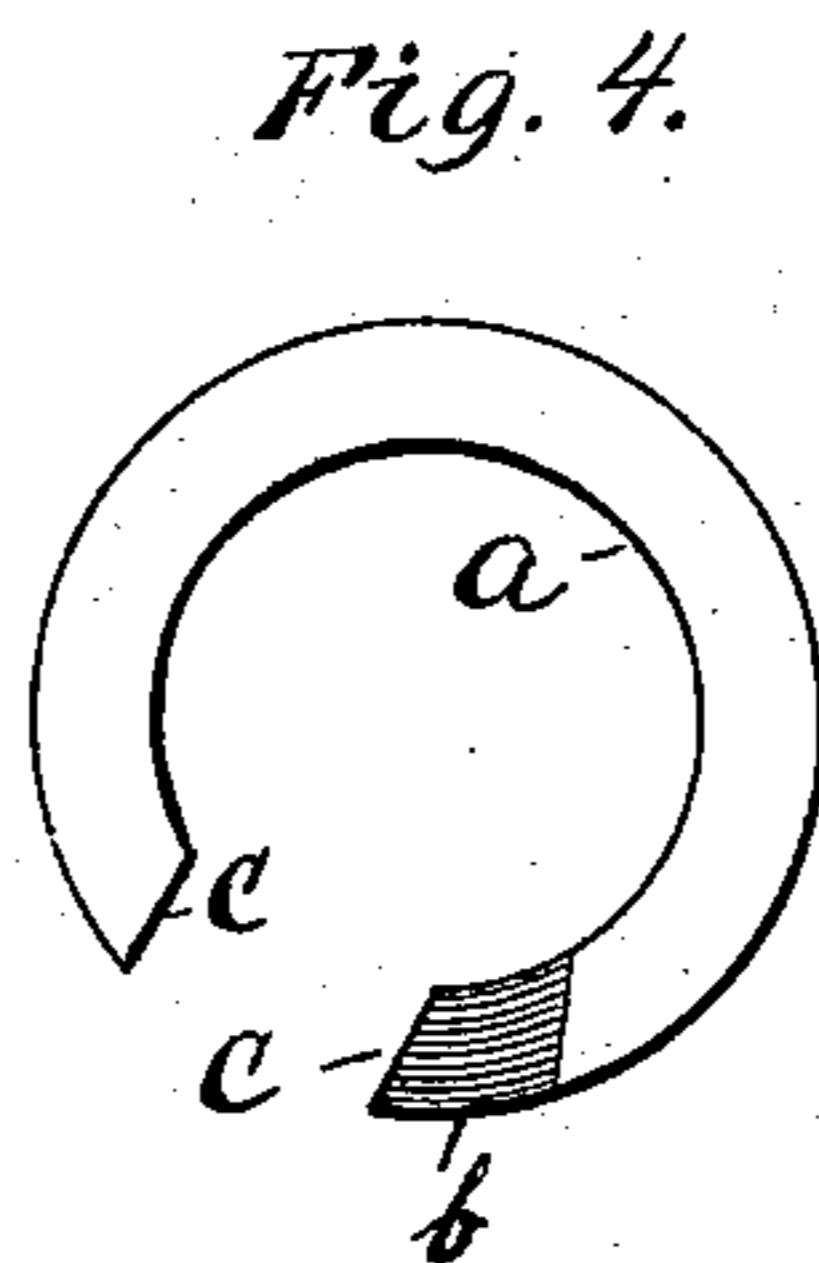
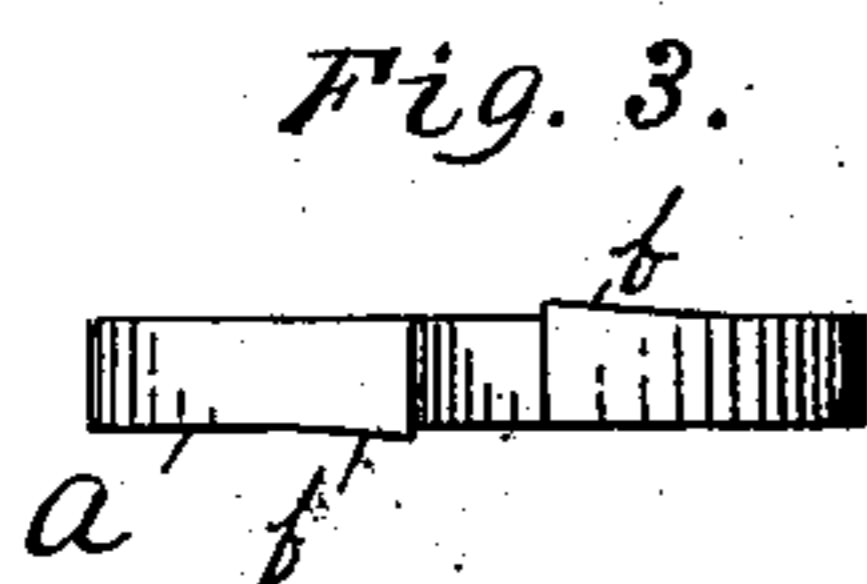
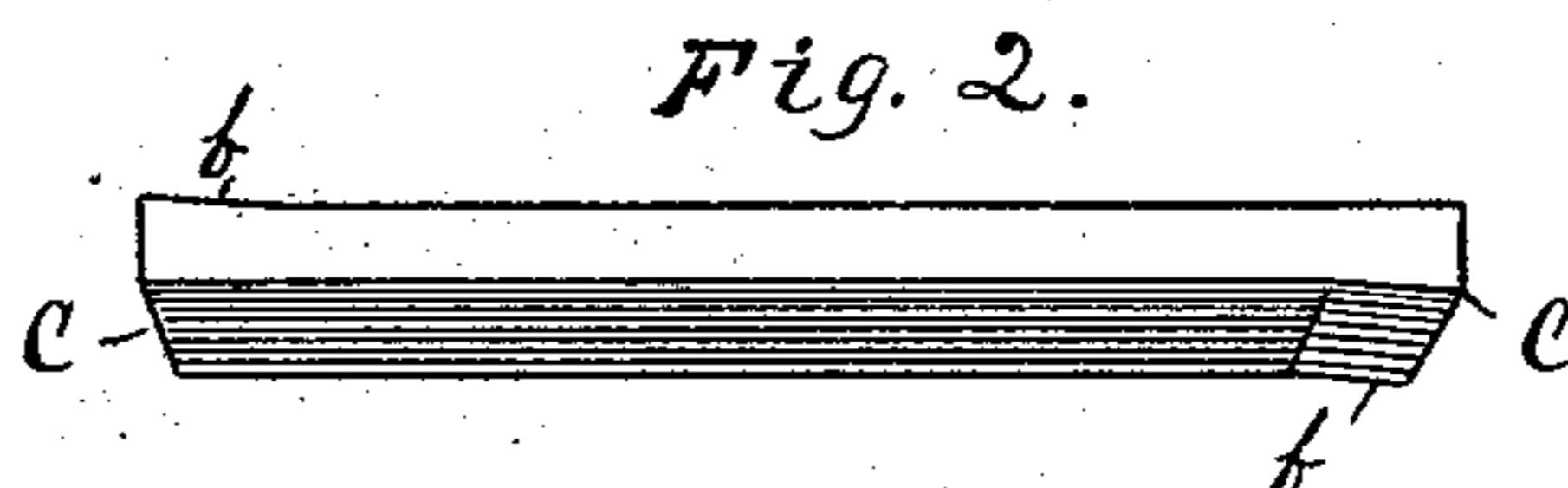
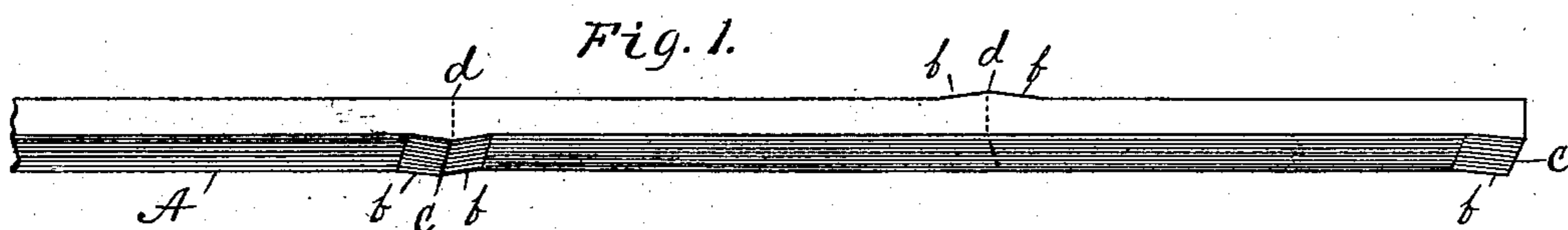


