

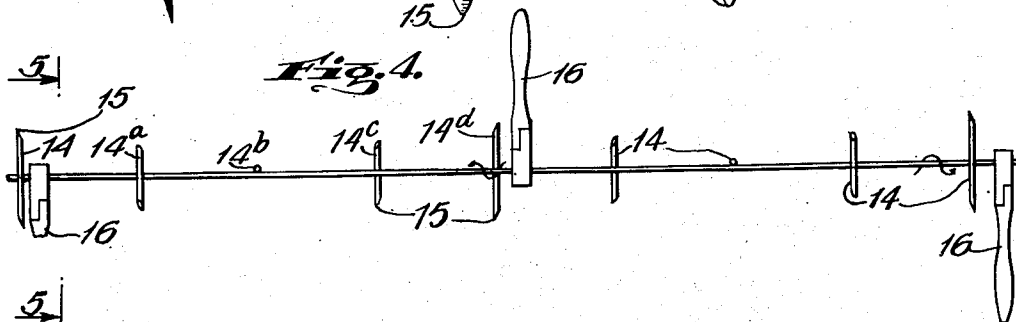
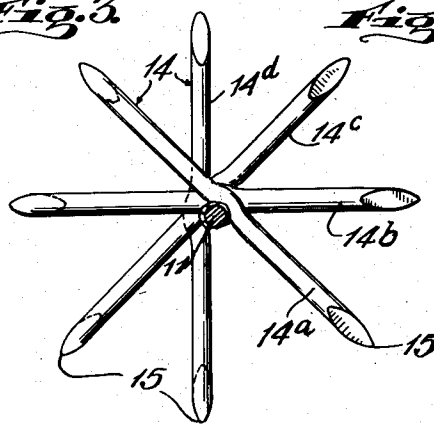
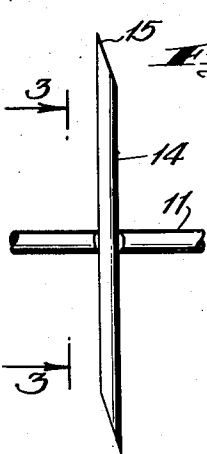
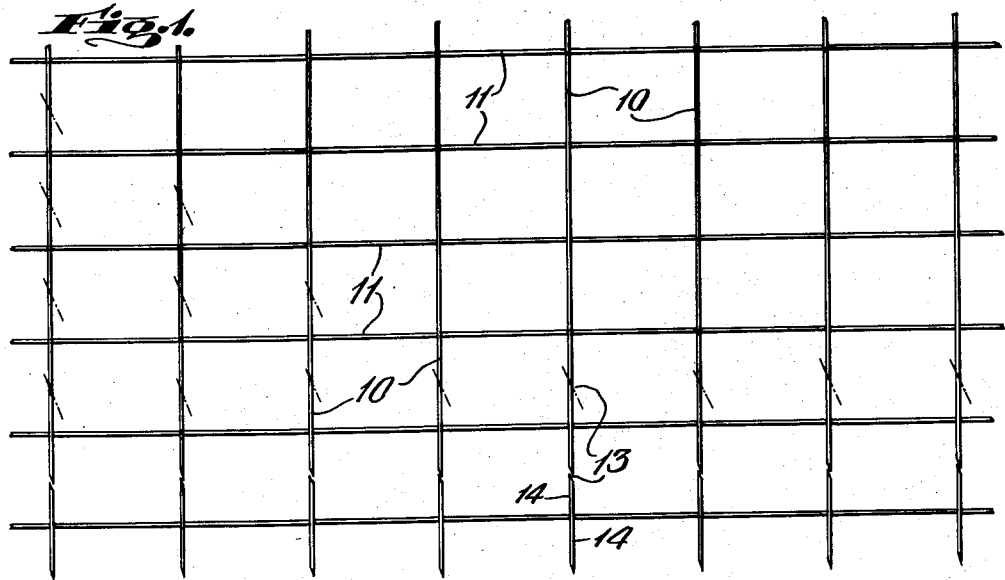
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BARBED WIRE AND METHOD OF MAKING SAME

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BARBED WIRE AND METHOD OF MAKING
SAME

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3 Claims. (Cl. 140—58)

This invention relates to barbed wires and method of making the same.

Among the objects of my invention are the provision of an improved barbed wire and an improved method of constructing barbed wire in which the barbs are arranged in different angular planes and in which such different angular arrangement of barbs is produced by twisting sections of the barb carrying wire or strand in opposite directions so that the barbed wire or strand as a whole will have no tendency to twist and coil as it is wound on the reel or is unreel and after it has been laid or strung in position.

