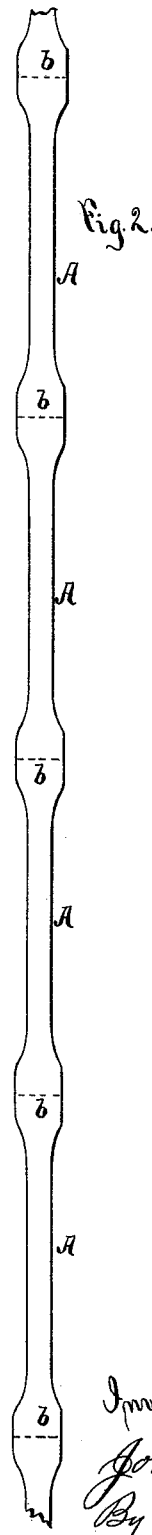
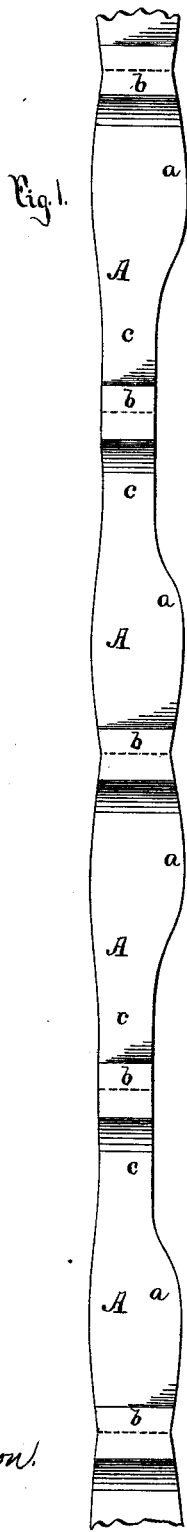


J. DEEBLE.  
Ox-Shoe Blank-Bars.

No. 220,813.

Patented Oct. 21, 1879.



Witnesses.  
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# UNITED STATES PATENT OFFICE.

JOHN DEEBLE, OF SOUTHLINGTON, CONNECTICUT.

## IMPROVEMENT IN OX-SHOE-BLANK BARS.

Specification forming part of Letters Patent No. **220,813**, dated October 21, 1879; application filed August 7, 1879.

### *To all whom it may concern:*

Be it known that I, JOHN DEEBLE, of Southington, in the county of Hartford and State of Connecticut, have invented certain new and useful Improvements in Ox-Shoe-Blank Bars, of which the following is a specification.

My invention consists, first, of a rolled bar in the form of a series of connected ox-shoe blanks, as hereinafter more fully described; second, in the peculiar form of blank, with the swell for the calks equally divided upon both sides, as hereinafter more fully described.

In the accompanying drawings, Figure 1 is a side elevation of a rolled bar, which embodies my invention, and Fig. 2 is an edge view of the same.

A designates the portion of a rolled bar which constitutes a single blank for an ox-shoe, the division of said blanks, or the point where they are cut into, being indicated by transverse broken lines. I form these blanks with the broad part, *a*, extending from the heel about half-way to the toe, and of substantially the form of a finished shoe, excepting the calks. The narrow part, *c*, on the toe end, I form of substantially the proper size, but nearly straight.

At each end of each blank I form a swell, *b*, substantially equally divided on each side, for convenience of rolling the bar, and for the further purpose that the blanks may be struck up in either a right-hand or a left-hand die to form either handed shoe, as may be desired. If desired, however, the bar may be rolled with the swells *b* which are to form the calks all on one side of the bar, instead of both sides, without materially changing the nature of the first part of my invention.

These blanks are joined together in the bar, toe to toe and heel to heel, for convenience of rolling. The bar, in the form shown, and of indefinite length, is to be produced by rolls, the peripheries of which are recessed with grooves which are the counterpart of the blanks A. A plain bar of hot iron passed through said rolls will produce the bar herein shown and described.

After the bars have been severed into blanks on the broken lines, the narrow portion, *c*, is bent into the desired curved form, after which the blank is struck in a proper die to level up one side, by throwing all the metal in the swells *b b* to the opposite side, and form the same into calks. It will readily be observed that these swells may be thrown to either side of the shoe, and, consequently, blanks which are all alike may be converted into either right or left handed shoes, as may be desired.

These bars are designed for sale to manufacturers of ox-shoes, to be finished in any proper dies. The dies patented to me December 16, 1873, No. 145,633, are suitable dies for finishing these blanks.

I claim as my invention—

1. As a new article of manufacture, the rolled bar consisting of the connected series of ox-shoe blanks, substantially as described, and for the purpose specified.

2. The ox-shoe blank herein described, in which the swells for forming the calks project equally from both sides, substantially as described, and for the purpose specified.

JOHN DEEBLE.

Witnesses:

JAMES SHEPARD,  
C. A. SHEPARD.