March 27, 1951 S. W. LA ROCQUE 2,546,643

SHEET METAL LOOP PICKER

Filed June 27, 1949 2 Sheets-Sheet 1

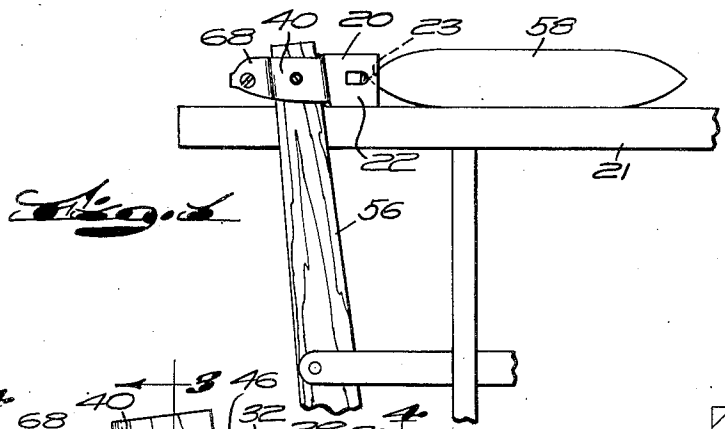


Fig. 1

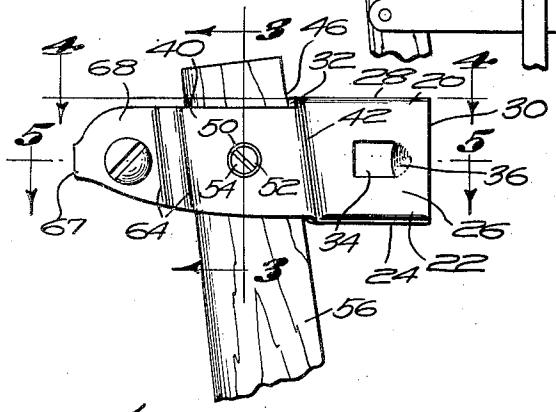


Fig. 2

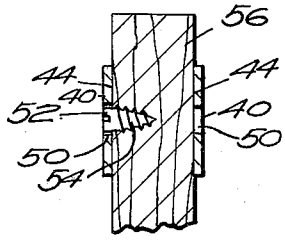


Fig. 3

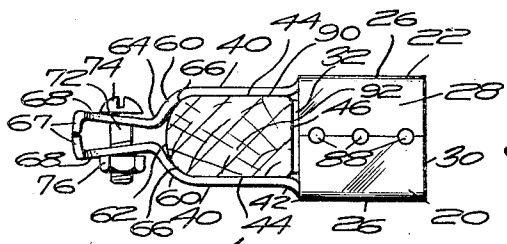


Fig. 4

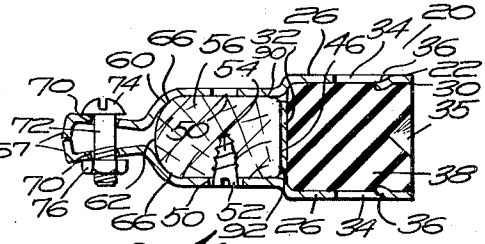


Fig. 5

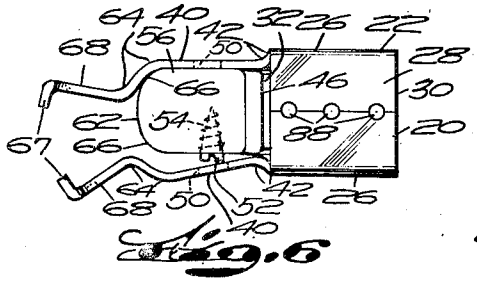


Fig. 6

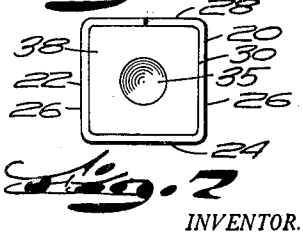


Fig. 7

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SHEET METAL LOOP PICKER

Filed June 27, 1949 2 Sheets-Sheet 2

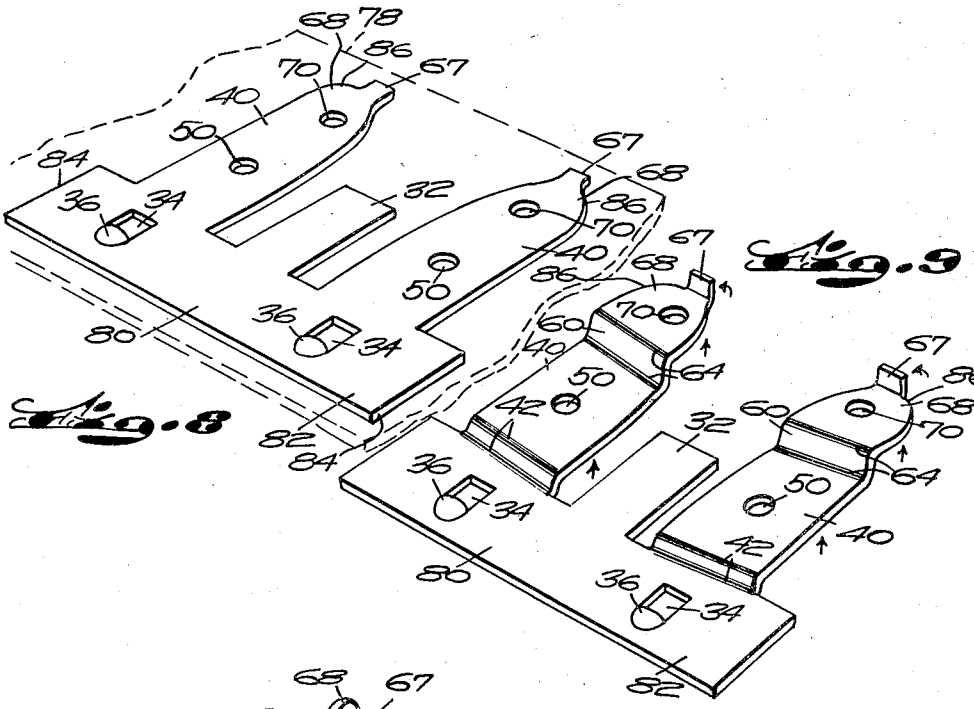


Fig. 9

Fig. 8

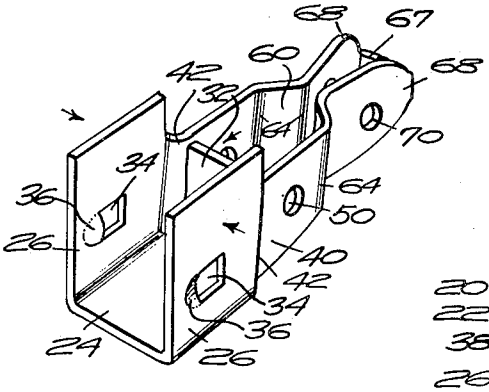


Fig. 10

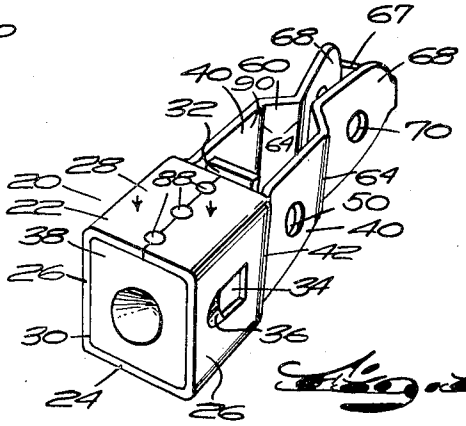


Fig. 11

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UNITED STATES PATENT OFFICE

2,546,643

SHEET METAL LOOP PICKER

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Application June 27, 1949, Serial No. 101,525

7 Claims. (Cl. 139—159)

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My invention relates to improvements in pickers of the type which are mounted adjacent the top of the picker stick to oscillate therewith for use particularly in single box looms.

So far as I am aware, I am the first to provide a practical light picker of this description cut and shaped from a strip of sheet metal.

An object of my invention, therefore, is to provide a picker having a metal body portion of a light practical type. At the present time most pickers of this type are made of rubber or composition and last only one or two months.

