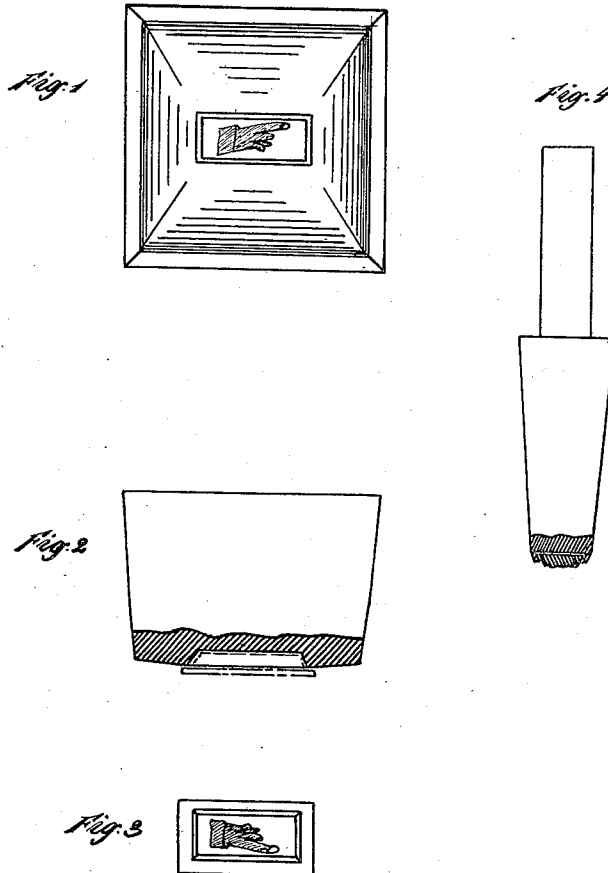


M. STAMM.
PROCESS FOR MAKING STEEL PUNCHES.
APPLICATION FILED JULY 17, 1911.

1,028,299.

Patented June 4, 1912.



Witnesses:

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Max Stamm

UNITED STATES PATENT OFFICE.

MAX STAMM, OF SOLINGEN, GERMANY.

PROCESS FOR MAKING STEEL PUNCHES.

1,028,299.

Specification of Letters Patent.

Patented June 4, 1912.

Application filed July 17, 1911. Serial No. 639,013.

To all whom it may concern:

Be it known that I, MAX STAMM, a subject of the German Emperor, and resident of Solingen, Germany, have invented certain new and useful Improvements in Processes for Making Steel Punches, of which the following is a specification.

This invention relates to an improved process for making steel punches, the so-called stroke or pressure punches, and it consists in that the writing or picture engraved in a matrix is by stroke or pressure copied on steel plates, which for intended use as stroke or pressure punches are fixed in a suitable holder.

Of particular importance in this process is the way of arranging the original writing or picture in the copying matrix, as the whole process is mainly dependent thereon. If, for instance, on the smooth surface of a matrix a writing would be engraved and attempts were made to copy the same on steel plates by stroke or pressure, the material of the steel plates would expand to the sides and consequently the writing or picture would be obliterated. This is avoided in the present process in that the writing or picture to be provided on the steel punches is engraved in an inwardly tapering hollow matrix, into which the steel plates are then beaten or pressed, whereby the material of the latter is compressed and the writing or picture is copied thereon. The finished

stamps show then inclined edges, which can preferably be used for attaching the same to a holder by a dovetail connection or the like.

The accompanying drawing shows how the process is put into practice.

Figures 1 and 2 are respectively an underside plan view and cross section of a matrix, the dotted lines in Fig. 2 indicating the steel plate, while Fig. 3 shows a plan view of the finished punch, and Fig. 4 its position in a holder, ready for use.

With the improved process, a large number of punches can be produced by using one and the same matrix.

I claim:

The process of making a stroke or pressure punch, consisting in taking an inwardly tapering hollow matrix having the writing or picture desired engraved therein, pressing or beating the metal from which the punch is to be made into the matrix in such manner as to produce a plate having the engraved writing or picture of the matrix copied thereon, and then attaching the plate to a suitable holder.

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

MAX STAMM.

Witnesses:

HENRY HASPER,
WOLDEMAR HAUPT.

Copies of this patent may be obtained for five cents each, by addressing the "Commissioner of Patents, Washington, D. C."