

(No Model.)

C. GLOVER.

MANUFACTURE OF BRACKETS FOR TRANSOM LIFTERS.

No. 515,670.

Patented Feb. 27, 1894.

Fig. 1.

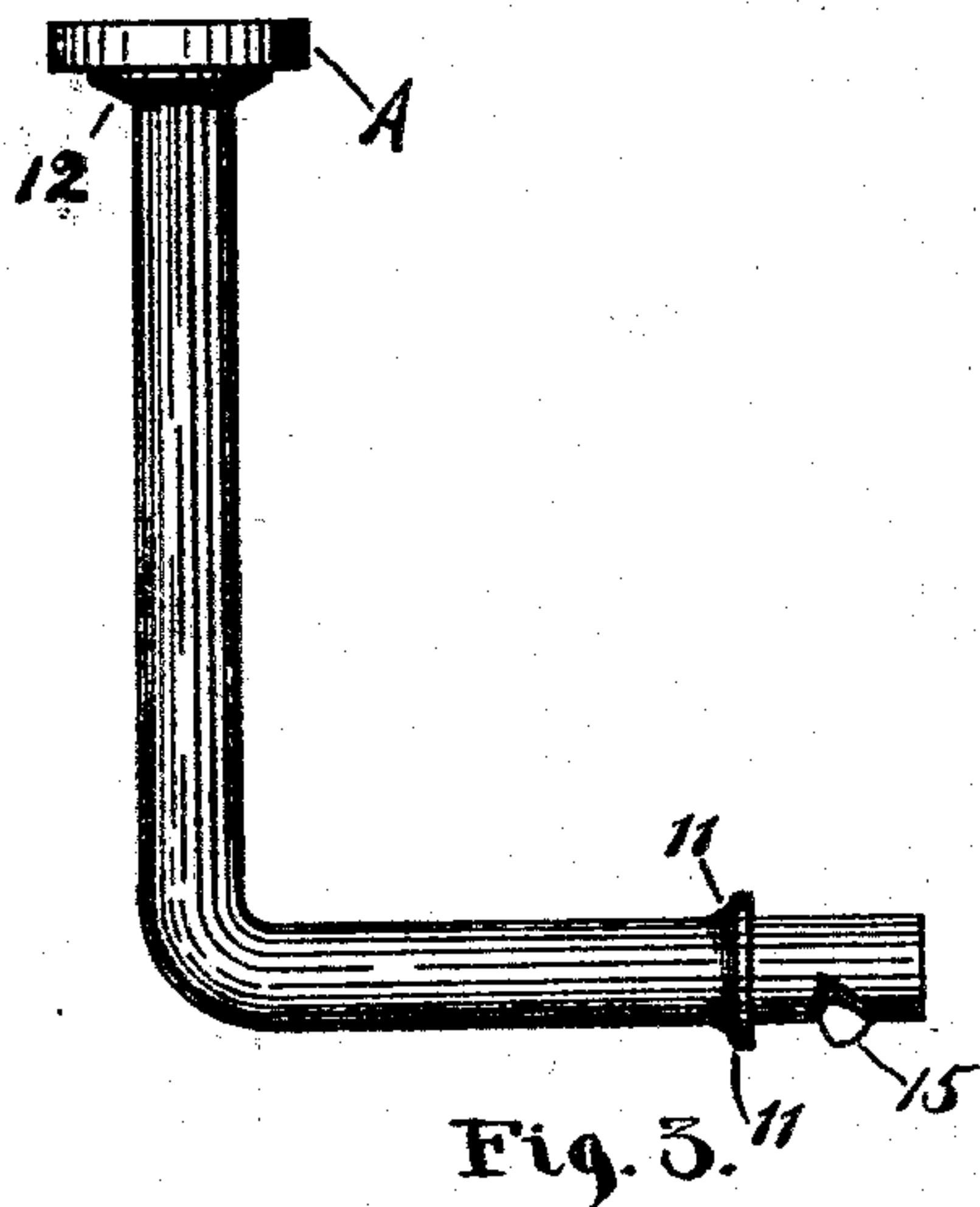


Fig. 2.

