

(No Model.)

W. C. WOOD.
BLANK FOR GIRDER RAIL CLAMPS.

No. 460,517.

Patented Sept. 29, 1891.

Fig. 1.

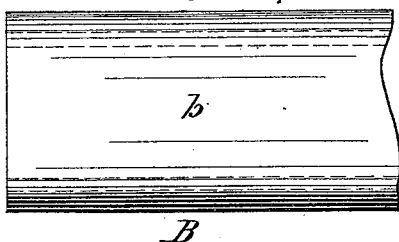


Fig. 2.

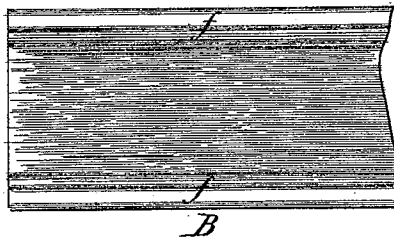


Fig. 3.

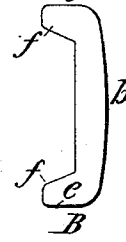


Fig. 4.

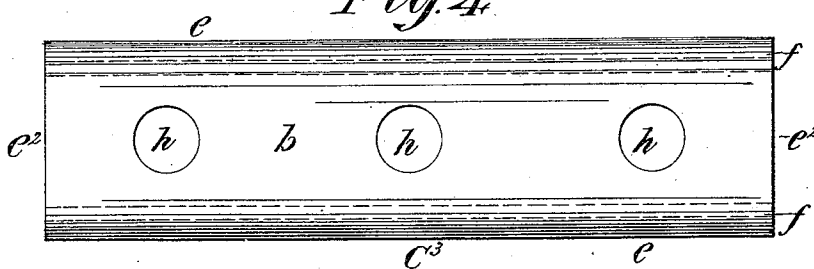


Fig. 5.

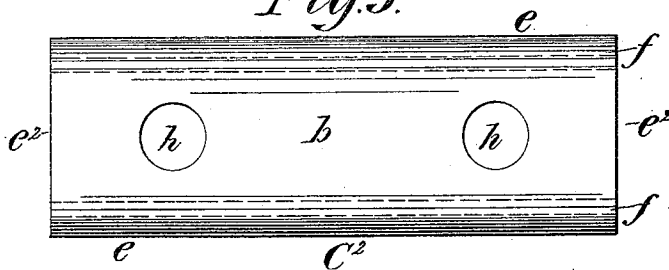
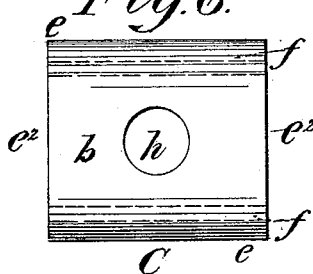


Fig. 6.



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WILLIAM CLARK WOOD, OF BROOKLYN, NEW YORK, ASSIGNOR TO THE
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BLANK FOR GIRDER-RAIL CLAMPS.

SPECIFICATION forming part of Letters Patent No. 460,517, dated September 29, 1891.

Application filed November 6, 1890. Serial No. 370,510. (No model.)

To all whom it may concern:

Be it known that I, WILLIAM CLARK WOOD, a citizen of the United States, and a resident of Brooklyn, in the State of New York, have
5 invented a new and useful Improvement in Blanks for Girder-Rail Clamps, of which the following is a specification.

This invention relates to means for economically producing a superior quality of clamps
10 of wrought-iron or steel, for use in connection with girder-rails and their fastenings, as set forth in my specifications forming part of United States Letters Patent No. 433,923, dated August 5, 1890, and No. 450,594, dated
15 April 14, 1891. Such clamps have heretofore been produced of inferior patterns, either by casting them or by bending flat bars transversely into shape.

The present invention consists in a novel
20 blank, as hereinafter set forth and claimed, adapted to be converted by punching and shearing into girder-rail clamps of any required length, each provided with one or more bolt-holes and having at opposite edges
25 smooth wedging inclines, and possessing throughout its length peculiarly great strength and rigidity in a transverse direction, which is its direction of greatest strain.

A sheet of drawings accompanies this specification as part thereof.

Figures 1, 2, and 3 of the drawings are, respectively, back, face, and end views of the said blank; and Figs. 4, 5, and 6 are back
35 views of punched clamps of different lengths cut therefrom.

Like letters of reference indicate corresponding parts in the several figures.

In carrying this invention into effect I take a billet of suitable metal and reduce it by a series of passes in a rolling-mill to a novel
40 blank B of the peculiar character represented by Figs. 1, 2, and 3. The essential characteristics of the said blank are continuous or indefinite length and uniform cross-section, together with its peculiar channel-bar shape,

which comprises a transversely-arched back *b* and internally-beveled longitudinal flanges *ff* at the respective edges of its face, Fig. 2. Between the bevels of the flanges the face is conveniently flat, and the outer edges *e* of the
50 bar, including the outer sides of said flanges *f*, may be and preferably are parallel with each other, and connected with the arch of the back by rounded shoulders; but this is not considered essential. By feeding one end
55 of the blank beneath a shearing-blade and one or more punches it is provided with one or more punched bolt-holes *h* and is cut off of the proper length for a clamp *C*³ or *C*² or *C*, Figs. 4, 5, and 6, the ends *e*² *e*² being also
60 squared by the shearing.

Suitable apparatus for carrying the process of manufacture into effect will be readily constructed by those skilled in the art without further instructions and forms no part of
65 this invention.

It will be observed that the internally-beveled flanges *ff* of the clamps receive their final form in the rolls, their bevels, which
70 coact with other wedging flanges and projections in use, being thus readily shaped with perfection, and that the transversely-arched back *b* is also thus readily produced and renders the clamps very rigid and strong in their direction of greatest strain, as aforesaid.

Having thus described the said improvement, I claim as my invention and desire to patent under this specification—

The blank B, of bar iron or steel rolled in continuous lengths of uniform cross-section
80 from end to end, having a transversely-arched back *b* and internally-beveled longitudinal flanges *ff* at the respective edges of its face and adapted to be converted into girder-rail clamps by punching and shearing, substantially as shown and described.

WILLIAM CLARK WOOD.

Witnesses:

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