

(No Model.)

J. PICKLES.
DIE FOR FORMING EYELETS.

No. 596,788.

Patented Jan. 4, 1898.

Fig. 1

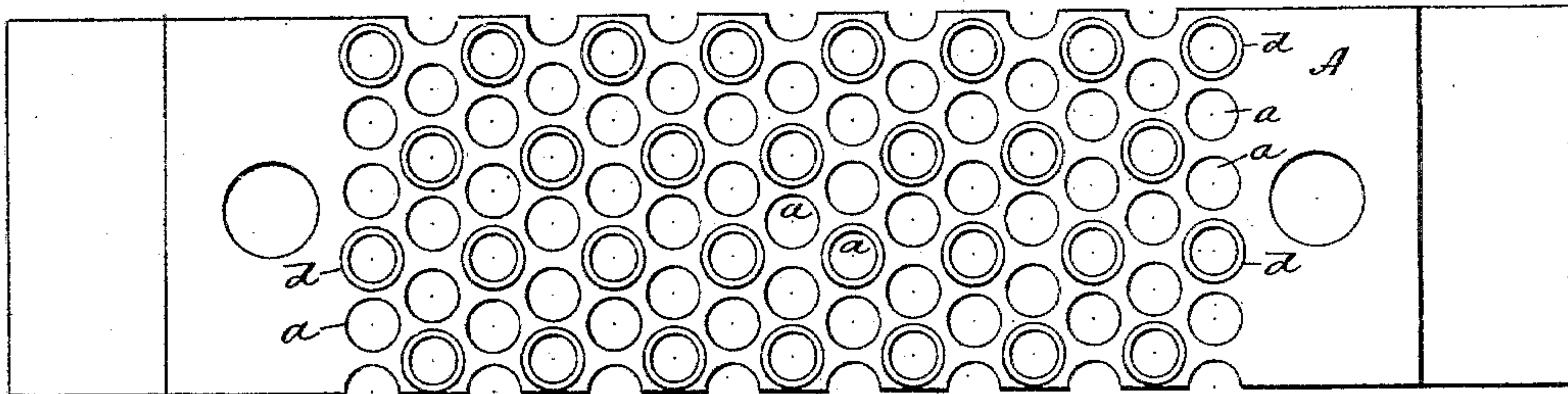


