

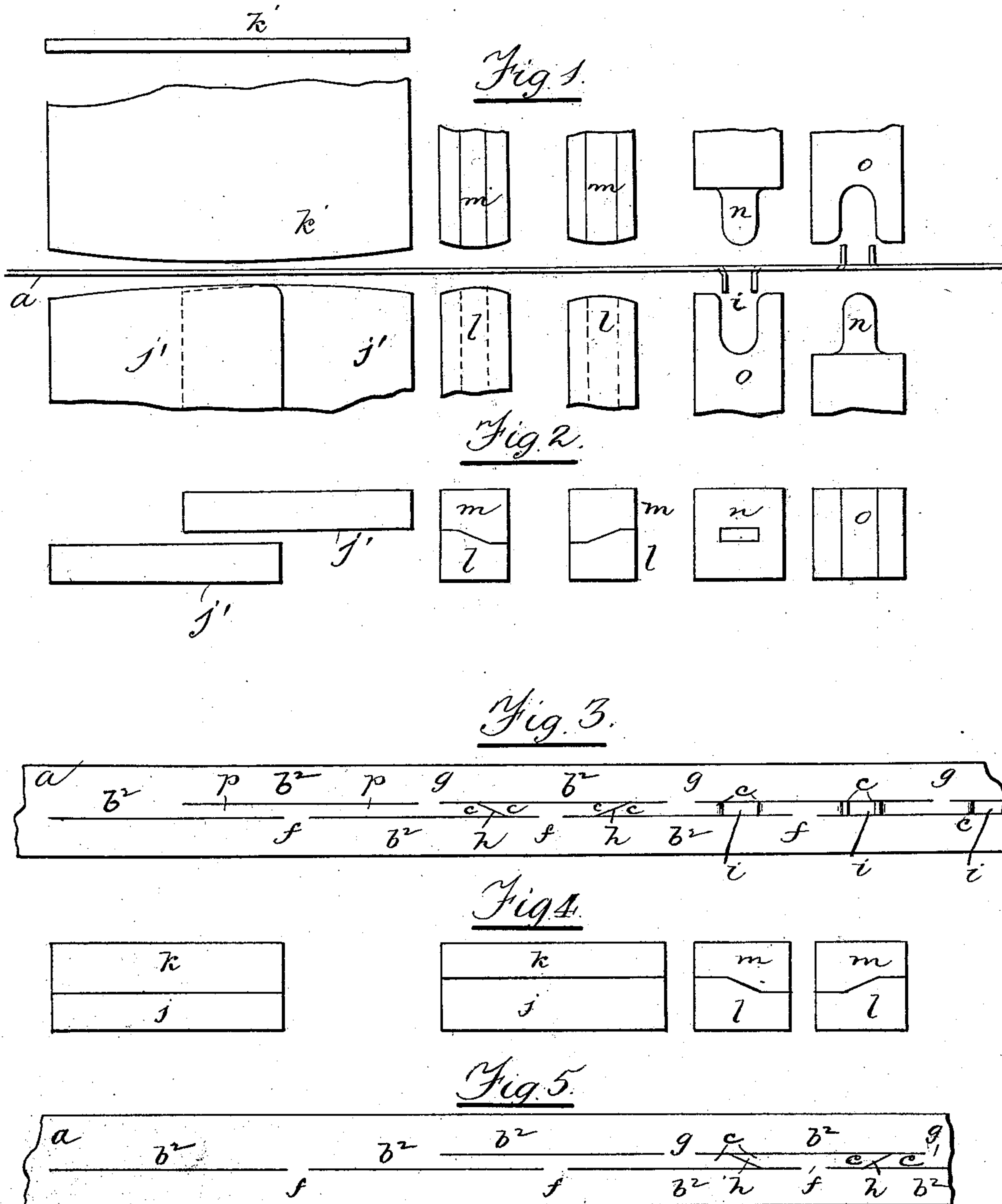
(No Model.)

2 Sheets—Sheet 1.

J. H. TEMPLIN.  
METHOD OF MAKING BARBED FENCING.

No. 507,182.

Patented Oct. 24, 1893.