One feature of my improved picker is that I provide a hole for receiving a picker head at the inner end of my improved picker of a length to completely receive substantially the entire length of the picker head within the hole so as to retain the picker head throughout its length tightly embraced throughout the periphery thereof so that it will not get out of shape, thereby prolonging the life of replaceable picker heads three or more times. The improved body portion of my invention being made of metal will last an indefinite period, at least comprising a multiplicity of years, much longer than the life of the picker head, so that the picker head may be replaced therein at small cost as it wears out, without replacing the entire picker.

A further object of my invention is to provide a picker which will keep all fibers of the picker head completely encased, so that they may not bulge outwardly in use or split off to provide fibers or lint to grip the yarn and mark the cloth.

A further object of my invention is to provide a picker having a body portion composed of light metal and which is also preferably streamlined so as to require less power to run.

A further object of my invention is to provide a reversible sheet metal picker which may be used either at the right or left hand side of the lay of the loom.

One cause of the rapid wearing out of picker heads has been that the picker head does not strike the loom evenly on the lay and an object of my invention is to provide a picker in which the picker stick hole is at an oblique angle to the head of the picker, so that the picker will strike the shuttle to throw it evenly across the lay at the proper portion of its pivoting stroke.

Inasmuch as I preferably make my improved picker out of resilient sheet metal, I am also enabled to provide a resilient clamp for positively clamping the end walls of the picker stick together to firmly mount my improved picker thereon, a feature not possible in cast metal or other previous types of pickers.

A further object of my invention is to provide a picker which, after once set, becomes automatically resettable after replacement of a

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picker head thereon. When the picker is first used, the loom fixer clamps it on and then tests it out on the lay to see if the center of the picker head strikes the tip of the shuttle, throwing the picker stick by hand for this purpose. When he finds that the tip of the shuttle is correctly aligned with the center of the picker head at the end of its throw, then he knows that the device is properly adjusted.

I provide a suitable headless locking wood screw receiving hole in each side strap of my improved picker, so that when the picker is correctly adjusted to the right height on the picker stick, the loom fixer may drill a hole in the picker stick and insert the headless locking wood screw therein to extend through the strap hole without projecting beyond it. When it is desired to replace a picker head in the picker head holding box, all the loom fixer has to do is to unclamp the tips of the straps of my resilient sheet metal picker and spread them so that the picker may be lifted off over the projecting end of the wood screw. He may then mount the picker on the picker stick by holding the end tips still separated until the end of the projecting screw is opposite its hole when the tips may then be again clamped together so that the end of the screw projecting through the hole of the picker will be automatically adjusted at the right height without making another adjustment. This may be repeated as many times as necessary to replace picker heads throughout the life of the picker. In addition, said locking wood screw maintains the picker in position for continued use, insuring against any tendency to slide up on the picker stick during use.

An object of my invention, therefore, is to provide a picker which, when initially set, is continuously set, despite removals for insertions of new picker heads therein, due to the structure of my improved picker.

A further feature of my invention resides in the fact that I provide an oblong picker head box having four right angles. This permits the use of a larger picker head than formerly, having more area of material to cushion and absorb shocks. It is also apparent that this particular shape of my picker head makes it possible to readily construct my improved picker from a piece of sheet metal.

A further object of my invention is to provide a novel method of making my improved picker with a minimum number of stamping, cutting and bending operations and one which, due to its inherent structure, may be readily stamped out in large quantities commercially.

These and such other objects of my invention as may hereinafter appear will be best understood

from a description of an embodiment thereof such as is shown in the accompanying drawings.

In the drawings, Fig. 1 is a diagrammatic front elevation of a portion of a loom showing the upper end of a picker stick having my improved picker mounted thereon in the act of abutting a shuttle to hurl it over the lay.

Fig. 2 is an enlarged front elevation of the upper end of the picker stick having my invention attached.

Fig. 3 is a vertical sectional view taken along the line 3—3 of Fig. 2.

Fig. 4 is a longitudinal sectional view taken along the line 4—4 of Fig. 2, showing the picker stick in section and my improved picker mounted thereon in plan.

