No. 646,777. Patented Apr. 3, 1900.

H. L. WILSON.

ART OF MAKING WROUGHT METAL BOILER BRACKETS.

(Application filed Apr. 24, 1899.)

(No Model.)

FIG. 1.

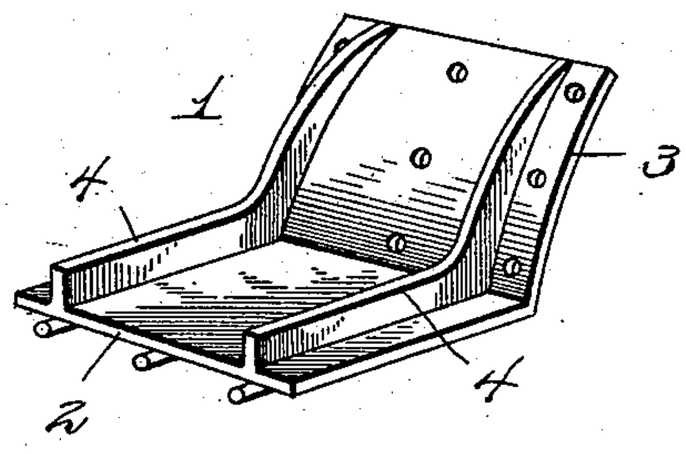


FIG. 2.

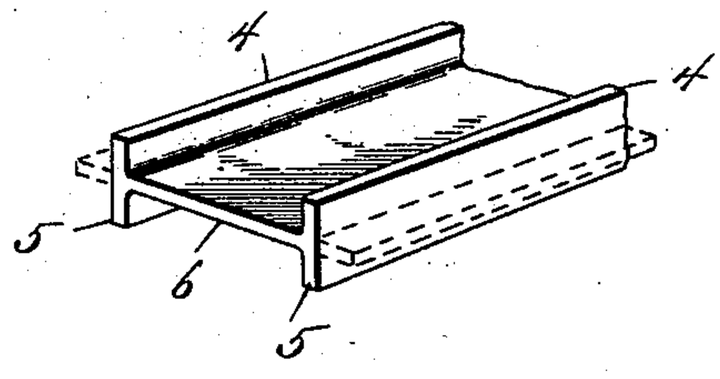
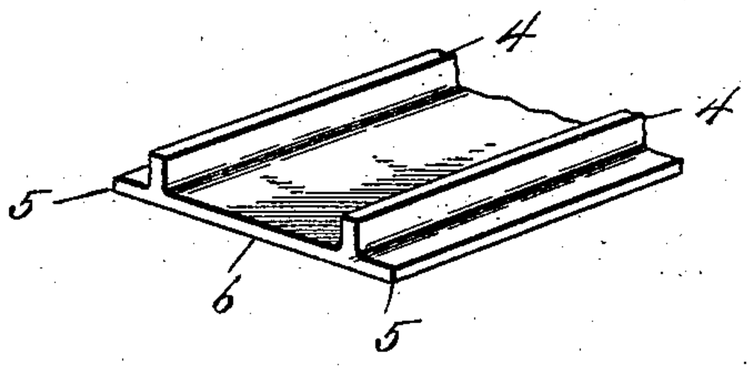


FIG. 3.



Witnesses
Harry L. Amer.
K. A. Rau.

Inventor
Harry L. Wilson.
By V. L. Stockbridge.
Attorney

UNITED STATES PATENT OFFICE.

HARRY L. WILSON, OF ERIE, PENNSYLVANIA.

ART OF MAKING WROUGHT-METAL BOILER-BRACKETS.

SPECIFICATION forming part of Letters Patent No. 646,777, dated April 3, 1900.

Application filed April 24, 1899. Serial No. 714,261. (No model.)

To all whom it may concern:

Be it known that I, HARRY L. WILSON, a citizen of the United States, residing at Erie, in the county of Erie and State of Pennsylvania, have invented certain new and useful Improvements in the Art of Making Wrought-Metal Boiler-Brackets; and I do hereby declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it appertains to make and use the same.

Boiler brackets or lugs have been heretofore made by rolling a blank of sheet metal to form flanges along the side edges in one case and to form a central flange or rib in another case. These brackets or lugs have proved in a measure satisfactory; but an objection has been discovered to the first form in that it is weak between the side flanges, causing bending of the material when the weight comes on one of the rollers between said flanges, and the second form has been found objectionable in that there is weakness at the outer edges, causing the bending of the material when the weight falls upon the outer rollers.

My invention is designed to overcome these objections; and it consists of a boiler-bracket having bracing-flanges located intermediate of the side edges of the bracket.

It also consists in the method of producing the same.

In the drawings forming a part of this specification, Figure 1 represents a perspective view of a completed bracket or lug constructed in accordance with my invention. Fig. 2 is a similar view of a section of I-beam, which constitutes the blank from which my improved bracket is made. Fig. 3 is a similar view showing the lower flanges of the I-beam bent outwardly into the position which they assume before the blank is pressed into shape to fit a boiler.

The bracket 1 is formed with a flat base 2, which rests upon the rollers, and with an upwardly-extending portion 3, which is curved to conform to the shape of the boiler to which it is applied. Between the side edges of the bracket a plurality of bracing-ribs 4 4 are formed.

It should be noted that it is difficult, if not impossible, to produce or form high ribs or flanges between and away from the edges of a flat bar or plate of metal. I, therefore, in constructing my bracket take a section of I-beam, substantially as shown in Fig. 2 of the drawings, and pass the same through suitable rolls to press out the lower flanges 5 5 until they are in alinement with the central web 6 of the beam. In doing this the blank is converted into the shape shown in Fig. 3 of the drawings, forming a broad bearing-surface with bracing-flanges intermediate of the side edges thereof. When in the form shown in Fig. 3, the blank is pressed into the shape shown in Fig. 1 of the drawings, so as to fit the boiler to which the same is to be applied. Weakness at the center and ends of the bracket is overcome in the completed lug, and bending of the same at the points noted is avoided.

What I claim as my invention is—

The improvement in the art of making wrought-metal boiler-brackets having a plurality of flanges intermediate the side edges thereof which consists in rolling the flanges on one side of an I-beam outwardly to the same plane with the central web cutting the beam to the desired length and then bending it to form a curved bar to fit the boiler, and a horizontal bar to rest on the boiler-support, substantially as described.

In testimony whereof I affix my signature in presence of two witnesses.

HARRY L. WILSON.

Witnesses:

J. P. FITTING,

MILES R. NASON.