(No Model.)

W. E. BROCK.

BARBED FENCING STRIP.

No. 305,282. Patented Sept. 16, 1884.

Fig. 1.

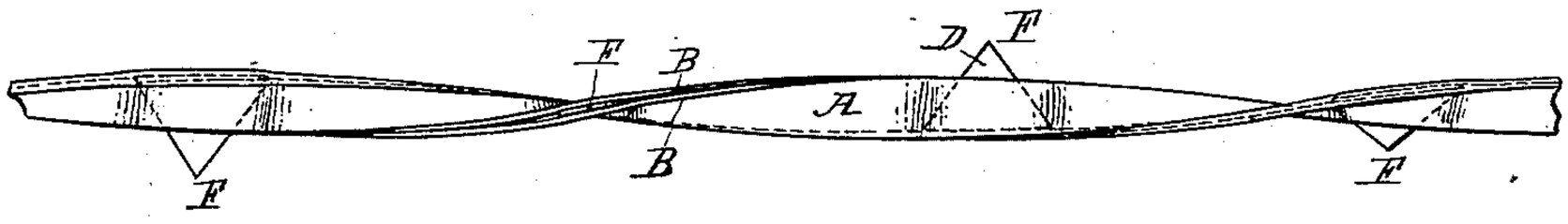


Fig. 2.

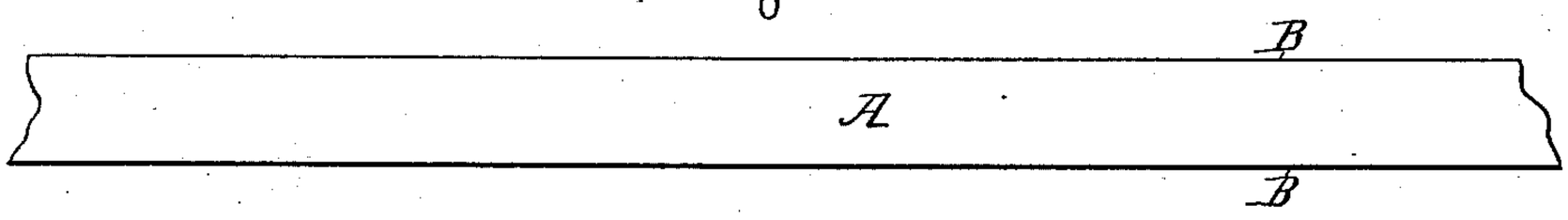


Fig. 3.

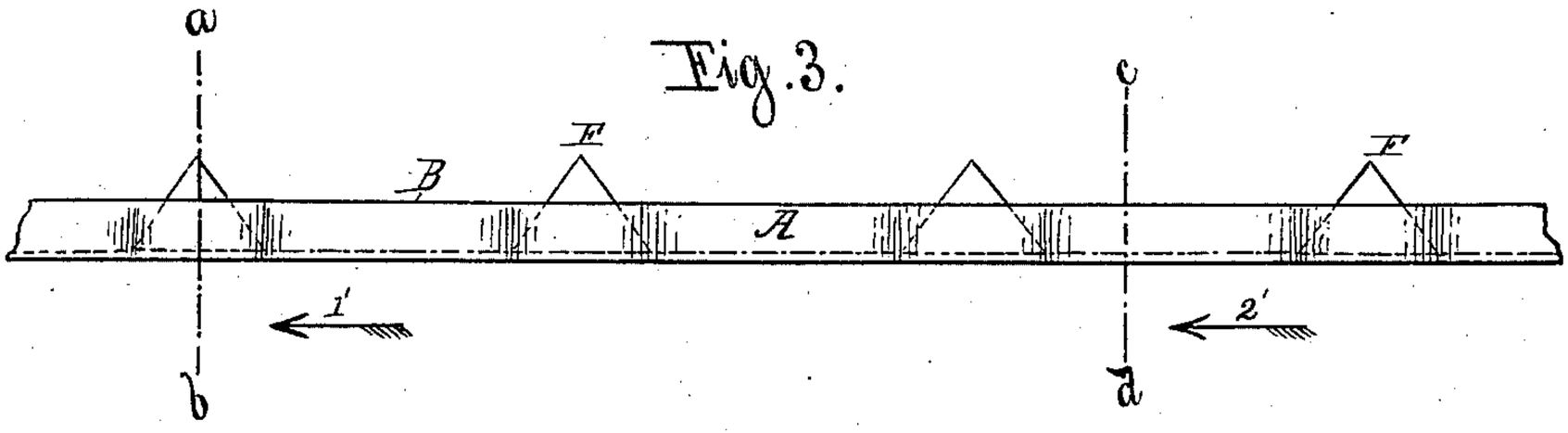


Fig. 4.

