

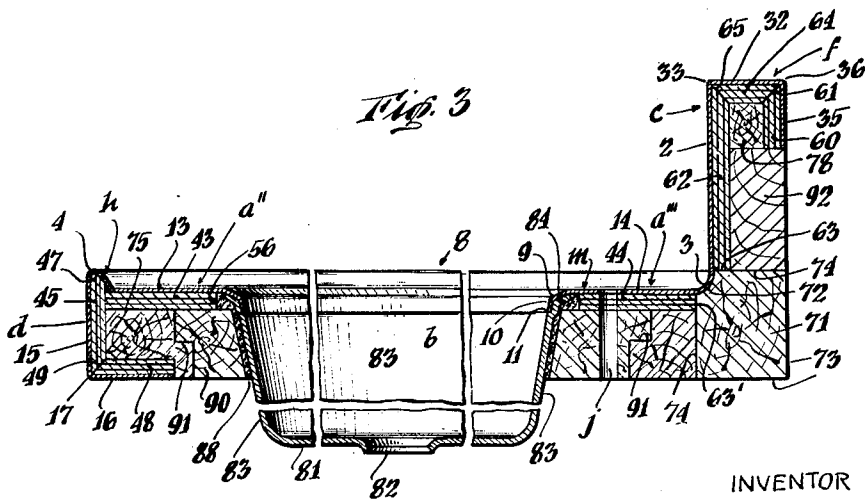
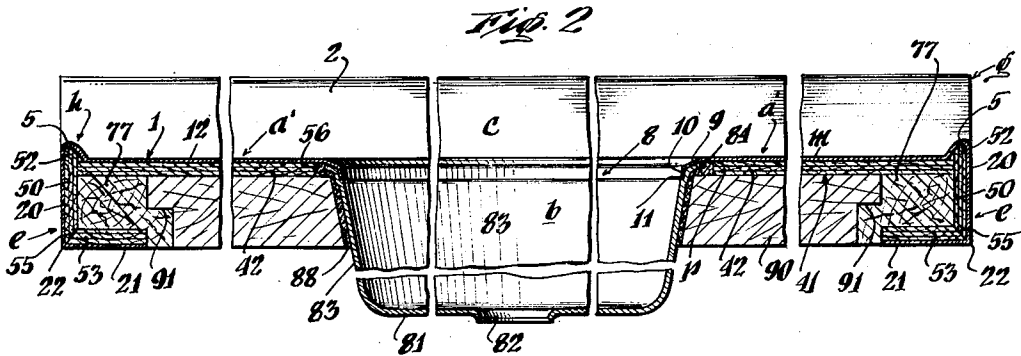
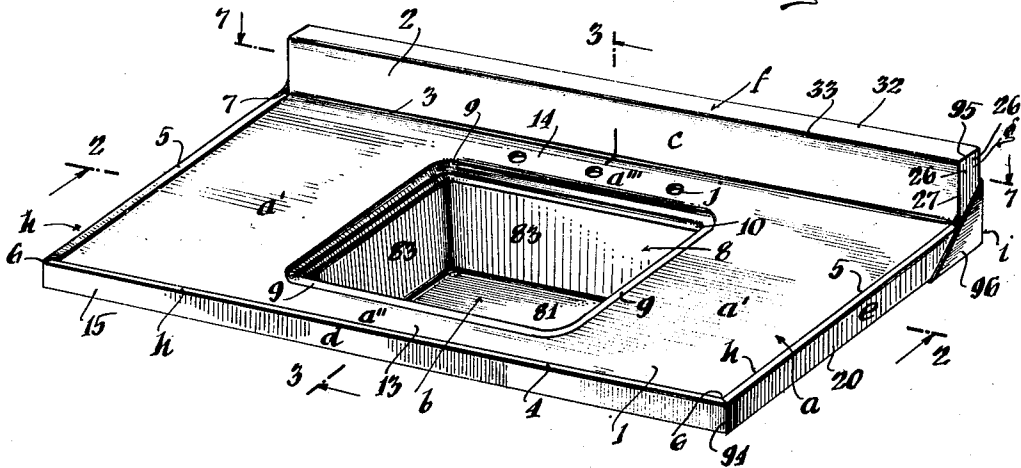
Jan. 30, 1951

