

(No Model.)

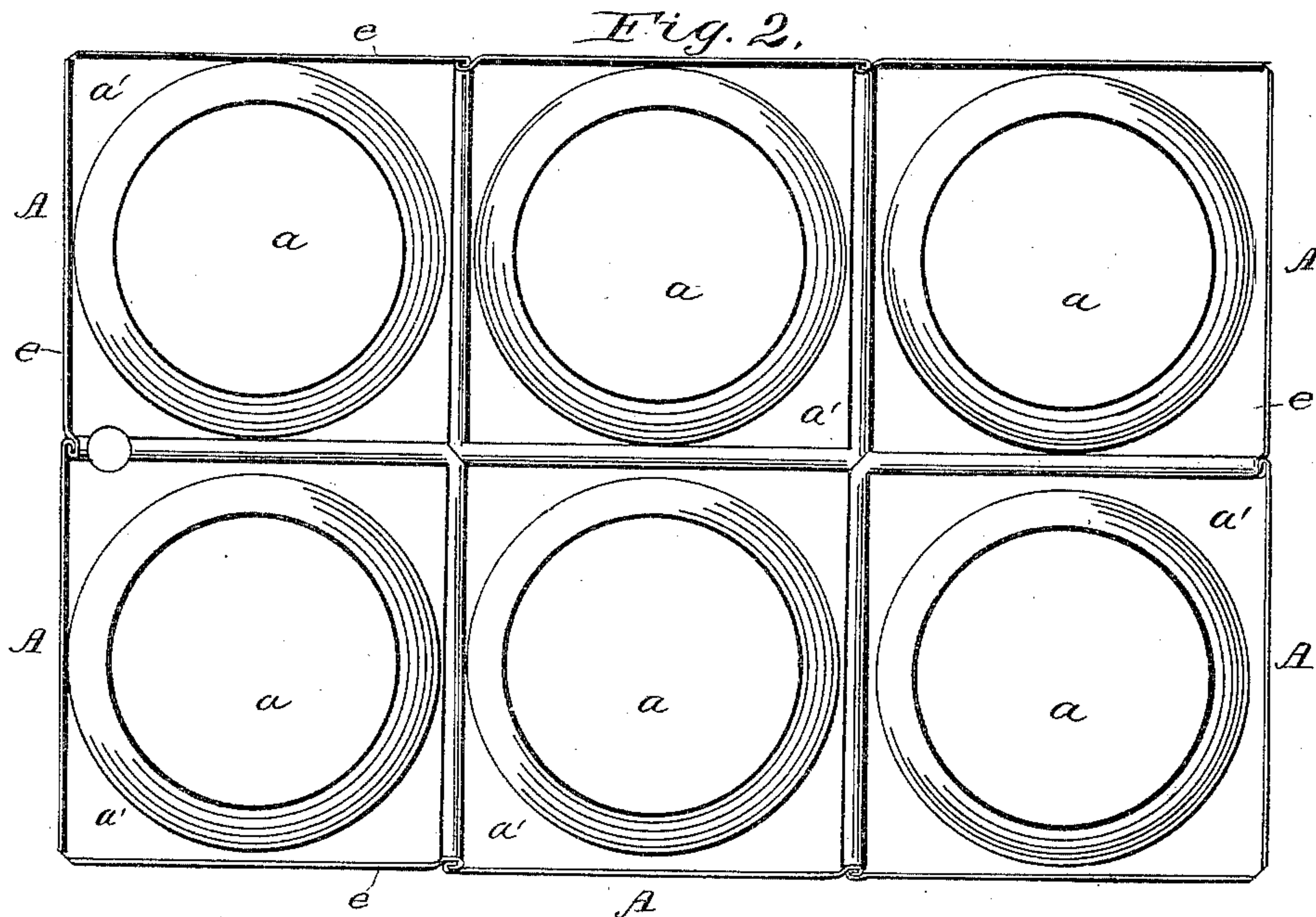
