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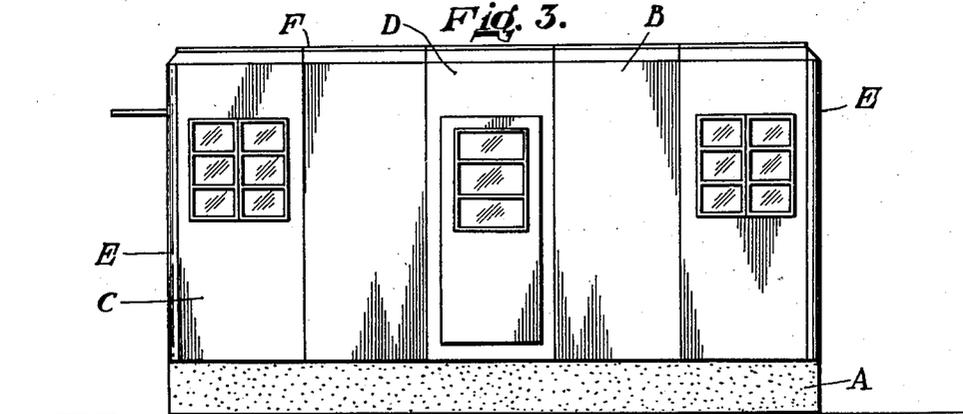
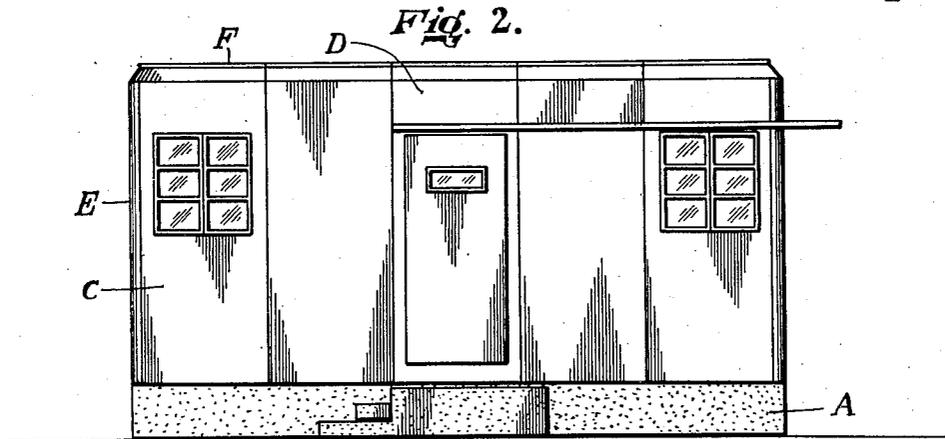
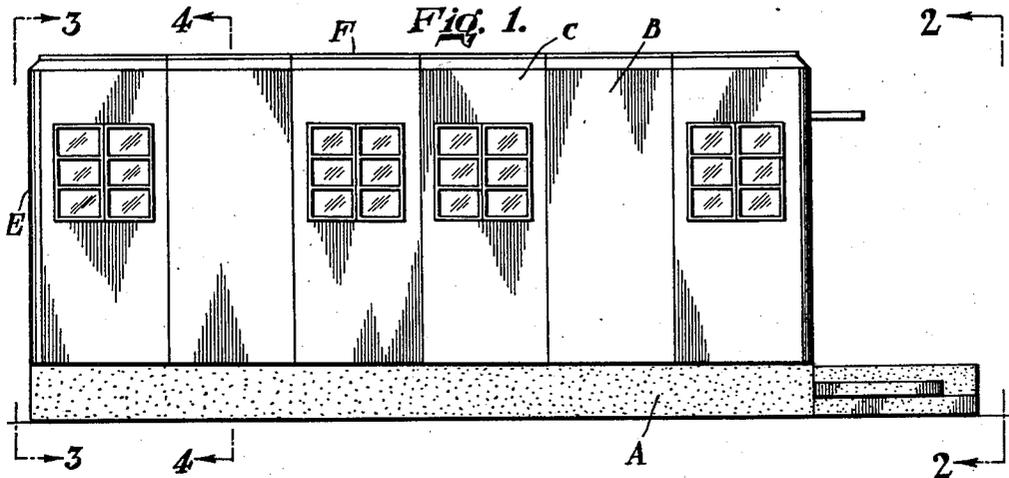
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PREFABRICATED HOUSE CONSTRUCTION

