E. E. SLICK.

METHOD OF MAKING TAPERING METAL POLES.

APPLICATION FILED JAN. 9, 1909.

999,267. Patented Aug. 1, 1911.

Fig. 1.

Fig. 3.

Fig. 2.

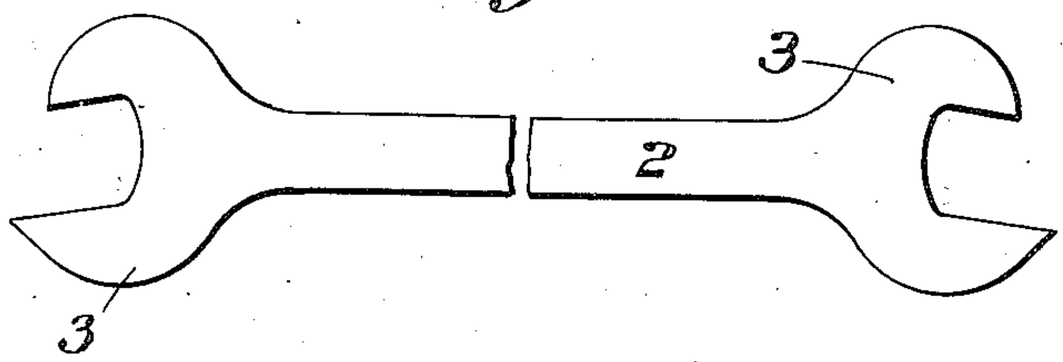


Fig. 4.

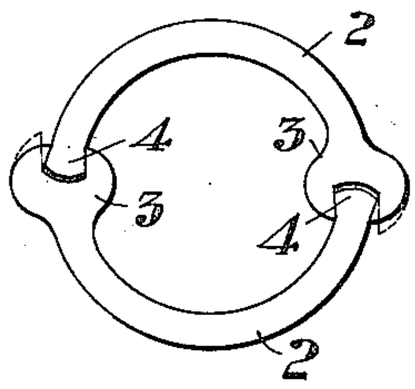
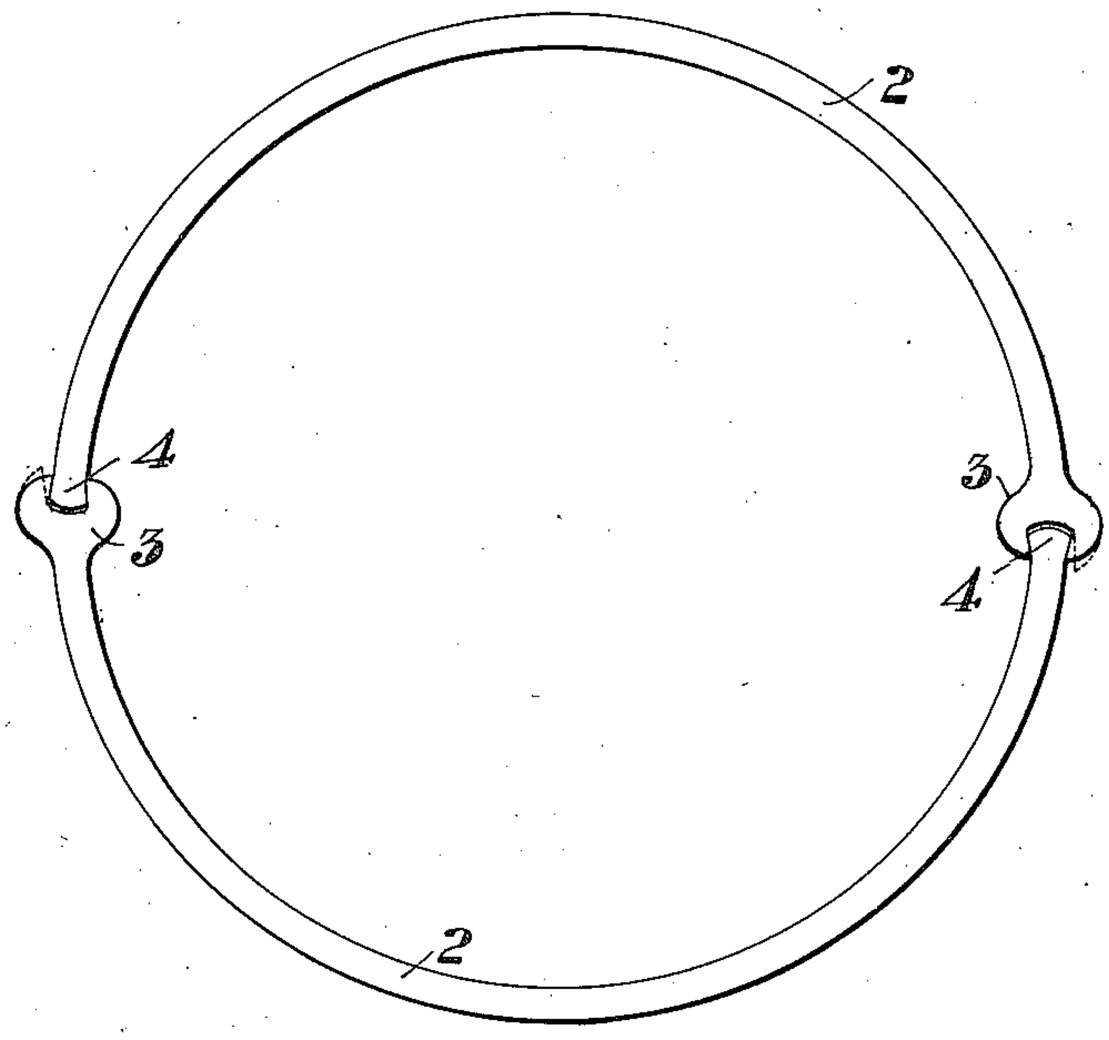


