Jan. 14, 1930. E. D. PRIEST 1,743,390

METHOD OF MAKING BELAYING CLEATS

Filed May 2, 1927

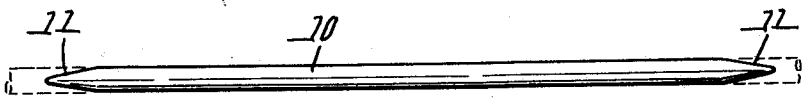


Fig. 1.

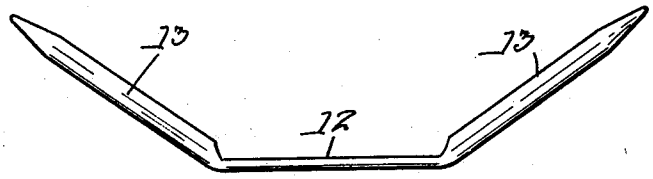


Fig. 2.

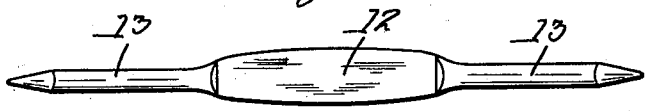


Fig. 3.

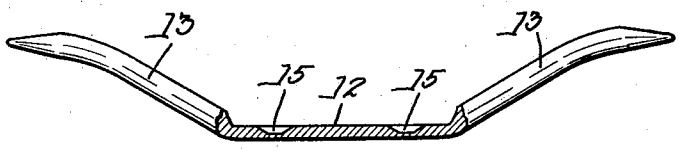


Fig. 4.

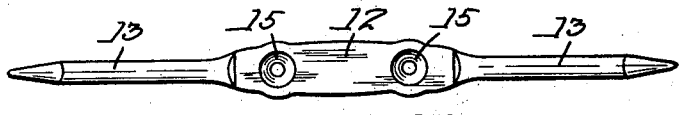


Fig. 5.

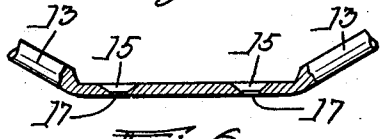


Fig. 6.

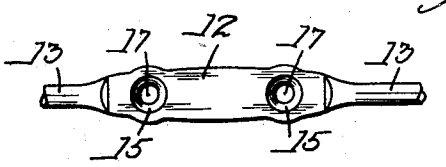


Fig. 7.

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UNITED STATES PATENT OFFICE

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METHOD OF MAKING BELAYING CLEATS

Application filed May 2, 1927. Serial No. 188,137.

This invention relates to a belaying cleat such as is commonly used for holding a rope on shipboard or elsewhere.

It is the general object of my invention to improve the construction of such belaying cleats, preferably forming the same of round wire rods by few and simple operations. Further objects are to provide a cleat having a firm attaching surface and having the necessary screw holes formed therein without materially weakening the structure of the cleat at the point where the screw holes are formed.

My invention further relates to an improved method of procedure in the formation of a belaying cleat, and to certain arrangements and combinations of parts which will be hereinafter described and more particularly pointed out in the appended claims.

A preferred form of the invention is shown in the drawings in which—

Fig. 1 shows a portion of a round rod, cut off and bluntly pointed;

Figs. 2 and 3 are side and plan views showing further steps in the formation of my improved cleat;

Figs. 4 and 5 are similar views showing succeeding steps in the procedure; and

Figs. 6 and 7 are partial similar views showing the formation of the finished cleat.

Referring to the drawings my improved cleat is formed from pieces of round wire rod 10, which are preferably bluntly pointed in any convenient manner as indicated at 11. The rod 10 is then submitted to a pressing or punching operation by which the middle portion 12 is flattened and the stock is preferably forced entirely to one side of the rod. The ends 13 of the rod are bent upward, either at the same pressing operation or at a subsequent operation as may be preferred.

I then form countersunk depressions 15 in the middle portion 12 of the rod by forcing a blunt pointed punch into the portion 12, without removal of any of the stock. By this operation the stock is forced outward, as indicated in Fig. 5, thus providing countersunk depressions while retaining substantially as great a cross section of material at the point where the countersunk depressions are formed as at points between the depressions.

The extreme ends of the end portions 13 may be bent downward at this same operation or at a subsequent operation, to the position indicated in Fig. 4.

The cleat is then completed by cutting through the bottoms of the depressions 15, as indicated at 17 in Figs. 6 and 7. As the stock is very thin at this point, the cutting of the perforations removes only a very small portion of the stock, and the countersunk holes are formed without substantially weakening the cleat at the point where the screw holes are formed.

The formation of the screw holes in the manner above described is a matter of very great importance, as the usual cleat formed from round stock is very much weakened by the provision of countersunk screw holes therein, on account of the large amount of stock removed in forming the countersunk holes.

Having thus described my invention and the advantages thereof, it will be evident that the number of separate operations may be varied somewhat. The cutting and pointing may be done by pointing dies, as a single operation and the flattening, bending, and formation of counter-sunk depressions may constitute either one, two or three steps as preferred, depending somewhat on the size of the stock.

I do not wish to be limited to the details herein disclosed otherwise than as forth in the claims, but what I claim is:—

1. The method of making a belaying cleat which consists in taking a piece of round wire rod, flattening the middle portion, punching countersunk depressions in the flattened portions and forcing the stock outward around said depressions without removal of stock, and perforating the thin bottom portions only of said countersunk depressions.

2. The method of making a belaying cleat which consists in taking a piece of round wire rod, bluntly pointing the same, flattening the middle portion and forcing all of the stock to one side of the rod, bending upward the end

portions, bending the extreme end portions downward, punching countersunk depressions in the flattened portion and forcing the stock outward around said depressions without removal of the stock, and perforating the thin bottom portions only of said countersunk depressions.

In testimony whereof I have hereunto affixed my signature.

EDWARD D. PRIEST.