

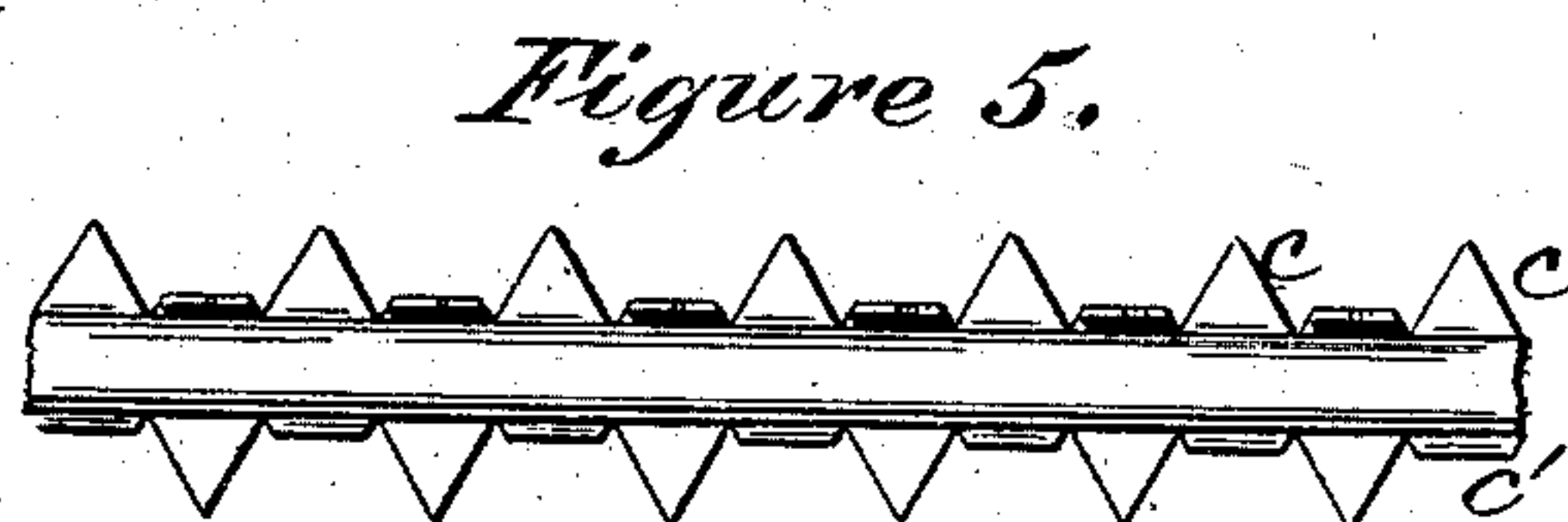
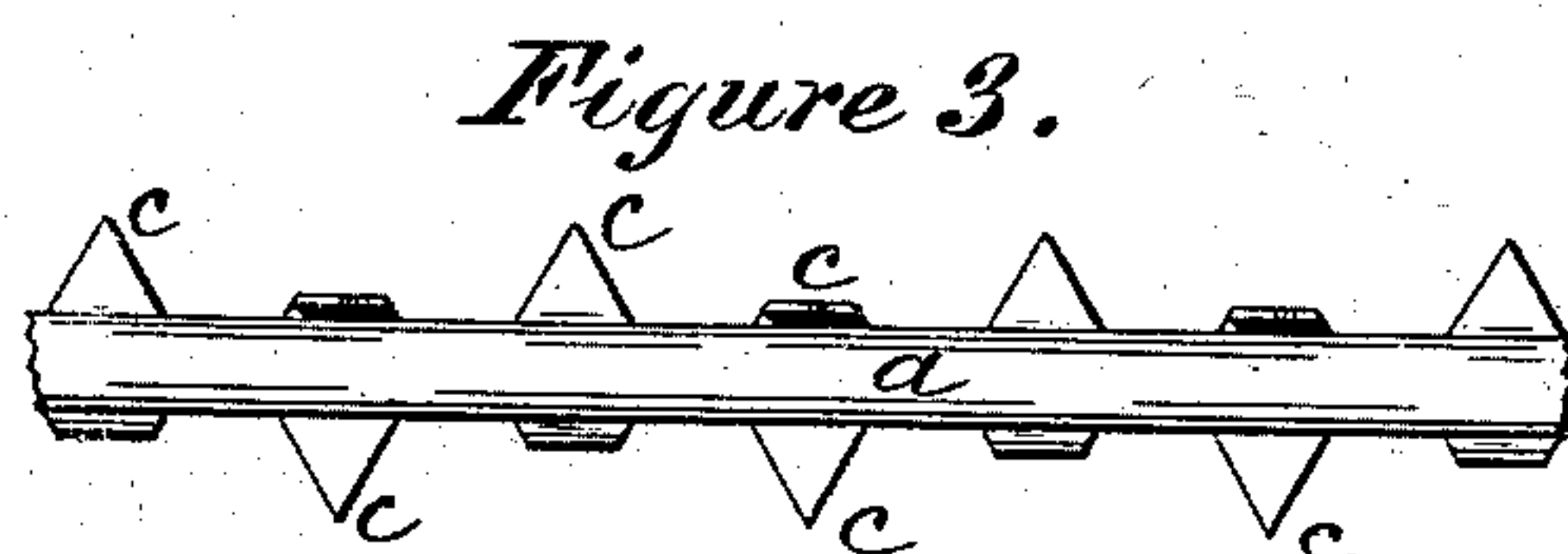
