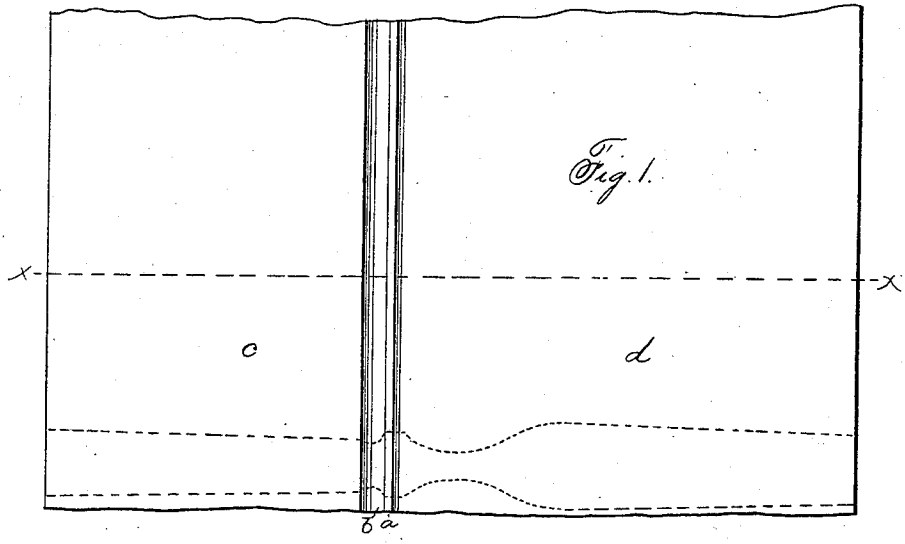
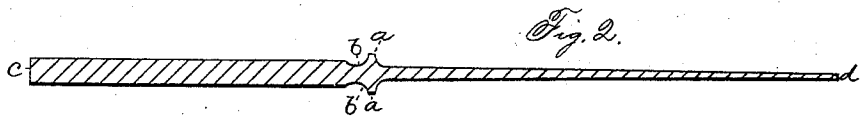
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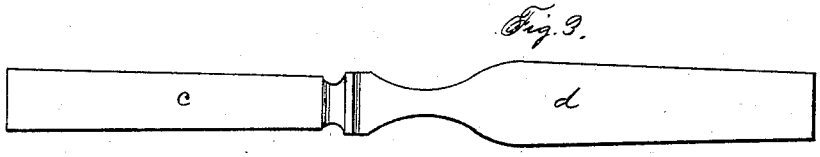
G. L. HART.

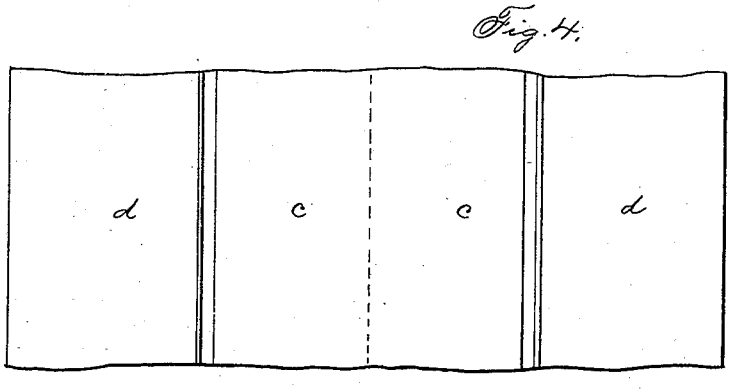
MANUFACTURE OF CUTLERY.

No. 265,959. Patented Oct. 17, 1882.









Witnesses
John Edwards Jr.
Settle Shepard.

Inventor.
George L. Hart.
By James Shepard.
atty

N. PETERS. Photo-Lithographer, Washington, D. C.

UNITED STATES PATENT OFFICE.

GEORGE L. HART, OF UNIONVILLE, CONNECTICUT, ASSIGNOR OF ONE-HALF TO H. C. HART, OF SAME PLACE.

