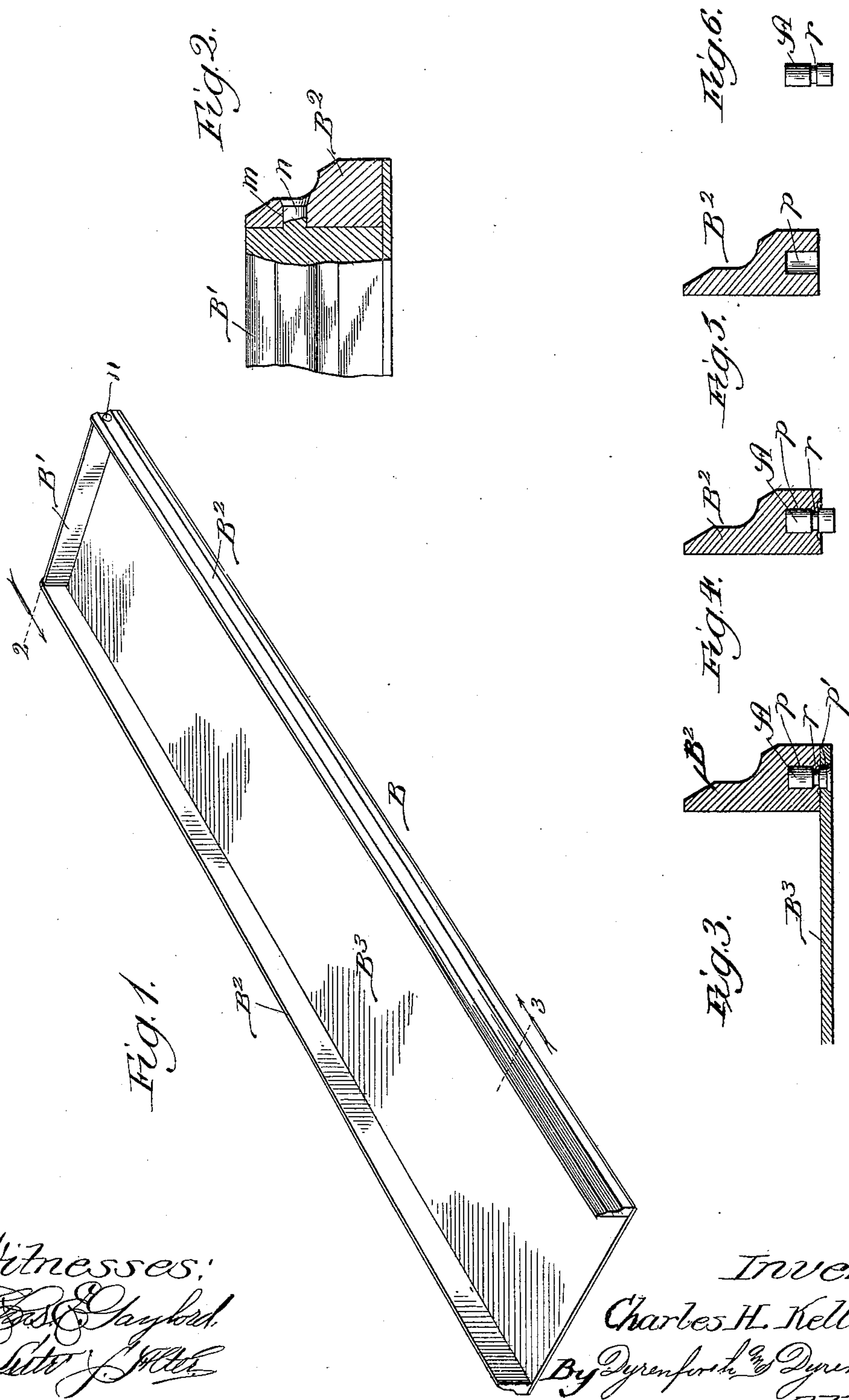


(No Model.)

C. H. KELLERMAN.
RIVETED METAL ARTICLE.

No. 599,903.

Patented Mar. 1, 1898.



Witnesses:
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UNITED STATES PATENT OFFICE.

CHARLES H. KELLERMAN, OF KENOSHA, WISCONSIN, ASSIGNOR TO THE
CHICAGO BRASS COMPANY, OF SAME PLACE.