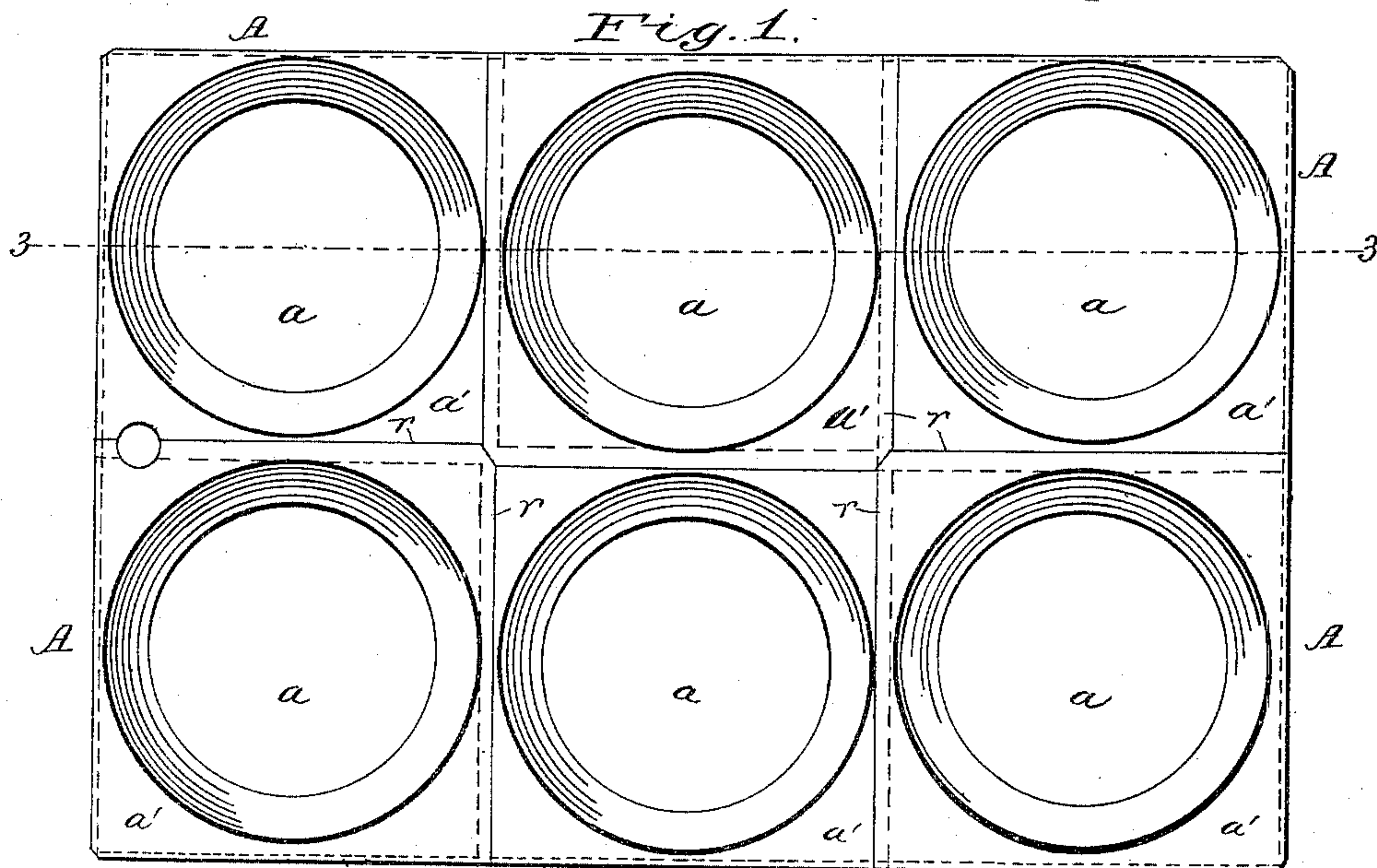
2 Sheets—Sheet 1.

