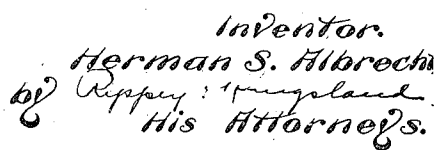


1,436,931.

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UNITED STATES PATENT OFFICE.

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METALLIC BILLET OR BAR.

Application filed May 9, 1921. Serial No. 468,080.

To all whom it may concern:

Be it known that I, HERMAN S. ALBRECHT, a citizen of the United States, residing at the city of St. Louis and State of Missouri, have invented a new and useful Improvement in Metallic Billets or Bars, of which the following is a specification.

This invention relates to improvements in metallic billets or bars, and consists in the novel construction hereinafter disclosed.

An object of the invention is to provide a metallic billet or bar having indentations or score lines extending into the surface of the metal thereof a sufficient depth so that the bar when broken will form slugs of substantially uniform cubic content.

In the drawing Fig. 1 is a side elevation of a round bar including the present invention.

Fig. 2 is a cross section on the line 2—2 of Fig. 1.

Fig. 3 illustrates, in side elevation, a modified form of bar including the invention.

Fig. 4 is a cross section on the line 4—4 of Fig. 3.

Fig. 5 illustrates, in side elevation, a further modification of the bar including the invention.

Fig. 6 is a cross section on the line 6—6 of Fig. 5.

Fig. 7 is a further modification of a bar, in side elevation, including the invention.

Fig. 8 is a cross section on the line 8—8 of Fig. 7.

As illustrated in the drawing the bar 1 may be of any desired shape in cross section, it not being intended to limit the bar as to shape.

The bar of the desired cross sectional shape is rolled in a suitable apparatus so that the outer surface thereof is indented at predetermined intervals forming indentations or score lines 2 substantially cutting through the body of the bar, leaving only a relatively thin connection 3 between the different sections 4 thereof. By rolling the bar the material thereof is pressed to shape, the molecular arrangement of the metal being modified and set in the changed shape by the pressure without loss of material, as in the case of cutting the bar to the shape desired.

A bar thus formed may be readily broken, the segments thereof being of substantially the same cubic content.

In practice it has been found very difficult to saw or otherwise sever the bar into uniform sections. In the bar of the present invention as the indentations are mechanically formed at uniform predetermined intervals, the sections when broken from the bar are uniform in cubic content.

I claim.

A rolled metallic billet or bar, composed of a series of axially aligned spherical bodies having their spherical surfaces in contact and integrally united.

HERMAN S. ALBRECHT.