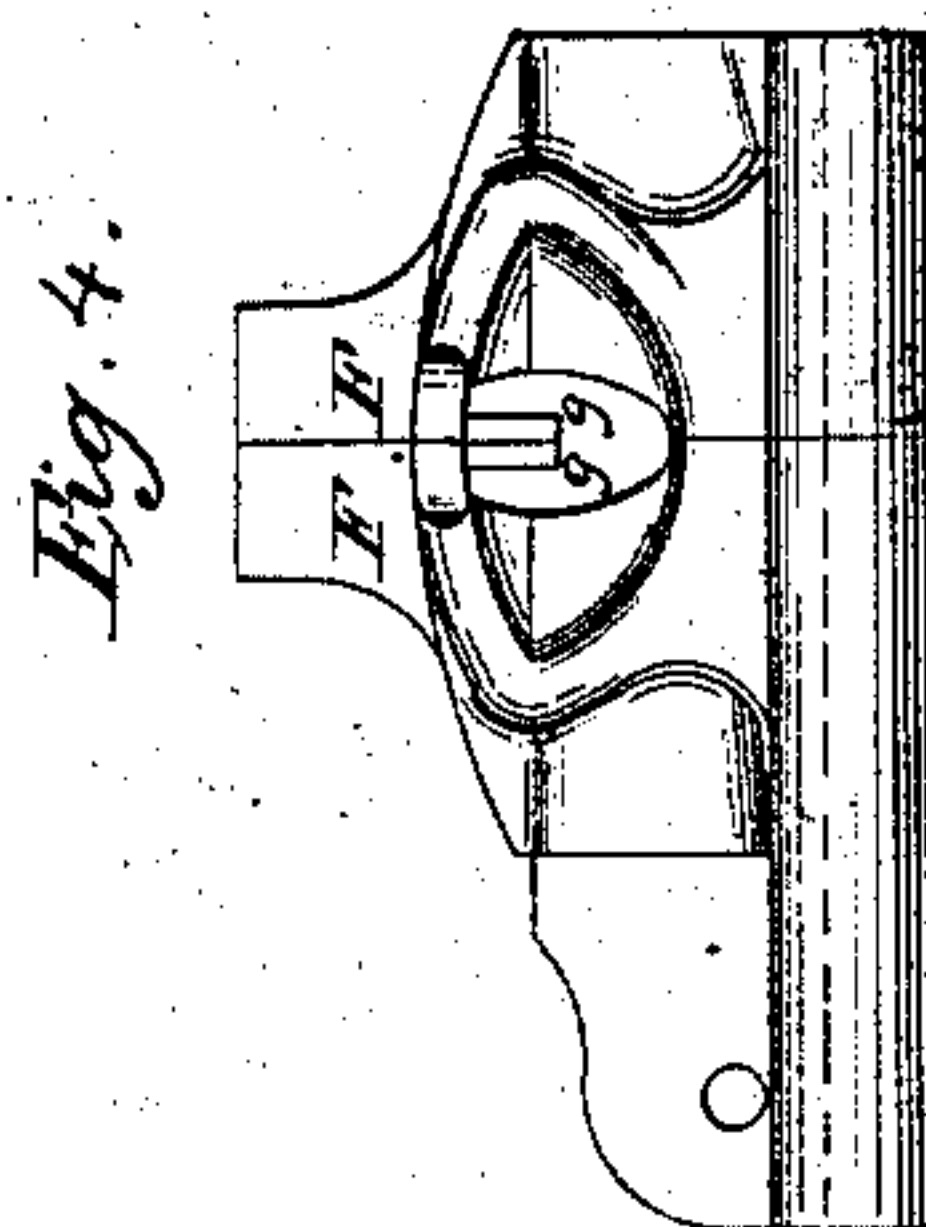
