Aug. 18, 1970 R. J. WERTEPNY, SR 3,524,363

METHOD OF PRODUCING BLADE TYPE CUTTING TOOL

Original Filed Oct. 19, 1966 2 Sheets-Sheet 1

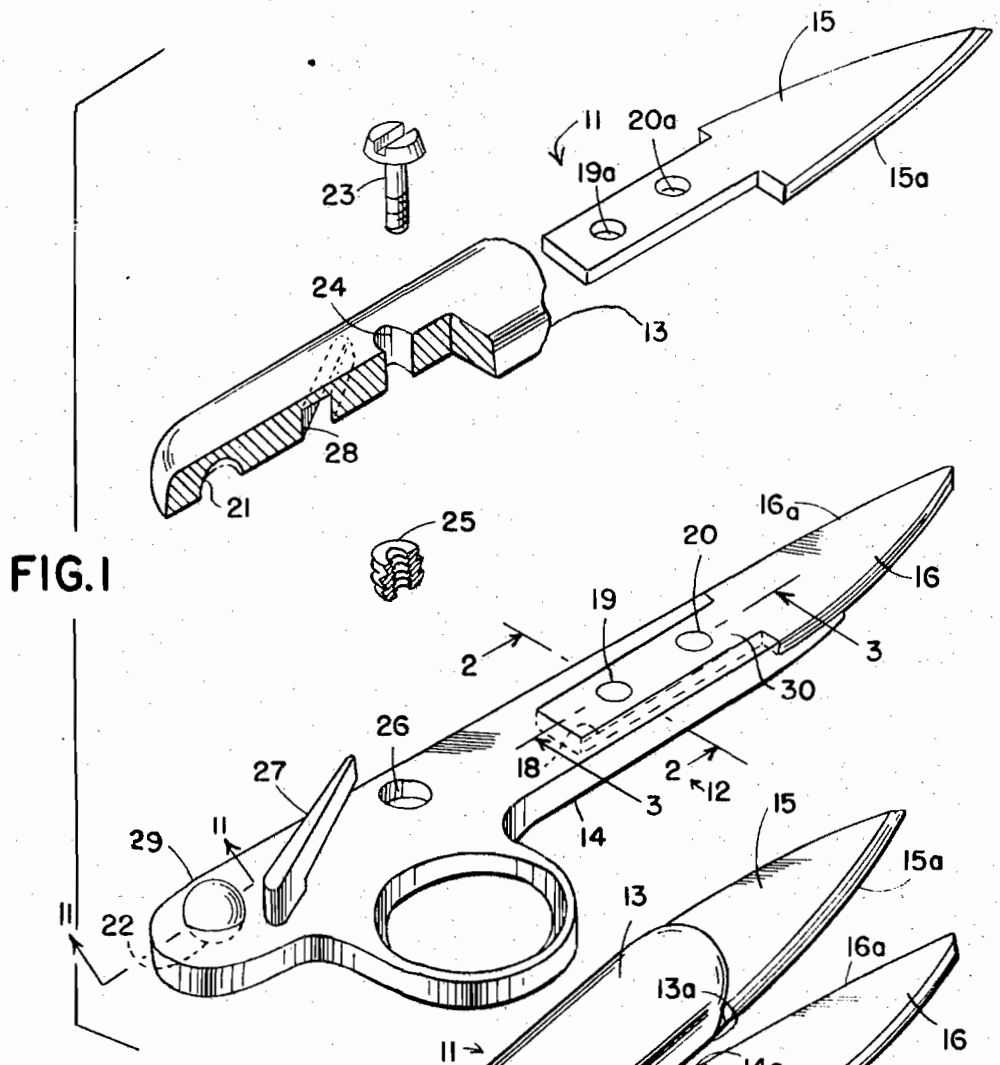


FIG.1

FIG.4

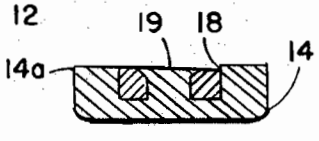


FIG.2

FIG.3

INVENTOR.
Rudolph J. Wertepny, Sr.

