

No. 878,871.

PATENTED FEB. 11, 1908.

J. H. DODS.

METHOD OF MAKING WROUGHT ARTICLES.

APPLICATION FILED AUG. 26, 1907.

Fig. I.

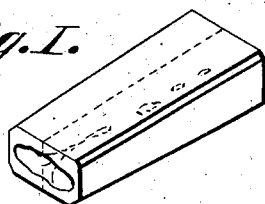


Fig. II.

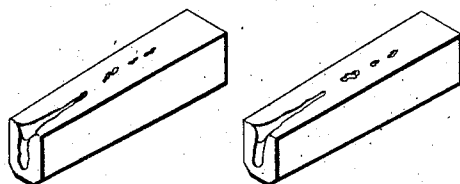


Fig. III.

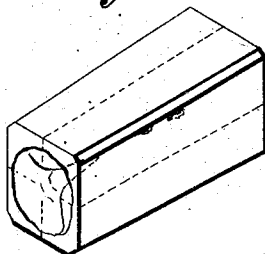
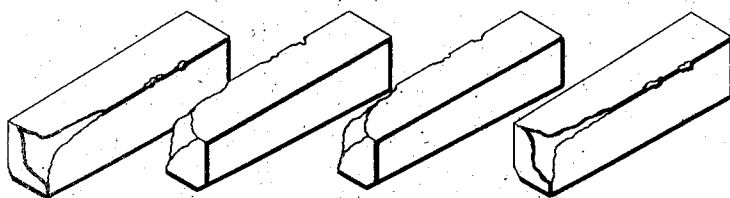


Fig. IV.



Attest.

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METHOD OF MAKING WROUGHT ARTICLES.

No. 878,871.

Specification of Letters Patent.

Patented Feb. 11, 1908.

Application filed August 26, 1907. Serial No. 390,131.

To all whom it may concern:

Be it known that I, JOHN H. DODS, a citizen of the United States of America, residing in Cherryvale, in the county of Montgomery and State of Kansas, have invented certain new and useful Improvements in the Method of Making Wrought Articles, of which the following is a full, clear, and exact description, reference being had to the accompanying drawing, forming part of this specification.

In making wrought articles such as steel rails and other sections of rolled metal there will be found in the center of the ingot, before it is passed through the rolls, an open and a more or less honey-comb portion commonly called the "pipe" of the ingot, and when the articles are rolled as the art is now practiced, this pipe is only imperfectly removed or destroyed because of its being surrounded by a more homogeneous or compact mass of metal, the result being an imperfect article.

The object of my invention is to overcome the above mentioned objection in making or rolling wrought articles such as steel or other metal rails or sections and this I accomplish by casting the ingot larger in cross section than the desired or required size for passing through the rolls (twice or four times as large) and then splitting it longitudinally into two or four pieces so as to bring the pipe to the outside, the result being that when the ingot is passed through the rolls the pipe

will be rolled out in the first few passes of the ingot through the rolls. 35

In the accompanying drawings: Figure I represents an ingot of twice the size desired for passing it through the rolls and the dotted lines show how it is split or cut into two pieces to expose the pipe to the action of the rolls. Fig. II shows the ingot of Fig. I as it appears when cut into two pieces, this view being presented for the purpose of more clearly bringing out or showing the pipe that exists in ingots. Fig. III represents an ingot 45 four times the size desired for passing through the rolls, and the dotted lines show how it is split or cut to bring the parts down to the desired size. Fig. IV bears the same relation to Fig. III that Fig. II does to Fig. I. 50

By making rails according to my improved method the pipe is entirely removed from the finished article.

I claim:

The improved method herein described of 55 making wrought articles which consists of casting an ingot of larger cross section than is necessary for the finished article, then splitting the ingot longitudinally through its pipe portion to expose the pipe of the ingot, and 60 finally reducing the parts.

JOHN H. DODS.

In presence of—

ROBERT H. SCURLOCK,
JOHN C. DODS.