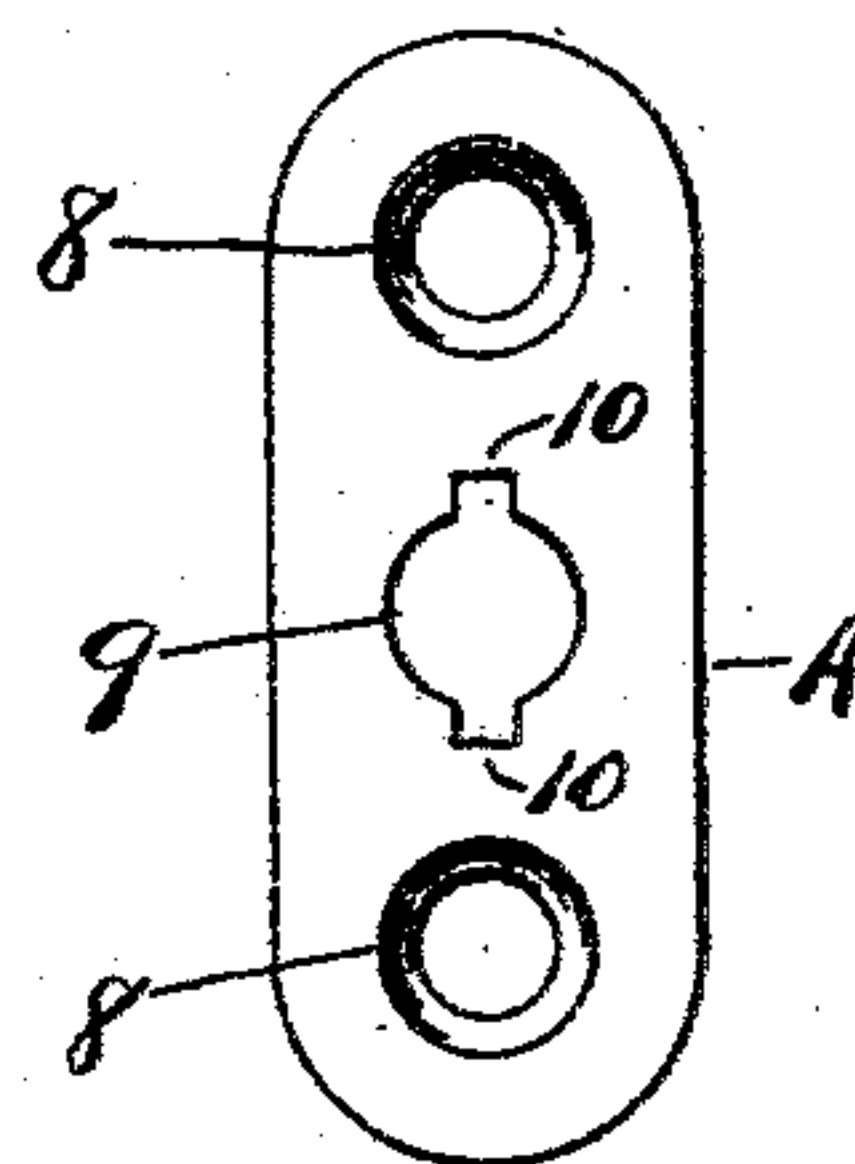
