

V. OLB.

MANUFACTURE OF TELEPHONE TRANSMITTER FACES AND THE LIKE.

APPLICATION FILED OCT. 20, 1909.

968,789.

Patented Aug. 30, 1910.

2 SHEETS—SHEET 1.

Fig. 1.

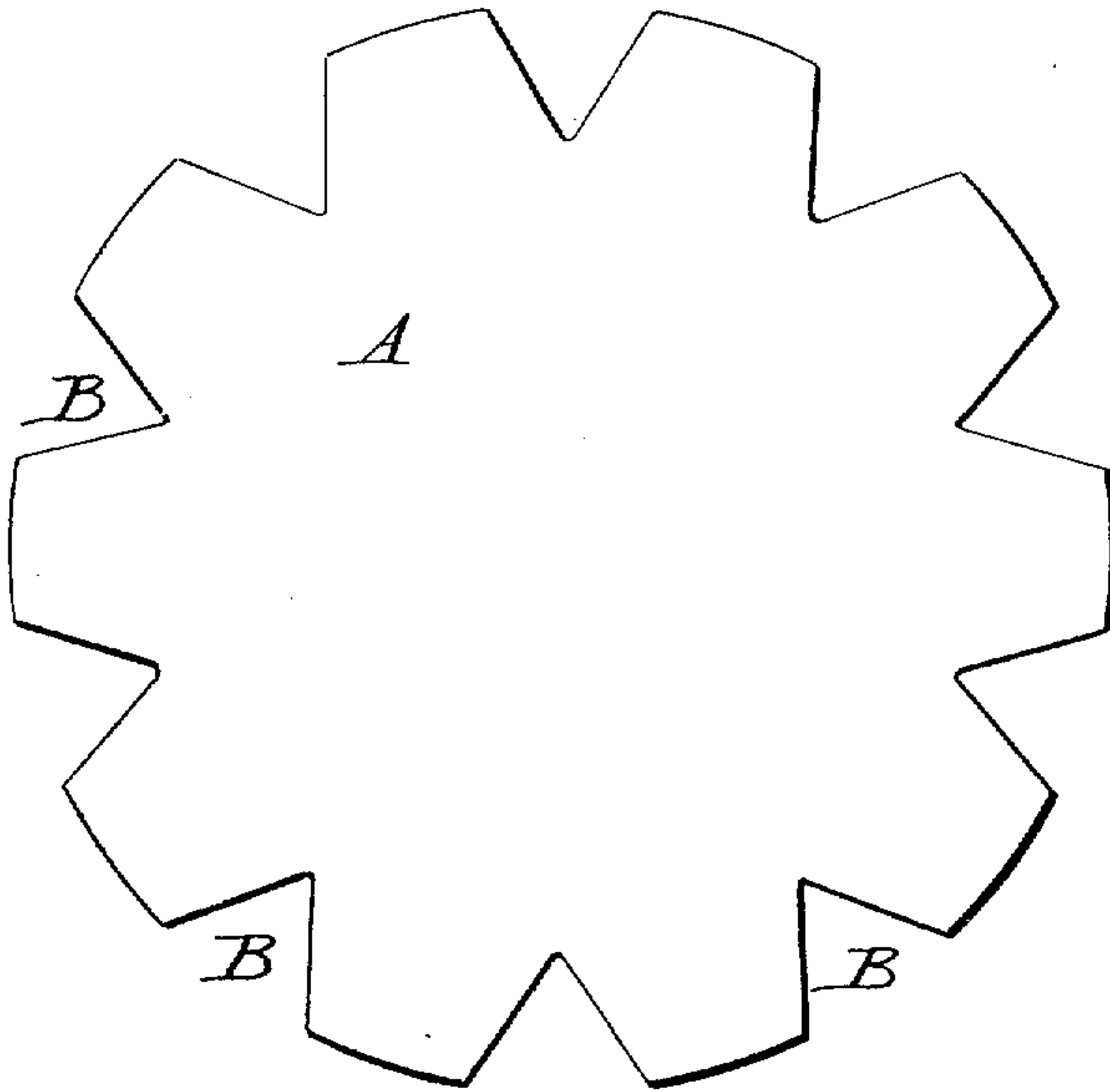


Fig. 2.