G. H. NORQUIST
METAL SINK CONSTRUCTION

2,539,464

Filed Feb. 10, 1947

4 Sheets-Sheet 1



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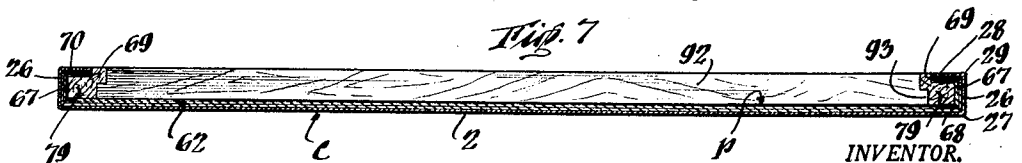
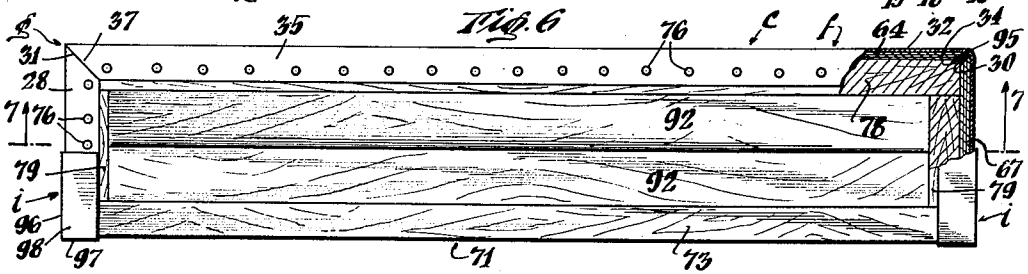
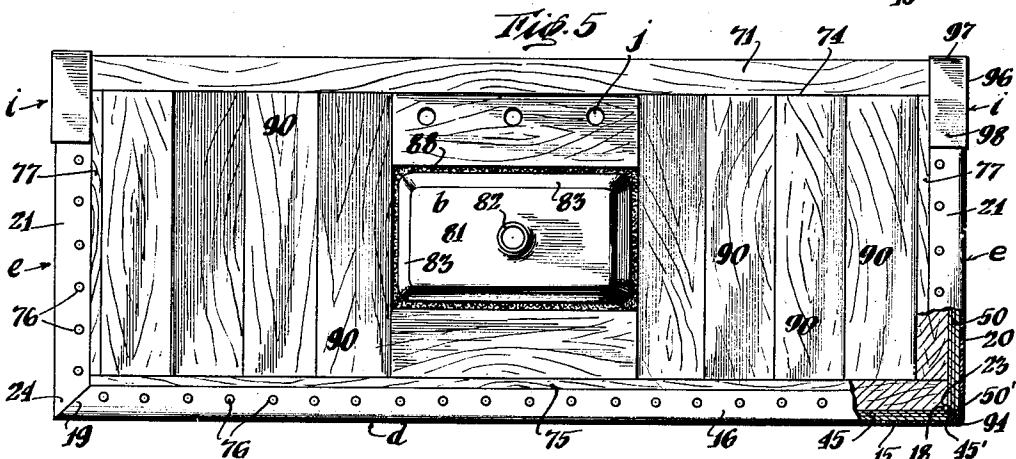
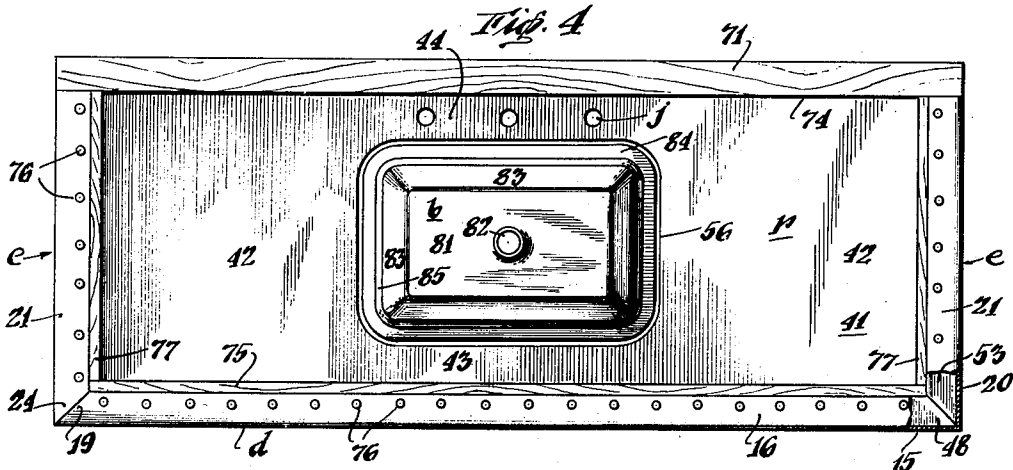
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G. H. NORQUIST
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4 Sheets-Sheet 2



