M. FOWLER.

Process of Making Sheet-Metal Spoons.

No. 202,431. Patented April 16, 1878.

Fig. 1

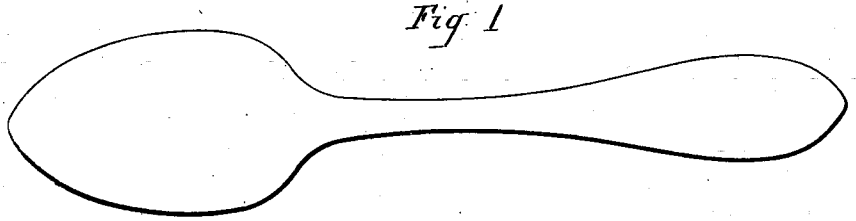


Fig. 2.

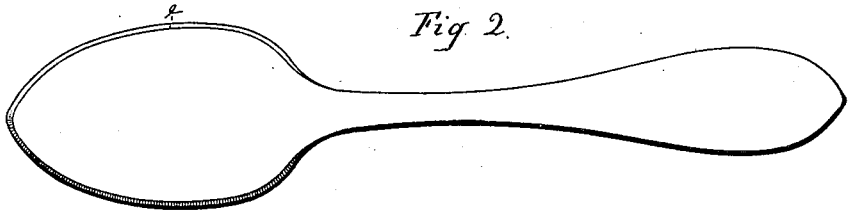
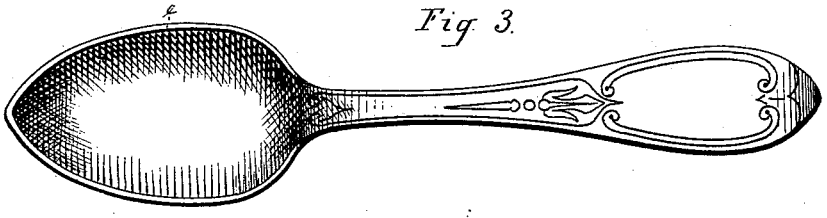


Fig. 3.



Witnesses.

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UNITED STATES PATENT OFFICE.

MALTBY FOWLER, OF NORTHFORD, CONNECTICUT.

IMPROVEMENT IN PROCESSES OF MAKING SHEET-METAL SPOONS.

Specification forming part of Letters Patent No. **202,431**, dated April 16, 1878; application filed January 28, 1878.

To all whom it may concern:

Be it known that I, MALTBY FOWLER, of Northford, in the county of New Haven and State of Connecticut, have invented a new and useful Improvement in the Art of Manufacturing Tinned-Iron Spoons; and I hereby declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it pertains to make and use it, reference being had to the accompanying drawing, which forms a part of this specification.

My invention relates to the manufacture of tinned-iron spoons having faced bowls and edged handles. Its object is to make such spoons with a planished even coating of tin over their entire surfaces; and the invention consists in punching the blanks from sheet iron or steel, in facing and edging the blanks from which the spoons are made before the blanks are tinned and before the operations of stamping the handles, raising the bowls, and forming the spoons, are performed.

Figure 1 is a view of a blank as punched from sheet-iron. Fig. 2 is a view of a blank the portion of which forming the bowl is beveled, and the portion forming the handle is smoothed and finished. Fig. 3 is a view of a finished spoon.

The blanks are punched from sheet iron or steel in the usual way, in the form shown in Fig. 1, and are faced—that is, the portions of the blanks forming the bowls have their edges beveled at such an angle (shown in Fig. 2) that when the bowls are raised the beveled edges *e* in the blanks become the facings *e* of the bowls. The portions of the blanks forming the handles have their edges smoothed and formed into proper shape, the operation being called edging. The blanks are then tinned by the usual process. The next steps are to stamp the handles, raise the bowls, and form the spoons. These operations may be performed singly by several dies, or at one operation by a single die or pair of dies, the dies planishing the tinned surfaces.

As generally practiced heretofore, the blanks have been tinned and the bowls have been raised before they were faced and before the handles were edged. The facing and edging took off the tin and showed the iron.

By my improved process I am able to make a cheap iron spoon having a faced bowl, edged handle, and a planished even coating of tin, ready for use or silver-plating.

When graded spoons are made by my improved process the blanks are punched in the form shown in Fig. 1, the bowl portion and the wide part of the handle are rolled to the required thickness, and the graded blank is trimmed by dies to the form shown in Fig. 1, when the graded blank is subjected to the processes in the order hereinbefore described for punched sheet-metal blanks.

Having stated my invention and described my process for making an improved tinned-iron spoon, what I claim as new and desire to secure by Letters Patent, is—

1. The herein-described improvement in the art of manufacturing tinned-iron spoons having faced bowls and edged handles, consisting, substantially, in punching blanks from sheet-metal, in facing, edging, and tinning the blanks, in stamping the handles, raising the bowls, and forming the spoons by dies, all the aforesaid several operations in the order and manner substantially as set forth.

2. A sheet-metal blank for spoons, having the edge of the part forming the bowl, when raised, beveled at such an angle as to make the facing of the bowl, as set forth.

MALTBY FOWLER.

Witnesses:
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