RIVETED METAL ARTICLE.

SPECIFICATION forming part of Letters Patent No. 599,903, dated March 1, 1898.

Application filed June 30, 1897. Serial No. 643,025. (No model.)

To all whom it may concern:

Be it known that I, CHARLES H. KELLERMAN, a citizen of the United States, residing at Kenosha, in the county of Kenosha and State of Wisconsin, have invented a new and useful Improvement in Riveted Metal Articles, of which the following is a specification.

The object of my invention is to facilitate riveting together the parts of articles formed of soft metal and requiring to be fastened together by riveting and at the same time to afford secure and durable fastening of the rivets in the parts to which they are applied.

My invention may be applied with advantage to any of various articles of the kind referred to, though I have devised it more especially with relation to a printer's galley having the side and end pieces and the bottom plate composing its several parts formed of brass, and because of that to illustrate my invention I show it in connection with a printer's galley in the accompanying drawings, in which—

Figure 1 is a perspective view of a printer's galley formed in accordance with my improvement; Fig. 2, a broken section taken at the line 2 on Fig. 1 and viewed in the direction of the arrow; Fig. 3, a broken section taken at the line 3 on Fig. 1 and viewed in the direction of the arrow; Fig. 4, a view like that presented by Fig. 3, but previous to fastening the bottom plate in place; Fig. 5, a similar view showing the part containing a rivet-hole, but before inserting and fastening the rivet therein; and Fig. 6, a view in elevation of the rivet.

To apply my invention in forming a riveted metal article, I provide a rivet A of brass or other suitable metal, which may be of the cylindrical shape illustrated or of any other desired shape, with a recess *r* preferably extending entirely about the rivet and nearer one end than the other.

B', B², and B³ are parts or sections of the article the sections of which are to be riveted together, and which in the instance illustrated are respectively the end piece, the side pieces, and the bottom plate of a common form of printer's galley B. In the sections B' and B²

holes *p* are formed at proper intervals and to

the desired depth, as by drilling, in the sides or, in the present instance, the bases of the parts to admit the rivets A, which are inserted up to the outer ends of the recesses *r*, or thereabout, into these holes. Thereupon a suitable or ordinary setting-tool or "set" (not shown) is applied over the projecting end of each rivet against the surface of the part about the hole into which the rivet has been inserted, and force is applied to the tool to cause it to spread the material of such part immediately surrounding such hole into and crowd it in the recess *r* of the rivet, as shown in Figs. 3 and 4, thus firmly binding it in its rivet-hole. Then, in the case of a printer's galley, the bottom plate B³, preparatorily provided with holes *p'* at intervals to cause them to coincide with the projecting ends of the rivets in the parts B' and B², is applied thereto to cause the holes *p'* to fit over the projecting rivet ends, which latter may then be upset, as shown by Fig. 3, in a usual or any suitable way or otherwise fastened to secure the several parts together.

For the sake of economy and for practicability each rivet-hole in a section B' or B² is drilled simultaneously with the corresponding rivet-hole in the bottom plate B³, and the holes in each section are necessarily of the same diameter to receive the sections of a rivet on opposite sides of its recess *r*, which rivets, being formed for the sake of economy by cutting them from a wire of uniform diameter throughout, are necessarily of the same diameter at opposite sides of their recesses.

In the example of article illustrated in the drawings the end piece B' is shown to be provided at each end with a tongue *n*, entering and upset in a slot *m* near one end of each side piece B² to afford additional fastening together of these parts.

By the term "soft" herein employed to qualify the metal for use with which my invention is adapted is meant all such metals as are susceptible of being spread in the manner or substantially in the manner described into a recess in a rivet.

What I claim as new, and desire to secure by Letters Patent, is—

In a sectional metal article having its sec-

100

tions fastened together by riveting, the coinciding rivet-holes in each two of said sections, of the same diameter throughout, and rivets A having recesses r and inserted at one end
5 into and fastened in the rivet-holes of one of said sections by the metal about said holes upset into said recesses and having their other

ends inserted into and fastened in the rivet-holes of the other of said sections, substantially as described.

CHARLES H. KELLERMAN.

In presence of—

R. T. SPENCER,
J. H. LEE.