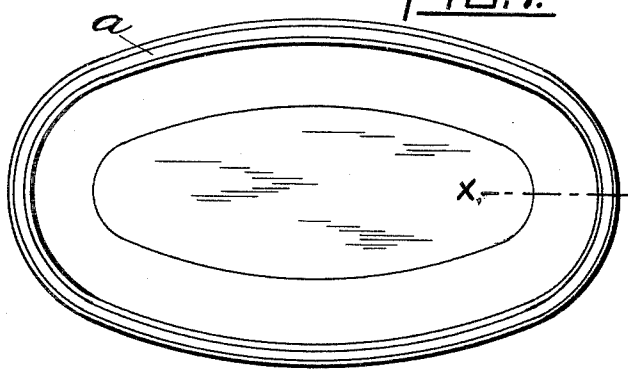
L. F. GRANDMONT.

PROCESS OF MAKING HOLLOW SILVERWARE ORNAMENTATIONS.

APPLICATION FILED MAR. 24, 1914.

1,098,567. Patented June 2, 1914.

FIG. 1.



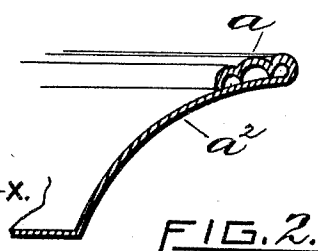


FIG. 2.

FIG. 3.

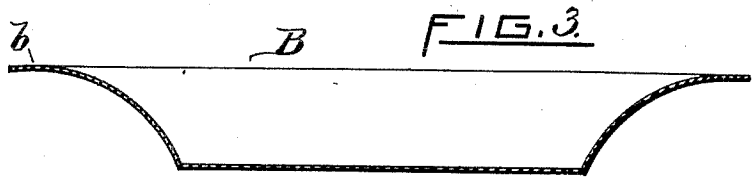


FIG. 4.

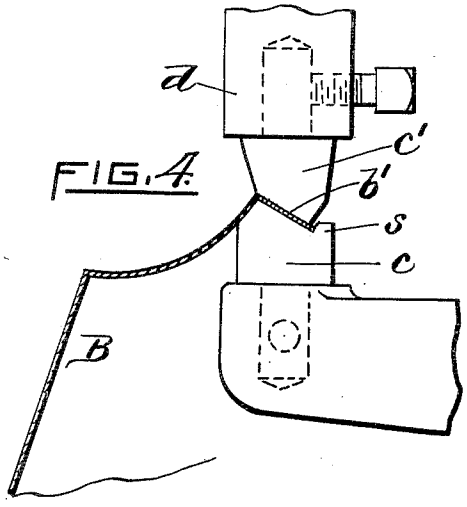
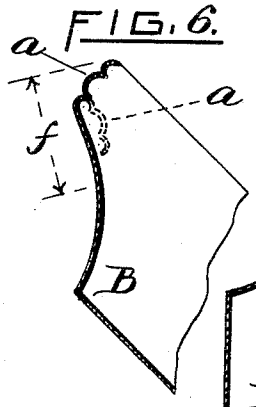


FIG. 6.



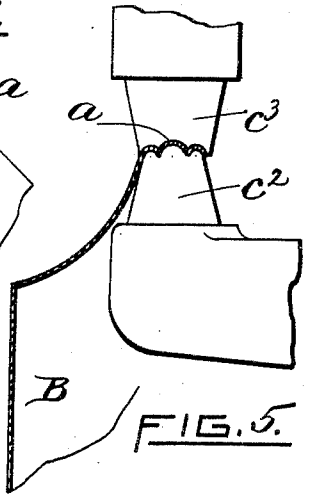


FIG. 5.

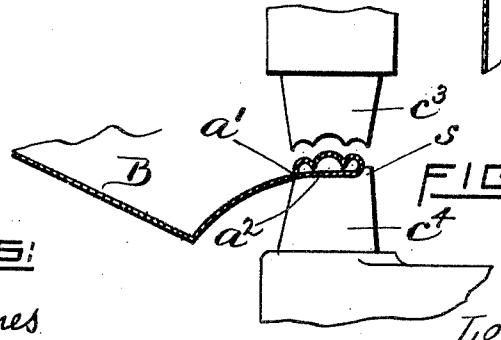


FIG. 7.

