

No. 896,155.

PATENTED AUG. 18, 1908.

W. F. RING.
METHOD OF FORMING ANVILS.
APPLICATION FILED JAN. 11, 1907.

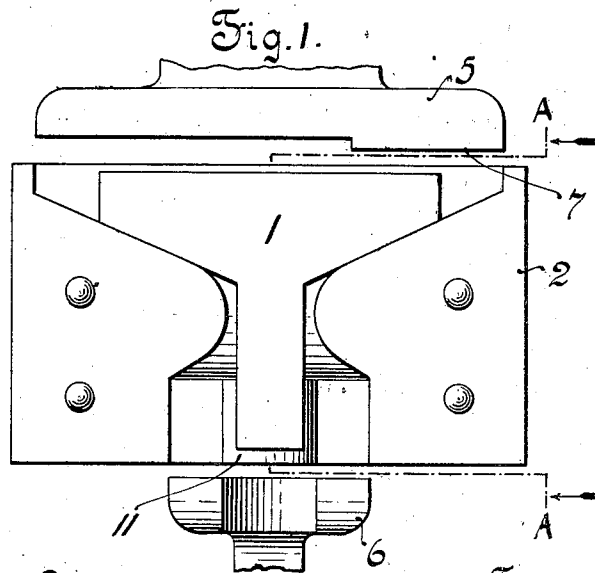


Fig. 2.

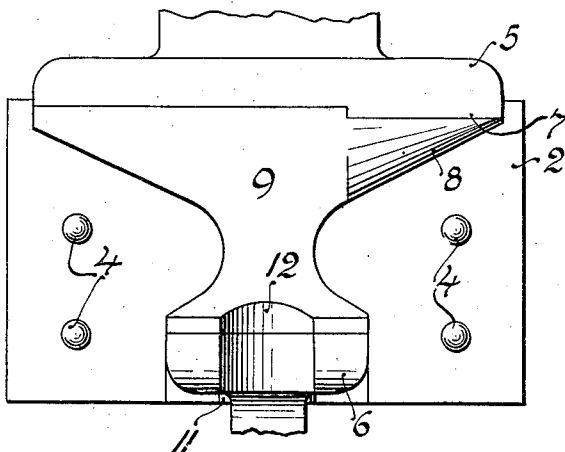


Fig. 3.

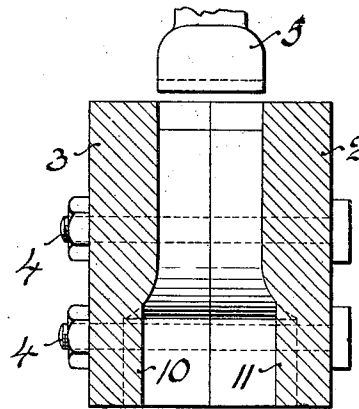


Fig. 4.

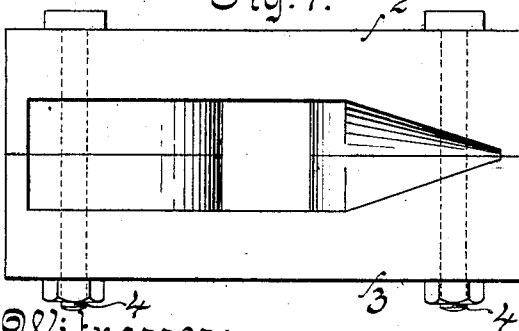
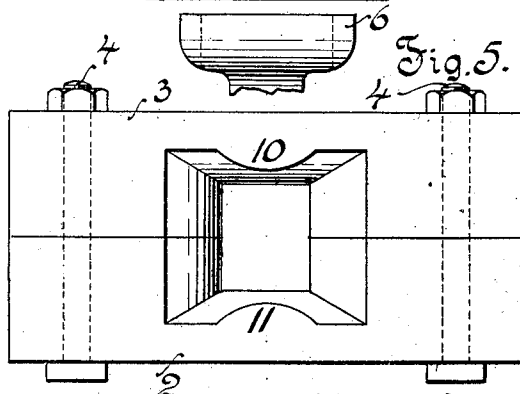


Fig. 5.



