

(No Model.)

T. V. ALLIS.

Blank for Barbed Metallic Fence Rods.

No. 234,936.

Patented Nov. 30, 1880.

Fig. 1.

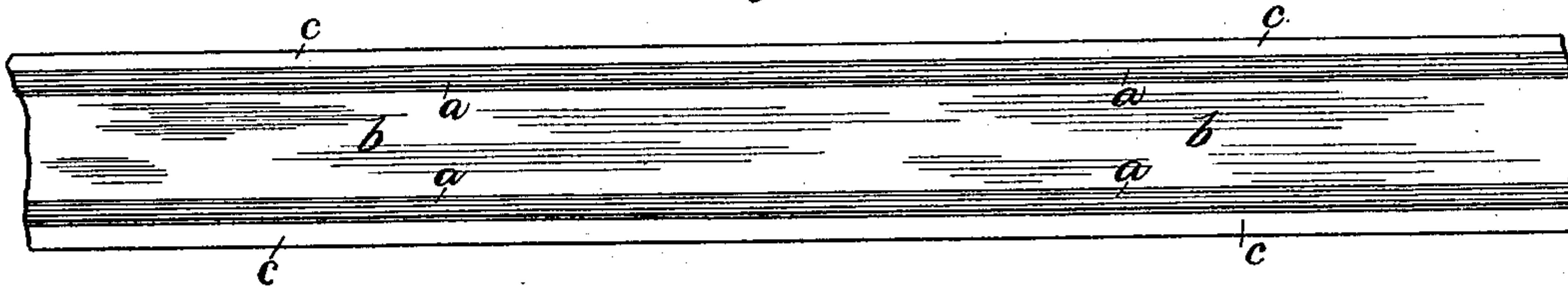


Fig. 2.



Fig. 3.

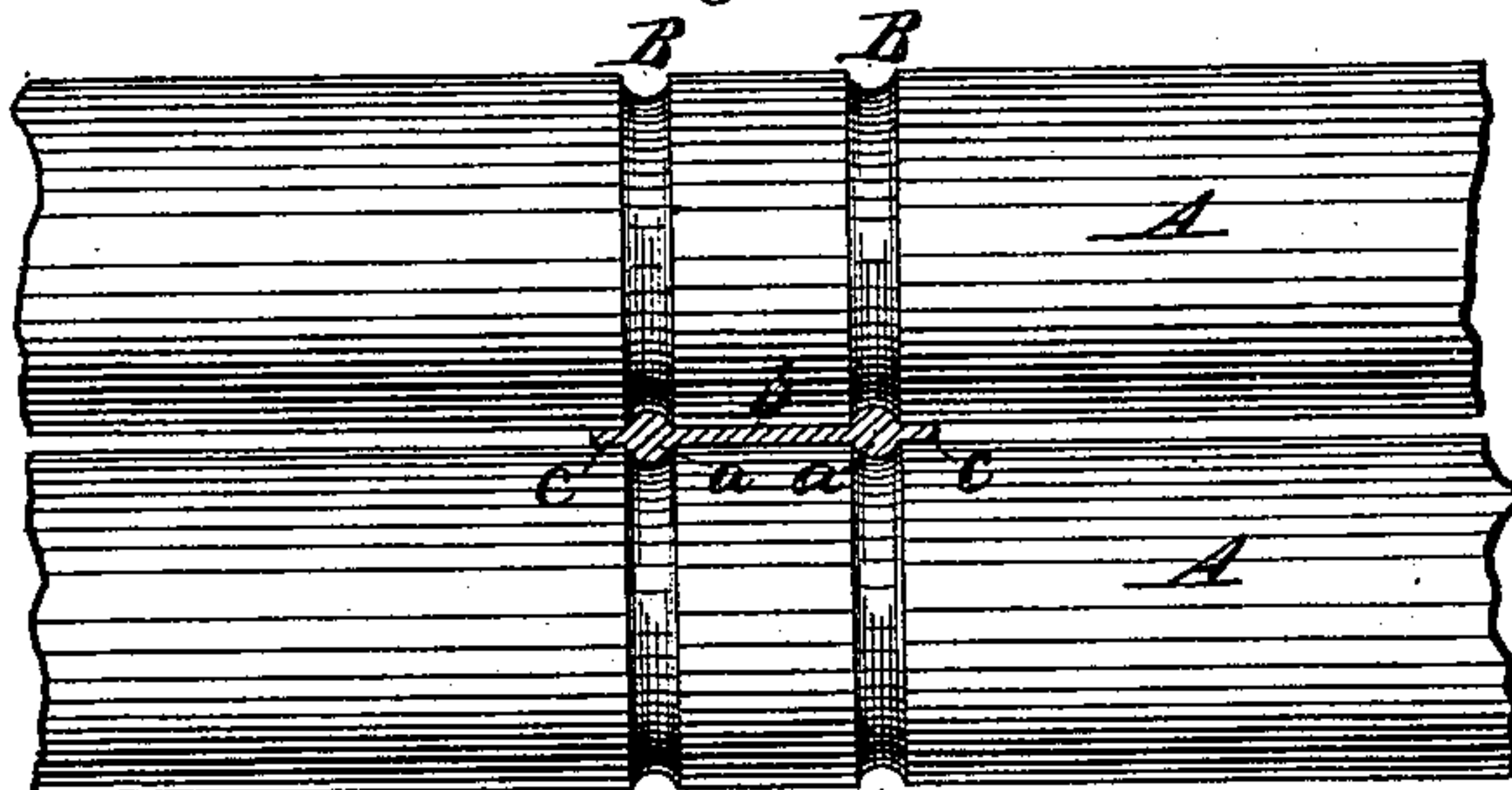
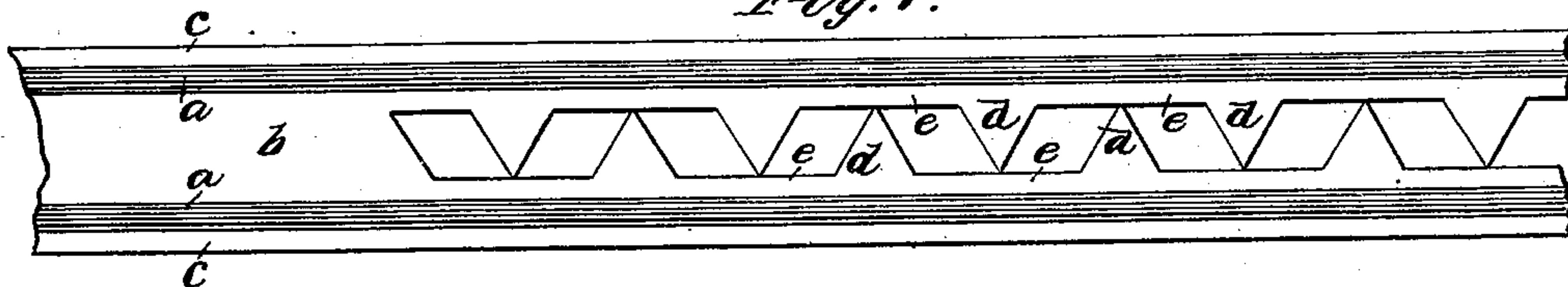


