G. F. DANIELSON.

PROCESS OF FORMING METAL SEATS.

APPLICATION FILED APR. 11, 1917.

1,289,685.

Patented Dec. 31, 1918.

Fig. 1

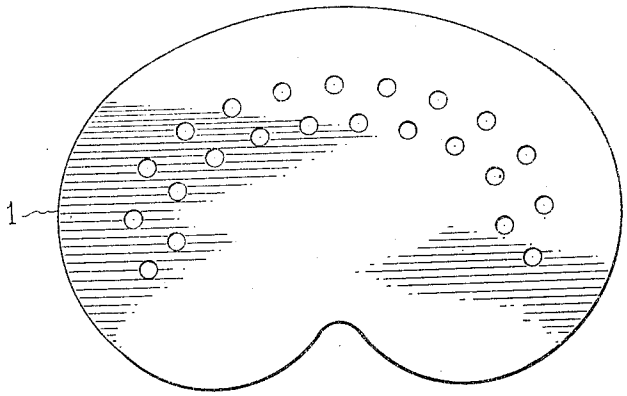


Fig. 2

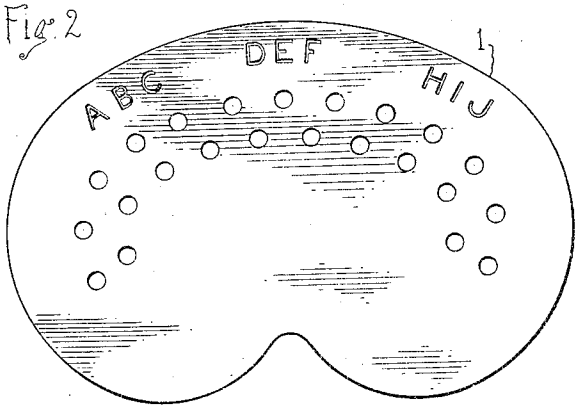


Fig. 3

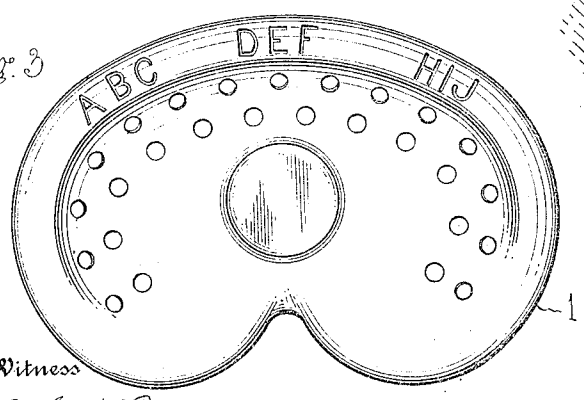
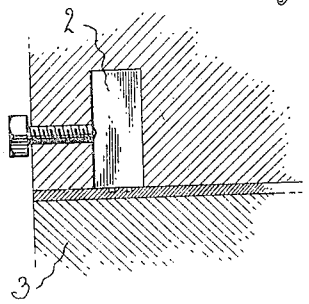


Fig. 4



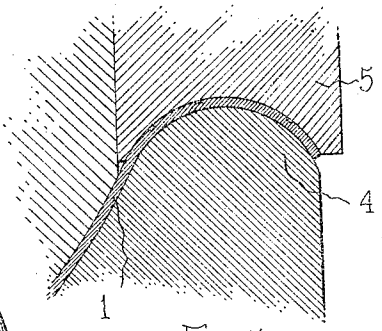


Fig. 5

Witness

Arthur F. Draper

Chas. W. Stauffiger

Inventor

Gustave F. Danielson

By Bartlett & Bartlett Attorneys

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

UNITED STATES PATENT OFFICE.

GUSTAVE F. DANIELSON, OF YOUNGSTOWN, OHIO.

PROCESS OF FORMING METAL SEATS.

1,289,685. Specification of Letters Patent. Patented Dec. 31, 1918.

Application filed April 11, 1917. Serial No. 161,380.

To all whom it may concern:

Be it known that I, GUSTAVE F. DANIELSON, a citizen of the United States of America, residing at Youngstown, in the county of Mahoning and State of Ohio, have invented certain new and useful Improvements in Processes of Forming Metal Seats, of which the following is a specification, reference being had therein to the accompanying drawings.

This invention relates to a method of impressing characters upon a sheet metal seat and to certain features thereof whereby very distinct indentations are formed without materially affecting the strength of the material.

The invention consists in the matters hereinafter set forth and more particularly pointed out in the appended claims.

In the drawings,

Figure 1 shows a seat blank ready for the impressing process;

Fig. 2 shows an impressed blank;

Fig. 3 shows a finished blank, and

Figs. 4 and 5 are views in detail of a die suitable for carrying out the method.

A blank 1 of sheet metal and appropriate contour, but plane in cross-section is stamped of sheet metal. It is then brought under an impressing die in which letter blocks 2 may be detachably secured by an appropriate means so as to permit ready change of the letters as desired. The bed 3 of the die is such as to prevent displacement of the metal below the plane of the blank, while the letter blocks themselves are arranged around the marginal portion of the blank as indicated in Fig. 2.

The plane blank is then brought under a forming die in which the flange 4 of the bed coöperates with a head 5 to convex and mold the impressed rim as indicated in Fig. 3 and thereby elongate the impressed letters without otherwise deforming the impressions.

As a result a seat blank is formed with impressions thereon that are very legible, are not deep enough to retain water or produce discomfort to the user.

Obviously changes in the details of operation may be had without departing from the spirit of my invention and I do not limit myself to any specific manner of effecting the several steps.

What I claim is:—

1. A method of impressing characters on a sheet metal seat that consists in shaping a plane blank, in impressing characters in a portion of one face thereof and in elongating the characters by crowning that portion of the blank on which the characters appear.

2. A method of impressing characters on a sheet metal seat which consists in shearing a blank to form from a plane sheet, in impressing characters on a portion of one face thereof, and in elongating the characters by outbending and crowning the face of the impressed portion.

3. A method of impressing characters on a sheet metal seat which consists in cutting a blank from a plane seat, in impressing or stamping characters thereon without displacement of the body of the sheet between the impressions and the opposite face of the sheet and in elongating the characters by convexing the impressed portions of the surface.

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

GUSTAVE F. DANIELSON.

Witnesses:

ANNA M. DORR,

G. E. MCGRANN.

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