

(No Model.)

J. H. TEMPLIN.

METHOD OF MAKING BARBED FENCING.

No. 507,186.

Patented Oct. 24, 1893.

Fig. 1.

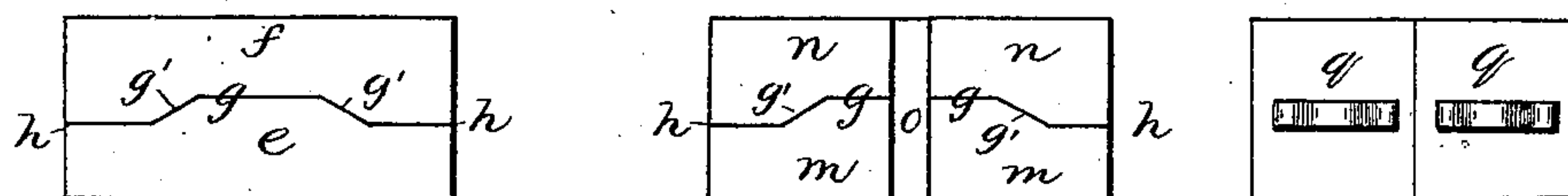


Fig. 2.

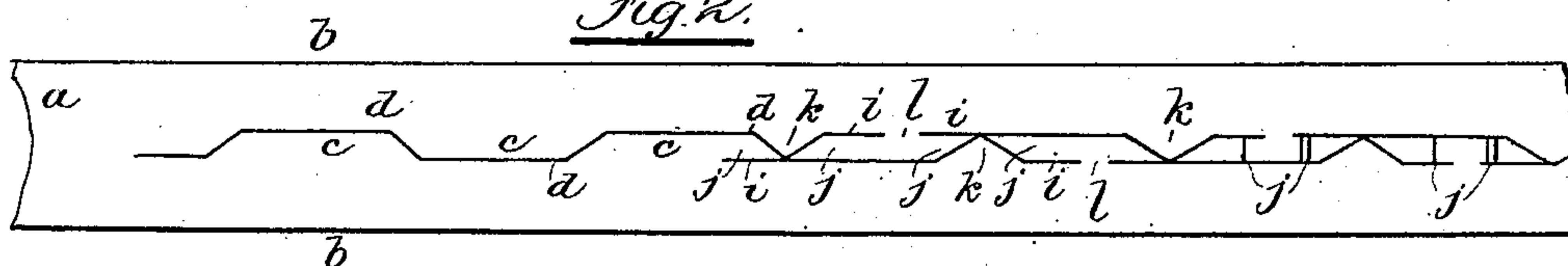


Fig. 3.

