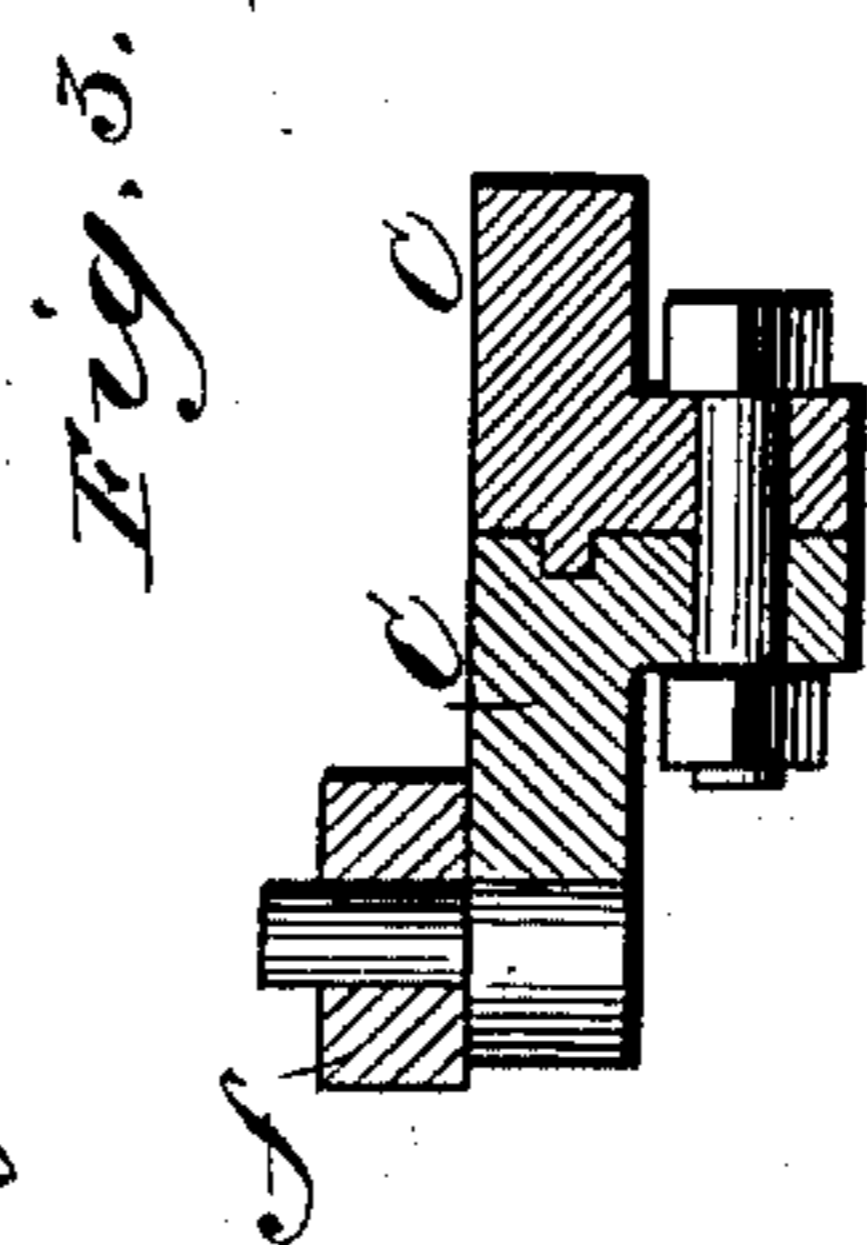
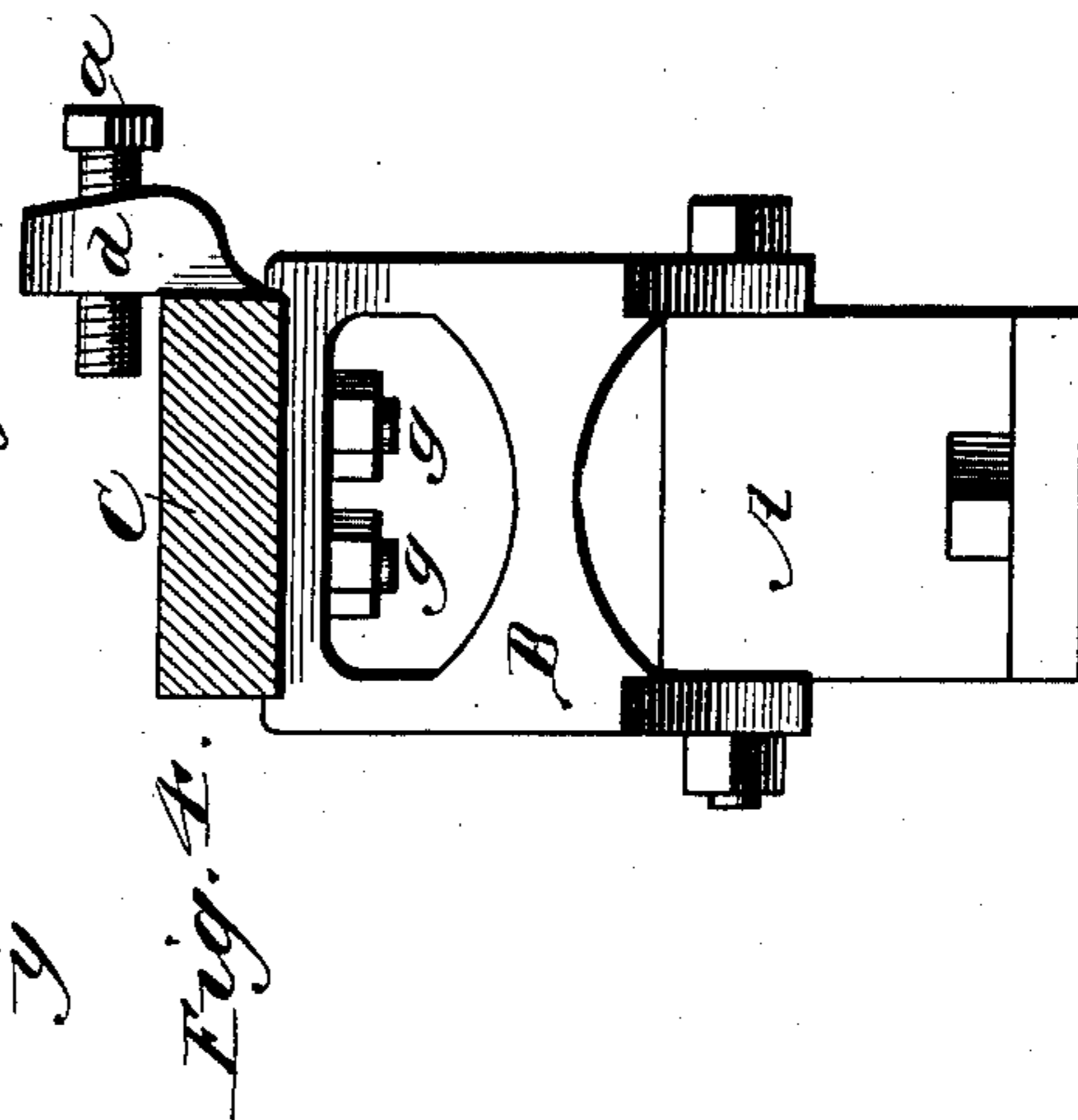