Fig. 2

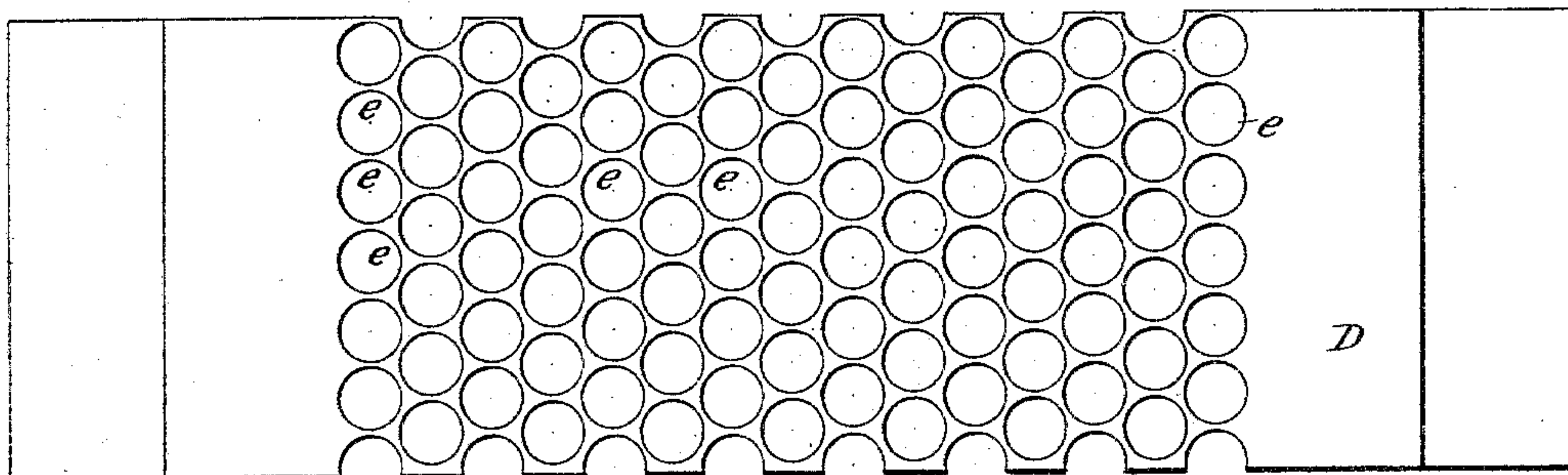


Fig. 3

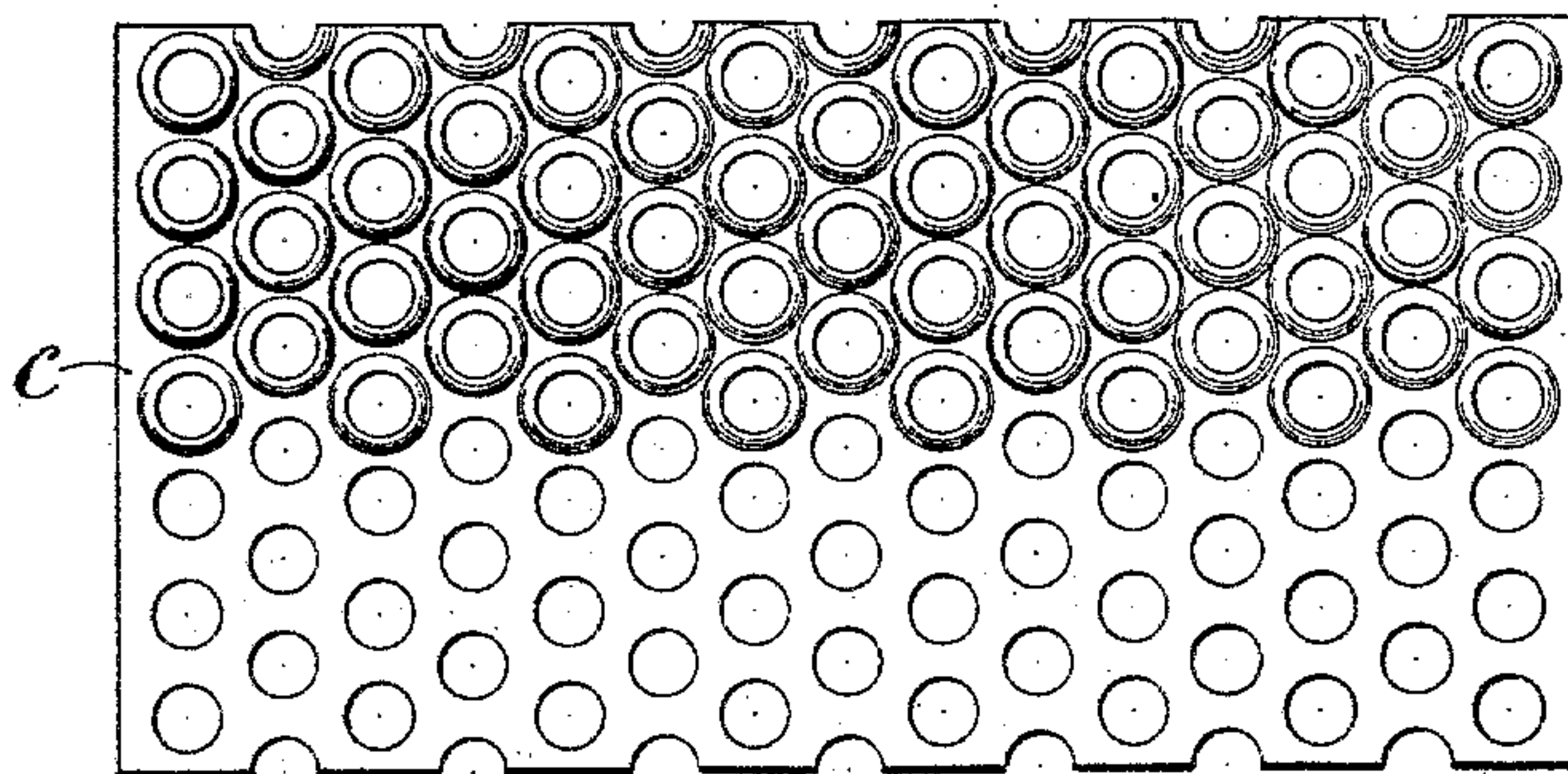


Fig. 4

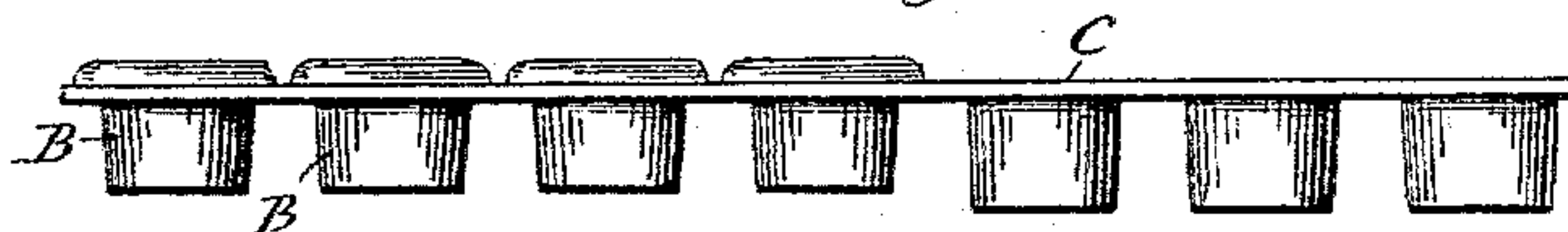