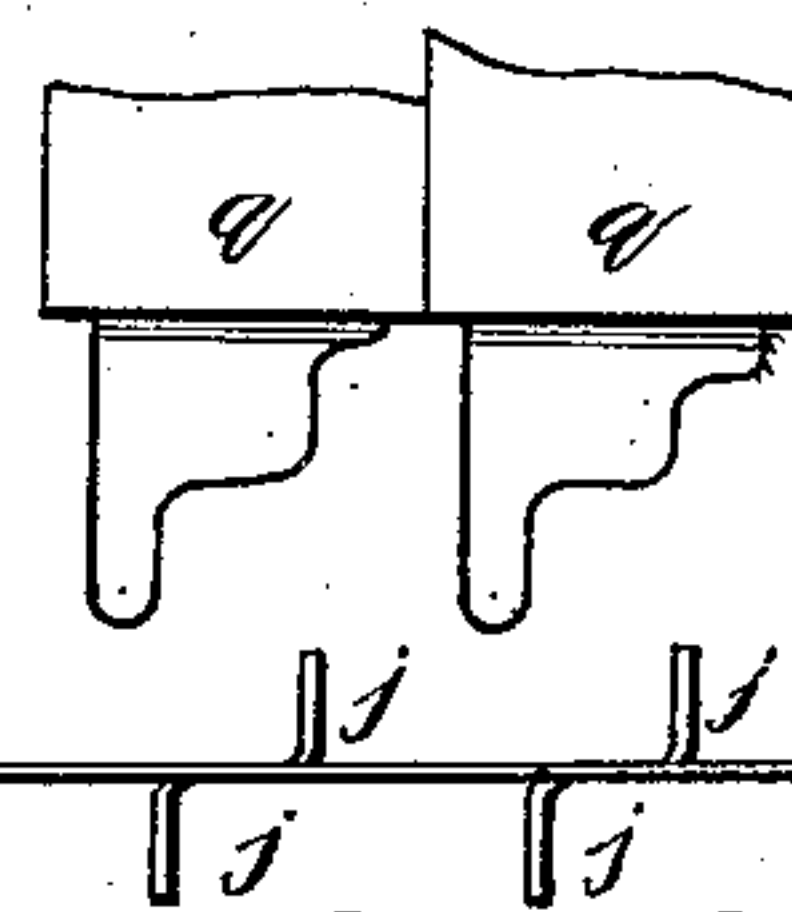
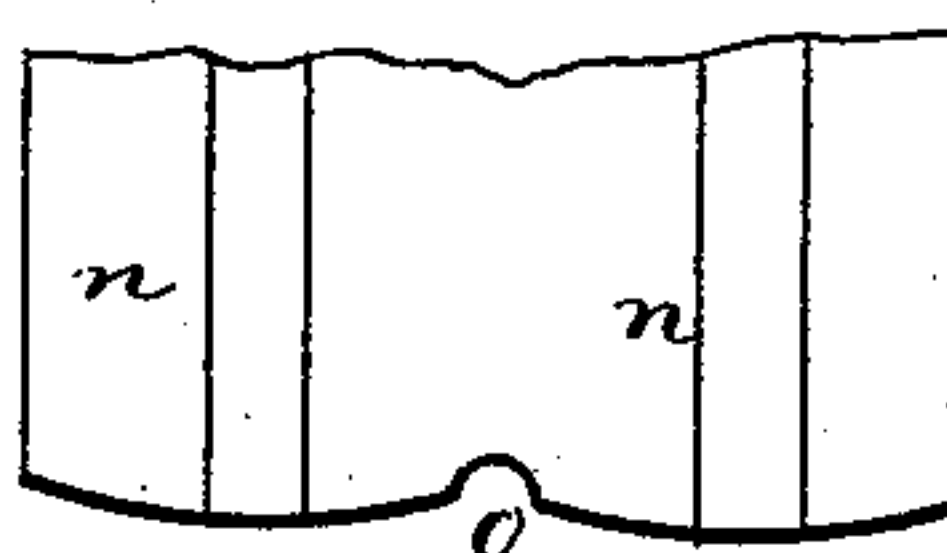
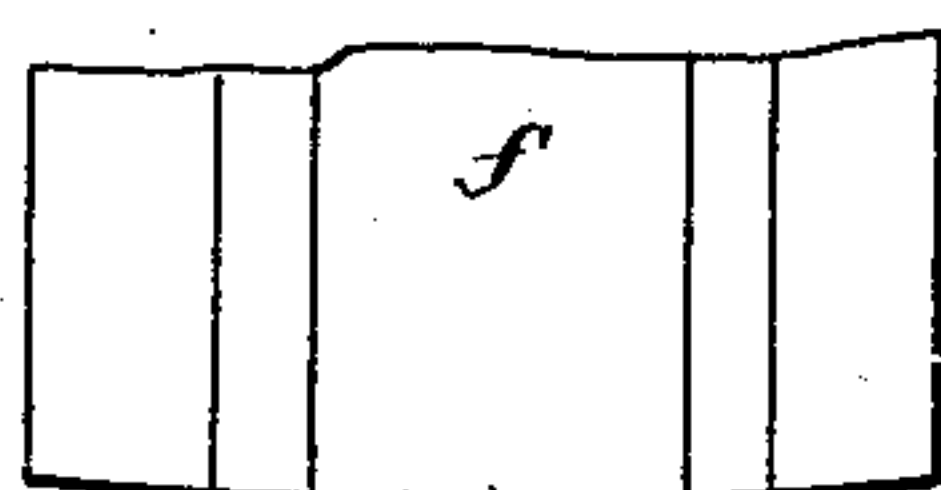


Fig. 4.