BY
Sparrow and Sparrow
ATTORNEYS

Aug. 18, 1970 R. J. WERTEPNY, SR 3,524,363

METHOD OF PRODUCING BLADE TYPE CUTTING TOOL

Original Filed Oct. 19, 1966 2 Sheets-Sheet 2

FIG. 5

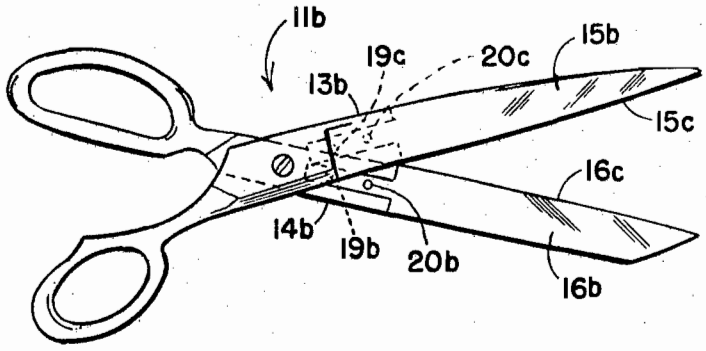


FIG. 6

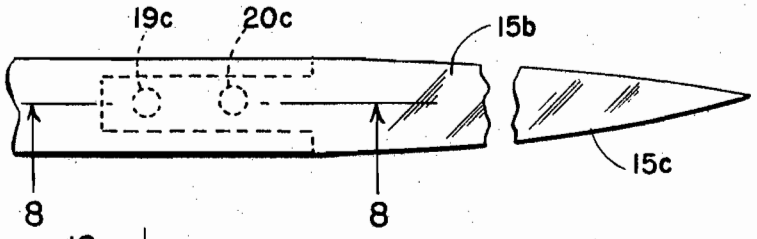


FIG. 7

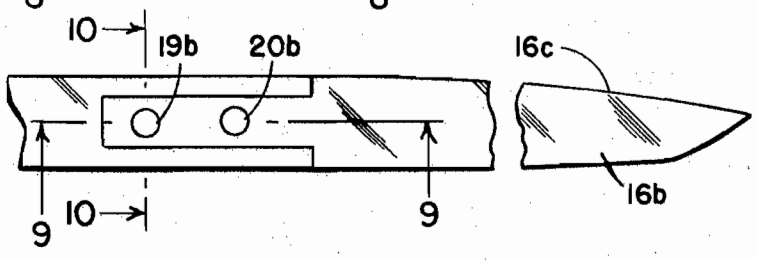


FIG. 8

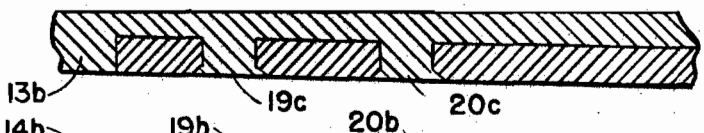


FIG. 9

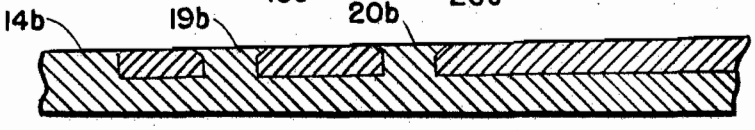
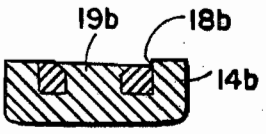


FIG. 10



INVENTOR.

Rudolph J. Wertepny, Sr.