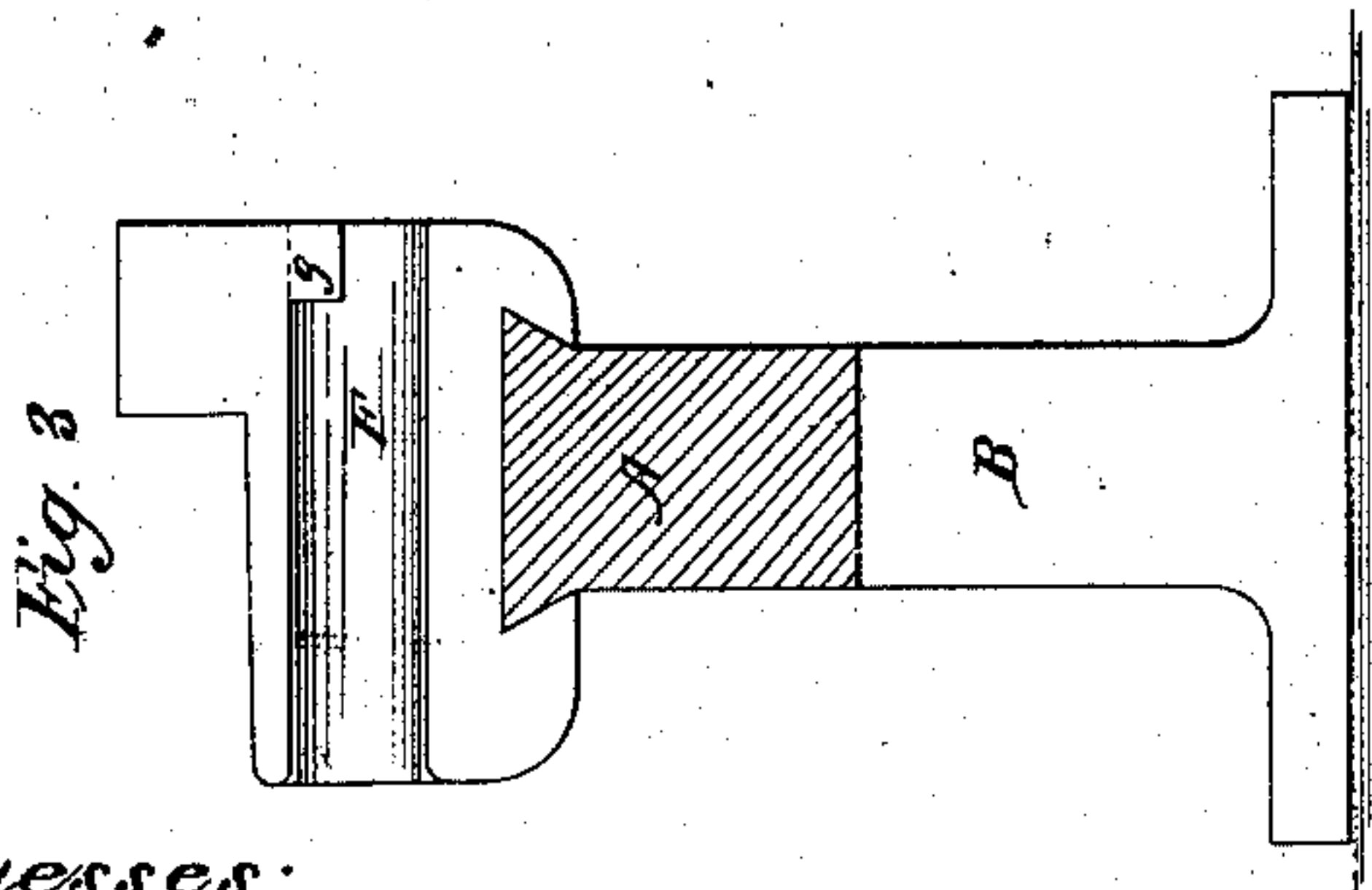
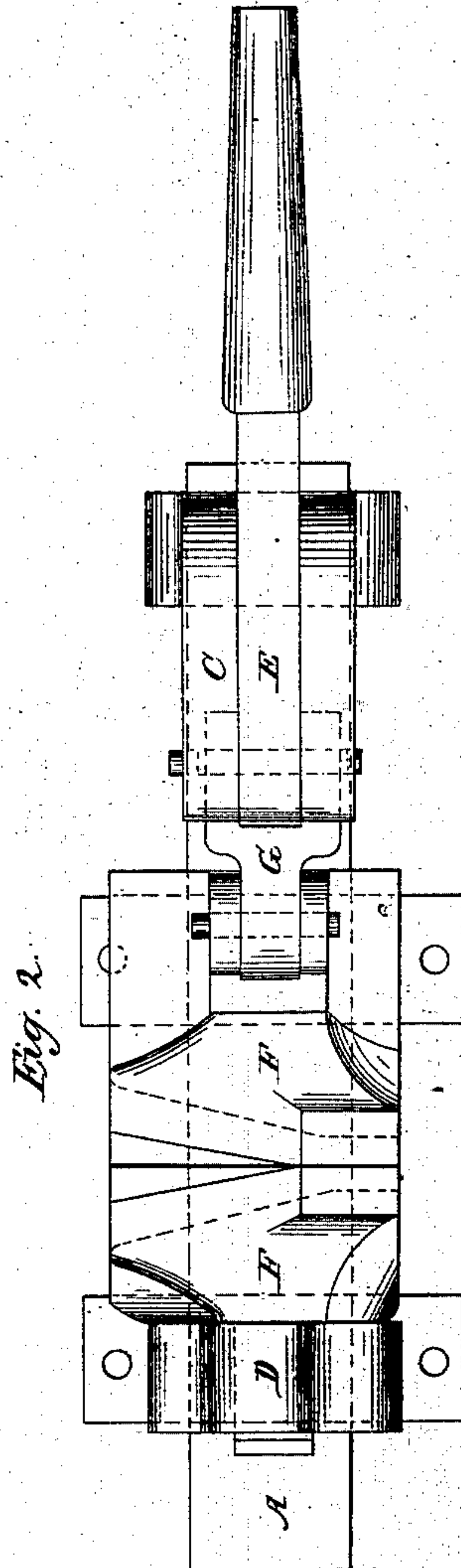
