

(Model.)

N. ECCLES.

DIE FOR FIFTH WHEEL HEADS.

No. 312,828.

Patented Feb. 24, 1885.

Fig. 1.

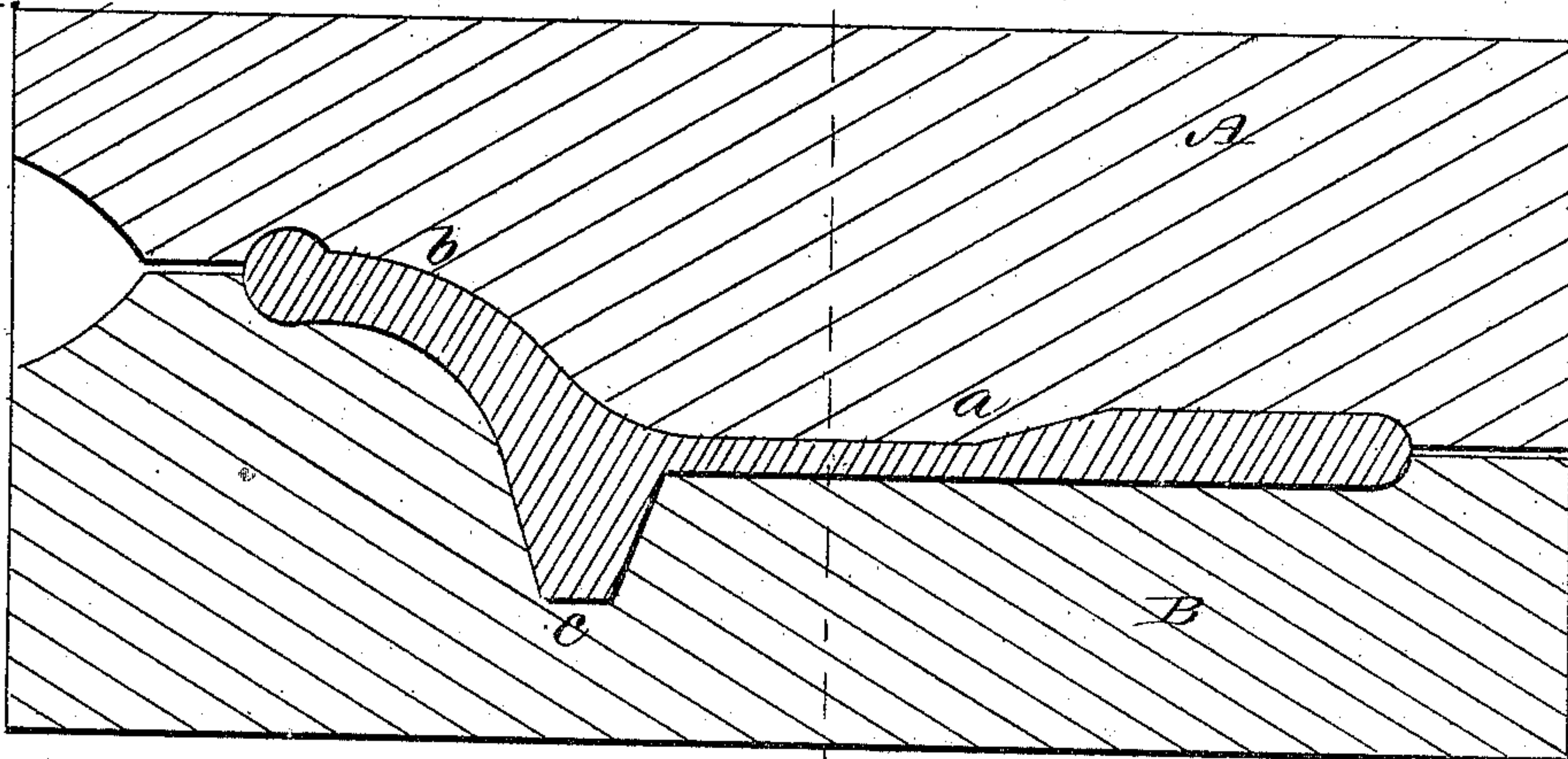


Fig. 2.

