No. 689,049.

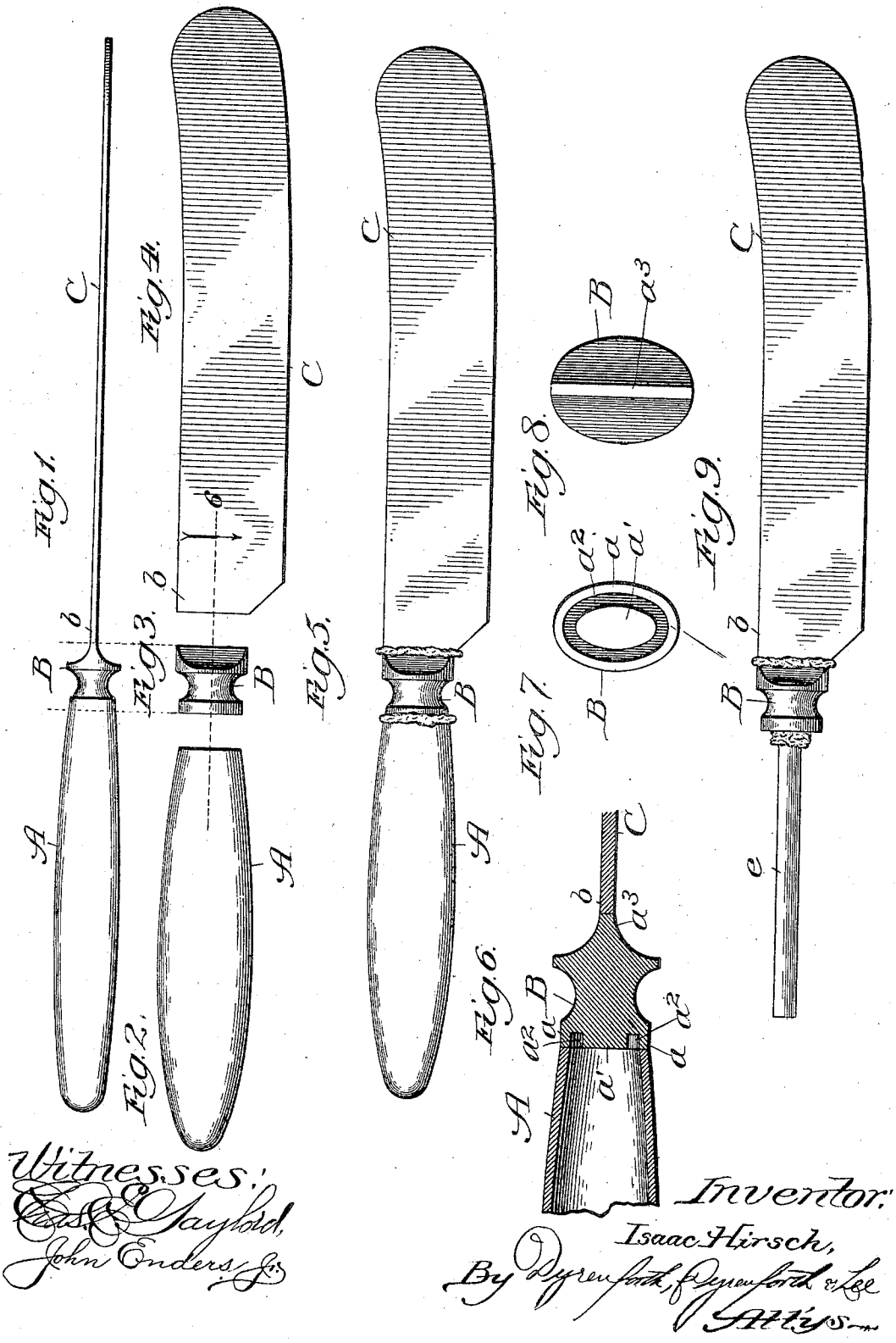
Patented Dec. 17, 1901.

I. HIRSCH.

TABLE CUTLERY.

(Application filed Aug. 7, 1901.)

(No Model.)



Witnesses:
Chas. E. Gaylord,
John Enders, Jr.

Inventor:
Isaac Hirsch,
By Dyrenforth, Dyrenforth & Lee
Attys.

THE NORRIS PETERS CO., PHOTO-LITHO., WASHINGTON, D. C.

UNITED STATES PATENT OFFICE.

ISAAC HIRSCH, OF CHICAGO, ILLINOIS.

TABLE-CUTLERY.

SPECIFICATION forming part of Letters Patent No. 689,049, dated December 17, 1901.

Application filed August 7, 1901. Serial No. 71,138. (No model.)

To all whom it may concern:

Be it known that I, ISAAC HIRSCH, a citizen of the United States, residing at Chicago, in the county of Cook and State of Illinois, have invented a new and useful Improvement in Table-Cutlery, of which the following is a specification.

