Aug. 29, 1950 F. E. ZEIGLER ET AL 2,520,486

METHOD OF MAKING STAINLESS STEEL DOUBLE SINKS

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Fig. 1.

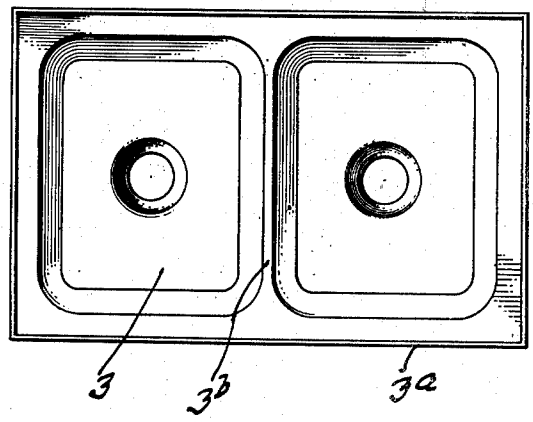


Fig. 2.

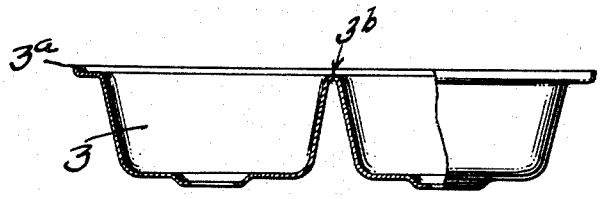
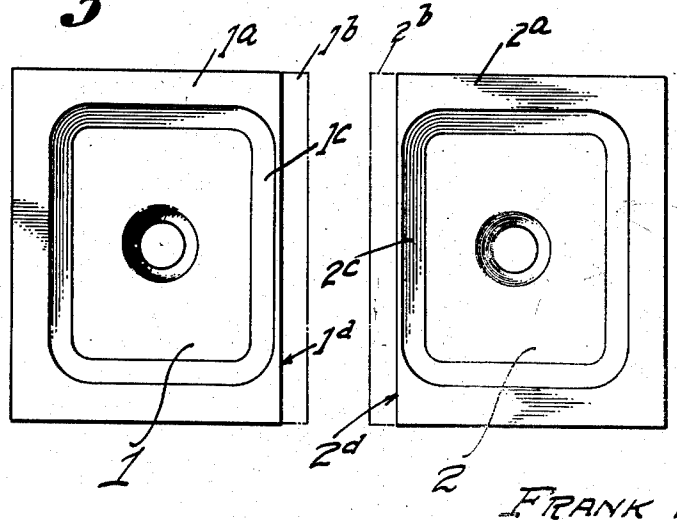


Fig. 3.



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METHOD OF MAKING STAINLESS STEEL DOUBLE SINKS

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1 Claim. (Cl. 113—120)

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This invention relates to kitchen sinks and has particular reference to improved methods of forming stainless steel sinks.

The kitchen sink of days gone by was made of wood, and the life of such sinks was quite limited, besides being unsanitary. Today this type of sink is almost entirely discarded in favor of the enameled cast iron sink, at least in the larger towns and cities.

Such cast iron sinks are, however, quite heavy, and the enamel is subject to wear, to cracking and chipping. It has, for this reason, been the aim of manufacturers to produce a sheet metal sink and, with the advent of hard and tough, rust resisting metal alloys, commercially known as stainless steel, Monel metal and the like, it would seem that the cast iron sink has had its day.

Such steel alloys are, however, so hard and tough that they are quite difficult to press or draw into the shape ordinarily found in sinks.

In view of the foregoing, it is the object of the present invention to provide a metal sink made from thin, corrosion resisting sheet metal. It is a further object to provide a sheet metal sink capable of withstanding ordinary use without denting or cracking.

The conventional, single basin sink is now being replaced by the more convenient double sink, at least in the larger cities and in more modern homes. But the manufacture of such double sinks, when such material as stainless sheet steel is used, is attended by additional difficulties and has so far only been successfully done on a relatively small scale.

It is, in view thereof, a further object of our invention to provide an improved method of producing such corrosion resisting sheet metal sinks.

These and the further objects of the invention will be better understood from the following description and by referring to the accompanying drawings, of which:

Fig. 1 is a plan view of a device embodying the invention;

Fig. 2 is a substantially corresponding side elevational view with a portion thereof broken away for the sake of clearness; and

Fig. 3 shows two identical single basin sinks, and this view is added in order to facilitate perusal of the following detailed description explaining my improved method of producing the type of sheet metal sink illustrated in Fig. 1.

Referring in the first instance to Fig. 3, it is noted that duplicate, single basin sinks 1 and 2 are formed in the same die with wide flanges 1^a, 2^a, whereupon the adjacent flanges of the sinks

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are trimmed back, as indicated at 1^b, 2^b, at the point where the flanges commence to curve into the inclined side walls 1^c, 2^c, of the basins.

The two sinks are thereupon pushed together and the abutting edges 1^d, 2^d, are welded together to form a one-piece, double basin sink. The device 3 in this manner produced is then put under the press and the outer edges of the top flange are drawn upwardly to form a rim 3^a which completely encompasses the sink.

This rising rim is advantageous for various reasons. It is important because it serves to anchor the sink more solidly within the tiling or other sheathing forming the drain board of modern sinks. Another advantage of the rising rim is that it checks the flow of any water which may leak under the bead of the drainboard within which the rim is anchored. In drawing the basins of the sink, the metal becomes so severely distorted that it is difficult to obtain a perfectly flat top flange. But it is found that the flatness of the flange is restored at the time the rim is formed. This is a further advantage of the rim.

In the sheet metal double sinks which have come to my notice, a rather wide, flat top band extends across the sink between the two basin recesses. Such flat band is objectionable because dripping water tends to gather thereon and running water, striking the band, causes disagreeable splashing. But when the two sinks are trimmed and combined as above described, it is noticed that the center ridge 3^b between the two basins is narrow and perfectly rounded. No water can gather on such ridge and splashing is substantially eliminated.

The weakest part of a sheet metal double sink is through the middle of this center ridge. But when the ridge is circular, as shown and the marginal rim 3^a is added it is found that the structure is considerably strengthened and that thinner metal may be used than is ordinarily required.

It is seen from the foregoing that we have provided a simple and inexpensive method of combining two single recess sinks into a one piece double sink of improved construction, lightness and strength.

We claim:

The method of constructing a double sink from stainless sheet steel which consists in drawing duplicate single sinks, each having inclined side walls tangent at the top to an outwardly curved portion whose cross section is circular and of small radius and merges smoothly into a wide horizontally directed flange forming a rectangu-

lar unbroken margin surrounding the recess of the sink, in trimming the flange at only one side of each sink on a line parallel with the outer edge of the flange and at the beginning of the curvature downward into the adjacent side wall, placing the trimmed edges of the sinks together to form a top ridge portion circular in cross section and narrower than the smallest ridge which could be obtained by drawing both sinks integrally from one blank, welding the abutting edges of said ridge together to produce the one-piece double sink and of drawing the outer edges thereof upward to form a vertically directed unbroken rim encompassing the double sink.

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