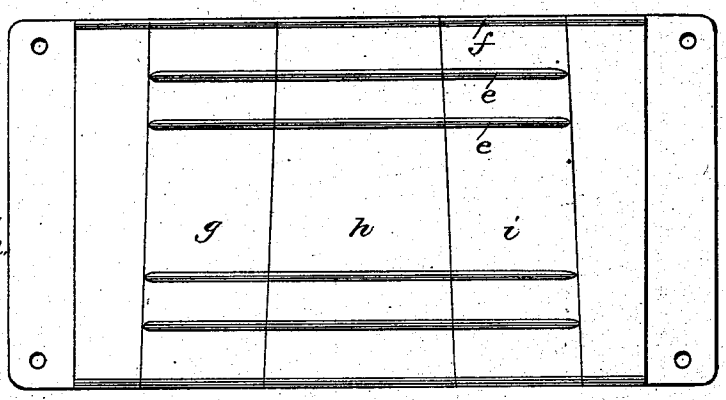
(No Model.)

C. T. SCHOEN.

DIE FOR MAKING STAKE POCKETS FOR CARS.

No. 381,175. Patented Apr. 17, 1888.

Fig. 1.



C. or d. the two being complemental.

Fig. 2.

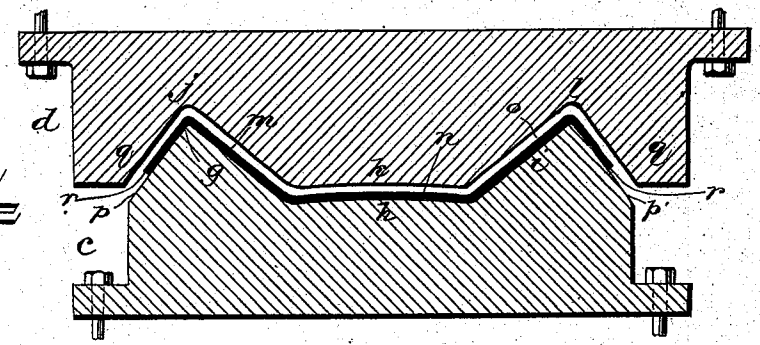


Fig. 3.

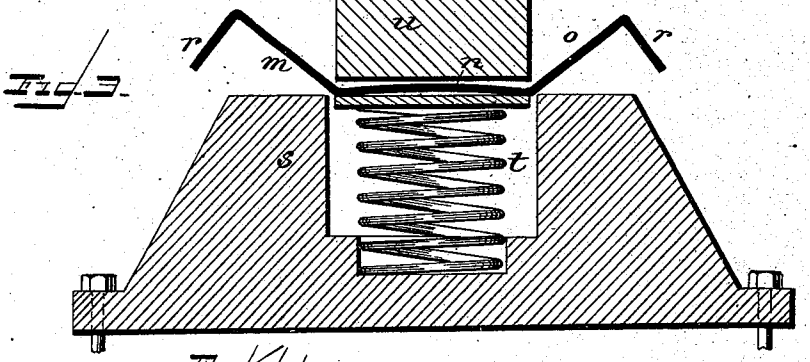


Fig. 4.

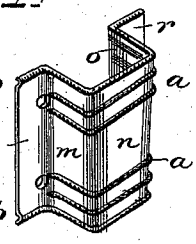
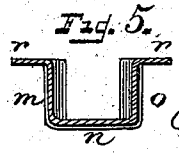


Fig. 5.



WITNESSES

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UNITED STATES PATENT OFFICE.

CHARLES T. SCHOEN, OF PHILADELPHIA, PENNSYLVANIA.

DIE FOR MAKING STAKE-POCKETS FOR CARS.

SPECIFICATION forming part of Letters Patent No. 381,175, dated April 17, 1888.

Application filed January 21, 1888. Serial No. 261,484. (No model.)

To all whom it may concern:

Be it known that I, CHARLES T. SCHOEN, a citizen of the United States, residing at Philadelphia, in the county of Philadelphia and State of Pennsylvania, have invented a certain new and useful Improvement in Dies for Making Stake-Pockets for Cars, of which the following is a full, clear, and exact description.

This invention relates to the manufacture of stake pockets or holders for railway-cars from wrought metal, such as sheet or plate steel or iron.

The object of the invention is to provide means for making in a practical and commercially-economical manner the wrought-metal stake-pocket forming the subject of my application of even date herewith, entitled "stake-pocket for cars."

The invention consists in dies for forging or striking up a wrought-metal stake-pocket.

In the accompanying drawings, in the several figures of which like parts are similarly designated, Figure 1 is a plan and Fig. 2 a cross-section of the blank-forming die. Fig. 3 is a cross-section of the finishing-die. Fig. 4 is a perspective view of the product, and Fig. 5 a cross-section of the said product.

At the outset I desire to say that I prefer to use two sets of dies and heat the blank separately for treatment in each, though it is within my invention to begin and finish the article in one heat and by a single set of dies.

A flat sheet or plate of wrought metal (say Bessemer steel) of the proper width and length is taken and the appropriate number of holes punched therein for the reception of the straps used to fasten the pocket to the car. Then this piece of metal is subjected to the action of dies which shape it and form thereon the beads or ribs *a b* of Fig. 4. The dies *c d* are formed with matrices and projections *e f* to form these beads or ribs, and also with the pyramidal or tapering matrices and projections *g*, *h*, and *i*, and *j*, *k*, and *l*, to form the body (three sides, *m n o*,) of the pocket, and are also provided with matrices or projections *p q* to form the flanges *r* of the pocket. The matrix *h* and projection *k* are slightly curved to correspondingly curve the face side *n*, so as to facilitate the subsequent squaring of the sides *m o*.

The blank is given the preliminary shape indicated in Fig. 2, and is then subjected to the dies of Fig. 3. In these dies the matrix *s* is provided with a spring-ejector, *t*, quite commonly employed to throw out the product after the action thereupon of the dies. This female die may be provided with recesses to receive the beads and preserve them from destruction or defacement by the male die *u*. The dies *s u* give to the pocket its finished shape, as shown in Figs. 4 and 5.

The dies may be constructed to form one or more pairs of beads, *a*, as the finished pocket requires. The beads *b* may or may not be required. The metal between the beads may be bowed out to form a seat for a curved instead of an angular clip, this being a known form of such pockets, and the dies in this particular will be modified accordingly.

Instead of forming the beads *a* and *b* in the dies they may be rolled in the manufacture of the sheet or plate, or subsequently and before treatment in the dies.

What I claim is—

1. Dies for making wrought-metal stake-pockets for railway-cars, provided with matrices and projections for forming the sides of the pocket, and appropriate parallel beads thereon for receiving the straps for securing such pockets to the car, substantially as described.

2. Dies for making wrought-metal stake-pockets for railway-cars, provided with matrices and projections for forming the body and body-flanges and beads thereon, substantially as described.

In testimony whereof I have hereunto set my hand this 20th day of January, A. D. 1888.

CHARLES T. SCHOEN.

Witnesses:
WM. H. LEWIS,
EDWIN A. SCHOEN.