(No Model.)

D. S. HAMMOND, Jr.

SATCHEL.

No. 394,487. Patented Dec. 11, 1888.

FIG. 1.

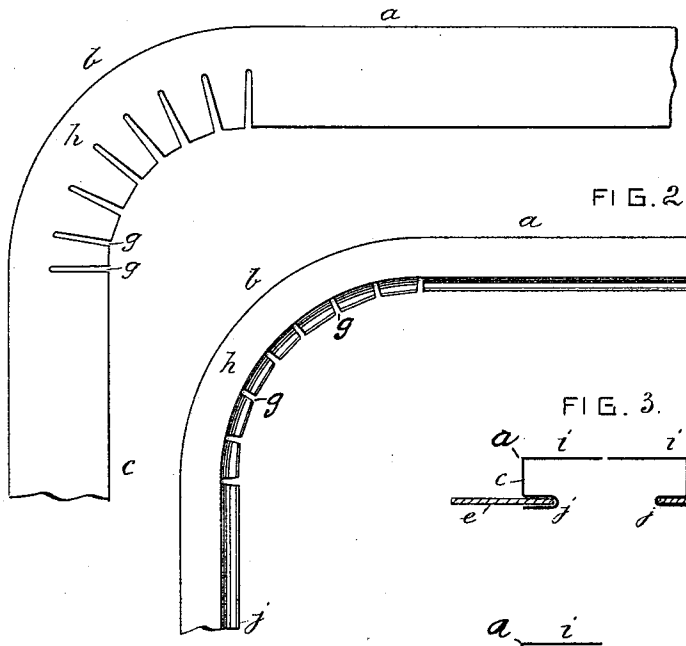


FIG. 2.

FIG. 3.

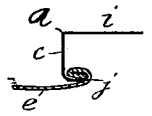
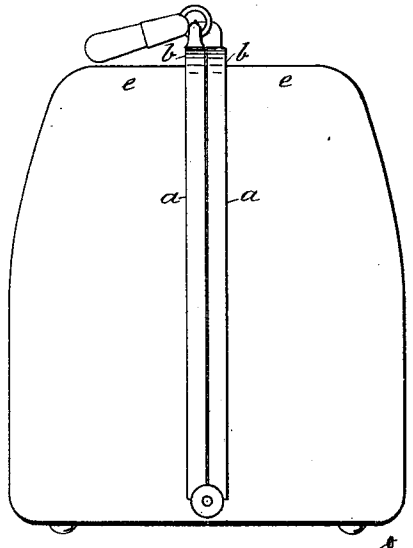


FIG. 4.

FIG. 5.



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UNITED STATES PATENT OFFICE.

DANIEL S. HAMMOND, JR., OF BROOKLYN, NEW YORK.

SATCHEL.

SPECIFICATION forming part of Letters Patent No. 394,487, dated December 11, 1888.

Application filed July 12, 1888. Serial No. 279,752. (No model.)

To all whom it may concern:

Be it known that I, DANIEL S. HAMMOND, Jr., a citizen of the United States, and a resident of Brooklyn, in the county of Kings and State of New York, have invented certain new and useful Improvements in Satchels, of which the following is a specification.

My invention consists of improvements in the contrivance of satchel-frames for and in the connection of the sack or box web or fabric thereto, as hereinafter described and claimed, reference being made to the accompanying drawings, in which—

Figure 1 is a side elevation of part of a jaw-frame partly prepared for reception of the sack or bag web or fabric. Fig. 2 is a similar view of the same as when completely formed ready for reception of the fabric. Fig. 3 is a transverse section of the two jaw-frames and parts of the sack or bag web, showing the contrivance of the connection of the webs with the frames, one side being complete and the other preparatory to the final act of clamping the metal on the bag-web. Fig. 4 is a transverse section of a jaw-frame and part of a sack-web, showing a modification of the connection of the web and jaw-frame. Fig. 5 is an end elevation of a complete satchel.

My invention relates to the construction of satchels having the metallic angle jaw-frames *a*, made with curved or rounded corners *b*, which are more symmetrical and preferable than the angular corners, which are generally made because it is very simple to make the bends for angular corners by cutting a single notch or slit, *d*, in the part or flange *c* of the angle-iron that has to be bent edgewise, while up to this time it has been so difficult to make round corners, together with the groove for securing the bag-web, that they have not been so generally used in cheap satchels as they would otherwise be.

To make the angular bend of the frame, which is necessarily concentrated at one point, the flange *c* has to be cut its whole breadth, so that the strength of one of the flanges of the jaw is wholly lost, except the parts are lapped and riveted together, which is generally done in practice to recover the lost strength. This adds considerably to the expense, and is therefore somewhat objectionable; but it is much more objectionable because of the way of connecting the bag-web *e*, which it makes necessary, which consists of drawing the edges of the web between the edges of flange *c*, laying or folding them back on the side of said flange and fitting a metallic inlay-strip, usually employed on the margins of the web, and sewing or riveting the whole together through the flange, said flange and inlay being suitably perforated for the purpose.