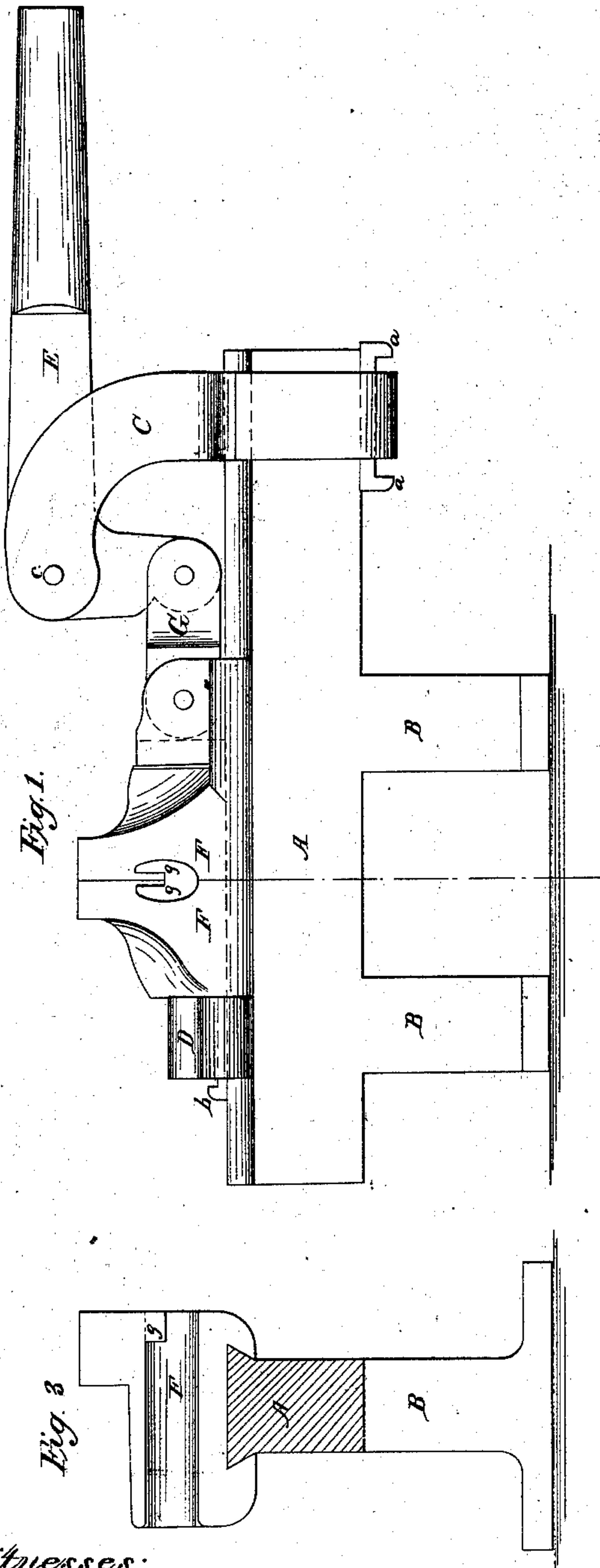


