

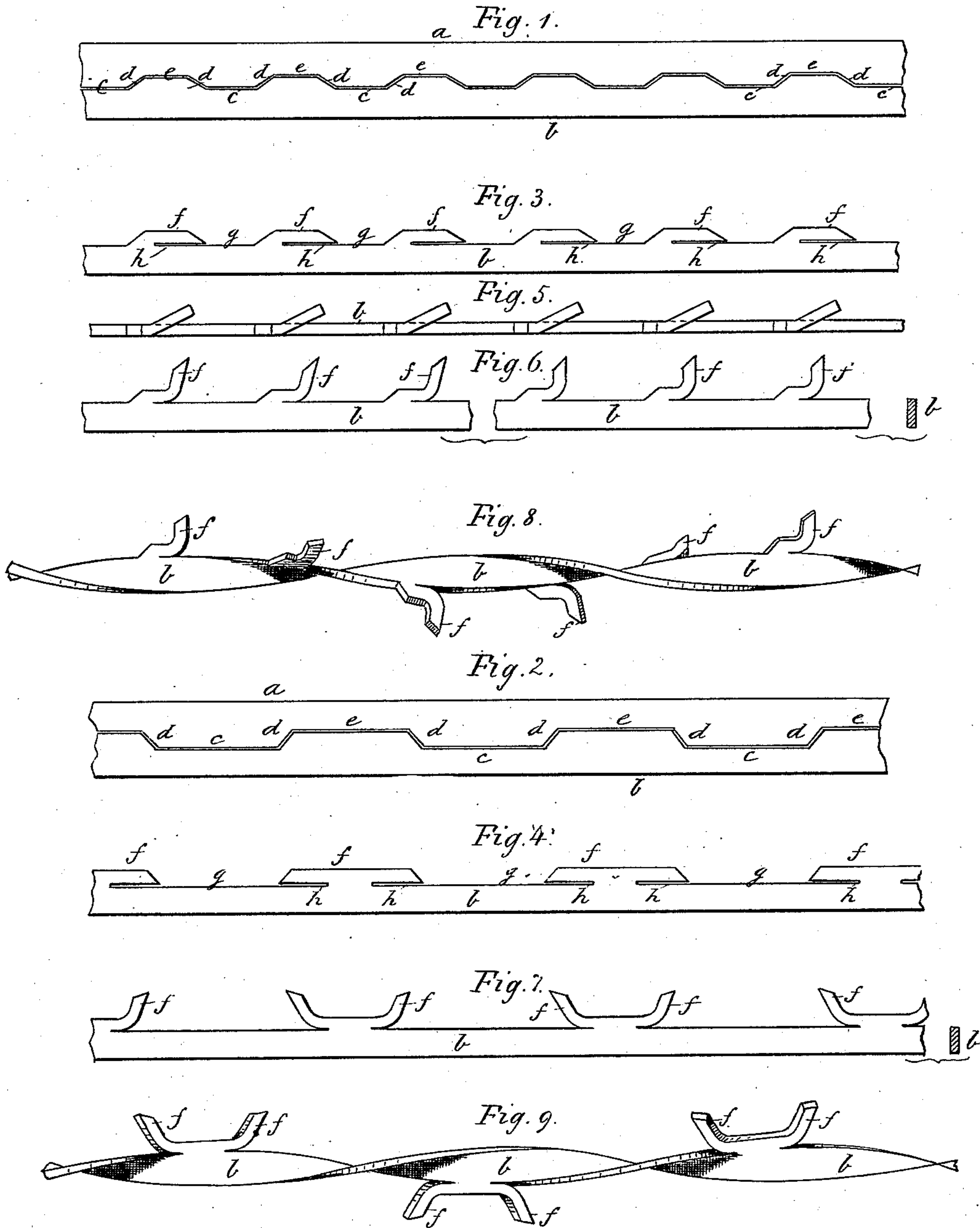
(No Model.)

E. JORDAN.

METHOD OF MAKING FENCE BARBS OF SHEET METAL.

No. 302,534.

Patented July 22, 1884.



