No. 763,663. PATENTED JUNE 28, 1904.

S. J. EDMISTON.

METHOD OF MAKING HEADS FOR BROOMS.

APPLICATION FILED MAY 23, 1903.

NO MODEL. 2 SHEETS—SHEET 1.

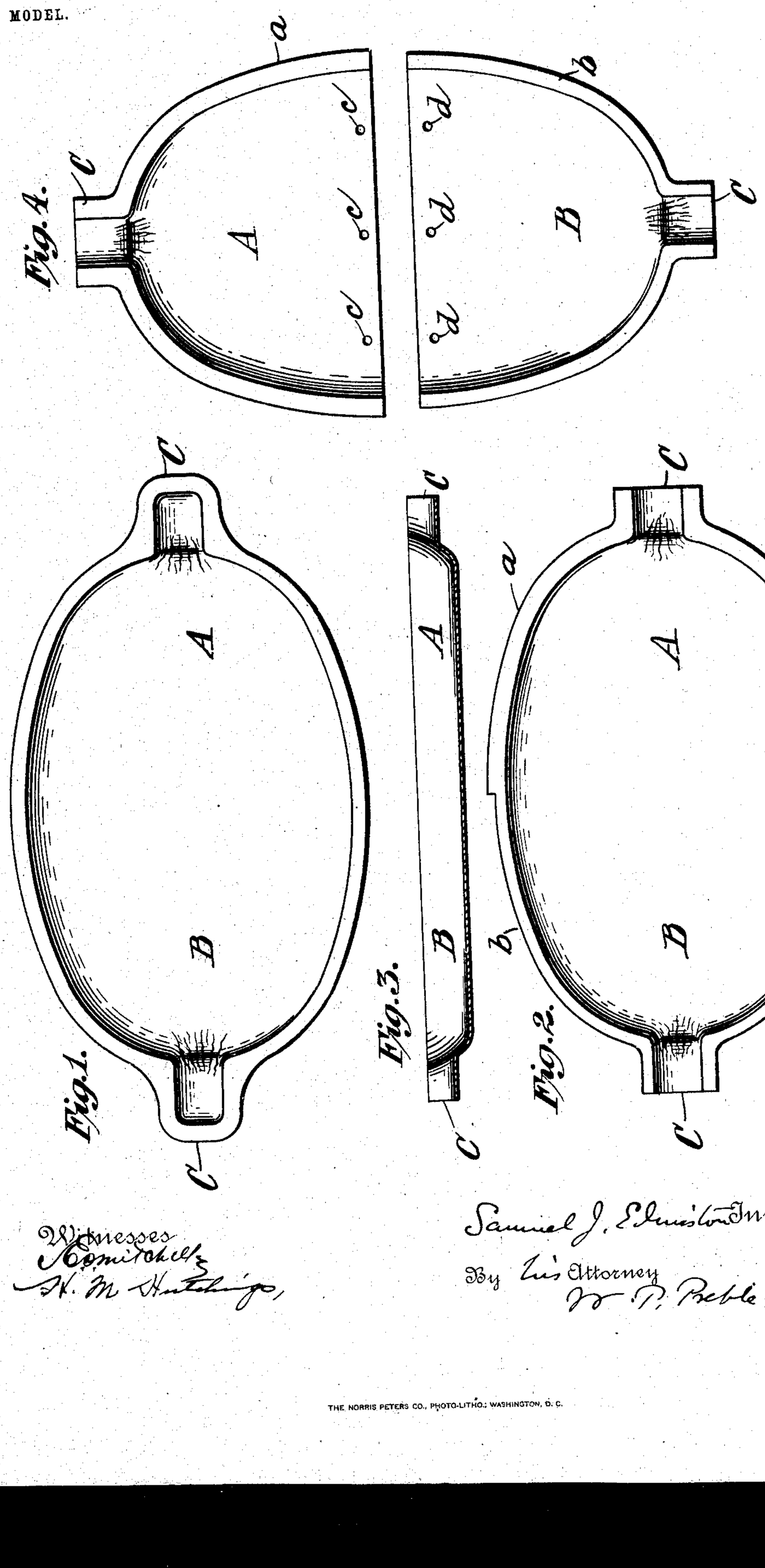

Fig. 4.

