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PATENTED MAR. 29, 1904.

W. A. WARNER.

METHOD OF INLAYING BLANKS FOR FLAT METAL TABLEWARE.

APPLICATION FILED JAN. 18, 1904.

NO MODEL.

Fig. 1.

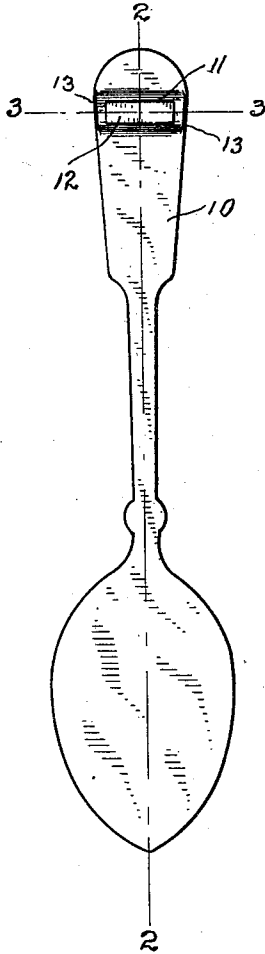
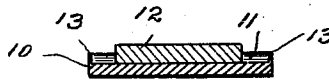


Fig. 2.



Fig. 3.



WITNESSES.

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UNITED STATES PATENT OFFICE.

WILLIAM A. WARNER, OF BRIDGEPORT, CONNECTICUT, ASSIGNOR TO THE HOLMES AND EDWARDS SILVER COMPANY, OF BRIDGEPORT, CONNECTICUT, A CORPORATION OF CONNECTICUT.

METHOD OF INLAYING BLANKS FOR FLAT-METAL TABLEWARE.

SPECIFICATION forming part of Letters Patent No. 755,727, dated March 29, 1904.

Application filed January 18, 1904. Serial No. 189,394. (No model.)

To all whom it may concern:

Be it known that I, WILLIAM A. WARNER, a citizen of the United States, residing at Bridgeport, county of Fairfield, State of Connecticut, have invented a new and useful Method of Inlaying Blanks for Flat-Metal Tableware, of which the following is a specification.

My invention relates to the manufacture of flat-metal tableware—for example, spoons, forks, and similar articles—having one or more precious-metal or alloy fillings at the point or points of wear and contact of the spoon or other article in use; and my invention has for its object to produce a method of manufacturing inlaid flat-metal tableware which shall produce the desired result in the simplest, cheapest, and most expeditious manner possible and with the least possible waste of the precious metal used for the inlaying, thus effecting a saving not only in the cost of material used, but greatly reducing the cost of manufacture by simplifying the method or process of combining the precious-metal inlay with the base metal of the blank and by reducing the number of operations required to produce the blank, the present method being an improvement on the method disclosed in my expired patent, No. 337,099, dated March 2, 1886.

With these and other objects in view my invention consists in certain improvements in the method of making blanks for flat tableware, which I will now describe, referring to the accompanying drawings, forming a part of this specification, and using reference characters to indicate the several parts.

Figure 1 is an elevation of the back of a blank, in the present instance a spoon-blank, showing the recess in the back of the handle with the piece of precious metal or alloy which forms the inlay lying therein and also showing the end walls or gates which retain the precious metal in the recess after it has been fused; Fig. 2, a longitudinal section on the

line 2 2 in Fig. 1; and Fig. 3 is a transverse section, on an enlarged scale, on the line 3 3 in Fig. 1.

10 denotes the handle of a blank, which is the only portion of the blank affected by the present invention; 11, the recess to receive the piece of precious metal or alloy to form the inlay; 12, the piece of precious metal which forms the inlay, and 13 walls or gates at the ends of the recess by which the precious metal is retained in the recess and prevented from running out after it has been fused. The special mode of forming the recess and the walls or gates is not of the essence of the invention. The recess and walls or gates may be formed in any ordinary or preferred manner, as by the use of a mill slightly narrower than the blank and which is caused to act centrally on the blank, grinding out the recess and leaving end walls or gates just as light and thin as possible, but amply sufficient to retain the molten metal in the recess.

Having formed the recess in the blank and provided the walls or gates at the ends of the recess, a suitable flux is placed therein and a piece of precious metal or alloy sufficient to form the inlay. The blank, with the piece of metal lying in the recess, is then subjected to the action of heat and the precious metal is fused and caused to unite with the base metal of the blank. The blank is then subjected to the action of dies which impart form to the article and also break away the end walls or gates of the recess, so that the thin strips of base metal comprising these walls are detached from the blank and form no part of the finished article. Having completed the inlaying of the blanks, the operations of plating and finishing may be completed in the ordinary or in any preferred manner.

Having thus described my invention, I claim—

The herein-described method of inlaying blanks for flat-metal tableware which consists

in forming a recess in the blank to receive the
precious metal leaving slight retaining-walls
at the ends of the recess, then fusing a piece
of precious metal in the recess and then sub-
5 jecting the blank to the action of dies, where-
by form is imparted to the blank and the re-
taining-walls are broken away.

In testimony whereof I affix my signature in
presence of two witnesses.

WILLIAM A. WARNER.

Witnesses:

T. B. LASHAR,
H. S. BIGLEY.