G. ABEL & J. PEDDER.

Blanks for Cutlery.

No. 205,329. Patented June 25, 1878.

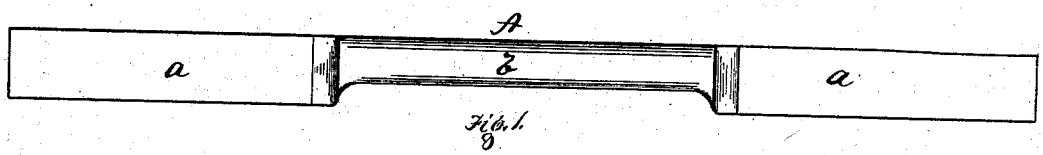

Fig. 1.

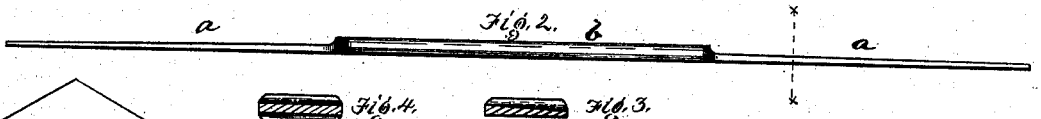

Fig. 2.

Fig. 4.

Fig. 3.

Fig. 5.

Fig. 7.

Fig. 6.

Witnesses.

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UNITED STATES PATENT OFFICE.

GEORGE ABEL AND JOHN PEDDER, OF BEAVER FALLS, PENNSYLVANIA.

IMPROVEMENT IN BLANKS FOR CUTLERY.

Specification forming part of Letters Patent No. **205,329**, dated June 25, 1878; application filed June 7, 1877.

To all whom it may concern:

Be it known that we, GEORGE ABEL and JOHN PEDDER, both of Beaver Falls, in the county of Beaver and State of Pennsylvania, have invented a new and useful Improved Skelp or Bar for Solid-Handled Blanks; and we do hereby declare the following to be a full, clear, and exact description thereof, reference being had to the accompanying drawing, forming a part of this specification, in which—

Figures 1, 2, and 3 are face, edge, and sectional views of a bar embodying our invention. Figs. 4, 5, 6, and 7 are illustrations of modifications embodying the essential features of our invention.

Like letters refer to like parts wherever they occur.

Our invention relates to skelp or bars for the manufacture of solid-handle knife and other blanks; and consists in a bar or skelp, one or both faces of which is composed of a series of longitudinal inclines or tapers, joined by portions of even gage longitudinally, and which exceed in thickness the tapered portions, the series arranged alternately and connected end to end, so that, when the bar is properly divided, blanks will be produced having the metal distributed in such relations and proportions as it occupies in a finished article of the class specified.

Heretofore, in the manufacture of solid-handled knives, forks, and similar articles, several methods have been adopted—first, the forging of single blanks under the hammer, which requires skilled labor to obtain uniform results, and involves the loss of time and material; second, blanks have been formed under the drop, but the latter is too slow to meet the requirements of the trade, demands an excess of metal in the bar to fill the dies and obtain good results, and is also attended with much loss of stock and time; and, thirdly, and most commonly practiced, is the method of cutting the knife-blade, fork-tine, or like articles from a blank and casting the solid handle thereon. This latter method involves increased manipulation, and does not give as good results as where the article and its handle are formed in one.

The object, therefore, of the present invention is to obtain a bar or skelp of a form which can be rapidly and readily produced, and from which blanks can be cut with little or no loss of material, and finished into the desired article with limited subsequent manipulation.

We will now proceed to describe our invention, in order that others skilled in the art to which it appertains may apply the same.

A represents a bar composed of a series of longitudinal inclines, *a*, the length and width of which will vary according to the article to be produced, whether a knife, fork, or other blank, said inclines or tapers alternating with portions *b*, of even gage, or nearly so, longitudinally, the thickness of portions *b* being determined by the amount of metal required in the handle of the article, and its form in cross-section by the manner in which it is desired to work up the blank cut from said bar. These inclines and even gage-sections are arranged alternating and end to end, preferably with the tapers or inclines joined at the points of equal area in cross-section. The longitudinal inclines *a* are also beveled transversely, so that the weight of metal will be toward one edge of the bar or at the back of a knife-blade, as clearly shown in cross-section, Fig. 3.

In Fig. 1, which is the preferred form of, or typical, bar, two of the inclines are joined end to end, and the portions *b* are of even gage, of less width than the inclines, and sufficiently long for two handles, so that when severed into blanks little subsequent work is necessary to finish the article.

In the modification shown in Fig. 4 the transverse bevel of the inclines *a* is omitted, and the blank will, therefore, require to be drawn transversely to an edge in order to finish a knife-blade therefrom after the blank has been severed from the bar.

The modification shown in Fig. 5 simply consists in giving the same width to the portions *a* and *b* throughout and beveling the portion *b* transversely, which is advantageous in some respects, for the reason that a bar or skelp of less thickness can be employed to form our improved bar, and at the same time the weight of metal required in the handle is obtained. To obtain a blank the bar is severed in like manner to that shown in Fig. 1; but in finishing the article the portion of *b* inclosed by

dotted line is swaged up to give a handle of the desired thickness.

Fig. 6 is but a duplication of Fig. 5, and is worked in a similar manner, excepting that it is slit longitudinally as well as severed transversely.

The bar above described, or either of its modifications, is of such form as can be readily produced in properly-grooved rolls, and may be rolled in lengths of twelve or fifteen feet, or any multiple of the length of blank desired, after which the bar can be cut up and the article finished in the usual way, with little or no loss of material, and with much less than the usual amount of labor.

Having thus described our invention, what we claim, and desire to secure by Letters Patent, is—

1. A bar or skelp, substantially as herein described, having one or both faces made up of a series of longitudinal inclines or tapers, alternating with a series of portions of even gage longitudinally, the latter of sufficient length to form one or more solid handles, and serving to connect the longitudinal inclines or blade portions of the bar, the whole joined end to end, substantially as and for the purpose specified.

2. A bar or skelp having one or both faces made up of longitudinal inclines or tapers, alternating with portions of the bar of even gage longitudinally, the longitudinal inclines being also beveled transversely, and the even-gage portions which connect the inclines being of sufficient length to form one or more solid handles, substantially as and for the purpose specified.

In testimony whereof we, the said GEORGE ABEL and JOHN PEDDER, both of Beaver Falls, Beaver county, and State of Pennsylvania, have hereunto set our hands.

GEORGE ABEL.
JOHN PEDDER.

Witnesses:
JAS. W. MAY,
HENRY WAGNER.