

(No Model.)

E. MERRITT, Dec'd.

E. CROCKER, C. W. SUMNER & C. D. NASH, Administrators.

MANUFACTURE OF NAIL DIES FOR HEELING MACHINES.

No. 388,535.

Patented Aug. 28, 1888.

Fig: 1.

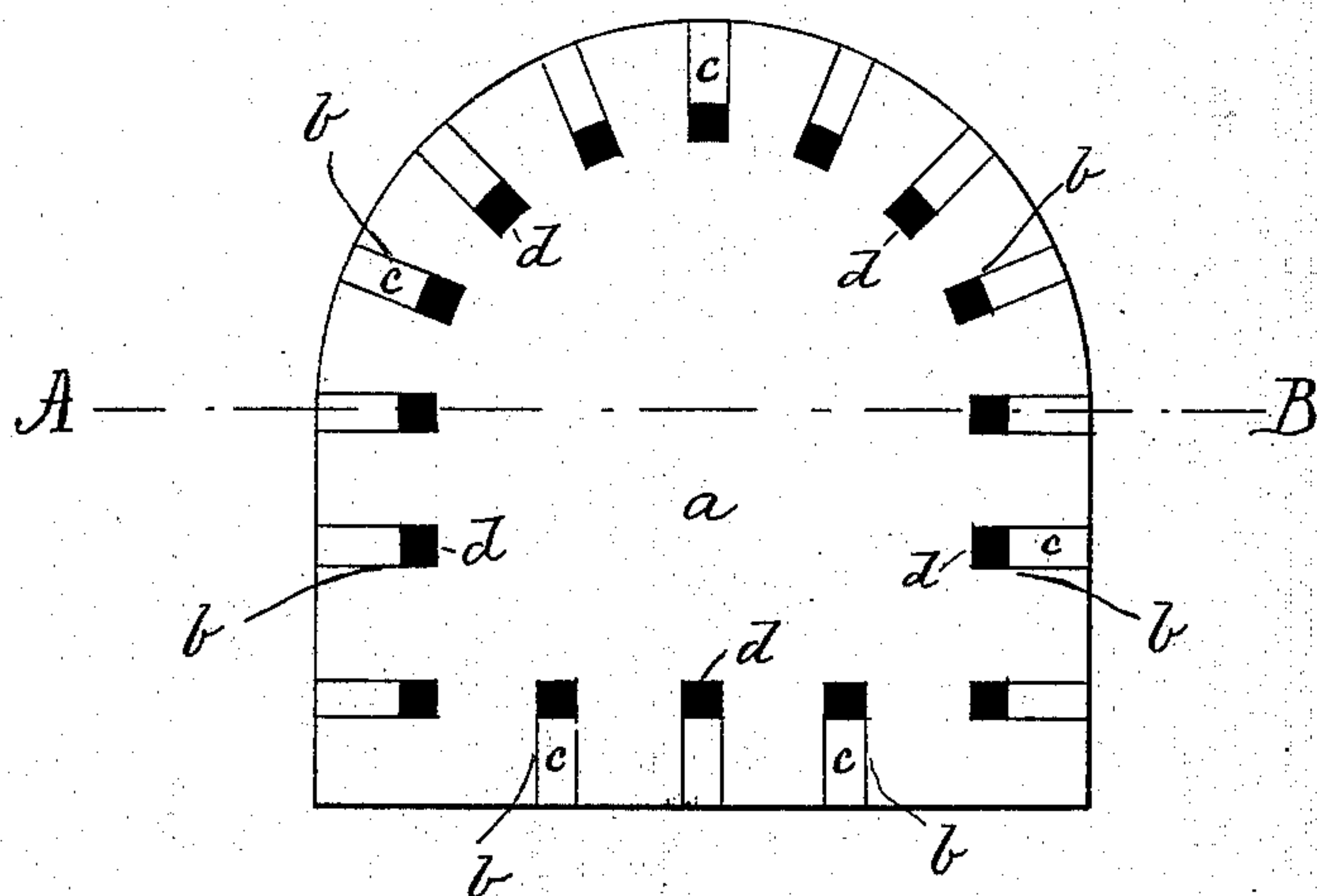
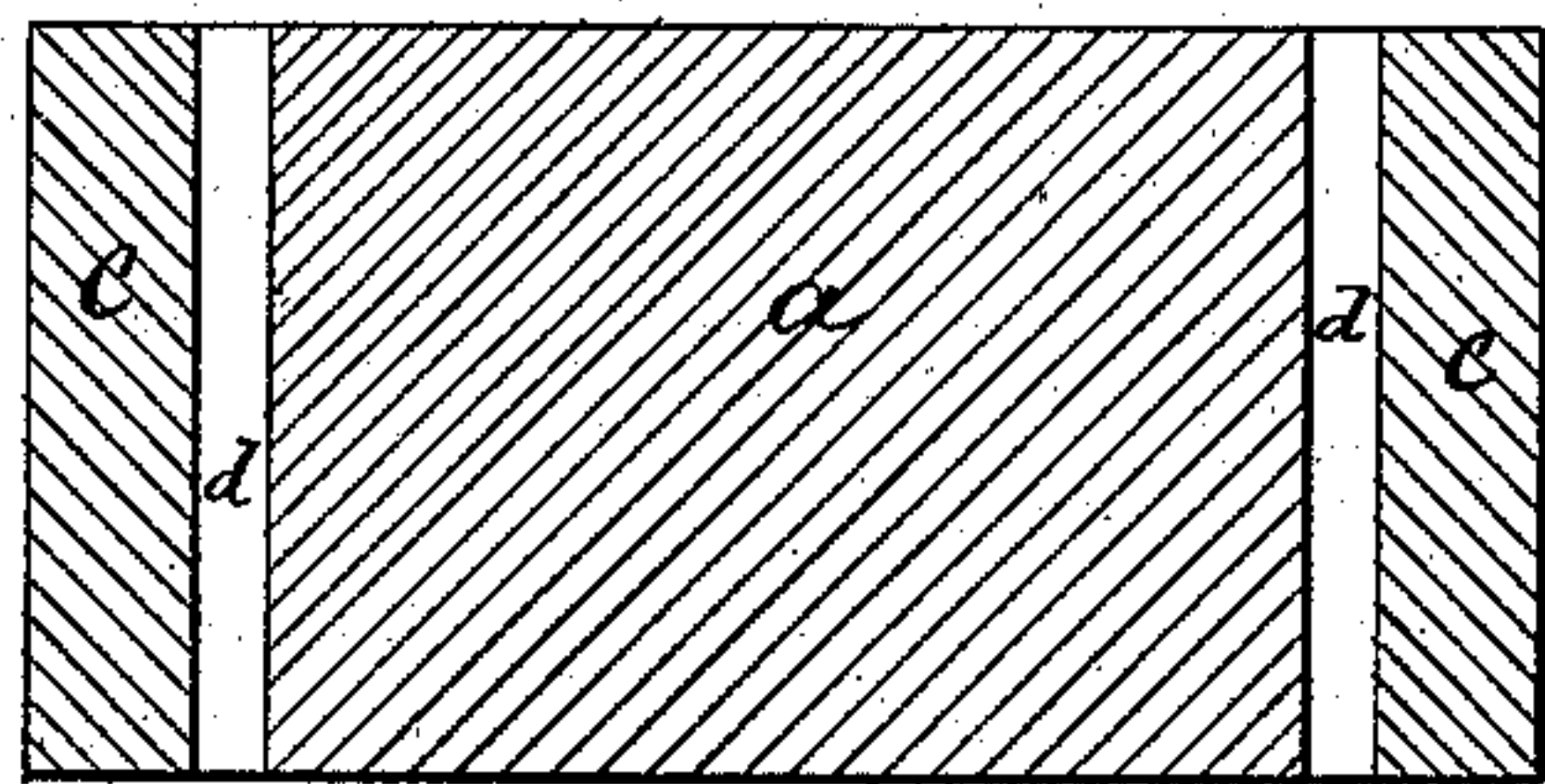


