(No Model.)

J. H. TEMPLIN.

METHOD OF MAKING BARBED FENCING.

No. 507,183. Patented Oct. 24, 1893.

Fig. 1.

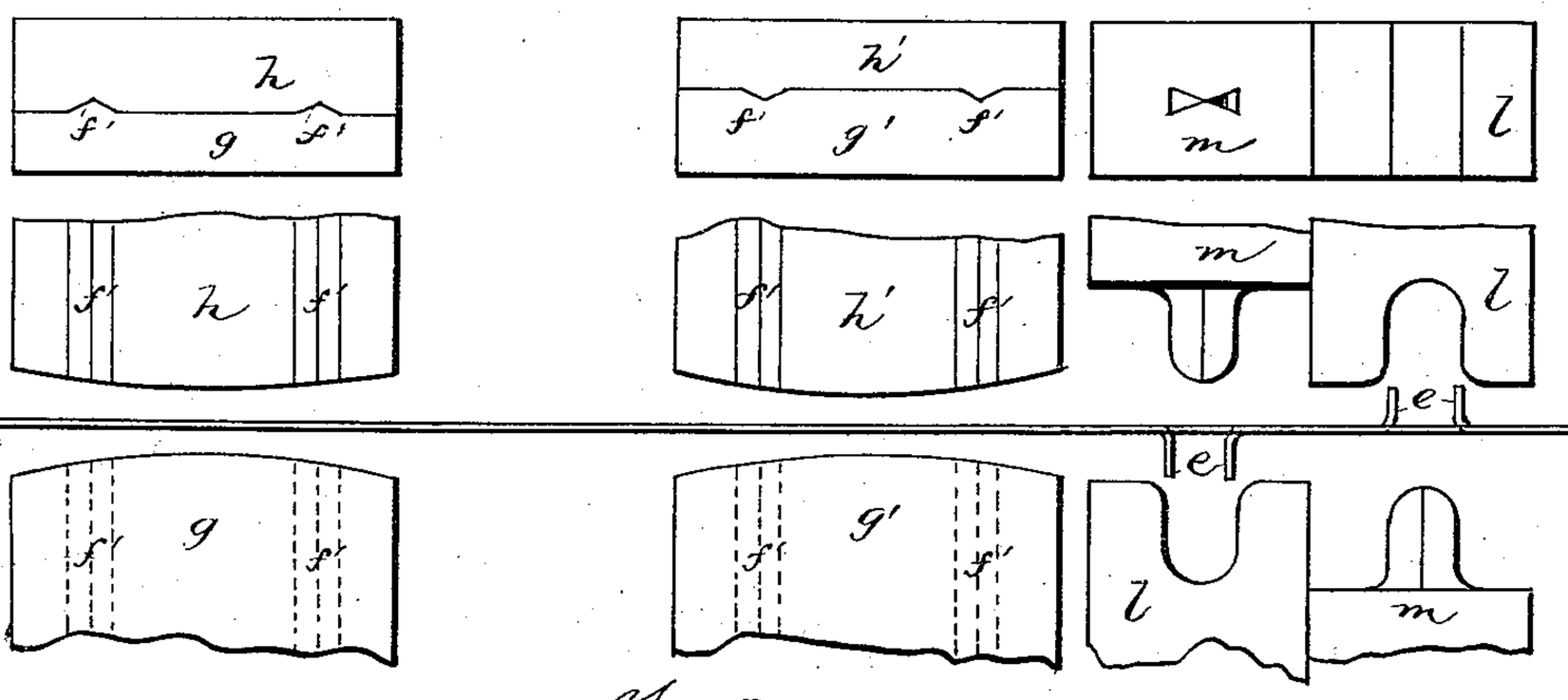

Fig. 2.

