W. F. GORTON.

PROCESS OF MAKING CUTLERY.

APPLICATION FILED AUG. 17, 1914.

1,155,229. Patented Sept. 28, 1915.

Fig. 1.

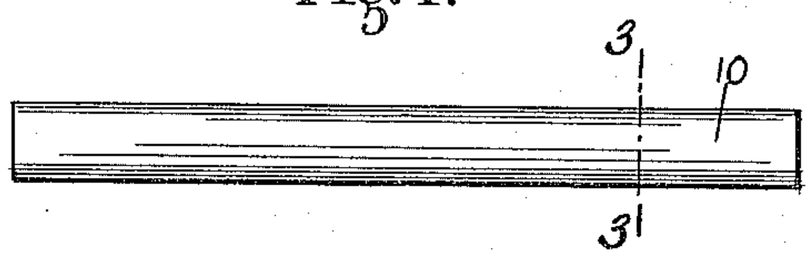


Fig. 2.

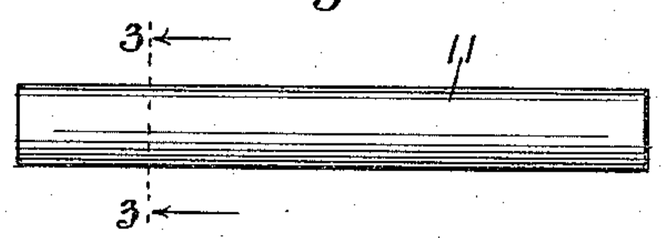


Fig. 3.

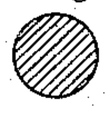


Fig. 4.

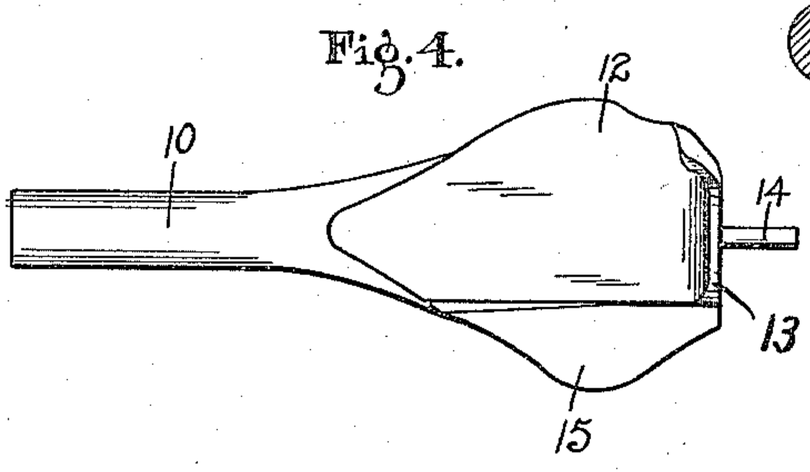


Fig. 5.

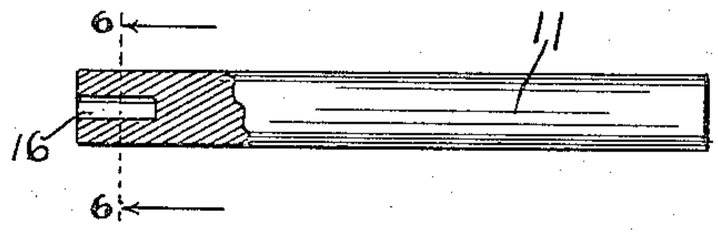


Fig. 6.

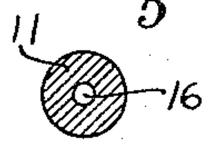


Fig. 7.

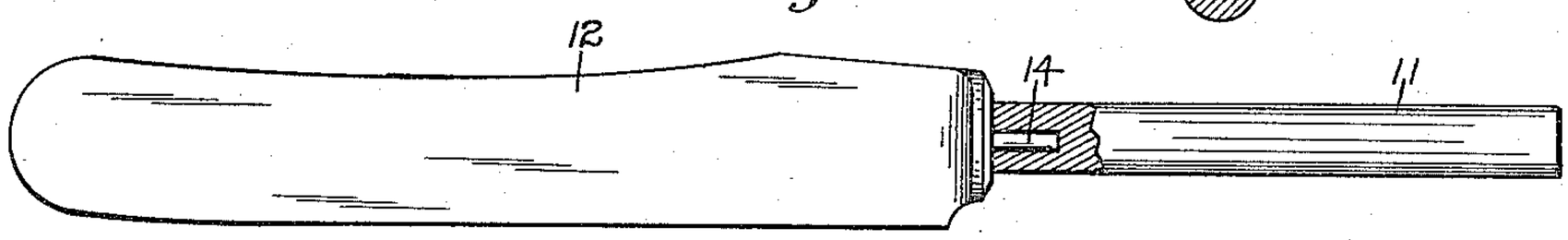


Fig. 8.

