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54 **Shelf bracket.**

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Description

The invention relates to a method for manufacturing a shelf bracket from a single metallic strip.

Such a method is known from GB-A-298,381. According to this known method the strip is bent along a cross-line such that two legs are obtained forming a right angle to each other. To obtain a sufficient stiffness the legs are provided with stiffening portions projecting from the surface of said legs.

The appearance of the shelf bracket obtained by this method does not meet high demands.

The object of the present invention is to provide a simple method for manufacturing a shelf bracket which has a better appearance and besides is stronger.

According to the invention the method is characterized by the features described in claim 1.

In this way it can be obtained that the side strips extend themselves in the corner which a shelf forms with a wall onto which the shelf bracket is mounted, so that in said corner no opening is present as this is the case with the known bracket.

A further embodiment of the method according to the present invention is described in claim 2. In this way a fine appearance of the bracket will be obtained and the material being present in the corner where the two legs joined need not be deformed too much.

The invention also relates to the shelf bracket obtained by the method described above.

Further it is noted that FR-A-2,590,464, describes a method for manufacturing a shelf bracket comprising two legs forming an obtuse angle to each other. The side strips, connected to said legs, however, have to make right angles with said legs and the legs are not directly connected to each other. Besides the bracket is not manufactured of a single strip but of two strips which have to be connected to each other.

The invention will now be further described by means of an embodiment, shown in the drawing, in which:

Fig. 1 shows a side view of a shelf bracket according to the invention;

Figs. 2 and 3 show cross sections according to the lines II-II and III-III respectively of Fig. 1;

Fig. 4 shows a rear view of the shelf bracket about in the direction of the arrow IV of Fig. 1; and

Fig. 5 shows a cross section of the corner of the shelf bracket according to the line V-V of Fig. 4.

The shelf bracket shown in the drawing comprises the legs 1 and 2 which in most cases do not have the same length. As appears from the Figs. 2, 3 and 4 each leg comprises a middle strip 3 and two side strips 4. Generally speaking the middle strip will have the same width over its total length while the width of the side strips will increase from the free end of the leg.

As in particular appears from Fig. 5 the middle

strips 3 are bent in the point 5, so that the parts 6 of it engage each other while these parts 6 are connected to each other in the point 7.

The shelf bracket is obtained by bending a strip 8 in the shape of a double trapezoid along the line running concurrently with the connecting line 7. The middle strips 3 of both legs then are running about straight, so in the elongation of the part 6 as indicated in Fig. 5. After this the middle strips are bent back with the lines 5 as bending lines to obtain the side strips 4 by bending along the bending lines 9', see Figs. 2 and 3, and the bending lines 9, see Fig. 1. During this last operation the piece of trapezoid shaped material 10 will have to be upset, so that it will run somewhat undulated indicated by 11 in Fig. 4.

As in particular appears from the Figs. 1 and 5 the free edges 12 of the side strips 4 of both legs 1 and 2 will lie in two planes making right angles to each other and the planes in which the middle strips 3 are lying will enclose an obtuse angle α to each other.

Claims

1. A method for manufacturing a shelf bracket from a single metallic strip whereby said strip (8) is in the shape of a double trapezoid and is first bent along the common base line (7) until the strip portions are lying nearly on each other, after which side strips (4), which are side-long joining the centrally located middle strip (3), are bent out of their plane along the connection line (9') with said middle strip (3) while simultaneously upsetting the material present in the corner between the legs (1,2), formed from said middle strip (3) by said first bent, and pressing the parts (6) of the middle strip (3), present in the corner, against to each other.
2. A method according to claim 1 whereby said side strips (4) are bent over such an angle that they form an obtuse angle with said middle strip (3) and that as seen in side view of said bracket the free edges (12) of the side strips of both legs (1,2) are lying in two planes being at right angles to each other and that the planes in which the legs (1,2) formed by said middle strip (3) are lying form an obtuse angle (α) to each other.
3. Shelf bracket obtained by the method according to claims 1 or 2.