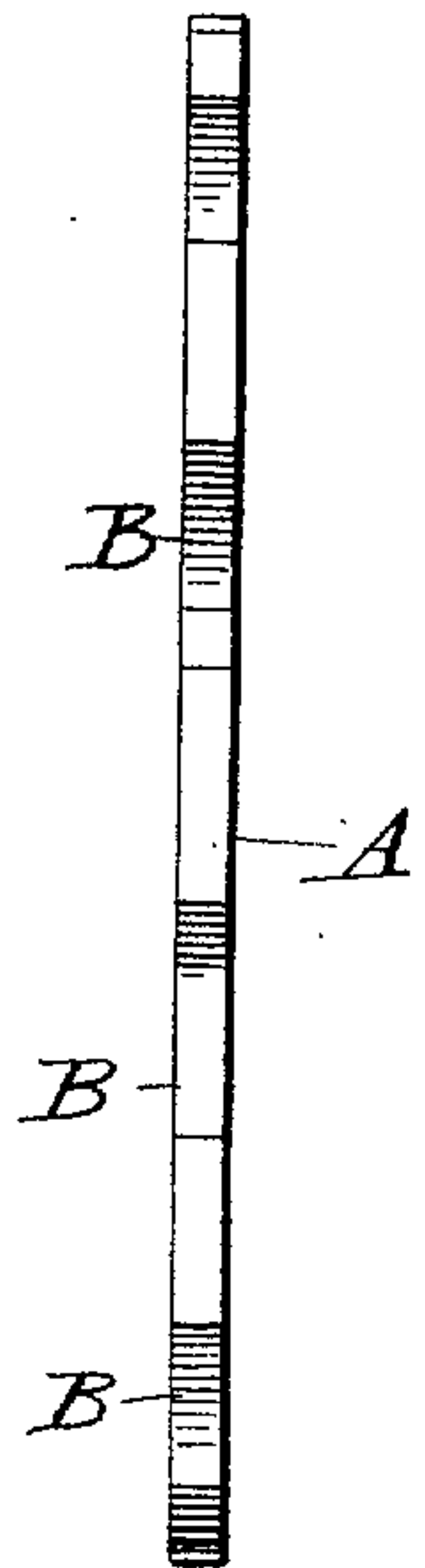


Fig. 4.

