

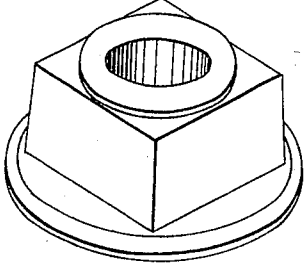
S. VANSTONE.

METHOD OF MANUFACTURING AXLE NUTS.

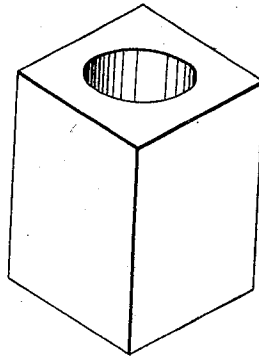
No. 104,904.

Patented June 28, 1870.

*Fig. 1.*



*Fig. 2.*



*Witnesses:*

*Walter S. Vincent*

*George C. Hall.*

*Inventor:*

*Samuel Vanstone*

# United States Patent Office.

SAMUEL VANSTONE, OF PROVIDENCE, RHODE ISLAND.

Letters Patent No. 104,904, dated June 28, 1870.

## IMPROVED METHOD OF MANUFACTURING AXLE-NUTS.

The Schedule referred to in these Letters Patent and making part of the same.

### To all whom it may concern:

Be it known that I, SAMUEL VANSTONE, of the city and county of Providence, in the State of Rhode Island, have made certain new and useful Improvements in the Art of Making Axle-Nuts; and I do hereby declare the following specification, taken in connection with the drawing making a part of the same, is a full, clear, and exact description thereof.

Figure 1 is a view of the nut.

Figure 2 is a view of the same before being pressed into shape.

The object of my invention is to make an axle-nut from wrought iron, and consists in the process for that purpose hereinafter described and claimed.

Axle-nuts have heretofore been made from wrought-iron by the ordinary hand-forging process, which, from its lack of rapidity and the expense of the labor required, is now seldom, if ever employed in their manufacture.

Axle-nuts are generally cast from malleable iron, although ordinary cast-iron is sometimes used.

In my invention I roll the wrought-iron in any desired manner into a long strip having four equal sides, through the center of which extends a round hole.

This tube thus formed is afterwards cut into pieces of the desired length, as shown in fig. 2. These pieces, after being brought to a proper degree of heat, are, by means of suitable dies and pressure, brought into the shape of an axle-nut, as shown in fig. 1, after which the thread is cut upon its inside circumference, when the nut is ready for use.

Thus I produce a nut from wrought iron by the process above described, superior to those now in use made from cast or malleable iron, by reason of its increased strength, and, from the rapidity of manufacture, with much less expense.

The tube may, however, be rolled six-square, or in any other shape that may be desired.

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

The process herein described of forming axle-nuts, consisting in the rolling of the iron into suitable tubes and the subsequent cutting and pressing of the same into nuts, substantially as described.

SAMUEL VANSTONE.

Witnesses:

GEORGE O. FALL,  
WALTER B. VINCENT.