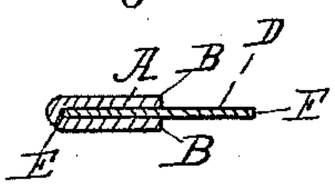


Fig. 5.

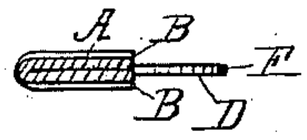
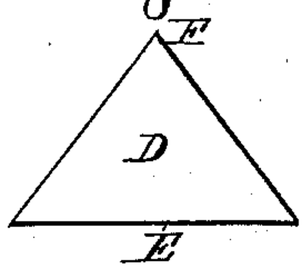


Fig. 6.



Witnesses;
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UNITED STATES PATENT OFFICE.

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BARBED FENCING-STRIP.

SPECIFICATION forming part of Letters Patent No. 305,282, dated September 16, 1884.

Application filed December 17, 1881. (No model.)

To all whom it may concern:

Be it known that I, WILLIAM E. BROCK, of New York city, in the county and State of New York, have invented certain new and useful Improvements in Barbed-Metal-Strip Fencing; and I do hereby declare that the following is a full, clear, and exact description of the same, reference being had to the accompanying drawings, forming a part of this specification, in which—

Figure 1 represents a section of my improved barbed fencing when completed, ready for use. Fig. 2 represents a side view of a section of the main metallic-strip material used in the manufacture of the barbed fencing represented in Fig. 1. Fig. 3 represents a side view of the barbed fencing after it has been completed, ready for the twisting operation. Fig. 4 represents, upon an enlarged scale, a section on line *a b*, Fig. 3, looking in the direction of arrow 1′ of same figure. Fig. 5 represents, upon an enlarged scale, a section on line *c d*, Fig. 3, looking in the direction of arrow 2′ of same figure; and Fig. 6 represents, upon an enlarged scale, a side view of one of the barbs, as will be hereinafter more fully described.

To enable those skilled in the art to which my invention belongs to make and use the same, I will proceed to describe it more in detail.

In the drawings, the part A represents the main metal strip, which is quite thin. A side view of a section of this strip is shown in Fig. 2. In the operation of manufacture the edges B B of this strip are bent up or folded together, as fully indicated in Figs. 3, 4, and 5 of the drawings, and the triangular sheet-metal barbs D are then inserted between the folded edges B B of said strip A, the base E of each barb resting upon the bottom of the strip A, as indicated by dotted lines, Figs. 1 and 3, and full lines, Fig. 4.

In the operation of manufacture I prefer to compress the folded edges B B between the barbs, as shown in Fig. 5, before the strip is run through the bath of zinc in the galvanizing process. As before stated, after the barbs D have been placed in position in the folded strip A, the barb-strip is run through a bath of molten zinc, thereby securely uniting the folded edges B B of the strip A, as well as the barbs D in position between the folded edges B B. The barbed strip shown in Fig. 3, after passing through the galvanizing operation, is subject to a twisting operation, whereby the barb-points F of the barb-piece D are left standing in different directions. The twisting operation may be performed before the fencing is galvanized, if preferred.

In the manufacture, if preferred, the barbs D can be cut and slipped into position as the strip A is gradually folded, the whole operation being performed by automatic machinery.

In my application of even date herewith, serially numbered 48,110, I have shown, described, and claimed a barbed-strip fencing, consisting of a metal strip folded longitudinally upon a barbed strip, the two being twisted spirally together, and I wish it to be understood that such construction is not covered by the present application.

Having described my improvements in barbed-metal-strip fencing, what I claim therein as new and of my invention, and desire to secure by Letters Patent, as an improved article of manufacture, is—

A metal fencing comprising a thin metal strip having a single longitudinal fold and triangular barbs inserted in said fold, the strip being twisted, substantially as described.

WILLIAM E. BROCK.

Witnesses:
GEO. T. PINCKNEY,
HAROLD SERRELL.