F. W. PARKER.

CRANK MAKING.

APPLICATION FILED MAR. 15, 1909.

929,241. **Patented July 27, 1909.**

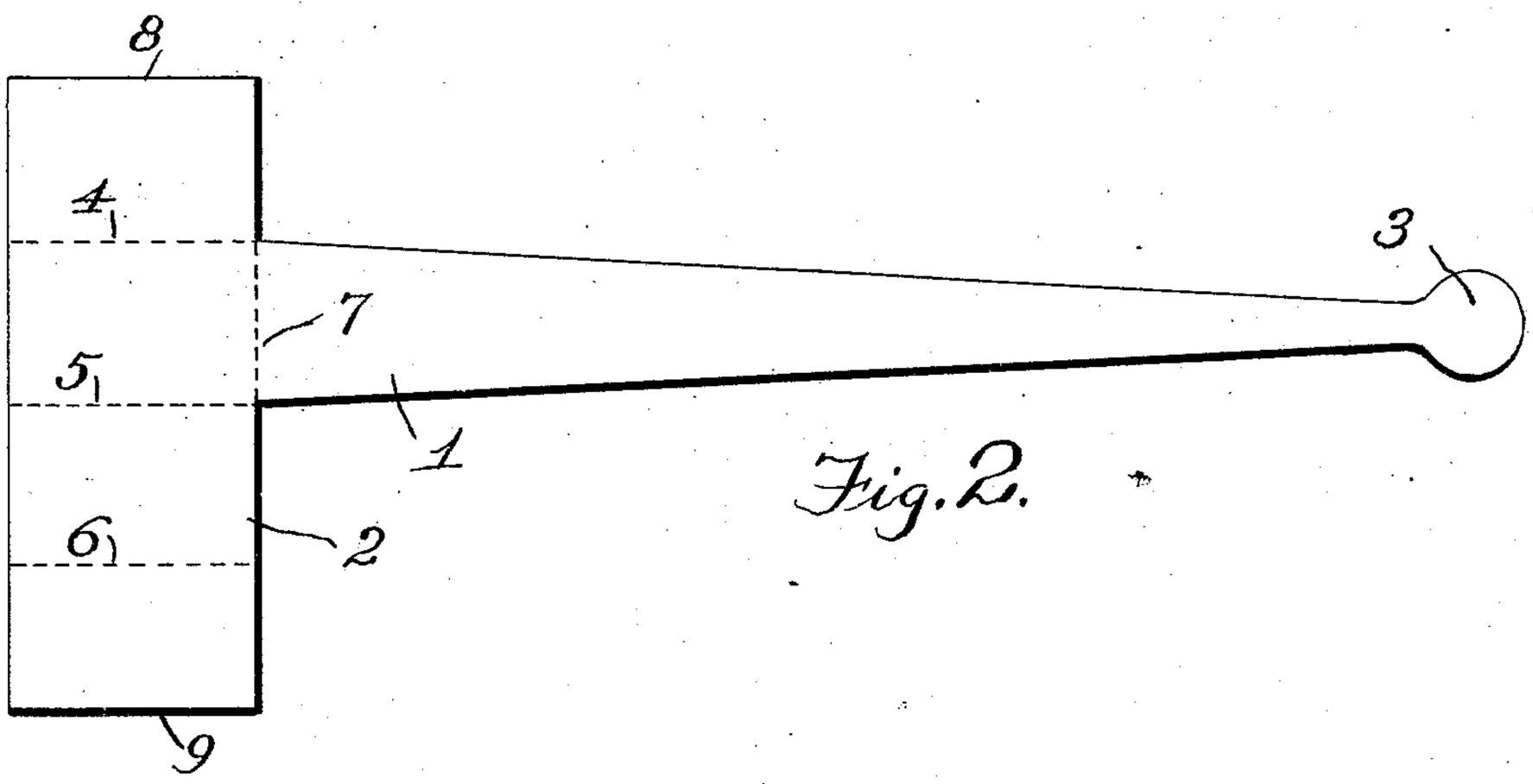

Fig. 2.