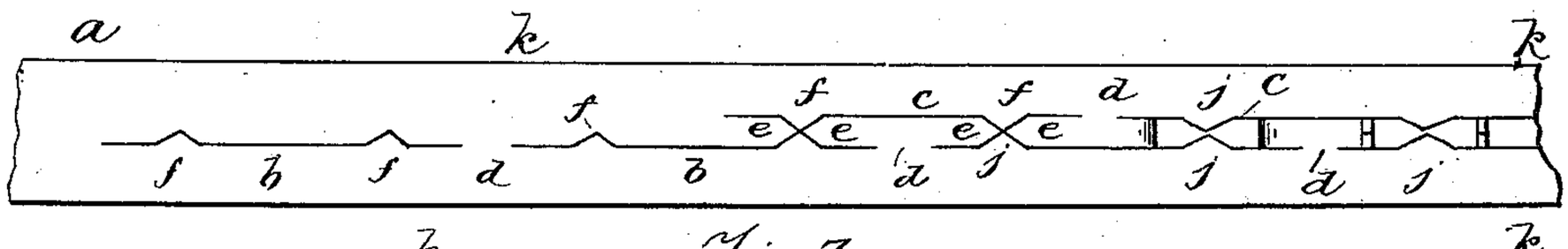

Fig. 3.

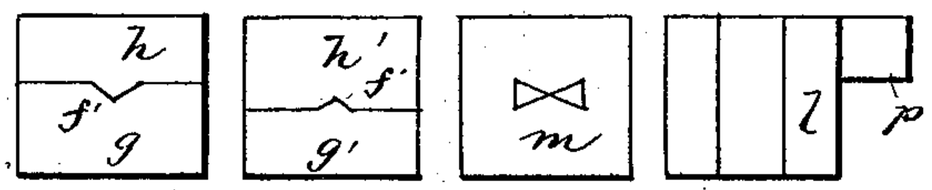

Fig. 4.

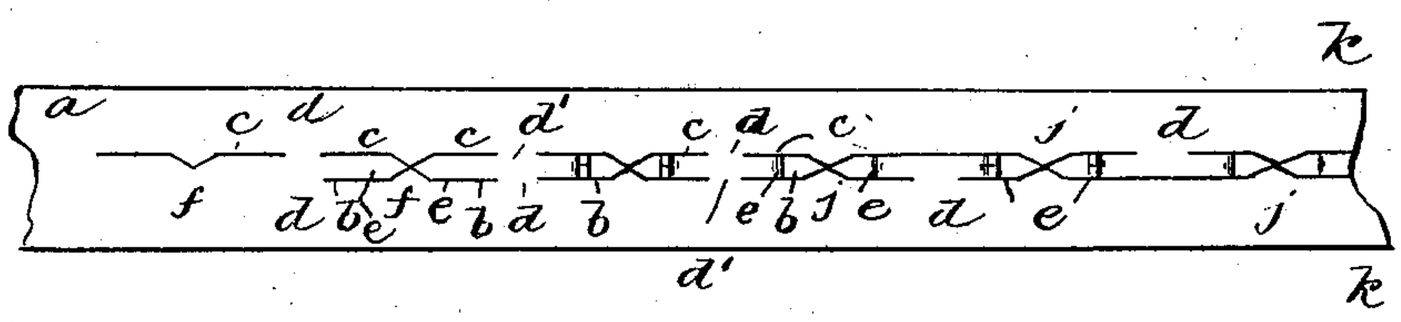

Fig. 5.

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METHOD OF MAKING BARBED FENCING.

SPECIFICATION forming part of Letters Patent No. 507,183, dated October 24, 1893.

Application filed June 8, 1888. Serial No. 276,521. (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 of making barbed fencing consists of producing two barbed strips from one double blank strip by making two parallel lines of slits at intervals apart along the middle portion of a double blank strip so that the intervals of uncut web in one line are opposite the middle of the slits of the other line, which slits are in the main straight but so diverge at two points toward the other line that the slits of the two lines meet thereat and cut apart and point the barbs and effect the separation of the two barb strips. The barbs thus cut are then bent laterally to the strips for effecting the required projection, all in a simple and effective manner as follows, referring to the drawings in which—

Figure 1, represents face views of the slitting and bending dies employed. Fig. 2, is a side elevation of the same with the blank strip between them, and Fig. 3, is a diagram of the blank strip showing the action of the dies on it. Fig. 4, is a face view of a modified form of the slitting dies. Fig. 5, is a diagram of the strip as cut by the dies of Fig. 4.

