

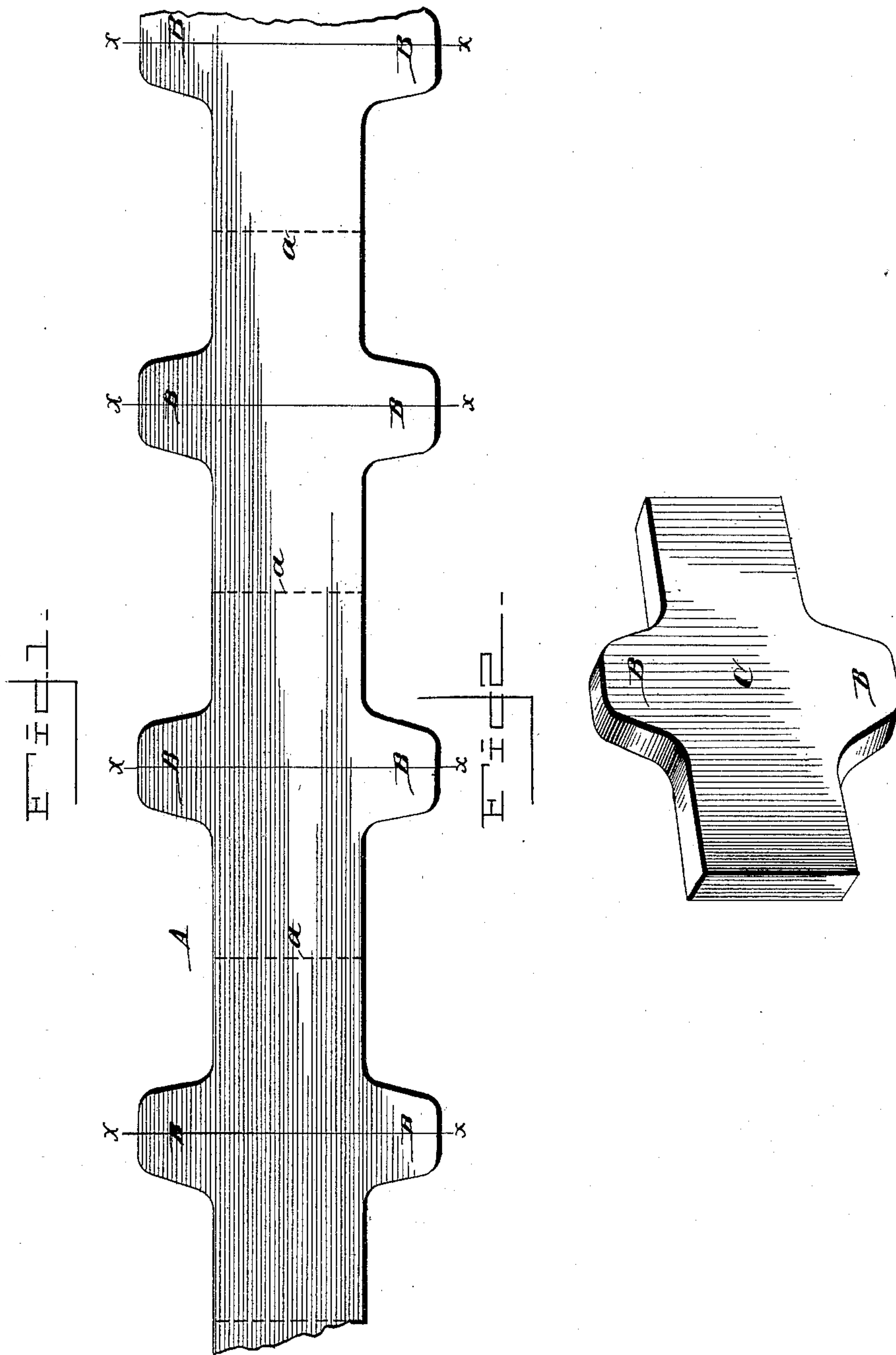
(No Model.)

J. J. JOHNSTON.

BAR FOR THE MANUFACTURE OF SHOVEL BLANKS.

No. 405,415.

Patented June 18, 1889.



WITNESSES

Walter H. Rumphrey.
Geo. G. P. Hooper.

INVENTOR

James J. Johnston
By Johnston, Reinhold & Dye
Attorneys

UNITED STATES PATENT OFFICE.

JAMES J. JOHNSTON, OF COLUMBIANA, OHIO, ASSIGNOR TO HENRY M. MYERS, OF BEAVER FALLS, PENNSYLVANIA.

BAR FOR THE MANUFACTURE OF SHOVEL-BLANKS.

SPECIFICATION forming part of Letters Patent No. 405,415, dated June 18, 1889.

Application filed April 4, 1889. Serial No. 305,919. (No model.)

To all whom it may concern:

Be it known that I, JAMES J. JOHNSTON, a citizen of the United States, residing at Columbiana, in the county of Columbiana and State of Ohio, have invented certain new and useful Improvements in Bars for the Manufacture of Shovel-Blanks; and I do hereby declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it appertains to make and use the same.

My invention relates to the art of making shovels, and has for its object the construction of a bar as a new article of manufacture for the production of double shovel-blanks.

The invention will be hereinafter described, and particularly pointed out in the claim.

In the accompanying drawings, which form part of this specification, Figure 1 represents a plan view of my improved bar, and Fig. 2 a perspective view of a blank severed from the bar.

Reference being had to the drawings and the letters thereon, A indicates a bar of iron or steel having projections or tangs B B on the edges thereof directly opposite each other for forming the handle-straps of a shovel, spade, or scoop when properly rolled or plated out. The distance between the centers (or line x) of the projections B B is about equal to the width of a finished shovel, spade, or scoop, and the bar is severed transversely midway between the projections, as on the

dotted lines $a a$, to form blanks C for the manufacture of double shovel-blanks. 35

The bar may be produced by rolling or in any other suitable manner, and blanks after having been severed from the bar are rolled in the direction of the projections B B to form handle-straps. 40

In the manufacture of double blanks with single handle-straps for use in making the "Antrim" shovel the tangs are not split; but in the manufacture of shovels with double handle-straps the projections are split. In reducing the blank between rolls the displacement of the metal is always in the line of the angle of force applied, and, as a consequence, the metal of the projections will be sufficient to form a handle strap or straps. 50

Having thus fully described my invention, what I claim, is—

As an article of manufacture, a bar for making double shovel-blanks, said bar having projections on its edges opposite each other, and the distance between the centers or lines x of said projections being about equal to the width of a shovel-blade, substantially as described. 55

In testimony whereof I affix my signature in presence of two witnesses. 60

JAMES J. JOHNSTON.

Witnesses:

S. A. TERRY,
D. C. REINOHL.