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4 Sheets-Sheet 3

Fig. 8

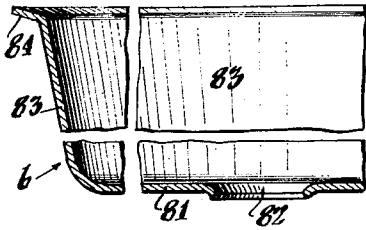


Fig. 9

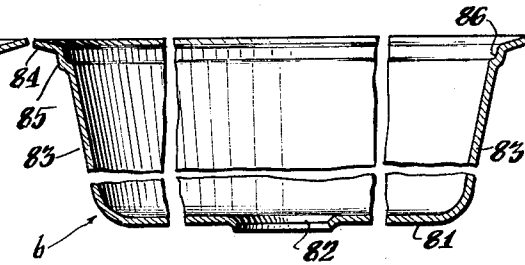


Fig. 10

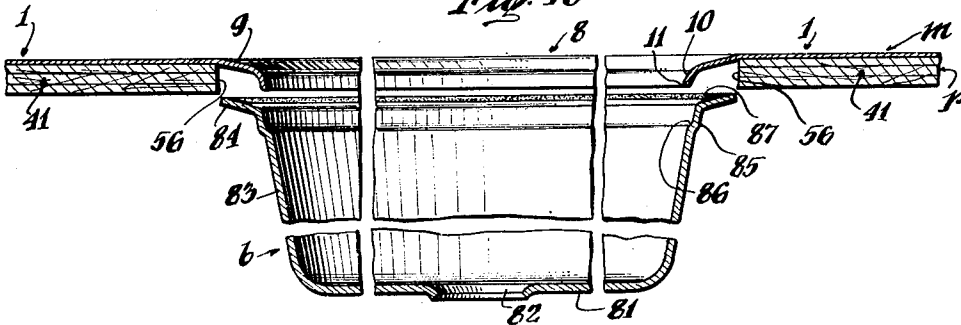


Fig. 11

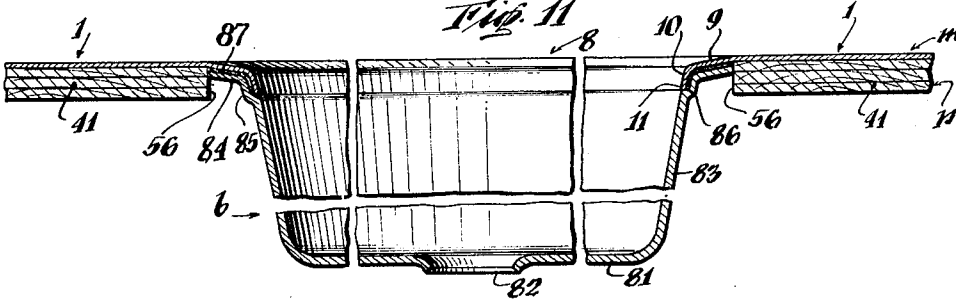
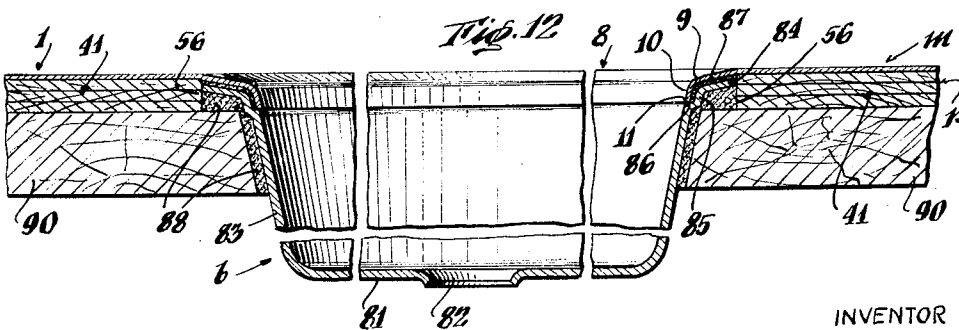


Fig. 12



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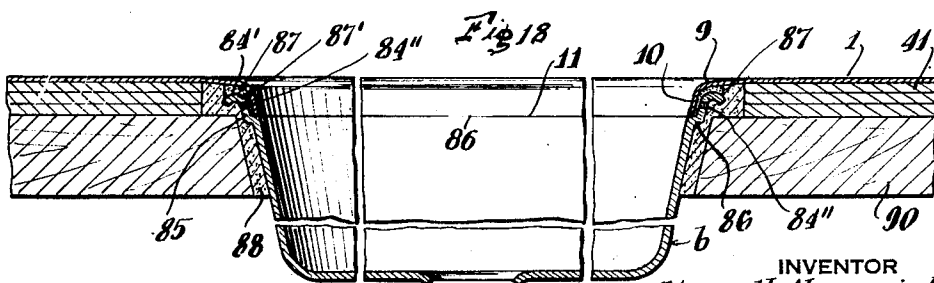
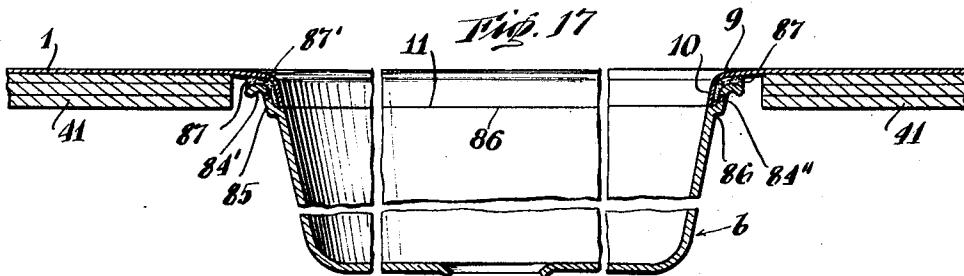
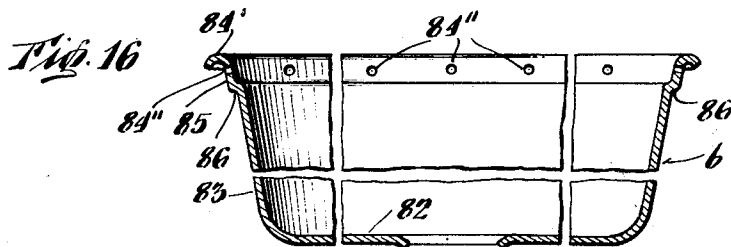
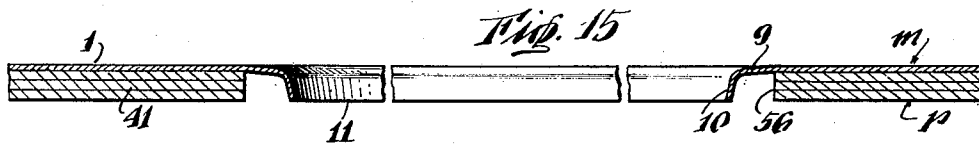
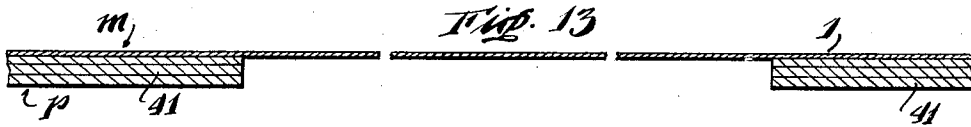
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METAL SINK CONSTRUCTION

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4 Sheets-Sheet 4



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METAL SINK CONSTRUCTION

Glenn H. Norquist, Jamestown, N. Y.

Application February 10, 1947, Serial No. 727,584

7 Claims. (Cl. 4—187)

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This invention relates to an improved metal sink construction, and more particularly to a metal table or drain board construction presenting metal facing surfaces formed of bright sheet metal having one or more sink wells associated therewith.

In accordance with this invention a metal clad sink top or table is provided presenting facing surfaces formed from a sheet of bright or polishable metal such as stainless steel, Monel-metal, brass, copper, zinc, tin or the like. The metal surfacing sheet is stiffened and reinforced by sections of fibrous material which may comprise laminated plywood, hard pressed fibre or composition board as commonly used in the building industry. These fibrous backing sections are adhesively bonded to the rear face of the metal facing sheet and thus prevent wrinkling, warping or other undesired distortions of the metal sheet, and in addition insures stiffness, strength and rigidity to the table or cabinet top construction, provides a sound deadening effect so that the metal facing surfaces will not reverberate or produce a metallic ring when drummed upon, and in addition permits the use of a relatively light gauge metal facing sheet which can be worked and shaped with relative ease.