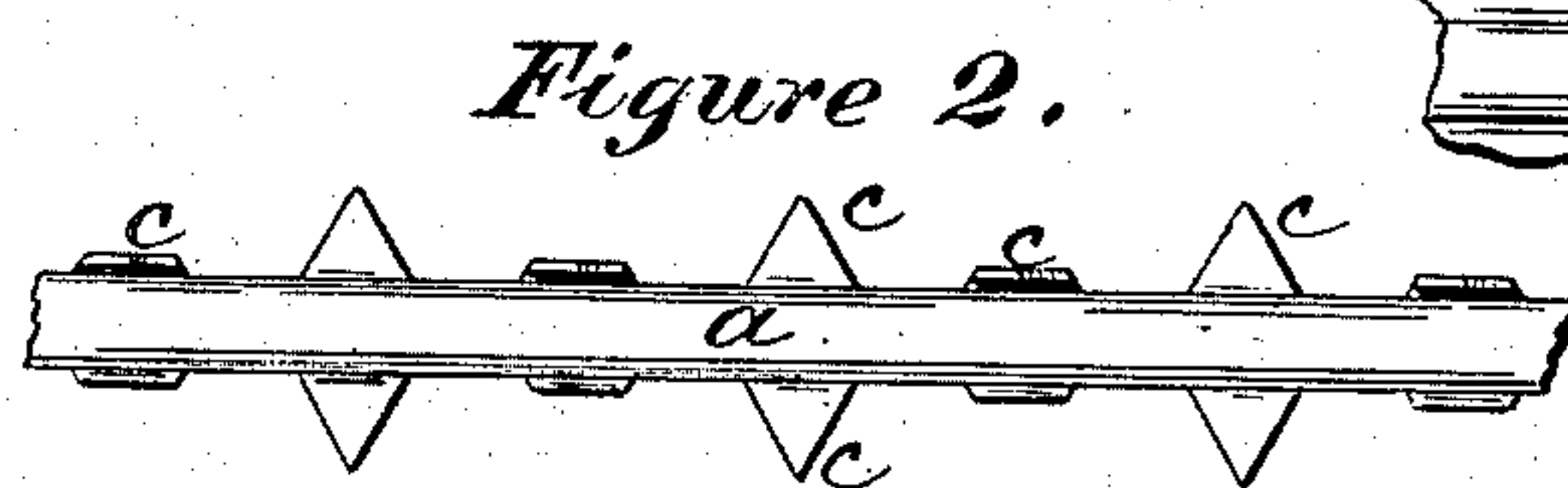
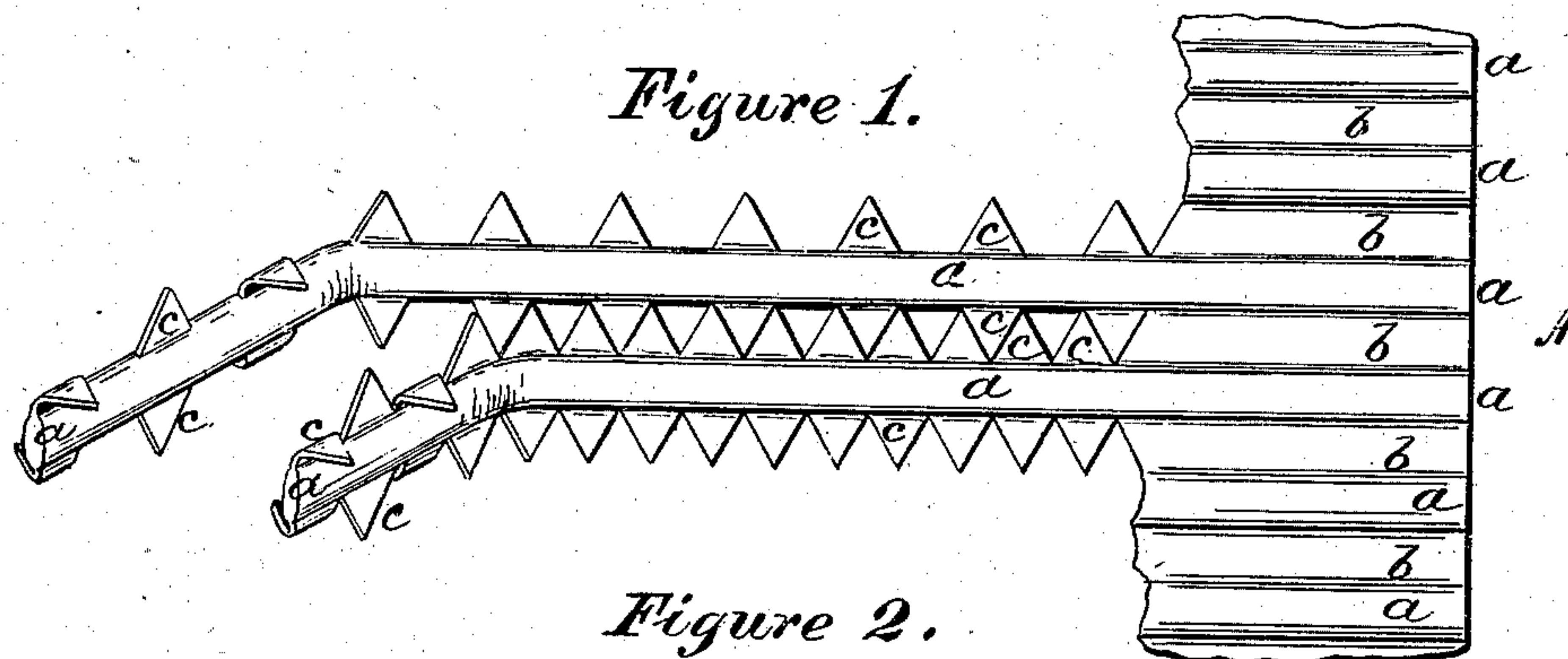
(No Model.)

