(No Model.)

J. BERBECKER.

MANUFACTURE OF SCREW KNOBS.

No. 439,830. Patented Nov. 4, 1890.

Fig. 1.

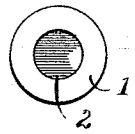


Fig. 2.

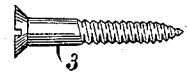


Fig. 3.

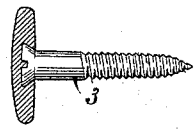


Fig. 4.

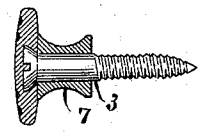


Fig. 5.

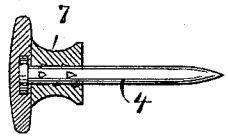
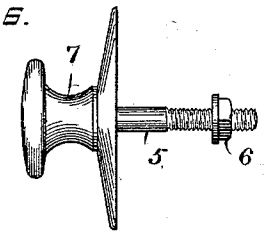


Fig. 6.



Witnesses

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UNITED STATES PATENT OFFICE.

JULIUS BERBECKER, OF NEW YORK, N. Y.

MANUFACTURE OF SCREW-KNOBS.

SPECIFICATION forming part of Letters Patent No. 439,830, dated November 4, 1890.

Application filed May 12, 1890. Serial No. 351,442. (No model.)

To all whom it may concern:

Be it known that I, JULIUS BERBECKER, a citizen of the United States, residing at New York, in the county of New York and State of New York, have invented certain new and useful Improvements in the Manufacture of Screw-Knobs; and I do hereby declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it appertains to make and use the same.

My invention has for its object the production of screw-knobs which shall be neat and attractive in appearance, capable of unlimited variation in design, and which may be produced entirely by press-work, thus wholly avoiding the use of high-priced machinery and greatly reducing the cost of production.

With these ends in view I have devised the novel screw-knob and method of making the same, of which the following description, in connection with the accompanying drawings, is a specification, numbers being used to denote the several parts.

Figure 1 is a plan view of a disk from which the head is formed; Fig. 2, an elevation of a wood-screw from which the shank is formed; Fig. 3, a section of the head after it is swaged in place upon the screw; Fig. 4, a section of a completed screw-knob; Fig. 5, a section of knob of this class, except that a nail is substituted for a screw; and Fig. 6 is an elevation of a screw-knob used in connection with an escutcheon—for example, as in a drawer-pull—an ordinary threaded bolt and nut being used instead of a wood-screw.

1 denotes the blank from which the head is formed, and which is provided with a recess 2. These blanks are formed complete and the recess formed therein at a single operation by an ordinary drop-press.

3 denotes an ordinary wood-screw; 4, a nail, the shank of which is roughened under the head, and 5 an ordinary bolt, having a nut 6, either of which may be used in connection with the blank. Instead of casting the knob upon the screw or bolt, or of casting the knob in a number of pieces, leaving them loose on the screw, or of forming the knob of vitreous or other material and attaching it to the screw by plaster or lead, all of which processes of making are in common use, I form a solid head upon the screw or bolt, but form the head entirely by press-work and secure it in place by press-work.

7 denotes the necks of the knobs, which I form by cutting a rod of metal, ordinarily brass, into suitable lengths and turning or otherwise forming them to any desired ornamental shape, drilling them, and then driving them on over the screw, as clearly shown in Fig. 4.

It will be seen that if the knob is formed from an ordinary wood-screw, as in Figs. 3 and 4, when the head is swaged in place upon the screw the metal of the head is forced into the cut in the head of the screw, which assists in holding the head in place. When a nail is used, as in Fig. 5, the irregularities and roughness of the head of the nail will accomplish the same purpose and prevent the head from turning off under any ordinary strain that can be applied. The same is true when bolts are used, as the irregularity of the shape of the heads will hold them firmly in place when the metal of the blank is pressed about them.

The necks of the knobs cannot get loose, as they are driven firmly to place, and there is, moreover, no strain upon them in use.

In making the better grades of knobs, and where they are to be used as drawer-pulls, as in Fig. 6, I give to the heads any desired ornamental appearance—as, for instance, a series of rings as indicated in Fig. 4—it being of course understood that it is quite easy to form the metal of the head in any desired pattern by cutting the pattern in the die.

Having thus described my invention, I claim—

1. The herein-described method of making screw-knobs, the same consisting in forming blanks with recesses in one side thereof, placing the heads of wood-screws in said recesses, swaging the metal of the blanks about the heads of the screws to form the heads of the knobs, forming the necks to the required shape by cutting sections from a rod of metal and drilling out said sections to form sleeves, and finally driving said sleeves over the screws into place under the heads of the knobs.

2. As a new manufacture, a screw or nail provided with a knob or head consisting of two portions, one of which is the head proper,

and which is swaged upon the blunt end of the said screw or nail, and the other of which is a bored-out metallic sleeve closely fitting the shank of the said screw or nail and driven into position close to the said head proper.

3. As a new manufacture, a screw-knob having a shank 3, consisting of an ordinary wood-screw, a head swaged over the ordinary screw-head, and an ornamental neck consisting of a metallic sleeve 7, closely fitting the shank of the said screw and driven into position close to the said head.

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

JULIUS BERBECKER.

Witnesses:
A. M. WOOSTER,
ARLEY I. MUNSON.