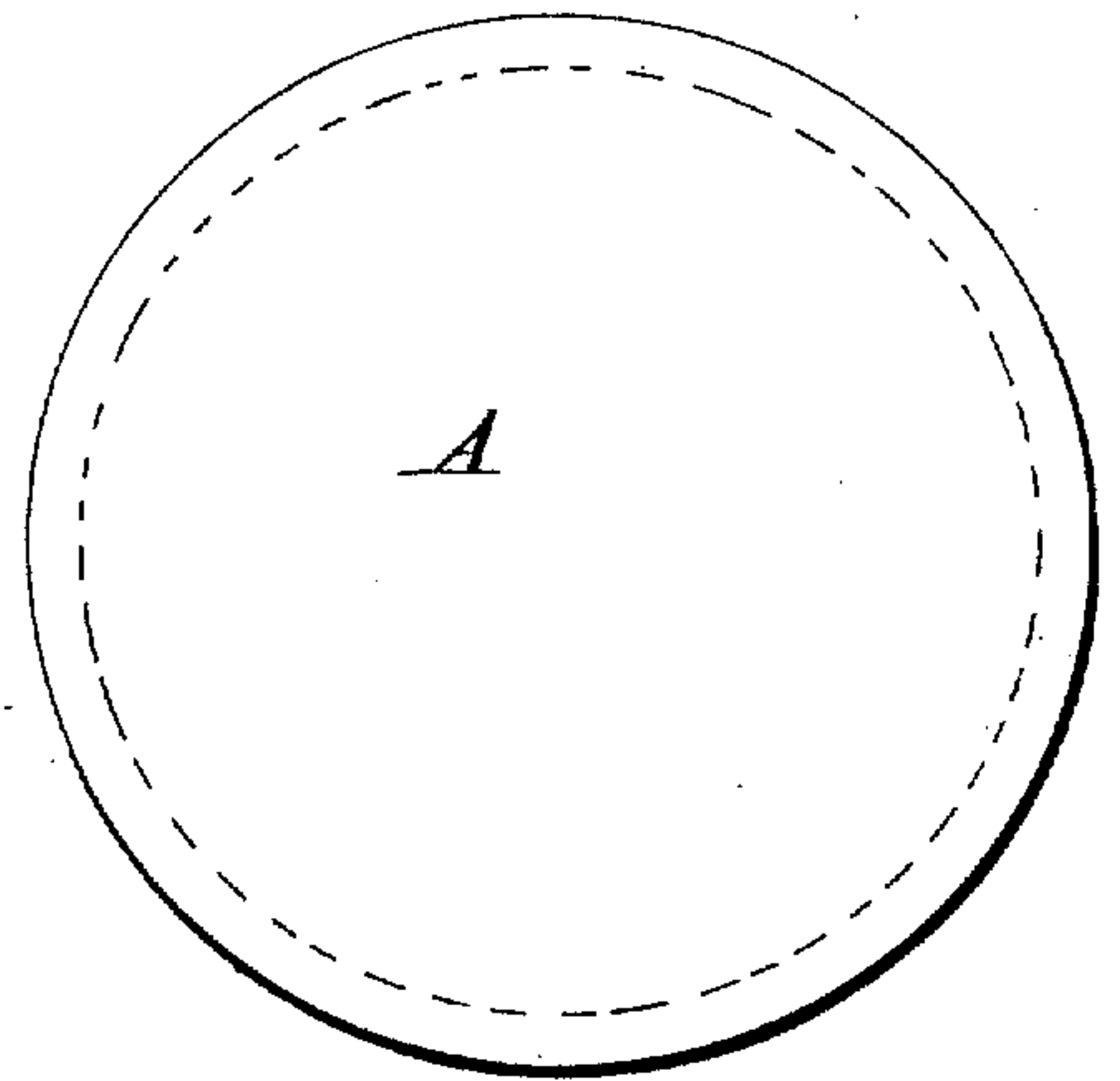
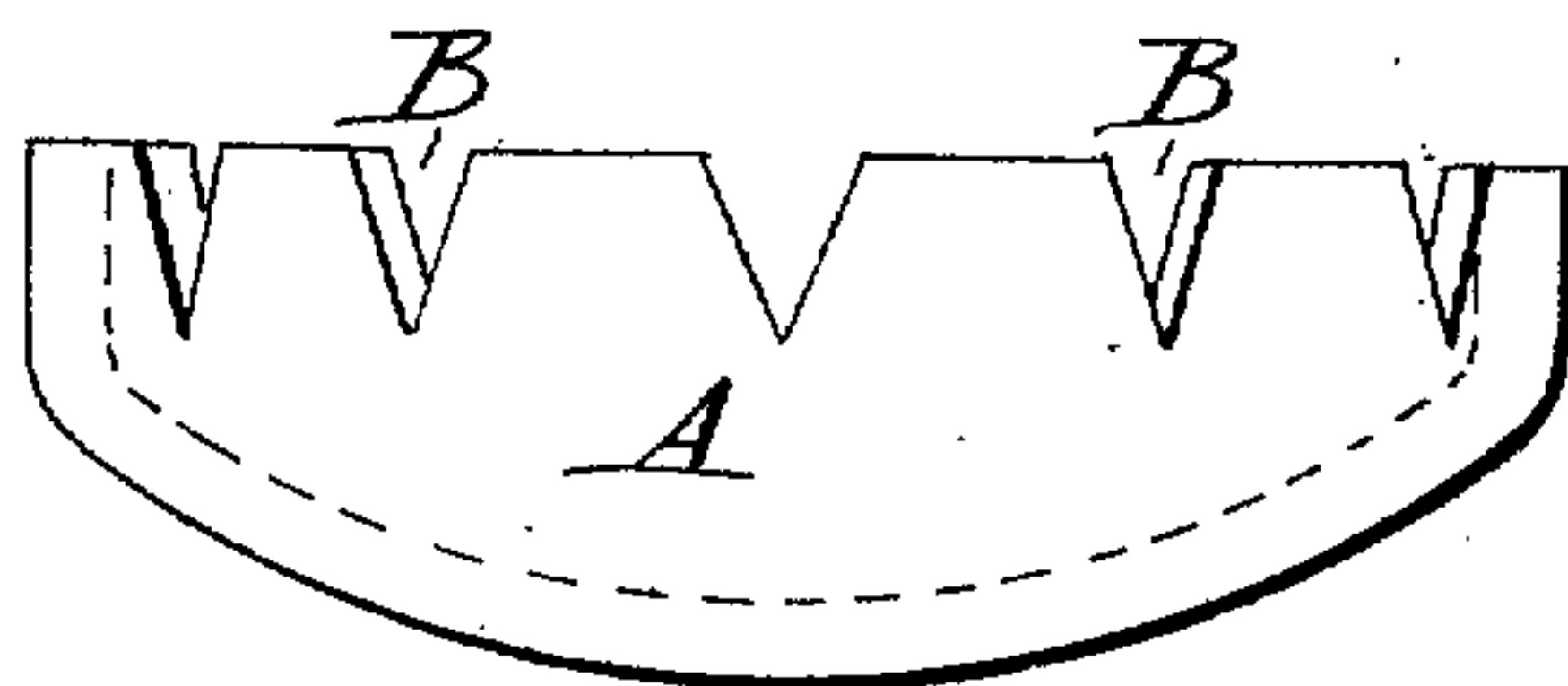


Fig. 3.



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2 SHEETS—SHEET 2.

Fig. 5.