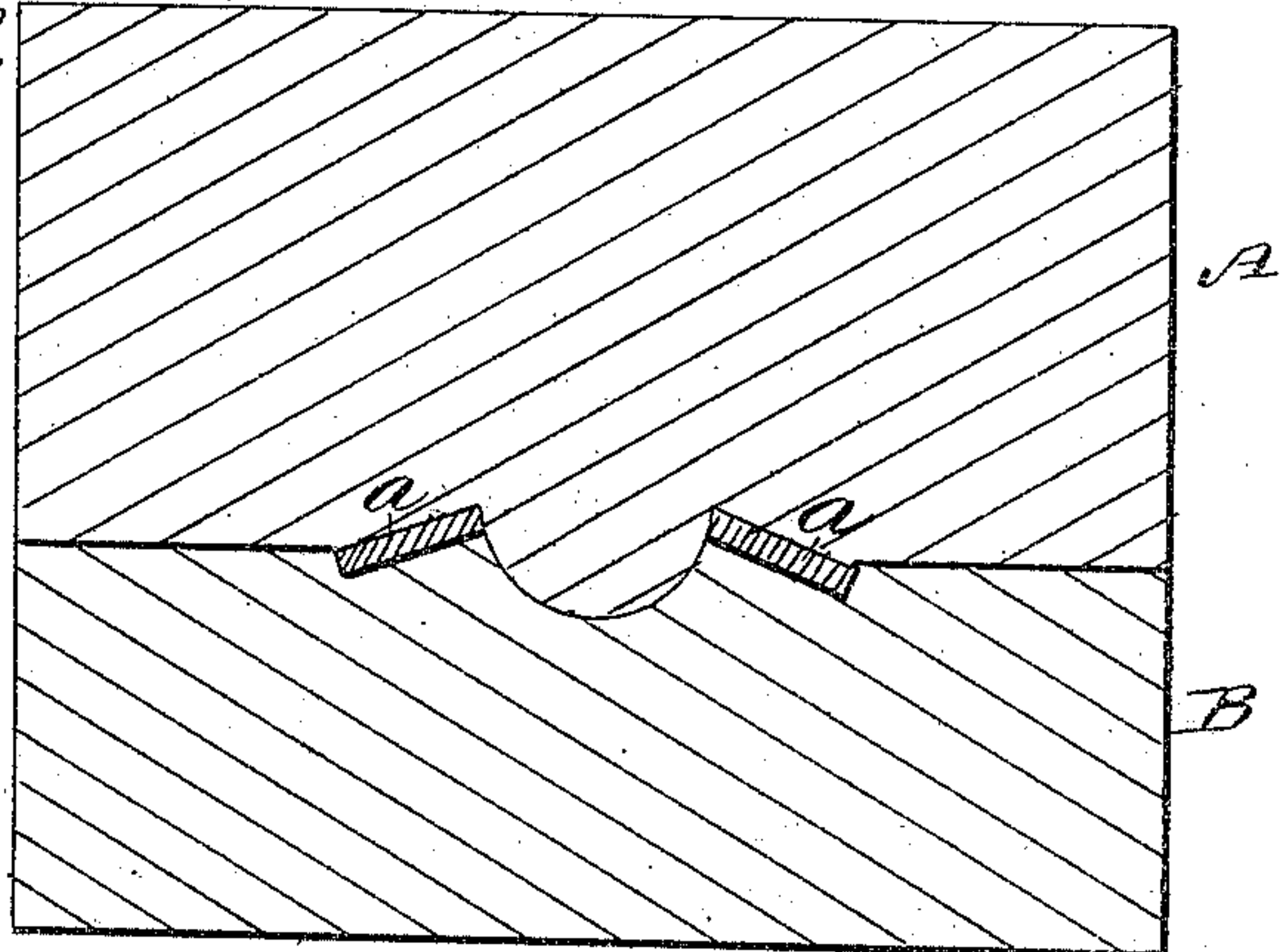
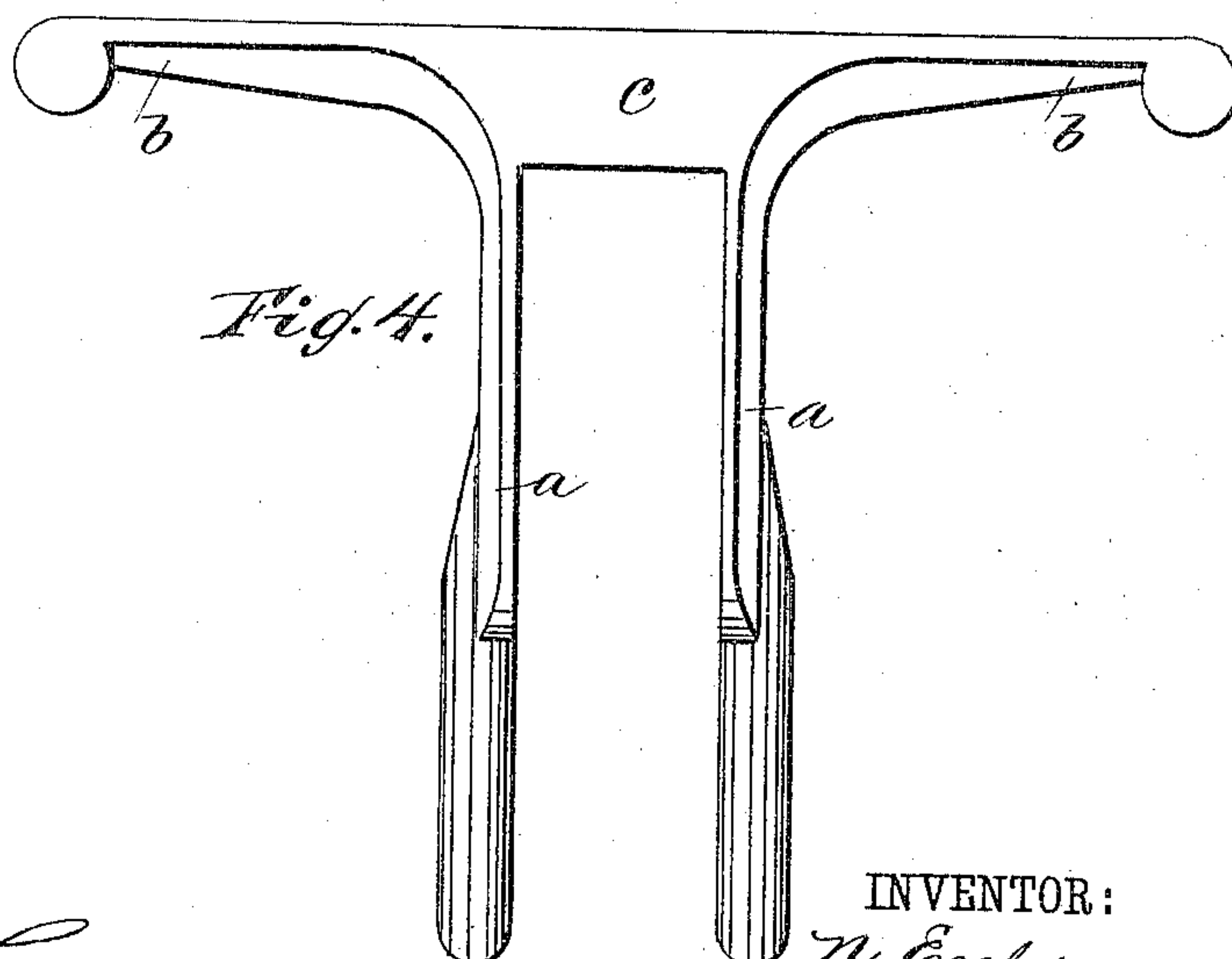