The polished metal facing sheet with the backing sections attached thereto are shaped to provide depending apron sections extending around the front and sides of the horizontal table section. The rear edge of the top construction may also be provided with a rear apron section, or may be shaped to provide an upwardly extending splash panel section.

The horizontal table area of the metal sheet is provided with one or more sink well openings into which a sink well is inserted. The sink well may be stamped or pressed from a sheet of bright metal of the desired gauge. The upper edge of the sink well is provided with an inset rim formation from which an outwardly flared flange or rim formation extends. The sink well opening in the metal facing sheet terminates in a downturned lip portion which snugly seats within the inset rim formation of the sink well structure, and these parts are soldered or welded together to provide a strong, smooth and leakproof joint.

The depending apron sections of the metal facing sheet may be provided with inturned flange sections which may be backed up by fibrous backing sections. Wood edging strips are preferably fitted within the inturned flange sections and secured in position to provide a stiffening framework for the horizontal table top section and the

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depending flange sections. The area within the wood edging strips may also be filled in with filler boards of wood or fibrous material which may be cemented in position and may have a notching interlock with the surrounding wood edging strips.

This improved sink construction is particularly designed to be applied to the top of wood or metal cabinets and like supporting structures to provide a highly useful working surface therefor. The horizontal working section of this improved table top construction is equipped with one or more sink wells to provide a highly useful and attractive sink with adequate horizontal working areas and drain board areas, and may be equipped with faucets and other plumbing facilities as desired.

An object of this invention is to provide an improved sink construction having metal facing surfaces of bright sheet metal, with the sink well rigidly attached to the table forming section of the metal sheet in a manner to provide a leak-proof joint, presenting smooth and rounded edges free from sharp corners and projections and insuring adequate drainage to the sink well.

Other objects and advantages of this invention will become apparent as the disclosure proceeds.

Although the characteristic features of the invention will be particularly pointed out in the claims appended hereto, the invention itself, and the manner in which it may be carried out, may be better understood by referring to the following description taken in connection with the accompanying drawings forming a part hereof, in which

Fig. 1 is a perspective view of the fully assembled sink, having a single sink well, constructed in accordance with this invention.

Fig. 2 is an enlarged longitudinal cross sectional view of the fully assembled sink as the same would appear when viewed along line 2—2 of Fig. 1.

Fig. 3 is an enlarged transverse cross sectional view of the fully assembled sink as the same would appear when viewed along line 3—3 of Fig. 1.

Fig. 4 is an underside view of the table section of the sink prior to the application of the filler boards, this view illustrating the sink well as attached to the underside of the sheet metal facing which surfaces the table section.

Fig. 5 is an underside view of the fully assembled sink, a corner section thereof being partially broken away to illustrate further structural details thereof.

Fig. 6 is a rear face view of the splash section

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of the fully assembled sink, a corner section thereof being partially broken away to illustrate certain structural details thereof.

Fig. 7 is a longitudinal cross sectional view of the splash section of the fully assembled sink as the same would appear when viewed along line 7-7 of Figs. 1 and 6.

Fig. 8 is a longitudinal cross sectional view of the sink well member as formed from a single sheet of bright metal and as the same appears prior to complete shaping formation of the upper rim portion thereof.

Fig. 9 is a cross-sectional view of the sink well after the upper rim portion thereof has been fully shaped for attachment to the sheet metal facing which covers the table section of the improved sink.

Fig. 10 is a longitudinal cross-sectional view of the sink well and a fragmentary portion of the table section in position for soldering attachment.

Fig. 11 is a longitudinal cross-sectional view of the sink well and a portion of the table section as the same appear when the sink well has been soldered thereto.

Fig. 12 is a longitudinal cross-sectional view of a fragmentary portion of the table section and attached sink well as the same would appear when fully assembled.

Fig. 13 is a fragmentary cross-sectional view taken longitudinally through the table section of the metal clad panel as the same would appear prior to cutting out the sink well opening of the metal facing sheet.

Fig. 14 is a fragmentary cross-sectional view through the table section of the metal clad panel after the sink well opening has been cut therein.

Fig. 15 is a fragmentary cross-sectional view of the table section of the metal clad panel at a further stage of assembly and as the same would appear after the metal flange portion and down-turned lip formation which defines the sink well opening have been shaped into proper form.

Fig. 16 is a cross-sectional view of a sink well having an upper rim portion of somewhat modified form.

Fig. 17 is a cross-sectional view of a fragmentary portion of the table section of the metal clad panel after the modified rim portion associated with the sink well shown in Fig. 16 has been bonded to the formed flange portion and down-turned lip formation of the metal facing sheet; and

Fig. 18 is a longitudinal cross-sectional view of a fragmentary portion of the table section of the fully assembled construction having the modified sink well shown in Fig. 16 incorporated therewith.

Similar reference characters refer to similar parts throughout the several views of the drawings and specification.

The improved sink construction, as generally illustrated in Figs. 1, 2 and 3, comprises a metal clad table section *a* which has one or more sink wells *b* positioned and arranged therein as may be desired. The metal clad table section *a* presents side drain portions *a'* at each side of the sink well *b*, a front ledge portion *a''* extending at the front of the sink well *b*, and a rear ledge portion *a'''* extending along the rear edge of the sink well *b*.

The table section *a* merges smoothly into a rear splash section *c* which may rise any desired distance to protect the building wall adjacent to which the sink is mounted. The front edge of the table section *a* merges into a downwardly ex-

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tending apron section *d*, and the side edges of the table section *a* merge into downwardly extending apron sections *e*. The vertical splash section *c* merges into a horizontally extending shelf section *f* and into vertical end sections *g*. The front edge and the side edges of the table section are surrounded by a raised rim *h* approximately $\frac{3}{8}$ to $\frac{1}{4}$ of an inch in height and adequate to prevent liquids deposited upon the table section from overflowing to the floor. Shoe sections *i* may be secured to the rear corners of the sink to further stiffen and strengthen the construction and give the sink a finished appearance. The rear ledge portion *a'''* of the table section *a* may be provided with suitable openings *j* for the convenient attachment of faucets and like plumbing fixtures.

