(No Model.)

W. HEWITT.

METHOD OF MAKING BARBED FENCE WIRE.

No. 276,039. Patented Apr. 17, 1883.

Fig. 2.

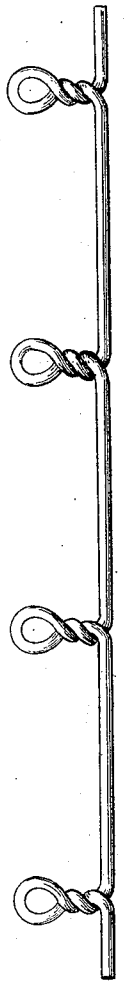


Fig. 3.



Fig. 5.

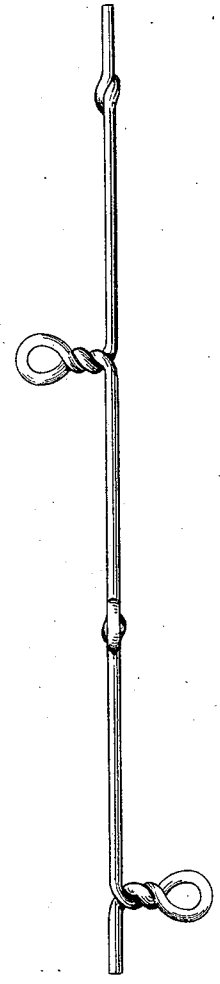


Fig. 6.

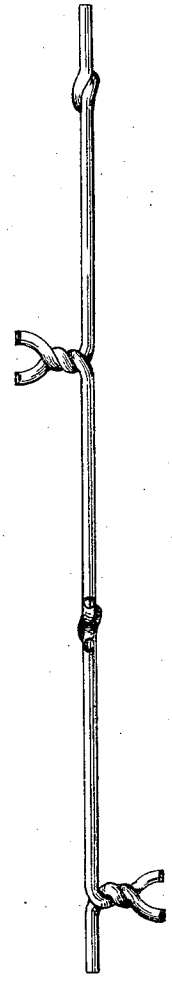


Fig. 1.

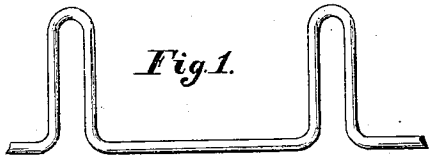
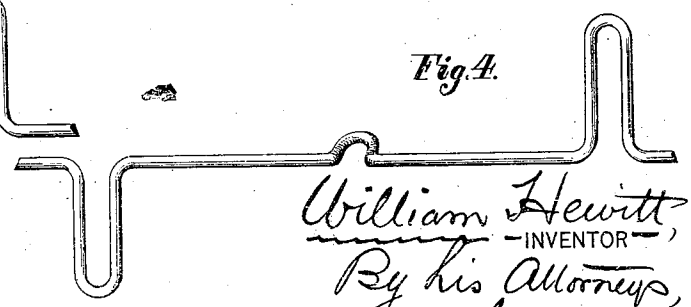


Fig. 4.



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UNITED STATES PATENT OFFICE.

WILLIAM HEWITT, OF TRENTON, NEW JERSEY, ASSIGNOR TO THE TRENTON IRON COMPANY, OF SAME PLACE.

METHOD OF MAKING BARBED FENCE-WIRE.

SPECIFICATION forming part of Letters Patent No. 276,039, dated April 17, 1883.

Application filed November 22, 1882. (No model.)

To all whom it may concern:

Be it known that I, WILLIAM HEWITT, of Trenton, New Jersey, have invented an Improved Method of Making Barb-Wire Fences, of which the following is a specification.

My method has for its object the manufacture of a barb fence-wire, in which both the barbs proper and the continuous lengths or strands of straight metal uniting the same are made out of one and the same single piece of wire, the said barb fence-wire being composed of a single strand at predetermined intervals along its length twisted upon itself, so as to form laterally-projecting necks or shanks terminated in one or two projecting extremities or barbs proper.