I take a plain flat strip *a*, as wide as two barb strips to be made besides the width of the barbs to be produced on the strips, and make two lines of slits *b*, *c*, in it at intervals along the middle portion, with intervals of uncut webs *d*, between the slits of each line, said lines of slits being apart from each other a distance equal to the width of the barb *e*, and the slits of each line being advanced relatively to the slits of the other line so that the uncut webs *d*, of each line are alternate with those of the other, and midway along the slits thereof. Each slit which is otherwise straight is at two points *f*, divergent in the direction of the other line of slits and to the extent of half the distance between them. One line of slits as *b*, is cut in advance of the other line by a pair of dies as *g*, *h*, having corresponding divergent portions *f'* of the cutting edges and the other line by similar dies as *g'*, *h'*, which pairs of dies are located the distance of about half the length of a feed movement of the strip apart along the feed way, so that when the slits of the second line are made their divergent points match with each one of the similar points of two slits of the other line, and thus separate the barbs along the edge from the strips, except where they remain connected by the uncut webs *d*, and effect the lateral or transverse cutting by which the barbs are cut and pointed at the ends and the separation of the barbed strips *k*, is completed, at the same time making center points, that is, beveled alike each way. This leaves slight points *j*, on the edges of the barb strips *k*, that may be trimmed off with suitable dies, or not, as preferred. After being thus formed the barbs are bent laterally for the required projection, by suitable bending dies, *l*, *m*, of which it is preferred to employ two pairs to bend the barbs alternately in opposite directions and so that each pair bending two barbs at each operation, the two will, together, bend the four which result from each operation of the slitting dies, simultaneously with the cutting of a like number successively. These long dies (Figs. 1 and 2) are preferred, for the greater amount of work they are capable of in a given time but dies of a little less than half the length of these may be used as in Fig. 4, for the same method of cutting the barbs, together with web cutters *p*, *q*, to be used with them, as, besides webs *d*, they leave uncut webs *d'*, that have to be subsequently separated, and with similar benders, but in this case the benders will only operate with each alternate operation of the cutters, as only two barbs are cut at each operation; one pair of benders would be sufficient except that it is desired to bend the barbs alternately in opposite directions. In this arrangement the two pairs of the slitting dies will be arranged the distance of one web *d*, apart.

The uncut webs *d'* between the slits are to be cut apart alternately in the different lines of the slits.

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

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

1. The method of producing two barbed strips from a double blank which consists of making two parallel lines of slits at intervals along the middle portion of the blank which slits are divergent laterally at certain points cutting through from line to line of the slits to cut apart and point the barbs, and completing the separation of the two strips along the opposite sides of the uncut webs alternately substantially as described.

2. The method of producing two barbed strips from a double blank, which consists of making two parallel lines of slits at intervals along the middle portion of the blanks whereof the intervening uncut webs of one line register with the middle of the slits of the other line, which slits are divergent laterally at certain points cutting through from line to line of the slits, to cut apart and point the barbs and complete the separation of the strips, substantially as described.

3. The method of producing two barbed strips having laterally projecting barbs, from a double blank strip which consists of making two parallel lines of slits at intervals along the middle portion of the blank, which slits are divergent laterally at certain points cutting through from line to line of the slits, to cut apart and point the barbs, and complete the separation of the strips, and bending the barbs laterally to the strips, substantially as described.

4. The method of producing two barbed strips from a double blank strip which consists of making two parallel lines of coincident slits at intervals along the middle portion of the blank, which slits are divergent laterally at the middle cutting through from line to line of the slits, to cut apart and point the barbs and partly separate the barb strips, and separating the uncut webs between the slits alternately along the respective slits, substantially as described.

5. The method of producing two barbed strips from a double blank having laterally projecting barbs, which consists of making two parallel lines of coincident slits at intervals along the middle portion of the blank, which slits are divergent laterally at the middle cutting through from line to line of the slits, to cut apart and point the barbs and partly separate the barb strips; bending the barbs laterally to the strip, and finally separating the uncut webs between the slits alternately along the respective lines of slits, substantially as described.

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:
W. J. MORGAN,
GEO. T. JANVRIN.