Sinks of the type generally above described may be economically fabricated and constructed to provide a highly serviceable and long-lasting construction of marked beauty and appearance, from a metal facing sheet *m* of relatively light gauge metal, preferably from a stainless steel sheet, which need not have a greater thickness than 18 gauge. The metal facing sheet is backed up, reinforced and stiffened by fibrous facing panels or sections *p* which may comprise laminated plywood, or other hard and durable fibrous sheet material, such as "Masonite" and like serviceable sheathing, used in the building industry.

The metal facing sheet *m* is cut and shaped into the general form as illustrated in Figs. 1 to 7 inclusive to provide the table section *1* and the splash section *2* joined by a curving bend *3*. The front edge of the table section *1* of the metal sheet is bent upwardly at an angle to form a rim formation *4*, and the side edges of the table section *1* are bent upwardly to form raised rim formations *5* shown more particularly in Figs. 1 to 3 inclusive. The adjacent ends of the front rim formation *4* and the side rim formations *5* merge together to provide a continuous raised corner formation *6*. The side rim formations *5* terminate as at *7* adjacent the curving bend *3*.

A sink well opening *8* is cut out of the table section *1* of the metal facing sheet, and if desired two such sink well openings in spaced relationship may be provided. The sink well opening *8*, cut in the table section *1* of the metal sheet, is defined and surrounded by a downwardly inclined flange portion *9* terminating in a down-turned lip portion *10* having a slightly rounded curvature, the lip portion *10* terminating in a square cut edge *11*. The flange portion *9* and lip portion *10* of the metal sheet provide means for the attachment of the sink well *b*, as will be more fully explained hereafter. The metal table section *1* presents side drain portions *12*, a front ledge portion *13*, and a rear ledge portion *14* extending between the down-turned flange portion *9* and the surrounding rim formations *4* and *5*.

The metal facing sheet is also provided with a front apron section *15* extending downwardly from the front rim formation *4*, and a front flange section *16* intumed along a bend line *17* which parallels the raised front rim formation *4*. An intumed lip portion *18* extends from each end of the front flange section *15* as shown in Fig. 5. Each end *19* of the front flange section *16* is preferably cut at a 45° angle.

A side apron section *20* extends downwardly from the side rim formation *5* and is provided with an intumed side flange section *21* which is intumed along a bending line *22* which parallels the adjacent raised side rim *5*. The front end of each side apron section *20* is provided with an in-

turned lip portion 23 as shown in Fig. 5. The front end 24 of each side flange section 21 is also preferably cut on a miter as shown in Fig. 5.

The splash section 2 has a side edging section 26 at each end thereof which, during fabrication of the sink, will be bent rearwardly along a bending line 27 which is substantially in alignment with the side forming rims 5 of the table section 1. Each side edging section 26 has an inturned flange section 28 bent along the vertical bending line 29 as shown in Figs. 6 and 7. The splash section 2 is provided with a top shelf section 32 which is bent rearwardly along the bending line 33 which parallels the curved bend 3. A flange section 35 also forms a part of the splash section 2 and is bent downwardly along the bending line 36 which parallels the bend line 33, as shown in Figs. 3 and 6.

The upper end of each side edging section 26 of the splash panel is provided with an inturned lip portion 30 which abuts against a similar lip portion 34 extending from the adjacent end of the top shelf section 32 as shown in Fig. 6. The upper end 31 of each end flange section 28 is cut on a bias, and the adjacent end 37 of the flange section 35 of the splash section 2 is likewise cut on a bias.

The fibrous backing sections *p* are adhesively secured to the underside of the metal facing sheet *m*. The backing sections may be approximately $\frac{1}{4}$ inch in thickness and may be formed of laminated plywood, hard pressed fibre, composition board, or like durable and strong fibre sheeting. The fibrous backing comprises a table backing section 41 adhesively secured to and covering the under face of the table forming section 1 of the metal facing sheet. As shown in Figs. 4 and 10, the table backing section 41 has a sink well opening cut therein which is slightly larger than the sink well opening 8 in the table forming metal section 1, so that the metal flange portion 9 overhangs the retracted edge portion 56 which defines the sink well opening in the backing section 41; the overhanging flange 9 of the metal sheet thus providing means for securing the sink well structure *b* to the table forming section 1 of the metal sheet. As thus constructed, the drain backing portions 42 provide stiffening support for the drain board sections 12 of the metal sheet, while the front backing portion 43 and the rear backing portion 44 provide support for the front ledge portion 13 and the rear ledge portion 14 of the table forming section 1 of the metal sheet.

A front apron backing section 45 covers and is bonded to the rear face of the front apron section 15 of the metal sheet and extends between the front rim formation 4 and the bend line 17 of the metal sheet as shown in Fig. 3. The upper edge 47 of the apron backing section 45 has a rounded contour to snugly seat against the rear face of the raised rim formation 4 of the metal sheet, and may be bonded thereto by means of a suitable adhesive. The vertical ends 45' of the front apron backing section 45 are preferably cut on a miter and are covered by the overlying inturned lip portions 18 of the metal sheet, as shown more particularly in Fig. 5. The inturned front flange section 16 of the metal sheet may be covered by a backing section 48 bonded thereto by a suitable adhesive. The adjacent front edges of the front apron backing section 45 and the flange backing section 48 are cut on a miter to provide a mitered joint 49 as shown in Fig. 3. Each end of the flange backing section 48 is cut

on a miter and terminates in line with the adjacent mitered end 19 of the inturned metal flange section 16.