Filed May 10, 1938

5 Sheets-Sheet 1



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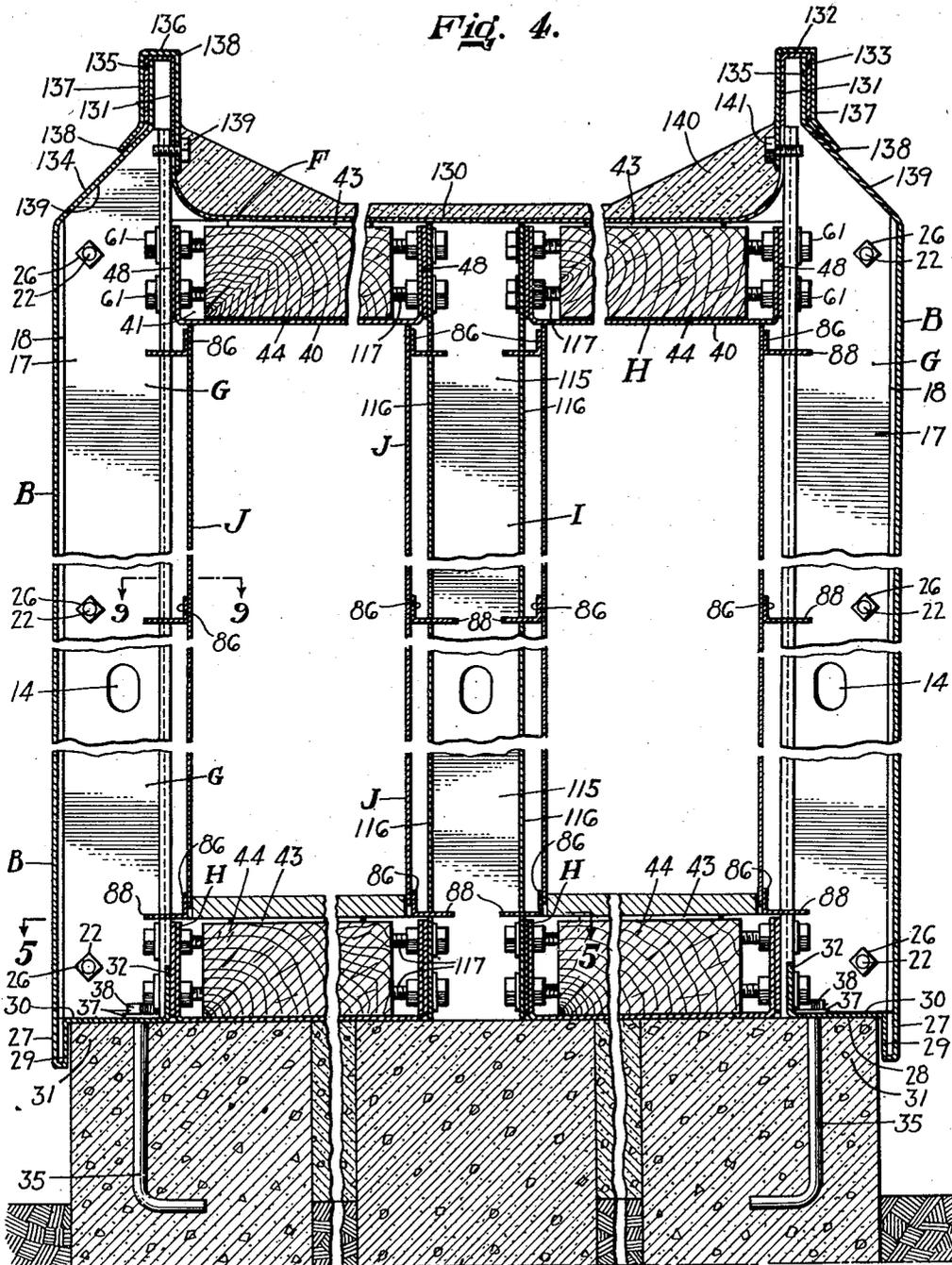
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PREFABRICATED HOUSE CONSTRUCTION

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Fig. 4.



