

(No Model.)

J. DEEBLE.

MANUFACTURE OF OX SHOES.

No. 336,900.

Patented Mar. 2, 1886.

Fig. 1.

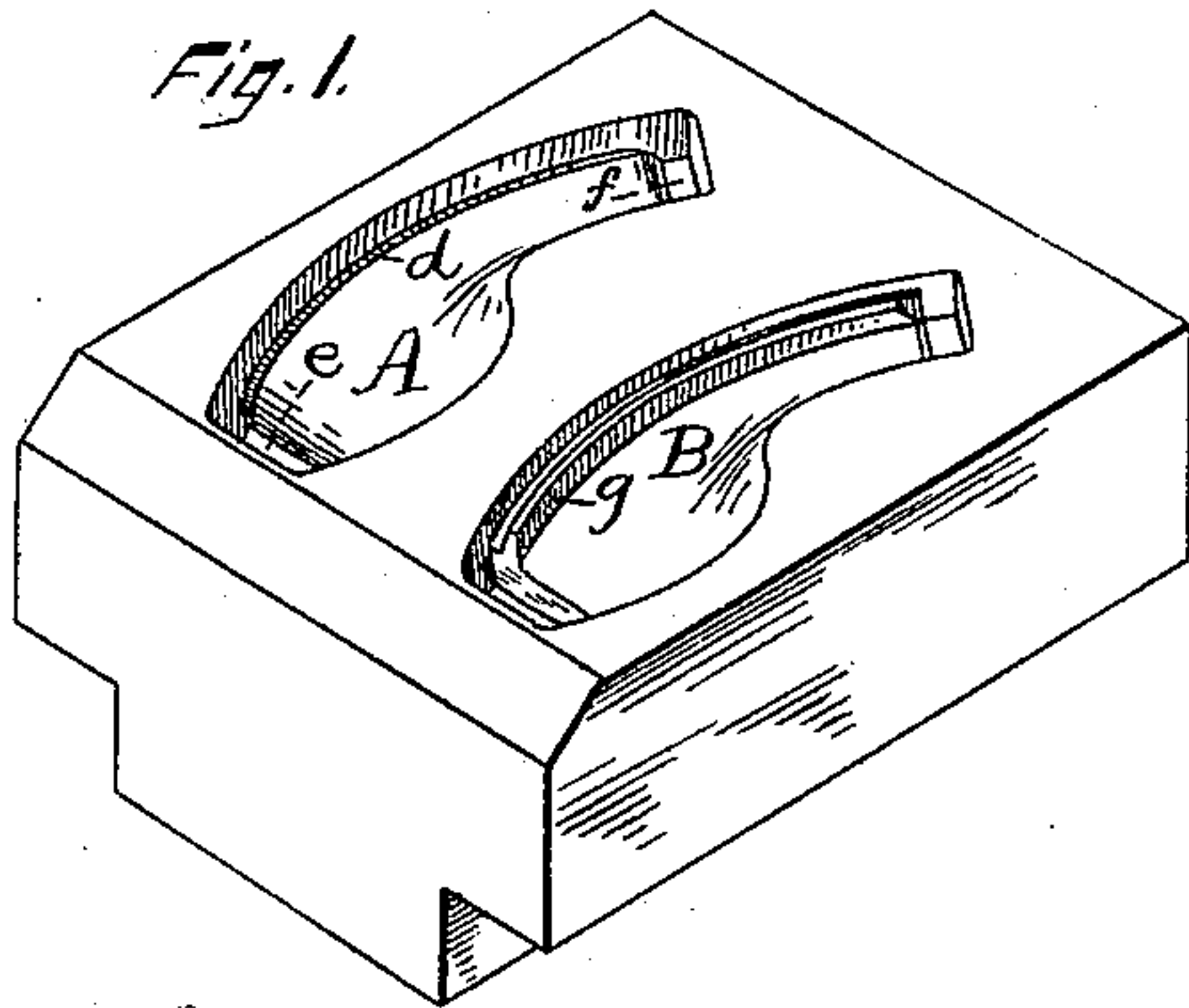


Fig. 2.

