

(No Model.)

2 Sheets—Sheet 1.

F. & C. F. MANKEY.

PROCESS OF MANUFACTURING ORNAMENTAL WOODEN HANDLES.

No. 353,364.

Patented Nov. 30, 1886.

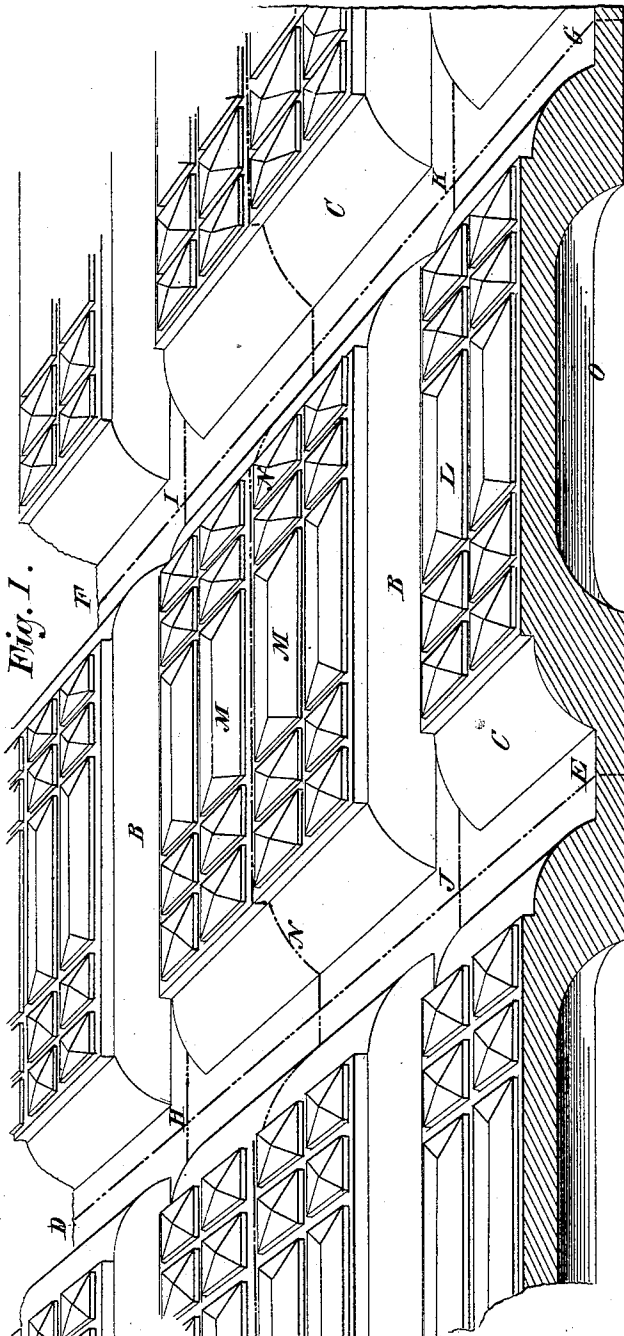


Fig. 1.

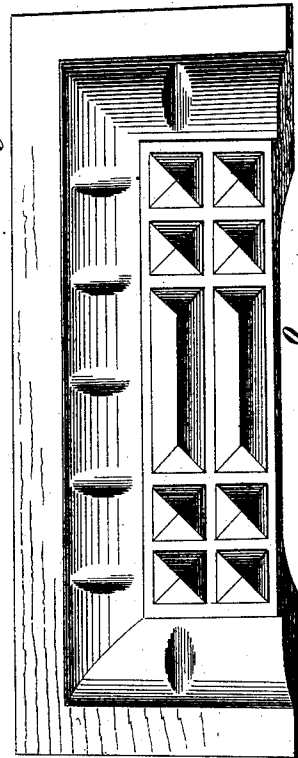


Fig. 2.

WITNESSES:  
*Gustav Katerich*  
*Edgar Goodwin*

INVENTORS:  
*Frederick Mankey*  
*Charles F. Mankey*  
 BY  
*Paul Benjamin*  
 ATTORNEY

(No Model.)