(No Model.)

W. E. SPOONER.  
METHOD OF MAKING NUT LOCKS.

No. 507,291.

Patented Oct. 24, 1893.



Witnesses  
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# UNITED STATES PATENT OFFICE.

WILLIAM E. SPOONER, OF NEW BEDFORD, MASSACHUSETTS.

## METHOD OF MAKING NUT-LOCKS.

SPECIFICATION forming part of Letters Patent No. 507,291, dated October 24, 1893.

Application filed February 3, 1893. Serial No. 460,906. (No specimens.)

*To all whom it may concern:*

Be it known that I, WILLIAM E. SPOONER, a citizen of the United States, residing at New Bedford, in the county of Bristol and State of Massachusetts, have invented certain new and useful Improvements in Methods of Making Nut-Locks, of which the following is a specification.

My invention relates to the manufacture of that class of nut-locks, wherein the body of the same is of varying thickness or irregular form; and especially to that class of nut-locks having an inclined edge at their ends, which projects beyond the plane of their upper and lower surfaces.

The objects of my invention is to cheapen and simplify the process of manufacture of said nut locks.

To this end my invention consists in forming or rolling said inclined edges in a bar of metal suitable for the formation of said nut-locks, and in dividing said bar through the apex of said inclines, and then bending the lengths into circular form, as is fully illustrated in the accompanying drawings, in which—

Figure 1. is a view in perspective of a portion of a bar of metal having the inclined edges rolled into it. Fig. 2. represents a view in perspective of one of the parts of said bar, after being divided. Fig. 3. represents an

edge view of the same after being bent into form as a nut-lock; and Fig. 4. is a plan view of the same.

A, represents a bar of metal, having the inclined surfaces *b*. rolled into it, on alternate sides thereof, and at uniform distances along its length. The bar is then divided through the line *c*, of the apex of the inclined surfaces *b*, and the dotted line *d*, into lengths *a*, (Fig. 2.) which lengths are then bent into circular form, as shown in Fig. 4, with the inclined edges on the sides of said form, as shown in Fig. 3.

By rolling the bar of metal into proper form several difficult operations in making the nut locks, are dispensed with, and the cost of manufacture thereby largely reduced.

I claim—

An improved method of making nut-locks of the character described, consisting of rolling or forming the bar of metal of which the nut locks are composed, with inclines as shown; dividing said bar, transversely at the apex of said inclines; and bending the pieces into circular form, having the said inclined edges on the sides of said form, all as shown and described.

WILLIAM E. SPOONER.

Witnesses:

JAMES C. HITCH,  
HENRY W. MASON.