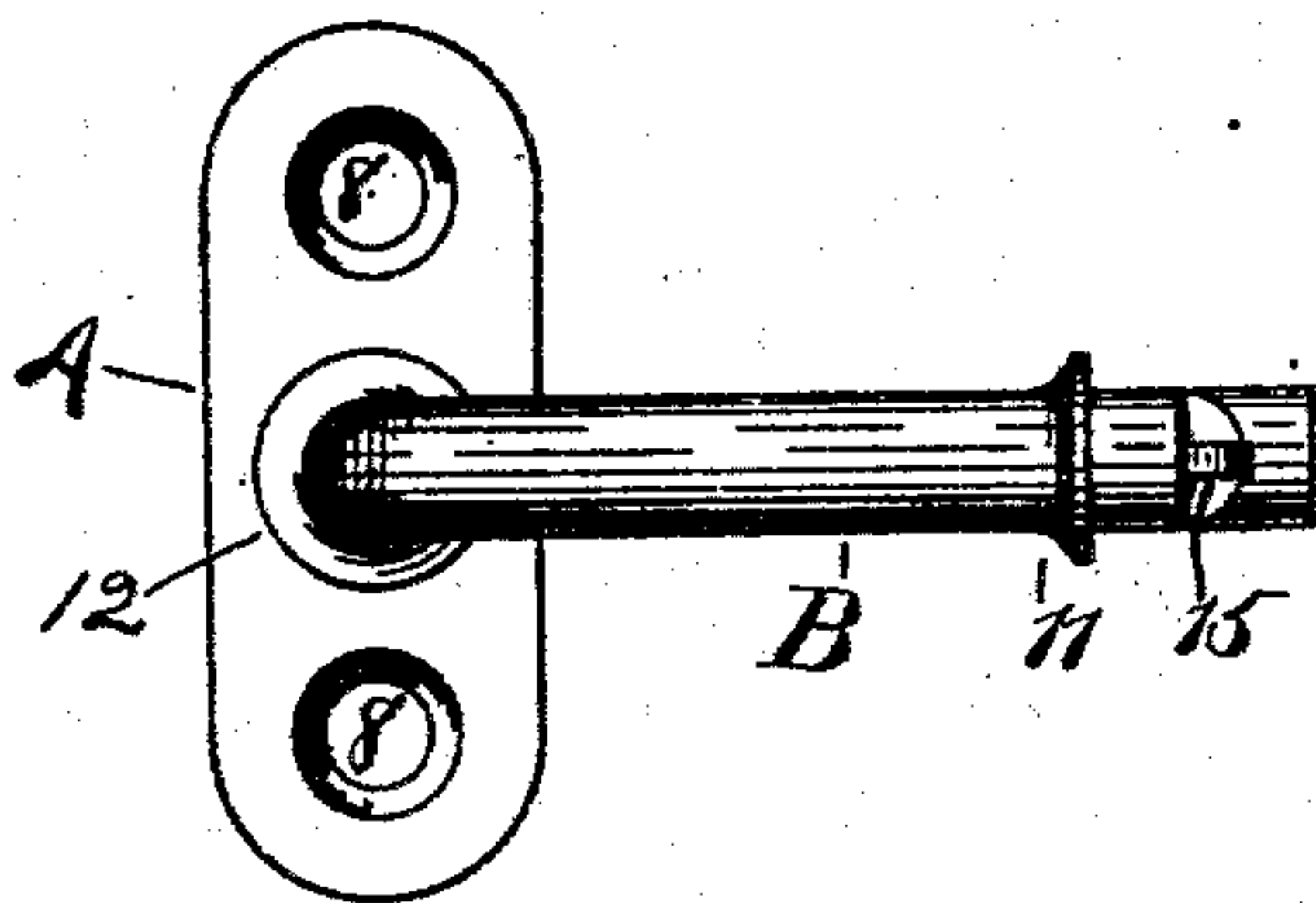
