(No Model.)

G. H. TUCKER.

DIE FOR MAKING LATHING.

No. 435,986. Patented Sept. 9, 1890.

Fig. 1.

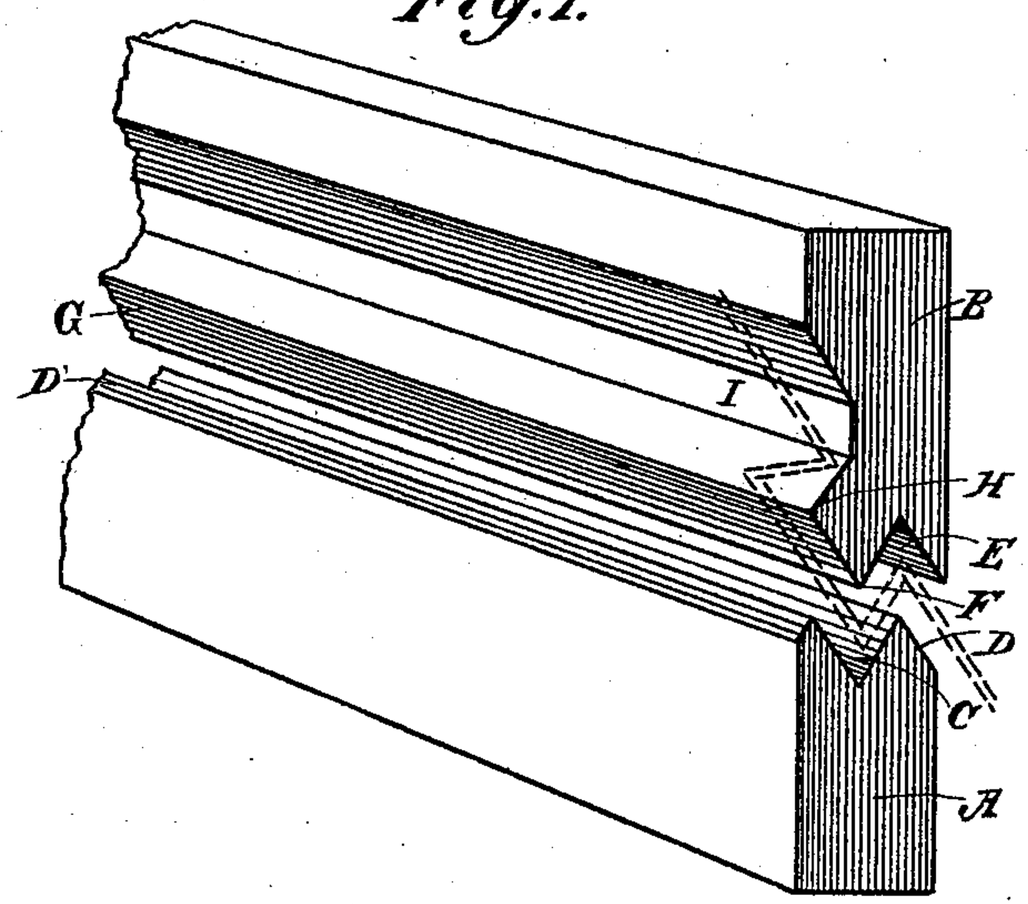
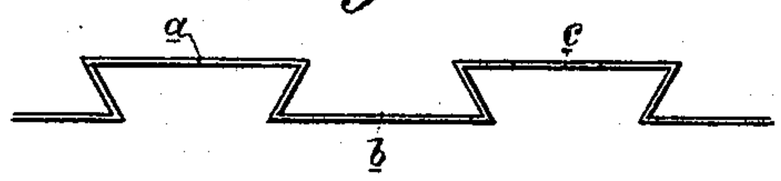


Fig. 2.



Witnesses;
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UNITED STATES PATENT OFFICE.

GEORGE H. TUCKER, OF SAN FRANCISCO, CALIFORNIA.

DIE FOR MAKING LATHING.

SPECIFICATION forming part of Letters Patent No. 435,986, dated September 9, 1890.

Application filed April 29, 1890. Serial No. 349,939. (No model.)

To all whom it may concern:

Be it known that I, GEORGE H. TUCKER, a citizen of the United States, residing in the city and county of San Francisco, State of California, have invented an Improvement in Dies for Metallic Lathing; and I hereby declare the following to be a full, clear, and exact description of the same.

My invention relates to a die which is especially adapted for the manufacture of lathing made of metal sheets, which sheets are folded so as to form alternate elevations and depressions, with acute angles and correspondingly-inclined sides to said depressions, for the purpose of forming a bond to hold the mortar in place.

My invention consists of a peculiarly-shaped metal die adapted to bend these sheets, of which the laths are formed, into their proper shape.

Referring to the accompanying drawings for a more complete explanation of my invention, Figure 1 represents a perspective view of my dies. Fig. 2 shows the form into which the sheet metal is bent.

A is the lower part of the die, which is fixed to a base or support in any suitable manner so as to remain stationary. This die is made of such a length as will be sufficient to bend the desired length of sheet, and the upper die B is made of the same length and is fixed into a machine or apparatus by which it is given a reciprocating motion, so as to bring it into contact with the lower die A. The lower die has a central V-shaped groove or channel C made in it, and from the upper outside edges of this channel the sides of the die are chamfered or beveled off, as shown at D, so as to form outwardly-inclined faces, as shown. The upper die is made with a reversed V-shaped channel, as shown at E, this channel fitting over the ridge formed between the meeting faces C and D of the lower die when the two are brought together. From the apex F of the V-shaped channel E in the upper die this die is beveled or chamfered away on the outer face, so as to form the inclined face G. Above the outer edge or angle H, formed by the incline G, the sides of the die are formed with a concaved or depressed channel, as shown at I.

The operation of this die will then be as follows: The sheets of metal having a length not greater than the length of the dies are first placed between the dies, and the upper die, having the reciprocating motion, as previously described, will be brought into contact with the sheet and will press it between the faces C D of the lower die and the faces formed by the channel E and the face G of the upper die. This forms two bends in the sheet of metal extending from *a* to *b* in Fig. 2. By reversing the sheet of metal the raised portion at *a* is received into the depression or channel I in the upper die, which allows the sheet to be brought between the dies in such form that the portion between *b* and *c* is bent in the manner first described, so as to complete one of the channels with a portion of the elevations on each side of it. The remainder of the sheet is bent in a similar manner until the whole width has been formed into the alternate channels and elevations, as shown.

In practice I have found it preferable to form one-half of all the channels holding the sheet in the same position, and by means of gages or marks bringing it successively between the dies until the first portion from *a* to *b* of all the angles upon one side are formed. The sheet is then reversed and introduced between the dies from the opposite side, and all the channels and angles from *b* to *c* are made by passing it through in the opposite direction.

I am aware that dies for bending sheet metal into various shapes have been used, and I do not claim, broadly, such dies; but what I do claim as new, and desire to secure by Letters Patent, is—

1. The fixed or stationary die having the central channel and the exterior inclined faces D D, in combination with the upper die having a central channel and the exterior inclined face G, substantially as herein described.

2. The fixed or stationary die having a central channel C and the outwardly inclined or beveled faces D D, in combination with the movable die having the central channel and the exterior inclined face G and the depression or channel I, formed above the face G and with relation thereto, substantially as herein described.

In witness whereof I have hereunto set my hand.

GEORGE H. TUCKER.

Witnesses:

S. H. NOURSE,

H. C. LEE.