Fig. 5 is a longitudinal sectional view through my improved picker and picker stick taken along the line 5—5 of Fig. 2.

Fig. 6 is a plan view of the picker and picker stick, illustrating the picker stick holding straps of my improved picker spread for lifting of the picker off the upper end of the picker stick, freeing the end of the adjusting wood screw mounted on the picker stick from its hole in the strap portion of the picker for this purpose.

Fig. 7 is a front elevation of my improved picker head.

Figs. 8–11 diagrammatically illustrate the steps in the method of making my improved picker from a resilient strip of sheet metal, Fig. 8 being a perspective view illustrating how the piece is first cut from the strip of sheet metal with the respective straps and picker head holding outer wall projecting laterally therefrom, with said strap portions having the aligned bolt holes, the aligned wood screw end receiving holes and the aligned claw holes simultaneously formed therein with the claws projecting upwardly from the inner ends of said claw holes, Fig. 9 being a perspective view illustrating the step of bending the straps upwardly along outwardly flaring lines adjacent the box forming strip and the tips obliquely and upwardly slightly less than half the thickness of the picker along similar outwardly flaring lines at points substantially the length of the picker stick from said first stepped portions, Fig. 10 being a perspective view illustrating the step of bending the center projection upwardly to form the outer wall of the picker head holding box and bending said strip end portions and integral strap portions vertically upwardly at points slightly exterior of said center projection to form said picker holding box side walls and to bring the strap portions into positions opposite the side walls of the picker stick and upwardly stepped outer portions over the round outer picker stick wall and the tips thereof substantially adjacent beyond said picker stick, and Fig. 11 being a perspective view illustrating the step of bending the tips of said upstanding end strips downwardly adjacent to each other and spot welding them together to form the top wall of the picker head holding box.

In the drawings, wherein like characters of reference generally indicate like parts throughout, 20 indicates a reversible picker constructed of a single piece of resilient sheet metal capable of abutting the shuttle in horizontal alignment therewith constructed in accordance with my invention.

As stated hitherto, I have particularly designed my improved reversible picker so that it may be readily constructed from a strip of sheet metal by cutting, stamping and bending operations, so that the picker may be made commercially in large quantities and I have so modified my method as to produce the desirable end results in the improved picker.

Thus, in order to provide a picker head holding box 22 I have constructed this of generally oblong formation having right angles, so that it may be readily bent to shape in a succession of steps and I have so designed my method of manufacture as to produce an oblong picker head holding box to provide a greater area of resilient material in the picker head. Thus, my improved reversible picker has an oblong picker head holding box 22, having a bottom wall 24, side walls 26, a top wall 28, an open front end 30 and an outer wall 32 to be described in more detail later.

I preferably provide said picker head holding box 22 with the holes 34 in the side walls thereof, having inwardly domed picker head engaging claws 36 projecting internally of the inner ends thereof to make the claws 36 bite into the resilient material of the picker head 38. While the holes 34 may be made of any desired shape, they are preferably made square so that a tool such as a small screw driver may be inserted therethrough to bite into the resilient material of the picker head 38 to assist in ejecting it from the picker head holding box 22.

In the embodiment shown, the top wall 28 extends outwardly a greater distance than the bottom wall 24 and the outer wall 32 extends resiliently obliquely upwardly between said side walls to resiliently abut the flat inner wall of the picker stick.

I provide the picker stick holding straps 40 projecting outwardly from said side walls 26 stepped substantially directly externally or laterally as at 42 along upwardly and outwardly flaring oblique lines extending from the inner end of the picker box bottom wall 24 to the inner end of the picker box top wall 28 for abutting the flat side walls 44 of the picker stick while its inner end wall 46 abuts the resilient rear outer wall 32 of the picker head holding box forcing it when attached against the inner end of said top wall 28 of the picker head holding box 22.

Said straps 40 are provided with the locking headless wood screw receiving holes 50 centrally of each side thereof, adapted to receive the tip 52 of one locking wood set screw 54, set at the right height in said picker stick 56 in the then front wall thereof, to cause said picker 20 to abut the shuttle 58 in horizontal position.