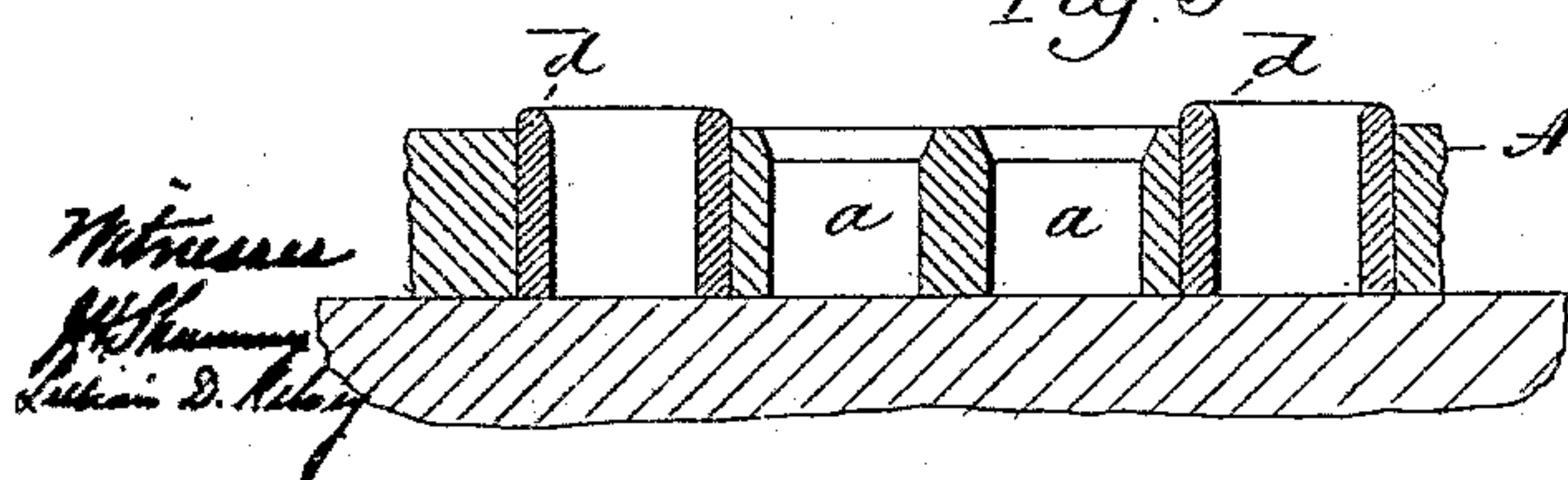


Fig. 5



Witness
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UNITED STATES PATENT OFFICE.

