To all whom it may concern:

Be it known that I, Richard H. Gardner, a citizen of the United States, residing at Chicago, in the county of Cook and State of Illinois, have invented certain new and useful Improvements in Builders' Hardware and Methods of Making Same, of which the following is a specification.

Hammered wrought iron has been generally considered as being artistic and especially adapted for use in making building hardware or the like to simulate antique designs. However, the manufacture of various devices from wrought iron is usually very expensive and furthermore such articles are more or less apt to rust when exposed to the weather.

The present invention relates more particularly to certain improvements in the manufacture of various devices used for building purposes or the like whereby such devices may be cheaply made but will have the desired antique appearance, and to such devices or articles which are made so that they are not apt to rust or deteriorate.

The objects of this invention are to provide certain improvements in the methods of manufacturing builders' hardware or the like; to provide a method of manufacturing devices of this character so that they will have an antique appearance or the appearance of hammered wrought iron; to provide improved builders' hardware which is not apt to rust or deteriorate and which will have certain desirable features which will be more particularly pointed out hereinafter.

In the accompanying drawing used for the purpose of illustrating this invention:

Figure 1 is a front view of a handle in the first stage of construction; and

Figures 2, 3 and 4 are similar views showing different stages in the process of manufacture.

This invention relates to all forms of devices such as hinges, door handles, door knobs, lock plates and various other devices, and the handle shown in the accompanying drawing is merely intended as illustrative of various articles which may be constructed. In order to prevent the devices from rusting or easily deteriorating, I prefer to make them of German silver or other suitable non-corrosive material. The article to be made as for instance the handle 5 is first cast with a more or less smooth surface as indicated in Figure 1 and then hammered so as to make depressions or indentations 6 as shown in Figure 2. Or in some instances the pattern may be hammered so that the casting will have a hammered effect as shown in Figure 2. The device is then painted or covered with black lacquer or paint as shown in Figure 3 so that the entire surface is covered. It is then rubbed over with emery cloth, sand paper or the like which removes the lacquer from the high spots but leaves the lacquer in the depressions 6 as shown in Figure 4. This treatment with the emery also gives the surface a more or less rough appearance which simulates the rough character of hammered wrought iron, the basic material being sufficiently white so that the blackened but scratched surface closely resembles that of the iron. The device may be completed by giving it a protecting coat of some suitable material such as transparent wax or the like, and it is then ready for use.

Hardware manufactured in this way has the appearance of hammered iron or antique iron and at the same time is more adapted for outdoor purposes as it will not rust or tarnish to any appreciable extent. It is apparent that my improved process may be used for making all sorts of devices and therefore I do not wish to limit myself to the exact device shown but desire to cover the process as adapted for the general manufacture of various articles of the character suggested.

Having thus described my invention, what I claim and desire to secure by Letters Patent is:

1. The method of manufacturing builders' hardware which consists in casting the article to be made from a non-corrosive material, then pounding it to make surface depressions, then painting the same with a black paint or lacquer, then rubbing the device with emery cloth or the like to remove the lacquer from the high surfaces and finally rubbing the device over with transparent wax.

2. The method of manufacturing builders' hardware which consists in casting the article from a non-corrosive alloy which is substantially white in appearance or similar in color to German silver, and then hammering or tooling it to make surface depressions to simulate hand hammered wrought iron then darkening or blackening the article and finally removing such darkening or blacken-
ing from the high surfaces and leaving the darkening or blackening in the depressions.

3. The process of making and finishing articles of the character set forth, which consists of making a casting of non-corrosive material of substantially white color, then hammering or tooling the same, then darkening or blackening the article, then removing the darkening or blackening from the high surfaces with a suitable abrasive, and leaving the darkening or blackening in the depressions and finally covering the article with a transparent covering such as wax, lacquer or the like, to simulate antique hand hammered wrought iron hardware.

4. Builders' hardware comprising cast articles formed of German silver having depressions in the surface resembling hammer marks, said depressions being filled with paint or the like and the main surface scratch finished, substantially as described.

5. The method of making builders' hardware which consists in casting the article to be made from a non-corrosive material of substantially white color, then making depressions in the surfaces of the article, then coating the same with a coating of black material and allowing such coating to dry, then rubbing the article with an abrasive to remove the black material from the high surfaces and finally covering the article with a transparent coating.

RICHARD H. GARDNER.