July 2, 1929. H. I. CLULEE 1,719,169

METHOD OF FORMING SPOUTS OR HANDLES FOR COFFEEPOTS OR SIMILAR ARTICLES

Filed Jan. 12, 1928 2 Sheets-Sheet 1

FIG. 4.

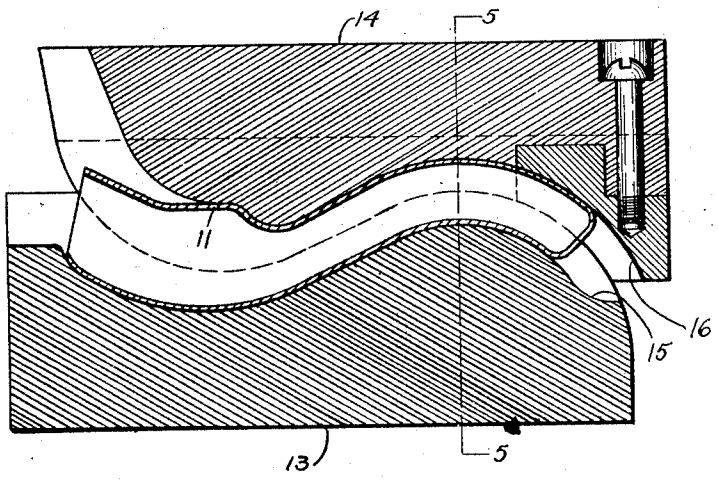


FIG. 5.

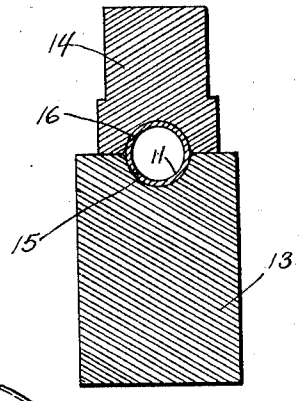


FIG. 6.

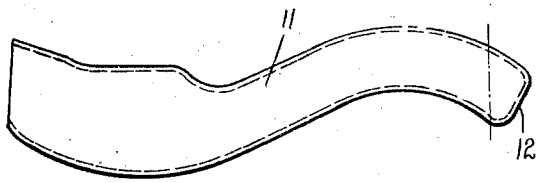


FIG. 2.

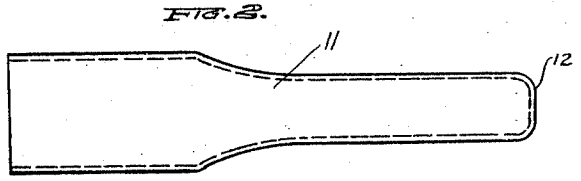
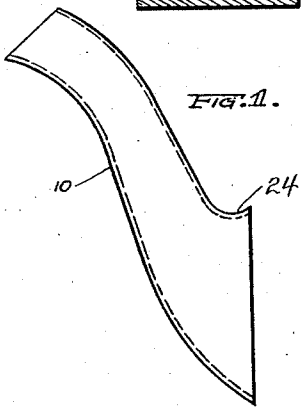


FIG. 1.



Inventor
Harry I. Clulee
by Seymour Earee Nichols
attys

July 2, 1929. H. I. CLULEE 1,719,169

METHOD OF FORMING SPOUTS OR HANDLES FOR COFFEEPOTS OR SIMILAR ARTICLES

Filed Jan. 12, 1928 2 Sheets-Sheet 2

FIG. 7.

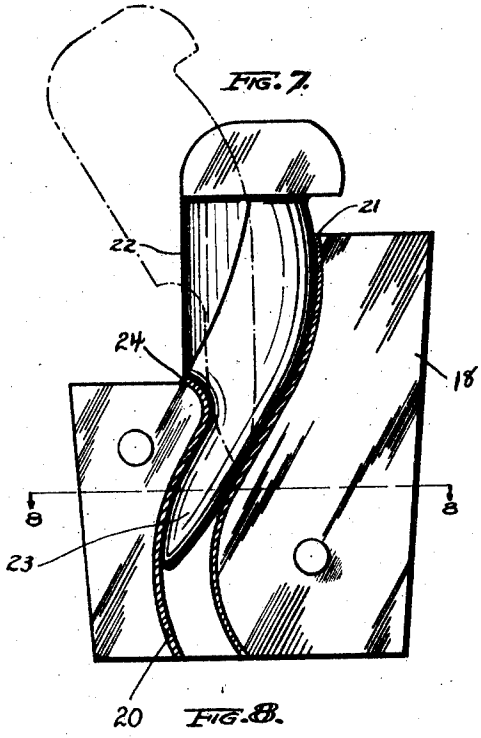


FIG. 8.