A

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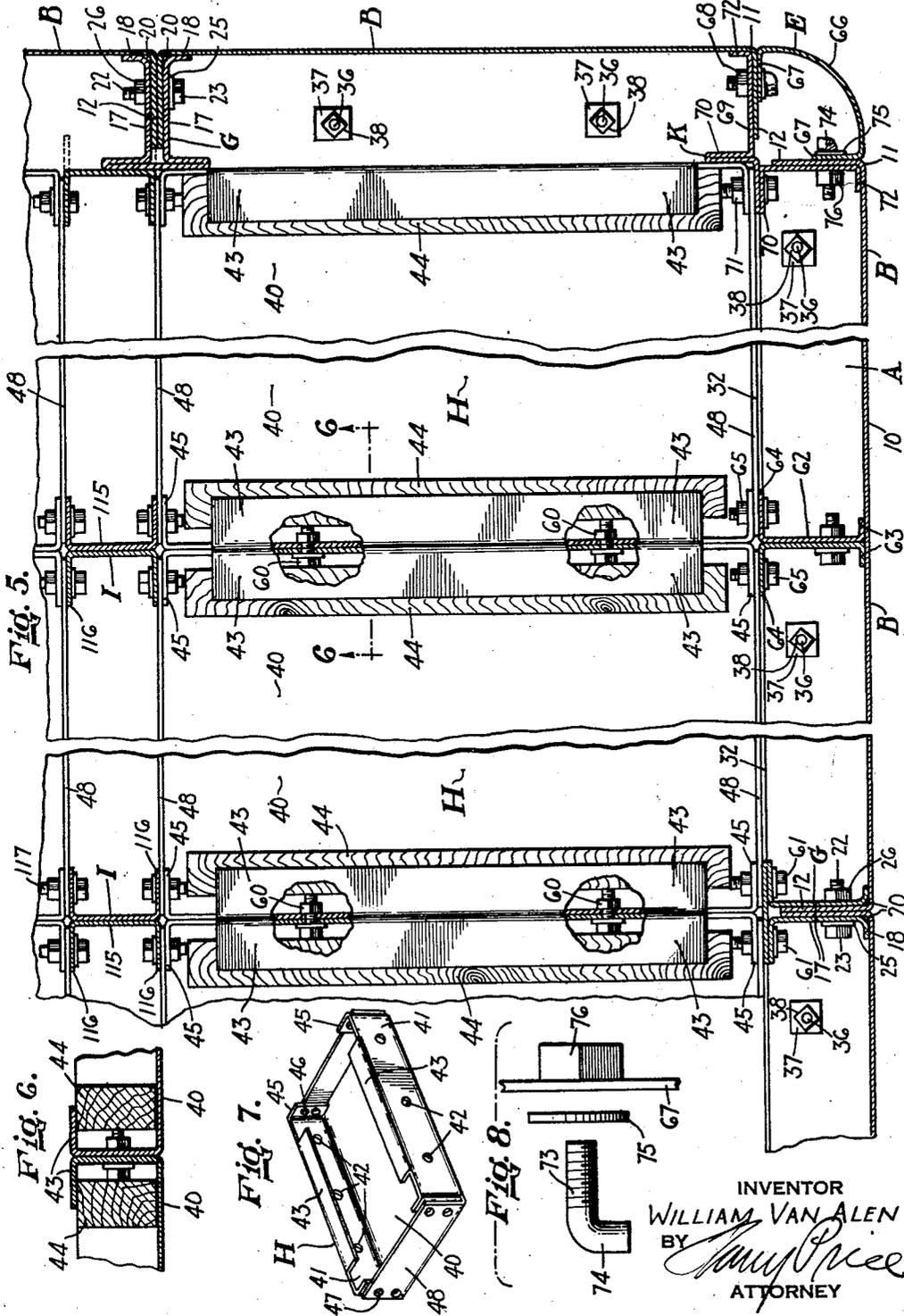
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PREFABRICATED HOUSE CONSTRUCTION

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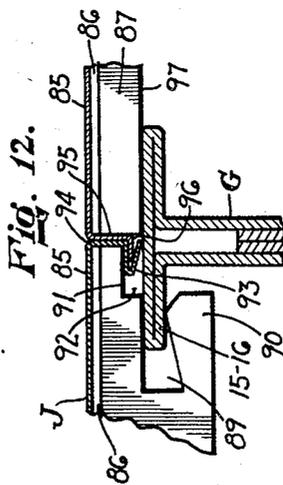
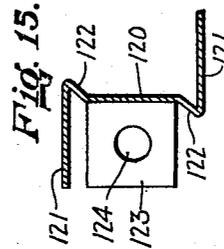
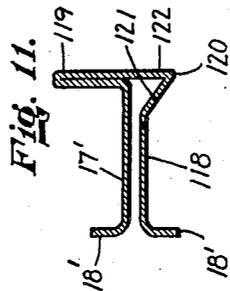
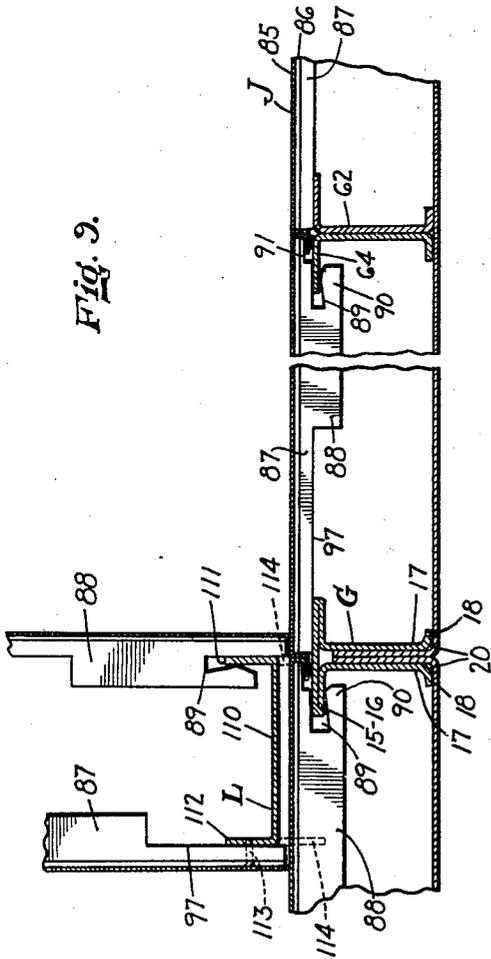
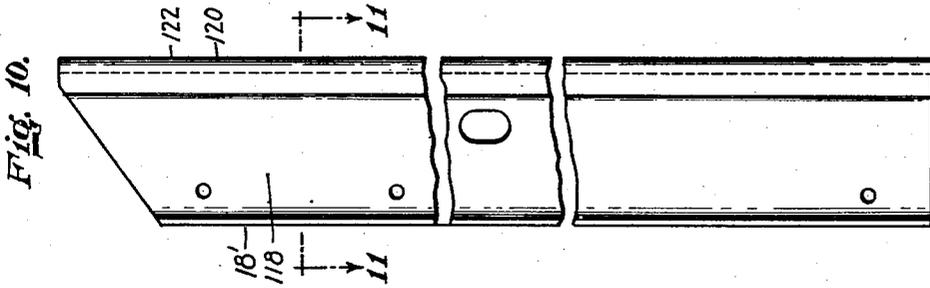
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PREFABRICATED HOUSE CONSTRUCTION

