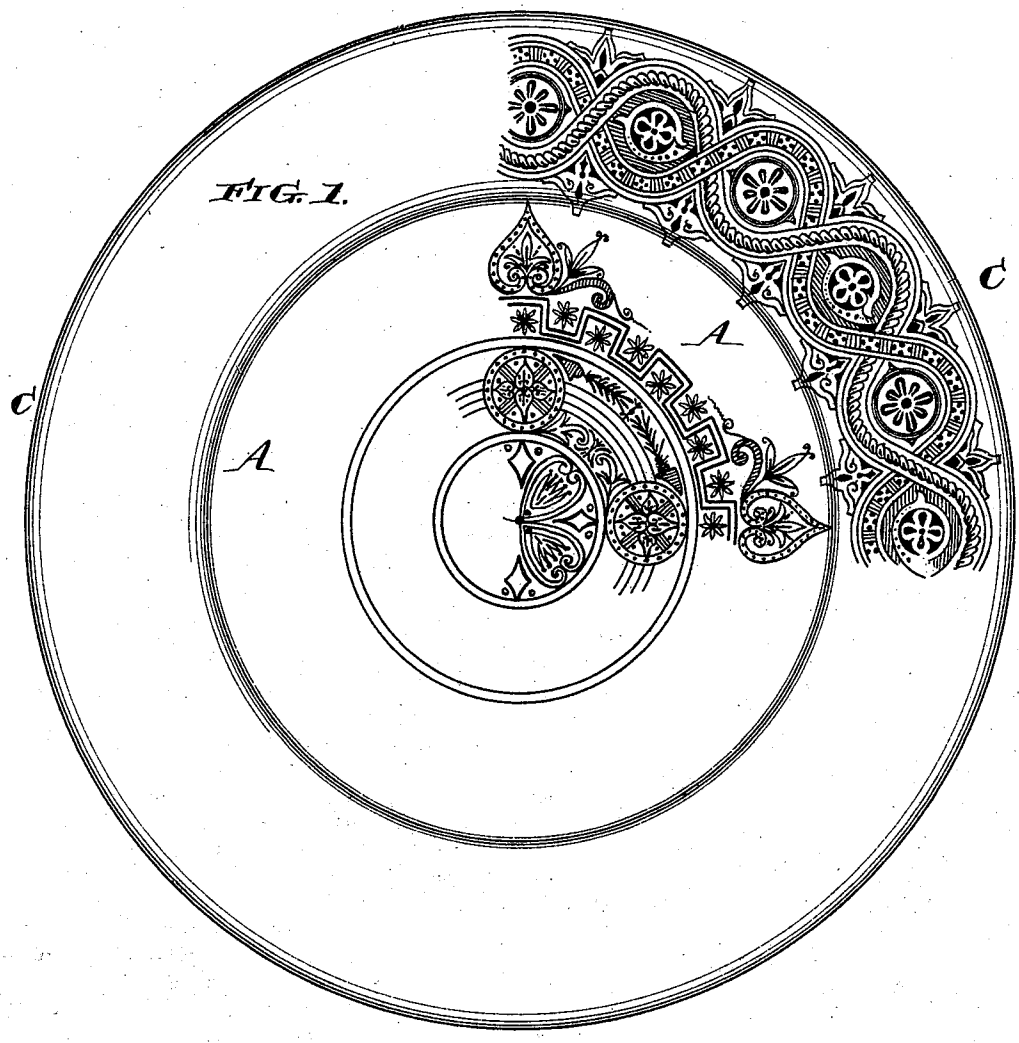
(No Model.)

Z. T. HALL.

PROCESS OF MAKING SHEET METAL SALVERS.

No. 499,359. Patented June 13, 1893.

FIG. 1.



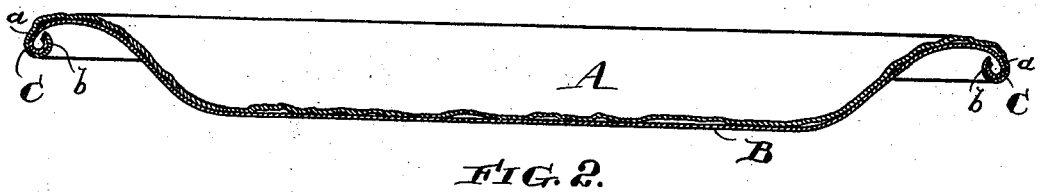


FIG. 2.

Witnesses:
Jos. G. Vogels.

Inventor:
Zachary Taylor Hall

UNITED STATES PATENT OFFICE.

ZACHARY TAYLOR HALL, OF PHILADELPHIA, PENNSYLVANIA.

PROCESS OF MAKING SHEET-METAL SALVERS.

SPECIFICATION forming part of Letters Patent No. 499,359, dated June 13, 1893.

Application filed May 22, 1891. Serial No. 393,782. (No model.)

To all whom it may concern:

Be it known that I, ZACHARY TAYLOR HALL, a citizen of the United States, residing at Philadelphia, in the county of Philadelphia and State of Pennsylvania, have invented new and useful Improvements in Methods of Constructing Artistic Sheet-Metal Salvers, of which the following is a specification.

There are several ways of working artistic designs into or upon the face surface of sheet metal salvers. They may be embossed on the blank sheet between properly prepared steel rollers; they may be etched on the plain surface by a proper use of wax and nitric acid; they may be engraved on the face with a graver's tool.

Etched and engraved designs properly executed on salvers are too expensive for the masses. Embossed work is the cheapest, and as heretofore made shows the impressions of the rollers on both sides of the sheet, as well when the salver is finished as before. This is deemed undesirable and gives them a common appearance by showing how they are made, with the result that salvers made from costly designs in this way do not command paying prices.

The object of my invention is to provide a composite salver new in character and moderate in cost. This I do by combining two sheets of the same size or dimensions, one embossed and the other plain, and forming them together not by spinning, but by stamping between properly prepared dies, so that a plain smooth under surface shall have for its upper or face surface a highly artistic, but embossed central face, its raised sides preferably plain, and rim ornamented, if desired, by stamping suitable figures at or near the edge of its raised part. The preparation of the dies includes the backing out of the follower over the embossed figures so that no ornamentation, by the process of drawing the sheets together by stamping, is marred; and finally in finishing the salver the edges of the two are folded or rolled together smoothly in the form of a plain bead, by which the edges of both are concealed and the two locked firmly together as one; and the finished salver has this new character, an embossed face, its reverse side plain, a strong and workmanlike article and the mode of its manufacture concealed from common observation.

In the drawings similar letters indicate similar parts in both views.

Figure 1 shows the level face side of the salver with a sample of a design that may be embossed upon it. Fig. 2 is a central cross section of Fig. 1 and includes the raised sides and rolled edges of the finished salver.

(A.) is the level central face embossed with an artistic design. It is the upper of the two sheets of metal used together.

(B.) is the lower of the two sheets used and is left by preference, entirely plain.

(*a.*) is the outside and (*b.*) the inside of the bead (C.) by which the two plates are firmly held together.

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

The method herein described and shown of constructing embossed sheet metal salvers; which consists of stamping an embossed sheet with a plain one and rolling their edges together so that the two sheets are concealed in the semblance of one; embossed on one side and plain on the other, substantially as and for the purpose herein set forth.

ZACHARY TAYLOR HALL.

Witnesses:

JOS. G. VOGELS,

GEO. R. MOORE.