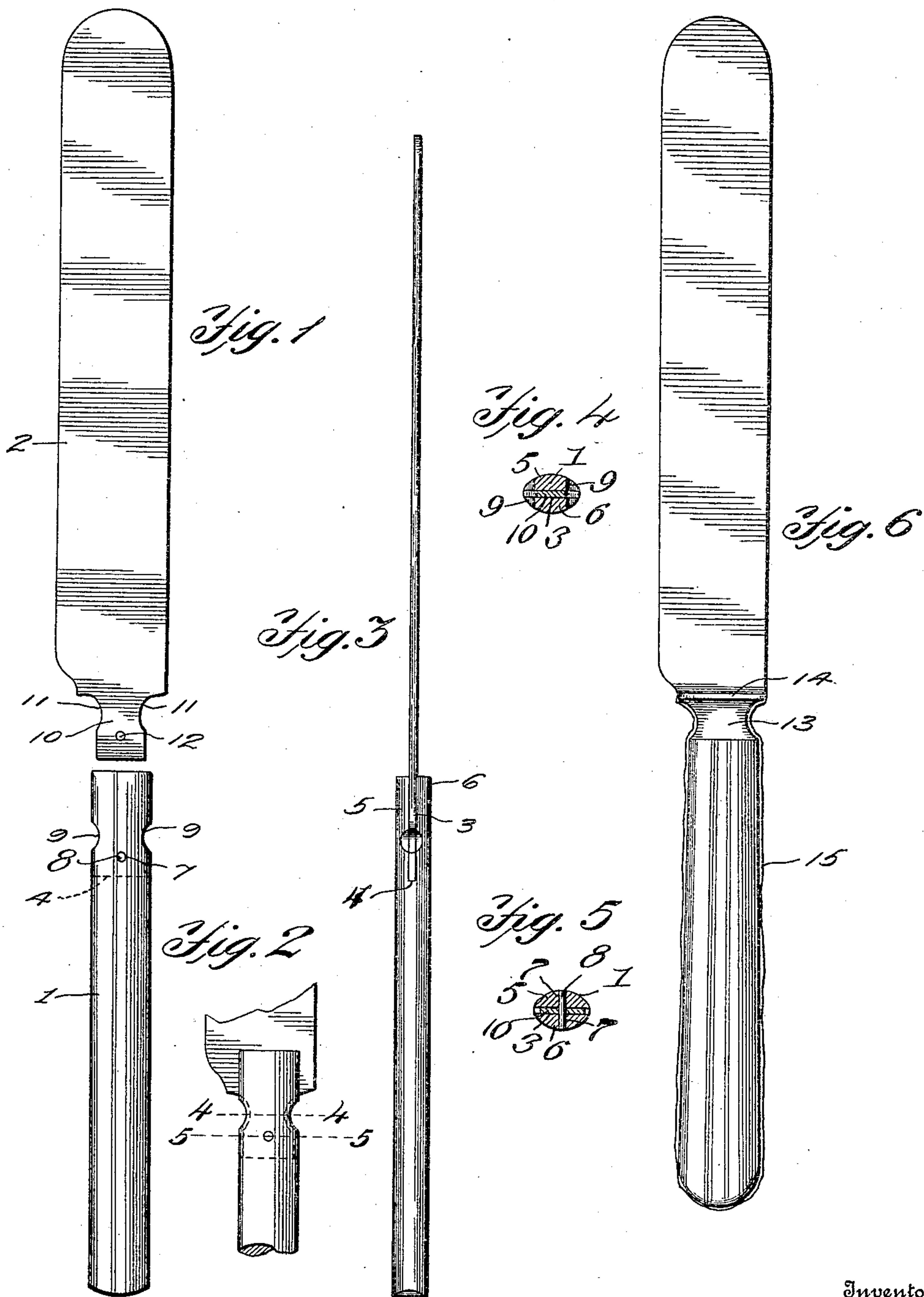


C. E. PECK.  
METHOD OF MAKING TABLE KNIVES.  
APPLICATION FILED JULY 10, 1907.

931,471.

Patented Aug. 17, 1909.



Witnesses

*R. C. Clafflin*

*C. C. Hines*

Inventor

*Charles E. Peck*

By *Victor J. Evans*

Attorney



# UNITED STATES PATENT OFFICE.

CHARLES E. PECK, OF YALESVILLE, CONNECTICUT, ASSIGNOR TO C. I. YALE MANUFACTURING CO., OF YALESVILLE, CONNECTICUT, A CORPORATION OF CONNECTICUT.

## METHOD OF MAKING TABLE-KNIVES.

No. 931,471.

Specification of Letters Patent.

Patented Aug. 17, 1909.

Application filed July 10, 1907. Serial No. 383,099.

*To all whom it may concern:*

Be it known that I, CHARLES E. PECK, a citizen of the United States, residing at Yalesville, in the county of New Haven and State of Connecticut, have invented new and useful Improvements in Methods of Making Table-Knives, of which the following is a specification.