2 Sheets—Sheet 2.

F. & C. F. MANKEY.

PROCESS OF MANUFACTURING ORNAMENTAL WOODEN HANDLES.

No. 353,364.

Patented Nov. 30, 1886.

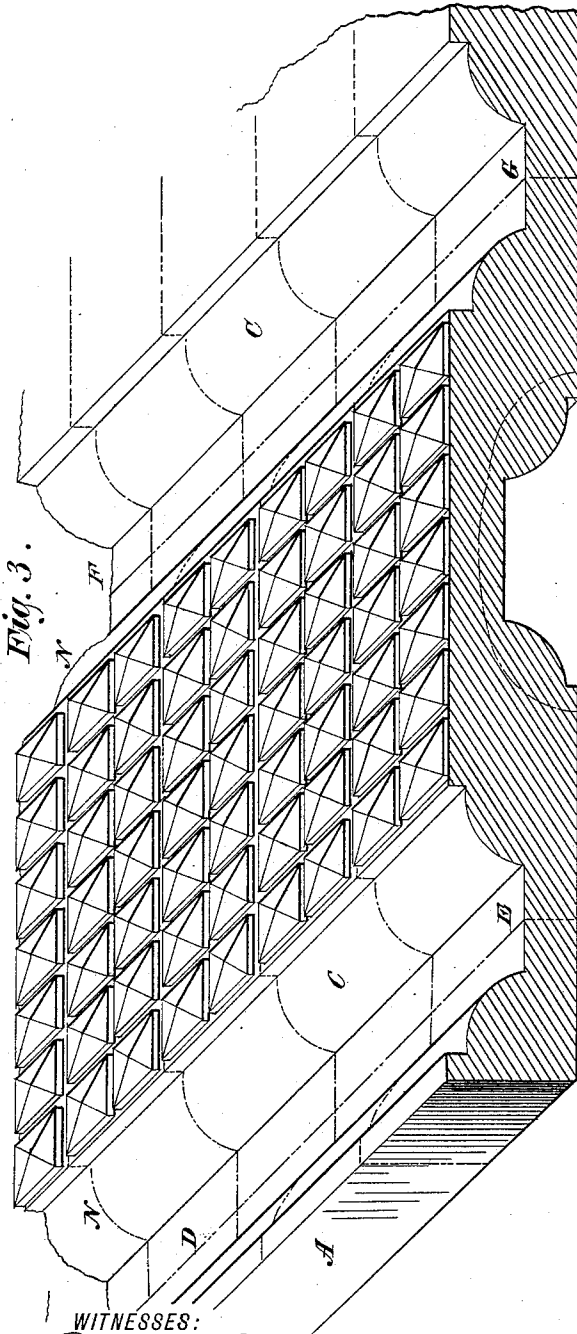


Fig. 3.

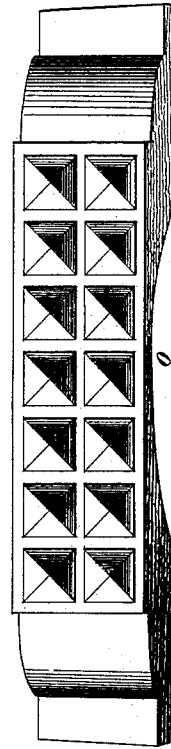


Fig. 4.

WITNESSES:

*Gustave Dietrich*  
*Edgar Goodwin*

INVENTOR  
*Frederick Mankey*  
*Charles F. Mankey*  
 BY *Paul Benjamin*  
*Reis*  
 ATTORNEY

# UNITED STATES PATENT OFFICE.

FREDERICK MANKEY AND CHARLES F. MANKEY, OF WILLIAMSPORT, PA.

PROCESS OF MANUFACTURING ORNAMENTAL WOODEN HANDLES.

SPECIFICATION forming part of Letters Patent No. 353,364, dated November 30, 1886.

Application filed July 12, 1886. Serial No. 207,775. (No model.)