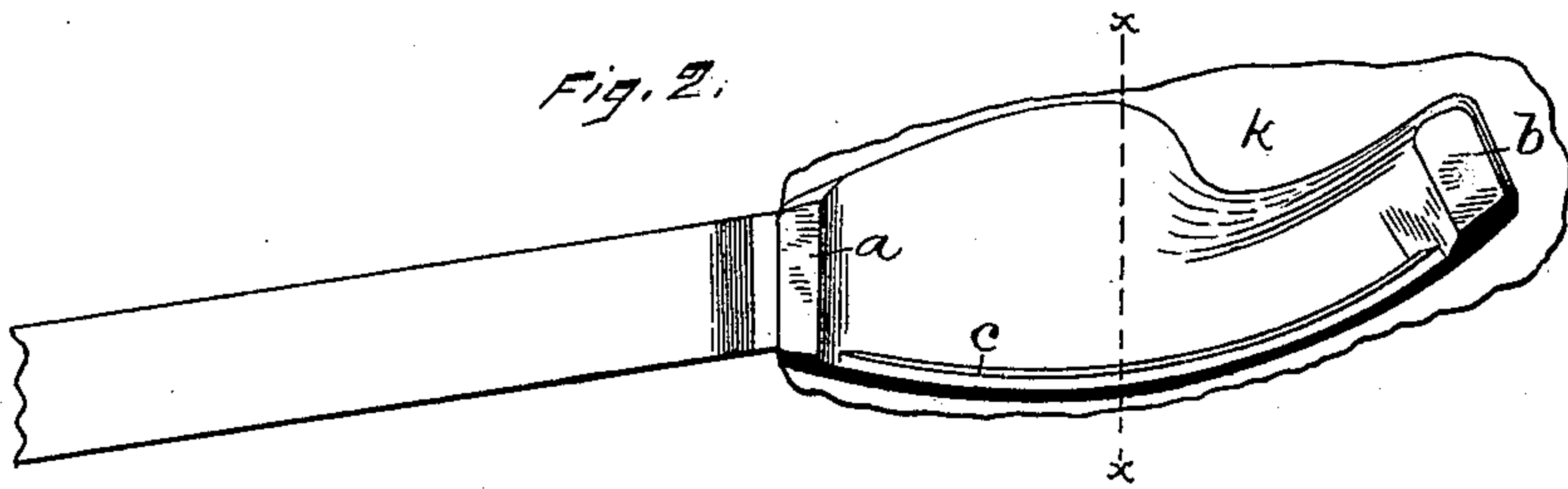


Fig. 3.

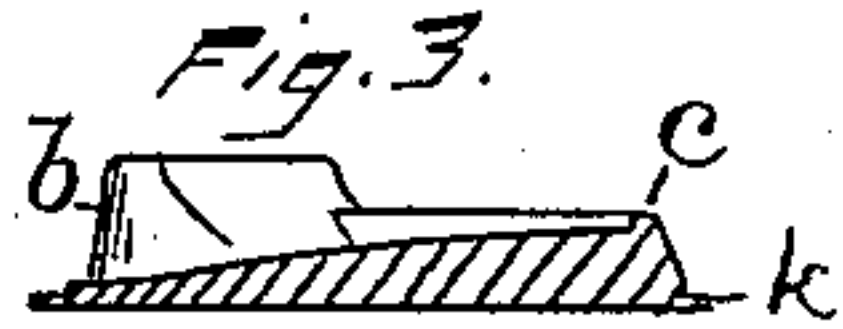


Fig. 4.

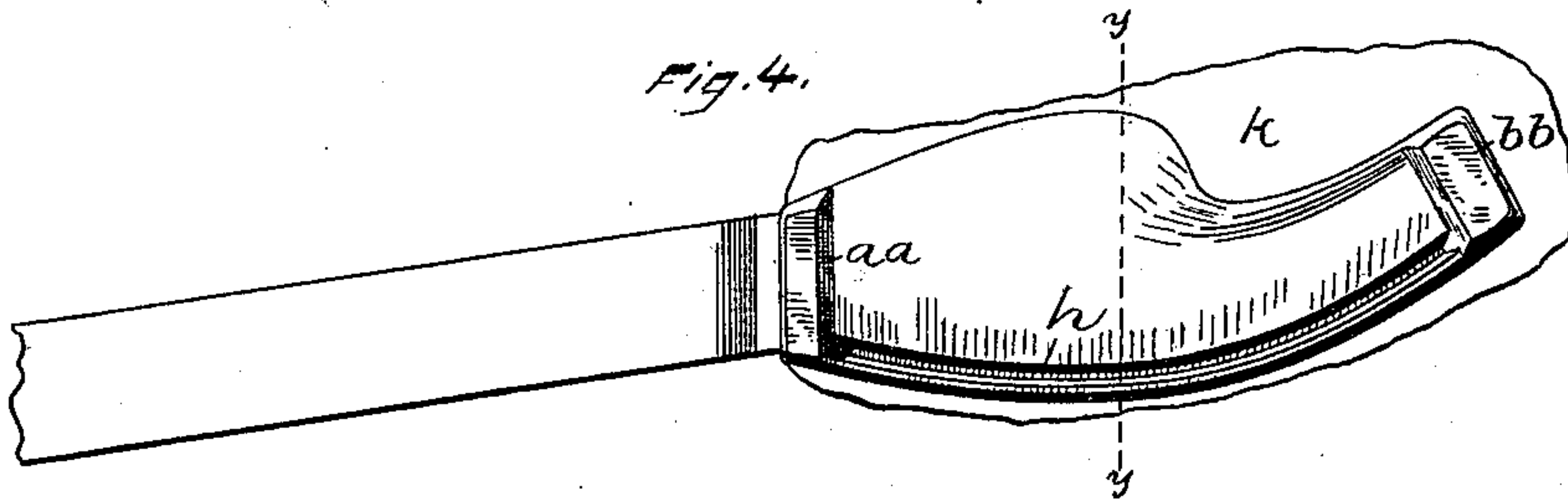
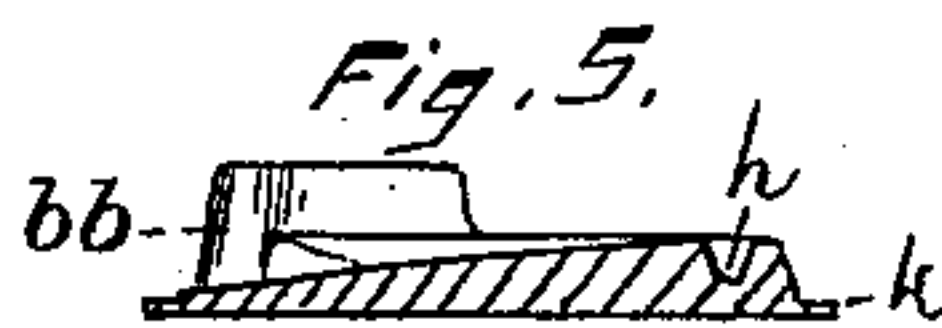


