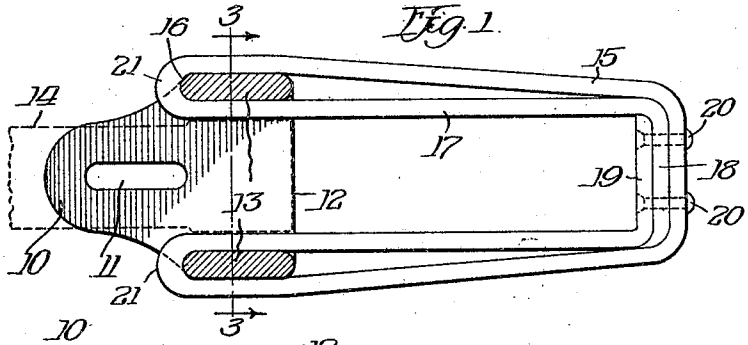
Dec. 19, 1922. 1,439,659.

C. E. BAUER.

DRAWBAR YOKE AND METHOD OF MAKING THE SAME.

FILED JULY 15, 1921.

Fig. 1.



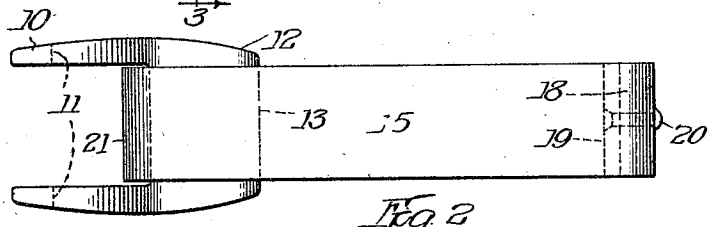
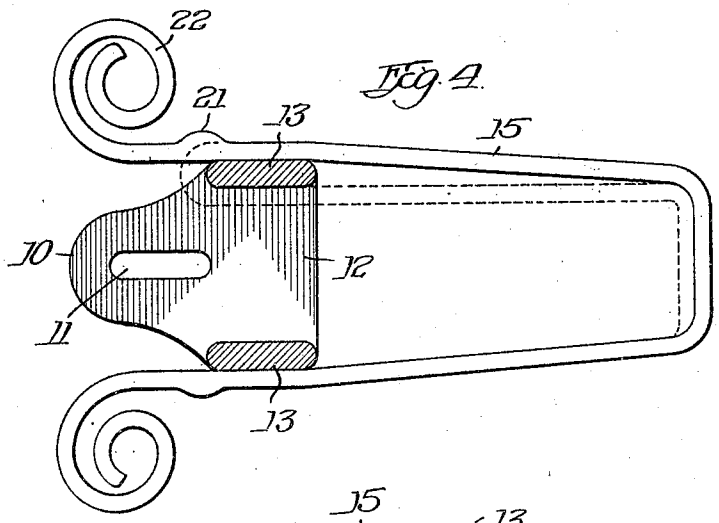


Fig. 2

Fig. 4.



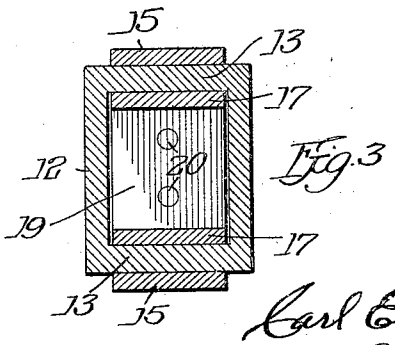


Fig. 3

Witnesses:

Inventor

Carl E. Bauer

By Murray, Hatz & Nelson Attys.

Patented Dec. 19, 1922. 1,439,659

UNITED STATES PATENT OFFICE.

CARL E. BAUER, OF HAMMOND, INDIANA.

DRAWBAR YOKE AND METHOD OF MAKING THE SAME.

Application filed July 15, 1921. Serial No. 484,936.

To all whom it may concern:

Be it known that I, CARL E. BAUER, a citizen of the United States, and resident of Hammond, in the county of Lake and State of Indiana, have invented certain new and useful Improvements in a Drawbar Yoke and Method of Making the Same, of which the following is a specification.