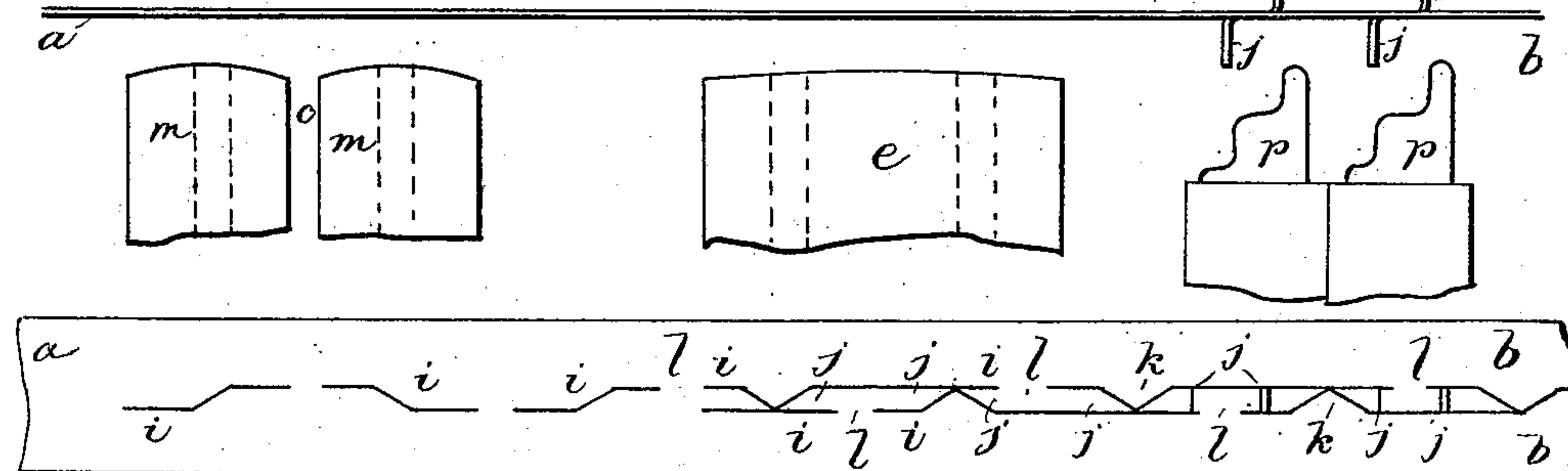
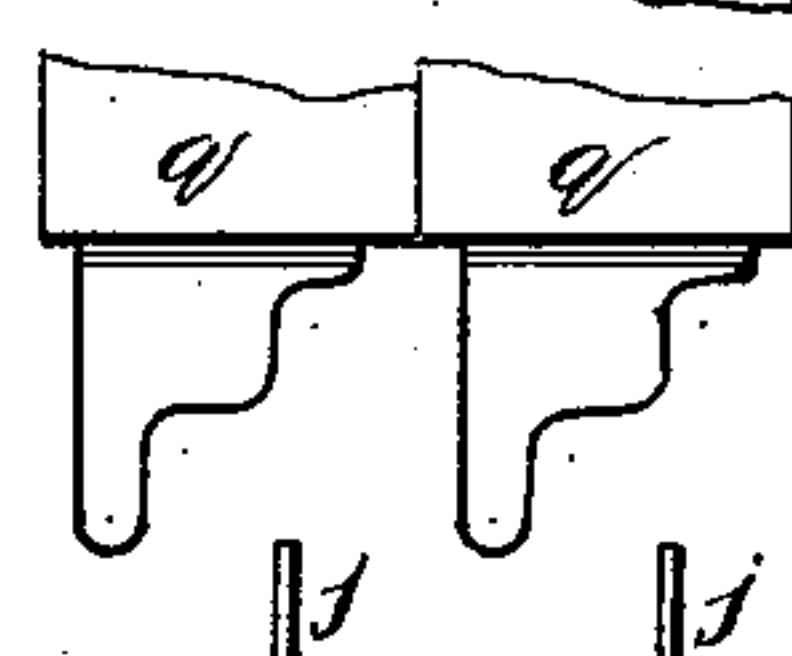