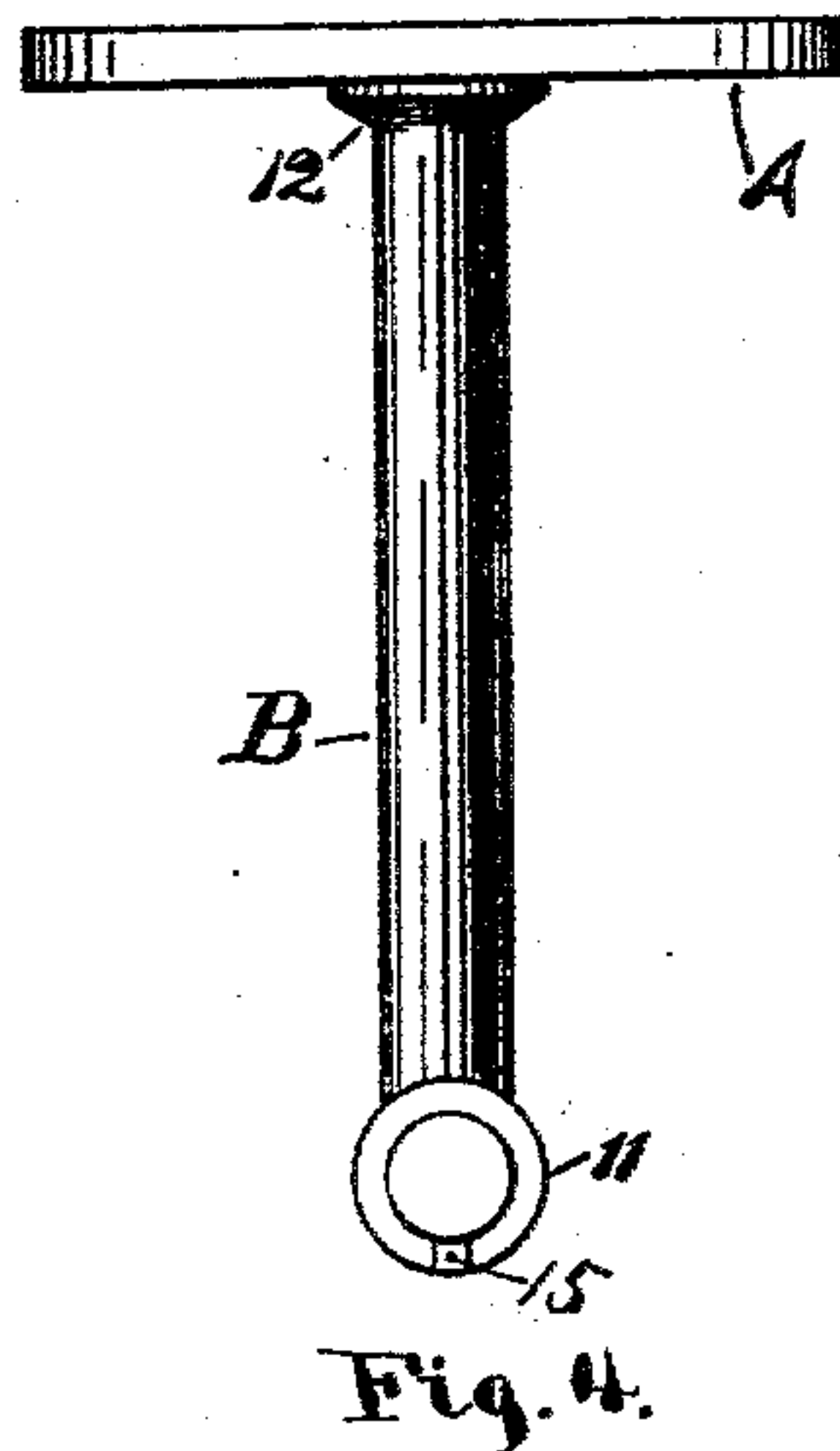