Other objects of the invention appear from the following description taken in connection with the drawing, in which

Fig. 1 is a plan view of a mesh constructed of longitudinally extending strand wires and transversely extended barbing wires with some of the barbing wires cut to provide barbs;

Fig. 2 is a side view of a strand and a barb;

Fig. 3 is a view on the line 3—3 of Fig. 2;

Fig. 4 is a view disclosing steps of twisting the strand; and

Fig. 5 is a view taken on the line 5—5 of Fig. 4.

The barbed wire may be produced by welding the barbing wire 10 as indicated in Fig. 1 to strands 11 in right angular relation as disclosed in Fig. 1, or in any other angular relation as desired. The diameters of the barbing wire and strands may be the same or different as found desirable. After the mesh has been produced the barbing wire may be cut between the strands as indicated at 13 to produce barbs as indicated at 14 in all of the figures. Preferably the barbing wire is sheared obliquely at a suitable angle to produce sharp prods 15.

To make the barbed wire more effective, the barbed wire or strand may be twisted by any suitable means, such as hand tools 16 disclosed in Fig. 4, such means being suitable where the strand is of a small gauge and in this case the twisting may be effected by the user at the place where the barbed wire is installed. The ends of a length of the barbed wire may be seized by the clamping devices 16 and as disclosed in the left half of Fig. 4 a length of wire carrying four barbs is twisted as indicated by the arrows until the barbs assume the relation disclosed in Fig. 5 as indicated by 14a, 14b, 14c, and 14d. The adjacent section of the barbed wire to the right and of equal length is then twisted in the opposite direction as indicated by the arrow at the right end of the figure until the barbs assume the relative angular positions disclosed in Fig. 5.

The tools 16 are preferably placed to grip the strand adjacent to the barbs as indicated in Fig. 4, the tool at the left of the figure being at the right side of the first barb on the strand and the tool in the middle of the figure at the right side of the last barb of the first series of barbs. In this way when the section of the strand is twisted as indicated by the arrows the barb 14a will be moved into the same angular relation with respect to the first barb as that of the barb 14b with respect to the barb 14a etc. By gripping the second section of the strand at the points indicated and rotating the tool 16 at the right of the figure in the direction of the arrow the first barb of the second series will be twisted angularly with respect to the last barb 14d of the first series and into the plane of the barb 14c. In this way all adjacent barbs will be angularly related and the amount of twist of the sections of strands between the barbs will be the same. The angular relation of the adjacent barbs of adjacent series may be made exactly the same as that of adjacent barbs of the series by gripping the strand at the barbs instead of adjacent thereto.

In cases where the adjacent barbs of adjacent series may be in the same plane, the center portions of the sections between the barbs may be gripped, and, if desired, by three tools and the center tool rotated.

It is obvious, of course, that if a different arrangement of the barbs is desired that lengths of the barbed wire supporting a smaller or larger number of barbs may be seized and twisted. If it is desired to arrange the barbs in the position disclosed in 14a and 14b, Fig. 5 then a length carrying but two barbs would be twisted. If it were desired to arrange the barbs as disclosed at 14a, 14b and 14c, then a section of the wire carrying three barbs would be twisted. The barb 14a, Fig. 5 is the first twisted barb on the left in Fig. 4. The first barb on the second length will be in the same angular position as barb 14c and on the same side of the strand.

The strands may be twisted at the factory as in the case in which the strands are of heavy gauge and the strands and barbs may be case-hardened.

While I have disclosed one form of barbed wire produced by the method specifically described, it is to be understood that I reserve the right to all such changes in the barbed wire and the method of making the same as fall within the principles of my invention and the scope of the appended claims.

I claim:

1. The method of producing a barbed wire with its barbs arranged in angularly related planes from a barbed wire having its barbs arranged in the same plane, which consists in twisting the ends of a section of the barbed wire carrying a series of barbs relatively in opposite directions and in twisting the corresponding ends of an adjacent similar section relatively in opposite directions with respect to each other and with respect to the direction of twisting of the corresponding ends of said first section.

2. The method of producing a barbed wire with its barbs arranged in angularly related planes from a barbed wire having its barbs arranged in

the same plane, which consists in seizing a section of the wire carrying a series of barbs, at points adjacent to and on the same side of an end barb of the series and the barb outside of the series and next to the other end barb of the series and in twisting said section in one direction, and in similarly seizing an adjacent section of the wire carrying a series of an equal number of barbs and in twisting said section in an opposite direction.

3. A barbed wire comprising a strand having adjacent sections twisted in opposite directions and a series of barbs connected to each of said sections of said strand.

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