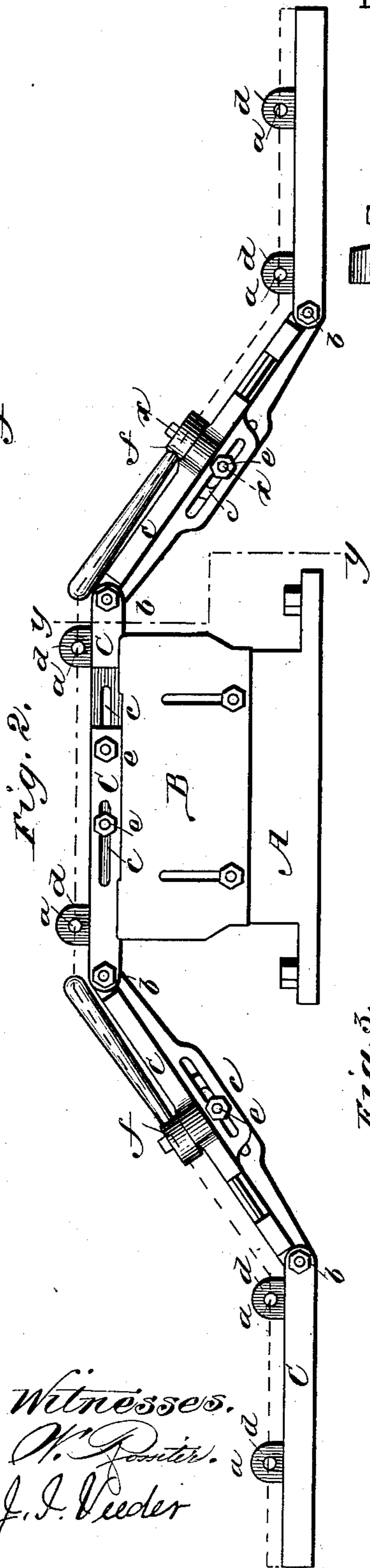
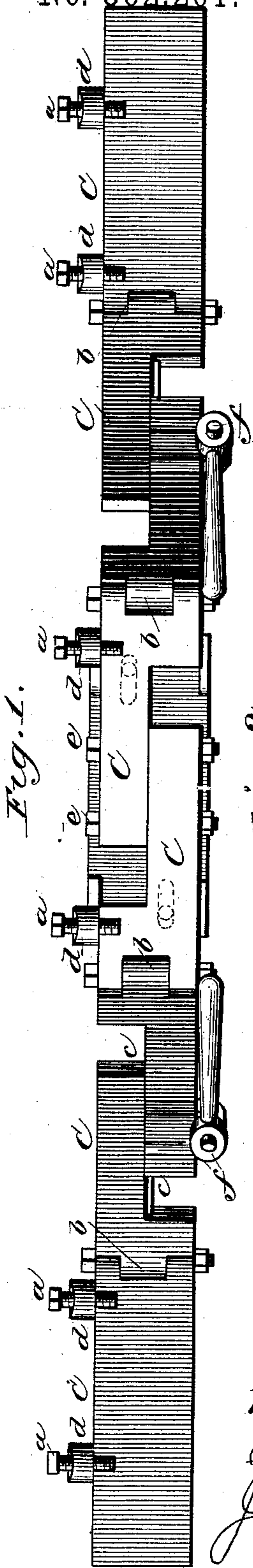


