H. H. GILMORE.

Horseshoe Blank-Bars.

No. 164,914. Patented June 29, 1875.

Fig. 1.

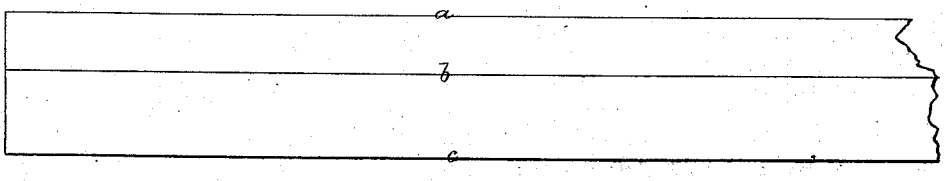
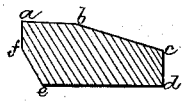


Fig. 2.



Witnesses.
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UNITED STATES PATENT OFFICE.

HENRY H. GILMORE, OF CAMBRIDGEPORT, MASSACHUSETTS.

IMPROVEMENT IN HORSESHOE-BLANK BARS.

Specification forming part of Letters Patent No. **164,914**, dated June 29, 1875; application filed February 12, 1875.

To all whom it may concern:

Be it known that I, HENRY H. GILMORE, of Cambridgeport, of the county of Middlesex and State of Massachusetts, have invented a new and useful Improvement in Metallic Bars for the Manufacture of Shoes for Horses or Mules; and do hereby declare the same to be fully described in the following specification, and represented in the accompanying drawings, of which—

Figure 1 is a top view, and Fig. 2 a transverse section, of a metallic bar made in accordance with my invention, it being usually made of sufficient length to be cut into several blanks or pieces, each suitable for being converted into a shoe of the kind mentioned.

Iron or steel bars, for being cut into pieces to be converted into either horse or mule shoes, have usually been square or rectangular in transverse section. With such a bar a blacksmith, in order to reduce a portion of it of requisite length to a shoe, has been under the necessity of first heating such portion, and by repeated blows of a hammer upon it "hemming it in," or beveling it on the edge to constitute the outer edge of the shoe, such being in order that such edge, by the subsequent process of creasing the metal, might be thrown out at or nearly at a right angle with the top surface of the bar, all of which required an expenditure of time, labor, and fuel, with much difficulty in producing a desired uniformity in the angle of the edge with the upper or lower surface of the bar.

The next operation in the making of the shoe is to bend the bar around into the correct form; to thicken and turn it at the heels, and thin and spread it from toe to heels; to crease it, and next make in it the usual nail-holes.

The object of my invention is to first save the necessity of the operation of hemming in the blank by the smith, and this I do by making the bar truncated or beveled at its lower outer corner or part, with the rest of the edge square to the tread, all being in manner as shown at *e f a* in Fig. 2, such being done in and by the process of rolling out the bar by means of reducing-rolls properly made for the purpose. From this it will be seen that when the creasing of a blank from such a bar takes place the metal at the outer edge, or where the bevel *e f* is, will be thrown out into the required angle with the upper surface. Furthermore, I roll the bar with a top slope, as shown at *b c* in Fig. 2, such being to save the smith much of the labor and time required in thinning down or concaving the blank.

When completed, the bar has the section as shown at *a b c d e f* in Fig. 2.

By having square to the tread *a b* the part *a f* of the outer edge that is above the crease, and making the slope *e f* to lead therefrom, instead of from the tread, a much better shoe, both in appearance and in other respects, can be formed, for the outer edge, on the crease being made, is not liable to be left hollow, as it is when the slope extends down from the tread. The metal thrown out by the creasing-tool is better supported at and near apex of the crease than would be the case were the whole outer edge one slope from the tread.

I therefore claim—

As an improved manufacture, a horseshoe-blank bar, rolled with or having a transverse section, substantially as shown at *a b c d e f* in Fig. 2, in which case the outer edge of the bar, in part, is square to the tread, as shown at *a f*, and below such slopes, as shown at *f e*, inward to an obtuse angle with the lower surface of the bar.

HENRY H. GILMORE.

Witnesses:

R. H. EDDY,

J. R. SNOW.