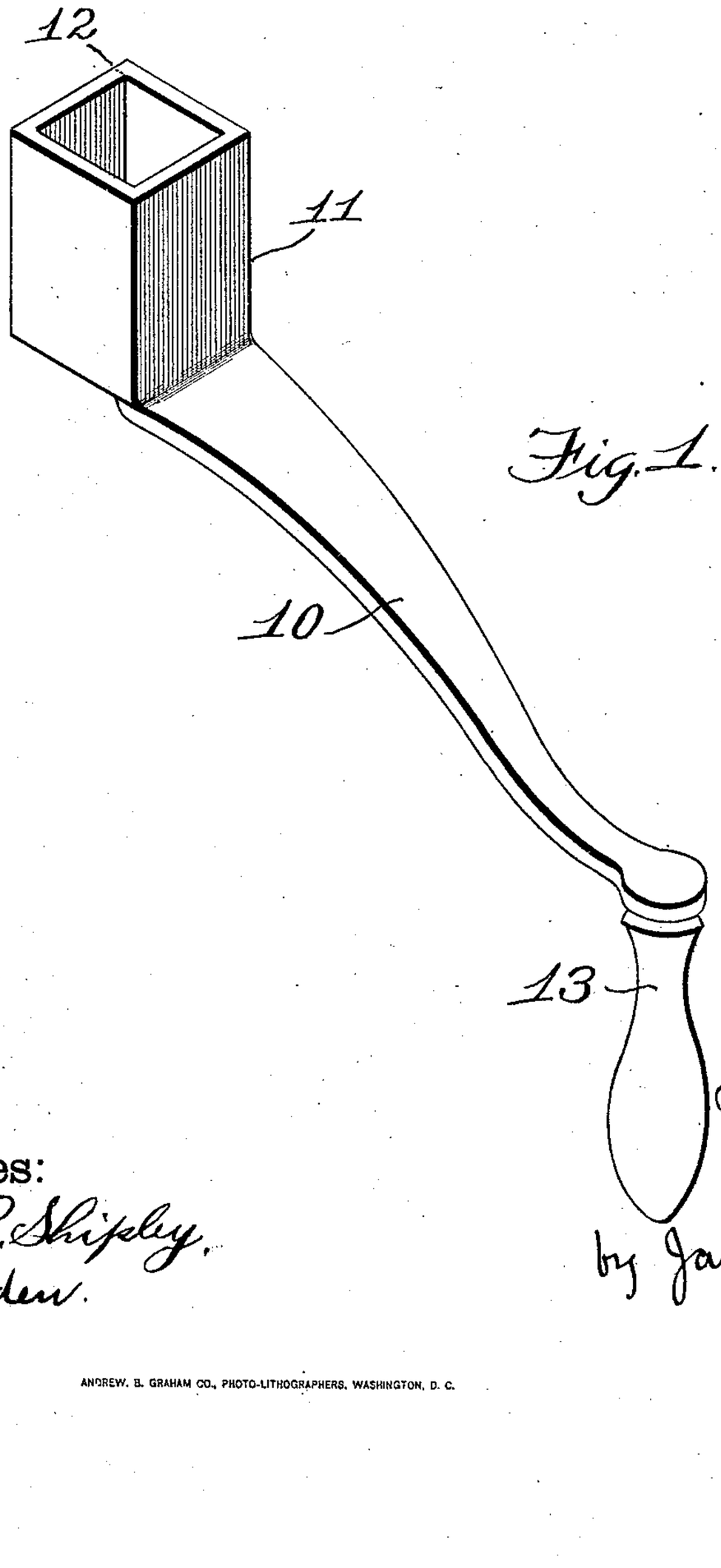

Fig. 1.

Witnesses:
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UNITED STATES PATENT OFFICE.

FRANK WESLEY PARKER, OF NEW YORK, N. Y., ASSIGNOR TO NILES-BEMENT-POND COMPANY, OF JERSEY CITY, NEW JERSEY.

CRANK-MAKING.

No. 929,241. Specification of Letters Patent. Patented July 27, 1909.

Application filed March 15, 1909. Serial No. 483,399.

To all whom it may concern:

Be it known that I, FRANK WESLEY PARKER, a citizen of the United States, residing at New York, New York county, New York, have invented certain new and useful Improvements in Crank-Making, of which the following is a specification.

This invention, pertaining to improvements in the method of making machine cranks will be readily understood from the following description taken in connection with the accompanying drawing in which:—

Figure 1 is a perspective view of a complete crank produced by my improved method: and Fig. 2 a plan of the blank from which the crank is to be formed.

The crank, with the exception of the handle, is formed by bending and seaming a suitably shaped sheet metal blank.

In Fig. 2 of the drawing:—1, indicates, generally, the sheet metal blank from which the crank is to be formed, the same involving a long lever portion: 2, a tee-portion formed at one end of the lever portion of the blank, the width of this tee-portion, in a direction lengthwise of the lever portion, being equal to the depth required for the socket of the crank: 3, the end of the lever portion opposite the tee-portion, the same being preferably somewhat enlarged: 4, 5 and 6, bending lines on the tee-portion of the blank, these lines lying parallel with each other and with the axis of the lever portion: 7, a bending line at the juncture of the lever portion with the tee-portion of the blank; and 8 and 9 the end extremities of the tee-portion of the blank.

The blank having been produced it is to be bent upon the lines 4, 5 and 6 to bring edges 8 and 9 into contact to form a non-cylindrical socket, as indicated at 11 in Fig. 1, the juncture of the ends 8 and 9 of the tee-portion of the blank being indicated at 12 in Fig. 1. The lever portion of the blank is then to be bent on line 7 till the lever portion lies at substantially right angles to the socket and the lever portion is then, if desired, to be curved outwardly from the socket as indicated at 10, Fig. 1. The juncture 12 is now to be seamed preferably by electric welding, and the handle 13 is to be secured, as by electric welding, to the extremity of the lever portion. The crank having been completed, in the manner indicated, may be finished up to any desired extent. For rough work it may be left without further finishing, and for medium work, it may be subjected to the action of the templet, and for finer work it may be polished up by usual processes.

I claim:—

The improvement in crank making consisting in producing a sheet metal blank having a lever portion and a tee-portion at one end of the lever portion, bending the tee-portion of the blank on lines parallel with each other and to the length of the lever portion so as to form a non-circular socket, bending the lever portion at substantially right angles to the socket at the point where the lever portion joins the socket, seaming the juncture of the approached end extremities of the tee-portion of the blank, and securing a handle to the end of the lever portion opposite the socket, substantially as set forth.

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