

(No Model.)

E. JORDAN.

METHOD OF MAKING BARBED METALLIC FENCING.

No. 301,126.

Patented July 1, 1884.

Fig. 1.

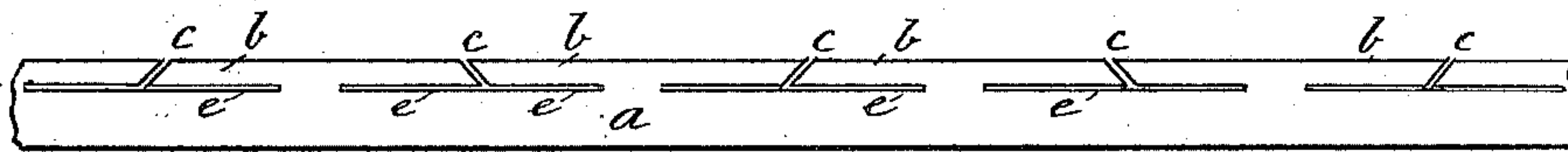


Fig. 2.

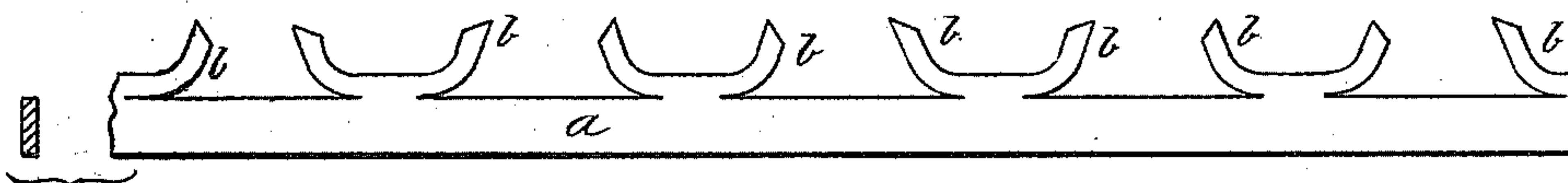
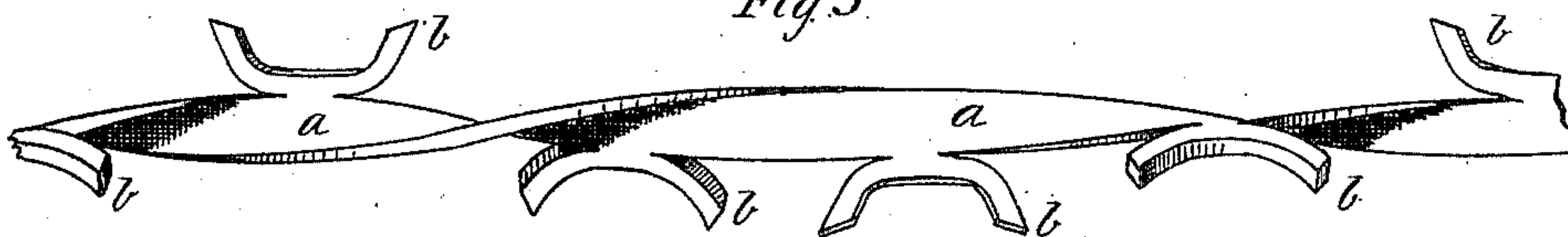


Fig. 3.



WITNESSES:

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METHOD OF MAKING BARBED METALLIC FENCING.

SPECIFICATION forming part of Letters Patent No. 301,126, dated July 1, 1884.

Application filed May 21, 1883. (No model.)

To all whom it may concern:

Be it known that I, E. JORDAN, a citizen of the United States, residing at Brooklyn, Kings county, New York, have invented new and
5 useful Improvements in the Method of Making Barbed Metallic Fencing, of which the following is a specification.

