

C. P. SHOWELL.
METHOD OF MANUFACTURING BULL RINGS.
APPLICATION FILED APR. 16, 1907.

913,651.

Patented Feb. 23, 1909.

Fig 1

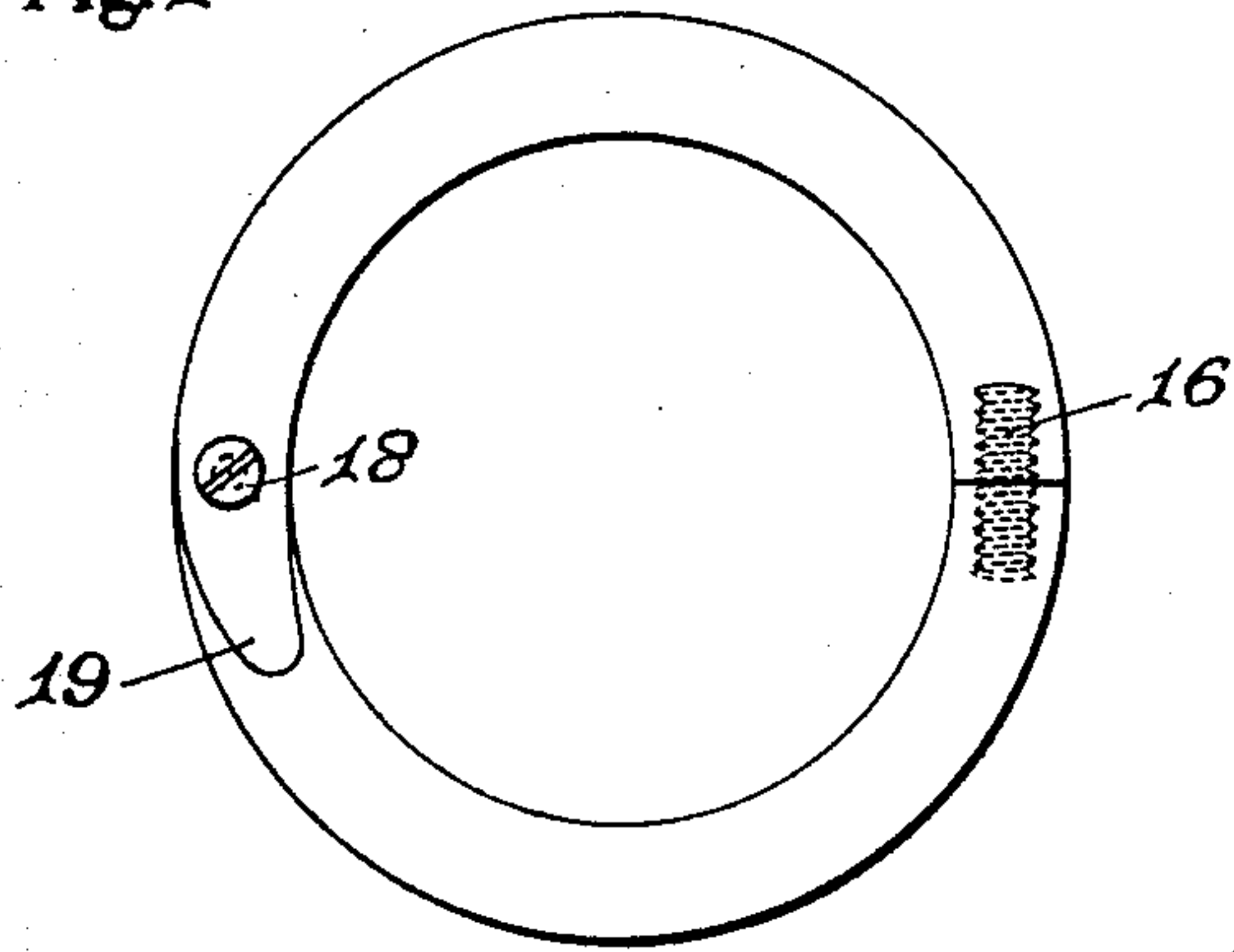