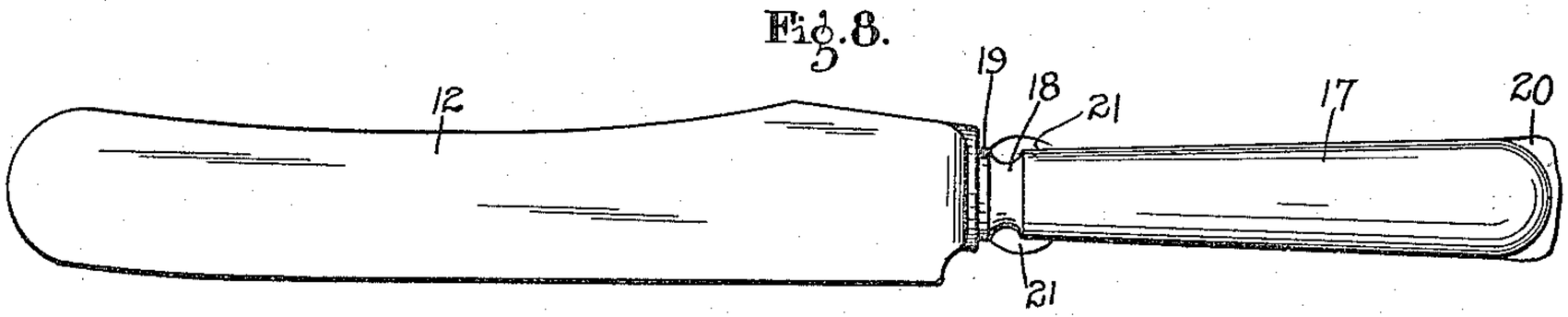


Fig. 9.

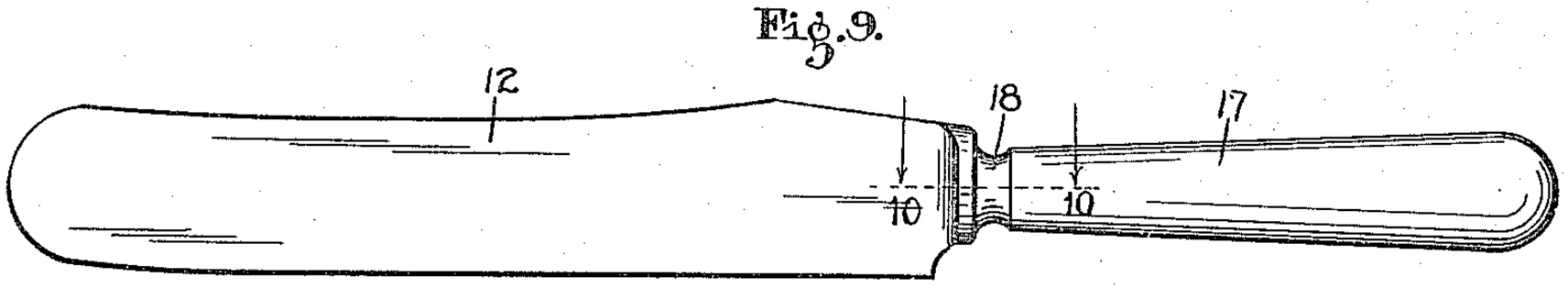


Fig. 10.

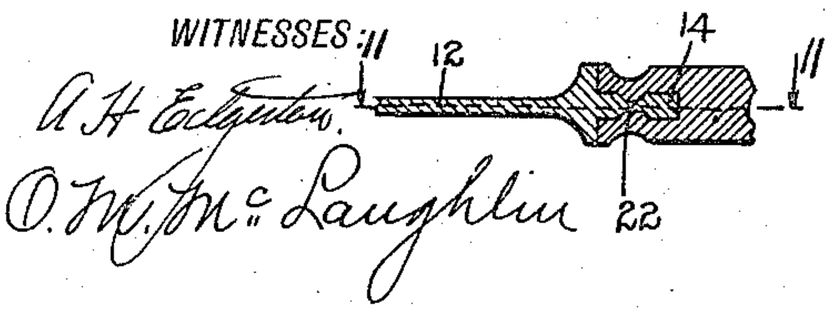
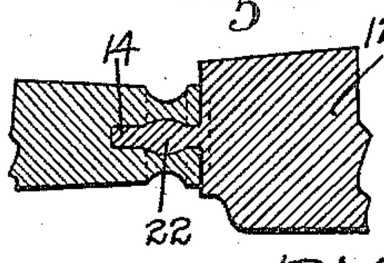


Fig. 11.