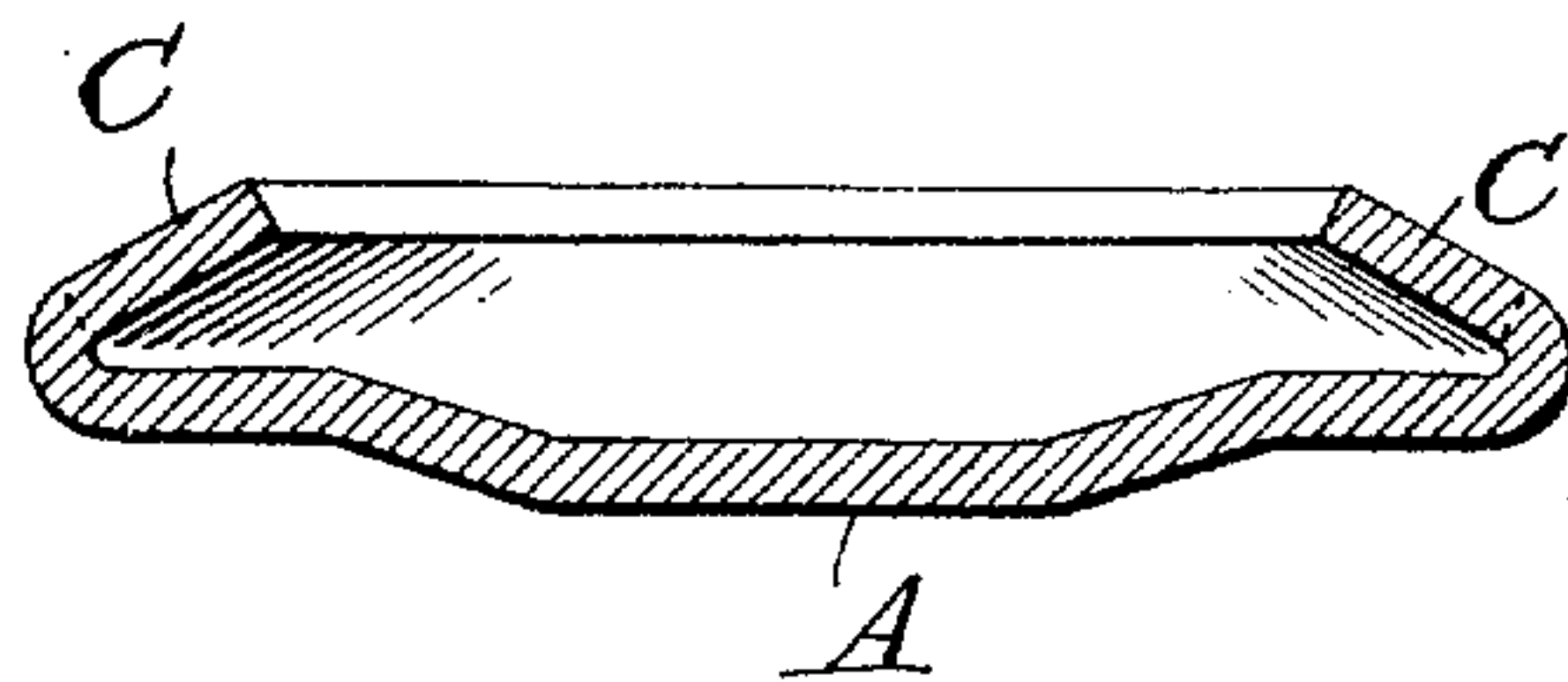


Fig. 6.