*To all whom it may concern:*

Be it known that we, FREDERICK MANKEY and CHARLES F. MANKEY, both of Williamsport, Lycoming county, Pennsylvania, have invented a new and useful Improvement in Processes of Manufacturing Ornamental Wooden Handles, of which the following is a specification.

Our invention relates to a new process of manufacture of ornamental wooden handles, such as are used upon the drawers of bureaus, tables, and other articles of furniture. By means of our process we are enabled to produce such handles both quickly and cheaply in large numbers.

Our invention consists in the process of crosscutting and dividing the plank, board, or block from which the handles are to be produced, as hereinafter more particularly set forth.

In the accompanying drawings, Figure 1 shows a board or plank having a suitable configuration formed upon it to adapt it for manufacture into handles. Fig. 2 is a finished handle made from the board or plank represented in Fig. 1. Fig. 3 shows a board or plank having a somewhat different surface configuration, and Fig. 4 is a handle produced therefrom.

Similar letters of reference indicate like parts.

A, Fig. 1, represents a board, plank, or block from which the handles are to be made. We first produce upon one surface of said board an ornamental design which is intended to appear on the front side of the finished handle—for example, the two elongated pyramids and the eight square pyramids shown in Fig. 2. This design may be repeated over the surface of the board. We produce it by crosscutting the material, by means of rotary cutters, transversely and longitudinally the natural direction of the grain of the wood. After the design is made as aforesaid, we produce upon the surface of said board the deep scores or channels B and the similar scores or channels C. The scores B are made longitudinally and the scores C transversely the grain. We then divide said board transversely along the lines D E, F G, &c., and then longitudinally along the dotted lines H I, J K, at right angles to said lines D E, F G. In this way we produce the pieces L and M M. Each piece M is

then divided longitudinally along the line N N to form two pieces similar to L and to Fig. 4. It remains simply to form the finger notch or cavity O on the rear side of the handle, which is then ready for use.

The mode of making the handle shown in Fig. 4 is substantially the same as that already described, the principal difference being the omission of the deep longitudinal channels B. The board is divided transversely, as before, along the dotted lines D E, F G, and the resulting pieces are divided along the lines N N to form the handle shown in Fig. 4. Upon the rear side of said handle the finger-notch is formed, as already explained.

We claim—

1. The method of making ornamental wooden handles, substantially as herein set forth, which consists in first forming on the surface of a block, plank, or board a new ornamental configuration, and deep channels or grooves standing at an angle to or transversely the direction of the grain of the wood and like channels standing longitudinally the direction of said grain, then dividing said board along the center lines of said channels and forming finger notches or recesses in the pieces so produced.

2. The method of making ornamental wooden handles, substantially as herein set forth, which consists in first forming on the surface of a block, plank, or board a new ornamental configuration, and deep channels or grooves standing at an angle to or transversely the direction of the grain of the wood and like channels standing longitudinally the direction of said grain, then dividing said board along the center line of said channels, and then dividing the pieces so produced and forming finger notches or recesses in said pieces.

3. The method of making ornamental wooden handles, substantially as herein set forth, which consists in forming on the surface of a block, board, or plank a new ornamental configuration, and deep channels or grooves disposed at an angle to or transversely the grain of the wood, then dividing said board along the center line of said channels, dividing the pieces so produced, and forming finger notches or recesses in said pieces.

4. The method of making ornamental wooden handles, substantially as herein set forth,

which consists in producing on the surface of a block, plank, or board a new ornamental configuration, and deep channels or grooves B and C, respectively disposed longitudinally and transversely the grain of the wood, dividing said board on the center lines of said channels, and then forming on the rear side of the pieces so produced finger notches or recesses.

5  
10 5. The method of making ornamental wooden handles, substantially as herein set forth, which consists in producing on the surface of a board, block, or plank a new ornamental

configuration, and deep channels or grooves C transversely the direction of the grain of the wood, dividing said board on the center lines of said channels, dividing said board on the lines N N, and forming on the rear side of the pieces so produced finger notches or recesses. 15

FREDERICK MANKEY.  
C. F. MANKEY.

Witnesses:

JAMES S. GREVES,  
EDGAR GOODWIN.