Fig 2

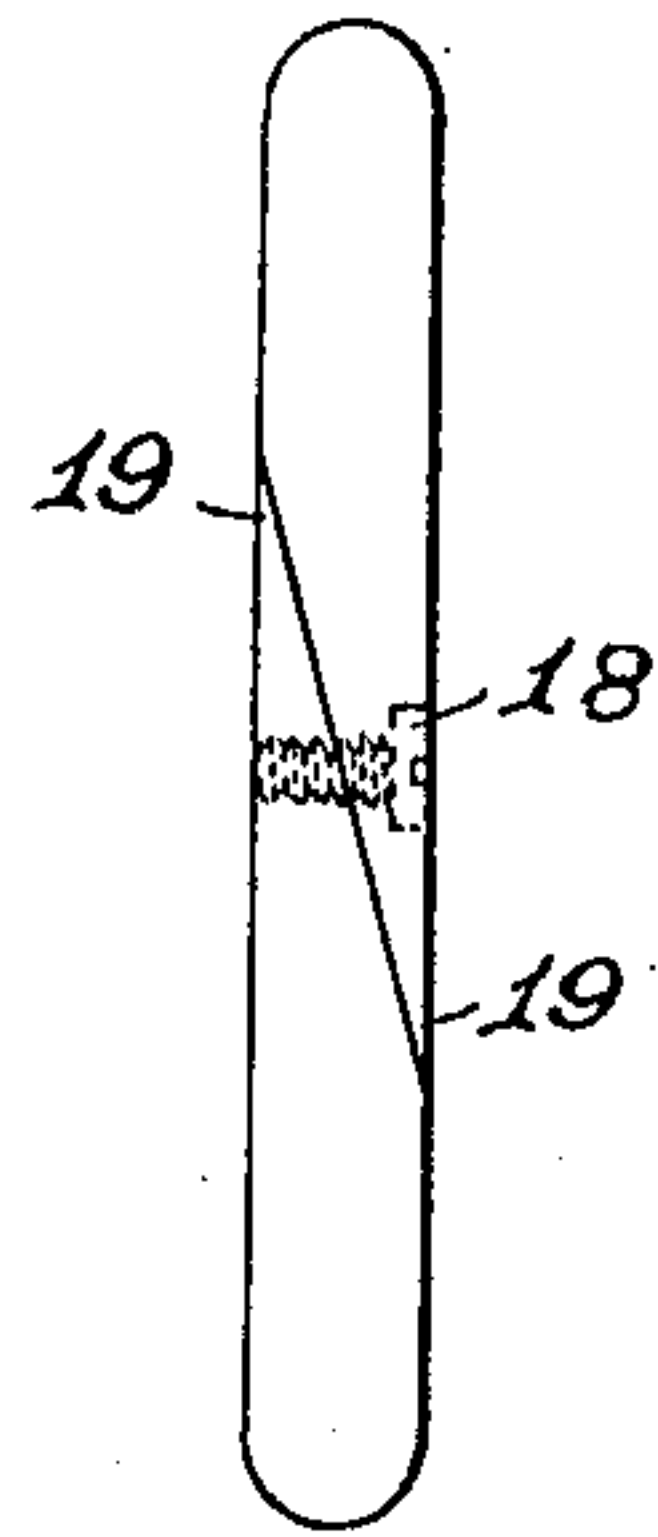


Fig 3

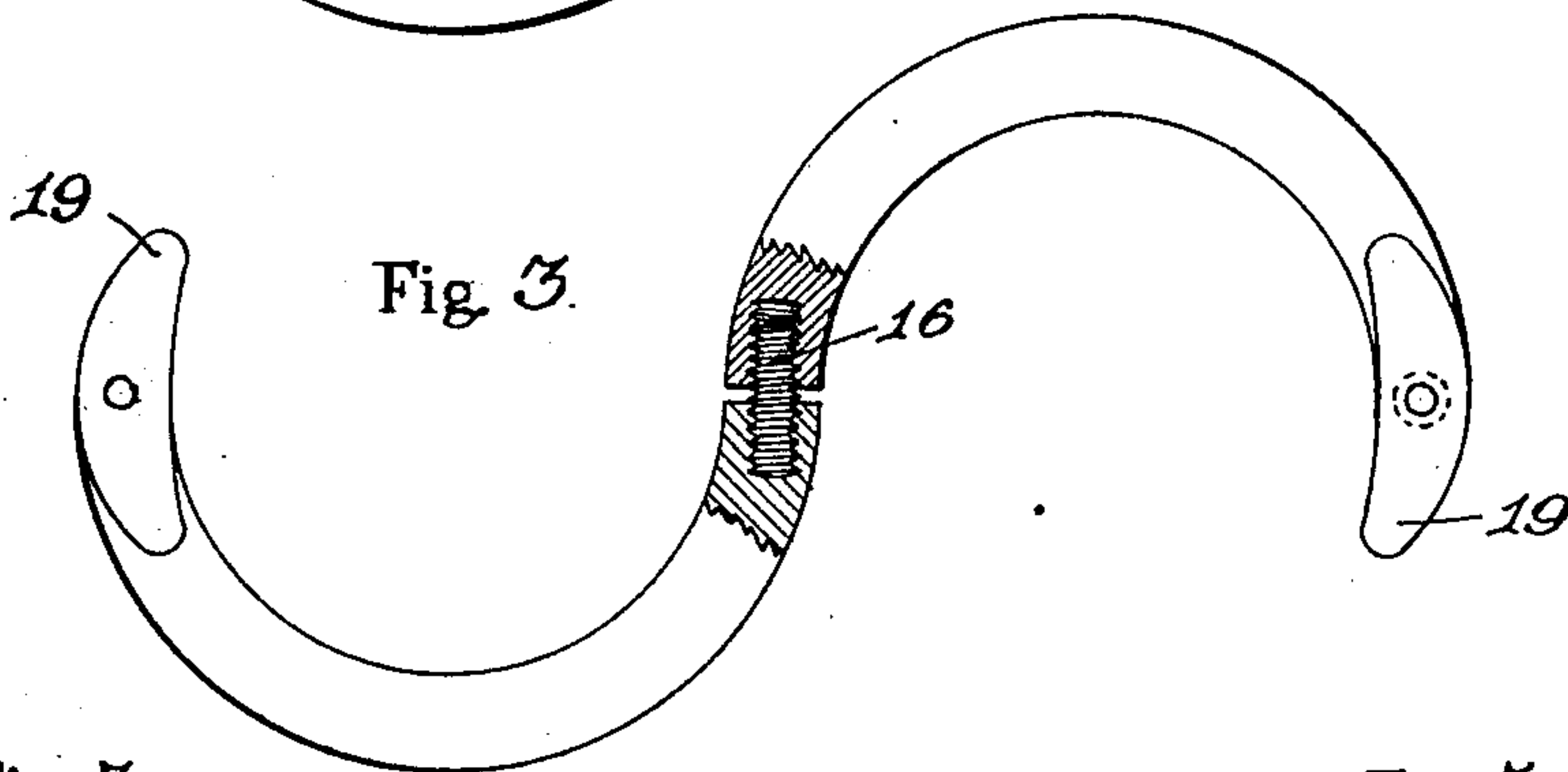