The first part of my invention consists in producing the frames with the desired curved or rounded corners *b* and the continuous flange *c*, without lap or rivet, without cutting flange *c* so far through its breadth as to materially weaken it, or, preferably, without cutting it at all, which may be done with powerful dies adapted for suitably drawing and shaping the metal while hot; but it may be done in a simpler way without heating by cutting it far enough to prevent unduly stretching said flange on the one edge and buckling it on the other, which latter results I obtain by cutting the series of notches *g* at suitable intervals apart along the portion to be bent, and of such depth as will leave such uncut breadth *h* next to the other flange, *i*, of the angle-frame as may be readily bent without buckling, and making the notches *g* of such angular form and dimensions as that they will close together, or thereabout, by the bending of the frame, and thus make the flange *c* practically continuous around the curve and uniform with the rest of the same.

The second part of the invention consists of providing the web-groove *j* in the flange *c* continuously around the curve and along the rest of the flange by striking or stamping it in suitable dies and inserting the edge or edges of the bag-web in said groove and clamping it therein by closing the side walls of the groove on it, said groove being preferably made in the outside of the flange, as represented in Fig. 3; but it may be made inside by turning the edge of the flange inward and then backward on itself, as represented in Fig. 4; but the preferable arrangement is that of Fig. 3, in which the bag-web enters the groove straight, while in the other it has to pass through the frame and be folded back over the coil of the flange and into the groove. It will be seen that it is feasible to make this

continuous groove in the flange *c*, which is itself thus made continuous and in curved form at the bend, while the angular form and lapped and riveted condition of the common arrangement cannot well or practicably be so grooved, and, especially when the groove is made on the outside of the flange, it affords the most simple as well as much the neatest and most practical way of securing the bag-web.

I am aware that it is not new to make a series of saw-kerfs in the side of a piece of wood to enable it to be bent into rounded or curved shape, and I disclaim such device. My invention consists in the construction of metallic angle bag-frames with rounded corners, so that one of the flanges, being bent edgewise or in its plane, has remaining an uncut part, which, after being bent and set in the desired curved form, still possesses the requisite strength for the purposes of the frame without re-enforcement of lapping and riveted parts, and also has uniform continuity of the flange, enabling the groove for reception of the edge of the bag-web to be formed continuously in said curved part as along the rest of the flange.

What I claim, and desire to secure by Letters Patent, is—

1. The improved angle jaw-frame for satchels, having the curved or rounded corners produced in the plane of flange *c*, made in suitable width for having the bag-web groove formed in it, with a series of notches, *g*, cut partly across the flange *c*, but leaving a continuous uncut part, *h*, thereof between said notches and the other flange, *i*, of the frame, said part *h* being bent in its plane to form the curved or rounded corner, and the notches thereby closed or practically closed and forming uniform continuity of the rest of said flange, substantially as described.

2. The improved angle jaw-frame for satchels, having the curved or rounded corners produced in the plane of flange *c*, made in suitable width for having the bag-web groove formed in it, with a series of notches, *g*, cut partly across the flange *c*, but leaving a continuous uncut part, *h*, thereof between said notches and the other flange, *i*, of the frame, said part *h* being bent in its plane to form the curved or rounded corner, and the notches thereby closed or practically closed and forming uniform continuity of the curved part with the rest of said flange, and said flange having the bag-web-receiving groove formed in it continuously around the curved part and along the rest of the flange, substantially as described.

3. The combination of the bag-web with the angle jaw-frames for satchels, having the curved or rounded corners produced in the plane of flange *c*, made in suitable width for having the bag-web groove formed in it, and with uniform continuity of said flange, and having the bag-web-receiving groove *j* formed around the curved part and along the rest of said flange in the outside of the same in the direction of or relation to the bag-web for receiving the edge of the web directly in it without curve or bend of said web, and the edge of the said web being clamped in the groove, substantially as described.

4. The combination of the bag-web with the angle jaw-frame for satchels, having the curved or rounded corners produced in the plane of flange *c*, made in suitable width for having the bag-web groove formed in it, with a series of notches, *g*, cut partly across the flange *c*, but leaving a continuous uncut part, *h*, between said notches and the other flange, *i*, of the frame, said part *h* being bent to form the curved or rounded corner, and the notches thereby closed and forming uniform continuity of said curved part with the rest of said flange, said flange having the bag-web-receiving groove formed continuously in it around the curved part and along the rest of the flange, and the edge of the bag-web being inserted and clamped in the groove, substantially as described.

Signed at New York city, in the county and State of New York, this 19th day of June, A. D. 1888.

DANIEL S. HAMMOND, JR.

Witnesses:
W. J. MORGAN,
GEO. T. JANVRIN.