(No Model.)

J. W. ROOP.

BARBED FENCING STRIP.

No. 345,259. Patented July 6, 1886.

Fig. 1.

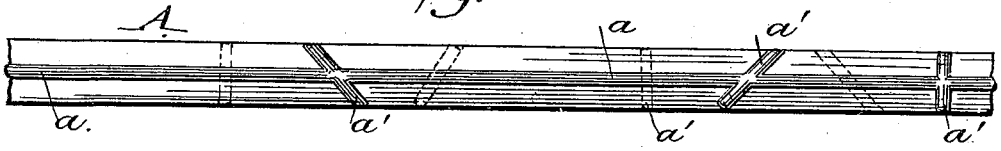


Fig. 2.

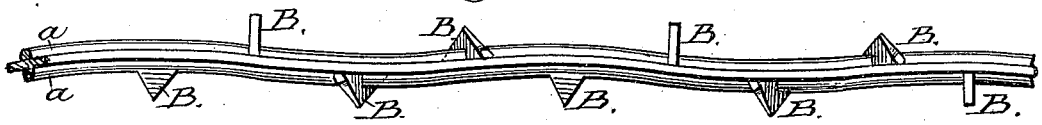


Fig. 3.

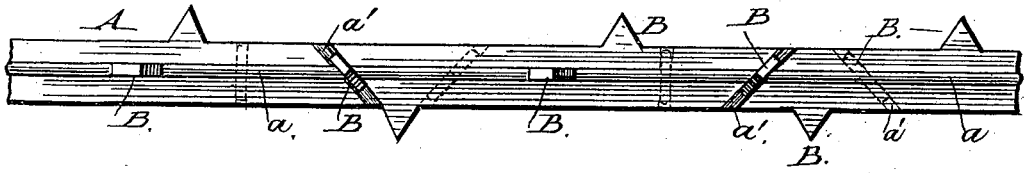
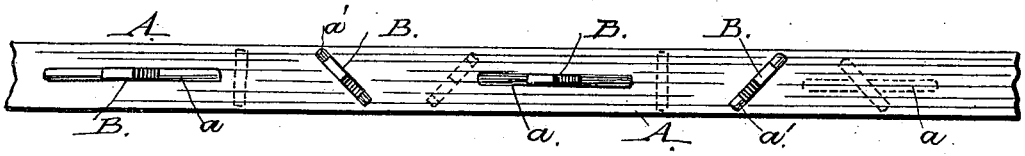


Fig. 4.



Witnesses
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UNITED STATES PATENT OFFICE.

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BARBED FENCING-STRIP.

SPECIFICATION forming part of Letters Patent No. 345,259, dated July 6, 1886.

Application filed October 28, 1885. Serial No. 181,134. (No model.)

To all whom it may concern:

Be it known that I, JACOB WARREN ROOP, a citizen of the United States, residing at Harrisburg, in the county of Dauphin and State of Pennsylvania, have invented a new and useful Improvement in Barbed Fencing-Strips, of which the following is a full, clear, and exact description, reference being had to the accompanying drawings, forming part of this specification, in which—

Figure 1 represents a side elevation of one of my improved fence-plates, showing the longitudinal, diagonal, and transverse ribs. Fig. 2 is a plan view of the same with the plate slightly curved and the barbs formed. Fig. 3 shows the barbs on the edges of the plate as well as on the sides. Fig. 4 shows the longitudinal rib broken or interrupted.

The object of my present invention is to produce a barbed fencing-strip of sufficient stiffness to resist the pressure of stock, and with barbs so placed that they will only scratch or slightly cut and not seriously lacerate the stock; and it consists in the strip hereinafter explained and claimed.

To enable others skilled in the art to make and use my invention, I will proceed to describe the exact manner in which I have carried it out.

In the drawings, A represents a rolled plate, of any suitable metal, formed with longitudinal and transverse oval stiffening-ribs *a a'* on each side of the plate. The transverse or diagonal ribs *a'* are placed at such intervals along the plate as it may be desired to place the spurs B, all of which are made integral with the plate itself. By means of these oval stiffening-ribs the plate is stiffened longitudinally, diagonally, and transversely, the transverse and diagonal ribs holding the transverse and diagonal spurs rigidly in place and preventing their yielding or turning from their position when pressed by the stock. The spurs are formed on each side of the plates and along the line of the transverse and diagonal ribs, as shown in Figs. 1 and 4. By thus forming the spurs on the line of the ribs and on the longitudinal center of the sides of the plate, I avoid lacerating the stock when attempting to pass it, the spurs thus placed only producing a scratching or slightly cutting effect and doing no serious injury.

The plates may be straight or slightly curved, to compensate for the effects of heat and cold on the metal, and the plates themselves may be slightly twisted without departing from the spirit of my invention.

The longitudinal rib may not be continuous, but may be broken or interrupted, as shown in Fig. 4; but this forms no part of my invention, but is only a modification to be adopted when the plates are sufficiently stiff to justify it.

In the manufacture of my improved fencing-strip the billet is placed between rolls or series of rolls, which reduce it, after which it passes between rolls in the peripheries of which and at an acute angle to their circumference are made depressions and grooves, which form upon opposite sides of the blank or billet suitable ribs and spurs. As the strip advances it is engaged by other rolls or finishing-rolls having in their peripheries grooves and depressions arranged substantially as those in the former rolls, the configuration of the depressions corresponding with the finished barbs. If it be desired to slightly corrugate the fencing-strip after it leaves the last-named rolls, it is passed through to cam-shaped rolls having grooves and depressions corresponding with those in the finishing-rolls.

The several rolls have peripheral grooves for the strip or billet as well as for the ribs and barbs, and the depressions have sufficient clearance to prevent the spurs or barbs being stripped during the rotation of said rolls. When it is desired to produce barbs on the edges of the strip in addition to or instead of those on the sides, I form in the circumference of the rolls, and projecting outward from their peripheral grooves, suitable V-depressions, into which the metal is forced during the passage of the billet or strip through the several rolls or series of rolls.

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

A metallic barbed fence-plate consisting of the plate A, provided with the longitudinal oval stiffening-ribs *a*, and having the transverse and diagonal oval stiffening-ribs *a'*, and spurs B, formed integral therewith, all constructed substantially as and for the purpose herein set forth.

JACOB WARREN ROOP.

Witnesses:
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