Fig 4

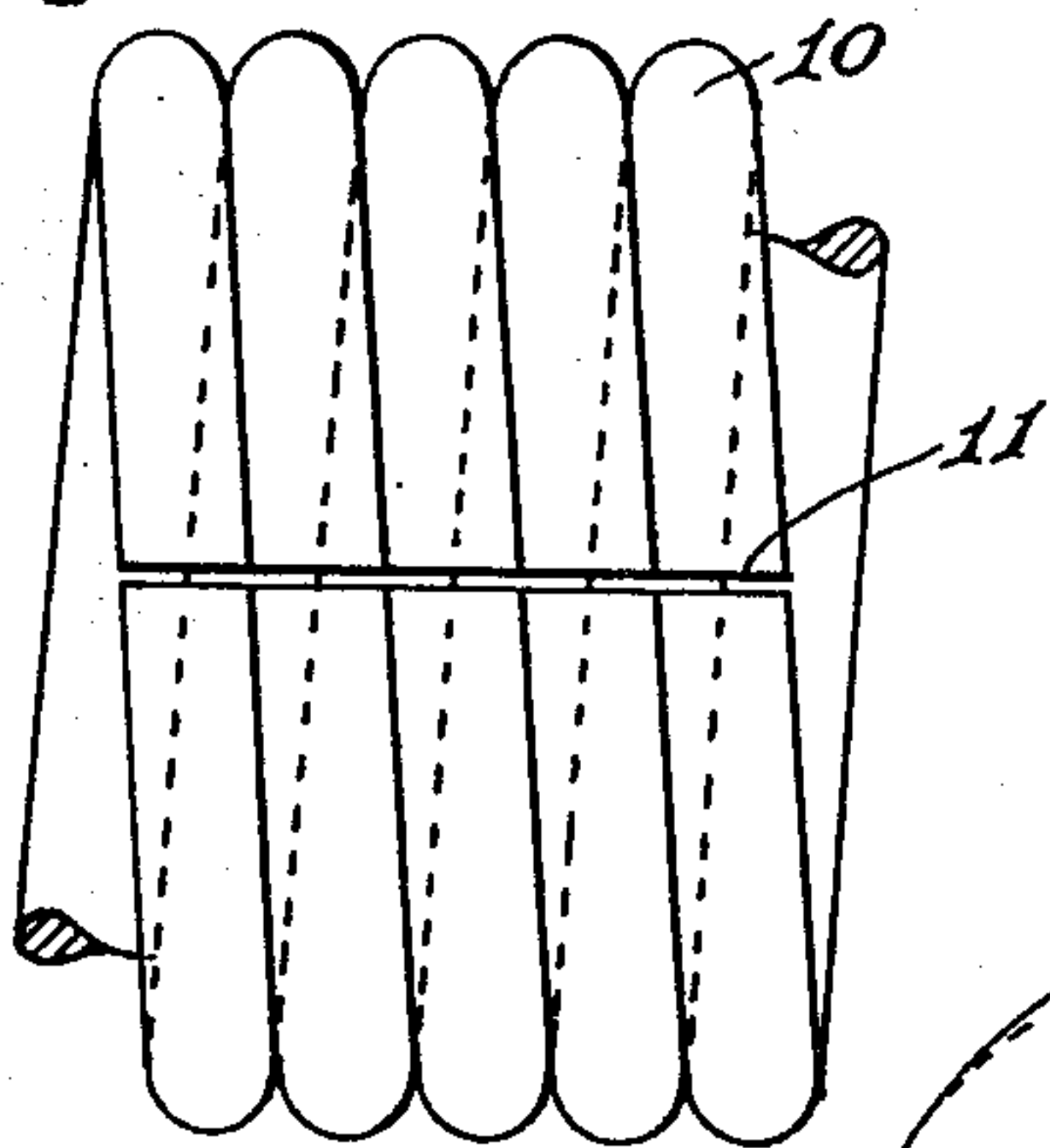


Fig 5 Fig 6 Fig 7

