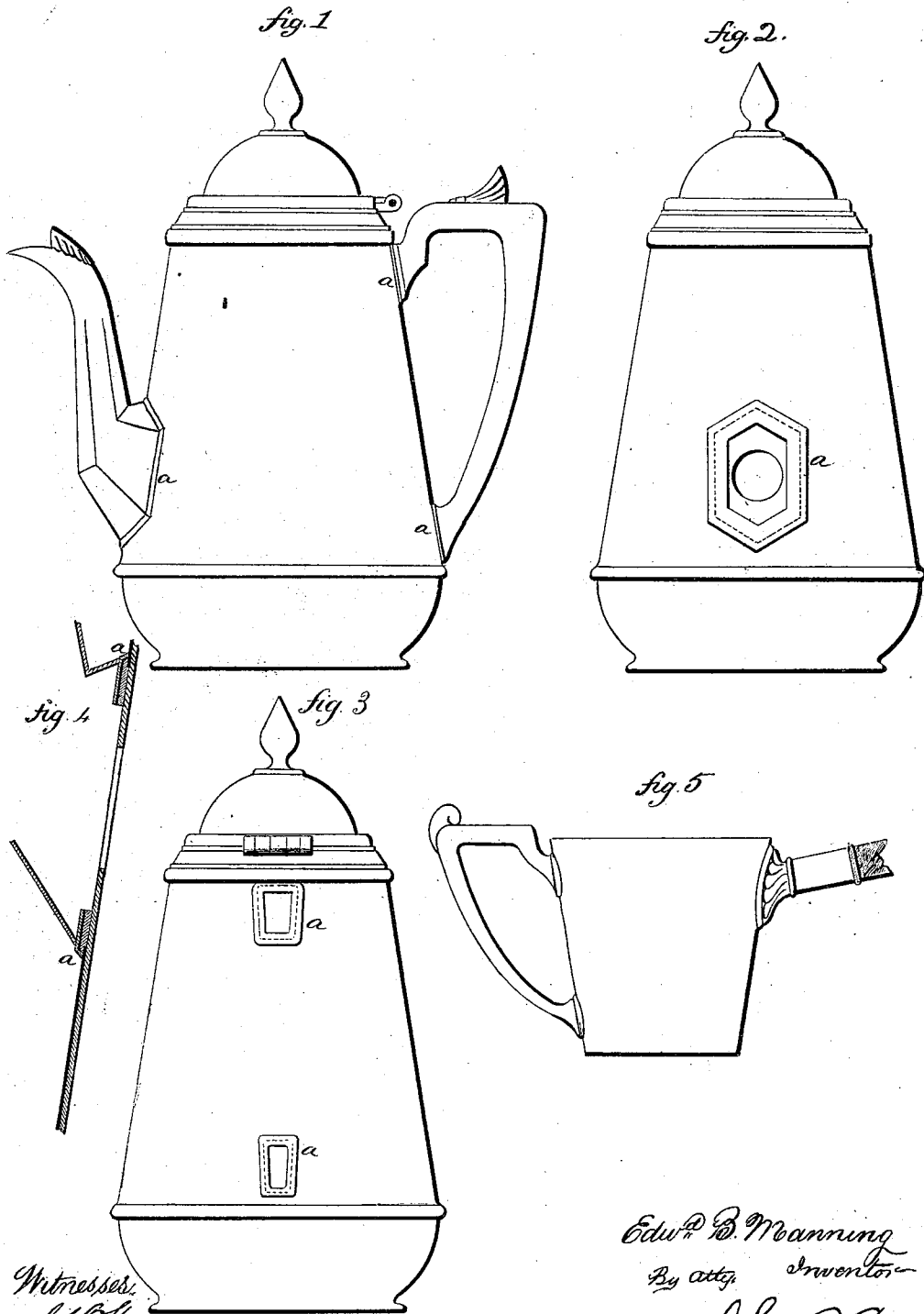


E. B. MANNING.

METHOD OF ATTACHING HANDLES TO GLAZED METAL GOODS.

No. 187,025.

Patented Feb. 6, 1877.



Witnesses:  
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# UNITED STATES PATENT OFFICE.

EDWARD B. MANNING, OF NEW HAVEN, CONNECTICUT.

## IMPROVEMENT IN METHODS OF ATTACHING HANDLES TO GLAZED METAL GOODS.

Specification forming part of Letters Patent No. 187,025, dated February 6, 1877; application filed October 9, 1876.

### *To all whom it may concern:*

Be it known that I, EDWARD B. MANNING, of New Haven, in the county of New Haven and State of Connecticut, have invented a new Method of Attaching Handles to Glazed Metal Goods; and I do hereby declare the following, when taken in connection with the accompanying drawings and the letters of reference marked thereon, to be a full, clear, and exact description of the same, and which said drawings constitute part of this specification, and represent, in—

Figure 1, a side view of a tea-pot complete; Figs. 2, 3, and 4, views illustrating the invention; and in Fig. 5, the invention as applied to other articles.

This invention relates to an improvement in the method of attaching handles to that class of tea and coffee pots and similar articles which are constructed from hard metal, and coated with porcelain or similar vitreous material.

It is impossible to connect the handles, spouts, &c., to such vessels by solder directly upon the surface, as can be done when the metal surface is exposed; hence the usual method of attaching such parts has been by means of a skeleton frame, as in the patent granted to me June 20, 1876, No. 178,938.

The object of this invention is to make a direct attachment to the vessel; and it consists in attaching these parts by means of a collar surrounding the connection, as more fully hereinafter described.

The pot or article to which it is desired to attach a handle or spout is first coated and finished upon the surface, preferably leaving an uncoated spot where the attachment is to be made, say as indicated in broken lines in Fig. 2, where the spout is to be attached, and in Fig. 3, where the two ends of the handle are to be attached, and also seen in Fig. 4, which represents an enlarged vertical section through the spout, solid black indicating the glaze or coating upon the outside; but, instead of leaving the spot uncoated, the whole surface may be coated, and then this band or spot ground until the metal is exposed.

A collar, *a*, of larger area than the uncoated spot, is laid upon that spot, and soldered from the inside—that is to say, the solder is allowed to flow between the under surface of the collar and the uncoated surface of the article. This collar is also of larger area than the bearing-surface of the article to be attached.

The collar or collars having been thus attached, the spout, or handle, as the case may be, is then placed upon the outer surface of the collar and soldered thereto from the outside, which is easily and readily done, being substantially such an operation as attaching the same part to a metal surface.

While it is preferable to first attach the collar, and then the parts to the collar, as described, it may be done by first attaching the handle or spout directly to the uncoated spot, and then passing the collar on over the handle or spout, and soldering it to such handle or spout, the collar being made to fit the handle or spout at the point of attachment. The appearance, when finished, will be the same in either case; but the first is the simplest and most desirable. The collar, in either case, serves to lap over onto the glazed surface and hide the joint or connection.

Fig. 5 represents a cup with a finger-handle attached to one side as a cup, and a shank-handle as a dipper upon the opposite side, attached in the same manner. It will, therefore, be understood that the invention is not confined to particular articles, but to such as are constructed from a glazed metallic body.

I claim—

The method herein described of attaching handles, spouts, &c., to glazed or similarly coated metal tea-pots and other articles, consisting in forming an uncoated margin or spot where the part is to be attached, and soldering the part thereto, and a collar placed around such point of attachment to overlap the glazed portion, substantially as specified.

EDWARD B. MANNING.

Witnesses:

J. H. SHUMWAY,  
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