Fig. 1.

Fig. 3.

Fig. 2.

Witnesses
Edmitchell
H. M. Hutchings

Samuel J. Edmiston Inventor
By his Attorney
W. P. Preble Jr

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NO MODEL. 2 SHEETS—SHEET 2.

Fig. 7.

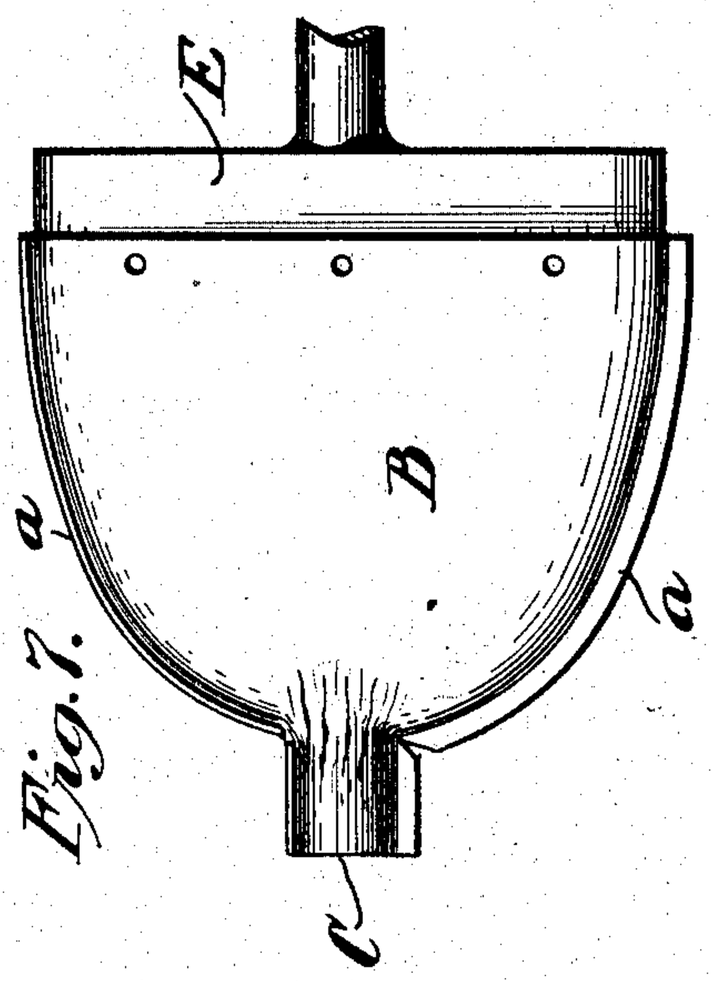

Fig. 9.

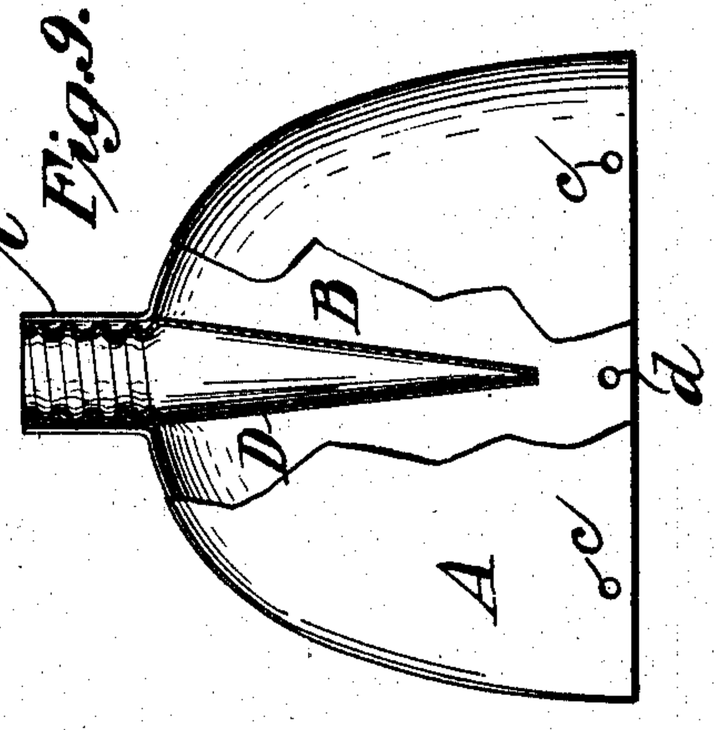

Fig. 5.

