J. G. Knapp,

Manf. Scoops.

No. 98,072. Patented Dec. 21. 1869.

Fig: 2.

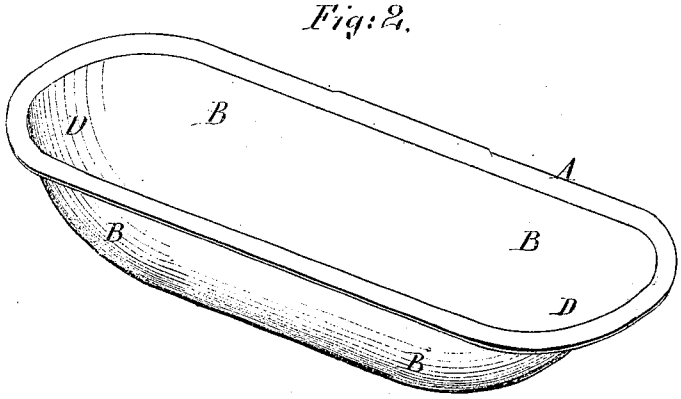
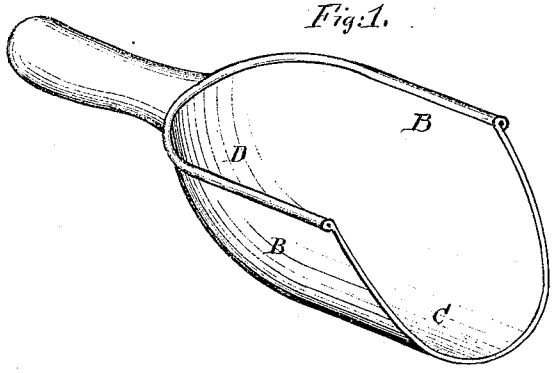


Fig: 1.



Witnesses:

M. Vorcamp

M. L. Brook

Inventor:

J. G. Knapp.

Per Munn & Co

Attorneys.

H. PETERS, PHOTO-LITHOGRAPHER, WASHINGTON, D. C.

United States Patent Office.

J. GEORGE KNAPP, OF WOODHAVEN, NEW YORK, ASSIGNOR TO THE LALANCE & GROSJEAN MANUFACTURING COMPANY, OF NEW YORK CITY.

Letters Patent No. 98,072, *dated December* 21, 1869.

IMPROVEMENT IN MANUFACTURE OF SCOOPS.

The Schedule referred to in these Letters Patent and making part of the same.

To all whom it may concern:

Be it known that I, J. GEORGE KNAPP, of Woodhaven, in the county of Queens, and State of New York, have invented a new and useful Improvement in the Manufacture of Scoops; and I do hereby declare that the following is a full, clear, and exact description thereof, which will enable others skilled in the art to make and use the same, reference being had to the accompanying drawings, forming part of this specification.

This invention relates to an improved mode of manufacturing sheet-metal flour, grain, and other scoops, and consists in forming the bowls in one piece of metal, without seams or joints, by stamping up sheets of metal into the form of troughs, with a flange around the top, and cutting the same transversely in the centre into blanks for the bowls of two scoops, to be finished by trimming or shaping the cut ends, turning down the flange at the top, for stiffening, either over wire or not, and attaching the handles, the object being to produce scoops with bowls formed in one piece, and shaped smoothly at the base, or the part where the handles are connected, and to effect an economy of labor by stamping two blanks at one blow of the drop-press, and also to control the metal under the action of the press better in shaping the deep curved part at the base, so as to upset and stiffen the blanks thereat.

Figure 1 is a perspective view of a flour or sugar-scoop made according to my improved mode of operation, and

Figure 2 is a perspective view of the blank for two scoops, as it is delivered from the drop-press.

I take sheets of the metal I propose to use, of any ductile kind, and in the forms and dimensions required for the production of two scoops, and strike them up in suitable dies prearranged for the purpose, into the trough-form represented in fig. 2, with the horizontal flange or margin A extending around the same.

I then cut these blanks transversely at the centre by any suitable means, and trim or dress the ends so cut as preferred, and attach the handles of any sort in any approved way, and finish the top by turning the flange A down, either over a wire or against the side of the bowl without the wire.

This mode of forming the blanks has the advantage of so controlling that part of the metal which forms the sides B, and also the bottom part C, that it is upset and stiffened to a greater degree in the curved base D where the greatest strength is required.

If struck up in separate blanks for each scoop, the sides B will be thrust forward by the action of the dies in bending up the part D in the direction of the open end, and the metal will not be thickened to or upset thereat, as in this case, where this force is imparted to the sides from each end equally, whereby it is counteracted in a way to cause the upsetting at the part D.

Having thus described my invention,

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

The mode of forming the blank scoop-bowls, by first striking the sheets up into the trough-shaped blanks for two scoops, as herein described, and then separating the blanks, all substantially as specified.

The above specification of my invention signed by me, this 1st day of November, 1869.

J. G. KNAPP.

Witnesses:

GEO. W. MABEE,

EDGAR TATE.