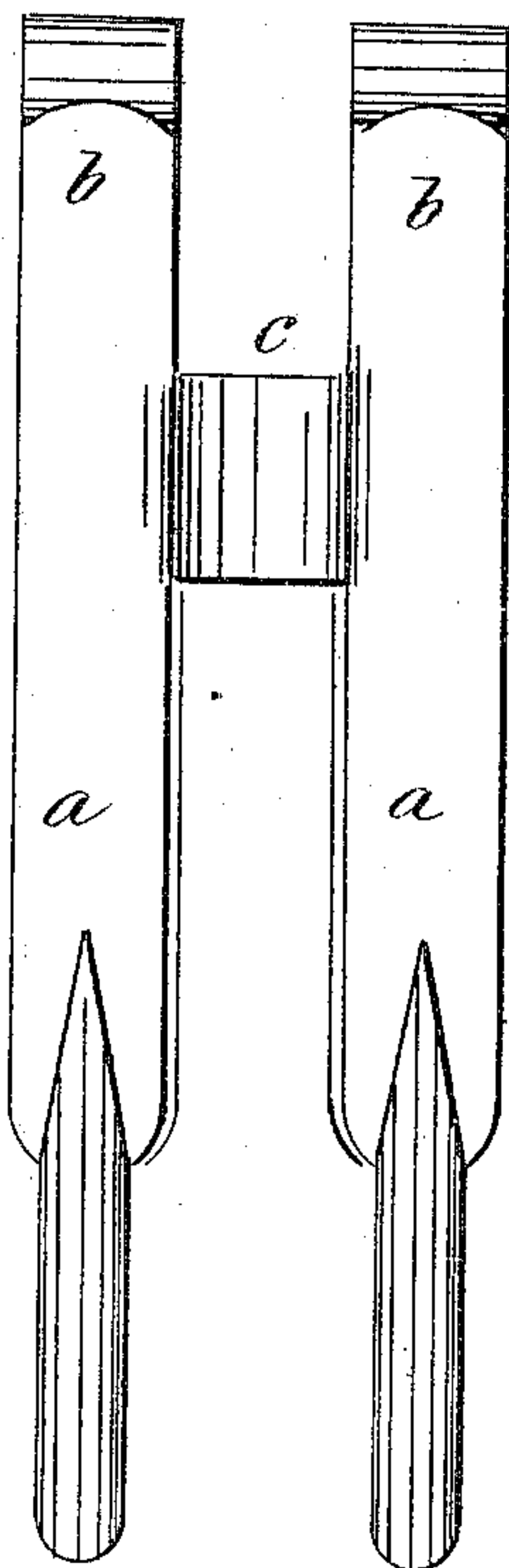