My invention consists in making barbed
10 metallic fencing by taking flat blank strips of steel as wide as the breadth of the barbs and of the barbed strip when completed, cutting notches into the edge oblique to the strip and as deep as the required width of the barbs,
15 then slitting along the strip parallel to the edge the length of a barb each way from the notch, and then bending out the two bars thus cut and slit apart from the strip, and forming two barbs of them. The diagonal cut into the
20 edge of the strip forms the points of the barbs, and the straight slit along the bar from the end of the diagonal cut to the termination of the slit forms a straight bar of equal dimensions throughout the portion that is to be bent in causing the point to project, whereby the
25 barb bends much more uniformly from end to end of the curve, and the metal is much less liable to crack, thus making much stronger barbs for a given size than can be made by cutting diagonally into the strip the whole
30 length of the barb. The barbs, being made the full thickness of the strip, have stronger connection with the strip than when made of thin ribs formed on the surface of a thicker wire, and they are made cheaper and better
35 than when so formed, because in this case it is the simplest form of bar or strip to make that is used, whereas the round or other shaped cores or rods with fins or ribs formed on the surface are more difficult and expensive to
40 make.

It is to be observed that I cut into the edge of the blank strip at such distance apart as will allow of slitting the bar each way along
45 from said cuts for turning out the barbs in opposite directions, which, together with the portion remaining in contact with the strip between the two barbs, makes the barbs the proper distance apart on the strip, and utilizes the whole of the edge of the strip for
50 barbs without waste of material, all as here-

inafter fully described, reference being made to the accompanying drawings, in which—

Figure 1 is a plan view of a blank strip, having the diagonal cuts in the edge to form points and to separate the ends of the bars
55 for the barbs from the strip, and also having the longitudinal slits parallel to the edge of the strip, to separate the said bars from the point to the base, the cuts in the edge being located a suitable distance apart to allow of
60 slitting along the bar both ways from the cut, to bend up the barbs in opposite directions. Fig. 2 is a plan view and section of the barbed strip, having the barbs bent up in opposite
65 direction. Fig. 3 is a side view of the barbed strip of Fig. 2, twisted and finished for use.

I take a plain, thin, and flat bar, *a*, as much wider than the barbed and finished bar is to be as the width of the barbs *b*, but of uniform
70 thickness throughout its breadth, and cut diagonally at *c* as deep as the required width of the barb, and then slit said bar along the
75 lines *c* both ways from the cuts *c*, as in Fig. 1, making the cuts *c* as far apart as is requisite for making two barbs between the cuts by
80 turning or bending them out in opposite directions, employing any approved means for cutting and slitting the strip, and also for bending the barbs out. It will probably be
85 best in practice to make the cuts *c* and the slits *e* by a shearing-punch and die, cutting both parts at once. For bending out the bars
90 *b* and forming them into barbs, any kind of wedging-dies may be employed.

The cuts *c* may of course be made square
85 or at right angles to the strip *a*; but in that case the barbs would have to be pointed by another operation, which would be accomplishing the same thing by unnecessary waste
90 of time and labor; and the slits *e* may be inclined to the edge of the blank strip to some extent; but that would be practically the same as the parallel slits as I propose to make them. I prefer to twist the barbed strips so formed
95 as represented in Fig. 3, but may use them without twisting.

I am aware of the Patent No. 242,636, in which a fencing-strip is represented with barbs cut from the edges of the strip and bent out
100 laterally to it; but my invention is distin-

guished from that in that I cut diagonally into the edge of the strip to point the barbs, and bend out the barbs in the plane of the strip.

5 What I claim, and desire to secure by Letters Patent, is—

The method of making barbed metallic fencing consisting of cutting the edge of a plain flat strip, *a*, diagonally to the width of the
10 barbs to be formed to point the same, slitting

along said strip from the said diagonal cut the length of a barb and bending out the slit portion of the edge in the plane of the strip.

In witness whereof I have hereunto signed my name in the presence of two subscribing
15 witnesses.

EDMUND JORDAN.

Witnesses:

JACOB G. CARPENTER,

A. P. THAYER.