W. S. BATE.

PROCESS OF PRODUCING BARBED FENCING MATERIAL.

No. 254,904.

Patented Mar. 14, 1882.



Witnesses:
William Paxton
Courtney A. Cooper.

Inventor:
William S. Bate,
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UNITED STATES PATENT OFFICE.

WILLIAM S. BATE, OF BROOKLYN, NEW YORK.

PROCESS OF PRODUCING BARBED FENCING MATERIAL.

SPECIFICATION forming part of Letters Patent No. 254,904, dated March 14, 1882.

Application filed October 27, 1881. (No model.)

To all whom it may concern:

Be it known that I, WILLIAM S. BATE, of the city of Brooklyn, county of Kings, and State of New York, have invented a new and useful Process of Producing Barbed Fencing Material and a new and useful Barbed Wire, of which the following is a full, true, and exact description, reference being had to the accompanying drawings.

My invention relates primarily to the production of thorned or barbed wire from sheets of metal which have been ribbed or corrugated in their manufacture, and have as a result each a series of alternate thick and thin portions. From the sheet of material so formed I prepare my fencing material by cutting the barbs, without loss of material, from the thinner alternate portions, while the thicker portions serve for the body or strengthening portion of the completed wire or fencing material. The barbs or thorns themselves are triangular in shape, and are formed of the thin or sheet part of the material, and the alternate barbs are subsequently bent so as to project at various angles from the body of the fencing material.

My invention will be readily understood from the accompanying drawings, of which—

Figure 1 represents the method of producing the material, showing the rolled metal and the barbs in process of formation. Figs. 2, 3, 4, and 5 represent different modifications, showing a variety of ways in which the thorns or barbs may be bent.

A represents generally a sheet of material, which has series of alternate ribs *a* and thin portions *b*. The thin portion is then to be cut by a suitable cutter or die on a zigzag line, leaving the barbs *c* alternately attached to the

adjacent wires or rods *a*. The alternate barbs of the fencing material so produced can then be bent at right or other angles to the intermediate barbs, so as to present barbs projecting in different directions from the body of the wire.

I am aware that barbed wires have been made from strips having each two ribs with fins on the outer edges, and connected by a web which is cut to form barbs; but this results in having the barbs all on one side, and necessitates the twisting of the wire. Moreover, there is considerable waste material which is avoided by the mode of manufacture above described. I also by such mode secure the production of a wire having numerous barbs on both opposite edges, and with but a fraction of the waste otherwise resulting.

I claim—

1. The within-described improvement in the mode of making barbed fence-wire, the same consisting in first forming a sheet with a series of parallel ribs separated by thin webs, then cutting said webs on both sides of each rib and on zigzag lines, producing barbs on the opposite ribs and on both sides of each rib without waste, and then bending said barbs, as specified.

2. As a new article of manufacture, a barbed wire consisting of a strip, *a*, having Δ -shaped barbs, one-half the barbs on opposite edges being radial to the wire, the other and intermediate barbs being bent on opposite sides tangential to the wire, as set forth.

W. S. BATE.

Witnesses:

GEO. H. EVANS,
WM. A. POLLOCK.