Fig. 3.



WITNESSES:

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NICHOLAS ECCLES, OF AUBURN, NEW YORK, ASSIGNOR TO R. & N. ECCLES,
OF SAME PLACE.

DIE FOR FIFTH-WHEEL HEADS.

SPECIFICATION forming part of Letters Patent No. 312,828, dated February 24, 1885.

Application filed August 5, 1884. (Model.)

To all whom it may concern:

Be it known that I, NICHOLAS ECCLES, of Auburn, in the county of Cayuga and State of New York, have invented a new and useful
5 Improvement in Dies and Processes for Making Fifth-Wheel Heads, of which the following is a full, clear, and exact description.

My invention relates to the manufacture of the articles known to carriage-makers as "fifth-wheel heads," the object being to produce a
10 stronger and better head than can be made by the methods heretofore employed. To that end I use dies which forge the members into form, and the operation is completed by bend-
15 ing the forging, as hereinafter described and claimed.

Reference is to be had to the accompanying drawings, forming a part of this specification, in which similar letters of reference indicate
20 corresponding parts in all the figures.

Figure 1 is a lengthwise, and Fig. 2 a cross-section, of the dies shown as containing the forged blank. Fig. 3 is a face view of the
25 forging, and Fig. 4 represents a completed head.

The dies A B are formed to divide a bar of iron lengthwise, thereby forming the two sides *a* of the clip in flat form and straight with the

grain of the iron, and also form the ends *b* of the head connected by the body portion *c*. 30
The forging made in this flat form does not stick in the dies.

The operation is as follows: The heated bar is first struck several blows in breakdown dies, and is then placed in the dies A B, which
35 are keyed in the drop-press. The forging is then removed, and the fin trimmed off, leaving it of the shape shown in Fig. 3. The forging is then bent to bring the body portion *c* straight, and the clip sides *a* into proper posi-
40 tion, and the ends *b* then bent out at right angles. In the forging the metal is so distributed that in the bending operation the metal is forced to its proper place, the head formed square, and the clip part twisted so as to lie
45 flat on the axle.

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

The dies A B, formed to produce the forging with clips *a* and ends *b* straight with the grain
50 of the metal, as specified.

NICHOLAS ECCLES.

Witnesses:

GEORGE W. NELLIS,
THOMAS KELLET.