My invention relates to table-cutlery generally, and more especially to table-knives; and it consists in an improved article of manufacture as well as a novel and improved method of manufacture.

My object is to provide a new method of producing and a new construction for table-knives and other articles of table-cutlery, particular attention being paid to facility of production of an article which is thoroughly substantial and perfect in construction.

In the accompanying drawings, which illustrate my invention and a mode in which it is carried out, Figure 1 represents a plan view of a knife embodying my invention; Figs. 2, 3, and 4, elevational views of a handle, bolster, and blade, respectively, being the component parts of the knife represented in Fig. 1; Fig. 5, a side elevational view of the knife after the parts mentioned have been electrically butt-welded together and before the burs thereby produced have been removed; Fig. 6, an enlarged sectional view taken as indicated at line 6 on Fig. 3 and representing the manner in which the parts abut against each other during welding; Figs. 7 and 8, rear and front face views, respectively, of the bolster; and Fig. 9, a view of the knife with a modified form of handle.

The preferred construction is as follows:

A represents the handle of a knife, B the bolster thereof, and C the blade thereof. The handle when hollow is preferably formed of a single piece in accordance with my invention described in my application Serial No. 71,137, of even date herewith. The bolster is preferably solid and of the configuration clearly shown in Figs. 3 and 6 to 8, inclusive, having a rear annular flange a, a central lug a', separated therefrom by an annular channel a^2, and having at its front portion a flange a^3. The blade has a stub-tang b, affording a shoulder corresponding in area to the shoulder afforded at the front surface of the flange a^3. The flange a has a shoulder which corresponds in area to the shoulder afforded by the front surface of the handle A. The parts abut against each other, as illustrated clearly in Fig. 6, and are electrically butt-welded together, as clearly appears from Fig. 5. After the welding operation the knife is ground and polished in the usual manner.

In the modification of Fig. 9 a separately-formed handle shaft or tang e, having a front surface affording a shoulder corresponding in area to the rear surface of the lug a', is butt-welded to said lug. In this construction any suitable handle may be secured upon the shaft e, and scales of any desired material and design may be employed in connection therewith for producing a fancy handle. In such case the front end of the handle proper may abut against the flange a or may telescopically inclose the same.

Where the hollow handle is employed, it is desirable to form the handle in one piece, because of the facility with which the handle is hermetically sealed when welded to the bolster. The importance of this is more readily apparent when it is recalled that articles of this sort are usually silver-plated, and if there is a defect in the handle the plating liquid may enter, with objectionable results. In the present construction it is easy to produce joints which will not be injured during the grinding and polishing operations. For reasons which will be appreciated by those skilled in the art of electric welding it is necessary to have corresponding shoulders of adjacent parts of substantially the same area.

Changes in details of construction within the spirit of my invention may be made. Hence no undue limitation is to be understood from the foregoing detailed description.

What I claim as new, and desire to secure by Letters Patent, is—

1. The process in producing an article of cutlery, which consists in forming a blade with a shoulder, and an independently-made bolster with a shoulder corresponding in cross-section with said first-named shoulder, and then butt-welding said parts at said shoulders.

2. The process in producing an article of cutlery which consists in forming a bolster with a handle-attaching shoulder and a han-

dle with a coacting shoulder of corresponding cross-section, and then butt-welding said parts at said shoulders.

3. The process of producing an article of cutlery which consists in forming a bolster with a handle-attaching shoulder and a blade-attaching shoulder, a handle with a shoulder corresponding in cross-section with said first-named shoulder, and a blade with a stub-tang having a shoulder corresponding in cross-section with said second-named shoulder, and then butt-welding said parts at said shoulders.

4. The process in producing an article of cutlery which consists in providing a bolster with an annular flange or shoulder, in providing a handle with an annular shoulder corresponding in area or cross-section, and then butt-welding said parts at said shoulders.

5. An article of cutlery, comprising separately-formed blade, bolster, and handle, butt-welded together.

6. An article of cutlery, comprising separately-formed blade, solid bolster, and handle, said bolster having blade and handle attaching shoulders, and said blade and handle having shoulders of corresponding cross-section, butt-welded to the appropriate shoulders of said bolster.

7. In an article of cutlery, a blade having a bolster-attaching shoulder and an independently-formed bolster having a shoulder of corresponding area or cross-section butt-welded thereto, said bolster being provided with handle-receiving means.

8. In an article of cutlery, comprising separately-formed blade, bolster, and handle, said bolster having a rear annular flange affording an annular handle-attaching shoulder and a front flange affording a blade-attaching shoulder, said handle having an annular shoulder corresponding in area with said first-named shoulder and said blade having a shoulder corresponding in area with said second-named shoulder, said parts being butt-welded together at appropriate shoulders.

ISAAC HIRSCH.

In presence of—
D. W. LEE,
ALBERT D. BACCI.