(No Model.)

J. E. EMERSON & J. S. KURTZ.

DIE FOR SHEARING FENCE PICKETS.

No. 422,929. Patented Mar. 11, 1890.

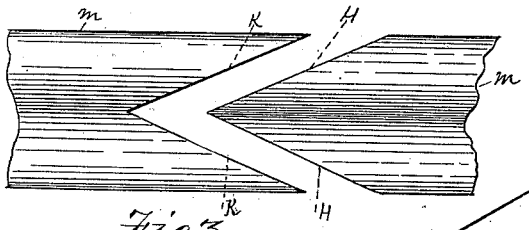

Fig. 3.

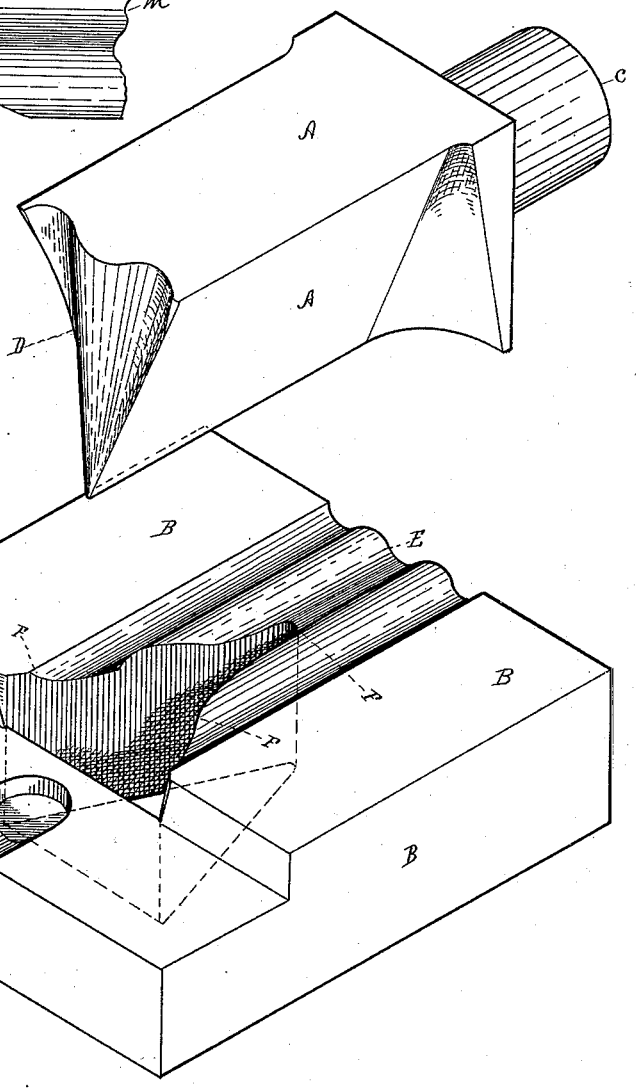

Fig. 1.

Fig. 2.

WITNESSES:

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JAMES E. EMERSON, OF BEAVER FALLS, AND JACOB S. KURTZ, OF ALLEGHENY, PENNSYLVANIA.

DIE FOR SHEARING FENCE-PICKETS.

SPECIFICATION forming part of Letters Patent No. 422,929, dated March 11, 1890.

Application filed December 2, 1889. Serial No. 332,180. (No model.)

To all whom it may concern:

Be it known that we, JAMES E. EMERSON and JACOB S. KURTZ, citizens of the United States, residing, respectively, at Beaver Falls, county of Beaver, and State of Pennsylvania, and at Allegheny, county of Allegheny, and State of Pennsylvania, have jointly invented or discovered a certain new and useful Improvement in Dies for Shearing Fence-Pickets, of which improvement the following is a specification.

The purpose of our invention is to devise top and bed dies adapted to shear the ends of pickets such as shown in Letters Patent No. 358,602 to James E. Emerson, dated March 1, 1887, for fence-pickets, or dies for similar work.

In the accompanying drawings, which make part of this application, Figure 1 is a perspective view of the top die, and Fig. 2 is a like view of the bottom die. Fig. 3 is a front view of the top and bottom of the pickets, broken away, and showing the cuts or shear made by the dies.

In Fig. 1 the upper die A has a pin C, by which the die A is securely set in the chuck of a suitable punching or shearing machine. The cutting-face of the die A is at D, which is corrugated or fluted to correspond to the corrugations in the pickets. The bed-die B has like corrugations at E, in which a part of the picket rests while being sheared. The cutting-face of the lower die is at F F along the two long sides of the triangle. The base of the triangle has no cutting-edge, as the intention is not to punch a triangular piece of metal out of the picket, but simply to point the top and notch the bottom of the pickets. Should the picket be barbed, the recess G will give the barb clearance.

The operation of the dies will now be apparent. The picket stuff M M, of the general outline shown in Fig. 3, is fed in long lengths into the dies, which simultaneously shear the point H H for the top of the picket and the notch K K for the bottom of the next picket, with no loss of metal whatever. Meantime the corrugations in the upper and lower dies have held the picket stuff gripped firmly in place without warping, bending, or twisting. By changing the cutting outline of the dies any desired form may be given to the point and notch.

Having fully described our invention, we claim—

The combination of the dies A and B for simultaneously pointing and notching the ends of adjacent picket-blanks.

In testimony whereof we have hereunto set our hands.

JAMES E. EMERSON.
JACOB S. KURTZ.

Witnesses:
WM. L. PIERCE,
C. C. LEE.