It is thus obvious that when the picker is reversed from a left hand picker to a right hand picker that it will face in the opposite direction, and that the screw tip 52 will then project through the opposite hole 50. Said straps 40 have the obliquely inclined step portions 60 extending internally around the rounded outer end 62 of the picker stick, extending for this purpose obliquely for a distance slightly less than half the thickness of said picker stick 56 along obliquely upwardly and outwardly flaring lines 64 substantially parallel to the oblique lines 42 of the first step to hug the rounded edges 66 of the round end 62 of the picker stick outer wall. It is obvious that as said steps 60 extend obliquely outwardly that they substantially conform to the rounded edges 66. Said straps 40 then extend integrally laterally outwardly in the clamping tips 68, preferably to flare away from each other in the manner shown. I provide suitable means to

clamp said tips 68 together to urge the inclined step portions 60 inwardly to clamp the picker stick against the resilient outer wall 32 of said picker box holding portion 22. So far as I am aware, I am the first to provide a metal picker having means therein to resiliently clamp it against the inner and outer end walls of the picker stick. Any suitable means may be provided to compress said tips together and for this purpose, I have provided said tips with the bolt holes 70 and I have provided the bolt 72, projecting through said holes having the head 74 on one end thereof and the lock nut 76 on the opposite end thereof, abutting respectively the exposed surfaces of said tips. The extreme ends 67 of the tips 68 may be bent inwardly to abut each other when the clamping means, namely, the bolt 72 and nut 76 are tightened to form a pivot for a lever action inwardly thereof, to cause the flat strap side walls 40 to bind laterally against the side walls of the picker stick, in addition to clamping the inner picker stick wall against the resilient outer wall 32 of the picker head holding box 22 in the manner explained. The lower portions of the straps 40 may also be obliquely cut away or streamlined to positively clear the back of the lay.

Said picker head holding box is adapted to have the oblong picker head 38 pressed therein in the usual manner to be retained therein by the claws 36 where employed.

When the picker 20 is first used, the loom fixer clamps it on the picker stick by compressing the strap tips 68, and then tests it out on the lay 21 to see if the center of the picker head 38 strikes the tip 23 of the shuttle 58, throwing the picker stick by hand for this purpose. When he finds that the tip 23 of the shuttle 58 is correctly aligned with the center of the picker head 38 at the end of its throw then he knows that the device is properly adjusted.

I provide a suitable headless locking wood screw receiving hole 50 in each side strap 40 of my improved picker, so that when the picker is correctly adjusted to the right height on the picker stick, the loom fixer may drill a hole in the picker stick 56 and insert a headless locking wood screw 54 therein to extend through the strap hole 50 without projecting beyond it. When it is desired to replace a picker head 38 in the picker head holding box 22, all the loom fixer has to do is to unclamp the tips 68 of the straps 40 of my resilient sheet metal picker 20 and spread them so that the picker may be lifted off over the projecting end 52 of the wood screw 54 (as indicated in Fig. 6) when the worn picker head 38 may be replaced by a new one in the usual manner. He may then mount the picker 20 on the picker stick 56 holding the end tips 68 still separated until the end 52 of the projecting screw 54 is opposite its hole 50, when the tips 68 may then be again clamped together so that the end 52 of the screw 54 projects through the hole 50 and the picker will be automatically adjusted at the right height without making another adjustment. This may be repeated as many times as necessary to replace picker heads throughout the life of the picker. In addition, said locking wood screw 54 maintains the picker in position for continued use, insuring against any tendency to slide up on the picker stick during use.

As stated hitherto, I have so designed my picker that it may be readily made commercially with a minimum of cutting and bending steps and I have so designed my improved method of making the picker that it may produce my novel article by a novel sequence of steps.

I have illustrated how the picker may be made in Figs. 8–11, each of which illustrates the picker after each respective step of making it has been performed thereon and have indicated by arrows the forces applied to achieve these steps.