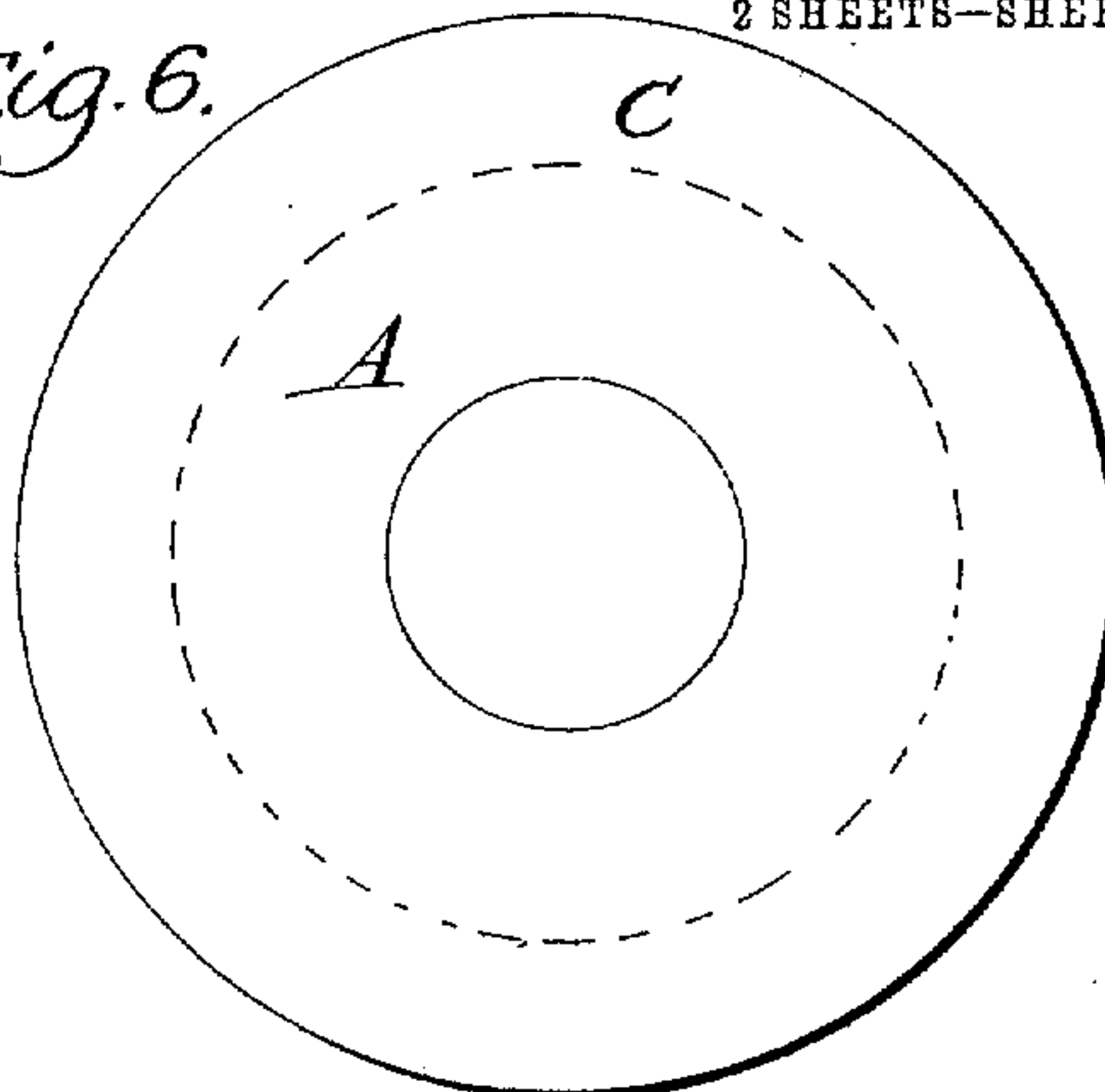


Fig. 7.

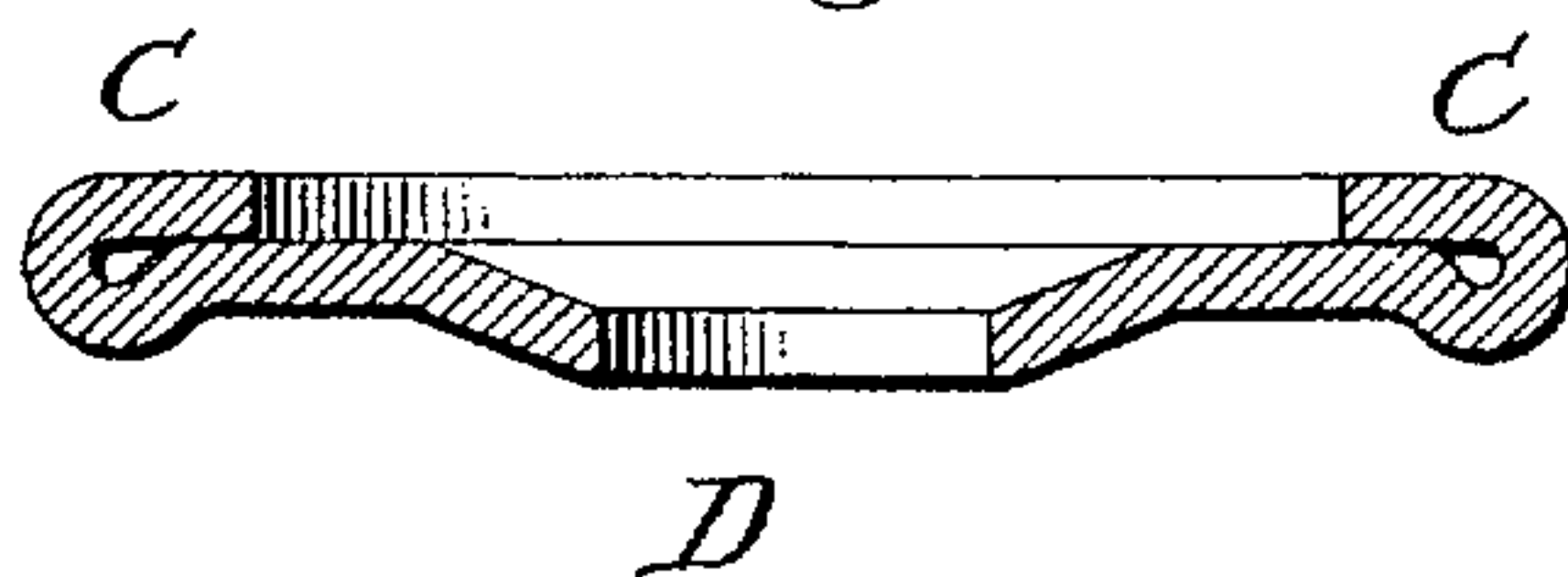


Fig. 8.