My invention relates to draft rigging appliances and particularly to a novel draw bar yoke.

One of the objects of my invention is to provide a draw bar yoke, which may be very economically produced and which shall possess unusual strength and rigidity. The structure is adapted for a simple form of connection between the head and yoke strap without the necessity for perforating or riveting the parts.

The desired result is secured by providing a hollow head in the form of a sleeve adapted to engage the butt of a drawbar by the usual key, a yoke strap in the form of a double loop engaging the head and accomplishing the usual function of such straps. The strap is very simply shaped to occupy its final position and a description of the method and of the finished structure follows.

The invention will be better understood by reference to the accompanying drawings, wherein,

Fig. 1 is a view of a yoke constructed in accordance with my invention, the top and bottom members of the head being shown in section;

Fig. 2 is a plan view thereof;

Fig. 3 is a sectional view on the line 3—3 of Fig. 1, and,

Fig. 4 is a view similar to Fig. 1, showing the preliminary stage of manufacture of the device.

In the drawings it will be seen that I provide a head having ears 10, slotted as at 11, the ears being integral with walls 12, 13. The walls constitute a sleeve having a rectangular opening adapted to accommodate a drawbar butt, indicated at 14. The strap consists of a long, relatively thin bar of metal, bent into a U-shaped member 15, the arms of which extend diagonally to the outer extremities of the walls 13, thence around the forward edges 16 thereof, thence inwardly forming a second U-shaped member 17. The free ends 18, 19, of the strap, as best shown in Fig. 1, are overlapped at the inner rear end of the yoke and may, if desired, be held in position by means of rivets 20, although these will, in many cases, be found to be unnecessary. The metal of the strap, at the bend around the forward edge of the walls 13, is thickened as at 21, in order to provide greater strength.

In the process of manufacture the yoke strap is first forged to upset the portion 21, and then shaped, as shown in Fig. 4, with the extremities curled up, as at 22. These curled up ends are then successively bent laterally into the plane of the opening through the head and then forced inwardly through the opening into their final position. One of the straps shown in Fig. 4 is indicated by dotted lines in its final position.

It is obvious that the construction may be modified to a material extent without departure from the spirit of my invention. The relation of the inner and outer straps so far as the ends of the device are concerned may be reversed if desired and other modifications may be made within the scope of my claims.

I claim:

1. The method of making drawbar yokes which consists in providing a head, then bending a bar into U-shape and rolling up the ends thereof, then associating the bar with the head and successively forcing the rolled up ends through said head and causing the material of said rolled up ends to conform to the interior of the U-shaped portion of the yoke.

2. The method of uniting a head and yoke strap which consists in bending the strap into U-shape with the terminal portions rolled up, then forcing said rolled up ends through the head and simultaneously unrolling them and causing the material to conform to the general contour of the interior of the U-shaped portion.

3. The method of uniting a head and yoke strap which consists in bending the strap into U-shape with the terminal portions rolled up, then forcing said rolled up ends through the head and simultaneously unrolling them and causing the material to conform to the general contour of the interior of the U-shaped portion with the free ends of the strap in overlapping relation at the rear end of the yoke.

4. The method of making a yoke having a head and double straps, which consists in upsetting and thickening a portion of the strap at the point of bend around the head,

then doubling the strap upon itself and rolling up the portions which are to constitute the inner portions of the double strap, then successively forcing said rolled up portions through said head at the same time unrolling the same and causing the free end of one strap to overlie the free end of the other strap at the inner end of the yoke.

5. A yoke comprising in combination a head and a strap, the strap being in the form of a double loop engaging the head, the free ends of which strap overlie each other inside of the yoke at its rear end.

6. A yoke comprising in combination a head and a yoke strap, said strap being in the form of connected double loops, one loop contained within the other, the head being held between the straps at the junction of the two loops.

7. A yoke comprising in combination a head and a pair of U-shaped straps one within the other and formed by bending a strap inwardly around the side portions of the head, the free ends of the strap being located inside and at the rear or closed end of the U.

Signed at Chicago, Ill., this 11th day of July, 1921.

CARL E. BAUER.