

SEAMS OR JOINTS.

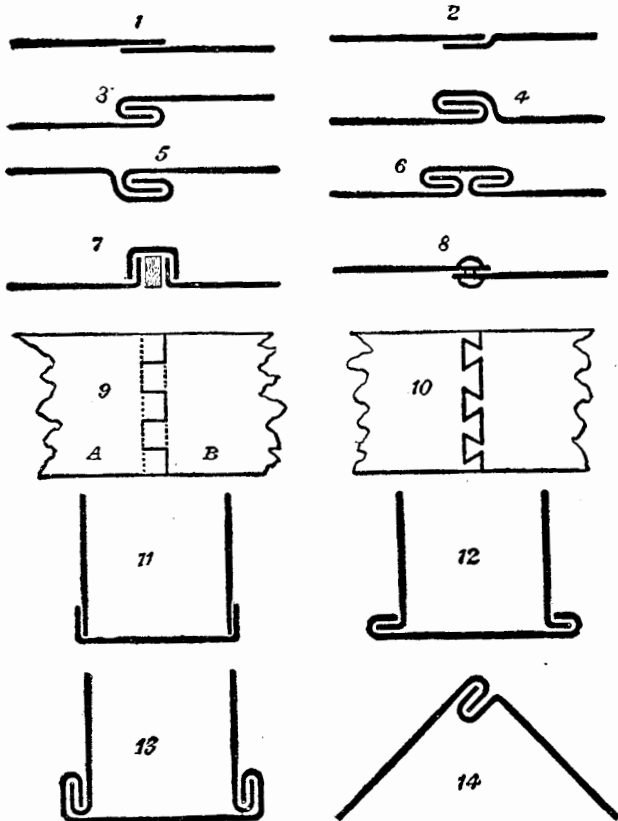


Fig. 146.

The more important seams or joints used in sheet-metal work are illustrated in Fig. 146.

Lap Seam. No. 1 shows how sheet-metal plates are arranged for a lap seam to be soldered.

Countersunk Lap Seam. This is shown in No. 2, it will be noticed that the edge of one of the plates is bent down, so that the edge of the other plate to be joined to it may lie in the shoulder formed by the part bent down.

Folded Seam. The method of preparing the edges of plates for a folded seam are shown in No. 3.

Grooved Seam. This is shown in No. 4. It may be seen that it is practically the same as No. 3, only one plate is countersunk.

Countersunk Grooved Seams. The seam shown in No. 5 is used when an unbroken surface is required on the outside of an article.

Double Folded Seam. This is shown in No. 6 and is used with thick plates, where these when joined are required to present an unbroken surface.

Zinc Roofing Joint. The joint shown in No. 7 admits of the expansion and contraction of the zinc sheets.

Rivetted Lap Seam. No. 8 shows a rivetted lap seam. The amount of lap should not be less than three times the diameter of the rivet.

Brazing Joints. A brazing joint for thin metal is shown in No. 9, the edge of plate A is cut to form laps and these laps are arranged alternately over and under the edge of plate B. A brazing joint for thick metal is shown in No. 10. It is practically the same thing as a carpenter's dovetail joint.

Circular Lap Seam. No. 11 shows how the edge of the bottom of a can is bent up previous to soldering.

Circular Folded Seams. A folded seam for a can or pail is sometimes made in the form of No. 12. Another form of circular folded seam is shown in No. 13.

Box Grooved Seam. The seam shown in No. 14 is used for joining sheets in square work, such as the ends or sides of a deed-box.