D. WILCOX.

Manufacture of Fifth Wheels for Carriages, &c.

No. 137,274. Patented March 25, 1873.

FIG. 1.

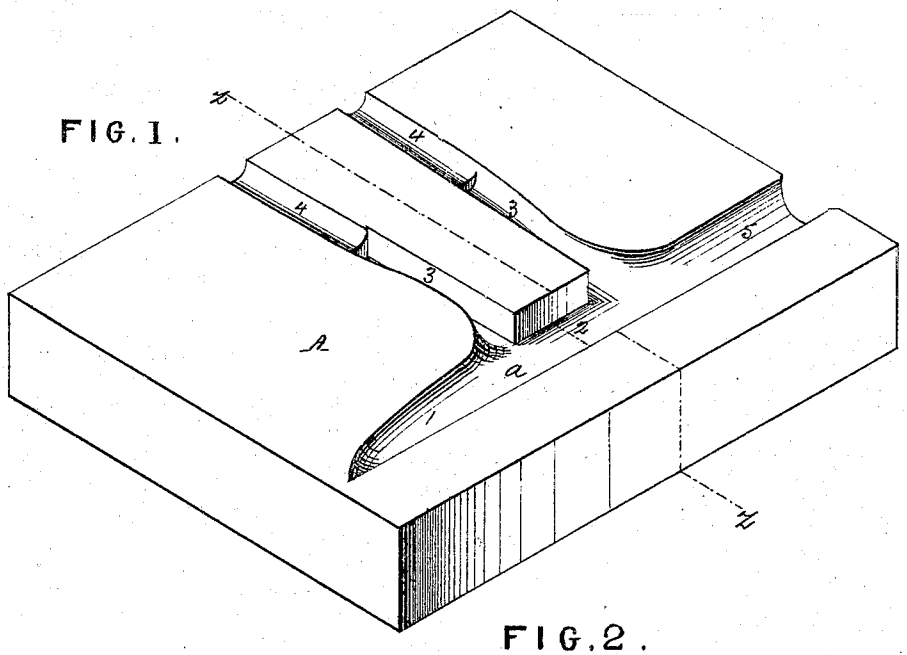


FIG. 2.

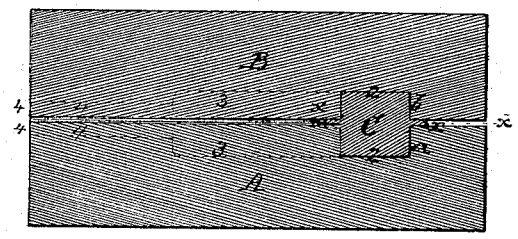
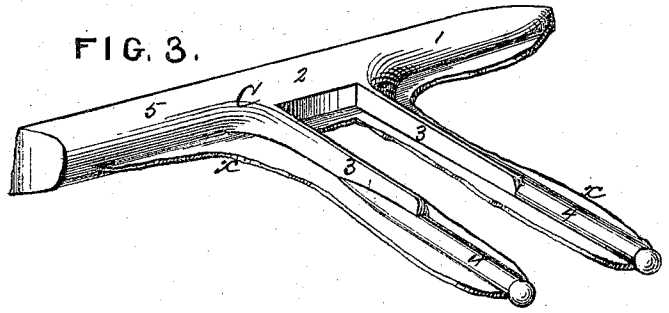


FIG. 3.



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UNITED STATES PATENT OFFICE.

DARIUS WILCOX, OF DERBY, CONNECTICUT.

IMPROVEMENT IN THE MANUFACTURE OF FIFTH-WHEELS FOR CARRIAGES, &c.

Specification forming part of Letters Patent No. **137,274**, dated March 25, 1873.

To all whom it may concern:

Be it known that I, DARIUS WILCOX, of Derby, in the county of New Haven and State of Connecticut, have invented an Improvement in the Manufacture of Clip-Heads for Fifth-Wheels of Vehicles, of which the following is a specification:

Nature and Objects of the Invention.

This invention relates to the manufacture of the clip-heads known as "clip-heads for fifth-wheels of vehicles," in a cheap, expeditious, and superior manner. The invention consists in a pair of dies for completing a clip-head at one operation from the rough blank, the same being so formed that the piece is struck edgewise. The operation is performed beneath a hammer, by one or more blows of the same, or in a power press.

Description of the Drawing.

Figure 1 is a perspective view of the lower one of a pair of dies, illustrating the invention. Fig. 2 is a vertical section of the pair of dies containing a finished clip-head. The plane of the section is represented by the line *z*, Fig. 1. Fig. 3 is a perspective view of a clip-head as taken from the dies.

General Description.

In carrying out this invention a pair of steel dies, A B, are constructed with matrical cavities *a b* in their faces, corresponding with the outlines of the flat faces or sides of the clip-head C which is to be produced, as illustrated in Fig. 1, so that the piece shall be struck edgewise. The form of the respective sides of the clip-head may be alike, and the cavities are of equal depth, and jointly equal to the thickness of the clip-head, less the usual provision for fins, *x*. The fins are thus formed along the different parts of the clip-head in a single central plane, as illustrated in Fig. 3, so as to leave the outer edges and angles full and clean, and to facilitate removing the fins. The numbers 1 2 3 4 5 indicate the matching-points of the clip-head and dies. The blanks for use with these dies are cut or swaged of the same general outline as the finished clip-head, and with a small surplus of metal. A blank is placed over the cavity of the lower die, and the upper die applied. The whole is then placed under a "trip-hammer," or "drop-hammer," or in a press, and subjected to one or more blows, or to the requisite pressure, when the clip-head, finished to the extent illustrated in Fig. 3, is removed, and another blank introduced. The clip-heads are subsequently cleaned of their fins and welded to the ends of traverse-bars, to form the lower members of fifth-wheels, which may be completed in usual manner. Uniform and perfect clip-heads for the use specified are thus readily manufactured at a reduced cost over the inferior article heretofore produced by drawing out each member of the clip separately.

It is known that other articles have been struck edgewise in dies, and this feature of the invention is not therefore broadly claimed.

Claim.

The following is claimed as new:

Dies A B, constructed with cavities of the forms herein specified, for forming clip-heads for fifth-wheels of vehicles, in the manner and for the purposes set forth.

DARIUS WILCOX.

Witnesses:

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