Witnesses:
Cyril Browne.
Harry Thorne.

Inventor
Walter F. Ring.
By attorney
Hornum & Howard

UNITED STATES PATENT OFFICE.

WALTER F. RING, OF NEW YORK, N. Y.

METHOD OF FORMING ANVILS.

No. 896,155

Specification of Letters Patent.

Patented Aug. 18, 1908.

Application filed January 11, 1907. Serial No. 351,853.

To all whom it may concern:

Be it known that I, WALTER F. RING, a citizen of the United States, and resident of the borough of Queens, in the city and State of New York, have invented a new and useful Method of Forming Anvils, of which the following is a specification.

My invention relates to the method of making anvils, with the object in view of forming an anvil in an expeditious manner and consists broadly in subjecting a blank held in a die to pressure upon its opposite ends to press the blank into shape with its top and bottom of greater cross section than the narrowest part of the die chamber.

Means for carrying my method into practical effect are represented in the accompanying drawings, in which

Figure 1 is a view of the inside face of one-half of the die in elevation showing the blank therein and the plunger heads in position to approach each other to press the blank into shape, Fig. 2 is a similar view showing the plungers in their advanced position and the anvil formed, Fig. 3 is a transverse section through the die in the plane of the line A—A of Fig. 1, the blank being removed, Fig. 4 is a top plan view of the die with the blank removed, and Fig. 5 is a bottom plan view of the die.

The blank is denoted by 1. It is of a general T-shape and its lower or stem portion is intended to be about the width of the space between the side walls of the die and extends downwardly below the point which the bottom of the formed anvil is to occupy to supply the metal for forming the base of the anvil while the top portion of the blank is composed of a mass of metal sufficient to fill the die between the advanced positions of the plungers.

The die is formed in two sections, denoted, respectively, by 2 and 3, which sections are intended to be firmly held together by suitable means, such, for instance, as bolts leaving between them a space of such size and shape as may be required to form the anvil.

The top plunger is denoted by 5 and the bottom plunger by 6. The top plunger is intended to fit with a close sliding fit the upper portion of the die chamber and is pro-

vided with a projecting lip 7 for off-setting the horn 8 of the anvil from the body portion 9.

The base portion of the die chamber is provided with rounded cheek pieces 10 and 11 projecting inwardly from the opposite sides thereof for the purpose of forming a curved recess 12 in each of the opposite sides of the base of the completed anvil.

In operation, the half sections of the die having been fastened firmly together and the blank 1 having been properly heated and placed in position as shown in Fig. 1, the plungers 5 and 6 are caused to approach each other by any well known or approved means not shown herein, and the blank 1 is thereby pressed into the form of the anvil 8, 9, 12. The plungers are then withdrawn and the half sections of the die are separated to permit the removal of the completed anvil. The process is preferably carried out by a single operation by causing the plungers 5 and 6 to move simultaneously toward each other to act upon the blank. During this process, the base of the blank has been pressed outwardly into a form wider than the narrowest part of the die chamber and the top has also been further elongated and formed but the completed anvil is readily removed by separating the half sections of the die.

What I claim is:—

The method of forming an anvil in a single operation consisting in seating a T-shaped blank within a die chamber shaped to form the walls of the anvil and having a contracted portion intermediate of the top and bottom of lesser width and length than the base and head of the completed anvil and simultaneously exerting pressure upon the opposite ends of the seated blank thereby forcing the blank laterally against the walls of the die chamber to form the top and bottom of the anvil of greater length and width than the most contracted portion of the die chamber.

In testimony, that I claim the foregoing as my invention, I have signed my name in presence of two witnesses, this 7th day of January 1907.

WALTER F. RING.

Witnesses:

HENRY THIEME,

F. GEORGE BARRY.