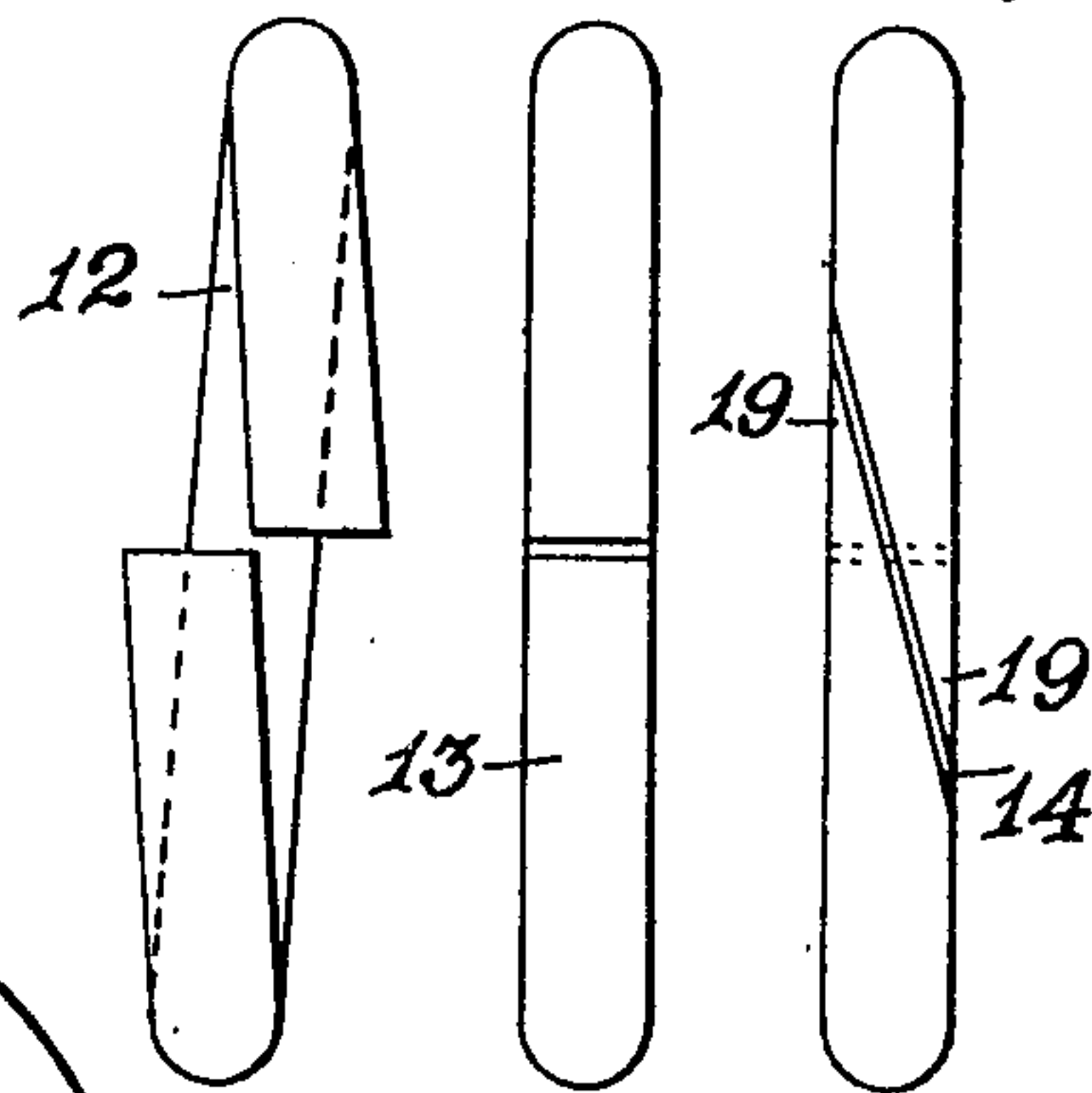
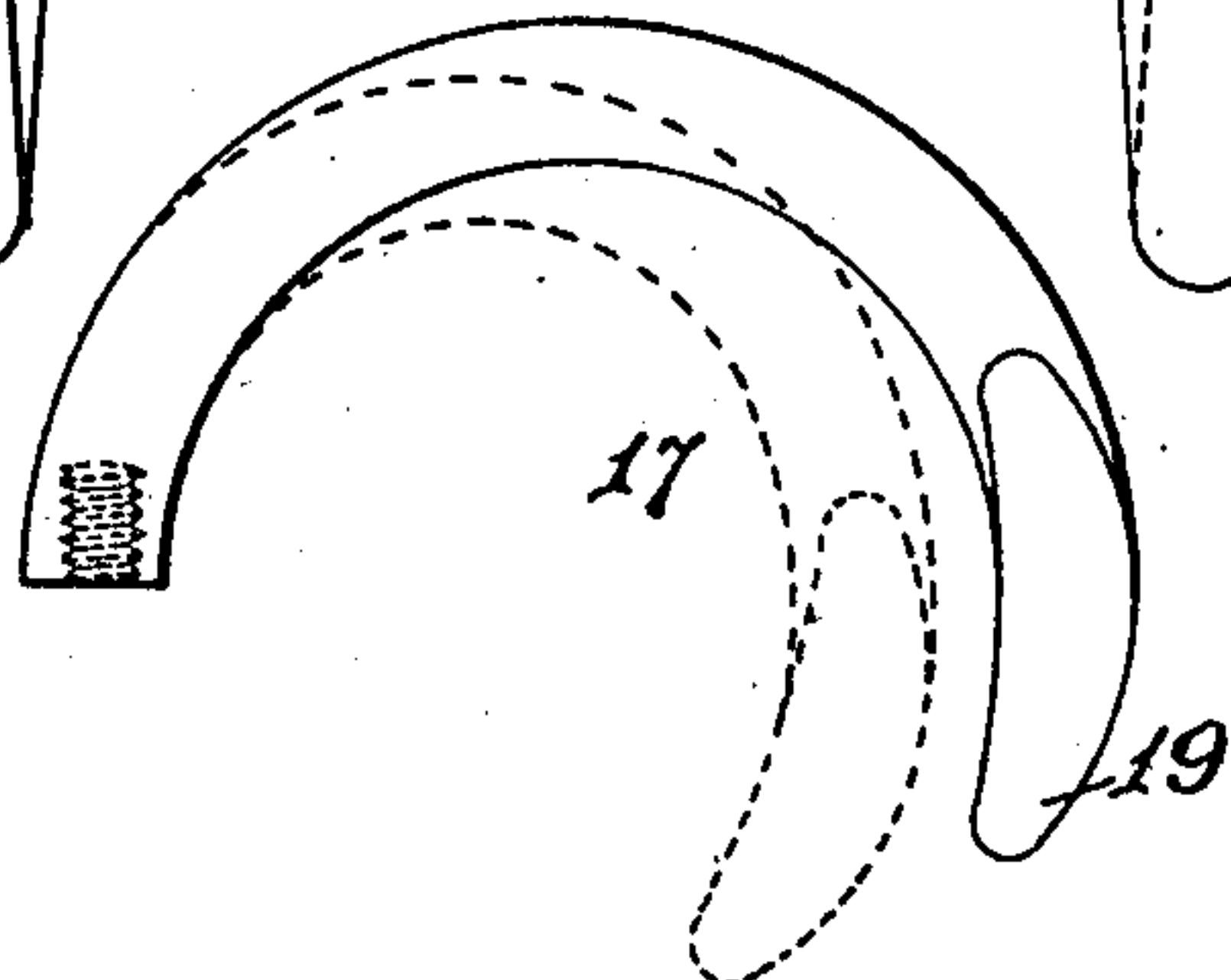


