N. L. JACOBUS.

METHOD OF PRODUCING FIGURE WHEELS AND THE LIKE.

APPLICATION FILED SEPT. 2, 1920.

1,357,565. Patented Nov. 2, 1920.

Fig. 1.

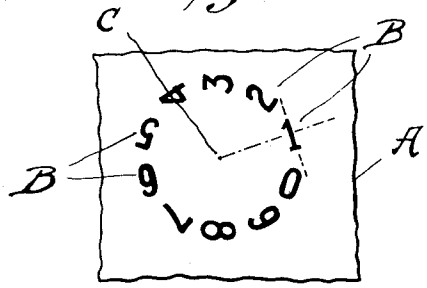


Fig. 2.

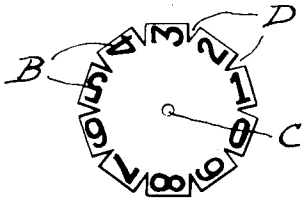


Fig. 3.

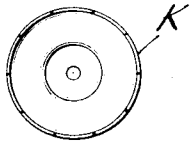


Fig. 4.

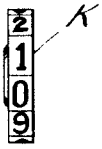
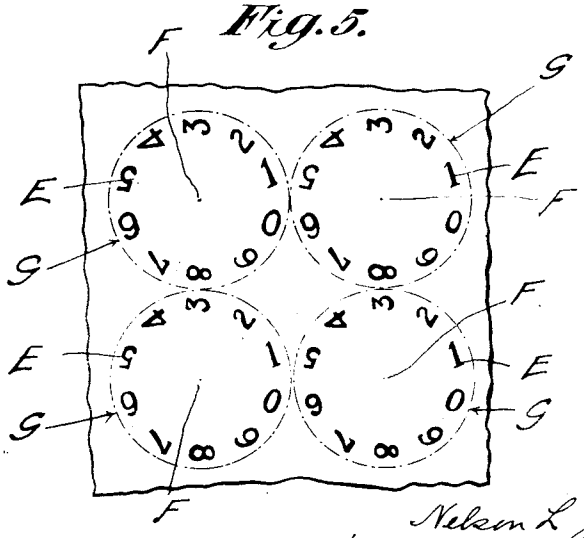


Fig. 5.



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METHOD OF PRODUCING FIGURE-WHEELS AND THE LIKE.

1,357,565. Specification of Letters Patent. Patented Nov. 2, 1920.

Application filed September 2, 1920. Serial No. 407,794.

To all whom it may concern:

Be it known that I, NELSON L. JACOBUS, a citizen of the United States, and a resident of Garden City Estates, in the county of Nassau and State of New York, have invented a certain new and useful Method of Producing Figure-Wheels and the like, of which the following is a specification.

This invention relates to a process of producing indication marks on the flange or upturned portion of a member of sheet material, such as a figure wheel for calculating or other machines and has for its main object reduction in cost of manufacture.

In the art of making figure wheels, as heretofore practised, it has been the custom to first shape the flanged wheel from a blank of sheet material by a drawing or stamping operation; and thereafter to apply indication marks on the circumferential flange so produced. This is a relatively expensive process and moreover is not wholly satisfactory since it results in considerable distortion of the indication marks on the flange. The main feature of this invention is a process whereby the indication marks may be applied to a blank of sheet material before it is bent in such manner that when the blank is subsequently bent, the indication marks will be arranged circumferentially on the flange of the figure wheel in properly spaced relation and alinement.

In the accompanying drawings, the invention is shown in a concrete and preferred form in which—

Figure 1 is a fragmentary view of a flat blank of sheet material with indication characters applied thereto;

Fig. 2 shows the blank after it has been notched;

Fig. 3 shows a plan view of the finished wheel;

Fig. 4 is a side elevation of the finished wheel; and

Fig. 5 shows a large blank with several groups of indication characters.

A indicates a blank of sheet material to the surface of which has been applied indication characters or marks B. It will be noted that these indication characters are so applied as to be radially disposed with reference to the center C of the blank. The blank is then trimmed and the edges thereof are then notched as at D by removing part of the material of the blank between adjacent indication marks. The blank is now provided with a flange K by bending the material carrying the indication marks and thereby bringing said indication marks into proper circumferential spacing and alinement on said flange,—that is, parallel to the axis of the figure wheel.

It will be understood that preferably, in practice, a large sheet of tin will be decorated to simultaneously produce a plurality of groups E of indication marks; the members of each group being radially disposed with reference to a common center F, as shown in Fig. 5, the decorating operation being carried on by printing, etching, photo-engraving or otherwise in a manner well understood in the art. The decorated blank can then be cut, say on lines G into a number of smaller blanks, and each blank notched and bent, as previously described. It will be understood that the cutting, notching and bending operations may be carried on practically simultaneously; or, they may constitute separate steps, as may be desired.

I claim:

1. The process of producing circumferentially extending indication marks, substantially parallel to its axis, on the flange of a member of sheet material which consists in applying, to a flat blank of sheet material, indication marks in substantially radial relation to the center of said blank, then in removing part of the material between adjacent indication marks, and in bending the material carrying the indication marks into flange formation.

2. The process of producing circumferentially extending indication marks, substantially parallel to its axis, on the flange of a member of sheet material which consists in applying, to a flat blank of sheet material, a plurality of groups of indication marks, the marks of each group being substantially radial to a common center, then in cutting said large blank into smaller blanks, then in removing part of the material between adjacent indication marks on the small blank, and in bending the material of the small blank carrying the indication marks into flange formation.

Signed at New York city, in the borough of Brooklyn, county of Kings and State of New York, this 25th day of August, 1920.

NELSON L. JACOBUS.