MANUFACTURE OF CUTLERY.

SPECIFICATION forming part of Letters Patent No. 265,959, dated October 17, 1882.

Application filed December 6, 1881. (No model.)

To all whom it may concern:

Be it known that I, GEORGE L. HART, of Unionville, in the county of Hartford and State of Connecticut, have invented certain new and useful Improvements in the Manufacture of Table-Cutlery, of which the following is a specification.

My invention relates to the manufacture of table-cutlery from a bar specially designed for said manufacture by cutting the blanks from the bar and then finishing them in any proper manner; and the objects of my invention are to produce a merchantable bar from which to manufacture solid articles of table-cutlery and to produce said articles at a small cost.

In the accompanying drawings, Figure 1 is a side elevation of said bar; Fig. 2, a transverse section on line *x x* of Fig. 1; Fig. 3, a side elevation of a fork-blank as cut from said bar; and Fig. 4 is side view of a double bar.

I first make or obtain a bar, preferably of steel, of any desired length, in the form shown in Figs. 1 and 2, which bar can be readily made by rolling in the ordinary manner of making bar steel or iron. As seen by the sectional view Fig. 2, this bar is provided with a longitudinal rib, *a*, and groove *b* upon each side, the rib and groove on one side being formed directly opposite that on the other side. The part *d* of the bar which is shown at the right of the ribs and groove is a thin web or plate, thin enough for forming the blade of the fork or knife, while the part *c*, which is upon the opposite side of said ribs and grooves, is thicker, so that the handle may be formed therefrom. After said bar is obtained I cut it up into blanks, Fig. 3, by means of a cutting-die and punch, which cut the contour in side view of said blank, as indicated by the broken lines in Fig. 1. In the blank so cut it will be observed that the thin portion *d* of the bar forms the blade of the knife or fork, the thick portion *c* the handle, and the ribs and grooves *a b* the bolster between said blade and handle. It should also be noticed that the part *c* is made fully as thick as the thickness of the handle in the desired knife or fork, and not merely a thin web from which to cut a knife-shank or any other part to which a handle is to be secured. The blanks so punched out are then struck in dies by a drop or other suitable machine, to round the edges of the handles, form up the rim and groove of the bolster, and to smith the blade. If a fork-blank, it may then be subjected to cutting-dies to punch out and form the tines, after which the blade is bent into the desired curvature. The part *d* of the bar is of a width equal to the length of a fork-blade blank to be produced on the part *c* of a width equal to the length of the handle, while the groove and rib together between the parts *c d* occupy a space in the width of the bar which is equal to the length of the bolster in the finished article, whereby said bar is specially adapted for making what is known as "solid table-cutlery," with the handles, bolsters, and blades all formed in one piece of solid metal.

A bar from which to cut knife-blanks will differ from one for fork-blanks by having the thin portion made enough wider to allow for the difference in length between a fork-blade and a knife-blade. I have specified said bar as wide enough only for the length of one blank; but, if desired, the bar already described may be duplicated by making a double bar wide enough for two blanks and connected together as one bar, as shown in Fig. 4.

I am aware that an English patent of an earlier date than my invention shows a bar with longitudinal ribs on opposite sides, but with no bolster-grooves, and having a thin web upon one side of said ribs from which to cut out a knife-blade and another thin web upon the other side from which to cut out the shank to which a handle may be secured, and I hereby disclaim said bar.

I claim as my invention—

The bar, substantially as hereinbefore described, for cutting out blanks for solid table knives and forks, the same consisting of the thin part of a width equal to the length of the blade to be cut therefrom, a middle part having the ribs and grooves, the combined width of which is equal to the length of the bolster portion of the knife or fork to be produced therefrom, and the thicker part of a width and thickness equal to the length and thickness of the handle for said knife or fork.

GEORGE L. HART.

Witnesses:
CARLOS L. MASON,
HENRY A. COWLES.