C. L. WAGANDT.

METHOD OF MAKING MUFFIN OR BAKE PANS.

No. 436,883.

Patented Sept. 23, 1890.



Witnesses:  
D. H. Curry.  
Ed. Sturtevant.

Inventor,  
Chas. L. Wagandt,  
by Smith & Low  
attys.

(No Model.)

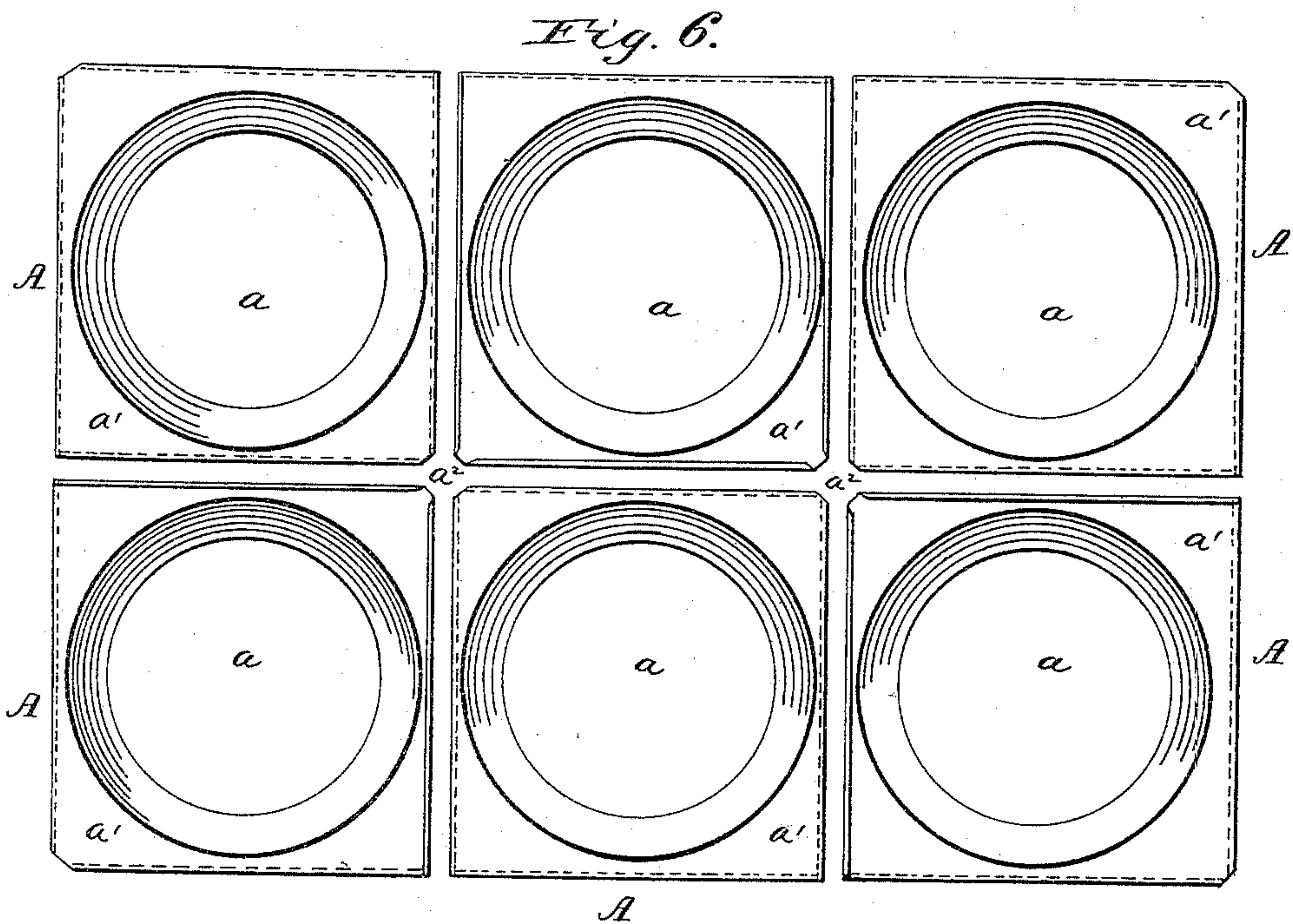
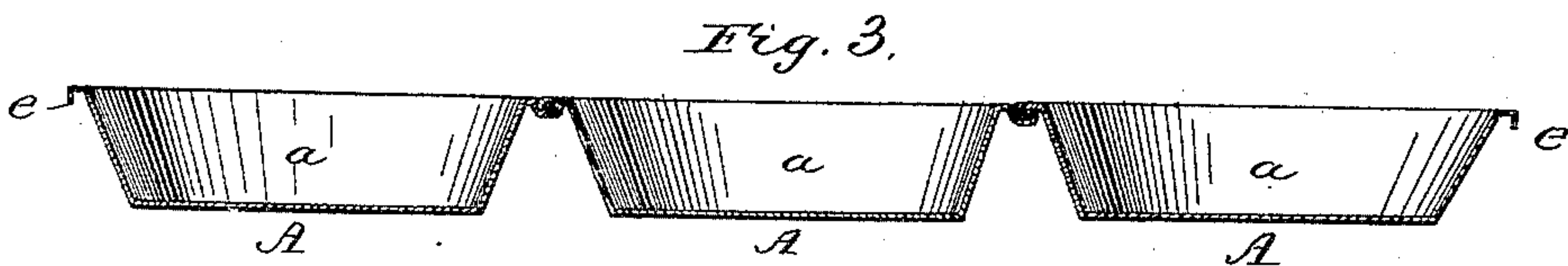
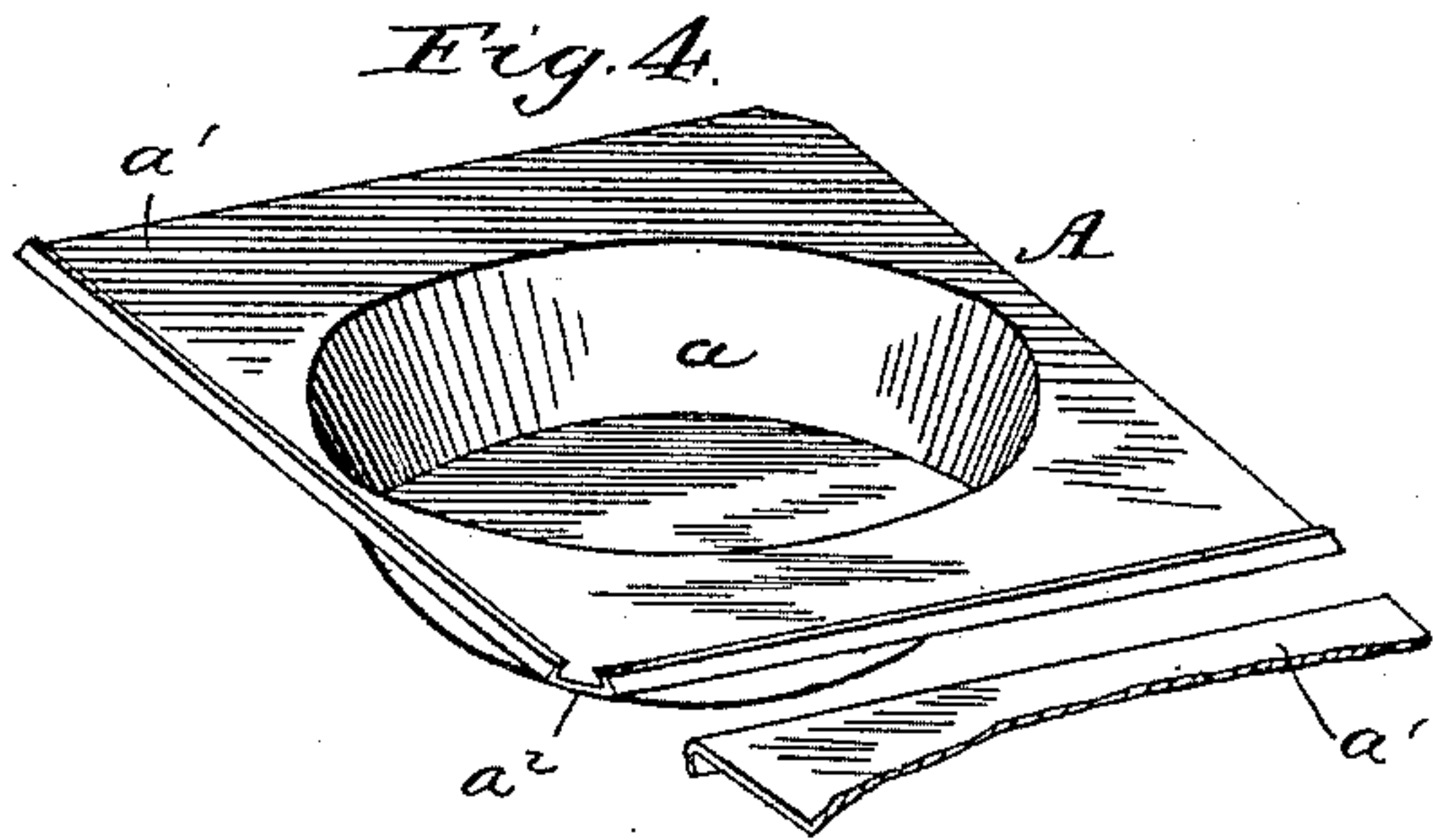
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# UNITED STATES PATENT OFFICE.