Fig. 5.

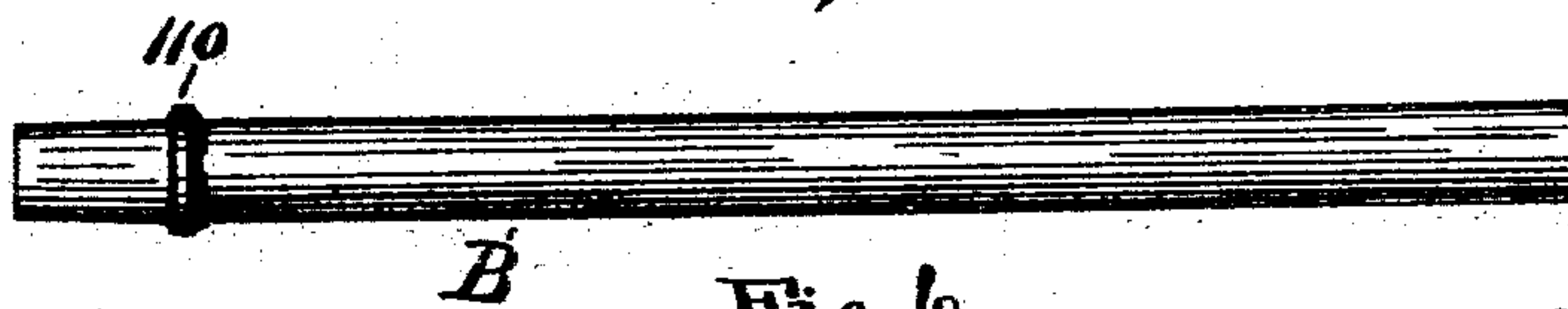


Fig. 6.

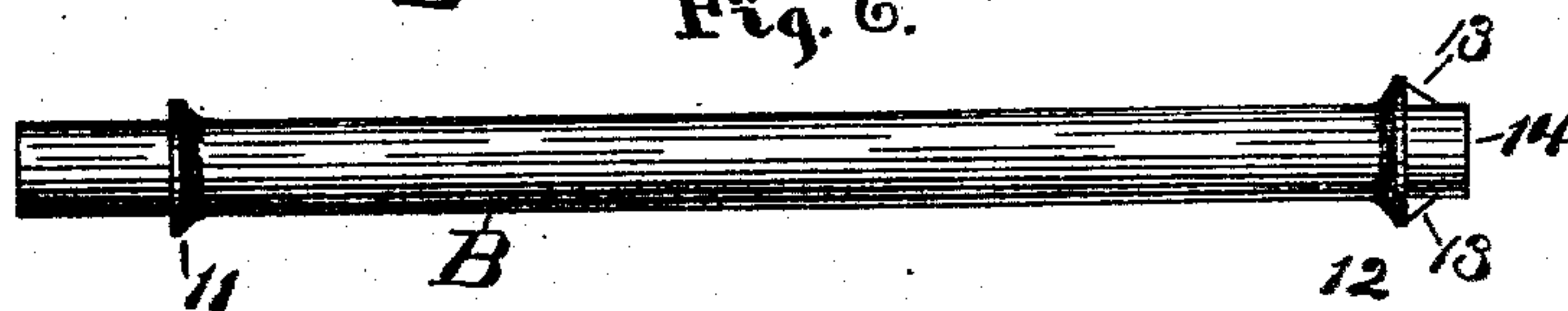
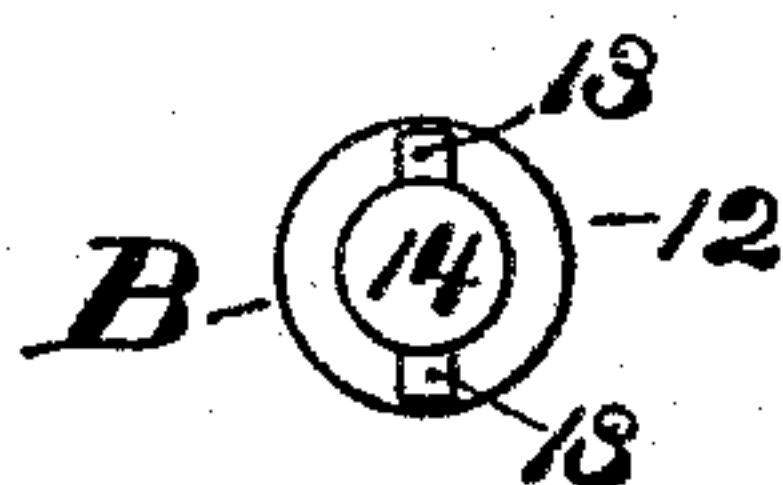


Fig. 7.



Witnesses
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UNITED STATES PATENT OFFICE.

CHARLES GLOVER, OF NEW BRITAIN, CONNECTICUT, ASSIGNOR TO THE
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MANUFACTURE OF BRACKETS FOR TRANSOM-LIFTERS.

SPECIFICATION forming part of Letters Patent No. 515,670, dated February 27, 1894.

Application filed March 6, 1893. Serial No. 464,693. (No model.)

