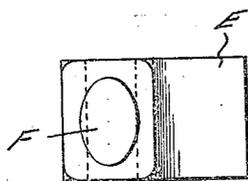
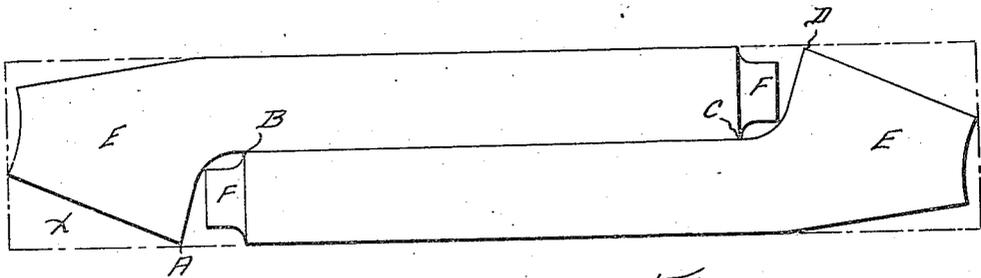
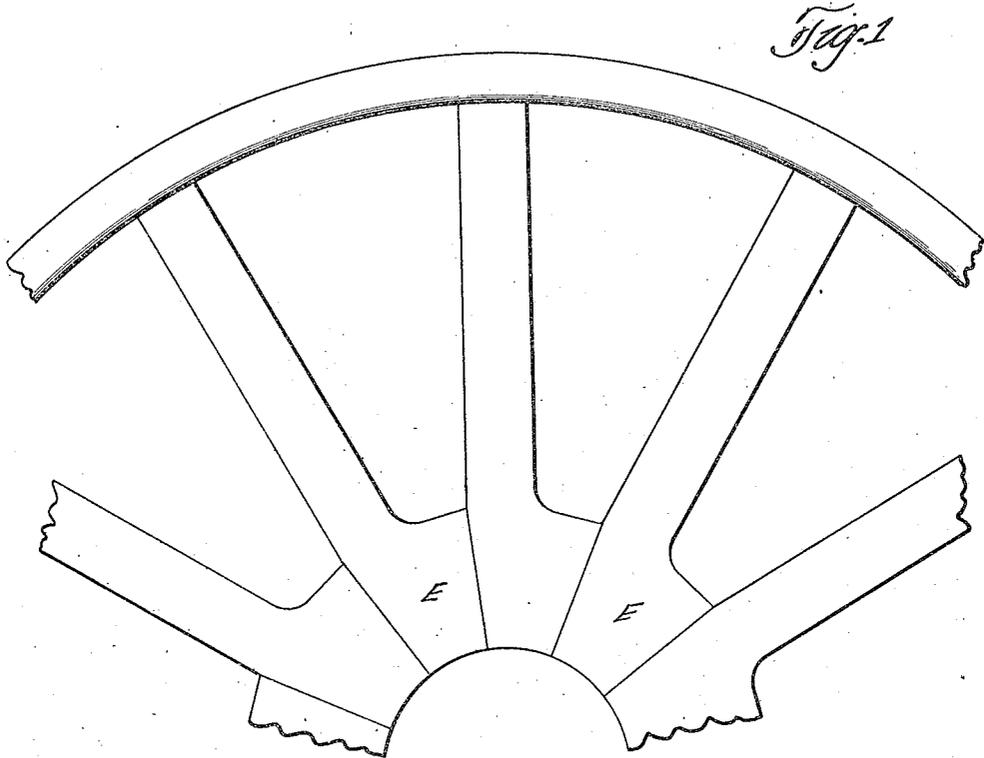


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J. H. WAGENHORST
METHOD OF MAKING SPOKES
Filed July 28, 1921



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UNITED STATES PATENT OFFICE.

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METHOD OF MAKING SPOKES.

Original application filed November 15, 1918, Serial No. 262,649. Divided and this application filed July 28, 1921. Serial No. 488,155.

To all whom it may concern:

Be it known that I, JAMES H. WAGENHORST, a citizen of the United States, residing at Jackson, in the county of Jackson and State of Michigan, have invented a certain new and useful Improvement in Methods of Making Spokes, of which the following is a full, clear, and exact description, reference being had to the accompanying drawings.

This invention relates generally to spokes for wheels and more particularly to the method of making the same, this application being a division of application #262,649, filed November 15, 1918. At the present time the usual method of spoke making is to provide a rectangular shaped billet and cut the spoke therefrom, using the longitudinal central line of said billet as the longitudinal central line of the spoke. By this method there is a great waste of wood as all of the stock on each side of the body of the spoke above the mitre is cut away and wasted.

The object of my invention is to avoid as much waste as possible and this I accomplish by providing a billet slightly wider and longer than the usual billet and then cutting two complete spokes from such billet, the spokes being so shaped as to permit the same.

Another object is to cut two spokes from one billet without waste and at the same time still maintain the grain of the wood in line with the spoke so that the full strength of the spoke is maintained.

The invention consists in the details hereinafter fully described and set forth in the appended claims.

In the drawings forming a part of this specification Fig. 1 is a partial view of a wheel made from spokes constructed in accordance with my invention; Fig. 2 is a view of the blank and two spokes made therefrom, and Fig. 3 is an end view of the spoke.

In carrying out my invention I employ a billet X (shown in dotted lines) which is just a trifle wider and longer than the usual sized billet for that size of spoke. This billet I cut in a peculiar manner, starting at the point A cutting inwardly on a curved line until the point B is reached which is located on the longitudinal central line of the billet.

The central longitudinal line is then followed to the point C when the cut is curved outwardly to the point D. This divides the billet into two similarly shaped pieces and from each piece a complete spoke can be turned providing the mitre E and tenon F and it will be noted that throughout the entire length of the spoke, tenon and mitre the grain of the wood is maintained in the proper direction to give the greatest strength to the spoke as a whole.

It will of course be understood that the cuts can be made separately or all at one time and in any approved manner so long as the billet is divided into two similar spoke blanks, having the proper shape.

By means of this method, it will be noted that there is very little waste about the mitre and tenon, and practically none about the spoke proper.

Having thus described my invention, what I claim is:

1. The herein described method of making spokes which consists in providing a billet substantially rectangular in shape, cutting into said billet at one side thereof at a point adjacent one end and carrying said cut inwardly to a point in the longitudinal center of said billet and then continuing said cut along said longitudinal line for the greater portion of the billet and then carrying said cut to the opposite side of the billet at a point adjacent the opposite end thereof, thereby providing two similar spoke blanks.

2. The herein described method of making spokes which consists in providing a billet substantially rectangular in shape, cutting into said billet at one side at a point adjacent one end and continuing said cut to the longitudinal central line of said billet, then continuing said cut along said longitudinal line for the greater portion of the billet and then carrying said cut in a direction reverse to the first cut to the opposite side of the billet at a point adjacent the opposite end of said billet, thereby dividing said billet into two similar spoke blanks and then shaping said blanks into finished spokes.

In testimony whereof, I hereunto affix my signature.

JAMES H. WAGENHORST.