Patentansprüche

1. Verfahren zur Herstellung einer Konsole für Regale aus einem einzigen Metallstreifen, wobei der genannte Streifen (8) die Form eines Doppeltra-

- pezes aufweist und zuerst gemäss der gemeinsamen Grundlinie (7) umgebogen wird bis die Streifenteile nahezu aufeinander liegen, wonach Seitenstreifen (4), die mit dem zentral liegenden Mittelstreifen (3) seitlich verbunden sind, aus ihrer Ebene gemäss der Verbindungslinie (9') mit dem Mittelstreifen (3) gebogen werden, wobei gleichzeitig das in dem Winkel zwischen den durch die erste Umbiegung von dem Mittelstreifen (3) gebildeten Beinen (1,2) befindliche Material gestaucht wird und die in dem Winkel befindlichen Teile (6) des Mittelstreifens (3) gegeneinander gedrückt werden.
2. Verfahren nach Anspruch 1, wobei die Seitenstreifen (4) über einen derartigen Winkel gebogen werden, dass sie einen stumpfen Winkel mit dem Mittelstreifen (3) bilden und dass, in Seitenansicht der Konsole gesehen, die freien Ränder (12) der Seitenstreifen beider Beine (1,2) in zwei senkrecht aufeinander stehenden Ebenen liegen und dass die Ebenen, in denen die durch den Mittelstreifen (3) gebildeten Beine (1,2) liegen, einen stumpfen Winkel (α) miteinander bilden.
3. Konsole für Regale erhalten durch das Verfahren gemäss den Ansprüchen 1 oder 2.

médiane (3), forment un angle obtus (α) entre eux.

3. Support de tablette obtenue suivant le procédé selon la revendication 1 ou 2.

Revendications

1. Procédé de fabrication d'un support de tablette à partir d'une seule bande métallique, de manière que ladite bande (8) présente la forme d'un double trapèze et soit d'abord pliée le long de la ligne de base commune (7), jusqu'à ce que les parties de bande se situent de manière proche l'une au-dessus de l'autre, à la suite de quoi des bandes latérales (4), qui sont reliées latéralement à la bande médiane (3) située de manière centrale, sont cintrées hors de leur plan, le long de la ligne de liaison (9') avec ladite bande médiane (3), tout en retournant simultanément le matériau présent dans l'angle entre les pattes (1, 2), formées par ladite bande médiane (3) selon ledit premier cintrage, et en comprimant les parties (6) de la bande médiane (3) présente dans l'angle l'une contre l'autre.
2. Procédé selon la revendication 1, dans lequel les dites bandes latérales (4) sont cintrées selon un angle tel qu'elles forment un angle obtus avec ladite bande médiane (3) et que, comme on le voit sur une vue de côté dudit support, les bordures libres (12) des bandes latérales des deux pattes (1, 2) se situent dans deux plans perpendiculaires entre eux, et que les plans, dans lesquels se situent les pattes (1, 2) formées par ladite bande

