M. SEWARD.

DEVICE FOR SHAPING CLIP-YOKES.

No. 190,629. Patented May 8, 1877.

Fig. 2

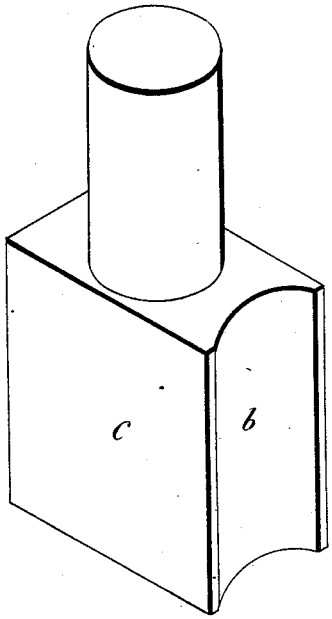


Fig. 1.

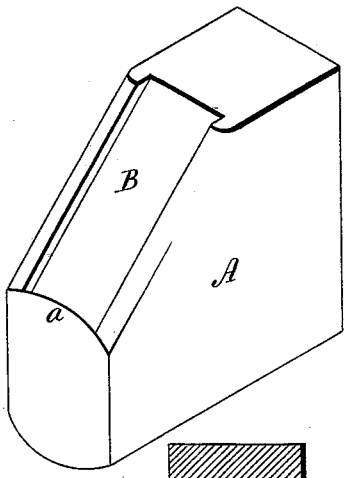


Fig. 4

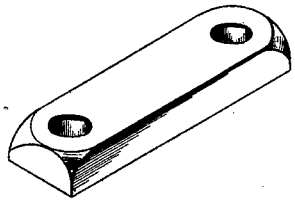
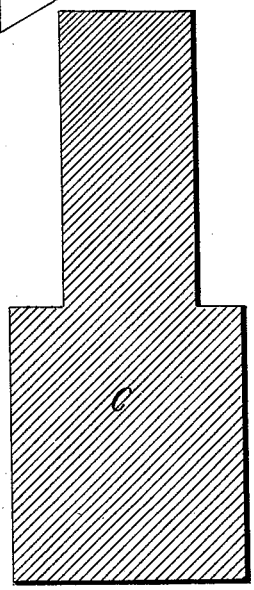
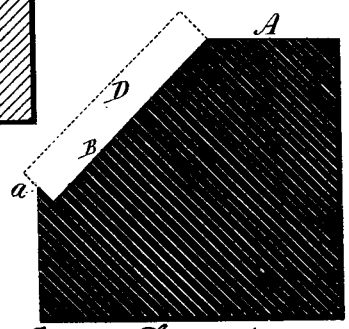


Fig. 3.





Witnesses.
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UNITED STATES PATENT OFFICE.

MOSES SEWARD, OF NEW HAVEN, CONNECTICUT.

IMPROVEMENT IN DEVICES FOR SHAPING CLIP-YOKES.

Specification forming part of Letters Patent No. **190,629**, dated May 8, 1877; application filed April 12, 1877.

To all whom it may concern:

Be it known that I, MOSES SEWARD, of New Haven, in the county of New Haven and State of Connecticut, have invented a new Improvement in Dies for Shaping Clip-Yokes; and I do hereby declare the following, when taken in connection with the accompanying drawings and the letters of reference marked thereon, to be a full, clear, and exact description of the same, and which said drawings constitute part of this specification, and represent, in—

Figure 1, a perspective view of the lower part of the die; Fig. 2, perspective view of the upper part of the die; Fig. 3, the two dies in working position; and in Fig. 4, perspective view of the bar as it comes from the dies.

This invention relates to dies for the manufacture of the article known to the trade as "carriage-clip yokes"—that is to say, the yoke which is used in connection with the clip for securing together parts of the running-gear, and particularly to that class of yokes which are formed with rounded ends. Such bars have usually been formed by forging in dies.

The object of this invention is to facilitate the manufacture of the yokes; and it consists in dies such as herein described—one shaped to receive and support the yoke-blank on an angle to the cutting-die, and a cutting-die which will strike the blank at an angle, so as to trim the end into the required shape, as more fully hereinafter described.

A is the lower part of the die, its working-surface formed so as to stand at an angle of about forty-five degrees. In this surface a seat, B, is formed, corresponding to the width of the yoke to be produced, and at the end of the seat a rest, *a*, is made, to support the blank against end thrust. The outer surface of the support *a* should correspond substantially to the shape to be produced. C, the second part of the die, has its working-surface made concave, as at *b*, or of the shape of the cut to be made. These dies are arranged as seen in Fig. 3, the die C being the moving die, and working vertically or at an angle of about forty-five degrees to the bearing-surface B. The blank D is cut from bars of iron of the required size, and to the required length. The blank is placed in the lower die, as seen in Fig. 3; then the upper die, forced down, clips the upper angle into the desired shape, (here represented as rounded, as seen in Fig. 4,) the working-surface *b* of the die being correspondingly concave. One end cut, the blank is reversed, and the other end cut in like manner. These may be done hot or cold, and much more rapidly than can be done by the usual forging process.

It will be understood that the holding-bed may be horizontal, and the moving die work diagonally thereto, and accomplish the same result, and that two similar cutting-dies may be arranged to work diagonally, so that the bar may be trimmed one end at a time, or both at the same time, without changing the position of the blank, and it will be understood that the relative position of the parts may be changed, so that the cutter will be stationary while the holder is moved.

I claim—

The device for shaping carriage-clip yokes, constructed substantially as shown and described.

MOSES SEWARD.

Witnesses:

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