(No Model.)

J. H. TEMPLIN.

METHOD OF MAKING BARBED FENCING.

No. 507,185. Patented Oct. 24, 1893.

Fig. 1.

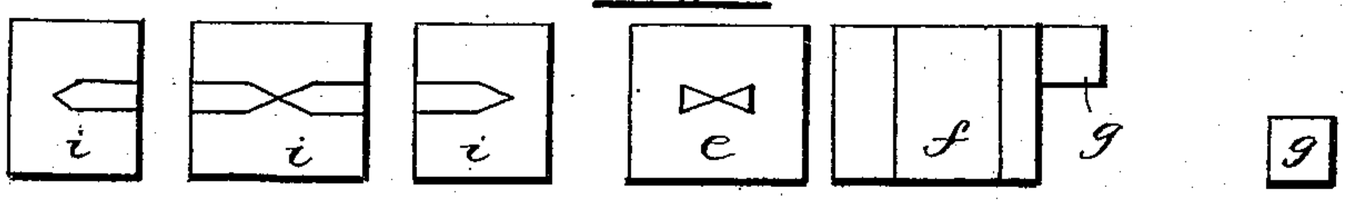

Fig. 2.

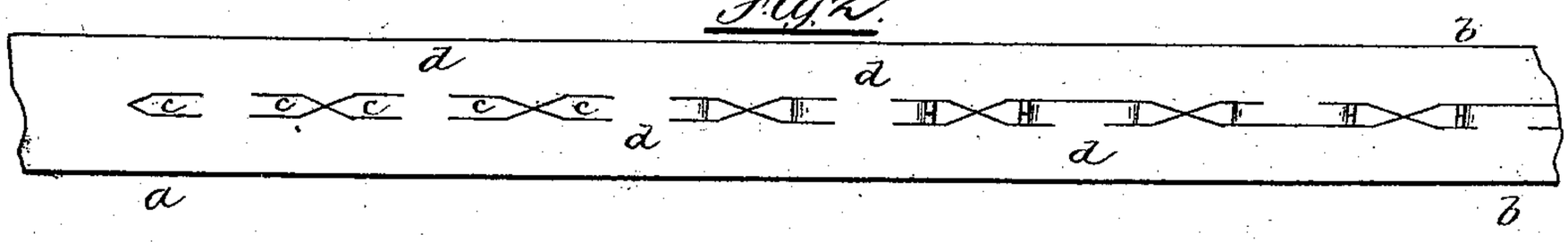

Fig. 3.

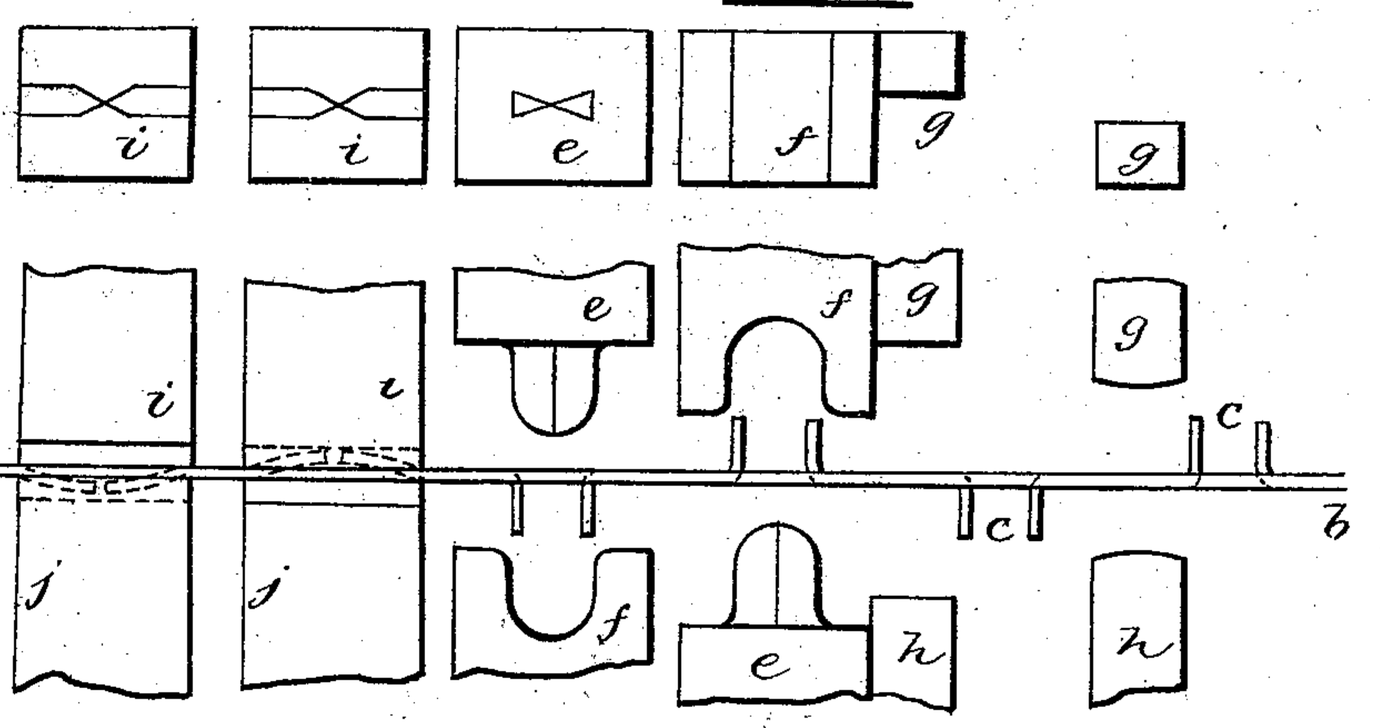

Fig. 5.