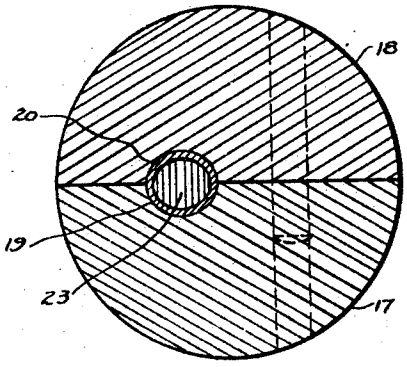
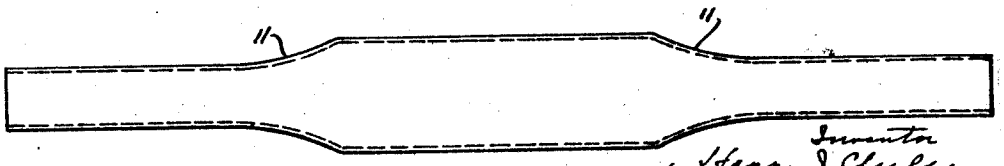


FIG. 3.



Inventor
Harry I. Clulee
by Seymour Earl Nichols
Attys

Patented July 2, 1929. 1,719,169

UNITED STATES PATENT OFFICE.

HARRY I. CLULEE, OF WALLINGFORD, CONNECTICUT, ASSIGNOR TO R. WALLACE & SONS MFG. CO., OF WALLINGFORD, CONNECTICUT, A CORPORATION.

METHOD OF FORMING SPOUTS OR HANDLES FOR COFFEEPOTS OR SIMILAR ARTICLES.

Application filed January 12, 1928. Serial No. 246,368.

This invention relates to improvement in method of forming spouts and handles for coffeepots and similar articles. In the more general construction of handles and spouts for coffeepots, they are formed from two complementary pieces which are secured together at their edges, but such handles and spouts will not stand the strain imposed upon them in the rough handling they receive in hotels and restaurants, and, furthermore, it is difficult to secure the parts together so as to form a perfect joint. The object of this invention is to swage the spouts or handles from a single piece of tubing and form that tubing by means of dies, as will be hereinafter described and particularly recited in the claim.

In the accompanying drawings:

Fig. 1 is a side view of a spout for a coffeepot or similar article constructed in accordance with my invention;

Fig. 2 is a side view of a blank from which the spout is formed from a piece of sheet-metal;

Fig. 3 is a side view of a blank formed from a piece of tubing;

Fig. 4 is a sectional view of blank-bending dies;

Fig. 5 is a sectional view on the line 5—5 of Fig. 4;

Fig. 6 is a side view of the bent blank;

Fig. 7 is an inside view of one of the finishing dies, showing a sectional view of the finished blank with the expanding-tool in its final position; and

Fig. 8 is a sectional view on the line 8—8 of Fig. 7.

In illustrating my invention, I have shown a spout, but it will be perfectly obvious that handles can be formed in the same manner. The spout 10 is formed from a tubular blank 11, which may be drawn from a metal blank, so as to have a closed end 12, or it may be formed from a piece of tubing, as shown in Fig. 3 of the drawings, which illustrates a blank adapted to be cut in two, so as to form two blanks. In either case, one end of the blank is larger in diameter than the other. A blank thus formed is placed between bending dies 13 and 14 having complementary longitudinally-curved grooves 15 and 16 between which the blank is placed, so that when the dies are forced together, as shown in Fig. 5 of the drawings, the blank will be given the desired curvature, as indicated in Fig. 6 of the drawings. The blank thus curved is then placed between finishing-dies 17 and 18 which have complementary curved groves 19 and 20 corresponding to the curved blank, while at the upper ends these grooves flare to form a mouth 21 corresponding to the socket-end of the spout or handle. A forming-tool 22 is then inserted into the blank at an angle represented in broken lines in Fig. 7, the nose 23 of the forming-die being curved, enters the blank, and as the forming-tool is forced downward and rocked to a vertical position, one end of the blank is expanded to form the socket-end 24, which is soldered to a coffepot or similar article in the usual way.

It will thus be seen that with this method and with these dies, a spout is readily formed from a single piece of metal, so as to avoid connecting the abutting edges of a two-part spout, thus not only improving the character of the spout itself, but greatly reducing the cost of manufacture.

While I have shown and described the construction of a spout, it is obvious, without further illustration, that handles can be produced in the same way, forming a socket at each end of the blank.

I claim:

A method of forming a spout or handle for coffeepots or similar articles, consisting in forming a tubular blank larger in diameter at one end than at the other end, inserting this blank between bending-dies by which it is curved longitudinally, then inserting the curved blank between finishing-dies, and then forcing a curved expanding tool by rocking movement into the larger end of the blank between the finishing-dies, whereby as the curved expanding tool is rocked, the larger end of the blank will be expanded.

In testimony whereof I have signed this specification.

HARRY I. CLULEE.