

(No Model.)

M. BROCK.

METHOD OF FORMING HEADS ON NAIL STRIPS.

No. 323,847.

Patented Aug. 4, 1885.

Fig: 1.



Fig: 2.

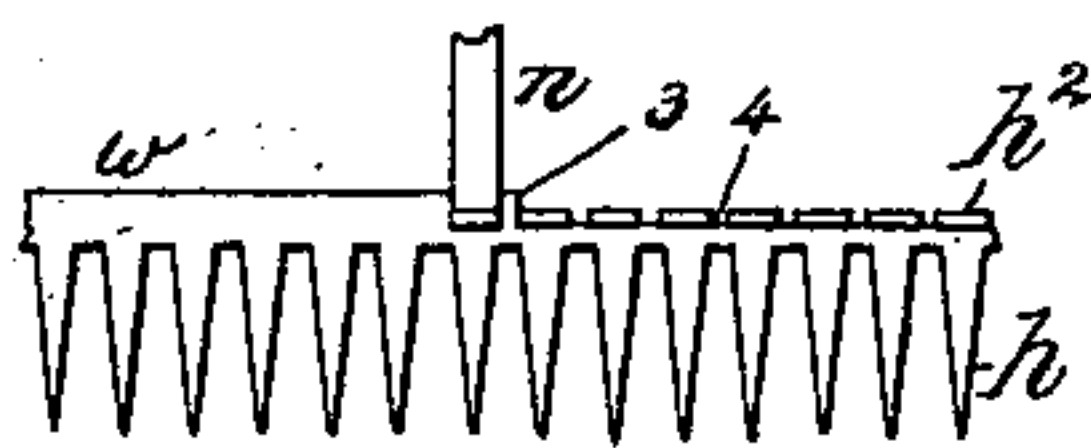


Fig: 3.

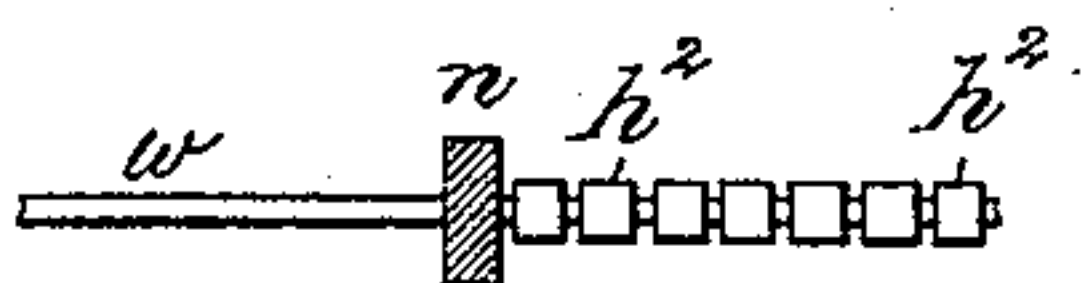
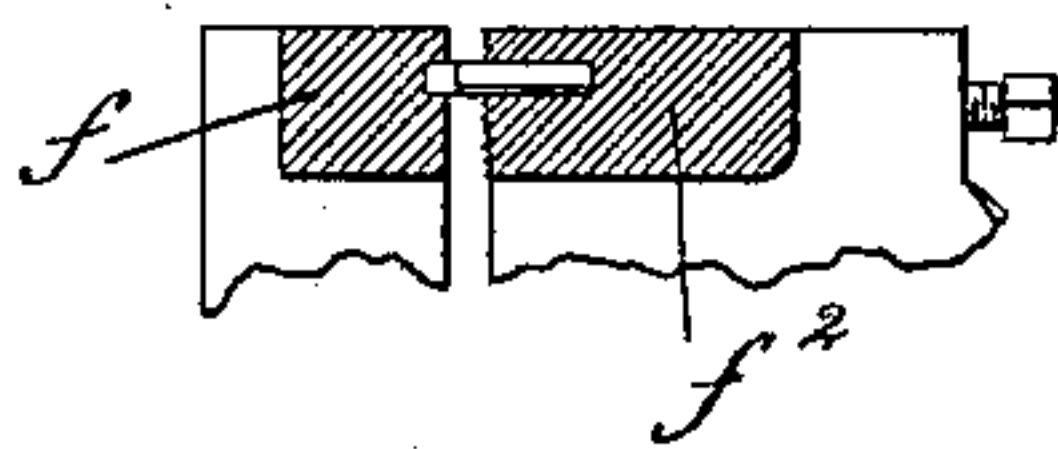


Fig: 4.



Witnesses.

Arthur Leppert.

B. J. Ayer.

Inventor.

Matthias Brock

by Crosby & Gregory Attys

UNITED STATES PATENT OFFICE.

MATTHIAS BROCK, OF BOSTON, MASSACHUSETTS, ASSIGNOR TO McKAY & COPELAND LASTING MACHINE COMPANY, OF PORTLAND, MAINE.

METHOD OF FORMING HEADS ON NAIL-STRIPS.

SPECIFICATION forming part of Letters Patent No. 323,847, dated August 4, 1885.

Application filed March 9, 1885. (No model.)

To all whom it may concern:

Be it known that I, MATTHIAS BROCK, of Boston, county of Suffolk, and State of Massachusetts, have invented an Improvement in
5 Method of Forming Projecting Heads on Comb-Nail Strips, of which the following description, in connection with the accompanying drawings, is a specification, like letters on the drawings representing like parts.

10 In another application by me, Serial No. 139,582, to which reference may be had, I have described a machine by means of which the method herein to be described may be practiced automatically.

15 My invention consists in clamping the comb-nail strip, leaving its head-forming edge extended beyond the clamp or jaw holding it, and while the strip is so held striking the said edge at intervals, or opposite each nail-
20 body or shank which is to be provided with a head, and thereafter cutting out or removing all that part of the said edge which is not struck directly by the upsetting-tool to a point below what is to constitute the tops of the
25 nail-heads, thus defining and leaving the said heads in condition to be easily separated.

Figure 1 in perspective, shows a piece of comb-nail strip as it is cut from the plate. Fig. 2 shows a piece of comb-nail strip one
30 part of which has been headed in accordance with my invention, the said figure showing a punch or upsetting-tool. Fig. 3 is a top view thereof, and Fig. 4 shows parts of a pair of jaws by which to hold the strip clamped.

35 The comb-nail strip shown in Fig. 1 is cut from sheet metal to form shanks h , connected

together by means of a narrow web, w , which is upset at intervals to form heads, one for each shank. A strip—such as shown Fig. 1—is clamped between suitable jaws, $f f^2$, preferably such as shown in my said application, where they are designated by like letters, and, so held, the web w is acted upon by a tool, n , which upsets the said web forming a head, h^2 .

The formation of the head, as described, by
45 upsetting a part of the web w leaves a narrow part, 3, of the web (see Fig. 2) extended between the adjacent heads, and thereafter the narrow part 3 is cut away by a cutter or chisel, leaving spaces between the heads of the comb-
50 nails, as at 4, the bottoms of the said spaces being below the tops of the heads h^2 . The nails so headed may be readily severed from the remaining nails of the comb-nail strip in the line of the spaces 4. 55

I claim—

The herein-described method of forming heads on a nail-strip, which consists in indenting or upsetting portions of the edge of the web of the strip at measured intervals, and
60 thereafter cutting out the projection left between adjacent upset portions to a point below the tops of the adjacent heads, substantially as described.

In testimony whereof I have signed my name
65 to this specification in the presence of two subscribing witnesses.

MATTHIAS BROCK.

Witnesses:

G. W. GREGORY,
F. CUTTER.