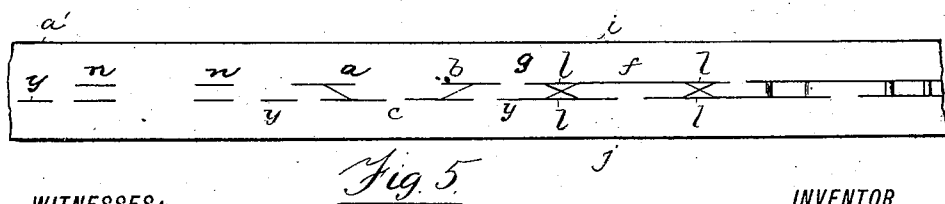
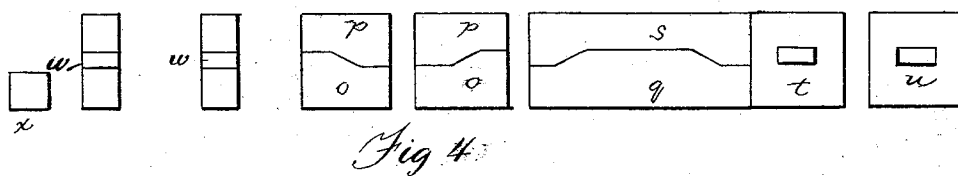
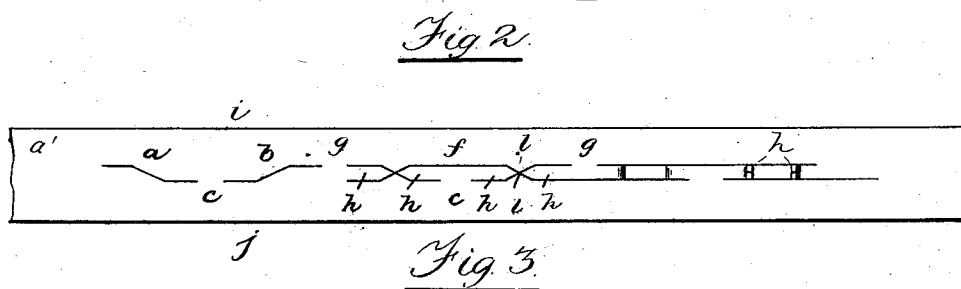
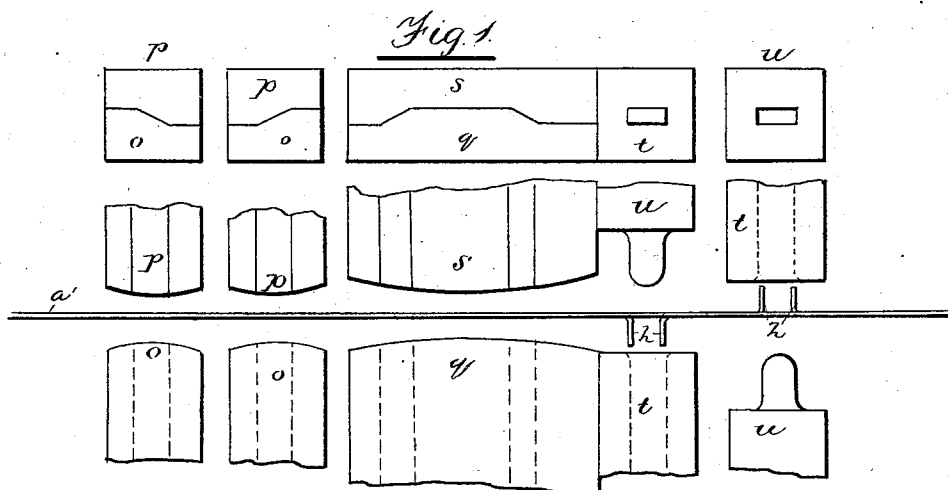


(No Model.)

J. H. TEMPLIN.
METHOD OF MAKING BARBED FENCING.

No. 507,184.

Patented Oct. 24, 1893.



WITNESSES:

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JOSEPH H. TEMPLIN, OF READING, PENNSYLVANIA, ASSIGNOR, BY MESNE ASSIGNMENTS, TO THOMAS V. ALLIS, OF NEW YORK, N. Y.

METHOD OF MAKING BARBED FENCING.

SPECIFICATION forming part of Letters Patent No. 507,184, dated October 24, 1893.

Application filed June 8, 1888. Serial No. 276,522. (No specimens.)

To all whom it may concern:

Be it known that I, JOSEPH H. TEMPLIN, a citizen of the United States, and a resident of Reading, in the county of Berks and State of Pennsylvania, have invented certain new and useful Improvements in Methods of Making Barbed Fencing, of which the following is a specification.