JAMES PICKLES, OF ANSONIA, CONNECTICUT, ASSIGNOR TO THE S. O. & C. COMPANY, OF SAME PLACE.

DIE FOR FORMING EYELETS.

SPECIFICATION forming part of Letters Patent No. 596,788, dated January 4, 1898.

Application filed February 12, 1897. Serial No. 623,093. (No model.)

To all whom it may concern:

Be it known that I, JAMES PICKLES, of Ansonia, in the county of New Haven and State of Connecticut, have invented a new Improvement in Dies for Forming Eyelets; and I do hereby declare the following, when taken in connection with the accompanying drawings and the letters of reference marked thereon, to be a full, clear, and exact description of the same, and which said drawings constitute part of this specification, and represent, in—

Figure 1, a face view of the lower die; Fig. 2, a face view of the upper die; Fig. 3, a top view of the strip, showing a portion whereon is indicated the ribs formed around a part of the barrels; Fig. 4, an edge view of the strip, showing at the right-hand side the strip without the ribs and at the left-hand side the strip formed with the ribs; Fig. 5, a sectional view of the lower die.

This invention relates to an improvement in dies for making eyelets, and is an improvement upon the invention shown in Letters Patent of the United States No. 234,690, granted November 23, 1880, to George O. Schneller. In that invention the eyelet-blanks were formed in transverse rows in long strips, but the eyelets when cut from such a strip necessarily had a flat flange. It is admitted that the preferred form of eyelet has a rounded or concavo-convex flange, and in the case of eyelets which are plated, enameled, or otherwise finished it is quite essential that the flange should be rounded before the eyelet is set, as the setting operation would injure the plating or other finish.

The object of this invention is to form the rounded flange in the strips from which the eyelets are to be cut; and it consists in the construction as hereinafter described, and particularly recited in the claim.

In carrying out my invention I first form the strip as shown in the Schneller patent, before referred to—that is, so that the barrels of the eyelets are arranged in transverse rows, being struck from the strip in suitable dies. With the strip thus formed the metal between and around each barrel is left in its normal or flat condition, and this strip I feed between a pair of dies, the under die of which is represented in Fig. 1 and consists of a block

A, formed with recesses or holes *a*, arranged in transverse rows and corresponding to the barrels B, previously formed in the strip of metal C. Around the holes *a* in alternate rows I form ribs *d*, which project above the surface of the die. The upper die D is formed with a series of depressions *e*, corresponding in location and arrangement to the holes *a* in the die A. The strip of blanks is formed in correspondence with the Schneller patent and is fed between the dies A and D, the barrels B entering the holes *a* in the die A, and when thus located the upper die is forced downward upon the strip, which depresses the metal around the ribs *d*, which forms a corresponding circular rib around a portion of the eyelets, and when thus formed the strip is fed inward another step to bring another row of eyelets over the ribs *d*, when the die again descends, forming the circular rib around the remaining portion of the eyelets, and this continues until a circular rib is formed around each barrel in the strip. The blanks thus formed may be cut in any desired manner, and when cut from the strip the flanges are concavo-convex shape, which is the form they should have when set, and so that the setting operation does not change the form of the flange, which may thus be plated, enameled, or coated in any desired manner.

Having fully described my invention, what I claim as new, and desire to secure by Letters Patent, is—

The herein-described dies for forming eyelet-blanks, consisting of a lower die formed with a series of holes arranged in transverse rows, and with ribs around the upper ends of non-adjacent holes in said rows, and an upper die formed with a series of depressions corresponding in position and arrangement to the holes in the lower die, substantially as described.

In testimony whereof I have signed this specification in the presence of two subscribing witnesses.

JAMES PICKLES.

Witnesses:

FRED. C. EARLE,
LILLIAN D. KELSEY.