

F. B. MORSE.
Carriage Clip.

No. 110,581.

Patented Dec. 27, 1870.

Fig. 1.

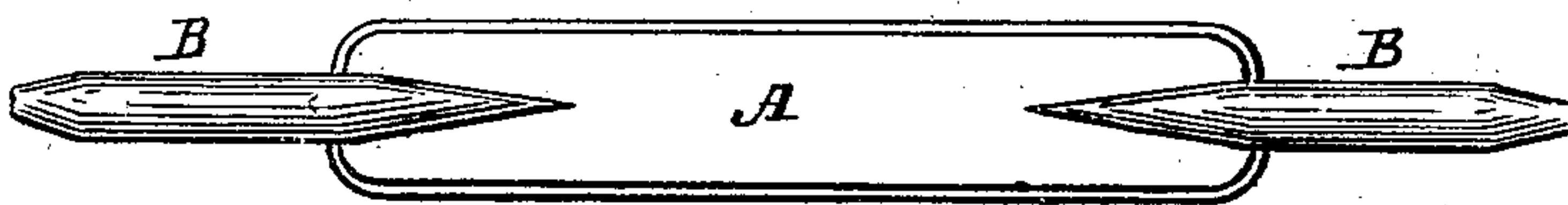


Fig. 2.



Fig. 3.



Fig. 4.



Witnesses:

J. H. Shumway
A. J. Tibbitts

Inventor:

Francis B. Morse
By his Attorney
John E. Earle

United States Patent Office.

FRANCIS B. MORSE, OF PLANTSVILLE, CONNECTICUT, ASSIGNOR TO HIMSELF AND H. D. SMITH & CO., OF SAME PLACE.

Letters Patent No. 110,581, dated December 27, 1870.

IMPROVEMENT IN CARRIAGE-CLIPS.

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, FRANCIS B. MORSE, of Plantsville, in the county of Hartford and State of Connecticut, have invented a new Improvement in Carriage-Clips; and I do hereby declare the following, when taken in connection with the accompanying drawing and the letters of reference marked thereon, to be a full, clear, and exact description of the same, and which said drawing constitutes part of this specification, and represents in—

Figure 1, a top view;

Figure 2, a transverse section of the clip after trimming;

Figure 3, a transverse section as finished; and in

Figure 4, a transverse section of an oval clip.

This invention relates to an improvement in carriage-clips.

In the manufacture of carriage-clips, after the clip has been formed it is placed in the trimming-die and the fin around the body of the clip is cut away, leaving a comparatively thick edge, and often rough, the trimming being the last process except what may be done by hand.

The object of my invention is to finish the edge of the clip after it comes from the trimming-die; and

It consists in bringing the edge of the clip, from shank to shank, down to a thin, sharp edge by striking it in dies prepared for the purpose after the trimming operation.

A is the body of the clip.

B B, the two shanks.

As heretofore formed, the body of the clip has been

made of an equal thickness and trimmed, leaving it in transverse section, as seen in fig. 2. This edge has sometimes been filed away over the central portion of the clip, but only in the very best of work, as the expense of so doing is too great.

To finish the clip, I prepare a die of the form of the clip, with a chamfered edge from shank to shank, the impression in the die being a little wider than the trimmed clip; then place the trimmed clip, heated simply to a dark-red heat, not enough to form a scale, into the die, and strike it therein by a follower in the usual manner, and the edge is chamfered corresponding to the die, as seen in fig. 3, from shank to shank, as seen in fig. 1, finishing the clip to a sharp edge.

If an oval clip is preferred, as seen in transverse section, fig. 4, the die is prepared accordingly, and the clip, as it comes from the trimming-die, is again struck, as described for the chamfered edge, the oval surface extending from shank to shank.

By this construction, which adds little if nothing to the expense of manufacture, the clip is neatly finished, and with an edge perfectly regular and smooth.

I claim as my invention—

As an improved article of manufacture, a carriage-clip in which the edge is chamfered or reduced, from shank to shank, after the clip has been trimmed, substantially as and for the purpose set forth.

F. B. MORSE.

Witnesses:

A. J. TIBBITS,

J. H. SHUMWAY.