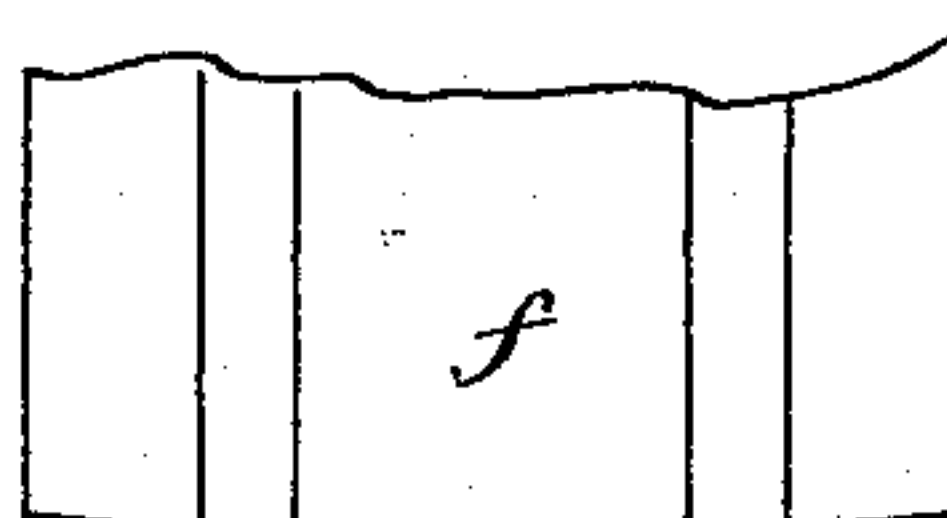
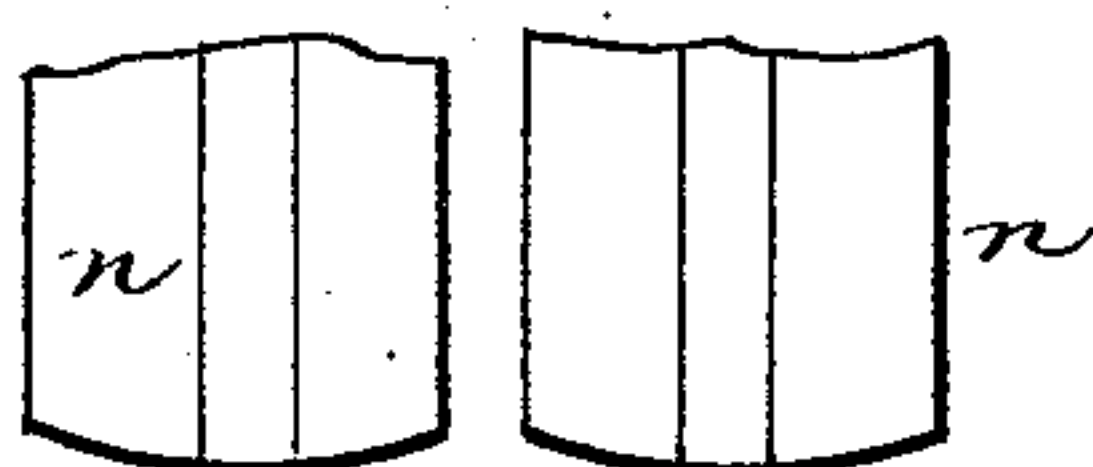
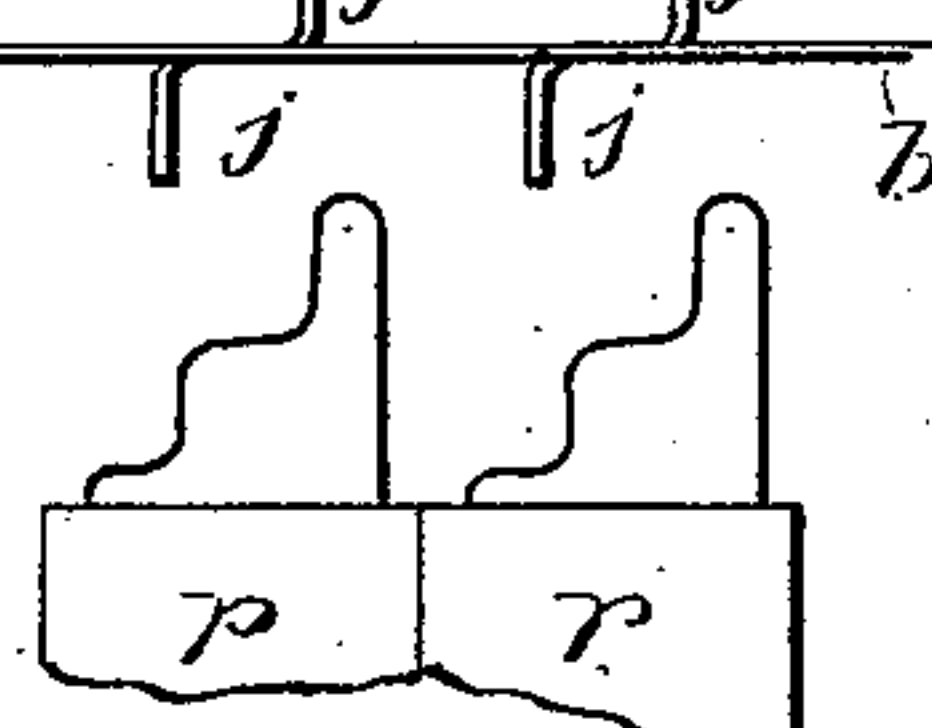