In the accompanying drawings I have represented, Figures 3 and 6, two preferred forms of such barb fence-wire as the practice of my method produces, and have also represented, as clearly as is possible, by pictorial illustrations, Figs. 1 and 2, 4 and 5, the several stages of said method. All the figures of the drawings are elevational views of sections of barb fence-wire, either as it appears in the process of making or after it has been completely made.

In the practice of my invention, providing myself with wire of the desired character, I by any convenient means first form an open or U-shaped loop by taking or pinching up a portion of the straight wire, and then twist up together the two sides of the open loop so pinched or taken up close to the straight longitudinal portions on either side of said open loop, so as to form a twisted shank bounded by the contiguous straight lengths at its base and externally terminated in a continuous closed loop. I have illustrated these steps in Figs. 1 and 2—in Fig. 1 representing the wire as pinched up at intervals to form open or U-shaped loops laterally extending and preferably right angular to the axis of the main wire or straight strand, and in Fig. 2 representing the U-shaped open loops shown in Fig. 1, twisted tightly upon themselves for a portion of their length, commencing from the straight portions or strands, and beyond such twisted portions or stems terminated in a continuous closed loop substantially of the character represented. Having formed these twisted shanks and closed loops, I sever the latter, preferably transversely across on a line parallel with the strands or straight lengths, and thus form such a barbed fence-wire as is represented in Fig. 3.

In Fig. 4 I have represented a method of forming the U-shaped or open loops, which are first pinched up from the straight wire, on opposite sides thereof; and in Fig. 5 I have represented these open loops twisted together to form twisted shanks with continuous closed loops at their outer extremities, and each twist projected in a plane at right angles to its neighbor, in the manner clearly represented in the drawings, and in such manner that every fourth loop trends in the same direction.

In Fig 6 I have represented the loops of the twisted wire of Fig. 5 cut off to form points beyond the twist.

It is obvious that it is inconsequential to the practicing of the invention proper as to what amount of wire is pinched up to form the twisted shank and closed loop, or as to what extent the twisting is carried, provided that a closed loop be formed beyond the twist, which loop is adapted to be cut or divided to leave one or two projecting ends, substantially as shown. This cut is preferably made, as stated, transversely across the loop, as represented in Figs. 3 and 6; but it may be made so as to leave but one spur or extremity. This, however, is not to be understood as restrictive of any preferred section of the loop, the object being to nip, as it were, a piece out of the loop, so as to leave two projecting points or barbs. The direction which the twists shall take from the main strand is also indifferent, as all twists may point in the same direction, or as all may lie in the same plane, but point alternately on opposite sides of the strands, or, as is probably advisable in practice, as all may point in separate and independent directions.

It is obvious that any method or wire-looping machine may be employed to effect the looping of the wire, although such a machine as was patented to William Wilson, Jr., in and by Reissued Letters Patent No. 9,404, dated October 12, 1880, is well adapted, with slight modifications, for the purpose.

The wire produced by the above method is not only easily made, but is less expensive than many other barb-wires now in use.

In cutting off the loop it is preferable to cut from both sides inwardly, so as to form an awl-edge on the projecting extremities of the divided loop, as shown in the drawings. This, however, is not essential.

Having thus described my invention, I claim and desire to secure by Letters Patent—

The method of making a barbed fence-wire, which consists, first, in taking a piece of wire of any desired material and thickness, and at predetermined intervals along the length thereof forming a twist terminated in a loop, both twist and loop being formed of the wire itself, and being projected from the straight portion or strand thereof; and, second, in cutting out or off a portion of the loop in such a manner as to leave two projecting ends of wire beyond the twisted portion, substantially as set forth.

In testimony whereof I have hereunto signed my name this 18th day of November, A. D. 1882.

WM. HEWITT.

In presence of—

J. BONSALL TAYLOR,

ROBERT J. OWEN.