

No. 647,809.

Patented Apr. 17, 1900.

E. E. DAVENPORT.
MANUFACTURE OF PIECED TINWARE.

(Application filed Feb. 7, 1900.)

(No Model.)

Fig. 1

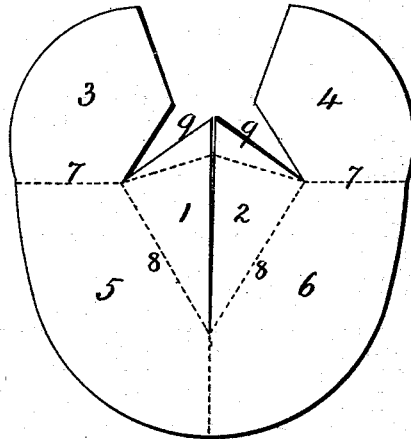
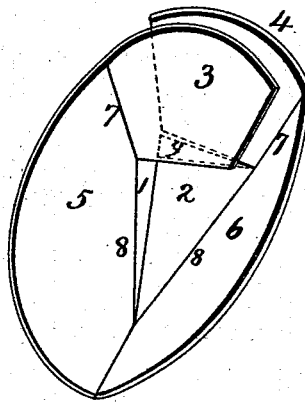


Fig. 2



WITNESSES

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MANUFACTURE OF PIECED TINWARE.

SPECIFICATION forming part of Letters Patent No. 647,809, dated April 17, 1900.

Application filed February 7, 1900. Serial No. 4,398. (No model.)

To all whom it may concern:

Be it known that I, ELMER E. DAVENPORT, a citizen of the United States, residing at Chicago, in the county of Cook and State of Illinois, have invented certain new and useful Improvements in the Manufacture of Pieced Tinware, of which the following is a specification, reference being had therein to the accompanying drawings.

My invention relates to the method of manufacturing "pieced tinware," in which a series of pieces or of seams are used, in contradistinction of "stamped tinware" or other articles which are seamless or stamped in one piece.

The objects of my invention are to produce articles intended to be finally of pieced and soldered tinned metal by my method out of black sheet metal, as sheet-iron or sheet-steel, by cutting, and, if necessary, by partially splitting the blank or pattern of said article of the required shape, bending said blank in any direction to obtain therefrom approximately the final form of the completed article, but with its edges or parts unconnected, and then coating with tin the faces and all the raw edges of the bent blank or disjointed article, and, lastly, bringing the joints or parts of the article in the positions they are to occupy finally and soldering them as ordinarily done in the manufacture of pieced tinware made of theterne or tin plates of commerce.

To illustrate the application of my invention to one article of manufacture, the blank of a sheet-metal scoop is shown in the accompanying drawings, in which—

Figure 1 is a plane top view of the black sheet-metal blank used to produce the scoop, the dotted lines showing where bends are to be made in the metal. Fig. 2 is a perspective view of the form given to the black sheet-metal blank by bending its component parts on the dotted lines of Fig. 1 before it is dipped in melted tin and after it is removed therefrom with its faces and edges coated with said tin.

The scoop shown is intended to have a reinforced back and bottom of two thicknesses of the metal, the bottom consisting of the two triangular parts 1 and 2. The part 1 in Fig. 2 constitutes the outside bottom and the part 2 the inside bottom. The two thicknesses at

the back are shown in the parts 3 and 4. They are bent from the sides 5 and 6 on the lines 7, so that they stand parallel to each other and about one-eighth of an inch apart. The sides 5 and 6 are bent from the triangular parts 1 and 2 of the bottom. On the rear ends of said triangular parts 1 and 2 are triangular lugs 9 to be turned up against the rear of the back 4. The parts 1 and 2 being substantially parallel to each other while the bent blank is being dipped in the melted tin, the whole surfaces of each part are coated on both sides without interfering with each other; but the bent blank may be lightly struck against the sides of the tin-holding tank or some part thereof to shake off any surplus tin, as this is done while tinning a bunch of small objects, as nails or tacks, and after the bent blank has become cold its bends are compressed slightly more by the operator's hands or by simple clamps to bring the joints in the positions they are to occupy finally, and said joints are soldered by well-known means. By this method of making pieced tinware there is no straining or rupture of the tin coating of the black metal at the bends of the blank and very little handling of the blank after it has been coated with tin. Therefore the finished article thereby escapes many scratches formed on tinware that has been cut and bent from the tin plates of commerce. There is also a great saving in not having to tin the scrap metal, which in the scoop shown forms a large part of the whole blank.

I am aware that many articles of tinware, particularly washbowls and cups, have been made of black sheet metal stamped and pressed to their final shape and then dipped into melted tin or zinc to coat them with said metals and that nails, tacks, and washers have been cut from black sheet metal into their final shape and afterward coated with tin; but their processes of manufacture are distinct from that necessary to make pieced tinware, which requires soldering in its construction, the black metal of which cannot ordinarily have its joints or parts soldered to complete the article.

Having now fully described my invention, I claim—

1. The method of manufacturing pieced

tinware which consists in cutting the blank parts of the article of black sheet iron or steel of the required shape, bending said blank parts in the approximately final forms necessary to construct the article, and tinning the bent or flat blank parts of the disjointed article, substantially as described.

2. The method of manufacturing pieced tinware which consists in cutting out of black sheet iron or steel the blank parts of the article, bending said blank parts in not their final forms, but in forms approximately like

the final forms to be given to the article, tinning the bent or flat blank parts of the disjointed article, and closing and soldering the joints or parts, whereby the article is completed substantially as described.

In testimony whereof I affix my signature in presence of two witnesses.

ELMER E. DAVENPORT.

Witnesses:

J. W. GHISELIN,
R. M. BARBER.