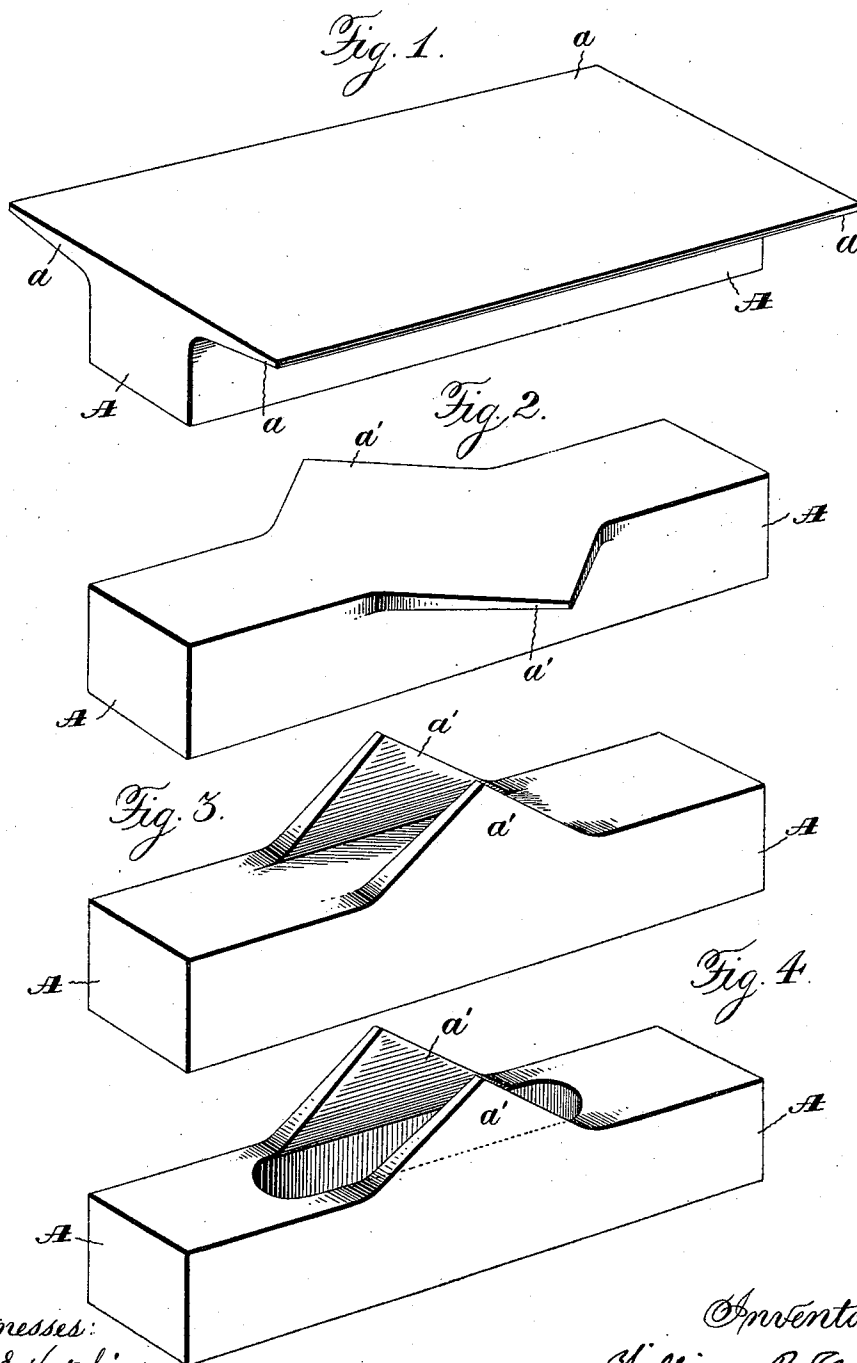


(No Model.)

W. R. JENKINS.
METHOD OF MAKING PICKS OR OTHER TOOLS.

No. 578,242.

Patented Mar. 2, 1897.



Witnesses:
Jas. E. Hutchinson.
Henry C. Hazard.

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his attorney

UNITED STATES PATENT OFFICE.

WILLIAM R. JENKINS, OF BELLEFONTE, PENNSYLVANIA.