This improved method of making barbed metallic fencing consists of producing two barbed strips from one double blank strip by slitting it at intervals along the middle by two different ranges of slits which slits are made in two parallel lines and two diagonal lines connecting the parallel lines and the slits of each range are so reversed to each other that the diagonal lines of one slit cross the diagonal lines of the other slit and cut the points of the barbs, while the parallel lines extend therefrom each way the length of the barbs and cut both edges of the body portions of them from the strips and complete the barbs and the separation of the two strips. Then the barbs are bent laterally for the required projection, and slight points left on the edges of the strips by the diagonal cuts are left or trimmed off at the same time or prior to the bending if desired all as follows, referring to the drawings, in which—

Figure 1 represents face views of the slitting and bending dies. Fig. 2, represents a side elevation of the same with the blank strip between them. Fig. 3, is a diagram of the blank strip showing the action of the dies on it, and Fig. 4 represents face views of the dies with other dies for trimming off the points left on the strips by the slitting dies between the diagonal cuts. Fig. 5 is a diagram of the strip as cut by dies of Fig. 4.

By one operation and preferably the first in order of time, I make the two slits *a, b*, in the middle of the blank strip *a'*, one a little in advance of the other, which slits are partly in two different parallel lines as wide apart as the width of the barbs to be made and partly in the diagonal lines connecting the parallel lines, said diagonals being inclined reversely to each other and the contiguous ends of the two slits being in one line and the opposite ends of said slits in another of

the parallel lines, with the uncut web *c*, between the ends of the slits; and by another operation, preferably after the blank shifts along one feed movement, I make another continuous slit *f*, of like character but longer than slits *a, b*, combined, and being reversed thereto so that its extremities are in the line of the contiguous ends of slits *a, b*, and its diagonals cross those of slits *a, b*, thus cutting four barbs *h*, and separating the barb strips *i, j*, two of which barbs are joined to one barb strip *j*, by the web *c*, left between the contiguous extremities of slits *a, b*, and two others are joined to barb strip *i*, by uncut webs *g*, left between the opposite extremities of said slits *a, b*, the former by reason of the distance of the cutters apart and the latter through the feeding of the blank as much more at each movement than the length of said slits as is required for reserving said retaining webs.

The slits *f*, preferably extend as much beyond slits *a, b*, at one end or at both ends opposite web *g*, as is requisite to cut through from slit to slit successively and make a continuous slit, but dies of equal length as the two pairs *o, p*, may be used as in Fig. 4 with web cutters as *x*, to make slits *y*, to separate the uncut webs that would be left opposite webs *g*, which cutters may be located in advance as shown, or in succession of the others. Then I cause the barbs to be bent laterally to the strips for the required projection either leaving the slight points *l*, or at the same time trimming them off by the benders, which points *l*, are left by the slitting cutters on the edges of the barb strips between the points of the barbs, or the trimming of said points may be effected by slits *n*, that may be made before the cutting of the barbs if desired.

It is to be understood that the slit *f*, may be made first and slits *a, b*, next, the result being the same in either case.

The slits *a, b*, are made by two pairs of dies *o, p*, and slits *f*, by another pair *q, s*, or a single pair having a gap to leave web *c*, may be employed for the slits *a, b*, if preferred. Two pairs of benders *t, u*, are employed to bend the barbs and they are arranged to bend

them alternately in opposite directions; *w*, represents face views of cutters employed to make slits *n*, to trim off the slight points *l*, left between the crossing of the diagonal lines, on which points of the barbs are cut. These may be arranged in advance of the rest of the cutters to accomplish the work by making initial slits *n*, as represented in Fig. 5 or they may be arranged for later action; but if desired the bending dies may be adapted for such trimming at the same time they do the bending as represented in Figs. 1 and 2, or if desired the benders *u*, may be so shaped as that they will pass said points without effect on them while bending the barbs.

What I claim, and desire to secure by Letters Patent, is—

1. The method of producing two barbed strips from one double blank strip, which consists in successively making two slits at intervals apart in the middle of the blank one a little in advance of the other, which slits are partly in two different parallel lines as wide apart as the width of the barbs to be made, and partly in diagonal lines connecting the parallel lines, said diagonals being inclined in reverse of each other, and the contiguous ends of the two slits being in one line, and the opposite ends of said slits in another of the parallel lines, and successively making other converse slits of like form as these two joined in one, with the diagonals crossing the diagonals of the said first two

slits and the parallels in extension of the parallels of the said first slits each way from the diagonals, and successively making a continuous slit substantially as described.

2. The method of producing two barbed strips from one double blank strip, each having laterally projecting barbs which consists in successively making two slits at intervals apart in the middle of the blank one a little in advance of the other, which slits are partly in two different parallel lines as wide apart as the width of the barbs to be made and partly in diagonal lines connecting the parallel lines, said diagonals being inclined in reverse to each other, and the contiguous ends of the two slits being in one line, and the opposite ends of said slits in another of the parallel lines, and successively making other converse slits of like form as these two joined in one with the diagonals crossing the diagonals of the said first two slits and the parallels in extension of the parallels of the said first slits each way from the diagonals, and successively making a continuous slit, and finally bending said barbs laterally to the strips substantially as described.

Signed at New York city, in the county and State of New York, this 2d day of May, A. D. 1888.

JOSEPH H. TEMPLIN.

Witnesses:

W. J. MORGAN,
GEO. T. JANVRIN.