(Model.)

T. DONAHUE & C. W. JUDSON.

KEY.

No. 268,643. Patented Dec. 5, 1882.

Fig. 1.

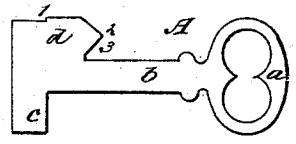


Fig. 2.

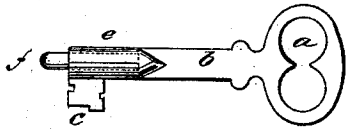


Fig. 3.

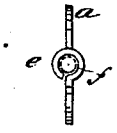
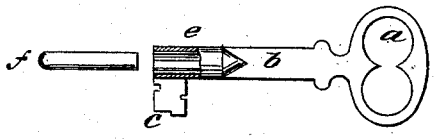


Fig. 4.



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UNITED STATES PATENT OFFICE.

THOMAS DONAHUE AND CHARLES W. JUDSON, OF TERRYVILLE, CONNECTICUT, ASSIGNORS TO THE EAGLE LOCK COMPANY, OF SAME PLACE.

KEY.

SPECIFICATION forming part of Letters Patent No. 268,643, dated December 5, 1882.

Application filed April 12, 1882. (Model.)

To all whom it may concern:

Be it known that we, THOMAS DONAHUE and CHARLES W. JUDSON, of Terryville, in the county of Litchfield and State of Connecticut, have invented a new and useful Improvement in Keys, of which the following is a full, clear, and exact description.

The invention consists in an improvement in the construction of sheet-metal keys, as hereinafter described and claimed.

Reference is to be had to the accompanying drawings, forming a part of this specification, in which similar letters of reference indicate corresponding parts in all the figures.

Figure 1 is a face view of the key-blank. Fig. 2 is a side view of a finished key, as provided with a spindle. Fig. 3 is an end view of the spindle-key, and Fig. 4 is a sectional side view of a barrel-key.

A is the blank of a sheet metal formed with the bow *a*, shank *b*, bit *c*, and the portion *d* that is to be turned or folded to form the barrel of the key. The portion *d* is shouldered at 1 to take behind the bit *c* when folded, and has also a pointed projection, 2, for lapping upon the shank *b*, to give finish to the inner end of the barrel, as shown. Between the shank *b* and projection 2 a shoulder, 3, is provided corresponding to the thickness of the blank, and which allows the projection to be folded down closely. The folding is done in the usual way by dies, a suitable length of the stem end of blank being concaved to form one half the cylinder and the part *d* folded over to form the other half, the whole making a complete barrel, *e*. To make a spindle-key the folding is done upon a pin, *f*, and the pin left in the barrel, so that its projecting end forms the spindle. For a barrel-key the folding is done without the pin. These operations can be carried out rapidly and inexpensively, and the key, made as described, is both light and strong.

We are aware that sheet-metal keys have been made of a single blank with a hollow cylindrical shank and a flat stem; also, that shoulders have been formed to limit the extent to which the key shall enter the lock; that the turn-over edge has been made to lie close to the side of the flat handle and the bit bent to bring it in the middle of the key; also, that the barrel of the finished key has been made to project beyond the bit; but

What we do claim as new is—

A sheet-metal key formed of a blank having the shank *b*, bit *c*, and portion *d*, provided with shoulders 1 3 and point 2, said portion *d* being adapted to form the barrel by folding under the shank and close up behind the bit, as shown and described.

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