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PREFABRICATED HOUSE CONSTRUCTION

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Application May 10, 1938, Serial No. 206,982

22 Claims. (Cl. 189—1)

The present invention relates to a pre-fabricated house construction and it particularly relates to a pre-fabricated house construction, the skeleton of which may be primarily made of pre-formed sheet metal elements.

It is among the objects of the present invention to provide a pre-fabricated house construction which is readily adaptable for the construction of dwellings, garages and other buildings, the component units of which may be readily fabricated at a central point and shipped to a place of erection and there readily assembled at low labor cost to form a house, garage or other building of any desirable plan or appearance.

Another object is to provide a pre-fabricated house construction, component parts of which may be standardized and readily manufactured at low cost, and, which, at the same time, will permit of the erection of buildings, garages and homes of widely varying designs and characteristics in accordance with the desires of the purchaser, builder and/or architect.

Another object is to provide a pre-fabricated house construction of fabricated metal, which will be strong and durable, and, which, at the same time, will have high heat insulating qualities, have an appearance as attractive as homes of stone or brick and, which most readily lends itself to modern electrical wiring arrangements and plumbing systems and to the installation of all other modern conveniences.

A further object of the present invention is to provide a pre-fabricated house construction, which, although made of relatively thin sheet metal units, will have the solidity and appearance of a masonry or stone dwelling or building without any of the undesirable effects and characteristics usually associated with metallic structures.

Other objects will be obvious or will appear during the course of the following specification.

In accomplishing the above objects it has been found most suitable to form the exterior walls, the floors and the roof of a plurality of pans, which may be of standard sizes or sections and which are suitably provided with attachment flanges. Said pans may be readily rolled and formed at a steel mill to desired thicknesses and sizes. The exterior wall pans are generally provided with inturned side flanges, while the floor pans are generally provided with upturned side flanges from each edge thereof, which side flanges in part or whole in turn are provided with inturned flanges.

The adjacent flanges of the wall pans are

preferably held together by clips or studs of T or modified Z cross section, which in combination with bolts may hold the exterior wall structure rigidly together. At the same time the interior wall panels are mounted upon the inside faces of said stud clamps.

The exterior walls may be covered or coated by successive or alternate sprays of cellulose esters and/or varnishes containing resins, varnishes and of marble dust, while the spaces between the exterior walls and the interior walls may be filled with expanded vermiculite.

The flashing is preferably provided with means to include and extend over the top of the wall pans, and over the top of the roof pans which are positioned at the top of the structure, which roof pans are of the same construction as the floor pans.

In the drawings, which show several of the various possible embodiments according to the present invention by way of illustration and not by way of limitation, since many changes and variations may be made all within the scope of the present invention:

Figs. 1, 2 and 3 are diagrammatic elevational views of the side, front and back of a house structure constructed according to the present invention, which structure may be considerably varied in design and appearance by variation in location and positioning of the wall pans and other structural parts, these views merely serving as a base from which the various sections may be taken.

Fig. 4 is a cross sectional view upon the line 4—4 of Fig. 1 upon a somewhat enlarged scale as compared to Fig. 1, showing a construction which may be applied to a one-story house, or just as readily to a two or three-story house or building, the structure being partly broken away to permit a more compact showing.

Fig. 5 is a transverse sectional view upon the line 5—5 of Fig. 4 with the floor removed showing the top of the floor pan construction and the exterior wall pans and also the interior walls.

Fig. 6 is a fragmentary transverse sectional view upon the line 6—6 of Fig. 5.

Fig. 7 is a top perspective view upon a reduced scale as compared to Figs. 4 to 6 of a floor pan unit.

Fig. 8 is a separated side view upon an enlarged scale as compared to Figs. 4 to 5, showing a hook bolt construction which may be utilized.

Fig. 9 is a fragmentary transverse sectional view upon the line 9—9 of Fig. 4 showing the

wall pan and interior panel constructions and assemblies,

Figs. 10 and 11 show an alternative stud clamp construction, Fig. 10 being a side elevation partly broken away for compactness, and Fig. 11 being a transverse sectional view upon the line 11--11 of Fig. 10,

Fig. 12 is a transverse sectional view upon an enlarged scale as compared to Fig. 9 showing in greater detail the connection between the stud clamps and the interior wall panel,

Figs. 13 and 14 are fragmentary perspective views in partial section upon an enlarged scale as compared to Figs. 9 and 12 showing the method of connection of the exterior wall pans and the assembly thereof upon a concrete base, Fig. 13 being a separated view and Fig. 14 being an assembled view showing the attachment to the base.