A side apron backing section 50, as shown in Fig. 2, covers and is bonded to the rear face of each side apron section 20 of the metal sheet. The upper edge 52 of each side apron backing section 50 possesses a semi-rounded or biased contour to snugly seat against the underside of the raised metal rim formation 5, and thus provides a firm backing therefor. The upper rounded edge 52 may also be adhesively bonded to the underside of the raised rim formation 5. The front end 50' of each side backing section 50 is cut on a 45° miter, and is covered by the overlying lip portion 23 of the metal sheet, as shown more particularly in Fig. 5. It will be noted that the lip portion 18 of the front apron section of the metal sheet and the adjacent lip portion 23 of the side apron section of the metal sheet are in face-to-face abutment. The joint therebetween may be covered by a solder seam 54 which is burnished and polished to give the front corner edge a finished appearance. The inturned flange section 21 of the metal sheet, as shown in Figs. 2 and 4, may be covered by a plywood backing section 53 which may be adhesively bonded along a mitered joint 55 to the adjacent side apron backing section 50. The front end of the flange backing section 53 may be cut on a miter in line with the mitered end 24 of the inturned flange section 21 of the metal sheet as shown in Fig. 4.

A splash backing section 62 and a shelf backing section 64 cover and are bonded to the rear face of the splash section 2 and shelf section 32 of the metal sheet, as shown more particularly in Fig. 3. The lower edge 63 of the splash backing section 62 is spaced from the adjacent rear edge 63' of the table backing section 41, leaving uncovered the rear area of the rounded bend formation 3 of the metal sheet. The adjacent edges of the splash backing section 62 and shelf backing section 64 present a mitered joint 65 which may be bonded by adhesive. The downturned flange section 35 of the metal sheet may be covered by a backing section 60 whose upper edge forms an adhesively bonded mitered joint 61 with the adjacent edge of the splash backing section 64. End backing sections 67 cover the end sections 25 of the metal sheet as shown in Figs. 6 and 7. The vertical edge of each end backing section 67 forms a mitered joint 68 with the adjacent vertical edge of the splash backing section 62. The inturned flange section 28 of the metal sheet may also be covered by a flange backing section 69 whose vertical edge forms a mitered joint 70 with the adjacent vertical edge of the end backing section 67.

Each end of the shelf backing section 64 is cut on a miter and covered by the inturned lip portion 34 of the metal sheet, as shown in Fig. 6. The upper end of the end backing section 67 is also cut on a miter and covered by the inturned lip portion 30 of the metal sheet. The adjacent lip portions 34 and 30 of the metal sheet are in face-to-face contact and may be firmly bonded together by a seam of solder or welding metal 95 applied to the horizontal corner edge of the shelf section, as shown in Figs. 1 and 6. The adjacent ends of the side flange backing section 69 and the top flange backing section 60 may be cut on a 45° angle in line with the beveled end 31 of the metal flange section 28 and the beveled end 37 of the metal flange section 35, as shown more particularly in Fig. 6.

In the construction above described it will be noted that the table forming section 1 of the metal sheet is firmly stiffened and supported by the table backing section 41, the front apron section 15 and front rim formation 4 of the metal sheet is supported and reinforced by the front backing section 45, and the side apron sections 20 and the side rim formations 5 of the metal sheet are supported and reinforced by the side backing sections 50. The main splash section 2, the top shelf section 32 and the end sections 26 of the metal sheet are firmly and rigidly supported and reinforced by the main splash backing section 52, the shelf backing section 64 and the end backing sections 67 respectively.

The table forming section *a* of the sink is further stiffened and reinforced by a front wood edging strip 75 which is inserted under the intumed front flange 16 and extends the full length of the sink as shown more particularly in Figs. 4 and 5. The wood edging strip 75 may be adhesively secured to the adjacent backing sections 41, 45 and 48, and the front flange section 16 may be secured to the wood edging strip 75 as by screws or nails 76. A wood side edging strip 77 is inserted under each of the intumed side flange sections 21, and extends the full width of the table section of the sink, as shown more particularly in Figs. 4 and 5. Each side edging strip 77 may be adhesively secured to the adjacent backing sections 41, 50 and 53, and may be secured to the adjacent intumed flange section 21 as by screws or nails 76.

A wood edging strip 78 may be set to extend under the intumed top flange 35 of the splash section *c* as shown more particularly in Figs. 3 and 6, preferably extends the full length of the splash section and is secured to the intumed top flange section 35 as by screws or nails 76. A side edging strip 79 of wood is inserted under each of the intumed and flange sections 28 of the splash panel *c* and is secured in position as by screws or nails 76 as shown in Figs. 6 and 7. The top edging section 78 and the side edging sections 79 may be additionally secured in position by adhesive applied to the adjacent areas of the splash backing section 62, shelf backing section 64, end backing sections 67 and flange backing sections 60 and 69. Thus the table forming section *a* and the splash forming section *c* of the sink are additionally stiffened and reinforced by wood edging strips which positively prevent deformation of the sink construction.

The splash section 2 of the metal sheet is bent to extend substantially at right angles to the table forming section 1 thereof along the curved bend 3 as shown in Figs. 1 and 3. The bend 3 has a rounded curvature, approximately $\frac{1}{2}$ inch in arcuate length. A wood stiffening bar 71 having a rounded edge contour 72 is snugly fitted against the rear face of the rounded metal bend 3, and may be adhesively secured thereto. The outside faces 73 of the stiffening bar extends substantially flush with the adjacent intumed flange sections 21 and 28 of the metal facing sheet. The other two side faces 74 of the wood stiffening bar 71 are so formed as to firmly abut against the adjacent ends of the side stiffening strips 77 of the table forming section and the side stiffening strips 79 of the splash forming section, to thereby support and retain the splash panel *c* in the desired right angle relationship with respect to the table section *a* of the sink.