WITNESSES:

Wm. A. Lowe
O. H. Morgan

INVENTOR

Edmund Jordan

BY A. P. Thayer,

ATTORNEY

UNITED STATES PATENT OFFICE.

EDMUND JORDAN, OF BROOKLYN, ASSIGNOR TO MICHAEL H. CASHMAN,
OF NEW YORK, N. Y.

METHOD OF MAKING FENCE-BARBS OF SHEET METAL.

SPECIFICATION forming part of Letters Patent No. 302,534, dated July 22, 1884.

Application filed May 21, 1883. Renewed June 7, 1884. (No model.)

To all whom it may concern:

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

My invention consists of slitting blank strips of flat bar steel, so as to make projecting ribs at intervals along the edges of two strips into which the blank is separated, so that the ribs of one strip are to be taken from the spaces between the ribs of the other strips, which ribs are then slitted along the lines of the edges of the strips in the depressions between the ribs, and then bent out to form the projecting barbs, all as hereinafter fully described, reference being made to the accompanying drawings, in which—

Figure 1 is a plan view of a blank strip slitted along the middle to divide it into two strips with projecting ribs along one edge to form barbs, the form of the slit being that employed for ribs to make a single barb. Fig. 2 is a plan view of a blank strip slitted along the middle to divide it into two strips, with projecting ribs along one edge to form barbs, the form of the slit being that employed for ribs to make two barbs—one at each end of each rib. Fig. 3 is a plan view of one of the ribbed strips from the blank of Fig. 1, with the ribs slitted from one end along the edge of the strip preparatory to bending them into the projecting condition for barbs. Fig. 4 is a plan view of one of the ribbed strips from the blank of Fig. 2, with the ribs slitted from both ends along the edge of the strip preparatory to bending them into the projecting position for making two barbs from one rib. Fig. 5 is an edge view of the barbed strip of Fig. 1 as it appears after slitting the barbs along the edge of the strip, as in Fig. 3. Fig. 6 is a plan view and cross-section of the completed barbed strip from the blank of Fig. 1. Fig. 7 is a plan view and cross-section of the completed barbed strip from the blank of Fig. 2. Fig. 8 is a side view of a twisted barbed strip from the blank of Fig. 1, and Fig. 9 is a side view of a twisted barbed strip from the blank of Fig. 2.

I take a narrow flat blank strip, *a*, of the desired thickness, as represented in the sec-

tion of Figs. 6 and 7, said strip being as wide as two of the completed strips *b* and one barb, and slit said blank along the lines *c d e* by any suitable contrivance of slitting machinery, separating it into two strips *b*, each having short barb ribs *f* at intervals along one edge, the ribs of one strip *b* being the metal taken from the notches *g* of the other strip, the said ribs and notches being longer or shorter according as I desire to make the ribs for a single barb or for two barbs. I then take the separate strips *b* and slit the barb ribs from its edge a suitable distance along the line *h* in any approved way, as by shearing them in the manner indicated in Fig. 4, from one end only for single barbs, and from both ends for two barbs to one rib, and then bend the barbs outward, as shown in Figs. 6 and 7, which represent them in two different angles, and they may be otherwise modified in this respect, and I also bend the barbs back into the plane of the strips *b*, either before or after bending them outwardly. The barbed strips thus made are to be twisted, as represented in Figs. 8 and 9, like other fencing of like character.

It will be seen that the above-described method of making barbed fencing is exceedingly simple and cheap, and is accomplished without any waste of material and by means of simple machinery, and the fencing itself is substantial and durable.

Having thus described my invention, what I claim, and desire to secure by Letters Patent, is—

The method of making barbed metallic fencing-strips by slitting a blank strip, *a*, along lines *c d e* through the middle portion to form two strips, *b*, having ribs *f* and notches *g*, by cutting the ribs *f* of one strip corresponding to the notches *g* of the other strip, then slitting the ribs *f* along lines *h* coincident with the edge of the strips in the notches *g* and bending out said ribs *f*, thus forming projecting barbs, substantially as described.

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

EDMUND JORDAN.

Witnesses:

JACOB G. CARPENTER,
A. P. THAYER.