BY

Sparrow and Sparrow

ATTORNEYS

United States Patent Office 3,524,363 Patented Aug. 18, 1970

3,524,363

METHOD OF PRODUCING BLADE TYPE CUTTING TOOL

Rudolph J. Wertepny, Sr., West Orange, N.J., assignor to J. Wiss and Sons Co., Essex County, N.J., a corporation of New Jersey

Original application Oct. 19, 1966, Ser. No. 587,916, now Patent No. 3,453,651, dated July 1, 1969. Divided and this application Jan. 28, 1969, Ser. No. 810,068

Int. Cl. B21k *11/00*

U.S. Cl. 76—104 4 Claims

ABSTRACT OF THE DISCLOSURE

Method for producing a blade-type cutting tool with a body member into which straight, flat cutting blades are inserted. The recesses for the blades are made with a certain lateral and longitudinal inclination at a certain angle to give the blades a desired cross-over and clearance angularity for proper cutting.

This is a division of application Ser. No. 587,916, filed Oct. 19, 1966, now Pat. No. 3,453,651, issued July 1, 1969.

The invention relates generally to blade-type cutting implements and their method of manufacture, and more particularly has reference to thread cutters or clips, such as are being used in the garment industry, as well as scissors, shears, snips, individual blades and like cutting implements.

The invention consists in such novel features, construction arrangements, combinations of parts and improvements as may be shown and described in connection with the cutting tools herein disclosed by way of example only and as illustrative of preferred embodiments.

Objects and advantages of the invention will be set forth in part hereafter and in part will be obvious herefrom or may be learned by practicing the invention, the same being realized and attained by means of the instrumentalities and combinations pointed out in the appended claims.

Heretofore, blade-type cutting tools, such as blade-type cutters, scissors, shears, snips and the like implements have been made with a twist in the blades between the fulcrum or pivot and the forward ends of the blades, so that, viewed in a vertical plane a consistently increasing angle between the two blades exists, starting from the fulcrum or pivot to their forward ends. In addition, the blades are bowed from the fulcrum or pivot to the forward ends of the blades so that, viewed from the top of the implement, when the blades are fully opened and the cutting edges are engaged near the fulcrum, the forward ends of the blades appear to overlap each other by an appreciable amount because of a constantly increasing bend from the fulcrum to the forward ends or tips of the blades.

It is an object of the present invention to provide blade-type cutting implements in which the blades have neither a twist nor a bow, yet provide the proper angularity for both cross-over and clearance of the blades.

Furthermore, it is an object of the present invention to provide a blade-type cutting implement having flat cutting blades in association with corresponding novel body members or backings.

A still further object of the present invention is to provide the foregoing type of cutting implement in which the proper angularity for both cross-over and clearance is molded into a plastic or metal backer, the flat blade being snapped over protrusions provided in the blade material and spin-welded or heat-welded in place.

Another object of the present invention is to provide

a method for producing the aforementioned cutting implement including the steps for setting and maintaining the blades in their proper relationship.

A further object of the present invention is to provide blade-type cutting implements having flat, non-twisted metal cutting blades secured to a body made of plastic, metal or other suitable material.

Yet another object of the present invention is to provide new and improved blade-type cutting implements which can be manufactured economically while retaining the properties of a precision tool.

Various further and more specific objects, features and advantages will clearly appear from the detailed description given below taken in connection with the accompanying drawings which form part of this specification and illustrates merely by way of examples embodiments according to the invention. In the following description and in the claims, parts will be identified by specific names for convenience, but such names are intended to be as generic in their application to similar parts as the art will permit. Like reference characteristics denote like parts in the several figures of the drawings, in which:

FIG. 1 is an exploded view of a blade-type cutting implement according to the invention, the top portion being partially cut away;

FIG. 2 is a section through **2—2** of the lower blade seen in FIG. 1;

FIG. 3 is a section through **3—3** of the lower blade seen in FIG. 1;

FIG. 4 is a perspective view of the cutting implement of FIG. 1 assembled;

FIG. 5 is a view of another blade-type cutting implement, such as a pair of sheers or scissors according to the invention;

FIG. 6 is a detail fragmentary view of the upper blade assembly seen in FIG. 5;

FIG. 7 is a detail fragmentary view of the lower blade assembly seen in FIG. 5;

FIG. 8 is a detail section through **8—8** of FIG. 6;

FIG. 9 is a detail section through **9—9** of FIG. 7; and

FIG. 10 is a detail section through **10—10** of FIG. 7.