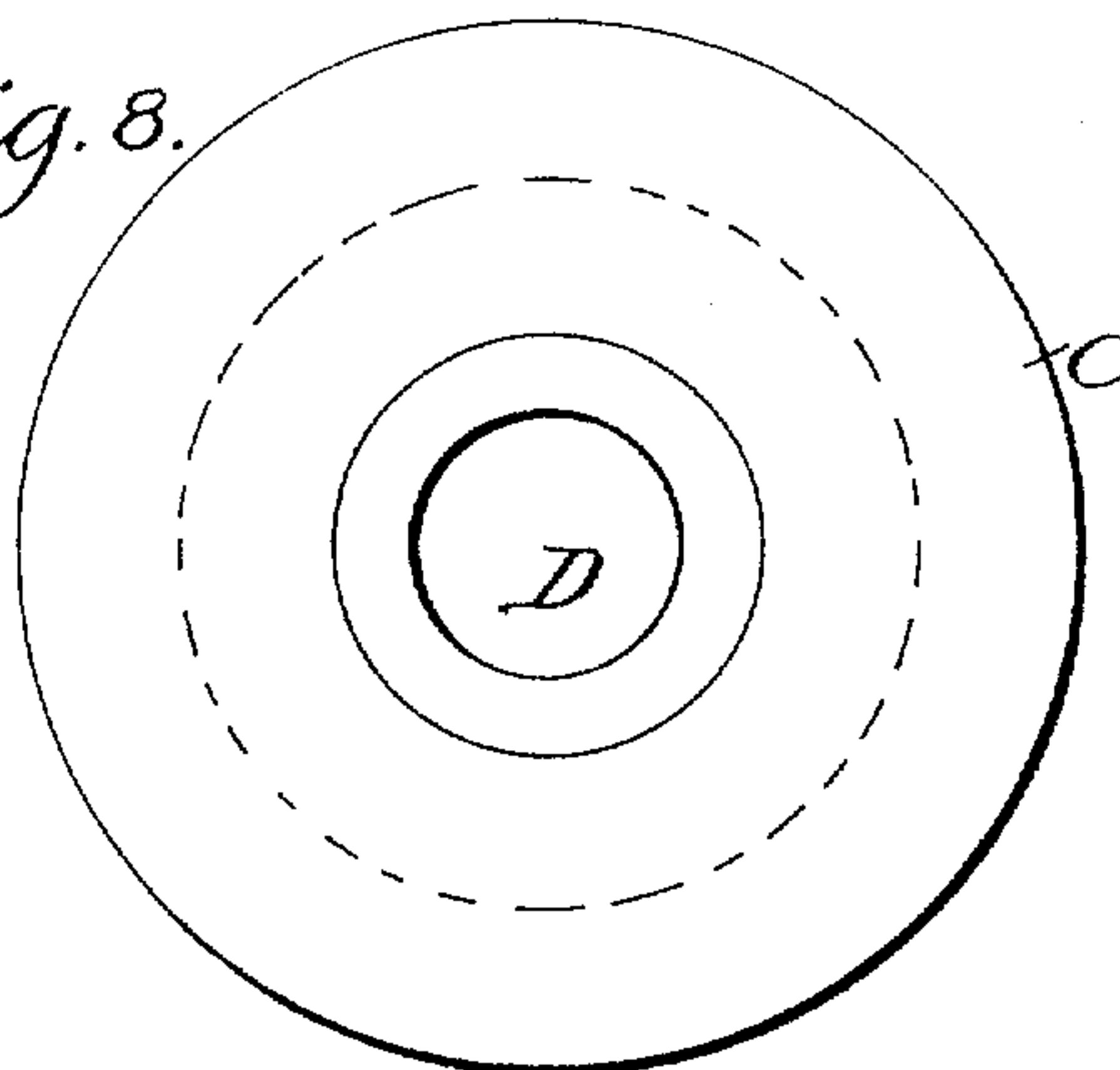


Fig. 9.