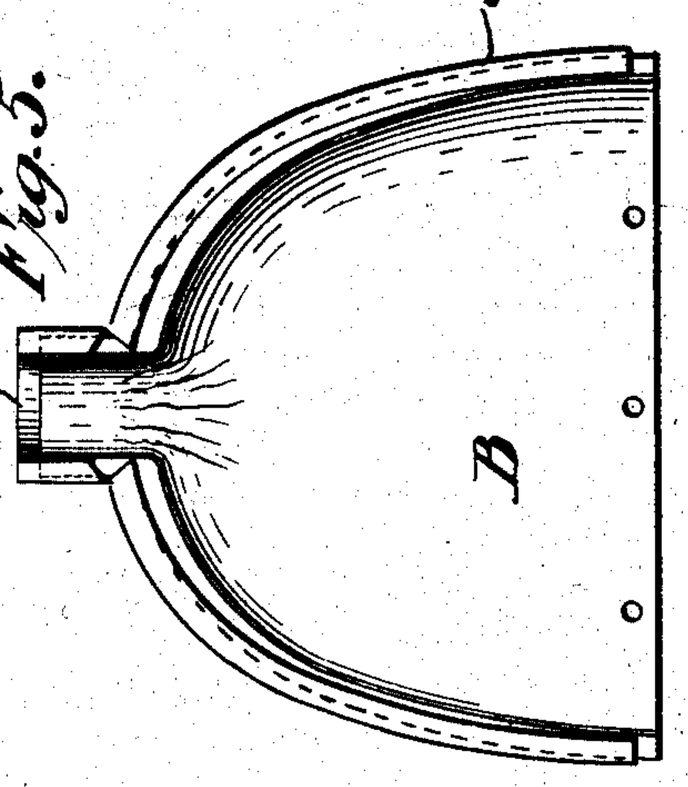

Fig. 6.

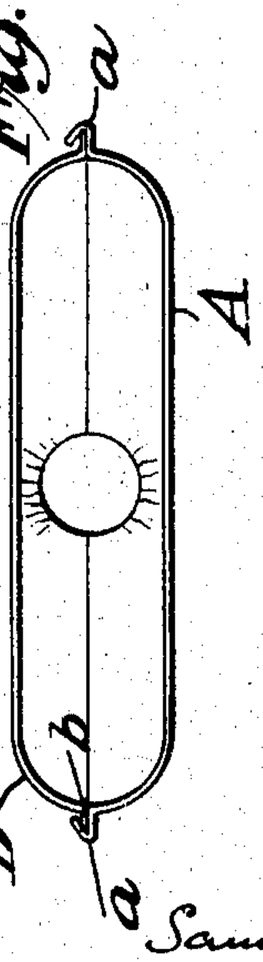

Fig. 8.

Witnesses
E. Mitchell
S. M. Hutchinson

Samuel J. Edmiston Inventor
By his Attorney
W. P. Preble Jr

No. 763,663. Patented June 28, 1904.

UNITED STATES PATENT OFFICE.

SAMUEL J. EDMISTON, OF GREENWICH, NEW YORK.

METHOD OF MAKING HEADS FOR BROOMS.

SPECIFICATION forming part of Letters Patent No. 763,663, dated June 28, 1904.

Application filed May 23, 1903. Serial No. 158,399. (No model.)

To all whom it may concern:

Be it known that I, SAMUEL J. EDMISTON, a citizen of the United States, and a resident of Greenwich, Washington county, New York State, have invented certain new and useful Improvements in Methods of Making Heads for Brooms, of which the following is a specification.

