No. 768,615. PATENTED AUG. 30, 1904.

E. A. MOORE.

METHOD OF MANUFACTURING LATCH LIFTING DEVICES.

APPLICATION FILED MAR. 29, 1904.

NO MODEL.

Fig. 1.

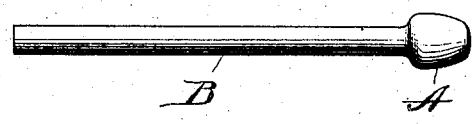


Fig. 2.

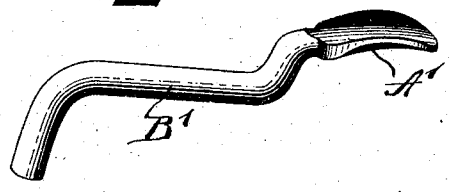
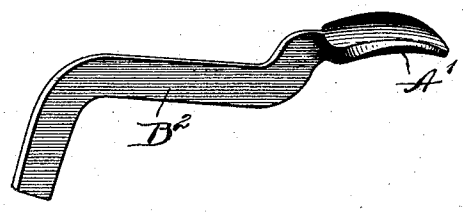


Fig. 3.



Witnesses
Geo. Y. Rappmann
W. D. Allyn

Inventor
E. A. Moore
By his Attorneys
Baxter, Brownell & Middleton

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UNITED STATES PATENT OFFICE.

ETHELBERT A. MOORE, OF NEW BRITAIN, CONNECTICUT, ASSIGNOR TO THE STANLEY WORKS, OF NEW BRITAIN, CONNECTICUT, A CORPORATION OF CONNECTICUT.

METHOD OF MANUFACTURING LATCH-LIFTING DEVICES.

SPECIFICATION forming part of Letters Patent No. 768,615, dated August 30, 1904.

Application filed March 29, 1904. Serial No. 200,578. (No model.)

To all whom it may concern:

Be it known that I, ETHELBERT A. MOORE, a citizen of the United States, residing at New Britain, Hartford county, and State of Connecticut, have invented certain new and useful Improvements in Methods of Manufacturing Latch-Lifting Devices, of which the following is a full, clear, and exact description.

My invention relates to a new and useful method of forming latch-lifting devices, and has for its object simplicity, economy, uniformity, and rapidity of production of an article having great strength adapted to its special usage.

Figure 1 is a side elevation of a blank from which the latch-lifting device is made, showing the product of the first step of my improved method. Fig. 2 is a perspective view of the latch-lifting device partially formed as the result of the second step of my method. Fig. 3 is a perspective view of the completely-formed latch-lifting device, the result of the third and final step of my method.

In carrying out my invention I employ a piece of wire of suitable length. The first step comprises the upsetting or enlarging of one end of this wire, so as to form a bulbous head A, as shown in Fig. 1, with the shank B extending therefrom. The second step comprises swaging the blank of Fig. 1 between suitable dies, so as to transform the bulbous head into a thumb-piece and to bend the shank so that it will assume approximately a curve adapted to the final use of the finished article. In Fig. 2 the finished thumb-piece is indicated at A′, and the partially-formed shank is indicated at B′. Having thus completed the thumb-piece and partially completed the shank, I subject the article to a third swaging, applying the dies this time, however, to the shank only and flattening the sides of the same in a plane substantially at right angles to the plane of the thumb-piece A′. In Fig. 3 I have shown the finished article, in which A′ represents the thumb-piece, as before, and B^2 represents the shank. This completes the steps of the new method. The lifter may of course be afterward drilled for a pivot-pin, finished, polished, plated, &c., as desired. The shape of the bulbous head, as shown, is such as to give the best results in forming a suitably-shaped thumb-piece.

By the employment of my improved method the fibrous structure of the iron or other metal employed is preserved, and the lifter is consequently strong and durable. These articles when produced by my method can be turned out rapidly and very economically and of uniform shape, size, and condition.

What I claim is—

The method of producing latch-lifting devices comprising upsetting one end of a wire blank to form a bulbous head, swaging said blank to flatten said head to produce a thumb-piece and bending the shank to the desired outline and finally swaging said shank to flatten it in the plane in which it is bent and substantially at right angles to the plane of the flattened thumb-piece.

Signed at New Britain, Hartford county, and State of Connecticut, this 25th day of March, 1904.

ETHELBERT A. MOORE.

Witnesses:
GEO. P. HART,
H. P. CARTER.