Fig. 15 is an alternative interior Z-channel construction for separating and supporting the interior walls.

Referring to Figs. 1 and 4 the usual construction is provided with a concrete foundation A, a plurality of two or four foot wall pans B, a plurality of window receiving wall pans C, a door receiving pan D, corner elements E and a roof pan F.

Referring to Fig. 4 the exterior wall pans B are held together by means of the stud clamps G, which are mounted upon and connected to the floor pans H. The stud clamps G, together with the channel bearing partitions I, carry the interior walls J.

Referring particularly to Figs. 13 and 14, the wall pans B may be made in standard sizes or of a variety of sizes, as for example in widths of 2 or 4 feet so they may be readily varied in assembly to form the complete exterior wall construction.

They consist of a main base section 10 which is exposed and which is desirably covered with successive layers of cellulose ester and/or synthetic resin varnishes, applied together with marble dust, the particles of marble dust desirably varying from an average particle size of $\frac{1}{64}$ " to $\frac{1}{8}$ ". The varnish may consist of various combinations of Glyptal resins, which are combinations of glycerol with phthalic anhydride and other mono- or poly-basic carboxylic acids, such as oleic, linoleic and di-basic acids, such as maleic and so forth.

The cellulose ester preferably used is a cellulose nitrate or nitrocellulose of low viscosity characteristics so that it may be readily sprayed through a gun.

These panels B are bent with a relatively sharp corner at 11 to form the flanges 12, which flanges are provided with coinciding bolt holes 13 and with wire conduit openings 14 (see also Fig. 4).

The stud clamps G have bases 15, inturned sections 16, parallel outwardly direct sections 17, which are slightly inclined away from each other for the purpose of resiliency, and out-turned outside flanges 18.

The bend at 19 is preferably on a larger radius than the bend 11. For example the bend 11 may be on an $\frac{1}{8}$ " radius, whereas the bend 19 may be on $\frac{1}{4}$ " radius. As a result the corners 11 and 19 will not meet and there will be a slight open space 20, as best indicated in Figs. 5 and 9.

By providing the bend 19 with a larger radius than the bend 11, provision is made for the expansion and contraction of the wall pans B

with varying temperature conditions and this expansion and contraction will be taken up by variation in the sharpness of the bend at 11 and without tendency to open up the joint formed by the stud clamp or vertical column G. This type of construction greatly relieves the strain encountered due to varying atmospheric conditions.

The bolt holes 21 in said flanges 17 are designed to cooperate with the bolt holes 13 to receive the bolts 22 having the polygonal heads 23 and the threaded shanks 24.

Washers 25 may be provided to receive the threaded shanks 24 and the ends of the shanks after insertion in the holes 13 and 21 may be screwed into the nuts 26.

When the two flanges 17 are drawn up by the bolts 22 upon the flanges 12, a very firm rigid connection will be obtained, as indicated best in Fig. 14.

Referring to Fig. 14, it will be noted that the wall pans B at the base of the house or building construction have sections 27 extending below the upper level 28 of the concrete base A which are then turned upwardly as indicated at 29 and are provided with inturned flanges 30 which fit over the corners 31 of said concrete base A. At its inside edge, the flange 30 is provided with an upturned flange portion 32.

It will be noted that the stud clamp G rests on top of the flange 30, as indicated at 33 and 34 and the flange 32 is cut away at 33' to receive the back of the stud clamp G.

The cement foundation A, when cast, receives a series of angular bent retaining anchors or bolts 35 which are threaded at their upper ends, as indicated at 36, and receive the washers 37 and the nuts 38 to hold said wall panels B rigidly in position.

The openings 39 in the rear portions of the stud clamps G are for the purpose of receiving the interior wall structure, whether it be wood or metal panels or any desirable type of lath while the openings 39' enable connection to the floor pans H.

Resting upon the concrete base A, attached to the lower portions of the stud clamps shown and positioned against the flanges 32 are the floor pans of the type shown in Fig. 7.

These floor pans are each provided with a base 40, with an upturned side flange 41 having the bolt holes 42 and with the inturned flanges 43. Beneath the flanges 43 are positioned wooden joist members 44 (see Fig. 6) which may serve as a means for attachment of the floor structure whether it be of metal or wood. If desired the floor pans may also be filled with concrete or mastic.

The ends of the walls 41 are provided with inturned flanges 45 which are provided with the bolt holes 46 and are aligned with the bolt holes 47 in the ends of the flanges 48. The flanges 48 are turned up from the ends of the base of the pan 40 to lie over the inturned flange portions 45. If desired, however, the flanges 45 may be over the outside of the flange 48. These floor pans, as shown in Fig. 7 are bolted together by the bolts 60 and the ends of the pans may be connected by the bolts 61 to the stud clamps G.

The floor pans are usually in two foot sections, as shown best in Fig. 5, and where the walls are four foot sections, it is usually desirable to provide reinforcing channel members at two foot intervals, as indicated at 62, having the outside flanges 63 abutting the interior face of the base 10 of the wall pans A.

