

J. F. LONG.

MANUFACTURE OF BUTT-PLATES FOR FIRE-ARMS.

No. 175,613.

Patented April 4, 1876.

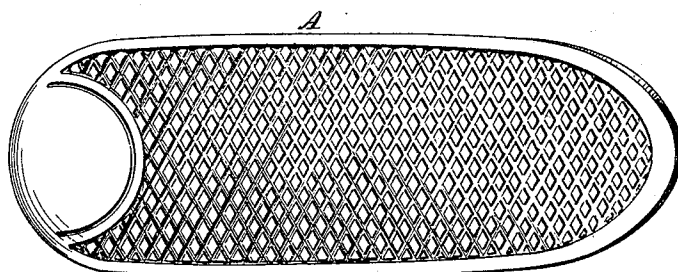


Fig. 1

Fig. 2

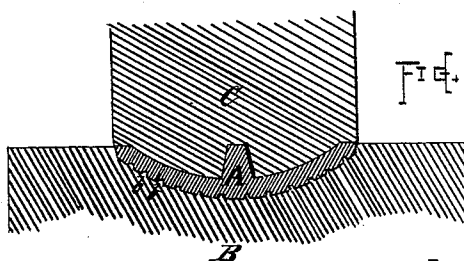
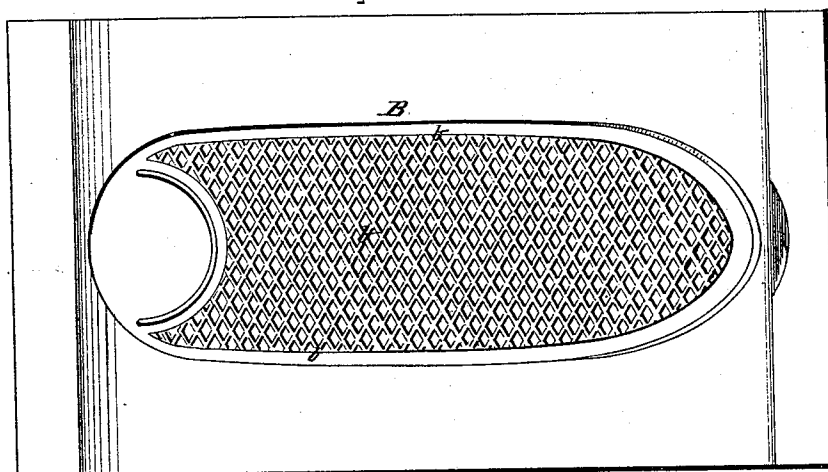


Fig. 3

Witnesses

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IMPROVEMENT IN THE MANUFACTURE OF BUTT-PLATES FOR FIRE-ARMS.

Specification forming part of Letters Patent No. **175,613**, dated April 4, 1876; application filed August 11, 1875.

To all whom it may concern:

Be it known that I, JOHN F. LONG, of the city and county of Providence and State of Rhode Island, have invented certain new and useful Improvements in the Manufacture of Butt-Plates for Fire-Arms; and I do hereby declare that the following is a full, clear, and exact description of the same, reference being had to the accompanying drawings, which form a part of this specification, and in which—

Figure 1 represents a face view of a butt-plate made in accordance with my invention. Fig. 2 represents a view of the forming matrix or die, and Fig. 3 represents a transverse vertical section through the dies and plate when in compressing position.

This invention relates to improvements in the manufacture of metal plates used upon the butts or stocks of fire-arms, and known as "butt-plates," the object of the invention being to cheapen the production, while, at the same time, producing a superior form of plate.

Heretofore, butt-plates having checked or roughened faces have been constructed by first forging out the plates, and finishing them by hand, and then engraving or cutting the checks by a milling-tool, or by hand graver.

In the drawing, A denotes the butt-plate. B indicates the lower die, and C the upper die.

My improved method of manufacture is as follows: The butt-plates A are first stamped

from bars of heated metal of proper thickness, and are compressed within the dies to nearly their required finished size and form. The edges of the plates are next trimmed to remove the fins or surplus metal. They are then reheated and placed between dies B C, and compressed to their proper finished size and form, the checking or roughening of the face of the plates being imparted by ridges or lines *b*, raised upon the surface of the matrix, as shown in Figs. 2 and 3, and at the same operation.

The plates thus produced are of superior finish, uniform in size and shape, and can be readily fitted to the gun-stocks without trouble, while the cost of production is but about one-fourth the cost of those constructed by the ordinary methods.

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

The within-described improved method of forming butt-plates for fire-arms, whereby the plate is shaped and its surface checked or lined at the same operation, substantially as set forth.

JOHN F. LONG.

Witnesses:

CHAS. H. BURLEIGH,
CHAS. B. LONG.