Fig: 2.



Witnesses:  
Harry W. Robinson.  
Henry Chadbourne

Inventor:  
Edward Merritt.  
by Alban Andrieu  
att. for administrators de bonis moribus of E. Merritt



# UNITED STATES PATENT OFFICE.

EDWARD CROCKER AND CHARLES W. SUMNER, OF BROCKTON, AND CHARLES D. NASH, OF WHITMAN, MASSACHUSETTS, (ADMINISTRATORS OF EDWARD MERRITT, DECEASED,) ASSIGNORS TO THE AMERICAN HEELING MACHINE COMPANY, OF MAINE.

## MANUFACTURE OF NAIL-DIES FOR HEELING-MACHINES.

SPECIFICATION forming part of Letters Patent No. 388,535, dated August 28, 1888.

Application filed May 21, 1888. Serial No. 274,533. (No model.)

*To all whom it may concern:*

Be it known that EDWARD MERRITT, deceased, late a citizen of the United States, and a resident of Brockton, in the county of Plymouth and State of Massachusetts, did invent certain new and useful Improvements in Nail-Dies for Heeling-Machines; and we do hereby declare that the same is fully described in the following specification and illustrated in the accompanying drawings.

This invention relates to improvements in making perforated nail-dies for heeling-machines, and it is carried out as follows, reference being had to the accompanying drawings, wherein—

Figure 1 represents a plan view of the improved nail-die, and Fig. 2 represents a cross-section on the line A B, shown in Fig. 1.

Similar letters refer to similar parts wherever they occur on the different parts of the drawings.

Heretofore in making square or rectangular perforations in nail-dies for heeling-machines the holes have first been drilled cylindrical and afterward made square or rectangular by means of files or other suitable tools. This manner of making square or rectangular perforations in metal nail-dies is very costly and laborious, and to cheapen and simplify the making of such nail-dies this invention is as follows:

*a* is the metal die, of suitable size, shape, and thickness. From the outer periphery of such die is cut, by means of a saw, milling-tool, or

other suitable tool or tools, a series of grooves or slits, *b b b*, and said slits or grooves are afterward partially filled up by means of metal pieces *c c c*, which are firmly secured to the slitted or grooved portions of the die by means of hard or soft solder, or other suitable devices, leaving the square or rectangular perforations *d d d*. (Shown in black in Fig. 1 and in section in Fig. 2.) In this manner one is able to make a die with square or rectangular or polygonal perforations without the costly and laborious method of drilling cylindrical holes and subsequent finishing.

The invention claimed is—

The herein-described manner of making perforated nail-dies, consisting in first slitting or grooving the outer periphery of the dies and afterward partially filling up such slits or grooves by the metal pieces *c c c*, and thereby producing the polygonal perforations *d d d*, or equivalent manner, as herein described.

In testimony whereof we have hereunto officially affixed our names, in the presence of two subscribing witnesses, on this 16th day of May, A. D. 1888.

EDWARD CROCKER,  
CHARLES W. SUMNER,  
CHARLES D. NASH,

*Administrators de bonis non of the estate of Edward Merritt, deceased.*

Witnesses:

HERBERT H. CHASE,  
LUCIUS LEACH.