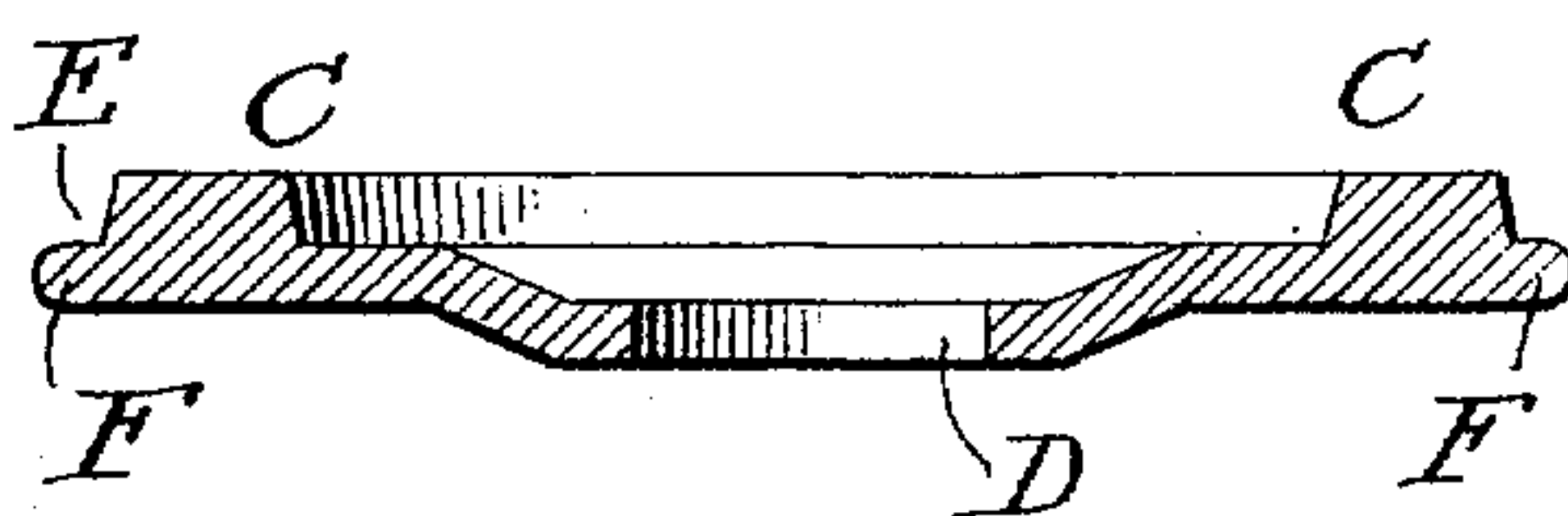
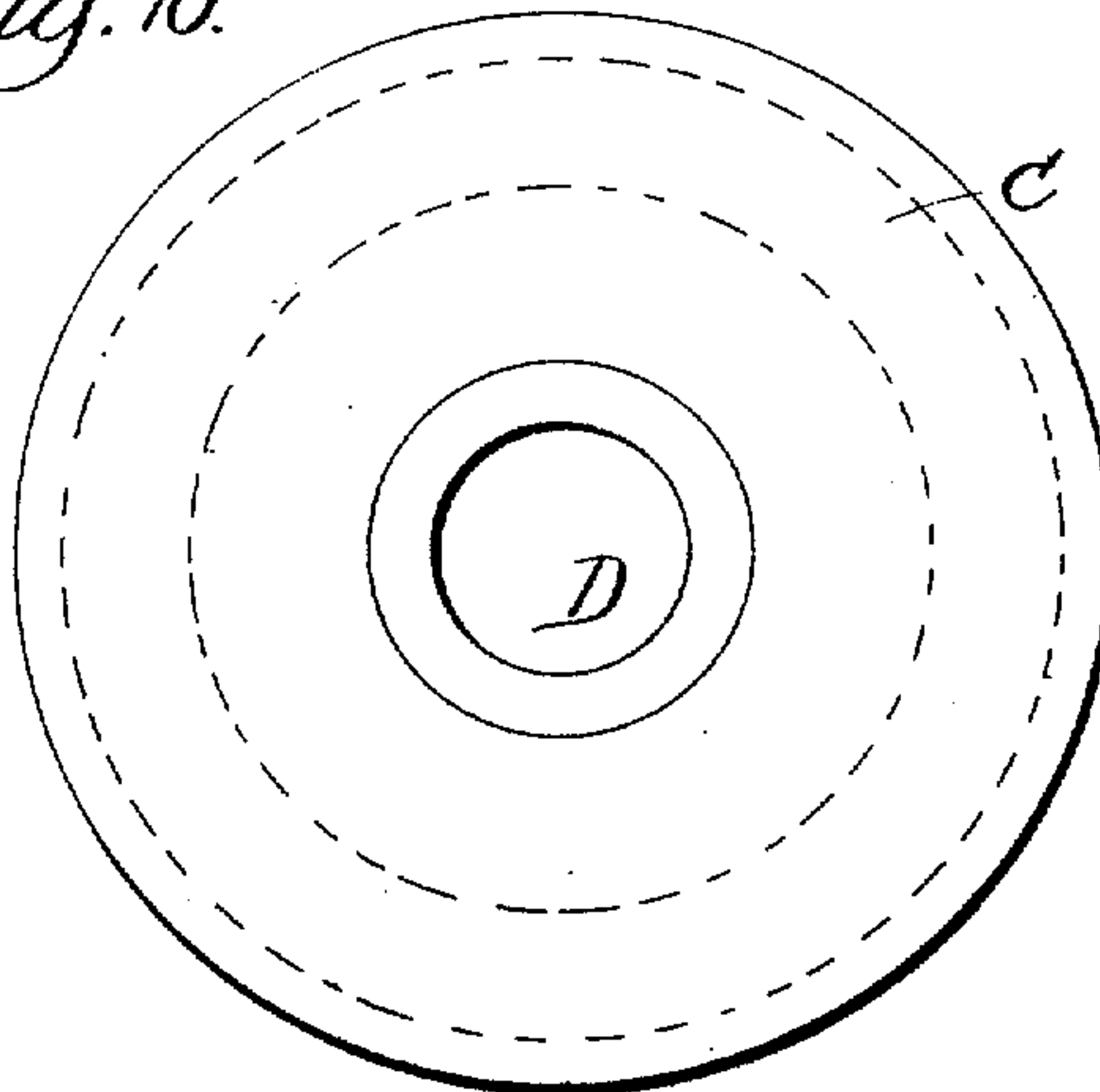


