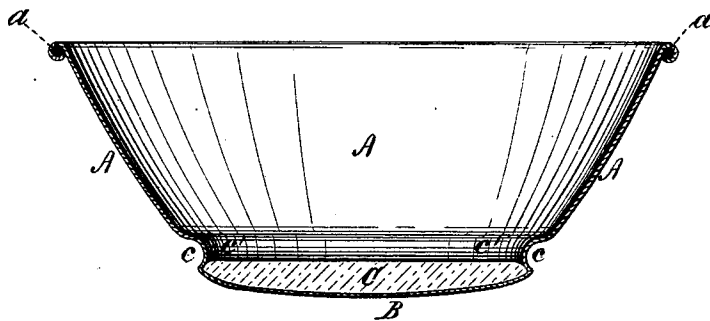


C. HARRISON.
WATER-CLOSET BASIN.

No. 188,897.

Patented March 27, 1877.



Witnesses:

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UNITED STATES PATENT OFFICE.

CHARLES HARRISON, OF NEW YORK, N. Y.

IMPROVEMENT IN WATER-CLOSET BASINS.

Specification forming part of Letters Patent No. **188,897**, dated March 27, 1877; application filed February 19, 1877.

To all whom it may concern:

Be it known that I, CHARLES HARRISON, of New York, N. Y., have invented an Improvement in Water-Closet Basins, of which the following is a specification:

Water-closet basins have been heretofore made of sheet metal, and have been lined on the bottom inside with porcelain, which has been secured in position by a strip of solder around the inside of the basin just above the edge of the porcelain.

It is the object of my invention to dispense with the use of solder in fastening the porcelain bottom linings in basins, and thus avoid the presence in the basins of the rough surface of solder, which is highly objectionable, because it catches soil. The further advantages of dispensing with the solder are, that the basin is improved in appearance, and the cost of manufacture is materially lessened.

My invention constitutes a new article of manufacture, which consists of a water-closet basin having for its inside bottom lining a porcelain disk which conforms to the shape of the bottom, and is secured thereupon by spinning the sheet metal of which the basin is made upon or over a portion of the porcelain disk. The porcelain disk is thus held in position by the friction of the annular recess in which the periphery of the disk is seated.

The accompanying drawing is a central section through the axis of a basin embodying my invention.

The drawing represents a water-closet basin of the ordinary form, the periphery of which, A, is conical, and is turned over upon its upper edge to receive the usual stiffening-wire *a*. The bottom B of the basin is slightly rounded,

and fits the inner face of the porcelain disk C, which constitutes the inner bottom lining of the basin.

In the process of manufacture, after the basin is formed, the disk is placed against the bottom, and the metal is then spun over the edge of the disk all the way around, forming on the outside of the basin the annular recess *c*, and on the inner side of the basin the annular shoulder or projection *c'*.

By this mode of manufacture the porcelain bottom lining is made to fit tight upon the sheet metal, and the basin is left perfectly smooth. At the same time the cost of the solder ordinarily used to secure the disk in place and the labor of soldering are saved.

I am aware that basins have been wholly lined with porcelain; but by lining the bottom only, as I do, the weight of the basin is not materially added to, as it is when the whole interior of the basin is porcelain-lined. At the same time my bottom lining matches in appearance the bowl upon the bottom of which the basin is applied, and gives the structure the same finish as if the whole interior of the basin were porcelain.

I claim as my invention—

As a new article of manufacture, a sheet-metal water-closet basin provided with an inside bottom lining of porcelain, which is secured in position by means of the annular shoulder *c'*, spun against or upon the edge of the disk, substantially as shown and described.

CHAS. HARRISON.

Witnesses:

EDWD. PAYSON,
GEO. W. MIATT.