B. P. ROWE.

METHOD OF MAKING TERMINAL DEVICES.

APPLICATION FILED SEPT. 26, 1910.

1,156,710.

Patented Oct. 12, 1915.

Fig. 1.

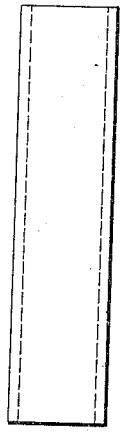


Fig. 2.

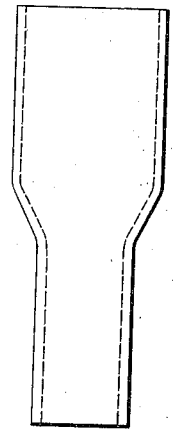


Fig. 3.

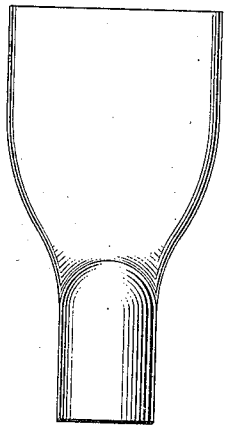


Fig. 4.

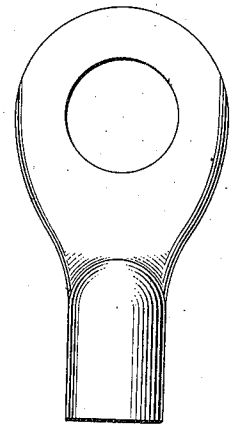
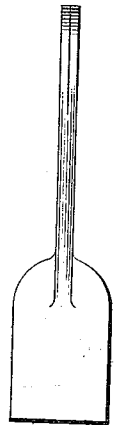


Fig. 5.



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METHOD OF MAKING TERMINAL DEVICES.

1,156,710. Specification of Letters Patent. Patented Oct. 12, 1915.

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To all whom it may concern:

Be it known that I, BERTRAND P. ROWE, a citizen of the United States, and a resident of Wilkinsburg, in the county of Allegheny and State of Pennsylvania, have invented a new and useful Improvement in Methods of Making Terminal Devices, of which the following is a specification.

My invention relates to terminal members for cables and other electrical conductors, and it has for its object to provide a simple and effective method of forming a terminal member that shall have a high current-carrying capacity and shall present a large area for engagement with parts to which it is connected.

A terminal member has heretofore been provided for electrical conductors which consisted of a tube having one open end for the reception of the cable or other conductor and its other end flattened for engagement with the part to which the conductor is connected. In order to permit of ready attachment of the terminal member to the said part, the flattened portion is usually perforated and the area presented for engagement with the said part is often thereby so reduced as to unduly diminish the current-receptive capacity of the member and to cause undue heating and drop of potential.

According to the present invention, a terminal member is formed by expanding one end of a tube and flattening and perforating the expanded end to provide such area for engagement with parts to which the member is connected that its current-receptive capacity may correspond to its conductive capacity.

Figure 1 of the accompanying drawing represents a blank from which the terminal member is made. Fig. 2 represents the terminal in its second stage of manufacture. Fig. 3 represents the terminal in the third stage of manufacture. Fig. 4 is a face view of a completed terminal, and Fig. 5 is a side view of a completed terminal.

The blank from which the terminal member is made consists of a tube, such as shown in Fig. 1, that is composed of copper or other suitable ductile material. The blank is first expanded at one end, as shown in Fig. 2, or its ends may be otherwise caused to have different diameters, as by swaging and reducing one end. The larger end of the blank, as shown in Fig. 2, is next flattened, as shown in Fig. 3, and is finally perforated and trimmed, as shown in Figs. 4 and 5.

By reason of the enlargement of the flattened end of the member, with respect to the unflattened end, the annular portion of the flattened end presents sufficient area, for engagement with parts to which the member is connected, to permit of conduction of current from the said part to the cable or other conductor without overheating and undue drop of potential.

I claim as my invention:

1. The method of forming a terminal member that consists in enlarging one end of a tube and then flattening and perforating the enlarged end.

2. The method of forming a terminal member that consists in causing a sheet metal tube to differ in diameter at its ends and then flattening and perforating the larger end.

In testimony whereof, I have hereunto subscribed my name this 17 day of September, 1910.

BERTRAND P. ROWE.

Witnesses:

H. N. BARTLETT,

B. B. HINES.