Fig. 5.



WITNESSES

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UNITED STATES PATENT OFFICE.

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METHOD OF MAKING TAPERING METAL POLES.

999,267. Specification of Letters Patent. Patented Aug. 1, 1911.

Application filed January 9, 1909. Serial No. 471,436.

To all whom it may concern:

Be it known that I, EDWIN E. SLICK, of Pittsburg, Allegheny county, Pennsylvania, have invented a new and useful Method of Making Tapering Metal Poles, of which the following is a full, clear, and exact description, reference being had to the accompanying drawings, forming part of this specification, in which—

Figure 1 is a plan view of the rolled blank showing the method of cutting; Fig. 2 is an end view of the blank on a larger scale; Fig. 3 is a side elevation of the pole; and Figs. 4 and 5 are top and bottom plan views of the pole on a larger scale.

My invention relates to the manufacture of hollow metallic poles, and is designed to provide a simple, strong and efficient tubular steel pole which will do away with the use of nested sections and may be easily and cheaply made and to provide a simple and cheap method by which such poles may be made.

The invention consists in a pole formed of two longitudinal sections, each section having along one edge a recessed locking portion and at the other edge a plain interlocking portion, the plain interlocking portion of each being engaged in the recessed interlocking portion of the other.

The invention also consists in rolling blanks and simultaneously forming the recessed interlocking portion along one or both edges thereof and forming tapered blanks therefrom. In the preferred form a blank is rolled with the recessed interlocking portion along both edges, this section then being cut on an inclined line to the parallel edges of the rolled blank, so as to give two tapered blanks, these blanks then being bent and assembled.

In the drawings, Figs. 1 and 2 show the rolled blank. This blank is of rectangular form, with a web 2 and recessed interlocking portions 3 at each side. The blank is cut to the length desired for the pole, and is then severed on the diagonal line *a*—*a* of Fig. 1. The two blanks are then bent or pressed into a semi-circle or other curved form, and they are then placed with the larger ends together and assembled with the plain engaging edge portion 4 of each within the interlocking portion 3 of the other.

In the act of shearing, the plain edges will be somewhat upset; and these may be further upset by a special step if desired. Also, instead of upsetting the ends I may bend the lips of the interlock down on the plain edge or into recesses along each side of the plain edge portion. The sections are then preferably passed between rolls, at least one of which is yieldingly pressed against the interlock with sufficient force to press the lip from the rolled position shown in dotted lines in Fig. 4 to the engaging position shown in full lines therein. This step is preferably carried out while the pole is provided with a core or mandrel to receive and resist the pressure. One or both rolls may be connected to a pressure device having sufficient power to bend down the interlock while at the same time having enough stroke or travel to allow for the taper of the pole being formed as it passes therethrough.

The advantages of my invention will be apparent to those skilled in the art. The use of separate nested sections, as in ordinary poles, is done away with, no welding is required, and a strong and simple article is obtained. No rivets, bolts, or other separate securing means are employed. The pole may be cheaply made and turned out in large quantities at small labor cost.

Instead of rolling a blank with the recessed interlock at each edge thereof, I may roll blanks with the interlock at one edge thereof only and shear tapered blanks from such rolled sections. I may also bend the blank into semi-rectangular shape or into angular portions to make poles of other than circular cross-section.

I claim:—

The method of forming tapered metal poles, comprising rolling metal blanks having longitudinally extending recessed edge portions, severing the blanks diagonally into two longitudinally tapering sections, upset-

ting the cut edges of the resulting blanks to form thickened longitudinal edge portions, assembling a plurality of the blanks with the thickened edge portion of one section in the recessed edge portion of an adjoining section, and bending the sides of said recesses into interlocking engagement with the engaging thickened edge portion of the adjacent blank; substantially as described.

In testimony whereof, I have hereunto set my hand.

EDWIN E. SLICK.

Witnesses:

R. D. LITTLE,

H. M. CORWIN.