J. FALLOWS.

Handles for Sheet-Metal Ware.

No. 145,286. Patented Dec. 9, 1873.

Fig. 3.

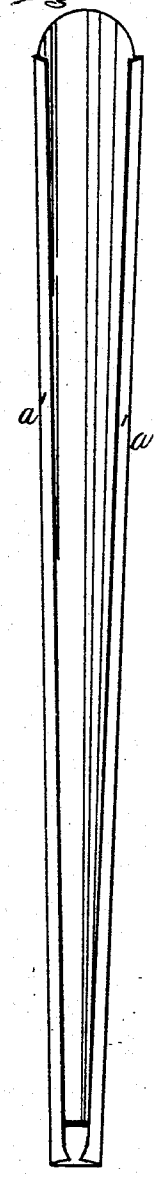


Fig. 1.

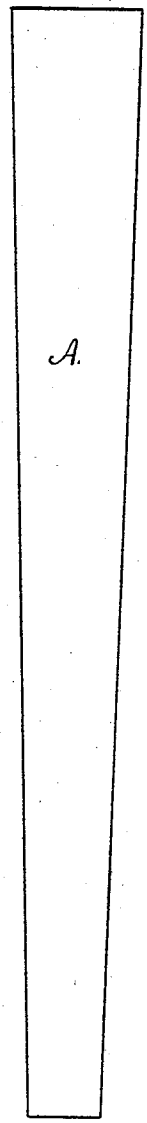


Fig. 2.

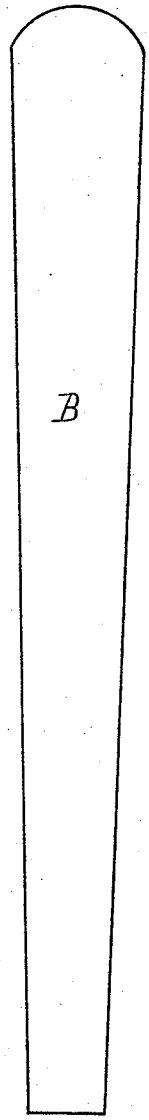


Fig. 4.

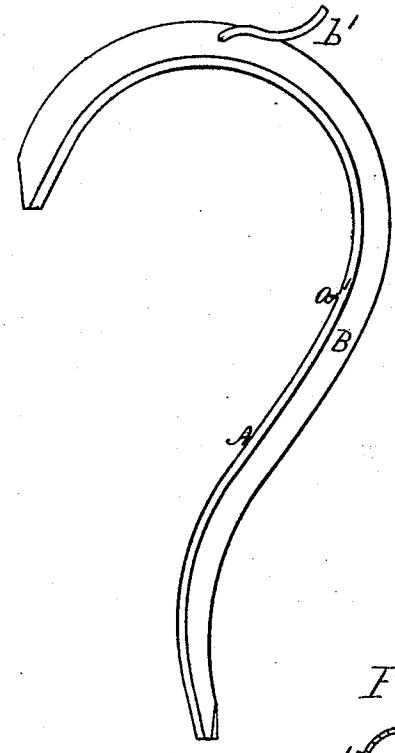
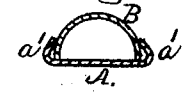


Fig. 5.



WITNESSES

Benj Morison

Wm H. Morison.

INVENTOR.

James Fallows

UNITED STATES PATENT OFFICE.

JAMES FALLOWS, OF PHILADELPHIA, PENNSYLVANIA, ASSIGNOR TO C. B. PORTER & CO., OF SAME PLACE.

IMPROVEMENT IN HANDLES FOR SHEET-METAL WARE.

Specification forming part of Letters Patent No. **145,286**, dated December 9, 1873; application filed August 11, 1873.

To all whom it may concern:

Be it known that I, JAMES FALLOWS, of the city of Philadelphia, in the State of Pennsylvania, have invented an Improved Sheet-Metal Handle for Tea and Coffee Pots, and similar vessels, of which the following is a specification:

The object of my invention is the production of a neat, appropriate, and reliable sheet-metal handle for tea and coffee pots, at much less cost of material and labor than heretofore required in the production of like appropriate sheet-metal handles for said vessels; and my invention consists of two blanks cut from the usual sheets of tin plate without waste, and then edged and arched respectively, slipped the one partly within the other, and bent into the desired form, as hereinafter set forth and described.

Figure 1 represents the blank for the inner side of the handle; Fig. 2, the blank for the outer side of the said handle. Fig. 3 represents the outer side of the handle before the two connected blanks are bent into the required curved form. Fig. 4 represents the handle completed ready for application to the vessel, and Fig. 5 a cross-section thereof.

The two blanks A and B are cut with straight side edges, and slightly tapering, from the plate of sheet metal, (tin plate being preferred,) alternately, so that the broader end of one blank shall be cut from the edge which is to afford the narrower end of the next blank, whether for either the inner or the outer side of the handle, as the blanks for each are exactly alike in length, width, and taper, as shown in Figs. 1 and 2, and consequently there need not be any waste of the sheet of metal from which the said blanks A and B are cut. The blank A has its two side edges bent over toward each other to an inclination of each of about forty-five degrees, more or less, (see Figs. 3 and 5.) The blank B is bent transversely along its whole length into nearly a semicircular form, (see Fig. 5,) and slipped between the two turned edges a' a', as represented in Fig. 3, thus producing a straight, nearly semicircular tube. In order to afford facility and to prevent any wrinkling of the edges while bending the said hollow straight tube, Fig. 3, into the finished form required, as represented by Fig. 4, I fill the hollow tube with melted tin, which unites the edges at both parts A and B, as represented by Fig. 3, when the filling has cooled. I then bend the whole into the finished form represented by Fig. 4, excepting a thumb-piece, b', which is finally attached by soldering a loop of wire, or a fold of tin plate, or their equivalents, to the upper part of the handle, substantially as shown in said Fig. 4; but before attaching the thumb-piece b' I immerse the solid bent handle into a bath of melted tin, which remelts the filling and allows it to be poured out, while the lapping edges remain firmly and neatly soldered together, thus completing the handle ready for application to the vessel in the usual manner.

The economy of time and labor and of the sheet metal employed in the production of said handles will be evident without any further explanation, and that the said handles can be made and sold as an improved article of manufacture put up in packages for the trade.

I claim as my invention—

The process of producing sheet-metal handles by fitting together two blanks of sheet metal, A and B, while in the straight form, as shown in Fig. 3, then filling with melted tin, and, after cooling, bending the same into the required form of handle, and, finally, immersing the said solid handle in a bath of melted tin to remelt the core, and thus permit of the same being run out, leaving the joints of the two plates A and B soldered together, substantially as described.

JAMES FALLOWS.

Witnesses:

BENJ. MORISON,

WM. H. MORISON.