As shown in Fig. 8, my initial step comprises cutting or blanking out from a continuous strip of sheet metal 78 a piece 80 having a continuous picker head holding box forming strip 82 at one side thereof, having a flat picker head holding box outer wall 32 extending centrally laterally therefrom and picker stick holding strap projections 40 projecting laterally therefrom intermediate said central projection 32 and said strip ends 84, preferably having the rounded ends 86, and preferably in the same operation, the bolt holes 70 are provided in the tip portions 68 of said strap portions 40 and the manipulating preferably square holes 34 are formed in said strip portions aligned with said bolt holes 70 and preferably having the domed picker head claw forming indentations 36 projecting forwardly from the inner ends thereof, and where desired I may also form the headless wood screw holes 50 in said strap portions 40 adapted to abut the side walls of the picker stick 56, intermediate and aligned with said claw holes 34 and bolt holes 70.

I then, as shown in Fig. 9, step bend said picker holding straps 40 in two places initially as at 42 substantially vertically upwardly adjacent said strip 82 along the outwardly flaring lines 42 and I similarly step bend said straps along similar outwardly flaring lines 64 a greater distance obliquely and upwardly as at 60 slightly less than half the thickness of the picker 56 at points substantially the length of the picker stick 56 from said first stepped portions 42 in any suitable manner by a suitable bending or stamping operation as indicated in Fig. 9. When it is desired to have the extreme ends 67 of the tips 68 abut each other in use in the manner explained, said ends 67 may be bent upwardly as the steps 42 and 60 are formed, as shown in Fig. 9.

I then bend said center projection 32 upwardly preferably slightly less than 90° to form the resilient outer wall 32 of said picker head holding box and I bend the strip end portions 26 and integral strap portions 40 vertically upwardly at points slightly exterior of said center projection 32 to form said picker holding box side walls 26 and to bring the strap portions 40 in positions opposite the side walls of the picker stick 56 and the tips 68 thereof substantially adjacent beyond said picker stick in the manner as indicated by arrows in Fig. 10. I then bend the tips of said upstanding ends 26 of the strip 82 downwardly adjacent to each other to form the picker head holding box top wall 28 and spot weld them together as indicated by the circles 88 to form the top wall 28 of said picker head holding box as indicated in Fig. 11.

To complete the picker, it is merely necessary to insert the bolt 74 through the hole 70 and attach the nut 76 thereto and to press a resilient composition picker head 38 within said picker head holding box 22 in the usual manner, so that the claws 36 engage the side walls thereof where employed.

It is apparent that the order of sequence of bending the various parts may be varied. For

instance, if the tips of the ends of the strip 82 are bent upwardly in the first bending step shown in Fig. 9, it is obvious that the final step of bending them down shown in Fig. 11 may be dispensed with.

As stated, the fact that the picker head holding box is made of right angles makes possible my improved method of manufacture and this also achieves the desirable result of being able to provide more resilient material in the picker head.

The picker head 38 may be provided with the usual centering cone 35.

It will be noted that in Fig. 11, the outer wall 32 of the picker stick holding box 22 is spaced a slight distance from the top wall 28 thereof, but that as the picker stick 56 is inserted through the picker stick receiving hole 90 formed by said outer wall 32, strap portions 40 and inclined portions 68, said end wall 32 resiliently yields to abut the edge of the top wall 28 as shown in Fig. 5, but clamping the picker firmly to the ends 62 and 92 of the picker stick in a novel manner.

It is apparent that I have provided a novel type of sheet metal picker, with the advantages mentioned hitherto, and a novel type of method for making the same commercially, with the products so designed as to make this method possible, and with the method designed to make this particular product.

It is understood that my invention is not limited to the specific embodiments shown or methods described and that various deviations may be made therefrom without departing from the spirit and scope of the appended claims.

What I claim is:

1. A reversible picker constructed of a single piece of resilient sheet metal and capable of abutting a shuttle in horizontal alignment therewith, comprising an oblong picker head holding box having side walls having holes therein, having inwardly domed picker head engaging claws projecting internally of the inner ends thereof, a bottom wall, a top wall extending outwardly a greater distance than said bottom wall, an open inner end and an outer wall extending resiliently obliquely upwardly between said side walls to abut the flat inner wall of the picker stick and integral picker stick holding straps projecting outwardly from said side walls stepped directly externally along upwardly and outwardly flaring oblique lines from the inner end of said picker box bottom wall to the inner end of said picker box top wall for abutting the flat side walls of the picker stick, having locking headless wood screw receiving holes centrally of each side thereof adapted to receive the tip of one locking wood screw set at the right height in said picker stick for said picker to abut the shuttle in horizontal alignment therewith, and having obliquely inclined stepped portions extending internally along obliquely upwardly and outwardly flaring lines substantially parallel to the oblique lines of the first steps to hug the rounded edges of a picker stick outer wall and then extending integrally laterally outwardly in clamping tips having clamping bolt holes therein and bolt means extending through said bolt holes, having nut means thereon to clamp said tips together, causing said outer obliquely inclined stepped portions to abut the rounded edges of the picker stick outer wall to clamp the picker stick against the resilient outer wall of the picker head holding portion, said picker head holding portion being adapted to have an oblong picker head pressed

therein whereby on unclamping said straps said straps may be spread for taking said picker off said picker stick over said headless set wood screw for replacement of a picker head thereon and remounted on the picker stick with said adjusted wood screw in its hole correctly realigning said picker with the shuttle.

2. A reversible picker constructed of a single piece of sheet metal and capable of abutting a shuttle in horizontal alignment therewith, comprising an oblong picker head holding box having side walls, a bottom wall, a top wall extending outwardly a greater distance than said bottom wall, an open inner end and an outer wall extending obliquely upwardly to abut the flat inner wall of the picker stick and integral picker stick holding straps projecting outwardly from said side walls stepped directly externally along upwardly and outwardly flaring oblique lines from the inner end of said picker box bottom wall to the inner end of said picker box top wall for abutting the flat side walls of the picker stick, and having obliquely inclined stepped portions extending internally along obliquely upwardly and outwardly flaring lines substantially parallel to the oblique lines of the first steps to hug the rounded edges of a picker stick outer wall and then extending integrally laterally outwardly in clamping tips and means to clamp said tips together, causing said outer obliquely inclined stepped portions to abut the rounded edges of the picker stick outer wall to clamp the picker stick against the outer wall of the picker head holding portion, said picker head holding portion being adapted to have an oblong picker head pressed therein.

3. A reversible picker constructed of a single piece of sheet metal and capable of abutting a shuttle in horizontal alignment therewith, comprising an oblong picker head holding box having side walls having holes therein, having inwardly domed picker head engaging claws projecting internally of the inner ends thereof, a bottom wall, a top wall extending outwardly a greater distance than said bottom wall, an open inner end and an outer wall extending obliquely upwardly to abut the flat inner wall of the picker stick and integral picker stick holding straps projecting outwardly from said side walls stepped directly externally along upwardly and outwardly flaring oblique lines from the inner end of said picker box bottom wall to the inner end of said picker box top wall for abutting the flat side walls of the picker stick, and having obliquely inclined stepped portions extending internally along obliquely upwardly and outwardly flaring lines substantially parallel to the oblique lines of the first steps to hug the rounded edges of a picker stick outer wall and then extending integrally laterally outwardly in clamping tips and means to clamp said tips together, causing said outer obliquely inclined stepped portions to abut the rounded edges of the picker stick outer wall to clamp the picker stick against the outer wall of the picker head holding portion, said picker head holding portion being adapted to have an oblong picker head pressed therein.

4. A reversible picker constructed of a single piece of resilient sheet metal and capable of abutting a shuttle in horizontal alignment therewith, comprising an oblong picker head holding box having side walls, a bottom wall, a top wall extending outwardly a greater distance than said bottom wall, an open inner end and an outer wall extending resiliently obliquely upwardly between said side walls to abut the flat inner wall of the

picker stick and integral picker stick holding straps projecting outwardly from said side walls stepped directly externally along upwardly and outwardly flaring oblique lines from the inner end of said picker box bottom wall to the inner end of said picker box top wall for abutting the flat side walls of the picker stick, and having obliquely inclined stepped portions extending internally along obliquely upwardly and outwardly flaring lines substantially parallel to the oblique lines of the first steps to hug the rounded edges of a picker stick outer wall and then extending integrally laterally outwardly in clamping tips and means to clamp said tips together, causing said outer obliquely inclined stepped portions to abut the rounded edges of the picker stick outer wall to clamp the picker stick against the resilient outer wall of the picker head holding portion, said picker head holding portion being adapted to have an oblong picker head pressed therein.

