

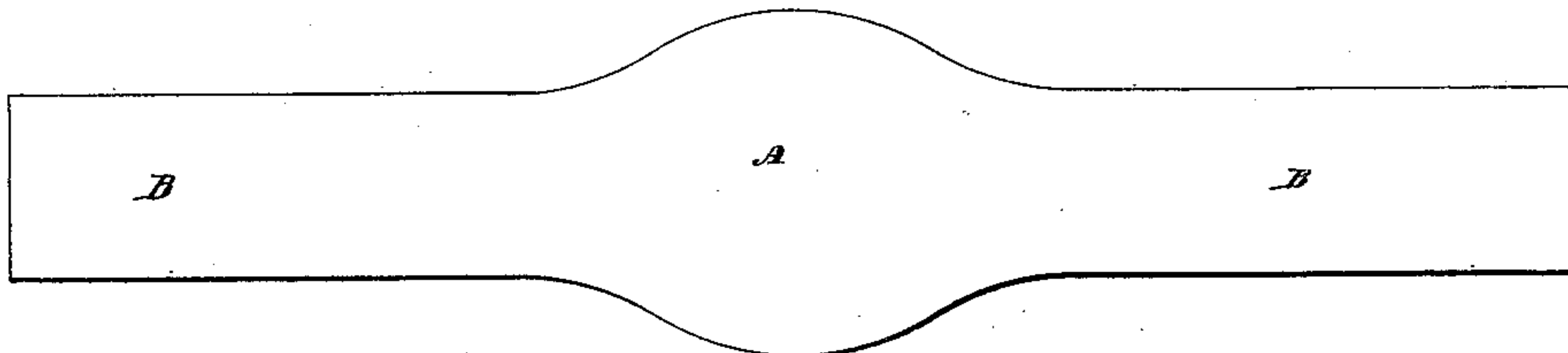
(No Model.)

H. C. HART.  
MANUFACTURE OF CUTLERY HANDLES.

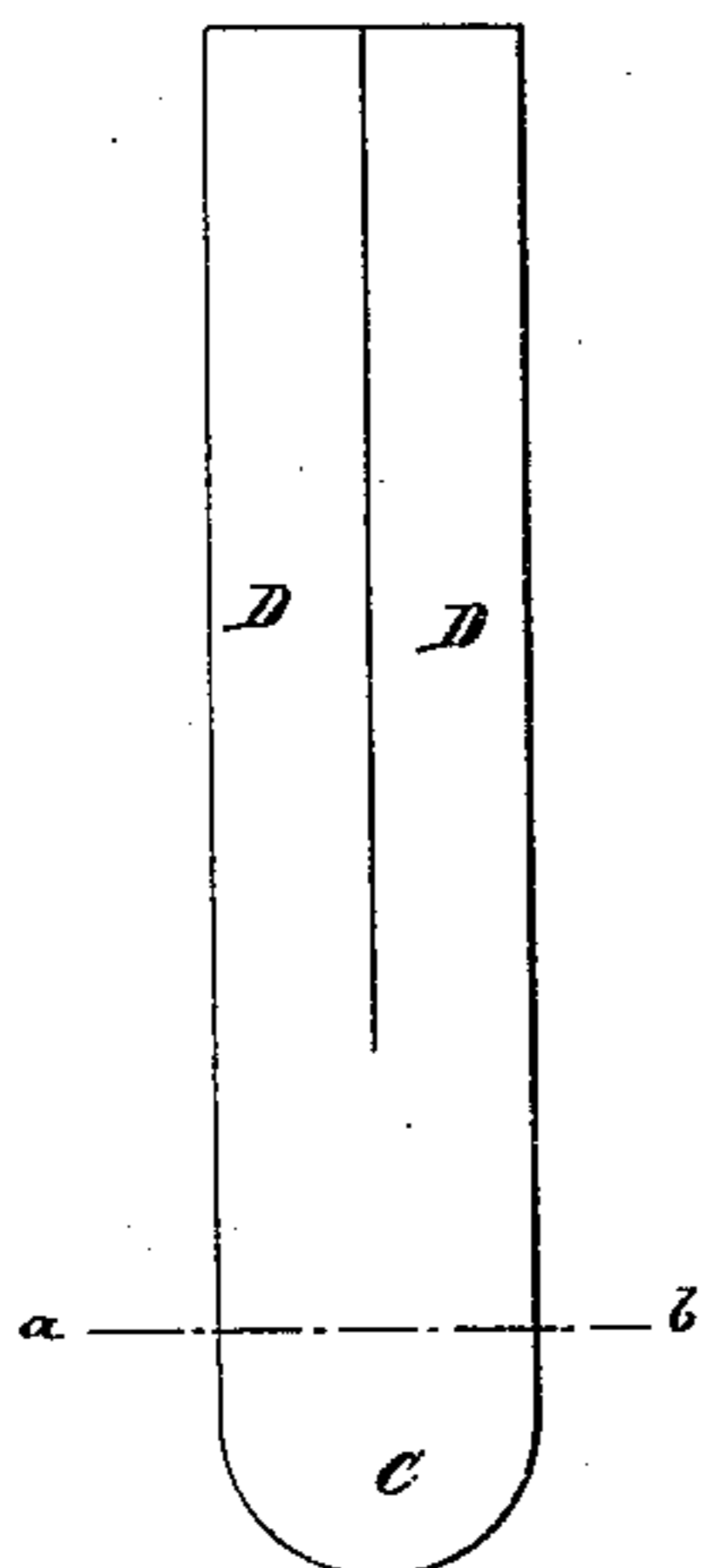
No. 410,834.