Fig. 5.



Witnesses.

John Edwards Jr.
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By James Shepard. Atty

UNITED STATES PATENT OFFICE.

JOHN DEEBLE, OF SOUTHTON, CONNECTICUT, ASSIGNOR OF ONE-HALF
TO JULIUS B. SAVAGE, OF SAME PLACE.

MANUFACTURE OF OX-SHOES.

SPECIFICATION forming part of Letters Patent No. 336,900, dated March 2, 1886.

Application filed August 24, 1885. Serial No. 175,133. (No model.)

To all whom it may concern:

Be it known that I, JOHN DEEBLE, a citizen of the United States, residing at Southington, in the county of Hartford and State of Connecticut, have invented certain new and useful Improvements in the Manufacture of Ox-Shoes, of which the following is a specification.

My invention relates to improvements in the manufacture of ox-shoes in forging-dies, and the chief object of my invention is to facilitate the forming of the groove or crease for receiving the nail heads.

In the accompanying drawings, Figure 1 is a perspective view of a die-block having two die-recesses for use in forming ox-shoes. Fig. 2 represents a blank as formed on the end of a bar within the first die-recess. Fig. 3 is a transverse section of said blank on line *x x* of Fig. 2. Fig. 4 represents a nearly-completed shoe as formed within the second die-recess, and Fig. 5 is a transverse section of the same on line *y y* of Fig. 4.

I first form a blank of the form shown in Figs. 2 and 3, the same having the general form of an ox-shoe with rudimentary calks *a b* and a rib, *c*, extending along by the convex or outer edge of the shoe, as shown. This rib projects to such an extent that the thickness of the blank, Figs. 2 and 3, at its outer edge is considerably greater than is the thickness of the finished shoe at said outer edge. I prefer to form said blank upon the end of a bar by means of the die-recess A and a plain-faced hammer or drop, the die-recess having a groove, *d*, along one side, and depressions *e f* at the ends, the whole forming a matrix into which said blank will fit.

The first step in my process resides in forcing the metal into substantially the form illustrated in Figs. 2 and 3, and not in the means for so doing. The metal in this form can be finished easier and with less wear of the finishing-die B than can blanks of any of the ordinary forms.

The second die-recess or finishing-die, B, is of ordinary form, and is substantially the same as that shown in my patent of December 16, 1873, No. 145,633, and has depressions for forming the calks *a a* and *b b*, and a rib, *g*, for forming the nail-head-receiving crease *h*. Heretofore it has been found in practice that this rib *g* wears away very fast, or breaks, and to save this die blanks have been struck in a die having no rib, and then struck again in a die having the rib. In other cases the blanking-die has been provided with a rounded rib of less projection than the rib of the finished die, so that the crease was partially formed in the blanking-die.

I have discovered that by making a rib along the outer edge of the blank, instead of a plain surface or a partial groove, the crease in the shoe can be formed better and with less wear of the finishing-die. I strike the blank, Figs. 2 and 3, in the ordinary finishing-die, B, (finishing-die so far as the forging is concerned,) thereby throwing the stock from the form illustrated in Figs. 2 and 3 into that shown in Figs. 4 and 5. The fin *k*, or surplus metal, is then removed by trimming-dies in the ordinary manner.

I claim as my invention—

That improvement in the manufacture of ox-shoes which consists in throwing the stock into the successive forms shown, namely: first, into a blank having the projecting rib *c* on the broad under side extending along by the convex edge of said blank, as shown in Figs. 2 and 3, and, secondly, into the general form of a finished shoe having the nail-head-receiving crease, substantially as described, and for the purpose specified.

JOHN DEEBLE.

Witnesses:

MARCUS H. HOLCOMB,
CHARLES H. POND.