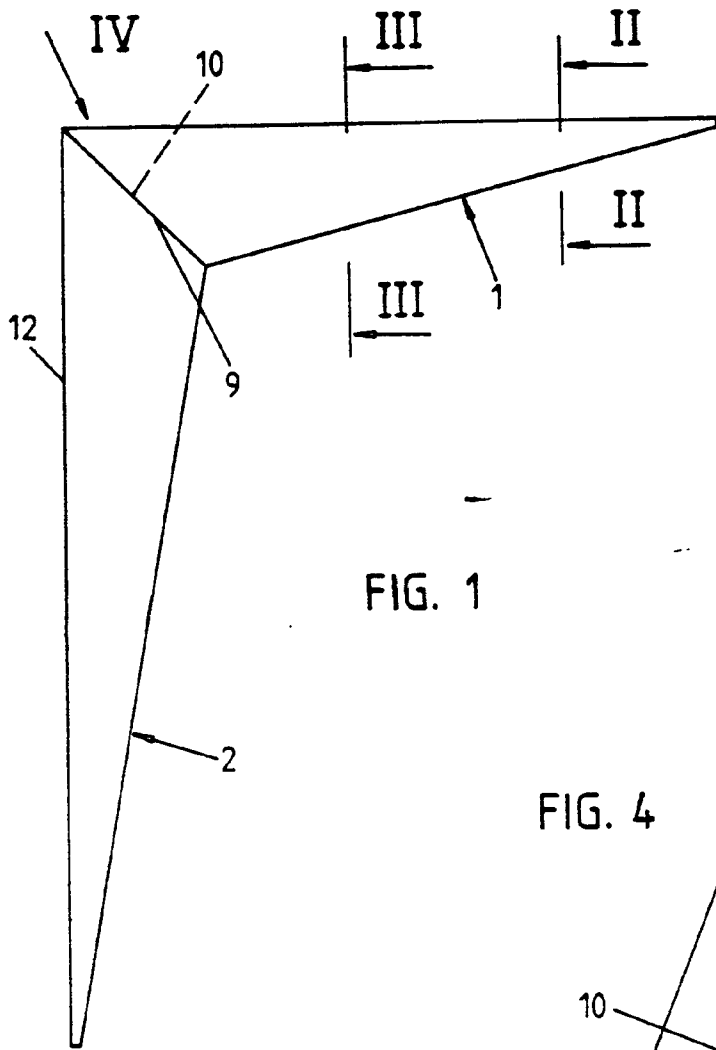


FIG. 1

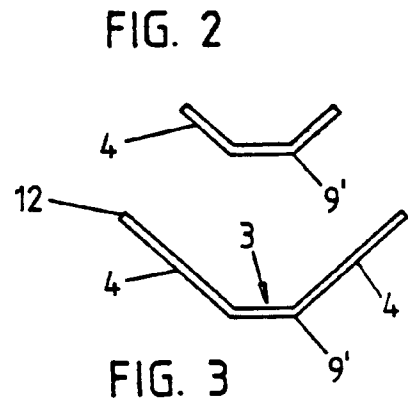


FIG. 2

FIG. 3

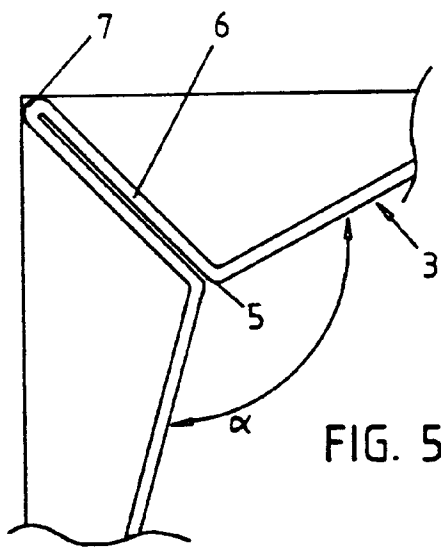


FIG. 5

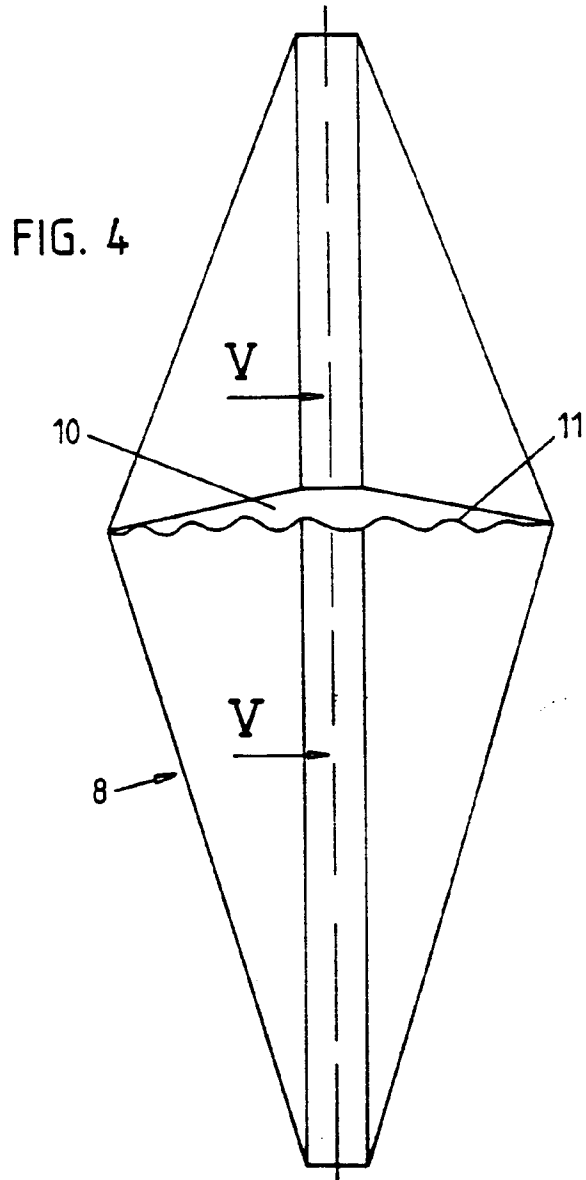


FIG. 4