

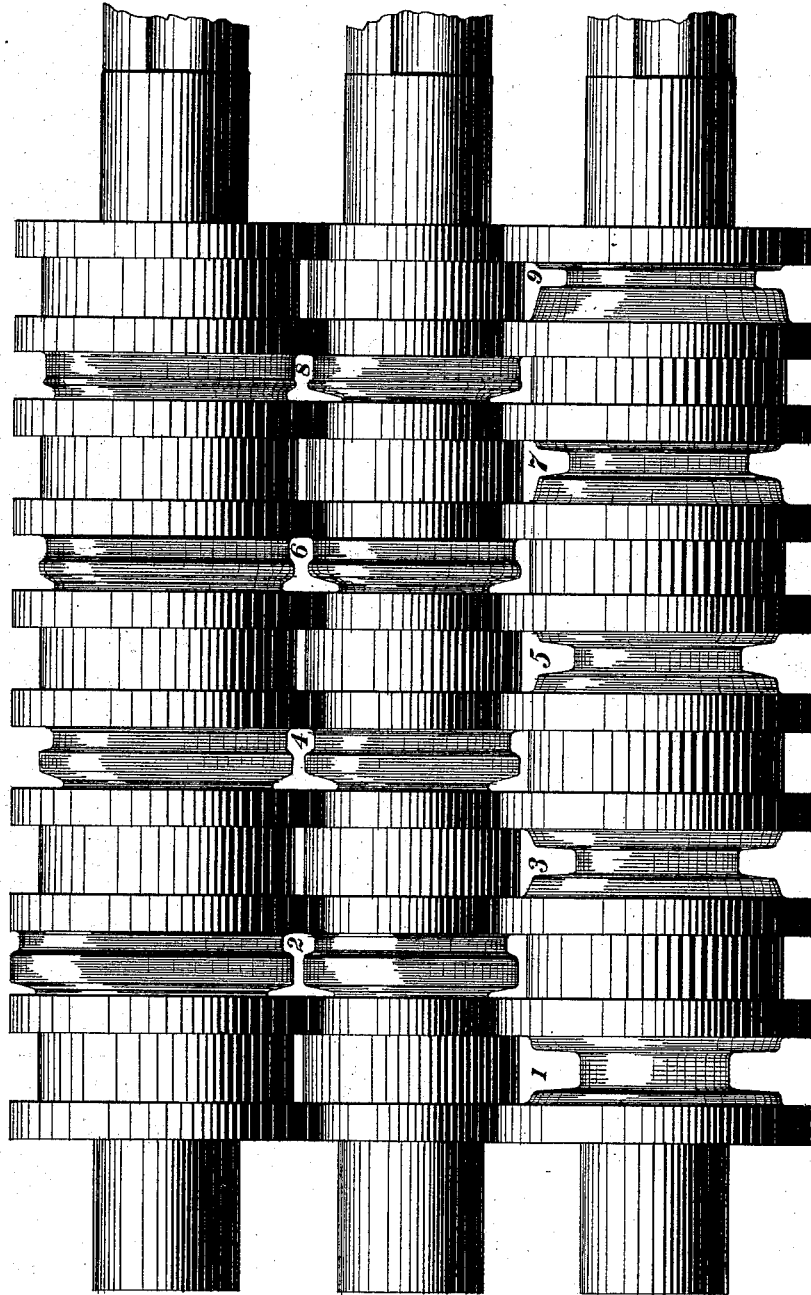
(No Model.)

G. WOSTENHOLM.

ROLLS FOR ROLLING FISH BARS FROM OLD RAILS.

No. 347,310.

Patented Aug. 10, 1886.



Witnesses:

B. E. Rep
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Inventor:

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UNITED STATES PATENT OFFICE.

GEORGE WOSTENHOLM, OF JEFFERSONVILLE, ILLINOIS, ASSIGNOR OF ONE-HALF TO THEODORE A. MEYSENBURG, OF ST. LOUIS, MISSOURI.

ROLLS FOR ROLLING FISH-BARS FROM OLD RAILS.

SPECIFICATION forming part of Letters Patent No. 347,310, dated August 10, 1886.

Application filed May 17, 1886. Serial No. 202,479. (No model.)

To all whom it may concern:

Be it known that I, GEORGE WOSTENHOLM, of Jeffersonville, Wayne county, Illinois, have made an Improvement in Rolls for Rolling Angled Fish-Bars from Old Steel Rails, of which the following is a full, clear, and exact description—that is, by means of rolls such as are shown in the annexed drawing, making part of this specification, angled fish-bars can be prepared from a single steel railway-rail, or, stated more definitely, the rolls serve to rough out the fish-bars, leaving them to be finished in rolls of the ordinary form.

The improvement consists, mainly, in the first two-thirds of the passes in combination with each other; but in practice the remaining passes are preferably employed in combination with the first six passes.

The rail from which the fish-bars are made is of the customary form in cross-section, it being generally a worn-out steel rail, such as commonly have been used upon railways.

In the first pass, numbered 1 in the drawing, the web of the rail is upset, say, three-eighths of an inch. In the second pass, numbered 2 in the drawing, one side of the rail-foot is reduced in width, say, one-fourth of an inch, the opposite side of the rail-foot is widened, say, one-sixteenth of an inch, the web of the rail is straightened, and the tread is narrowed, say, five-sixteenths of an inch. In pass numbered 3 the web is again upset, say, three-eighths of an inch. In pass numbered 4, the rail-foot at one side is narrowed, say, another quarter of an inch, and at the opposite side is widened, say, another sixteenth of an inch, the web is straightened, and the tread narrowed, say, another quarter of an inch. In pass numbered 5 the web is upset

another quarter of an inch. In pass numbered 6 the rail-foot at one side is reduced, say, another quarter of an inch, and at the opposite is enlarged another sixteenth of an inch, and the tread narrowed another, say, five-sixteenths of an inch. In pass numbered 7 the web is upset, say, another three-eighths of an inch. In pass numbered 8 the rail-foot at one side is reduced, say, another quarter of an inch, and at the opposite side is widened, say, another sixteenth of an inch, and the tread is narrowed, say, nine-sixteenths of an inch, and in pass numbered 9 the now approximately-formed angled bar is upset, say, another quarter of an inch, when it is ready for the finishing-rolls, which are not shown in the drawing. In passes numbered 2 4 6 8 the web of the rail is not only straightened, but is also gradually thickened—that is, say, one-sixteenth of an inch in pass 1, the same amount in pass 4, say another sixteenth of an inch in pass 6, and in pass 8, say, one-fourth of an inch more, and making that part of the construction about one inch in thickness.

I claim—

1. A set of rolls for rolling angled fish-bars from old steel rails with passes of the respective shapes shown in the accompanying drawing, and therein numbered from 1 to 9, inclusive, as described.

2. For the purpose described, a set of rolls with passes of the respective shapes shown in the accompanying drawing, and numbered from 1 to 6, inclusive, as described.

Witness my hand.

GEORGE WOSTENHOLM.

Witnesses:

C. D. MOODY,

C. T. BISER.