The object of my invention is to provide a method of making heads for brooms whereby such an intimate union is secured between all parts of the inside of the case or head and the corn-straws of which the broom is composed that there is no corner or crevice in which any dust or other unclean or unsanitary substance can find a lodging-place. At the same time the heads or cases made by my improved method are light, durable, cheaply made, and of uniform structure.

My improved method of making heads for brooms consists, primarily, in stamping out and drawing from a sheet of metal a blank provided with a peripheral flange and depressed to correspond to half the cross-section of the case or head to be formed, cutting said blank in two portions midway of its length, and trimming the flanges to adapt them for interlocking each other, associating the two portions thus formed together by interlocking the said flanges and forming a complete broom head or case by forcing the interlocking flanges into intimate union, thereby forming a durable seam. It will be readily understood that this method may be applied to broom-heads of different figuration; but the form which I have found most satisfactory, both for manufacturing purposes and use, is made with tapering and rounded shoulders, as shown in the accompanying drawings, in which—

Figure 1 is a top view of the blank as first stamped and drawn from a sheet of suitable material, preferably tin. Fig. 2 is a top view of said blank after the flanges have been trimmed, which is preferably done by placing the blank of Fig. 1 under a second die. Fig. 3 is a longitudinal section of Fig. 2. Fig. 4 is a top view illustrating the next stage of the operation, which consists in separating the blank into two pieces and perforating each piece along the cut edge. Fig. 5 is an elevation showing the two halves of the case nearly put together by slipping the narrow flange of one half into the doubled-over flange of the other half. Fig. 6 is an end view. Fig. 7 illustrates the next step of the operation—namely, the formation of a permanent seam along the meeting edges of the two halves of the case by compressing the flanges into close contact. Fig. 8 is a detail of the broom-handle socket. Fig. 9 is an elevation, partly broken away, of the complete broom-head.

The same letters indicate similar parts in the different figures.

A is one half the body portion of the case. B is the other half.

C C are the two portions of the neck for receiving a handle.

D D represent a tapering screw-socket separately formed and adapted for insertion in the neck.

The portion A is provided with a peripheral flange *a*, which is somewhat wider than the peripheral flange *b* of the other body portion B. The flange *a*, therefore, can be bent over upon itself, so as to inclose the flange *b*, as shown in Fig. 6. The perforations *c c* of the portion A correspond with the perforations *d d*, so that when the two portions are brought together to form a case the fastening-wire can be passed through from side to side to draw the case down upon the broom-corn.

E is a former upon which the seam is compressed, as shown in Fig. 7, the upper half being shown as compressed, while the lower half is not yet acted upon.

Although shown in various stages, for the sake of clearness two or more of these stages may be performed simultaneously as one operation of the machine adapted for that purpose. For example, the blank shown in Fig. 1 may be formed by one operation from the sheet of metal and the blank of Fig. 2 by a second, or the original die might draw and cut the blank shown in Fig. 2 directly from the sheet of tin. On the other hand, the severing of the two portions shown in Fig. 4 and the perforating thereof might form part of the operation of cutting the blank of Fig. 2 from the blank of Fig. 1. The association of

these two halves, as shown in Fig. 5, is done by hand after the bending over of the flanges, as shown in Fig. 6, which is preferably done by machinery. The compression of the seam, as shown in Fig. 7, may be either with a revolving former or horn, in which case one-half is done at a time, or on a stationary horn, in which case both sides may be compressed at once.

I claim—

A method of forming heads for brooms which consists first in stamping out and drawing from a sheet of metal a blank provided with a peripheral flange and depressed to correspond to half the cross-section of the case or head to be formed; second cutting said blank into two portions midway of its length, and trimming the flange on one portion so that it may be caused to interlock with the flange of the other portion, associating the two portions thus formed, together, by interlocking the said flanges; compressing the interlocked flanges into intimate union, and lastly inserting a suitable handle-socket whereby a complete broom-head is formed.

SAMUEL J. EDMISTON.

Witnesses:
W. P. PREBLE, Jr.,
H. M. HUTCHINGS.