METHOD OF MAKING PICKS OR OTHER TOOLS.

SPECIFICATION forming part of Letters Patent No. 578,242, dated March 2, 1897.

Application filed April 1, 1896. Serial No. 585,802. (No model.)

To all whom it may concern:

Be it known that I, WILLIAM R. JENKINS, of Bellefonte, in the county of Centre, and in the State of Pennsylvania, have invented certain new and useful Improvements in Methods of Making Picks or other Tools; and I do hereby declare that the following is a full, clear, and exact description thereof, reference being had to the accompanying drawings, in which—

Figure 1 is a perspective view of the blank in the form of a T-shaped bar. Fig. 2 is a like view of the same after portions of the side flanges have been removed. Fig. 3 is a similar view of said blank after the handle-engaging ears or lugs have been bent to position, and Fig. 4 is a perspective view of the same after the eye has been punched.

Letters of like name and kind refer to like parts in each of the figures.

The object of my invention is to provide a method for the easy, cheap, and rapid manufacture of picks, hatchets, and other tools that, adjacent to the eye on each side thereof, have an ear or projection to overlap and engage the side of the tool-handle; and to this end said invention consists in the method employed in making tools, substantially as and for the purpose hereinafter specified.

In the carrying of my invention into practice in the construction of picks I first form by rolling of suitable material—preferably soft steel—a straight bar that is T-shaped in cross-section, being composed of a heavy central body A and oppositely-projecting flanges a and a' . From such bar a piece of sufficient length is cut off to form the central body portion of the pick, and next portions of each of the flanges are removed, as by stamping or shearing, to produce at the longitudinal center of the bar ears or projections a' and a'' , one on each side. Said ears by suitable means are then bent at right angles to their original position, so as to lie parallel with each other, as shown in Fig. 3, and next the portion of the metal of the bar A in line with the space between said ears is punched out to form the eye for the reception of the handle, the result being shown in Fig. 4. The blank is now complete, except as to being given the customary curved shape, and when this has been done the pick is finished by

welding on the point-steels in the usual manner.

As all of the operations involved in forming the eye-ears can be done upon ordinary punching-machines, it will be seen that my method results in a better product and in the simpler, easier, and cheaper production of the blank than is the case with the customary process, in which the eye is first punched from a simple plain bar and then the ears forged out from the latter.

While I prefer the order of steps described hereinbefore, I wish it understood that I do not limit myself thereto; as the order of the operations may be changed without involving any departure from the scope of my invention, and instead of employing a blank of the form shown in Fig. 1, with the flanges projecting in opposite directions, a blank may be used having said flanges projecting from the bar parallel with each other in the direction in which the completed ears extend. I also wish it understood that I do not limit myself to any particular machinery or tools in the carrying out of my method.

Having thus described my invention, what I claim is—

1. The method employed in making tools having ears projecting adjacent to the eyes, which consists in forming a blank comprising a body having flanges at opposite sides, removing portions of each flange at each side of its longitudinal center, and forming an eye through the body portion of the blank that is in line with the space between the remaining flange portions, substantially as and for the purpose specified.

2. The method employed in making tools having ears projecting adjacent to the eyes, which consists in taking a blank comprising a body having two oppositely-projecting flanges, removing portions of the latter at each side of the longitudinal center of each flange, bending the remaining portions of said flanges to cause them to extend outwardly in lines parallel, or substantially parallel, with each other, and forming an eye through the body portion of the blank that is in line with the space between said flange portions after they have been so bent, substantially as and for the purpose shown.

3. The method employed in making tools

having ears projecting adjacent to the eyes,
which consists in taking a bar having two
oppositely-projecting flanges so as to be T-
shaped in cross-section cutting said bar into
5 blanks, taking each blank and removing por-
tions of each of said flanges, so as to leave a
lug or ear on each side of the blank, bending
said lugs at a right angle to make them pro-
ject outwardly from the blank in the same
10 direction, and then forming an eye in the

blank in line with the space between the lugs
or ears, substantially as and for the purpose
described.

In testimony that I claim the foregoing I
have hereunto set my hand this 4th day of 15
March, 1896.

WILLIAM R. JENKINS.

Witnesses:

N. B. SPANGLER,
ELLIS L. ONIS.