The central sections or web sections of the channels 62 may be spot welded or bolted together and the interior flanges 64, as indicated in Fig. 5, are bolted at 65 to the corner portions of the floor pans, as shown in Fig. 7.

The corner sections E, as best shown in Fig. 5, have a quarter circular outside wall 66 and the inturned anchor flanges 67 which are attached by the bolts 68 to the flanges 69 of the inside corner members K.

These inside corner members K are provided with the right angular return bend portions 70, one or both of which may be connected by bolts 71 to the corners of the floor pans, as shown in Fig. 7 and their corner flanges 72 may fit into the corners 11 of the wall pans G in the same manner as the flanges 18 of the stud clamp G, as illustrated in Figs. 13 and 14.

Because of the difficulty of access into the opening formed by the outside corner members E when the flanges 12, 67 and 69 are to be clamped together, special bolt constructions 68 are provided as best illustrated in Fig. 8.

These bolt constructions consist of a threaded member 73 having a right angular end portion 74, which is inserted through the washer 75 through openings in the flanges 67 and 12 and into the tapped nut 76. If desired, instead of using hook bolts 74, nuts may be welded at their corners onto the flanges 67. This will overcome any difficulties due to lack of accessibility.

The interior wall panels J may be assembled with the stud clamps in the manner indicated in Figs. 9 and 12.

These panels J may be provided with relatively thin metal webs or bases 85, to the inside faces of which may be welded the upright flanges 86 of the angle bars 87. These flanges 87 may be provided with extension portions 88 which have inwardly divergent slots 89 to receive the flanges 64 of the reinforcing members 62 or the double flanges 15 and 16 of the stud clamps G (see particularly Figs. 9 and 12).

The tongue 90 formed by the slot at the end of the enlarged portion 88 is of sufficient resiliency to be able to grip tightly either the flange 15-16 of the stud clamp G or the single thickness flange 64 of the reinforcing channel 62.

The ends of the enlarged portion 88 of the flange are cut away, as indicated at 91, to form a recess 92, in which is inserted the return bend portion 93 extending from the inwardly bent flange 94 of the interior wall panel 85. The adjacent wall panel 85 is also provided with an inwardly turned flange 95 which has an outwardly turned flange 96 grasped by the return bend element 93 to form a rigid connection.

It will be noted that the interior edge 97 of the flange 86 abuts (see Fig. 12) the rear face of the stud clamp G.

At the ends of the interior partitions extending between the rooms and adjacent the exterior walls are positioned the special bearing partition channels L. These special bearing partition channels L are provided with the webs 110 and with the side flanges 111, one of said side flanges fitting into the recess 89 in said flange 88. The other side flange may be bolted or otherwise attached, as indicated at 113, to the reduced width portions 97 of one of said flanges 87.

The lower portion of the web 110 is broken and the two sections are turned outwardly, as indicated at 114, to abut the floor or roof pan H, as the case may be.

The intermediate channel partitions I are of

the construction best shown in Fig. 5 and they consist of two U-shaped members, the webs 115 of which may be spot welded or bolted together, and the flanges 116 of which are bolted, as by the bolts 117, to the corners of the floor pans.

In lieu of the stud clamps, as shown in Figs. 13 and 14, it is also possible to utilize the stud clamps as shown in Fig. 10 and 11, which has the outwardly turned flanges 118, the side flanges 117 and 118, the rebent flange 119 and the oblique corner portion 120 having the oblique portion 121 and the straight leg portion 122. This stud clamp adapts itself for many purposes more satisfactorily than the stud clamps shown in Figs. 13 and 14.

In lieu of the bearing partition I, shown in Figs. 4 and 5, it is also possible to use a bearing partition of the type illustrated in Fig. 15, having the single web 120 and the side flanges 121 together with the oblique connecting portions 122.

The bottom flange 123 provided with the bolt hole 124 may extend off the base web 120. The flashing F, as best shown in Fig. 4, has a base 130 with the upturned side flanges 131. The side flanges are turned over as indicated at 132 to have the downwardly extending intermediate flange portions 133.

The upper portions of the wall pans B are turned inwardly at the top of the building or house, as indicated at 134, and have flange portions 135, which fit in back of the flanges 133. The coping band 136 is provided with the downturned outside flange portion 137 and the downturned inside flange portion 138, the latter being bolted at 139 through the flange 131 to the stud clamp G, as indicated best in Fig. 4.

The flange 137 is provided with a downturned portion 138 which extends over the inclined wall portion 134 and abuts the obliquely cut-off edge 139 on the stud clamp G.

The flashing F is provided with mastic 140, which extends upwardly, as indicated at 141, to cover the bolts 139 and make a water-tight connection.

It is apparent that the dimensions of the component elements may be widely varied but it has been found most suitable to form the exterior wall panels or pans in two foot or four foot widths.

The height of the wall pans, the stud clamps and the bearing partitions may vary between about 8' to 9' and, if desired, in certain instances the stud clamps for multi-story houses may be made of the height of two stories, as for example, sixteen or eighteen feet. The windows and doors may be set in or attached to flanges pressed out of the webs of the wall pans.

In erecting the house the concrete foundation is first made and the anchor bolts are set in said foundation. The wall pans are then attached to these anchor bolts in the manner shown in Fig. 4 and the floor pans are set in position at about the same time.