Referring now in more detail to the drawing illustrating an embodiment by which the invention may be realized, there is shown in FIG. 1 an exploded view of a blade-type cutting implement which, by way of example only, is in the form of a thread cutter or clip, such as that used in the garment industry, and which embodies the principle of the invention.

FIG. 4 is a perspective view of the cutting implement of FIG. 1, assembled, and which is designated generally by the numeral **10**. For purposes of clarity, blades **11** and **12** of implement **10** are shown opened wider with respect to each other than they would be in normal use. In normal use, they would open only to expose cutting edges **15***a* and **16***a*. Numeral **11** indicates the upper blade assembly or unit, and the numeral **12** indicates the lower blade assembly or unit depicted in the drawing.

Lower blade assembly or unit **12** comprises a body member **14**, which may be made of suitable metal or of plastic, and a cutting blade member **16** made of metal which has a reduced or narrower extension or shank portion **30**. The reference **16***a* represents the cutting edge. A recess or socket **18** is provided in body member **14** which is inclined or angular in both transverse and longitudinal sections (FIGS. 2 and 3). Longitudinal recess or socket **18** extends to the forward end of body member **14**, and in its narrower portion is provided with spaced studs or protuberances **19** and **20**. The shank portion **30** of blade member **16** has a pair of perforations within which fit studs **19** and **20**. Blade member **16** is permanently secured to body member **14** at said studs by spin-welding (in case body member **14** is made of metal) or by heat-

welding (in case body member **14** is made of plastic) or by any other suitable means. The perforations of blade member **16** have a slight countersink into which the spin- or heat-weld displacement of the backing material travels so as to retain the blade in position.

The construction of upper blade assembly generally indicated by the numeral **11** is similar to that with respect to lower blade assembly **12**, except that the transverse and longitudinal slopes are to opposite hand. The parts are made of similar material. In upper blade assembly **11** the corresponding parts seen are indicated as follows: body member **13**, cutting blade member **15** with cutting edge **15***a*, perforations **19***a*, **20***a* for the corresponding studs or protuberances similar to **19**, **20**. The blade portions having the cutting edges **15***a*, **16***a* protrude from the respective body members **13**, **14**.

Each of blade members **15** and **16** is made of straight, flat cutting steel or other suitable material and does not have any twist or bow, the longitudinal recesses or sockets (only 18 seen) being provided in such angular shape or inclination that the necessary cross-over and clearance of blade members **11** and **12** are provided for therein. The proper angular shape or inclination is achieved by choosing an angled tangent at the correct position on a sphere of a size to give the required amount of twist and bow.

Thus, with respect to the lower blade assembly, the recess **18**, located at the forward portion of body member **14**, slopes upwardly in lateral and longitudinal directions, that is, inclines transversely of the body member **14** towards the edge **14***a* of body member **14** and longitudinally towards the forward end thereof. Consequently, blade **16**, following the inclination of obliqueness of recess **18**, likewise slopes or slants upwardly laterally in the direction of the cutting edge **16***a* of blade member **16** and longitudinally in the direction of its tip. Similarly, but to opposite hand, and with respect to the upper blade assembly, the recess accommodating blade member **15** slopes or inclines downwardly in lateral or transverse and longitudinal directions, that is, towards the edge **13***a* of body member **13** and longitudinally towards the forward end thereof. Consequently, blade **15** likewise slopes or inclines downwardly laterally in the direction of its cutting edge **15***a* and longitudinally in the direction of its tip. Thus, the recesses or sockets are formed in such manner that they provide suitable rests or retainers for blade members **11** and **12** against transverse forces which are the largest forces present in this type of cutting tool. Obviously, both said recesses and blade members are provided with close tolerances in order to warrant proper operating relationship between the cutting edges of blade members **11** and **12**. Thus, the method according to the invention provides for setting and keeping the blade members in the proper operating relationship. The fulcrum and blade arrangement herein provided is such that the blade members have no twist and no bow; the proper angularity for both cross-over and clearance is provided in the plastic or metal body member, the flat blade member being snapped over the two studs or protuberances of the body member and spin-welded or heat-welded in place. The shank of the corresponding blade member which fits into the corresponding recess or socket molded or otherwise formed in the body member, may be punched or otherwise formed such as to provide close tolerances so that the blade member may assume the proper angle relationships with its mating counterpart.

