

(No Model.)

R. H. PLASS.
METHOD OF MAKING CUT NAILS.

No. 385,373.

Patented July 3, 1888.

Fig. 1.

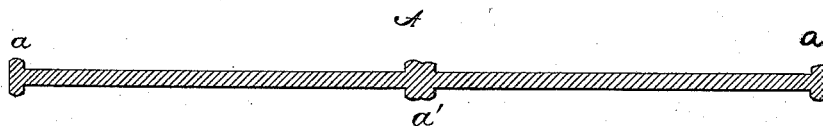
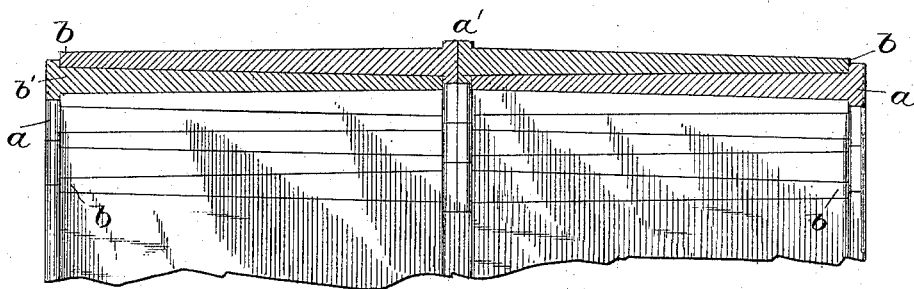


Fig. 2.



Witnesses:

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UNITED STATES PATENT OFFICE.

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METHOD OF MAKING CUT NAILS.

SPECIFICATION forming part of Letters Patent No. 385,373, dated July 3, 1888.

Application filed September 10, 1886. Serial No. 213,217. (No model.)

To all whom it may concern:

Be it known that I, REUBEN H. PLASS, a citizen of the United States, residing at New York, in the county of New York and State of New York, have invented certain new and useful Improvements in Method of Making Steel Nails; and I do hereby declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it appertains to make and use the same.

This invention relates to the manufacture of nails.

The object of the invention is to produce nails by a method of manufacture in which they may be made without waste and by workmen not necessarily skilled.

With these objects in view my invention resides, essentially, in a method of manufacturing nails, consisting in first rolling the metal from which the nails are to be made into sheets of the thickness of which it is designed to make the nails, the said sheets being formed at each edge and in the center with raised flanges extending upon both sides of the plate; next, in punching or cutting the nails from the plate by a suitable die in such manner that the points of one set of nails will be cut away near the heads of the adjacent set of nails, so that any loss of material is avoided.

In the accompanying drawings, in which my method of making nails is illustrated, Figure 1 represents a sectional view of a plate rolled in accordance with the first step of my invention. Fig. 2 is a plan view showing the sheet of metal after it has been stamped to form the nails.

In the drawings, A represents the sheet of metal. *a a* represent the beads or flanges formed on the outside of the plate, and *a'* represents the flange formed in the center of the plate. This flange formed in the center of the plate is of twice the size of those formed upon the edges, and is usually provided with an indentation designed to divide the heads of adjacent nails. The dies for stamping the nails from the plates are of such shape that the heads and points will be formed at one operation, as will be readily understood.

In the drawings I have outlined nails formed with square ends and tapering gradually from the heads toward these ends. It will be observed that the smaller portion, *b*, of one nail is in contact with the larger portion, *b'*, of the next adjacent nail, thus utilizing all the metal

Of course, in case the nails are stamped to form pointed smaller ends, the under side of the heads will be slanting in order to conform thereto.

By making the plate of sufficient width and providing it with the central indented rib or flange, *a'*, I am enabled to make a very large quantity of nails by a single operation, and it is only necessary so to form the die by which the nails are punched or cut from the plate as to provide for the division of the heads at the center of the plate.

I am aware of a plate for making nails having the side edges provided with flanges, and I lay no claim to such construction, inasmuch as my invention consists in providing the plate not only with the edge flanges, but with a double central flange, so that two nails are formed across the width of the plate.

Having thus fully described my invention, what I claim as new, and desire to secure by Letters Patent, is—

The improvement in the method of making cut nails, which consists in rolling a piece of metal into sheets, to provide said sheets with heads or flanges at each edge and a corresponding flange of double width along the center, each of said flanges projecting a uniform distance beyond both surfaces of the sheet, and then stamping, cutting, or shearing out the finished nails in such manner that the smaller portion of one nail is adjacent to the larger portion of the next nail, substantially as described.

In testimony whereof I affix my signature in presence of two witnesses.

REUBEN H. PLASS.

Witnesses:

CHAS. A. FENN,
DANIEL HUEBNER.