To all whom it may concern:

Be it known that I, CHARLES GLOVER, a citizen of the United States, residing at New Britain, in the county of Hartford and State of Connecticut, have invented certain new and useful Improvements in the Manufacture of Brackets for Transom-Lifters, of which the following is a specification.

My invention relates to improvements in the manufacture of brackets for transom lifters, and the objects of my improvement are to produce an efficient transom lifter bracket at a small cost and to construct the same of wrought metal.

In the accompanying drawings, Figure 1 is a plan view of my bracket. Fig. 2 is a side elevation of the same. Fig. 3 is a front view. Fig. 4 is a detached front view of the bracket supporting plate. Fig. 5 is a side elevation of the bracket rod showing the result of a sub-step which may be practiced in the production of my bracket. Fig. 6 is a side elevation of the bracket rod as formed ready for being bent into the position shown in Figs. 1 to 3, and Fig. 7 is an end view of that end thereof which is designed to be secured to the bracket plate.

I form my bracket of two parts, the bracket plate A and bracket rod B. The plates A are cut from sheet metal by means of dies, said plates having two perforations for the screw holes 8 and a central perforation 9 with side notches 10 as shown in Fig. 4 to receive the end of the bracket rod hereinafter described.

The bracket rod is first formed from a suitable rod of metal by forming the flange 11 for the link supporting shoulder and the plate shoulder 12 with lateral wings 13 at the junction of said shoulder and tenon 14 as shown in Figs. 6 and 7. The flange 12 and wings 13 are so near the end of the rod that they may be formed in suitable gripping dies by pressure on the end of the rod; but the flange 11 is so far from the end of the rod that I prefer to first practice the sub-step illustrated in Fig. 5, of forming a rudimentary flange 110 in a suitable upsetting machine by endwise pressure in gripping dies, and then completing the flange as shown in Fig. 6 in the same machine and by the same operation as that by which the flange 12 and wings 13

are formed. Near the end of the rod adjacent to the flange 11, I form a lateral wing 15 which is formed by pressure between dies that cut into the body of the metal adjacent to said wing and then press out and flatten the stock between the points so cut to force out said projecting wing 15, changing that portion of the rod which is outside of the flange 11 from the form shown in Fig. 6 to that shown in Figs. 1, 2 and 3. This wing 15 may be formed when the bracket rod is straight and before it is secured to the bracket plate, or it may be formed after said rod is bent and secured.

The bracket rod B has its tenon 14 inserted in the central orifice 9 of the bracket plate A with its wings 13 entering the side notches 10 of said central orifice and is then firmly secured thereto by upsetting or heading the end of the rod or tenon 14. The rod B is also bent from the position shown in Fig. 6 to that shown in Figs. 1, 2 and 3 to bring the end of the flange in proper position to the bracket plate.

The general form of my bracket when produced in cast metal is old. The flange 11 and wing 15 are for the purpose of holding one end of the operating link on said bracket, the perforation in said link having a side notch or recess so that when in one position it may be slipped on the bracket rod over the wing 15 and then partially rotated to confine it between said wing and flange 11.

By my improvement I produce the bracket wholly of wrought metal and by simple and few operations whereby I produce a light and substantial bracket of rods and sheet metal and produce the same at a small cost.

I claim as my invention—

1. That improvement in the manufacture of brackets for transom lifters which consists in cutting the bracket plate from sheet metal with screw holes and bracket rod receiving orifice, upsetting the bracket rods to form the link supporting and plate shoulder flanges, cutting and pressing a wing 15 from the body of the rod adjacent to the flange 11, securing the bracket rod to the bracket plate and bending the said rod into form, substantially as described for the purpose specified.

2. That improvement in the manufacture

of brackets for transom lifters which consists
in cutting the bracket plate from sheet metal
with the bracket rod receiving orifice having
the side notches, upsetting the bracket rods
5 to form the link supporting shoulder flange
and the plate flange and wings 13, securing
the bracket rod with its end and wings 13 in
said orifice and its side notches and bending
the rod to form, substantially as described
and for the purpose specified.
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