This invention relates to a method of making table knives of that character in which the knife is formed of primarily independent handle and blade sections which are welded together.

The main object of the invention is to provide a novel method of joining the independent blank members by which the handle may be formed of a material inferior to that of the blade and the two combined in a manner to lock them firmly together and produce a completed knife which will in all respects be similar to the more expensive one-piece knives.

In the accompanying drawing, illustrating the invention:—Figure 1 is a plan view of the handle and blade blanks as they appear before assembled. Fig. 2 is a similar view of the same assembled. Fig. 3 is an edge view of the assembled blanks. Figs. 4 and 5 are cross sections on the lines 4—4 and 5—5 of Fig. 2. Fig. 6 is a view of the complete knife ready for the finishing process.

Referring to the drawing, the numeral 1 designates the handle and 2 the blade of the knife having the primary form shown in Fig. 1. The handle blank 1 is cut out from a bar of metal, and is cut or incised at its forward end to provide a vertical longitudinal slot 3, the rear wall of which constitutes a stop shoulder 4. The side walls 5 and 6 of said slot are formed with registering openings 7 for the passage of a fastening rivet 8, as hereinafter described, and in advance of said openings the top and bottom edges of said walls are cut away to provide partially circular notches or recesses 9 terminating at their forward ends about midway of the distance between the shoulder 4 and front ends of the walls 5 and 6.

The slot 3 is adapted to receive a tang 10 formed upon the rear end of the blank 2, said tang being of less length than the length of the slot, so that when it is inserted therein, as shown in Figs. 2 and 3, with its rear edge abutting against the shoulder 4, the forward

portions of the walls 5 and 6 will extend beyond said tang and lap over upon the rear end of the body of the blade. The edges of the tang 10 are cut away to provide partially circular recesses 11 of somewhat greater length and depth than the corresponding recesses 9 of the handle blank 1 and so disposed thereon as to come opposite said recesses when the blade is fitted to the tang, as illustrated in Fig. 2. In the tang is formed an opening 12 for the passage of the rivet 8; said opening being located just in rear of the line of the rear ends of the recesses 11.

In the primary operation of forming the knife, the tang 10 of the blade is slipped longitudinally into the slot 3 until it abuts against the shoulder 4, after which the rivet 8 is applied and its ends upset flush with the faces of the walls 5 and 6 to fasten the blade in position. The tang 10 is of less width than the slot, so that, by reference to Fig. 2, it will be noted that the edges of the tang extend inwardly from the edges of the walls 5 and 6. After the parts are combined and fastened together by the rivet 8 in the manner above described, the blanks are permanently united by the process of a drop forging, the shape of the dies being such as to impart to the completed knife, as shown in Fig. 6, the usual form, in which the handle is connected with the blade by a reduced neck 13 circularly of a concaved form, and reinforced at its point of junction with the rear edge of the blade by side ribs 14. In this operation of drop forging, the blade is flattened out throughout its entire length and a fin or rough edge 15 produced by the action of the dies, as will be readily understood by those versed in the art. This is removed in the final operation by grinding or cutting it away, the surfaces buffed or smoothed down, and the knife then nickel plated or silver plated, resulting in the production of a knife which in point of durability and appearance conforms in all particulars to the ordinary one-piece knife, whereby an equally efficient knife is produced at a much less cost.

In the action of the dies in forging the parts together, the ends of the walls 5 and 6 projecting over upon the body of the blade are welded to the blade and shaped to produce the ribs 14, while the projecting side edges of said walls are united and welded



into interlocking engagement with the tang 10, the metal of said walls being forced into the recesses 11, whereby a locking connection is produced to firmly and securely bind 5 the handle and blade together.

By the construction and mode of operation set forth, the handle 1 may be made of inferior metal to the blade, and a process of manufacture is provided by which the knife 10 may be more quickly, conveniently and economically manufactured than the usual one-piece knife, without loss of strength or efficiency, since the triple interlocking connection afforded by the rivet, the engagement 15 of portions of the handle with the recesses 11 and the welding of the bifurcated portion of the handle to the blade produces a substantially homogeneous bond or connection between the handle and the blade 20 which is as strong as though the connection were an integral one.

Having thus described the invention, what I claim, is:—

The herein-described method of making a table knife, consisting in forming independent 25 handle and blade blanks respectively provided with a slot and a tang, said tang being of less length and width than the slot and provided in its edges with recesses, fitting the tang of the blade into the slot of the 30 handle, riveting the parts together, and finally forging the connected parts together so as to produce the usual connecting neck and to displace the edge portions of the walls of the slot of the handle into overlapping 35 engagement with the side edges of the tang.

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

CHARLES E. PECK.

Witnesses:

J. ELLIOTT MAY,  
H. D. MAY.