WITNESSES:

*Wm. A. Rosinbaum*  
*Chas. J. Morgan*

INVENTOR:

*J. H. Templin*  
BY  
*A. P. Hayer*  
ATTORNEY

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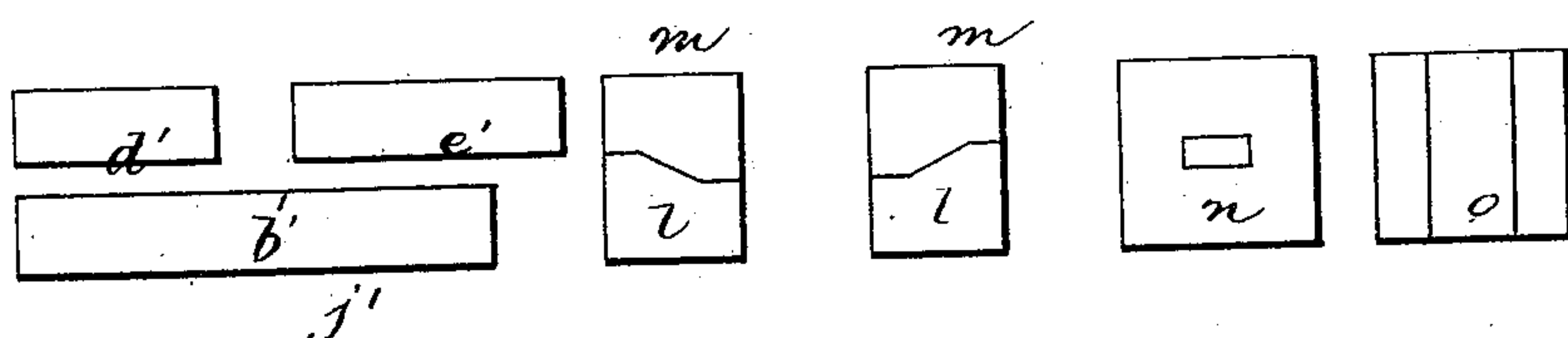


Fig. 7.

Fig. 8.

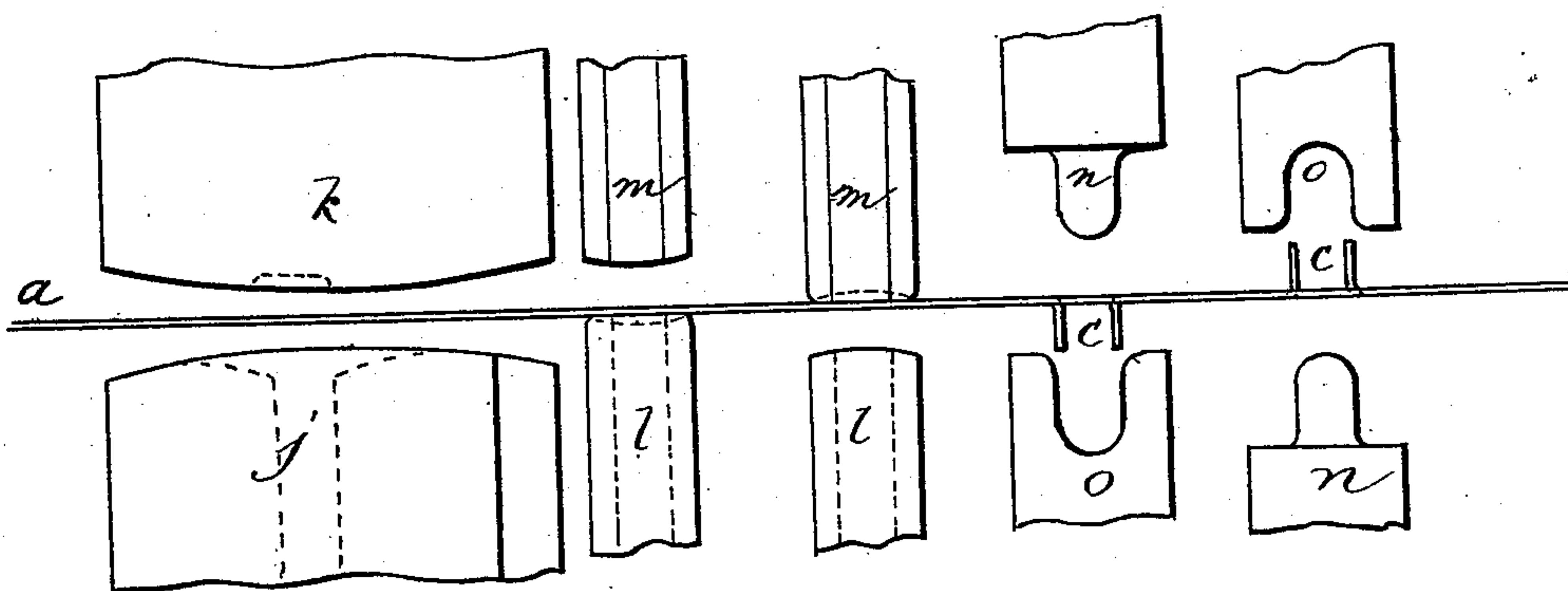
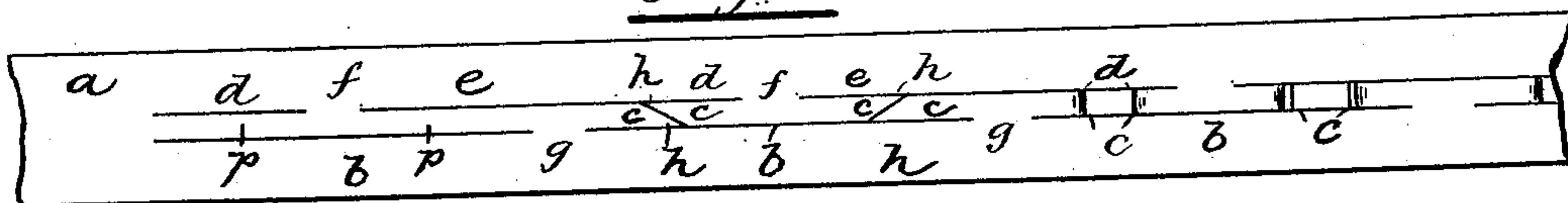


