(No Model.)

H. C. HART.

ART OF MAKING SPOONS.

No. 458,168. Patented Aug. 25, 1891.

Fig. 1

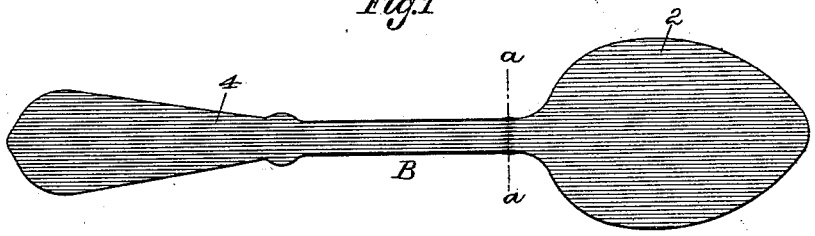


Fig. 4

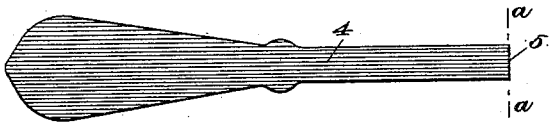


Fig. 2

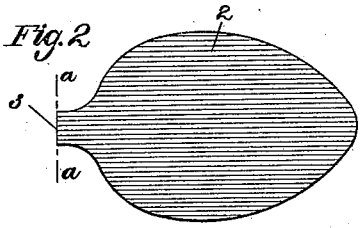


Fig. 5

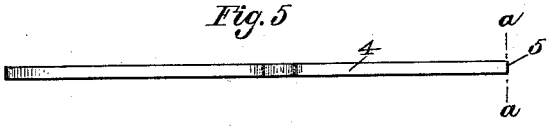


Fig. 3

Fig. 7

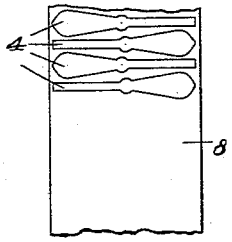


Fig. 6

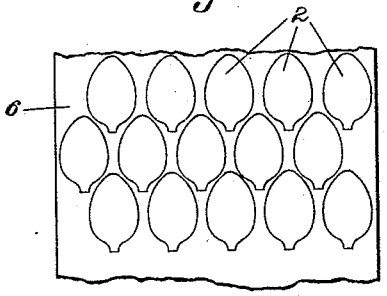


Fig. 8

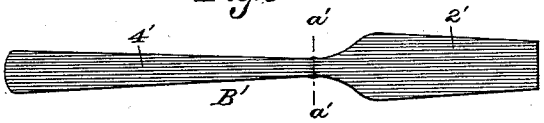
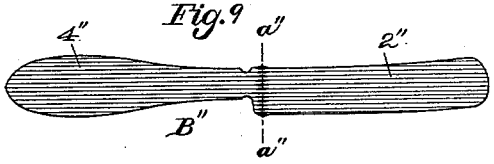


Fig. 9



Witnesses:

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ART OF MAKING SPOONS.

SPECIFICATION forming part of Letters Patent No. 458,168, dated August 25, 1891.

Application filed March 11, 1891. Serial No. 384,569. (No model.)

To all whom it may concern:

Be it known that I, HUBERT C. HART, a citizen of the United States, residing at Unionville, in the county of Hartford and State of Connecticut, have invented certain new and useful Improvements in the Art of Making Spoons, of which the following is a specification.

This invention relates to the manufacture of spoons or other like articles from sheet metal, the object being to furnish an improved method or process whereby the cost of the goods may be reduced by effecting a saving of metal and of labor, while maintaining or improving the quality of the manufactures.

In the drawings accompanying and forming a part of this specification, Figure 1 is a plan view of a spoon made according to my improvements and ready for the usual finishing operations. Fig. 2 is a plan view of the bowl-blank of the spoon. Fig. 3 is an edge view of the same. Fig. 4 is a plan view of the handle-blank of the spoon. Fig. 5 is an edge view of the same. Fig. 6 illustrates the manner of making the bowl-blanks by cutting out the same from a sheet of metal, the cuts being arranged contiguous to each other and oppositely disposed. Fig. 7 illustrates the manner of making the handle-blanks by cutting out the same from a sheet of metal, the cuts being arranged contiguous to each other and oppositely disposed. Fig. 8 is a plan view of a fork made according to my present invention and ready for the usual finishing operation. Fig. 9 shows a knife made according to my present invention.

Similar characters designate like parts in all the figures.

My present invention is designed for and is especially applicable to the manufacture of spoons from sheet metal; but it is also applicable to the manufacture of certain styles of forks and knives. Acordingly I have herein more fully described my improvements as applied to the manufacture of an ordinary dessert or table spoon, and have briefly illustrated the same as applied to the manufacture of said kinds of forks and knives.

When spoon-blanks are cut from a sheet of metal in the ordinary way, a very large proportion of the sheet metal, usually aggregating somewhat more than one-half of the same, is necessarily converted into scrap or waste, thereby entailing a great loss. According to my present improvements, the blank spoon B, Fig. 1, or other like article is divided on a line *a a* into two parts 2 and 4, each especially adapted to be cut from a suitable sheet of metal by the so-called "interlocking" method, with the least waste of material, said parts having the weld ends 3 and 5, respectively. By this method the spoon-blank is manufactured by the welding or soldering together of a separate bowl-blank and a separate handle-blank, the weld or other joining together being at the said line *a a*. The bowl-blanks 2 are cut out of one sheet of metal 6, Fig. 6, the successive cuts being arranged contiguous to each other in the sheet, thereby utilizing in the largest degree the sheet of bowl metal. In a similar manner the handle-blanks are cut out from a suitable sheet of handle metal 8 with a very slight waste. For making the handle-blanks a sheet of handle metal is provided of the required quality and thickness; and for making the bowl-blanks a suitable sheet of bowl metal is provided, which may be of a different quality, and should, for the ordinary kinds of spoons, be of a different thickness than for the handle-blanks. The making of the spoon-blank B of two separate blanks permits the use for each part of the kind of metal more especially adapted therefor by reason of its physical qualities and its cost.

By the old method of manufacturing spoons, forks, or knives, wherein the blank for the entire article is cut from the same sheet of metal, the bowls or blades of the articles are subjected to special treatment for spreading the metal to some extent, and thereby reducing the bowls or blades to suitable thicknesses relatively to the handles, this treatment consisting in rolling operations made especially for the purpose and representing a considerable percentage of the cost of shaping the spoon or other like article. By my improvement those special operations are avoided, being replaced by the simple and at the present time cheaper operation of welding.

In Fig. 8 the fork-blank B′ is composed of

the handle-blank 4′ and the blade-blank 2′, joined on the line a' a', after the method described in connection with Figs. 1 to 6, inclusive. In Fig. 9 is shown a knife-blank B″, similarly constructed by joining the separate handle and blade blanks 4″ and 2″, respectively, after the aforesaid method.

Having thus described my invention, I claim—

That improvement in the art of making spoons or like articles which consists in cutting out the bowl-blank from a sheet of bowl metal of one thickness and with the projecting weld end, cutting out a handle-blank from a sheet of handle metal of a different thickness and having a corresponding weld end, and welding the weld end of the bowl-blank to the weld end of the handle-blank, as set forth.

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