Patented Sept. 10, 1889.

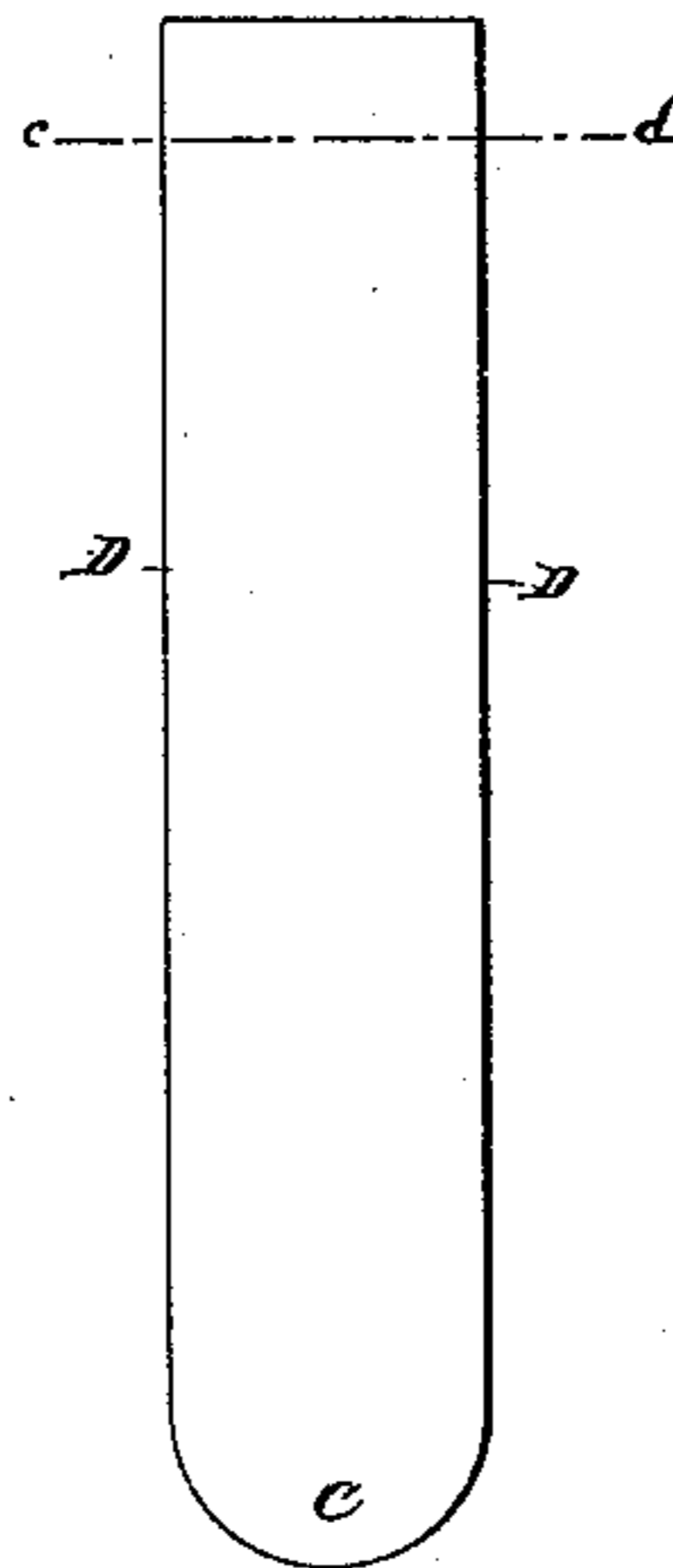
*Fig. 1*



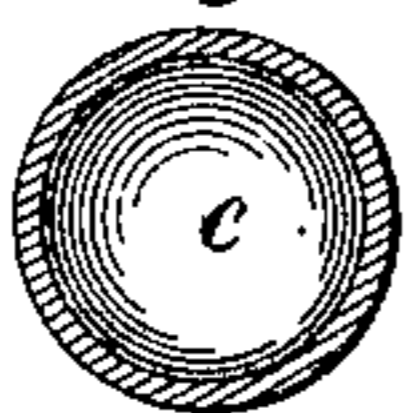
*Fig. 2*



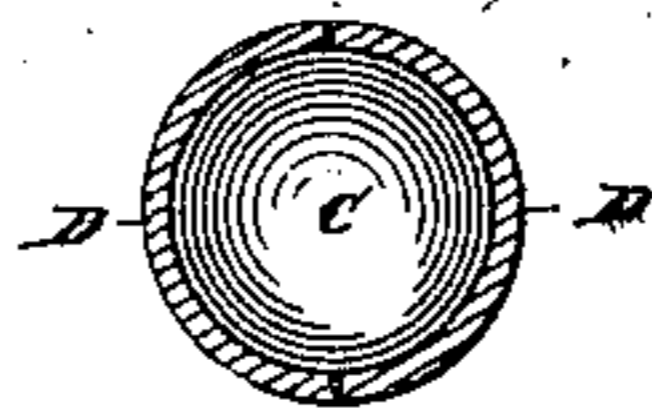
*Fig. 3*



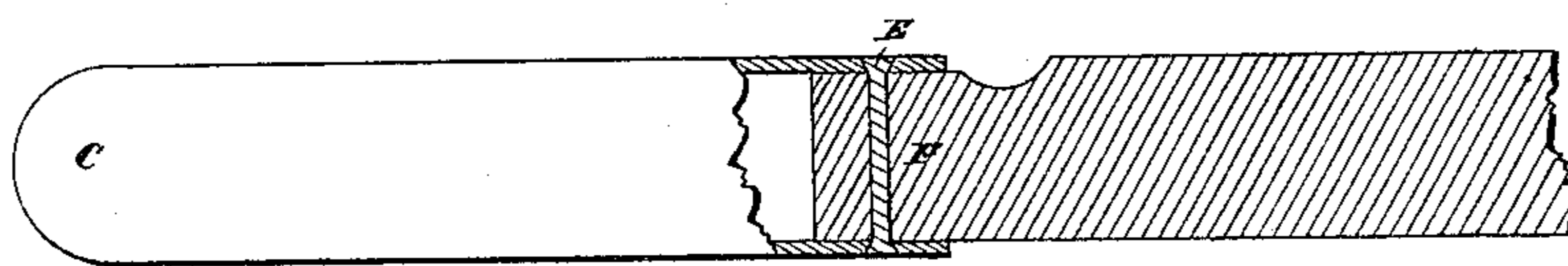
*Fig. 4*



*Fig. 5*



*Fig. 6*



Witnesses:  
*Chas. B. Shumway.*  
*M. S. Seely.*

Inventor  
*Hubert C. Hart.*  
By *George D. Seymour*  
Att'y.

# UNITED STATES PATENT OFFICE.

HUBERT C. HART, OF UNIONVILLE, CONNECTICUT.