The sink well *b* may be formed from stamped

sheet metal, preferably stainless steel, of somewhat heavier gauge than the panel forming metal sheet *m*. The sink well may be of any desired shape or form designed to fit within the well opening 8 of the table forming metal sheet. The sink well is initially formed as shown in Fig. 8 from a single sheet of pressed metal to present a bottom forming wall 81 having a suitable drain opening 82 to which the sink drainage fixture is to be secured. The sink well *b* is enclosed by side enclosing walls 83 of any desired depth, which terminate in an outwardly flared flange portion 84. Prior to the attachment of the sink well to the table forming section of the sink, an off-set formation 85 is formed in the enclosing side-walls 83 adjacent the outwardly flared flange portion 84, the off-set formation 85 being shaped to present a shoulder portion 86 as shown in Fig. 9. The inside faces of the laterally flared flange portion 84 and off-set formation 85 are shaped in close conformity with the contour of the flange portion 9 and down-turned lip portion 10 of the metal table facing section 1 of the metal sheet.

A band of soldering or welding metal 87 is deposited upon the outwardly flared flange portion 84 of the sink well as shown in Fig. 10, and the outwardly flared flange portion 84 is then pressed into firm contact with the metal flange portion 9 and lip portion 10 of the metal table section 1 of the sink as shown in Figs. 10 and 11. When a soldering or welding heat is applied to the adjacent flange portions 9 and 84 by the use of electrical contact elements, the soldering or welding metal 87 becomes spread between the flange portions 9 and 84 to integrally bond the flange portions together. The welding or soldering metal will flow uniformly between the adjacent flange portions 9 and 84 and the adjacent surfaces of the lip portion 10 and the off-set formation 85 as shown more particularly in Figs. 11 and 12 to provide a leak-proof seal, with the terminal edge 11 of the metal facing sheet snugly abutting the shoulder portion 86 of the sink well. A smooth and even joint is thus made, with the inside face of the lip portion 11 flush with the inside face of the enclosing walls 83 of the sink well, so that no sharp corners or edges are presented to the user of the sink. The inclined flange portion 9 also facilitates the drainage of waste liquids into the sink well from the drain board areas *a'*, *a''* and *a'''*. The sink well can thus be attached to the metal table facing section 1 of the sink economically and expeditiously to provide a leak-proof joint therebetween and to provide a construction which is free from sharp edges and corners, which facilitates drainage, and which is strong and lasting in use and attractive in appearance.

There is illustrated in Fig. 16 a sink well having a somewhat modified form of upper rim portion, wherein the flange portion 84 of the sink well shown in Fig. 8 is shaped to a generally rounded curvature 84' which curves smoothly into the off-set formation 85 and the shoulder portion 86. Thus when the upper rim portion of the sink well *b* is applied to the table section, the down turned lip portion 10 and the inclined flange portion 9 of the metal facing sheet will snugly seat against the off-set formation 85 and the shoulder portion 86 of the sink well, and at the same time leave a slight gap 87' between the rounded flange portion 84' of the sink well and the adjacent underface of the inclined flange portion 9 of the metal facing sheet as shown in

Fig. 17. The gap 87' may be provided to facilitate the in-flow of the soldering or welding metal 87 between the rounded flange portion 84' of the sink well and the inclined flange portion 9 and the lip portion 10 of the metal facing sheet.

To further enhance the bond between these flange portions, small spaced holes 84'' may be punched in the rounded rim portion 84' of the sink well into which holes the soldering or welding metal 87 may flow. By adopting this modification, a firm metallic bond between the rounded rim portion 84' and the off-set formation 85 of the sink well, and the inclined flange portion 9 and the lip portion 10 of the metal facing sheet, may be expeditiously achieved. The filler boards 90 may then be applied and the joint between the side walls of the sink well and the filler boards 90 and the table backing section 41 may be filled with a suitable mastic 88 as shown in Fig. 18.

To further stiffen and strengthen the construction, the under side area of the table section of the sink between the front edging strip 75, side edging strips 77 and rear stiffening bar 71, may be filled in with wood or fibrous filler boards 90 as shown more particularly in Figs. 2, 3 and 5. The front edging strip 75, the side edging strips 75 and the rear stiffening bar 71 may be notched or grooved as at 91 to lock the filler boards 90 thereto. The filler boards 90 may also be adhesively secured to the edging strips 75 and 77, to the stiffening bar 71, and to the table backing section 41. Wood or fibrous filler boards 92, shown in Figs. 3, 6 and 7, may be applied to the rear face of the splash panel c. The filler boards 92 preferably have a notched interlock as at 93 with the edging strips 78 and 79 of the splash panel. The filler boards 92 may additionally be adhesively secured to the edging strips 79 and 79 and to the rear face of the splash backing section 62. The filler boards 90 and 92 provide additional reinforcing, insuring a finished sink of great strength and rigidity, and yet relatively light in weight. Suitable water-proof packing 88, such as a bituminous or gummy compound, may be packed between the outside faces of the side enclosing walls 83 of the sink well b and the adjacent edges of the filler boards 90, and the surrounding edges 56 of the table backing section 41 as shown in Figs. 5 and 6.

In forming the sink from a single sheet of facing metal *m* in the manner above described, the ends of the wood stiffening bar 71 would not be covered by metal sheeting. Where the sink sides are to abut against a wall or cabinet, metal coverage of the ends of the stiffening bar 71 may be unnecessary. However, the ends of the stiffening bar 71 may be easily covered by the provision of a shoe *i* formed from a stainless steel sheet shaped as shown in Figs. 1, 5 and 6 to present a generally triangular shaped side facing portion 96, a vertical flange portion 97 and a horizontal flange portion 98. The sheathing shoe *i* is so shaped that the facing portion 96 will fully cover the exposed end of the stiffening bar 71. The vertical flange 97 of the sheathing shoe *i* seats over and is secured to the rear face 73 of the stiffening bar 71 and the horizontal flange 98 fits over and is secured to the horizontal face 73 of the stiffening bar 71.