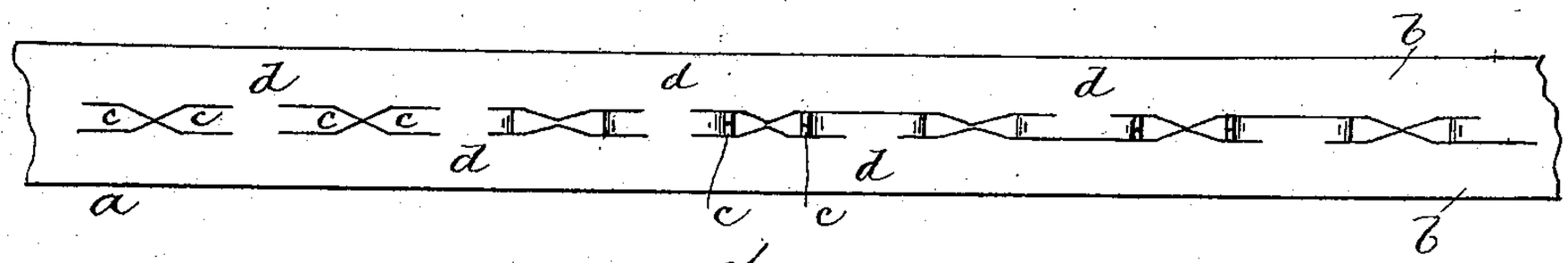

Fig. 4.

WITNESSES:

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METHOD OF MAKING BARBED FENCING.

SPECIFICATION forming part of Letters Patent No. 507,185, dated October 24, 1893.

Application filed August 13, 1888. Serial No. 282,552. (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 metallic fencing consists of producing two barbed strips from one double blank strip by first punching pointed barbs at intervals along the middle of the double blank strip having retaining connection at the base with the strip, bending said points into suitable lateral projections, and separating the uncut webs between the barbs, so as to divide the barbs so made alike between the two strips thus produced out of the blank.

Referring to the drawings: Figure 1, represents face views of one arrangement of dies that may be employed to carry out my invention. Fig. 2, is a diagram of the blank strip showing the action of the dies on it. Fig. 3, represents face views of other or modified forms of dies that may be employed. Fig. 4, is a diagram of the strip showing the action of the dies of Fig. 3, and Fig. 5 is a side elevation of dies such as represented in Fig. 3, with the blank strip between them.

In the blank *a*, which is a plain flat strip of metal of suitable width for two completed barb strips *b*, I punch pointed barbs *c* at intervals along the middle portion of the blank strip *a*, so that they have retaining connection at their base with the strip by intervening uncut webs *d*, left between each two barbs, and also so that the punching of the barbs separates the rest of the blank between said webs into two parts, the points of said each two barbs being cut from close proximity in the blank, but the bases being distant from the next two the length of an uncut web *d*, and the edges of the barbs are preferably parallel except at the points. After thus cutting the barbs I bend them laterally to the strip for the required projection therefrom by any approved benders as *e*, *f*, and then separate the remaining uncut webs *d*, by cutters as *g*, *h*, alternately in the lines of the different edges of the barbs, so that the making of two strips is completed and the barbs are equally divided between them, two together alternately on each strip, and the barbs of each couple are bent in opposite directions.

To cut the barbs I prefer to employ suitable punchers *i*, with corresponding counterparts *j*, adapted to cut parallel edges and center pointed barbs as shown in due succession, preferring to employ four in a gate for cutting four barbs at each operation, which punches may either be arranged in the order of Fig. 1, or of Fig. 3 as preferred; the former being a contrivance of two punches cutting points together at the middle of the gate with one each side cutting points reversely, and the latter being duplicate contrivances of two punches cutting points together and arranged side by side in the gate. Thus four barbs are made, two on each barb strip at each operation of the dies, and two are bent in one direction by one pair of the bending dies, and two in the opposite direction.

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 one double blank strip which consists of punching at intervals along the strip pointed barbs having retaining connection therewith, and separating the uncut webs between the barbs alternately along the lines of the respective edges of the barbs to complete the separation of the two strips and divide the barbs alike between the strips, substantially as described.

2. The method of producing two barbed strips from one double blank strip which consists of, first, punching at intervals along the strip two barbs in line, the points of which are taken from a common point of the blank, and the bases being retained in connection with the blank by the intervals of uncut webs between the punched portions of the barbs, second, bending the projecting portions of

the barbs laterally to the blank, and third, separating the uncut webs between the barbs alternately along the lines of the respective edges of the barbs to complete the separation of the two barbed strips and divide the barbs alike between the two strips, 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.