J. PEACE.
MACHINE FOR BENDING SKELP.

No. 62,063.

Patented Feb. 12, 1867.



Witnesses:
J. A. Jackson
Chas A. Peck Dr

Inventor:
John Peace
Per. Wm. H. Attorney

United States Patent Office.

JOHN PEACE, OF CAMDEN, NEW JERSEY.

Letters Patent No. 62,063, dated February 12, 1867.

IMPROVEMENT IN MACHINES FOR BENDING SKELP.

The Schedule referred to in these Letters Patent and making part of the same.

TO ALL WHOM IT MAY CONCERN:

Be it known that I, JOHN PEACE, of Camden, in the county of Camden, and State of New Jersey, have invented a new and improved Machine for Bending Skelp for Tubing; and I do hereby declare that the following is a full, clear, and exact description thereof, which will enable others skilled in the art to make and use the same, reference being had to the accompanying drawings, forming part of this specification, in which—

Figure 1 is a side elevation of the skelp-bending machine.

Figure 2 is a plan of the same.

Figure 3 is a vertical section taken in the line *x x*, between the clamping dies, fig. 1.

Figure 4 is a front view of the clamping dies.

Similar letters of reference indicate like parts.

This invention relates to the manufacture of metal pipes or flue-tubes, and consists in an arrangement of dies for clamping and bending the skelp or iron plate into shape, preparatory to welding the edges or laps so formed for making the tubes or flues. The advantage of the machine, over machines in use for the same purpose, is that the flat skelp or strip of iron can be drawn out of the heating furnace in a flat or horizontal position, thus avoiding the necessity, attending all other machines, of turning the metal plate edgewise, and thus giving a twist or wind in the two edges to be welded. The simplicity of the machine saves much expense in its construction, with a continued saving of labor in its operation.

A represents a slide-rest, with supports or legs B B, to fasten it to a draw-bench. Fitted upon the slide-rest A, is an adjustable bracket and lever fulcrum, C, which is keyed at *a a* to the under side of the rest. At the opposite end of the slide-rest A is an adjustable stop, D, also keyed to the rest at *b*. A bent lever, E, is pivoted to the bracket C, at *c*, and connected by the jointed arm G to one of a pair of clamp dies, F F, which are made to fit and move upon the slide-rest A. The dies F F are made hollow and bell-mouthed on one end, as shown in fig. 4, of the proper width for receiving the skelp flat when introduced into them, and tapering smaller to the opposite end until they assume nearly a half oval shape when closed. Two plates or pins, *g g*, are fastened flush to the inner faces of the dies, one on each, and project down between them to form grooves for receiving the edges of the skelp which makes the laps for welding and forming tubes. The adjustable stop D moves upon the slide-rest A for the purpose of adapting it to dies of different sizes; and the adjustable bracket C, and bent lever E, are for opening and closing the dies F F. The flat sheet of iron or skelp is heated to a red heat in a proper heating furnace; one end is then placed with a pair of tongs between the dies in the bell-mouthed end, so as to extend far enough through the other side for seizing it with a pair of pliers, when the lever E closes the dies and brings the skelp to its proper shape between them. The pliers which have hold of the skelp are then hooked to an endless chain or draw-bench, which draws it through the dies and makes it the proper shape from end to end.

Having described the construction and operation of my invention, what I claim as new, and desire to secure by Letters Patent, is—

I claim the horizontal slide-rest A, or its equivalent, the adjustable bracket C, the bent lever E, the adjustable stop D, and the dies F F, all constructed, combined, and arranged substantially as and for the purposes herein described.

JOHN PEACE.

Witnesses:

FRANK BOARDMAN,
JAMES M. CASSADY.