Stainless steel sinks constructed in accordance with this invention are particularly designed for mass production at a price well within the reach of the modest home owner, and at a greatly reduced cost as compared with stainless steel sinks heretofore provided. These sinks are lasting in

use, are designed to be supported upon and easily fitted to any desired cabinet structure and to the interior wall of the building in which they are placed, and provide a construction of lasting utility, highly attractive and appealing in appearance and finish.

While certain novel features of the invention have been disclosed herein, and are pointed out in the annexed claims, it will be understood that various omissions, substitutions, and changes may be made by those skilled in the art without departing from the spirit of the invention.

What is claimed is:

1. An improved sink construction having a table section formed from a metal sheet shaped to provide the facing surface thereof, a fibrous backing section bonded to said metal facing sheet to provide backing support therefor, said metal facing sheet and said table backing section having a sink well opening therein, the metal facing section presenting a downturned lip portion overhanging the adjacent edge of the sink well opening in the table backing section, a metal sink well structure secured to said table section, said sink well structure presenting an inset rim formation providing a smooth fitting seat for the downturned lip portion of said metal facing sheet, and a bonding metal securing the inset rim formation of said sink well structure to the downturned lip portion of said metal facing sheet, said rim formation of the sink well terminating in a downwardly bent end portion spaced from the adjacent part of the facing sheet to present a flared gap therebetween shaped to facilitate the application of the bonding metal.

2. An improved sink construction having a table section formed from a metal sheet shaped to provide the facing surface thereof, a fibrous backing section bonded to said metal facing sheet to provide backing support therefor, said metal facing sheet and said table backing section having a sink well opening therein, the metal facing section presenting an inclined flange portion terminating in a down-turned lip portion overhanging the adjacent edge of the sink well opening in the table backing section, a metal sink well structure secured to said table section, said sink well structure presenting an inset rim formation and an outturned rim portion providing a smooth fitting seat for the flange portion and the downturned lip portion of said metal facing sheet, and a bonding metal securing the outturned rim portion and inset rim formation of said sink well structure to the flange portion and downturned lip portion of said metal facing sheet.

3. An improved sink construction having a table section formed from a metal sheet shaped to provide the facing surface thereof, a fibrous backing section bonded to said metal facing sheet to provide backing support therefor, said metal facing sheet and said table backing section having a sink well opening therein, the metal facing section presenting an inclined flange portion terminating in a downturned lip portion overhanging the adjacent edge of the sink well opening in the table backing section, a metal sink well structure secured to said table section, said sink well structure presenting an inset rim formation and an outturned rim portion providing a smooth fitting seat for the inclined flange portion and the downturned lip portion of said metal facing sheet, a bonding metal securing the outturned rim portion and inset rim formation of said sink well structure to the inclined flange portion and downturned lip portion of said metal facing sheet,

filler boards secured to the under face of said table backing section, and a water-proofing compound filling the space between said filler boards and said sink well structure.

4. An improved sink construction having a table section formed from a metal sheet shaped to provide the facing surface thereof, a fibrous backing section bonded to said metal facing sheet to provide backing support therefor, said metal facing sheet and said table backing section having a sink well opening therein, said metal facing sheet presenting a flange portion terminating in a downturned lip portion overhanging the adjacent edge of the sink well opening in the table backing section, a metal sink well structure presenting an inset rim formation and an outwardly curving rim portion, a bonding metal securing the inclined flange portion and downturned lip portion of the metal facing sheet to the curved rim portion and the inset rim formation of the sink well structure, the free edge of said curved rim portion of the sink well structure being spaced from the inclined flange portion of the metal facing sheet to present a gap therebetween to facilitate the application of the bonding metal.

5. An improved sink construction having a table section formed from a metal sheet shaped to provide the facing surface thereof, a fibrous backing section bonded to said metal facing sheet to provide backing support therefor, said metal facing sheet and said table backing section having a sink well opening therein, said metal facing sheet presenting an inclined flange portion terminating in a downturned lip portion overhanging the adjacent edge of the sink well opening in the table backing section, a metal sink well structure presenting an inset rim formation and an outwardly curving rim portion, and a bonding metal securing the inclined flange portion and downturned lip portion of the metal facing sheet to the curved rim portion and the inset rim formation of the sink well structure, the free edge of said curved rim portion of the sink well structure being spaced from the inclined flange portion of the metal facing sheet to present a gap therebetween to facilitate the application of the bonding metal, said curved rim portion of the sink well structure having spaced holes therein to further increase the holding strength of said bonding metal.

6. An improved sink construction having a table section formed from a metal sheet shaped to provide the facing surface thereof, said metal facing sheet having a sink well opening therein, said metal facing sheet presenting a downwardly sloping flange portion terminating in a down-

turned lip portion defining the sink well opening therein, a metal sink well structure presenting an inset rim formation and an outturned rim portion providing a smooth fitting seat for the flange portion and the downturned lip portion of said metal facing sheet with the facing surface of said downturned lip portion and the adjacent facing surface of the sink wall structure presenting a smooth and flush joint therebetween, and a bonding metal securing the outturned rim portion and inset rim formation of said sink well structure to the flange portion and downturned lip portion of said metal facing sheet.

7. An improved sink construction having a table section formed from a metal sheet shaped to provide the facing surface thereof, said metal facing sheet having a sink well opening therein, said metal facing sheet presenting a downwardly sloping flange portion terminating in a downturned lip portion defining the sink well opening therein, and a metal sink well structure presenting an inset rim formation and an outturned rim portion shaped substantially in contour conformity with the flange portion and the downturned lip portion of said metal facing sheet to provide a smooth fitting seat therefor and forming a smooth and flush joint between the facing surface of said downturned lip portion and the adjacent facing surface of the sink well structure, bonding metal securing the inset rim formation and the rim portion of the sink well structure to the flange portion and lip portion of the metal facing sheet, said outturned rim portion of the sink well structure terminating in a downwardly bent end portion spaced from the adjacent metal facing sheet to present a gap therebetween and shaped to facilitate the application of the bonding metal.

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