Fig. 4.



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# UNITED STATES PATENT OFFICE.

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## BLANK FOR BARBED METALLIC FENCE RODS.

SPECIFICATION forming part of Letters Patent No. 234,936, dated November 30, 1880.

Application filed June 17, 1880. (No model.)

*To all whom it may concern:*

Be it known that I, THOMAS V. ALLIS, of the city, county, and State of New York, have invented a new and useful Improvement in  
5 Blanks for Barbed Metallic Fence Rods, of which the following is a specification.

My invention consists of a blank rod specially designed for the manufacture of twisted barbed metallic fencing, having one row of  
10 barbs made out of a fin of said rod, with narrow webs of said fin along the rod and connecting the bases of the barbs, said rod, also, having a narrow plain fin on the side opposite to said webs, between the barbs, of about the  
15 same width, for balancing them when the rod is twisted after the barbs are formed on it, to make it twist straightly, which said blank is composed of two cores or ribs connected by a thin web to form the barbs and their connect-  
20 ing-webs, and a narrow fin to each core or rib opposite the said connecting-web, to make the aforesaid balancing fins for insuring straightness in the rod when twisted after the barbs are formed.

25 The advantages of this form of blank are, first, the facility with which it can be rolled, in consequence of only requiring grooves in the rolls for the cores or rib portions, while the web and the fins may be made between  
30 the plain faces of the rolls; and, second, the fins come in the places where fins naturally make in rolling metal.

The web furnishes the barbs for both rods by so punching the surplus metal away that  
35 the barbs of one are made in the spaces between the barbs of the other rod.

Figure 1 represents a plan view of my improved blank rod for barbed fencing. Fig. 2 is a transverse section of the blank. Fig. 3 is  
40 an elevation of the rolls for making the blank and a section of the latter, and Fig. 4 is a plan of a section of the blank, partly punched, as in the making the barbs and separating the rods one from the other.

45 *a* represents the said ribs or cores; *b*, the

web connecting the same, to make the barbs *d* and the narrow webs *e*, connecting the bases of the barbs, along the core, and *e* represents the outside narrow fins opposite to the web *b* and the barbs *d* and webs *e*, made from said  
50 web, for balancing said webs *e* when the barbed rod is finally twisted. If the web *b* could be cut close to the side of the ribs *a*, so as not to leave the narrow webs *e*, this balancing-fin *c* would not be needed, as the rod  
55 would then twist straightly; but it cannot well be done when the web *b* is radial to the core, because the die on which the core lies to be punched has to be grooved for the core, which makes an acute-angled edge to the die,  
60 which will not last under the blows of the punches; consequently it has to be strengthened by widening the metal between the groove and the cutting-edge beyond the radius of the core from which the webs *e* result, which webs,  
65 if unbalanced, would prevent the rod from twisting straightly, and therefore require the balancing effect of the fin *c*.

*A* represents the rolls for making this blank, which are plain, except a groove, *B*, for each  
70 of the ribs or cores *a* of the blank.

I am aware that blanks for making nails, combs, rakes, &c., consisting of two parallel ribs connected by a thin web, have been made; but I am not aware that such form of metal with  
75 the outside narrow fins, *e*, have ever before been employed as a blank for the manufacture of any article.

Having thus described my invention, what I claim, and desire to secure by Letters Pat-  
80 ent, is—

The improved blank rod herein described for barbed metallic fencing, consisting of two ribs or cores, *a*, each having a narrow outside fin, *c*, and being connected by a thin web, *b*,  
85 between them, substantially as specified.

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Witnesses:

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