

UNITED STATES PATENT OFFICE.

JULIUS F. KENKEL, OF CANANDAIGUA, NEW YORK, ASSIGNOR TO
GEUDER & PAESCHKE MANUFACTURING COMPANY, OF MIL-
WAUKEE, WISCONSIN, A CORPORATION OF WISCONSIN.

MANUFACTURE OF ENAMELWARE.

SPECIFICATION forming part of Letters Patent No. 779,655, dated January 10, 1905.

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To all whom it may concern:

Be it known that I, JULIUS F. KENKEL, a citizen of the United States, residing at Canandaigua, in the county of Ontario and State of New York, have invented new and useful Improvements in the Manufacture of Enamelware, of which the following is a specification.

My invention relates to processes for manufacturing enamelware and the like, in which a coating of enamel of some kind is deposited upon a plate; and the object of my invention is to provide means to distribute the coating upon the plate and also to so distribute the coating that when finished it will present a mottled, wavy, spotted, or other variegated appearance.

The following specification will describe in detail the manner in which I accomplish my object.

Hitherto a great number of devices have been employed to obtain a mottled, wavy, or variegated effect upon enamelware, some by oxidizing the base of the article or plate by adding acid or sulfates to the enamels or by powdering salts on the enamels or, again, by using enamels containing particles of coloring oxids or enamel kernels of different size, which are sprinkled or spattered on the plates, or by dipping them in enamels prepared to stay suspended in water for some time and then manipulating the article by hand to produce a wavy effect.

In carrying out my process I first prepare the enamel of any well-known compositions or colors, then slush or dip the article to be enameled in the enameling compound, and fire in the usual way. On top of this ground I slush a second coat of enamel of any color and when yet in a wet state subject the enamel to a current of compressed or forced air against the surface, thus disturbing the evenness of the enamel on the plate by forcing the current of air against the enamel coating on the article and distributing the enamel unevenly upon the plate, thereby causing a wavy or uneven surface of the enamel. I have been able to produce the same wavy effect upon a plate with one coat of enamel only; but the effect is more pleasing by using two or more

coats with contrasting colors. Also pleasing effects may be produced by slushing the first or ground coat and then slushing or dipping the article again in enamel of different colors and using the air-jet to disturb the even layer of the second coat, and thereby producing a mottled, wavy, or variegated appearance in different colors, or I may use several contrasting colors on the ground or in the second coat and then use the air to variegate or mix the colors and form a wavy or streaked appearance. After the enamel has been distributed by the air it is then dried and fired in the usual manner. It is manifest that any kind of blower to distribute the enamel may be used, as an ordinary bellows or blowers or air-compressors with removable nozzles of different shapes and sizes adapted to deliver a fine jet of air or a heavy jet or any other kind of air-jet and under different pressures.

It will be readily understood that by my process these wavy and different-colored effects may be produced at a very small cost and very rapidly and upon one or more coats of the enamel. Besides, the article may be produced with less enamel and in a very large variety of styles and colors.

Having now described my invention, what I claim is—

1. A process for the manufacture of enamelware, consisting of coating the plate to be enameled with a preparation of enamel and burning the same, then slushing the coated, and burned plate in an enamel preparation and then distributing the enamel by a blast of air.

2. A process for the manufacture of enamelware, which consists in applying a series of coatings of enamel to the plate to be enameled and firing the same, then applying a coat of colored enamel, subjecting the same to a blast of air to spread and disturb the evenness of the enamel, and then firing the same.

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

JULIUS F. KENKEL.

Witnesses:

ALBERT BAUM,
P. A. MAYLAHN.