CHARLES L. WAGANDT, OF BALTIMORE, MARYLAND, ASSIGNOR OF ONE-HALF TO KEEN & HAGERTY, OF SAME PLACE.

## METHOD OF MAKING MUFFIN OR BAKE PANS.

SPECIFICATION forming part of Letters Patent No. 436,883, dated September 23, 1890.

Application filed December 23, 1889. Serial No. 334,709. (No model.)

*To all whom it may concern:*

Be it known that I, CHARLES L. WAGANDT, a citizen of the United States, residing at Baltimore city, in the State of Maryland, have invented certain new and useful Improvements in the Method of Making Muffin or Bake Pans; and I do declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it appertains to make and use the same.

My present invention relates to a method of making muffin or bake pans formed of as many separate pieces as there are depressions or muffin-compartments, said pieces being united directly to each other by seaming without the use of solder, rivets, or independent connecting-pieces. In this article of manufacture I have thus effected a very material economy of tin and of time and labor requisite for the production of a bake-pan.

In order to make my invention more clearly understood, I have shown in the accompanying drawings means for carrying the same into practical effect.

In said drawings, Figure 1 is a plan view of a muffin or bake pan embodying my invention. Fig. 2 is a bottom plan view of the same. Fig. 3 is a vertical sectional view on line 3 3, Fig. 1. Fig. 4 is a perspective view of one of the sections of which the pan is composed. Fig. 5 is a sectional view, upon an exaggerated scale, illustrating the seam by which the sections of the pan are united. Fig. 6 is a top view of the sections properly arranged, but not joined together.

Referring to the drawings, A indicates the sections, each of which is drawn and stamped in the usual manner by suitable dies to form a circular and slightly-conical recess or compartment *a*, surrounded by a horizontal flange *a'*. The material used will preferably be tin or sheet-iron. The compartment having thus been formed, the edges of the flange *a'* are trimmed so that each section will be polygonal, preferably rectangular, in shape. The corners of said flanges are then slightly trimmed off, as indicated at *a*<sup>2</sup>, to permit the subsequent seaming.

Supposing that a pan is to be formed

comprising six compartments and sections, (though any desired number of the sections may be united in a single pan,) as illustrated in the drawings, the edges of the flanges *a'*, which are to connect with each other in the final position of the sections in the pan, are bent over, as indicated at *b*. In Fig. 4 the flange is represented as bent upward; but the flange of the next contiguous section upon its edge which is to be connected with said bent-up flange will be bent downward. The sections being hooked together by their bent flanges are then seamed together, either by hand or, preferably, by a suitable machine, in such manner that each section is securely locked in place by seams running at an angle to each other. As shown in Fig. 5 upon an exaggerated scale, the flanges, whose edges are bent upward, are further bent to form rabbets *r*, running parallel with and just inside of the bent edges. The bent edge *s* of the adjoining section rests in said rabbet, and the top surface of all of the flanges *a'* are thus brought into the same horizontal plane, giving the pan an even surface and an even bottom. The sections being oppositely flanged, as above described, the seaming together above mentioned is performed by pressure applied to the top and bottom surfaces of the pan, and the dies which perform this operation will, besides completing the seams between the sections, bring the top surface of the pan into a single plane and perfect the article at this one operation. By reason of said rabbet *r* the seams are of such character that the sections cannot be disunited by pressing them toward each other any more than by pulling them in directions away from each other. As a finish to the whole article and to still further stiffen the pan and lock the sections together, the edge of the pan formed by the outer edges of all of the flanges *a'* is bent downward, as indicated at *e*. The result is a bake-pan of very strong and rigid construction of neat appearance, which has a complete or continuous upper surface adapted to prevent dough or batter from rising over the edges of the compartments and dropping through between the

sections, which is made without rivets or separate joining or seaming pieces, and which may be very economically manufactured.

Having thus described my invention, what  
5 I claim is—

The herein-described method of making a muffin or bake pan, consisting of a plurality of separate sections, which consists in first forming a number of such sections each with  
10 a recess or compartment *a* and a flange *a'*, then bending the edges of said flanges upon

the sections alternately upward and downward, and then seaming together the flanges thus bent to form a complete flat-topped pan, substantially as set forth.

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

CHARLES L. WAGANDT.

Witnesses:

JNO. T. MADDOX,

WM. W. RICHARDSON.