Fig 8



Witnesses
J. Bernard Hayward
H. Goodwin

Inventor
Charles Phipson Showell
per Charles F. Howell
Attorney

UNITED STATES PATENT OFFICE.

CHARLES PHIPSON SHOWELL, OF STIRCHLEY, ENGLAND.

METHOD OF MANUFACTURING BULL-RINGS.

No. 913,651.

Specification of Letters Patent.

Patented Feb. 23, 1909.

Original application filed April 17, 1906, Serial No. 312,257. Divided and this application filed April 15, 1907.
Serial No. 368,313.

To all whom it may concern:

Be it known that I, CHARLES PHIPSON SHOWELL, subject of the King of Great Britain, residing at Nine Elms, Stirchley, in the county of Worcester, England, have invented certain new and useful Improvements in the Method of Manufacturing Bull-Rings, of which the following is a specification.

This invention relates to improvements in the method of manufacturing bull rings, and forms the subject of division of application for patent filed April 17th, 1906, Serial Number 312257, now Patent No. 881,726, granted and refers to the construction of the same as hereinafter set forth, having reference to the accompanying drawings, in which:—

Figure 1 is a side view, and Fig. 2 an edge view of a completed ring made according to this my invention. Fig. 3 shows the ring in its open position ready for insertion into the nose of the animal. Figs. 4 to 8 inclusive illustrate the various stages of the method of manufacturing the rings.

Similar reference numbers refer throughout the several views to the same thing or part.

A rod of metal, usually of copper, is wound into a coil 10 of any convenient length, (see Fig. 4), whose diameter slightly exceeds that of the desired finished ring. This coil is now placed in a suitable holding tool, or upon a mandril, so that a thin sawcut 11 may be made through the one side of the said coil, so that after such cut has been made the parts fall off in the form of rings 12. A ring 12 is then closed, so that its joint comes fair, as seen at 13. The ring is then secured in any suitable holding device, so that the diagonal sawcut 14 may be made at the opposite side of the ring to the previously described severance. Thus the ring is now divided into two parts exactly alike, so that any two of such parts may form a ring complete. A hole is now

drilled and tapped in the one end of these parts, into which is firmly screwed the dowel or what is known as a grub screw 16, whose one end stands forward to enter the complementary part to form the complete ring. One of these parts is now bent inwards, as shown at dotted lines 17, to permit of the screwing up of the two parts together. After this has been done the bent part 17 is placed in suitable tools in a press, so that it may be opened out to its original shape, that is, brought into line with the other portion. Suitable holes are now made in both parts to receive the fastening screw pin 18. The entire ring is now cleaned up, polished, or otherwise finished as desired while in its secured position. It will be seen that the sharp points at 19 give the necessary cutting quality to facilitate the piercing of the same through the nose of the animal. Its use therefore will be readily understood to be as follows:—With the removal of the screw pin 18 the ring may be opened, as seen in Fig. 3, when either of the ends 19 may be passed through the nose of the animal, then the two parts closed and secured by the pin 10. By these means there is practically no waste of metal in the manufacture of these rings.

What I claim as my invention and desire to secure by Letters Patent is:—

The herein described method of manufacturing bull rings consisting of shaping a rod into a ring with ends substantially abutting, and finally cutting said ring diagonally at a point opposite the abutting ends to produce reduced extremities.

In testimony whereof I have hereunto set my hand in the presence of two subscribing witnesses.

CHARLES PHIPSON SHOWELL.

Witnesses:

N. GOODWIN,

J. BERNARD HAYWARD.