(No Model.)

O. M. CAREY.
ARCH BAR JIG.

No. 362,201.

Patented May 3, 1887.



Witnesses.
W. D. Foster.
J. I. Deeder

Inventor
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UNITED STATES PATENT OFFICE.

ORRIN M. CAREY, OF HEGEWISCH, ILLINOIS, ASSIGNOR TO THE UNITED STATES ROLLING STOCK COMPANY.

ARCH-BAR JIG.

SPECIFICATION forming part of Letters Patent No. 362,201, dated May 3, 1887.

Application filed January 24, 1887. Serial No. 225,344. (No model.)

To all whom it may concern:

Be it known that I, ORRIN M. CAREY, of Hegewisch, in the county of Cook and State of Illinois, have invented a certain new and useful Arch-Bar Jig, of which the following is a specification.

The object of my invention is to provide a support for centering and holding car-truck arch-bars while undergoing the drilling process, which shall be adjustable to the various shapes and sizes occurring in practice; and my invention consists in the combination of parts hereinafter described and claimed.

In the drawings, Figure 1 is a plan, and Fig. 2 a side, view of my improved jig. Fig. 3 is a cross-section through *x x*, Fig. 2; and Fig. 4 is a cross-section through *y y*, Fig. 2.

A, Figs. 2 and 4, is the base, secured in any suitable manner to the table of a drill-press. At its center is bolted the vertically-adjustable support B. Resting upon it is the arch-bar support C. The support C is hinged at *b b b b* and divided and slotted at *c c c c*, and the several sections are clamped together by the several bolts, *e*. The central bolts, *g g*, Fig. 4, serve to secure the two supports B and C together.

From one side of C rises a series of lugs, severally marked *d*. Passing through these are set-screws *a a*. On the opposite side of the

support C are two eccentric cams, *f f*. By means of the set-screws and cams, bars of any width may be held and instantly detached.

The mode of operation is obvious. The height and shape of the jig is made, by the adjustments before described, to conform to those of the arch-bar. It is then secured to the drill-press in the proper position relative to the gang of drills, and is ready for use.

The location of the holes in the arch-bar is determined wholly by the relation of the jig to the drills, as no "laying out" is done nor templet used; and for this reason it is important that the support for the arch-bar should correspond in shape thereto, so that the arch-bar may be accurately centered.

I claim—

1. The arch-bar jig consisting of the base A, support B, and arch-bar holder C, the latter being hinged and slotted, substantially as described.

2. The arch-bar jig consisting of the base A, support B, and arch-bar holder C, the latter being hinged and slotted and having eccentric clamps upon one edge opposed to set screws upon the other, all substantially as described.

ORRIN M. CAREY.

Witnesses:

J. L. STAGG,
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