(No Model.)

C. PUDDEFOOT.

MANUFACTURE OF METALLIC DOOR KNOBS.

No. 267,105. Patented Nov. 7, 1882.

Fig. 1

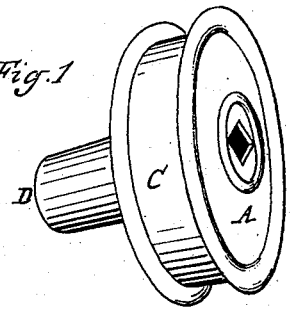


Fig. 3

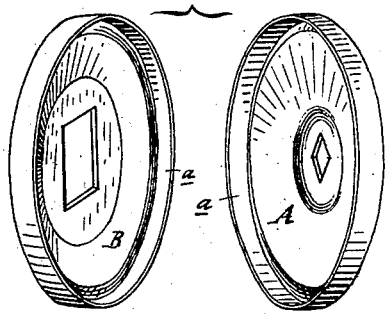
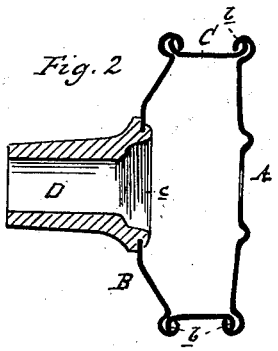


Fig. 2



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UNITED STATES PATENT OFFICE.

CHARLES PUDDEFOOT, OF DETROIT, MICHIGAN, ASSIGNOR TO THE DETROIT STAMPING COMPANY, OF SAME PLACE.

MANUFACTURE OF METALLIC DOOR-KNOBS.

SPECIFICATION forming part of Letters Patent No. 267,105, dated November 7, 1882.

Application filed August 10, 1882. (No model.)

To all whom it may concern:

Be it known that I, CHARLES PUDDEFOOT, of Detroit, in the county of Wayne and State of Michigan, have invented new and useful Improvements in Metallic Door-Knobs; and I do hereby declare that the following is a full, clear, and exact description thereof, reference being had to the accompanying drawings, which form a part of this specification.

The nature of this invention relates to certain new and useful improvements in the manufacture of door-knobs, by means of which a more highly finished, more ornamental, and a lighter knob is provided at a less cost than attends the manufacture of metallic knobs manufactured in the usual manner. Such knobs have hitherto been cast in brass or bronze, and the consequent porosity of the cast metal has militated against their receiving a high polish; or, if made of sheet metal, they have been spun into shape in sections which have been afterward brazed or soldered together—a process which materially adds to their cost, while at the same time it prevents any ornamentation upon their exposed faces.

The invention consists in a novel method of producing, as a new article of manufacture and sale, a metallic knob made of sheet metal, pressed into shape in proper sections, which, when "gathered," are secured together by means of suitable presses, and in like manner secured to the cast-metal socket which is designed to embrace the spindle, as more fully hereinafter described.

Figure 1 is a perspective view of my improved knob finished, ready to be attached to the spindle. Fig. 2 is a central vertical cross-section. Fig. 3 shows the reverse and obverse heads of the knob detached.

In the accompanying drawings, which form a part of this specification, A represents the obverse head of the knob, and B the reverse. These are pressed into the proper shape in the ordinary manner, leaving an inwardly-turned flange, *a*, on each.

C is the body or central section, also pressed so as to have an outwardly-projecting flange on each edge. This is lettered *b*, and the flanges are not at right angles to the vertical wall, but diverge, as shown in Fig. 2. The dies of the presses in which the work is done may be ornamented in any desired manner to give a like ornamentation to the parts.

D is the spindle-socket, and this, for convenience in manufacture, is preferably of cast metal, and provided with a squared end, *c*.

In gathering the parts together the squared shoulder end of the socket is inserted from the outside into a suitable hole in the reverse head, and a press is employed to rivet the parts together by "peening" over the squared end of the socket. Then the body, first having been pressed into the form of a ring with the flanges, as described, is laid upon the inner side of the reverse head and within its flange, and a suitable press is employed to turn such flange on the head to engage it with the adjacent flange on the body, as shown in Fig. 2. Then the obverse head is in the same manner engaged with the other flange on the body and the parts will be found to be very thoroughly secured together without soldering or brazing, and it is now ready for polishing by any proper means. A hole, *d*, is centrally cut through the obverse head, to enable the knob to be secured to the spindle.

If preferred, the obverse head and the body may be pressed from one piece, although I prefer to make the knob as described, as the loss in imperfect work will be materially lessened.

What I claim as my invention is—

The process of manufacturing door-knobs herein described, consisting in first forming and pressing the metal into sections, then securing the back section to the knob-socket by pressure, then similarly securing the body to the back portion, and finally securing the front section to the body, the securing means being of the material at the several points of contact, as specified.

CHARLES PUDDEFOOT.

Witnesses:

H. S. SPRAGUE,

E. SCULLY.