5. A reversible picker constructed of a single piece of sheet metal and capable of abutting a shuttle in horizontal alignment therewith, comprising an oblong picker head holding box having side walls, a bottom wall, a top wall extending outwardly a greater distance than said bottom wall, an open inner end and an outer wall extending obliquely upwardly to abut the flat inner wall of the picker stick and integral picker stick holding straps projecting outwardly from said side walls stepped directly externally along upwardly and outwardly flaring oblique lines from the inner end of said picker box bottom wall to the inner end of said picker box top wall for abutting the flat side walls of the picker stick, having locking headless wood screw receiving holes centrally of each side thereof adapted to receive one locking wood screw set at the right height in said picker stick for said picker to abut the shuttle in horizontal alignment therewith, and having obliquely inclined stepped portions extending internally along obliquely upwardly and outwardly flaring lines substantially parallel to the oblique lines of the first steps to hug the rounded edges of a picker stick outer wall and then extending integrally laterally outwardly in clamping tips, and means to clamp said tips together, causing said outer obliquely inclined stepped portions to abut the rounded edges of the picker stick outer wall to clamp the picker stick against the outer wall of the picker head holding portion, said picker head holding portion being adapted to have an oblong picker head pressed therein, whereby on unclamping said straps, said straps may be spread for taking said picker off said picker stick over said headless set wood screw for replacement of a picker head thereon and remounted on the picker stick with said adjusted wood screw in its hole correctly realigning said picker with the shuttle.

6. The method of making a picker which comprises cutting out from a sheet of resilient sheet metal a piece having a continuous picker head holding box forming strip at one side thereof, having a flat picker head holding box outer wall forming projection extending centrally laterally therefrom, and picker stick holding strap projections projecting laterally therefrom intermediate said central projection, and said strip ends, having bolt holes centrally of said ends and holes in said strip portions aligned with said bolt holes having domed picker head engaging claw forming indentations projecting forwardly from the inner end thereof, and headless wood screw holes intermediate and aligned with said claw holes and bolt holes, step-bending said picker holding straps a short distance substantially vertically upwardly adjacent said strip along outwardly flaring lines, and similarly step-bending said straps along similar outwardly flaring lines a greater distance obliquely and upwardly slightly less than half the thickness of the picker stick at points substantially the length of the picker stick from said first stepped portions, bending said center projection upwardly slightly less than 90° to form the resilient outer wall of said picker head holding box and bending said strip end portions and integral strap portions vertically upwardly at points slightly exterior of said center projection to form said picker holding box side walls and to bring the strap portions in positions opposite the side walls of the picker stick and upwardly stepped outer portions over the rounded outer picker stick wall and the tips thereof substantially adjacent beyond said picker stick, bending the tips of said upstanding end strips downwardly adjacent to each other and spot-welding them together to form the top wall of the picker head holding box, whereby a picker head may be pressed into the picker box holding portion and retained therein by said claws.

7. The method of making a picker, which comprises cutting out from a sheet of resilient sheet metal a piece having a continuous picker head holding box forming strip at one side thereof, having a flat picker head holding box outer wall forming projection extending centrally laterally therefrom, and picker stick holding straps projecting laterally therefrom intermediate said central projection and said strip ends, step-bending said picker holding straps a short distance substantially vertically upwardly adjacent said strip along outwardly flaring lines, and similarly step-bending said straps along similar outwardly flaring lines a greater distance obliquely and upwardly slightly less than half the thickness of the picker stick at points substantially the length of the picker stick from said first stepped portions, bending said center projection upwardly to form the outer wall of said picker head holding box and bending said strip end portions and integral strap portions vertically upwardly at points slightly exterior of said center projection to form said picker holding box side walls and to bring the strap portions in positions opposite the side walls of the picker stick and upwardly stepped outer portions over the rounded outer picker stick wall and the tips thereof substantially adjacent beyond said picker stick, bending the tips of said upstanding end strips downwardly adjacent to each other and spot-welding them together to form the top wall of the picker head holding box.

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