The interior partitions, the interior bearing partitions, the stud clamps, floor pans and wall panels are inserted in sections and the roof pans may also be inserted and placed in position at the same time.

When the wall panels and the floor and roof pans are completely set, the electrical wiring and plumbing is placed in position before setting the interior partition walls, which may consist of steel or ply-wood panels.

After the exterior walls and bearing partitions are lined, they are filled with vermiculite or other insulating material by pouring this material into the wall by an opening at the roof level.

After the complete assembly of the exterior wall pans, the floor pans, the roof pans and the bearing partitions and interior walls, the floors are laid in position and finally the various accessory hardware and doors are assembled.

By the expression "T stud" or "T clamp" as used in the accompanying claims is included the vertical columns or structural members indicated by G in Figs. 1 to 10 and 12 to 14, as well as the structure shown in Fig. 11. These structures, as shown in Figs. 1 to 10 and 12 to 14 and also in Fig. 11, have an approximate T cross section.

The invention, however, is not intended to be restricted to any particular arrangement of pre-fabricated house construction, or to any particular application of any such construction, or to any specific method of operation, or manner of use, or to any of various details thereof, herein shown and described, as the same may be modified in various particulars or be applied in many varied relations without departing from the spirit and scope of the claimed invention, the practical embodiments herein illustrated and described merely showing some of the various features entering into the application of the invention.

What is claimed is:

1. A pre-fabricated building construction comprising a plurality of floor and roof pans and a plurality of exterior wall pans, said pans being bolted together to form the house construction, all of which are provided with inturned abutting flanges and means to hold said flanges together, the inturned abutting flanges of the wall pans extending transversely inwardly from the bases of said wall pans substantially the full depth of said walls and closely abutting over their entire length and width, and the means to hold said last-mentioned abutting flanges together consisting of elongated stud clamps taking the form of a T and serving as vertical beams, said T's having stem portions also formed of closely spaced parallel flanges, which closely abut and fit against throughout their entire length, the exterior faces of said last-mentioned inturned abutting flanges and which are provided at their head portions with means for carrying an interior wall structure and at their foot portions with outturned end flanges contacting the inside faces of the exterior wall pans, and said outturned end flanges being turned outwardly upon a greater radius than the inturned abutting flanges of the wall pans are turned inwardly, whereby said wall pans may be drawn together with said stud clamps to form a tightly braced structure.

2. A pre-fabricated building construction comprising a plurality of wall pans, a plurality of floor and roof pans, said pans being bolted together to form the house construction, a plurality of stud clamps holding said wall pans together and attached to said floor pans and a flashing structure bolted to the top portions of said stud clamps.

3. A pre-fabricated building construction comprising a plurality of wall pans, a plurality of floor and roof pans, said pans being bolted together to form the house construction, a plurality of stud clamps holding said wall pans together and attached to said floor pans and a flashing structure bolted to the top portions of

said stud clamps, said flashing structure consisting of a relatively fiat base with upturned side flanges, forming a receptor for mastic and flanges extending downwardly from the edges of said side flanges to engage and cover the top of the wall pans and stud clamps.

4. In a pre-fabricated building construction, a plurality of exterior wall pans, a plurality of interior wall panels, a plurality of integrally constructed stud clamps having plate members embracing said inturned abutting flanges and having transverse plates at their interior ends, said stud clamps holding said exterior wall panels together and angle bar members attached to the rear of said wall panels to engage the transverse plates at the inside ends of said stud clamps.

5. A pre-fabricated building construction comprising a plurality of exterior wall pans, a plurality of interior wall panels and means for connecting said exterior wall pans and said interior wall panels together, comprising stud clamps, integral in construction, attached to the exterior wall pans and clip members attached to the interior wall panels and to the stud clamps, said stud clamps consisting of elongated clamp members of T-shaped cross section, the stems of said stud clamps consisting of two members which embrace and press together said inturned abutting flanges and the transverse end portions of which stud clamp members engage said clip members.

6. In a pre-fabricated building construction, comprising a concrete base, return bend flanges at the bottom of the wall structures, exterior wall pans forming the wall structures and anchor bolts carrying the return bent portions of said exterior wall pans the exterior faces of said wall pans extending substantially below the top of said concrete base and said return bent flanges being of Z cross section with right angular bends so as to closely fit and abut the edges of said concrete base.

7. A pre-fabricated building construction comprising a plurality of floor and roof pans and a plurality of exterior and interior wall pans, all of which are provided with inturned abutting flanges and means to hold said flanges together including a plurality of stud clamps, said stud clamps gripping said abutting flanges and having outturned portions which extend across and have a lesser curvature than the bends forming said inturned flanges.

8. A pre-fabricated building construction comprising a plurality of interior and exterior wall pans, a plurality of floor and roof pans, a plurality of stud clamps holding said wall pans together and attached to said floor and roof pans and a flashing structure bolted to the top portions of said stud clamps, the edges of said flashing structure and of said stud clamps being inwardly bevelled.

