

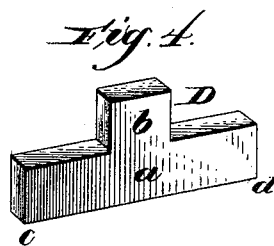
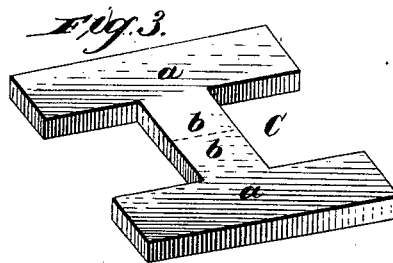
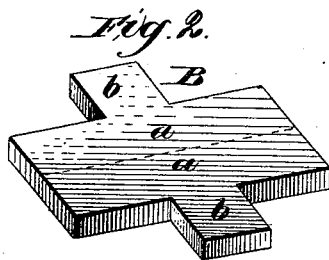
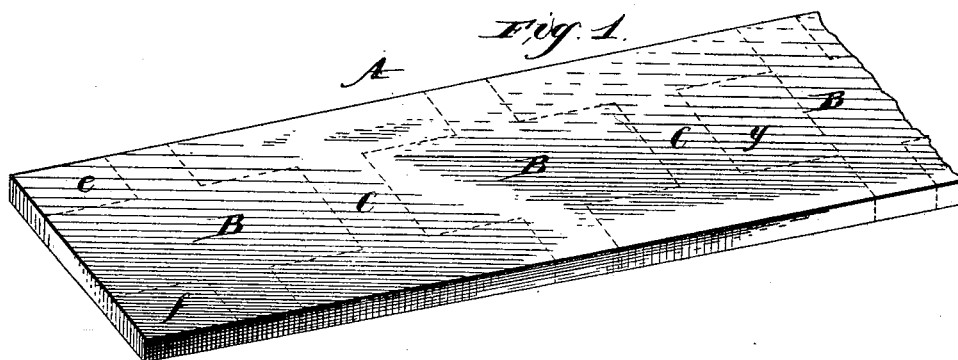
(No Model.)

H. M. MYERS.

METHOD OF MAKING SHOVEL BLANKS.

No. 385,819.

Patented July 10, 1888.



Witnesses—

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UNITED STATES PATENT OFFICE.

HENRY M. MYERS, OF BEAVER FALLS, PENNSYLVANIA.

METHOD OF MAKING SHOVEL-BLANKS.

SPECIFICATION forming part of Letters Patent No. 385,819, dated July 10, 1888.

Application filed March 27, 1888. Serial No. 268,696. (No model.)

To all whom it may concern:

Be it known that I, HENRY M. MYERS, a citizen of the United States, residing at Beaver Falls, in the county of Beaver and State of Pennsylvania, have invented certain new and useful Improvements in the Method of Manufacturing Shovel-Blanks; 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.

My invention relates to the art of shovel-making, and has for its object an improved method of manufacturing blanks.

The invention will be hereinafter described, and particularly pointed out in the claim.

In the accompanying drawings, which form part of this specification, Figure 1 represents a perspective of a bar, showing double shovel-blanks in dotted lines. Fig. 2 is a similar view of two blanks with their body portions joined. Fig. 3 is a similar view of two blanks joined at their tangs, and Fig. 4 represents a single blank.

Reference being had to the drawings and the letters marked thereon, A represents a bar of metal from which double shovel-blanks B C are cut. The blanks B are joined at their body portion *a*, and the blanks C at their tangs *b*. In cutting blanks by this method the bar A is fed into a suitable machine (not shown) provided with cutting-dies of the configuration of the double blank B, and after the first cut in the end of the bar which severs the first double blank B each subsequent downstroke will cut out a blank, B, and a blank, C, thus making two double blanks at each stroke of the cutting-machine.

In the manufacture of shovels having only one handle strap formed integral with the blade of the shovel and the back strap riveted on the blanks may be reduced to the dimensions of shovel-blades before they are severed; but in the manufacture of shovels in which the

socket is formed before the blank is reduced, and both handle-straps are formed integral with the shovel-blade, the double blanks must be separated before they are reduced. To separate the double blanks and form single blanks, the blanks B are severed through the body portion on the dotted line shown in Fig. 2, and the blanks C are severed through the tangs on the dotted line shown in Fig. 3. Each single blank D will then be provided with a tang, *b*, and a body, *a*, which is of a width from the end *c* to the end *d* substantially equal to the blade of the finished shovel made therefrom. Blanks other than for the manufacture of shovels may be made in the same manner.

By cutting double blanks in the manner shown and described the bar from which the blanks are cut is fed into the machine without turning it after each stroke of the machine, and may therefore be handled with much greater ease by an operator than when the bar is required to be turned; or an automatic feed mechanism may be employed to move the bar a suitable distance between the strokes which cut the blanks.

The only waste metal in the bar is the rectangular corner-pieces *ef* at one end, and the square piece *g* at the other end.

Having thus fully described my invention, what I claim is—

The method of manufacturing shovel-blanks herein described, which consists in severing double blanks from a bar, each alternate blank being joined in the body of the blank, and the intermediate blanks joined in their tangs, then separating the double blanks and forming single blanks.

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

HENRY M. MYERS.

Witnesses:

J. F. MERRIMAN,
JOHN REEVES.