Fig. 10.



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UNITED STATES PATENT OFFICE.

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MANUFACTURE OF TELEPHONE-TRANSMITTER FACES AND THE LIKE.

968,789.

Specification of Letters Patent.

Patented Aug. 30, 1910.

Application filed October 20, 1909. Serial No. 523,640.

To all whom it may concern:

Be it known that I, VALENTINE OLB, a citizen of the United States, and a resident of Weehawken, in the county of Hudson and State of New Jersey, have invented certain new and useful Improvements in the Manufacture of Telephone-Transmitter Faces and the Like, of which the following is a specification.

The invention relates to telephone transmitters of the form commonly known as Blake transmitters or of any similar form, and more particularly to the portion of said transmitters known as the face or face piece thereof.

The invention consists in the improved method or process of manufacturing such a transmitter face, by stamping and otherwise forming the same out of sheet metal, as hereinafter more particularly described.

In the accompanying drawings Figure 1 represents a plan view of the metal blank as the same appears after the first step in my improved method or process; Fig. 2 is a side view of the same; Fig. 3 is a side view of the partially formed blank, as it appears after the second step in my process; Fig. 4 is a plan view of the same; Figs. 5, 7 and 9 are transverse vertical sections showing the subsequent and final steps in the carrying out of my improved method or process; and Figs. 6, 8 and 10 are plan views respectively of the corresponding sectional views.

In carrying my invention into effect I first stamp or punch out from a suitable piece of sheet metal, a blank A, of the shape shown in Fig. 1, being an approximately circular piece but with serrations B around its periphery as shown. This blank is next stamped into the form shown in Fig. 3, where, as will be seen, the periphery is bent upward, and the serrations B partially closed. The next step consists in bending the edges C still farther over, and forming

the bottom of the previously saucer-shaped figure, into the form shown in Fig. 5. The next step is the forcing down of the edges C until they lie upon the bottom, and also punching out the opening D in the middle of the bottom, resulting in the form shown in Fig. 7. The final step in the process is the stamping down of the edges C so that they become practically integral with the remainder of the blank and at the same time forming a recess E having a shoulder F. The dies or stamps employed in performing this final step of my improved process should of course be formed accurately to the proper size, so as to produce a finished transmitter face, having the annular recess E, and the annular shoulder F of the exact size required so as to fit snugly into the corresponding back of the transmitter.

Among the principal advantages of my invention may be mentioned the increased simplicity of the process, the decrease in the number of steps required to produce the finished article.

Having thus described my invention, what I claim as new and desire to secure by Letters Patent is as follows:

The method or process of producing a telephone transmitter face or the like which consists in stamping or punching from sheet metal an approximately circular blank, forming the bottom and bending over the edges by successive steps, punching out a central aperture therefrom, and stamping down said edges so as to form an annular recess therein.

In witness whereof, I have signed the foregoing specification, at New York city, N. Y., this 19th day of October, 1909, in the presence of two witnesses.

VALENTINE OLB.

Witnesses:

GENE S. GOEBEL, Jr.,
JACOB C. GOEBEL.