Fig. 6.

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# UNITED STATES PATENT OFFICE.

JOSEPH H. TEMPLIN, OF READING, PENNSYLVANIA, ASSIGNOR, BY MESNE ASSIGNMENTS, TO THOMAS V. ALLIS, OF NEW YORK, N. Y.

## METHOD OF MAKING BARBED FENCING.

SPECIFICATION forming part of Letters Patent No. 507,182, dated October 24, 1893.

Application filed June 8, 1888. Serial No. 276,520. (No specimens.)

*To all whom it may concern:*

Be it known that I, JOSEPH H. TEMPLIN, a citizen of the United States, and a resident of Reading, in the county of Berks and State of Pennsylvania, have invented certain new and useful Improvements in Methods of Making Barbed Fencing, of which the following is a specification.

This improved method for making barbed metallic fencing consists of producing two barbed strips from one double blank strip by first slitting a plain flat blank strip of metal which is equal in width to two barbed strips to be made plus the breadth of the barbs, by two lines of parallel slits side by side and distant apart the width of the barbs, to form bars of which barbs are to be made, and to partly separate the blank; second separating said bars obliquely at the middle to completely separate the blank strip and point the barbs; and third bending the barbs thus formed to project laterally from the strips as hereinafter fully described.

Figure 1 is a side elevation of the dies and face view of the upper slitting die such as may be employed and as I prefer to make them for carrying out this improved method. Fig. 2 represents face views of some of the cutting dies and of one of each pair of the bending dies. Fig. 3 is a diagram of the blank strip showing the action of the dies of Figs. 1 and 2 on it. Fig. 4 represents face views of slitting dies as they may be arranged. Fig. 5 is a diagram showing the action of the slitting dies of Fig. 4. Figs. 6, 7, 8, are side views, face view, and diagram representing other different forms of slitting dies adapted for accomplishing the same results by the same method of operations.

In the most preferable way of carrying out my said new method of producing two barbed strips from a double blank strip, I make two parallel lines of straight overlapping slits  $b^2$  along the middle portion of the blank  $a$ , said lines being distant from each other the width of the barbs to be made, and so advanced in each line and as to the respective lines that uncut webs  $f-g$ , are left between the slits of each line opposite the middle of the slits of the other line, thus forming bars  $p$ , for the

making of the two barbs each, which bars I then cause to be cut apart on the oblique lines  $h$ , which completes the cutting for separating the blank and forming the barbs and also effects the pointing of the barbs which are then bent laterally to the strip as indicated at  $i$ , and this completes the work. The slits  $b^2$  are preferably made simultaneously with a pair of dies  $j'-k'$ , having suitable cutting edges for making such interval slits without unduly distorting the metal at the ends of their slits and the diagonal slits  $h$ , are made by cutters  $l, m$ , of which there are two pairs, cutting each side of the webs  $f$  and  $g$ , and they cut the lines reversely to each other for pointing the barbs of both strips alike relatively to them.