## MANUFACTURE OF CUTLERY-HANDLES.

SPECIFICATION forming part of Letters Patent No. 410,834, dated September 10, 1889.

Application filed March 13, 1889. Serial No. 303,109. (No model.)

*To all whom it may concern:*

Be it known that I, HUBERT C. HART, residing at Unionville, in the county of Hartford and State of Connecticut, have invented certain new and useful Improvements in Handles for Cutlery; and I do declare the following to be a full, clear, and exact description of the same, reference being had to the accompanying drawings, which form a part of this specification.

My invention relates to an improvement in handles for cutlery, and particularly for knives and forks, the object being to produce a strong, durable, and light article at small cost.

With these ends in view my invention consists in certain new methods for forming handles for cutlery from a blank of peculiar shape, which will be hereinafter described and claimed.

In the accompanying drawings, Figure 1 is a plan view of my improved handle-blank. Fig. 2 is a view in side elevation of a handle developed from such a blank. Fig. 4 is a view in transverse section, on the line *a b*, through the drawn end of the handle. Fig. 3 is a view in side elevation of the handle after it has been welded and finished. Fig. 5 is a view in transverse section, on the line *c c*, through the welded part of the handle; and Fig. 6 is a view showing how the handle is assembled with another part, a knife-blade being chosen for illustration.

As herein shown, the blank consists of a flat piece of sheet metal having an enlarged central portion A and two narrow straight-edged leaves B, having square ends and extending in opposite directions from the said central portion, the curved edges whereof merge into them. This blank is subjected to a drawing and forming operation, whereby its enlarged central portion is drawn out into a hollow rounded seamless end C, and whereby its leaves are longitudinally folded to form the sides D D, which are brought together edge to edge and constitute a continuation of the drawn end of the handle. It will be understood that the blank will be proportioned and shaped so that these results will occur when it is drawn and folded. After the handle has been developed its leaves are

welded or otherwise secured together, after which its whole exterior surface is finished. Preferably a rivet E is passed through the said leaves and the bolster F of the part to which the handle is to be united. After this the whole thing is hot-welded in dies.

A handle constructed as described cannot leak at its end, whereas the ordinary hollow handle having a seamed end is very liable to leak, on account of the difficulty of perfectly uniting the parts on a curved line. My improved handles also wear better than a handle having its end seamed, because the finish always wears off the seam sooner than elsewhere and exposes the seam. The handle is also easy to form and finish, and when done is of fine appearance.

I would have it understood that I do not limit myself to the exact construction shown and described, but hold myself at liberty to make such changes and alterations as fairly fall within the spirit and scope of my invention.

Having fully described my invention, what I claim as new, and desire to secure by Letters Patent, is—

1. A sheet-metal blank for cutlery-handles, consisting of an enlarged central portion having outwardly-curved side edges adapted to be drawn into a cup to form a seamless butt-end for the handles, and two corresponding leaves extending in opposite directions from the said central portions, having straight edges and of uniform width throughout and adapted to be folded to form the upper part of the handle, substantially as set forth.

2. A method of making cutlery-handles, consisting in part in drawing the central portion of a suitable blank into a cup forming a seamless butt-end for the handle, and transversely and longitudinally folding the two ends of the blank to conform them to the exterior curvature of the cup and to bring them into line with the length thereof.

3. A method of making cutlery-handles, consisting in drawing the central portion of a blank into a cup and transversely and longitudinally folding the two ends of the blank and uniting the edges of the said folded ends.

4. A method of making cutlery-handles, consisting in drawing the central portion of

a suitable blank into a cup and transversely and longitudinally folding the two ends of the blank and coupling the said folded edges by a transverse rivet.

- 5 5. A method of making cutlery-handles, consisting in drawing the central portion of a suitable blank into a cup and transversely and longitudinally folding the two ends of the blank, coupling the said folded ends by  
10 a transverse rivet, hot-welding their edges to-

gether in dies, and finally finishing the handle.

In testimony whereof I have signed this specification in the presence of two subscribing witnesses.

HUBERT C. HART.

Witnesses:

GEORGE D. SEYMOUR,  
CHAS. B. SHUMWAY.