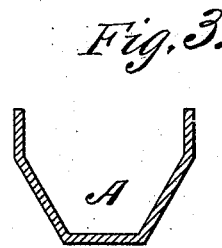
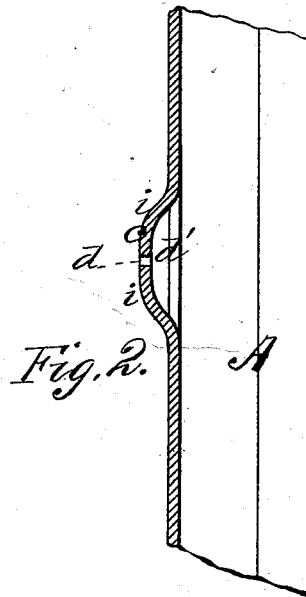
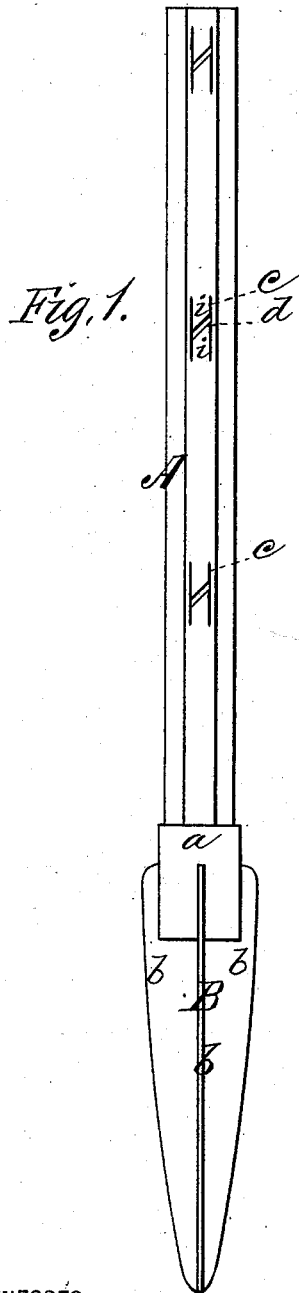


S. MILLER.  
Metallic Fence-Post.

No. 203,753.

Patented May 14, 1878.



WITNESSES  
*Mary S. Utley.*  
*F. J. Elasi*

INVENTOR  
*Samuel Miller,*  
*By E. W. Anderson.*  
ATTORNEY

# UNITED STATES PATENT OFFICE.

SAMUEL MILLER, OF CLINTON, IOWA.

## IMPROVEMENT IN METALLIC FENCE-POSTS.

Specification forming part of Letters Patent No. **203,753**, dated May 14, 1878; application filed January 5, 1878.

*To all whom it may concern:*

Be it known that I, SAMUEL MILLER, of Clinton, in the county of Clinton and State of Iowa, have invented a new and valuable Improvement in Metallic Fence-Posts; and I do hereby declare that the following is a full, clear, and exact description of the construction and operation of the same, reference being had to the annexed drawings, making a part of this specification, and to the letters and figures of reference marked thereon.

Figure 1 of the drawings is a representation of a front view of my invention. Fig. 2 is a longitudinal section of the same. Fig. 3 is a cross-section.

This invention has relation to improvements in metallic fence-posts for wire fences.

The nature of the invention consists in the process of forming opposite holding-lugs in a wrought-iron fence-post by cutting two parallel vertical slits and one oblique slit joining said vertical slits, bending the angular portions outward, and separating the two prongs thus formed by punching, thereby forming two opposite holding-lugs, bent toward each other, and an oblique slot of sufficient width to receive a wire between them, as will be hereinafter shown and described.

In the annexed drawings, the letter A designates the wrought-metal portion, and B the cast point, of my improved fence-post. The former is of the usual length, and is stamped out of sheet-iron, of suitable thickness, in the form of a half octagon, as shown in Fig. 3. It may, however, be forged out in the usual way. This upright is set in a mold, and a (preferably) three-flanged drive-point, B, cast on, the metal being run up the body several inches above the tops of the flanges *b* of the point, as shown at *a*, thereby giving the upper part of the post a firm bearing or seat in the point.

In the face of the part A are a number of catches, *c*, designed to hold the wires, which complete the fence. These catches are punched out of the body of the upright by means of a die of oblong form, having an advanced transverse oblique bit, which cuts the oblique slit *d* in metal forming the said catches before the strip of metal of which they are formed is punched out beyond the face of the upright.

The catch is formed of two branches, *i*, separated by the oblique slit *d* aforesaid. The wire is passed into this slit, and is received into the space *d'* between the catch and the body of the upright. Its connection with the post is thus made very secure, as it can only be detached therefrom by first raising the said wire, then bending it obliquely until its obliquity corresponds to that of the slit *d*, and then drawing it away from the post through the said slit, which can never occur casually.

What I claim as new, and desire to secure by Letters Patent, is—

The process of forming opposite holding-lugs in a wrought-iron fence-post, by cutting two parallel vertical slits and one oblique slit joining said vertical slits, bending the angular portions outward, and separating the two prongs thus formed by punching, thereby forming two opposite holding-lugs bent toward each other, and an oblique slit of sufficient width to receive a wire between them, substantially as specified.

In testimony that I claim the above I have hereunto subscribed my name in the presence of two witnesses.

SAMUEL MILLER.

Witnesses:

WILLIAM L. BRAY,  
CARLYLE B. MILLER.