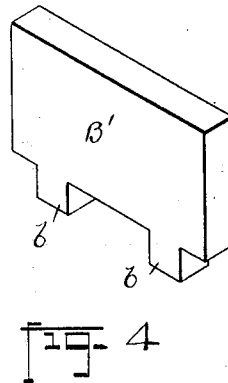
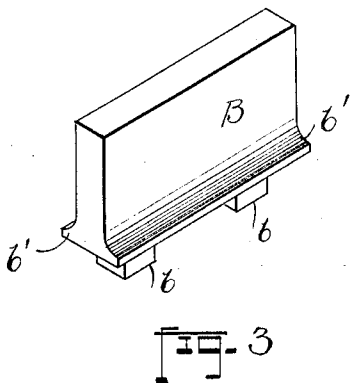
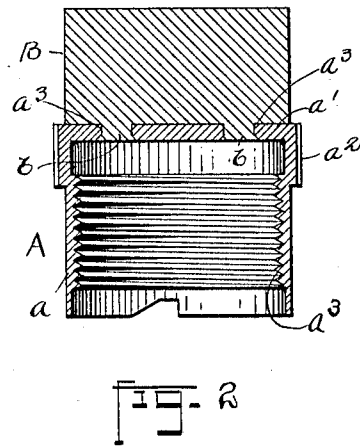
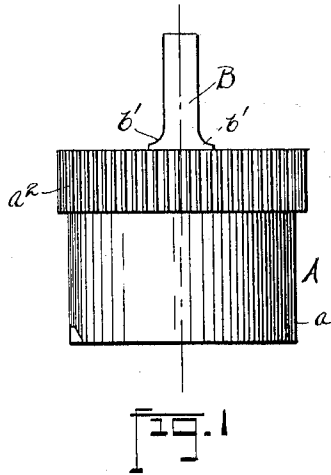


O. ZERK.
 PROCESS OF MAKING WINGED CAPS.
 APPLICATION FILED FEB. 19, 1912.

1,048,261.

Patented Dec. 24, 1912.



WITNESSES
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PROCESS OF MAKING WINGED CAPS.

1,048,261.

Specification of Letters Patent.

Patented Dec. 24, 1912.

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To all whom it may concern:

Be it known that I, OSCAR ZERK, a subject of the Emperor of Austria-Hungary, residing at Cleveland, in the county of Cuyahoga and State of Ohio, have invented a certain new and useful Improvement in Processes of Making Winged Caps, of which the following is a full, clear, and exact description, reference being had to the accompanying drawings.

This invention relates to screw threaded caps provided with wings for turning them. For example, the caps of grease cups.

The object of the invention is to provide for the making of such caps very cheaply.

To this end the invention consists, in one aspect, of the process of producing the wing and securing it to the cap, and in the other aspect, of the wing and cap so designed that they may be very cheaply constructed by such process.

The drawings hereof show the article and serve to illustrate the method of its manufacture.

In the drawings, Figure 1 is a side elevation of my improved winged cap; Fig. 2 is a transverse vertical section thereof; Fig. 3 is a perspective view of the wing before it is applied to the cap; Fig. 4 is a perspective view of the blank from which the wing is made.

My winged cap consists of the cap proper A formed with a side wall a and a top a' , and a wing B formed independently of the cap and riveted to it by lugs b of the wing which extend through the top a' of the cap and are upset on the under side of the cap. The wing is provided on opposite sides with flanges or ribs b' which lie along the top of the cap and prevent the wing being displaced in either direction.

The cap is shown as having an outwardly pressed annular portion a^2 of its wall, which is suitably knurled to provide a finger hold. Internally, the wall of the cap is shown as having screw threads a^3 . The openings a^4 in the top of the cap which are occupied by the lugs b of the wing may flare or be coun-

tersunk on the under side to receive the peened portion of the ends of the legs.

In constructing my winged cap, the cap is formed by stamping or pressing from sheet metal with openings through the top for the reception of the lugs of the wing. Such operation, in the case of a cap of the form shown in the drawings, may be made by forcing a disk through dies to bend it into a substantially cylindrical cap and then applying liquid pressure to the interior of the cap while the outside is held between dies which have a recess to receive the head portion. The wing is made from a parallel sided blank of metal, as shown at B' in Fig. 4. After being cut out, as shown in this figure, the blank is placed in dies and pressure is brought to bear against the edge thereof opposite the lugs b . This pressure forces out the two side ribs b' , as well as causing the lugs to fill the die recesses which they occupy. When the wing is formed it is placed upon the cap with the lugs projecting through the openings in the top of the cap and then these lugs are upset or riveted over on the under side of the cap.

The cap produced by my process is as neat in appearance and as effective in service as if the wing were one integral piece with the cap, while the article is very much cheaper in construction, enabling both the cap and wing to be pressed out of sheet metal, as above explained.

Having thus described my invention, what I claim is:

1. The process of making winged caps consisting of forming the cap with an opening through its top and forming the wing with a lug on one edge and upsetting projecting ribs from the sides of said wing adjacent to the lug, and passing said lug through an opening in the cap and upsetting the under side of the lug.

2. The process of making winged caps consisting of forming a cap with a flat top having openings through it and forming a wing by pressure from a flat blank, said pressure forcing outwardly a pair of flat

bottomed flanges on opposite sides of the wing near one edge, there being lugs projecting from such edge, and then passing such lugs through the openings in the cap
5 with the flanges abutting the top surface of the cap, and then upsetting the lugs on the under side of the cap top.

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

OSCAR ZERK.

Witnesses:

ALBERT H. BATES,
GERTRUDE K. SMITH.

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