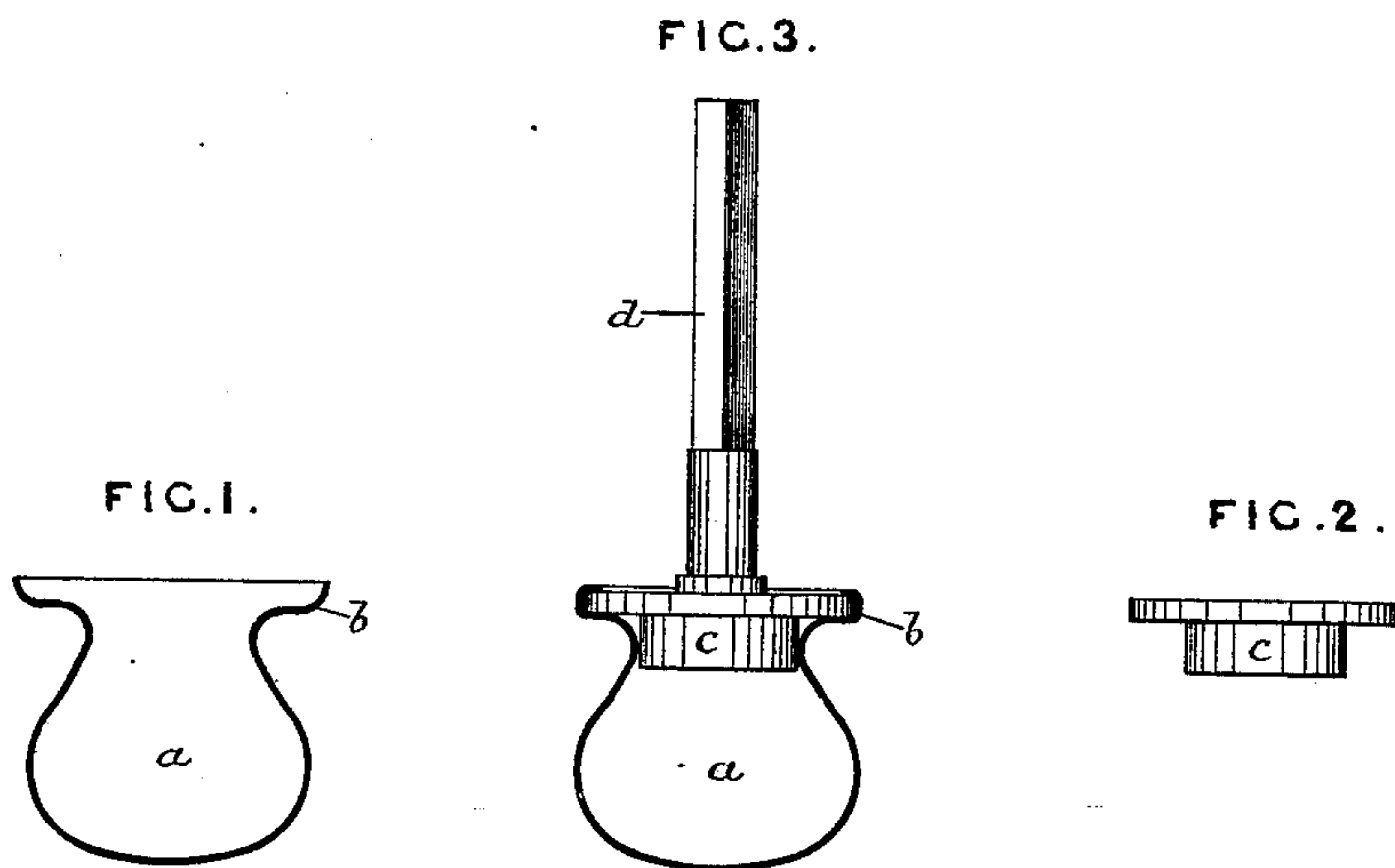


W. S. DACKUS.
Manufacture of Door-Knobs.

No. 222,251.

Patented Dec. 2, 1879.



WITNESSES=

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UNITED STATES PATENT OFFICE.

WILLIAM SEAGER DACKUS, OF BIRMINGHAM, GREAT BRITAIN, ASSIGNOR
TO HENRY PAYTON, OF SAME PLACE.

IMPROVEMENT IN THE MANUFACTURE OF DOOR-KNOBS.

Specification forming part of Letters Patent No. **222,251**, dated December 2, 1879; application filed August 5, 1879; patented in England, May 27, 1879.

To all whom it may concern:

Be it known that I, WILLIAM SEAGER DACKUS, a resident at Birmingham, in the county of Warwick, in the Kingdom of Great Britain, have invented certain Improvements in the Manufacture of Brass Door and other Metal Knobs, of which the following is a specification.

The object of this invention is so to construct brass door and other metal knobs of a similar kind that they may be more durable and may be produced at less cost than those made according to the general mode of manufacture. Hitherto these knobs have been usually made with a brass neck, cast, and attached to the front part thereof; but this is found to cause a waste of material, and in wear the stamped part of the knob is often found to become loose and detached from its cast brass neck.

Now, according to my invention, I construct the knob and its neck from a single piece of sheet metal, and I do this by stamping the blank to a much higher or greater degree than has hitherto been accomplished for that purpose. I then, by the operation of spinning, form the knob into the shape required, and then by the same kind of operation secure or inclose the front end of the said neck into or upon a suitably-shaped pommel, which is furnished either with a suitable groove formed within it or a rim formed thereon to receive the before-described neck.

In order that my invention may be clearly understood, I have prepared drawings thereof, which I will now to proceed to describe.

Figure 1 represents, in section, a knob, *a*, and its neck *b*, made from one piece of sheet metal, according to my invention.

Fig. 2 represents, in elevation, a pommel, *c*, which may be made of any suitable shape, and of either cast or wrought metal.

Fig. 3 shows, in section, the flange of the neck *b*, spun upon the pommel *c*, so as completely to embrace and inclose the edge thereof, and firmly to unite the two parts. *d* is the stem or spindle, which may be fixed into the pommel *c* in the usual manner.

What I claim is—

The within-described mode of constructing door-knobs of metal and attaching the same to their pommel, the same consisting in first stamping and spinning the knob into the required shape, together with its neck as an integral, and then spinning the neck upon the pommel, as herein shown and set forth.

WILLIAM SEAGER DACKUS.

Witnesses:

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