange portion to be seamed to a can body and integral with the flange a mouth-defining annulus of U-cross-section of which the extremity of one limb of the U is connected by a radius to the flange portion and the other limb terminates in a curl which overlies the base of the U-section and has a portion thereof located in close proximity with said radius. The flange portion may include a can body side-engaging portion concentric with the mouth-defining annulus and extending beyond the top of the curl. 35

65 The invention also comprises a can the

mouth of which is defined by a thin metal mouth-ring having a flange portion end-seamed to the can body and integral with the flange portion a mouth-defining annulus of U-cross-section of which the extremity of one limb of the U is connected by a radius to the flange portion of the other limb terminates in a curl which overlies the base of the U-section and has a portion thereof located in close proximity with said radius. 70

The invention also contemplates a can the mouth of which is defined by a thin metal mouth-ring having a flange portion end-seamed to the can body with a part of the flange portion engaged with the interior of the can body, and a mouth-defining annulus integral with the flange portion and of U-cross-section with one limb of the U connected by a radius to the flange portion and the other limb of the U terminating in a curl which overlies the base of the U-section, the curl having a portion thereof located in close proximity with said radius and its top located below the rim of the can defined by said end seam. 75

The mouth of a can may be closed by a lid having a plug-portion frictionally engaging the sides of the mouth and a guide spigot at the inner end of the plug-portion, said spigot being of lesser diameter than that of the plug-portion and connected therewith by a flat step inclined from the plug-portion towards the axis and the inner end of the plug-portion. The outer end of the lid may be provided with a curl to overlie the curl provided on the mouth-ring and to co-operate therewith to determine the maximum extent of movement of the plug portion into the mouth of the can. 80

In a preferred embodiment of the invention the plug-portion of the lid has integral therewith an inverted dish-like portion concentric with the sides of the plug-portion and having a diameter less than that of the plug-portion. 85

In order that the invention may be clearly understood, some embodiments thereof will now be described, by way of example, with reference to the accompanying drawings, in which:— 110

Fig. 1 is a top plan of a mouth-ring according to the invention;

Fig. 2 is a section, to an enlarged scale, on line II—II, Fig. 1;

5 Fig. 3 illustrates, partly in section, a can having fitted thereto a mouth-ring as illustrated in Figs. 1 and 2;

10 Fig. 4 is a section through the upper portion of a can the mouth of which is closed by a lid, and illustrates the method of removal of the lid from the mouth, and

Fig. 5 is a section through an alternative form of lid.

Referring to the drawings the mouth-ring 15 is made from thin sheet metal, such as tinplate, and is provided with a flange portion 1 adapted to be end-seamed to a can body as illustrated in Figs. 3 and 4. The flange portion includes a portion 2 which is engaged with the interior of the can body, as illustrated in Figs. 3 and 4. The flange portion also includes a portion 3 which is substantially at right-angles to the portion 2 and which is connected by a radius 4 with the extremity of one limb 5 of a mouth-defining annulus of U-cross-section. The other limb 6 of the mouth-defining annulus terminates in a curl 7 which overlies the base of the U-section and has a portion 9 thereof located in close proximity with the radius 4.

20 The mouth-ring is end-seamed to a can body 10 in known manner, as illustrated in Figs. 3 and 4, and the mouth of the can is closed by a lid having a plug portion 11 which frictionally engages the sides of the mouth as defined by the limb 6 of the mouth-forming annulus. Due to the resiliency resulting from the construction of the mouth-ring, when the plug portion 11 is inserted 30 into the mouth the limb 6 moves towards the limb 5 to facilitate the insertion of the plug portion 11 into the mouth, and the resiliency of the mouth-defining annulus ensures good frictional engagement between the plug portion 11 and the limb 6. As stated above, the portion 9 of the curl 7 is located in close proximity with the radius 4 and permits movement of the limb 6 towards the limb 5, but if the portion 9 should engage the radius 4 movement of the limb 6 towards the limb 5 will still be permitted as the curl will tend slightly to close during the insertion of the plug portion into the mouth.

35 The inner end of the plug portion 11 is provided with a guide spigot 12, Figs. 4 and 5, which is of lesser diameter than that of the plug portion and is connected with the plug portion by a flat step inclined from the plug-portion towards the axis and the inner end of the plug-portion. The provision of the guide spigot 12 ensures that the inner end of the lid enters the mouth and does not form an interference fit therewith during application of the lid to the can, and the 65 flat step facilitates the location of the lid rela-

tive to the mouth of the can so that the lid and can are substantially co-axial prior to the application of top pressure to the lid to effect insertion of the plug-portion of a lid into the mouth. The outer end of the lid is provided with a curl 14 arranged to overlie the curl 7 provided on the mouth-ring and to co-operate therewith to determine the maximum extent of movement of the plug portion into the mouth of the can.

70 In a preferred embodiment of the invention the top of the curl 7 is located below the rim 15 of the can as defined by the end seam 16 by which the mouth-ring is seamed to the can body. This permits the lid to be so constructed that, as illustrated in Fig. 4, when the lid is applied to the can by known closing mechanism the top of the lid does not project above the rim 15 of the can. The distance by which the top of curl 7 is spaced from the plane of rim 15 may, however, be such that when the top of the lid is in the plane of the rim the curl 7 is not engaged by curl 14.

80 As can be seen from Fig. 4 should the curl 14 be moved into engagement with the curl 7 there will still be a space or gap 17 which will provide a terminal for the escape of volatile or low surface tension liquids between the mating surfaces 6 and 11.

85 Cans constructed and closed as described with reference to Fig. 4 can be readily opened by the insertion of the edge of a penny or other opening implement 18 between the curl 14 and the rim 15 of the can, the lower edge of the implement resting on the flange portion 3 and being prevented from entering between the radius 4 and the end portion 9 of the curl 7 due to the close proximity of radius 4 and portion 9. As can be seen from Fig. 4 the arrangement is such that prior to pressure being exerted on the opening implement, to move it clockwise as viewed in Fig. 4, the implement is disposed at an angle of about 60° in relation to the plane of the top of the container and the arrangement is such that the full mechanical advantage is obtained by the clockwise movement of the opening implement.

90 The plug-portion of the lid illustrated in Fig. 4 has integral therewith an inverted dish-like portion 19 which is concentric with the sides of the plug-portion and which has a diameter less than that of the plug-portion. The dish-like portion 19 increases the ullage or head-space in the can. It will be understood that it is not always necessary to provide a maximum ullage or head-space and when this feature is not required the lid illustrated in Fig. 5 may be employed to closure the can, the lid of Fig. 5 differing from that of Fig. 4 only in that it is not provided with a dish-like portion 19.

95 From the foregoing description, and from the drawings, it will be readily understood 130



that by the use of a mouth-ring as described herein no raw or cut edge is presented to the interior of the can, and the mouth-ring is so constructed as to allow for deflection and resiliency of the mouth during the insertion thereof of the plug-portion of a lid, thus ensuring the maximum interference between the lid and the mouth without stressing the lid beyond the yield point thereof or causing

the plug-portion of the lid to be reduced in diameter and rendering it a loose-fit in the mouth. 10

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