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LOUIS F. GRANDMONT, OF TAUNTON, MASSACHUSETTS.

PROCESS OF MAKING HOLLOW SILVERWARE ORNAMENTATIONS.

1,098,567. Specification of Letters Patent. **Patented June 2, 1914.**

Application filed March 24, 1914. Serial No. 826,881.

To all whom it may concern:

Be it known that I, LOUIS F. GRANDMONT, a citizen of the United States, residing at the city of Taunton, in the county of Bristol and State of Massachusetts, have invented certain new and useful Improvements in Processes of Making Hollow Silverware Ornamentations, of which the following is a specification.

This invention relates to new and useful improvements in the process of making hollow silverware ornamentations.

The present invention consists of a method of providing hollow ornamental designs upon the outer edge of silver-ware articles such as trays, plates, dishes, bowls, and the like. While the ornamentation of such articles is broadly old, my improved method materially differs from the usual ornamentation which is effected by embossing or designing the desired ornamentation directly upon the exposed surface of the article. The method of combining a stamped or embossed sheet with a plain base sheet for making up an article is also known but my improved method materially differs from either of the same, and the present object primarily resides in providing a hollow ornamental rim upon the silver-ware article by designing and forming such ornamentation from an integral bent and overlapped portion thereof.

A further object of the present device is to provide a cheap method of manufacturing hollow ornamentations upon silverware articles by means of inexpensive ornamenting and bending dies, and whereby the ornamentations may be perfected by a press operator upon receiving the plain blank stamped from sheet metal.

For illustrating the successive steps of the process of manufacture, the accompanying drawings are referred to having corresponding characters designating like parts throughout the several views and in which:—

Figure 1 is a plan view of a finished piece of silver-ware provided with an improved hollow ornamental edge portion. Fig. 2 is an enlarged transverse sectional view of a portion of the article taken upon lines *x*—*x* of Fig. 1. Fig. 3 is a central longitudinal sectional view taken through the plain blank after having been stamped in dish form and being ready to receive the improved hollow ornamental edge. Fig. 4 illustrates the first step in the process, the dish blank being shown in section. Fig. 5 illustrates the next step in the process, the blank being similarly shown. Fig. 6 illustrates the partially formed edge upon the article shown in section as the same is removed from the press and illustrating the finished edge in dotted lines, and Fig. 7 shows the final step in the process.

The process more specifically described consists in subjecting the rim of the plain blank article taken from the stamp operator as typified by the structure in Fig. 3, and then bending the outer portion of the rim —*b*— of the blank B inwardly providing the annular flange —*b'*—, the same being effected by means of the male die —*c*— and the female die —*c'*—, the latter die being carried by the short-stroke plunger —*d*— of the press. The male die is provided with an integral stop —*s*— forming a gage against which the free edge of the article rests during the bending operation, the said article being held by hand and turned around for bringing the entire circumference of the edge under the operation of the dies.

The next step in the process consists as shown in Fig. 5 in shaping said edge —*b'*— by means of the ornamenting dies —c^2— and —c^3—, and whereby the ornamental edge —*a*— is produced.

The next step consists in annealing the silver of that portion, designated at —*f*— in Fig. 6, sufficiently to render the same pliable and then bend it to the overlapped position, indicated in dotted lines in Fig. 6.

The final step in the process as illustrated in Fig. 7 consists in placing the overturned edge —*a*— within pressing dies —c^3—, —c^4—, and whereby the edge —*a'*— of the overturned rim is forced firmly upon and in abutting engagement with the upper face of the rim stock —a^2—, and thus producing the finished hollow ornamentation of the silver-ware rim of the article.

What is claimed as new is:—

The herein described method of making hollow silver-ware ornamentations consisting

in subjecting the edge of a silver-ware blank to bending dies and forming an inwardly extending angular flange circumferentially of the rim thereof, then ornamenting said flange by means of crimping dies, then annealing the flange and adjacent rim and inwardly bending the ornamented flange into seating contact upon the inner face of the rim, and then submitting the ornamented portion of the rim between pressing dies and firmly positioning the flange and rim together.

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

LOUIS F. GRANDMONT.

Witnesses:
C. T. HANNIGAN,
WALTER BARNES.

Copies of this patent may be obtained for five cents each, by addressing the "Commissioner of Patents, Washington, D. C."