The benders  $n$ , are pointed suitably to punch through the cut blank between the slits, to bend the barbs, and benders  $o$ , are suitably grooved or chambered to form cavities into which the barbs may be so bent. These benders are in two pairs and cause the barbs to project in opposite directions, each pair bending one barb of each strip. They are arranged in suitable connection with the cutters for working with them and in due order of succession on the blank strip.

By another arrangement of dies that may be used, I make one long slit  $b$ , the same as  $b^2$ , and about the length of four barbs  $c$ . Along the strip lengthwise, and parallel with it, in line with each other and similarly distant from the said slit, I make two other slits  $d, e$ , one of which  $d$ , is less, and the other,  $e$ , is a little more than half the length of  $b$ , said slits terminating short of each other opposite the middle of slit  $b$ , so as to leave uncut webs  $f$ , forming the connections of two barbs with one of the completed strips. The slits  $d$ , and  $b$ , terminate coincidently at the rear ends, considering the direction in which the strip feeds along the dies, but the slit  $e$ , overlaps slit  $b$ , in the other direction, so as to reach the rear of the advance or preceding slit  $d$ , and leave no uncut web thereat, although the blank strip feeds along the dies at each operation as much more than the length of the slit  $b$ , as is requisite for leaving the uncut webs  $g$ , between the slits  $b$ , for the connec-



tions of the barbs with the other of the completed strips. After making these slits I cause the bars to be cut apart and bent as above described.

5 The slits *b*, *d*, *e*, are made simultaneously with a pair of dies *j*, having cutting edges *b'* *d'* *e'*; and *k*, having edges same as *k'*, suitably arranged for the purpose and also like dies *j'* and *k'* being of such convex form on  
10 the faces as enables them to make interval slits without unduly distorting the metal at the ends of the slits, and the diagonal slits *h*, are in like manner made by cutters *l*, *m*, of which there are two pairs, one of which cuts  
15 in this case from slit *b*, to slit *d*, and the other from said slit, *b*, to slit *e*, each side of the web *f*, and as before they cut the oblique lines reversely to each other for pointing the barbs of both strips alike relatively to them.

20 The slits *b*<sup>2</sup> may of course be made separately by a separate pair of dies *j*—*k*, for each slit, arranged a suitable distance apart for working independently of and without interference with each other, as represented in  
25 Fig. 4, but for simpler and more compact construction it is important to contrive the dies so that they may be made in one pair.

It will be seen that although the method is very simple four barbs are produced at each  
30 operation of the gang of dies, two on each strip produced from the one blank.

The dies are reserved for a separate application for a patent.

What I claim, and desire to secure by Letters Patent, is—

35 1. The method of producing two barbed strips from one double blank, by making two

lines of straight parallel overlapping slits along the middle of the blank, distant from each other the width of the barbs to be made, 40 and so advanced that uncut webs are left between the slits of each line opposite the middle of the slits of the other line, forming bars for the making of two barbs each, which bars are united at their ends to the two partly 45 separated barb strips respectively by said uncut webs, and then cutting said bars apart obliquely which completes the forming and pointing of the barbs and the separating of the barb strips substantially as described. 50

2. The method of producing two barbed strips from one double blank, by making two lines of straight parallel overlapping slits along the middle of the blank, distant from each other the width of the barbs to be made, 55 and so advanced that uncut webs are left between the slits of each line opposite the middle of the slits of the other line, forming bars for the making of two barbs each, which bars are united at their ends to the two partly 60 separated barb strips respectively by said uncut webs, and then cutting said bars apart obliquely which completes the forming and pointing of the barbs and the separating of the barb strips and then bending the barbs 65 laterally to the strip.

Signed at New York city, in the county and State of New York, this 2d day of May, A. D. 1888.

JOSEPH H. TEMPLIN.

Witnesses:

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GEO. T. JANVRIN.