It is understood that, in the event it is convenient or desirable to use recesses or sockets of uniform section (that is, not sloped), the desired transverse and/or lateral sloping or slanting of the blade members **15**, **16** may be accomplished by employing transversely sloping inserts between the blade members and the bottoms of the recesses, respectively, or providing the blade members per se with the desired sloping or slanting sections or portions.

FIGS. 1 through 4 show a device with a ball pivot, while FIG. 5 shows a device with a conventional screw pivot. It is understood that this invention performs equally well with these or any other type pivot.

The ball pivot device consists of a ball-shaped member **29** which is half-and-half inserted in cup-shaped cavities **21** (upper body member **13**) and **22** (lower body member **14**). In order to tighten blades **15** and **16**, a threaded insert **25** is anchored in a bore **26** in the lower body member **14** and a screw **23** is inserted through a bore **24** in the upper body member **13**. Screw **23** fits in insert **25** and can be tightened thereon at will. An elastic bar **27** is fastened in lower body member **14** and a corresponding recess **28** is provided in upper body member **13**. Elastic bar **27** fits in recess **28** and acts as a spring member for opening the cutting blades **15**, **16**.

FIGS. 5 to 10 inclusive depict a blade-type cutting implement, such as scissors or shears **11***b* embodying the principles of the invention with reference to the blade assemblies. The upper blade assembly or unit comprises body member **13***b* and cutting blade member **15***b* and lower blade assembly comprises body member **14***b* and cutting blade member **16***b*. The references **15***c*, **16***c* indicate the cutting edges of the respective blade members. The reference **19***c*, **20***c* indicate the studs or protuberances in the upper body member **13***b* and the references **19***b*, **20***b* indicate the studs or protuberances in the lower body member **14***b* which are received in corresponding perforations in the respective blade members **15***b*, **16***b*. The reference **18***b* corresponds to the reference **18** with respect to FIGS. 1 to 4.

While the invention has been described and illustrated with respect to certain preferred examples which give satisfactory results, it will be understood by those skilled in the art after understanding the principle of the invention that various changes and modifications may be made without departing from the spirit and scope of the invention, and it is intended therefore in the appended claims to cover all such changes and modifications.

I claim:

1. Method of producing a cutting tool which comprises forming in a pair of body members respective recesses, and securing in each of said recesses an untwisted and unbowed metal blade member having a cutting portion in such manner that each of said cutting portions is inclined along its length and width but to opposite hand with relation to each other, and pivotally connecting said body members in such manner that the cutting edges of said cutting portions face each other.

2. Method according to claim 1, and including forming the bottom zone of contact between said recesses and said blade members with inclinations to provide said inclinations of said cutting portions.

3. Method according to claim 1, and including the step of forming each of said recesses with a transverse and longitudinal inclined bottom to opposite hand with relation to each other.

4. Method of producing a cutting tool which comprises forming in a pair of body members transversely and longitudinally inclined recesses respectively to opposite hand, securing in said recesses untwisted and unbowed metal blades each of which has an extended cutting portion in such manner that said blades follow the inclinations of said recesses, and pivotally connecting said body members in such manner that the cutting edges of said cutting portions face each other.

References Cited

UNITED STATES PATENTS

784,069	3/1905	Polkowski.	
2,666,258	1/1954	Vogel	30—349

BERNARD STICKNEY, Primary Examiner