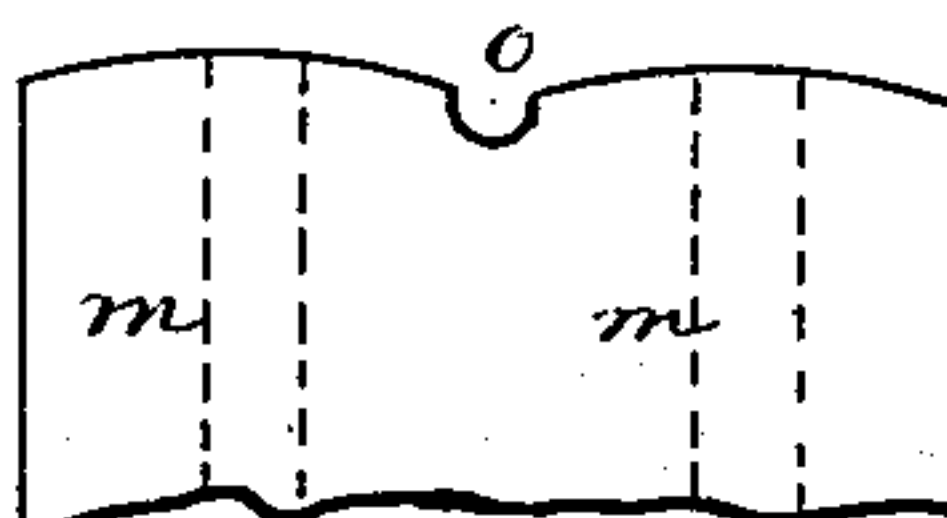
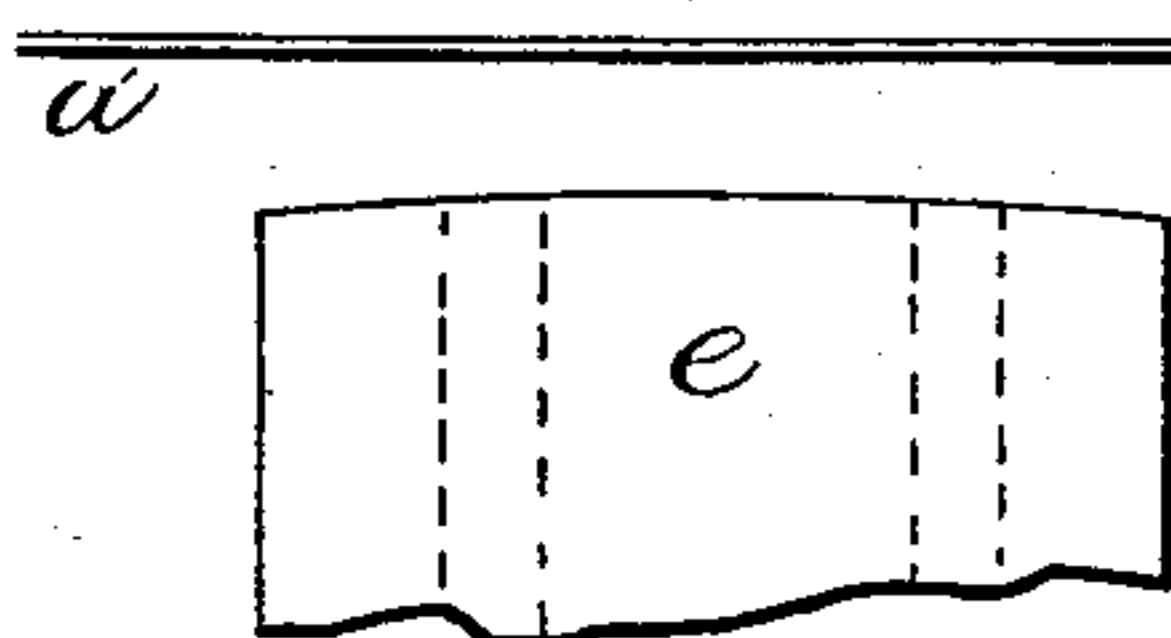


