March 18, 1941. A. J. LAWSON 2,235,437

METHOD FOR MANUFACTURING POLE CLIMBERS

Original Filed Feb. 2, 1939

Fig. 3.



Fig. 1.

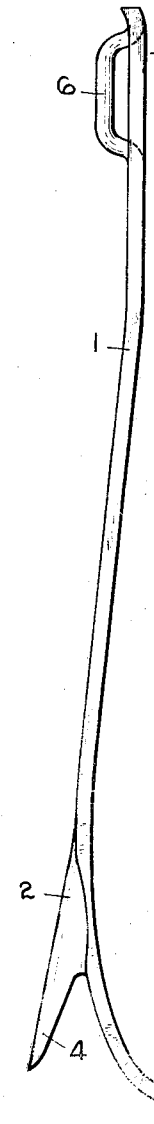


Fig. 2.

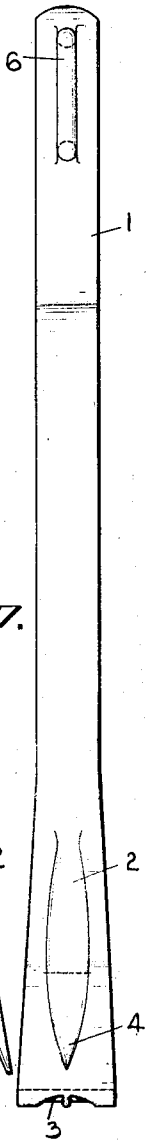


Fig. 8.

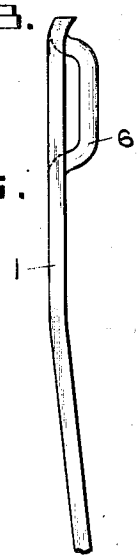


Fig. 4.

Fig. 5.

Fig. 6.

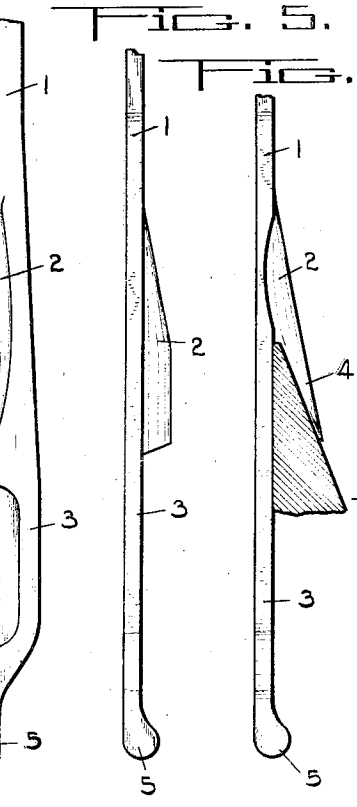
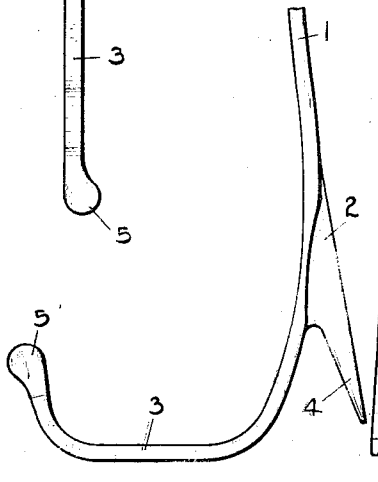


Fig. 7.



Inventor
A. J. LAWSON
By
J. E. M. Fetherstonhaugh
Attorney

Patented Mar. 18, 1941 2,235,437

UNITED STATES PATENT OFFICE

2,235,437

METHOD FOR MANUFACTURING POLE CLIMBERS

Arthur J. Lawson, Merritton, Ontario, Canada, assignor to Hayes Steel Products Limited, Merritton, Ontario, Canada, a corporation of Canada

Original application February 2, 1939, Serial No. 254,270. Divided and this application October 30, 1939, Serial No. 301,976

1 Claim. (Cl. 29—148)

My invention relates to improvements in methods for manufacturing pole climbers and an object of the invention is to devise a method of fabricating the climber wherein the spur can be formed integrally with the leg portion during the process of forging the climber into its ultimate shape, thus making for a pole climber in which the spur will be much stronger and less liable to fracture at its point of junction with the leg portion of the climber.

This application is a division of my application Serial No. 254,270, filed Feb. 2, 1939.

With the above and other objects in view which will hereinafter appear as the specification proceeds, my invention consists, in its preferred embodiment, of the method all as hereinafter more particularly described and illustrated in the accompanying drawing in which—

Fig. 1 represents a front view of a pole climber manufactured by my method.

Fig. 2 is a side view thereof viewed from the spur side.

Fig. 3 is the round bar from which the climber is forged.

Fig. 4 is a side view of the lower portion of the bar showing the first step in the method wherein the round bar of Fig. 3 is forged into flattened cross-section with a protuberance on one side from which the spur is subsequently formed and the lower portion increased in width from which the stirrup of the climber is subsequently formed.

Fig. 5 is an edge view of the bar as illustrated in Fig. 4.

Fig. 6 is a similar view to Fig. 5 only showing the protuberance split by a wedge-like tool to form the spur.

Fig. 7 is a front view showing the lower portion of the bar illustrated in Fig. 6 bent to form the stirrup, and

Fig. 8 is an edge view of the upper portion of the bar showing the upper strap loop formed therein.

Like characters of reference indicate corresponding parts in the different views of the drawing.

In fabricating a pole climber as illustrated in Figs. 1 and 2, I take a round steel bar A as illustrated in Fig. 3 and hot forge it into one of flattened cross-section 1 with a protuberance 2 on one side and a lower portion 3 of increased width. I then slit the protuberance 2 at its junction with the leg portion of the bar 1 longitudinally upward an appreciable extent by means of a wedge-shaped tool, lifting the spur or gaff 4 thus formed. The lower portion 3 is then bent into its stirrup form; the entire bar is now annealed; the lower strap loop lug 5 has an orifice stamped therethrough and the upper strap D-loop 6 is stamped out of the upper portion of the bar 1.

The pole climber has now been fabricated into its ultimate form and it is then heat treated so that it will be of uniform hardness throughout.

It now only remains to weld the ends of a ring 7 together after it has been inserted into the orifice stamped in the lug 5 and then sharpen the point of the spur 4.

A spur 4 formed integrally with the leg portion of the climber has the advantage of increased strength at the point of strain and an absence of brittleness as would occur where the spur is riveted to the climber. Furthermore any looseness between spur and climber is obviated.

What I claim as my invention is:

In a method of fabricating pole climbers, the steps which consist in initially forging a longitudinal protuberance on a surface of the bar from which the climber is made, subsequently slitting such protuberance longitudinally upward an appreciable extent at its junction with the surface of the bar, then lifting the slit portion of the protuberance away from the bar whereby a spur is formed, and finally bending the lower portion of the bar into stirrup form whereby the space betwen the free end of the spur and the bar is increased.

ARTHUR J. LAWSON.