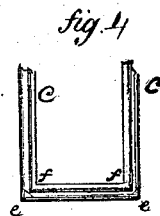
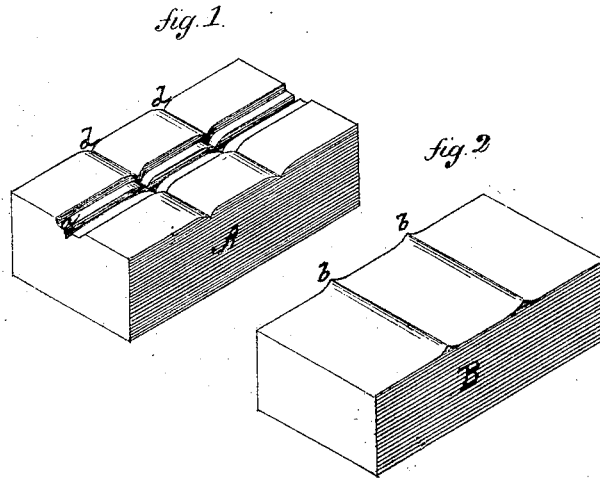


M. SEWARD.

Improvement in Dies for Forging Carriage-Clips.
Patented April 25, 1871.

No. 114,051.



Witnesses
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UNITED STATES PATENT OFFICE.

MOSES SEWARD, OF NEW HAVEN, CONNECTICUT.

IMPROVEMENT IN DIES FOR FORGING CARRIAGE-CLIPS.

Specification forming part of Letters Patent No. **114,051**, dated April 25, 1871.

To all whom it may concern:

Be it known that I, MOSES SEWARD, of New Haven, in the county of New Haven and State of Connecticut, have invented a new Improvement in Dies for Forging Carriage-Clips; and I do hereby declare the following, when taken in connection with the accompanying drawings and the letters of reference marked thereon, to be a full, clear, and exact description of the same, and which said drawings constitute part of this specification, and represent, in—

Figure 1, a perspective view of the lower die; Fig. 2, a perspective view of the upper die inverted; Fig. 3, the blank as it comes from the die, and in Fig. 4 the clip finished.

This invention relates to an improvement in dies for forming the blanks for carriage-clips such as are bent at right angles, the object of the invention being to prepare the blank so as so form perfect angles when bent.

To this end the invention consists in dies shaped corresponding to the surface of the clip-blank to be produced, with a sharp depression at the two points where the angles are to be formed, and the upper die with corresponding projections.

A is the lower die, with a channel, *a*, through its surface, shaped corresponding to the surface of the clip to be produced. Transversely across the die I form two sharp depressions, *d*

d, distant from each other according to the width of the clip to be produced.

B, the upper die, is a plain surface, with two transverse projections, *b b*, corresponding to the depressions *d*. The dies being properly arranged, the blank from which the clip is to be formed (after being properly heated) is placed in the channel *a*, and the upper die struck down thereon shapes the surface of the blank, and at the same time makes the depressions *f f* (see Fig. 3) upon the upper surface, and corresponding sharp projections, *e*, upon the reverse side. The blank thus shaped is then, by any suitable device, bent up until the two sides *C C* are parallel to each other, as seen in Fig. 4, in which operation the blank is straightened between the depressions, the sharp projections forming the external angles and the depressions the internal angles, clearly and sharply defined, as in Fig. 4, which cannot be done when the clip is bent without such depressions, as the metal upon the outside will be drawn and form a round corner.

I claim as my invention—

The dies, constructed as herein described, for forging carriage-clips.

MOSES SEWARD.

Witnesses:

J. H. SHUMWAY,
A. J. TIBBITS.