Fig. 5.

WITNESSES:

Chas Morgan,
Geo T. Janvin

INVENTOR

INVENTOR
Josh A. Templin

B4

BY *A. P. Hayes*

ATTORNEY

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. 507,186, dated October 24, 1893.

Application filed August 13, 1888. Serial No. 282,553. (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 invention consists of an improved method of making barbed fencing by slitting apart a plain flat double blank strip, and at the same time making other cuts in addition to the slitting cuts whereby two barbed strips are produced, each having two barbs formed on one edge and projecting laterally therefrom in opposite directions alternately with another barb also formed on the edge but projecting therefrom in the plane of the strip, as follows referring to the drawings, in which—

Figure 1 represents face views of the slitting and barb cutting dies and some of the bending dies. Fig. 2 is a diagram of the strip showing the action of the dies upon it. Fig. 3 is a side elevation of the slitting, cutting and bending dies, with a blank strip between them. Fig. 4 represents side views of a modified arrangement of dies. Fig. 5 is a diagram of the strip as cut by the dies of Fig. 4.

In the first place I proceed to separate the blank strip A by successive cuts, into two strips b, each having projecting ribs c, alternating with corresponding notches d, preferably using therefor the dies e, f, made with the offset of the cutting edges h, along the middle portion, represented by the line g, parallel to h, and the reversely inclined diagonals g', joining lines h, and g. The length of said offset is the required length of the projections c, for producing three barbs, and the width is that which is designed for the width of the barbs that are to be made to project laterally from the strip. The length of the parts h, together is equal to the length of line g, or may be somewhat greater, so that these dies cut the length of one projection and one notch of each strip b, at each operation, the blank a, being fed the length of said dies at each movement. Then I make other cuts or slits i, partly along the base of the projection c, of one strip, partly diagonally

across the contiguous projection c, of the other strip from its extremity, and partly along the base of the latter, the diagonals of the alternate slits i, being reverse to each other, and the extremities of these slits terminating a little short of each other in the base lines of the respective projections c, thus producing the barbs j, cut lengthwise along the strips but retained thereon by the uncut base webs l, left between the extremities of slits i, and the barbs k, left between the diagonal cuts of slits i, and of the first slits made in separating the blank, which diagonals also serve to point the barbs. To make these slits i, I prefer to employ the dies m, n, substantially like dies e, f, except being a little shorter and having the gap at o, in the part g, of the offset, to leave the uncut webs l, for retaining the barbs j, of one barb strip, and being so located relatively to said dies e, f, that their diagonal edges g' cut into the projections c, from one end respectively, and suitable to make points k, and being a little shorter than dies e, f, and also shorter than the length of the feed movements of the strip, they leave the other webs l, between the cuts of the successive feed movements, and uniting barbs j, to the other barb strip, but these dies may be constructed in two separate pairs, each being the length of a slit i, as shown in Fig. 4. Following these dies which complete the cutting of the barbs, are two pairs of bending dies p, q, which bend the barbs j, one pair to each barbed strip and each pair bending two barbs at the same time but in opposite directions. They are likewise arranged in the due relation to the preceding dies for working successively with them. I have represented the parting of the blank by the dies e, f, as the first step in the process, because it is the preferable way, but it is obvious that the slits i, may be first made and the parting next, if preferred, as represented in Figs. 4 and 5, and I consider both ways included in my invention.

I reserve the dies 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 strip which consists of separating the same into two strips each having an alternate ribbed and notched edge, and making other cuts along the base
5 lines of the projections and across the same at one end, substantially as described.

2. The method of producing two barbed strips from a double blank strip having barbs projecting laterally from the strip, which
10 consists of separating the same into two strips, each having an alternate ribbed and notched edge, and making other cuts along the base

lines of the projections and across the same at one end, and bending the barbs thus cut along the base webs of the projections, substantially as described. 15

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.