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UNITED STATES PATENT OFFICE.

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PROCESS OF MAKING CUTLERY.

1,155,229. Specification of Letters Patent. Patented Sept. 28, 1915.

Application filed August 17, 1914. Serial No. 857,159.

To all whom it may concern:

Be it known that I, WILLIAM F. GORTON, a citizen of the United States, and a resident of Muncie, county of Delaware and State of Indiana, have invented a certain new and useful Process of Making Cutlery; and I do hereby declare that the following is a full, clear, and exact description thereof, reference being had to the accompanying drawings, in which like letters refer to like parts.

The object of this invention is to cheapen and improve the construction of cutlery such as knives, forks, spoons and the like, and particularly of that type in which the handle and blade portions are made of different qualities or kinds of metal. The quality of metal in the blade should be superior to that of the handle.

The chief feature of the invention consists in taking two pieces of metal, a portion of one of which has been formed into a knife blade, and uniting said pieces of metal with the use of compression dies and at the same operation forming both the handle and the bolster.

The full nature of the invention will be understood from the accompanying drawings and the following description and claims.

In the drawings, Figure 1 is a plan view of a bar of superior steel of which to form the blade. Fig. 2 is a plan view of a bar of metal to form the handle. Fig. 3 is a section on the line 3—3 of Figs. 1 and 2. Fig. 4 is a plan view of the knife bar after the same has been partially formed. Fig. 5 is the same as Fig. 2 with one end broken away in section showing the hole or recess in the inner end of it. Fig. 6 is a section on the line 6—6 of Fig. 5. Fig. 7 is a plan view of the blade and handle after they have been permanently secured together. Fig. 8 is a plan view of the blade and handle after they have been treated with a punch press. Fig. 9 is a plan view of the knife after it has been finished. Fig. 10 is a section on the line 10—10 of Fig. 9. Fig. 11 is a section on the line 11—11 of Fig. 10.

In carrying out this process, a round bar 10 of cutlery steel is cut the right length to form the blade, and a round bar 11 of suitable metal is made the proper length to form the handle and bolster. Both of these bars are solid, as shown in Fig. 3.

Then the blade bar 10 is treated by a suitable stamp die or otherwise to convert it into the form shown in Fig. 4, where a portion of the blade 12 is shown with shoulders 13 at the inner end of the blade suitably formed and a round pin 14 extends centrally from the inner end of the blade and there is also a fin 15 on the back. The bar 10 is further treated until it forms the blade shown in Fig. 7 in substantially the final form and shape.

The handle bar 11 is provided with a round hole 16 in its inner end of suitable diameter and depth to receive snugly the pin 14 on the blade.

The next step of the process consists in bringing together the handle and the blade, as shown in Fig. 7, by suitable compression dies, which dies also form the handle 17 of the desired shape and also forms an annular recess or bolster 18 near the inner end of the handle and leaving a shoulder 19 at the extreme inner end of the handle near the shoulder 13 of the blade. This process also leaves fins such as 20 and 21. The pressing action of said compression dies in forming the recess or bolster 18 is to flatten the pin 14 so as to provide it with a thin portion 22 between its ends and said thin portion is also wider than the remaining portion of the pin, as shown in Figs. 10 and 11, and the metal of the handle is similarly crushed or pressed into close union and conformation with said pin so that the handle bolster and blade are very securely united.

Thereafter the piece of cutlery is finished, as shown in Fig. 9. It is thus seen that no special heating, brazing or welding is employed in uniting the blade and handle, but the same is done by subjecting the parts to the action of the compression dies or the like.

The invention claimed is:

1. The process of making cutlery, which process consists in taking two pieces of metal, and uniting them by means of compression dies and in the same operation forming the handle and bolster.

2. The process of making cutlery, which

process consists in taking two pieces of metal, forming one of said pieces of metal into a blade, and thereafter uniting said two pieces of metal by means of compression dies and in the same operation forming the handle and bolster of the cutlery.

In witness whereof, I have hereunto affixed my signature in the presence of the witnesses herein named.

WILLIAM F. GORTON.

Witnesses:
L. S. GANTER,
HARRY BEEBE.