

An article published in the Engineering News, August 17, 1905, with a sketch and description of an eye-bar upsetting machine at the Keystone Bridge Works, 1882.

“Bar “B” is placed between two flat dies and clamped down by a vertical plunger. “A” comes against the end of the bar, as shown. When the bar is heated the free end next to the plunger is covered with clay so that only the portion coming between the opening in the dies is heated. The stroke of the plunger upsets the bar to the shape shown. It is then reheated and formed to the final shape by the die, “C” and a suitable plunger, “D”. The bar is then given a wash heat and die forged: then hammered to thickness between flat dies by a helve hammer.”