9. A pre-fabricated building construction comprising a plurality of interior and exterior wall pans, a plurality of floor pans, a plurality of stud clamps holding said wall pans together and attached to said floor pans and a flashing structure bolted to the top portions of said stud clamps, said flashing structure consisting of a relatively fiat base with upturned side flanges, forming a receptor for mastic, and flanges extending downwardly from the edges of said roof pan to engage and cover the top of the wall pans and stud clamps, and coping bands enclosing the upper edges of the flashing and wall pans.

10. In a pre-fabricated building construction,

a plurality of exterior flanged wall pans, a plurality of interior wall panels, a plurality of stud clamps holding said exterior wall panels together, angle bar members attached to the rear of said wall panels having recessed portions to engage the inside ends of said stud clamps and interlocking clip means on the adjacent edges of said interior panels.

11. A pre-fabricated building construction comprising a plurality of exterior wall pans, a plurality of interior wall panels and means for connecting said exterior wall pans and said interior wall panels together, comprising stud clamps attached to the exterior wall pans and slotted angle elements and clip members attached to the interior wall panels and to the stud clamps, said clip members consisting of sheet metal members forming a tongue and socket connection abutting the inside faces of said stud clamps and engaging said slotted angle elements.

12. In a pre-fabricated building construction comprising a concrete base, recessed return Z-bend flanges at the bottom of the wall structures, exterior wall pans forming the wall structures and anchor bolts carrying the return bent portions of said exterior wall pans, and stud clamps holding said pans together and fitting in said recesses.

13. In a prefabricated building construction comprising a concrete base, recessed return Z-bend flanges at the bottom of the wall structures, exterior wall pans forming the wall structures and anchor bolts carrying the return bent portions of said exterior wall pans, and stud clamps holding said pans together and fitting in said recesses, said exterior wall pans having inturned abutting flanges and said stud clamps gripping said inturned abutting flanges and thereby holding said pans together.

14. In a prefabricated building construction, a floor pan comprising a rectangular base, upturned flanges from each edge of said base, said upturned flanges on opposite sides of said pan being provided with bent side extensions to overlap the edges of the remaining two upturned flanges, said two opposite upturned flanges being provided with inturned flanges at their upper edges, and wooden beam members fitting under said inturned flanges to enable attachment of a floor structure.

15. In a prefabricated building construction, a roof pan comprising a flat base member, upturned side flanges, the upper edges of which upturned side flanges are turned outwardly and then downwardly to fit over the top of the wall structure.

16. In a prefabricated building construction, an integrally constructed roof pan comprising a flat base member, upturned side flanges, the upper edges of which upturned side flanges are turned outwardly and then downwardly to fit over the top of the wall structure and the wall structure including a plurality of bolted together wall pans having inwardly and upwardly extending obliquely disposed upper portions.

17. In a prefabricated building construction, a roof construction including inwardly obliquely and then vertically upwardly directed exterior vertical wall pan portions, an integral roof pan

comprising a flat base member, upturned side flanges, the upper edges of which upturned side flanges are turned outwardly and then downwardly to fit over the top of the wall pan portions.

18. In a prefabricated building construction, a roof construction including inwardly obliquely and then vertically upwardly directed exterior vertical wall pan portions, an integral roof pan comprising a flat base member, upturned side flanges, the upper edges of which upturned side flanges are turned outwardly and then downwardly to fit over the top of the wall pan portions, a cap extending over and enclosing said wall pan portions and said upturned side flanges of the roof pan.

19. In a prefabricated building construction, a plurality of vertical side wall pans having inturned abutting side flanges and vertical beams consisting of stud clamps, integral in construction, having a transverse head and side abutting members embracing said abutting side flanges, said side abutting members having outturned edges touching the interior faces of said side wall pans, said inturned abutting flanges being positioned closely against one another and extending substantially the full depth of the walls and said side abutting members also positioned closely parallel to one another and pressing against the exterior faces of said abutting side flanges, the transverse heads of said vertical beams having means to carry the interior wall construction, the outturned edges of said side abutting members being curved on a greater radius than the inturned portion of the abutting side flanges, whereby said wall pans and said stud clamps may be drawn tightly together to form a braced structure.

20. In a prefabricated building construction, a plurality of vertical side wall pans having inturned abutting side flanges and vertical beams consisting of stud clamps, integral in construction, having a transverse head and side abutting members embracing said abutting side flanges, said side abutting members having outturned edges touching the interior faces of said side wall pans, and interior wall panels having rear hook members engaging said transverse head.

21. In a prefabricated building construction of sheet steel sections, a plurality of steel sections forming the upper outside face of the exterior wall, the upper portions thereof being inclined inwardly and obliquely at the top of the exterior wall and a cap flashing extending over the upper edges of said exterior wall and having flanges extending downwardly in front and in back of said upper edges of said exterior wall.

22. In a prefabricated building construction of sheet steel sections, a plurality of steel sections forming the upper outside face of the exterior wall, the upper portions thereof being inclined inwardly and obliquely at the top of the exterior wall and a cap flashing extending over the upper edges of said exterior wall and having flanges extending downwardly in front and in back of said upper edges of said exterior wall, the inside edge of said cap flashing being covered by water proofing plastic composition.

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