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G. W. TALBOT

SCORED VENEER AND METHOD AND MEANS OF MAKING SAME

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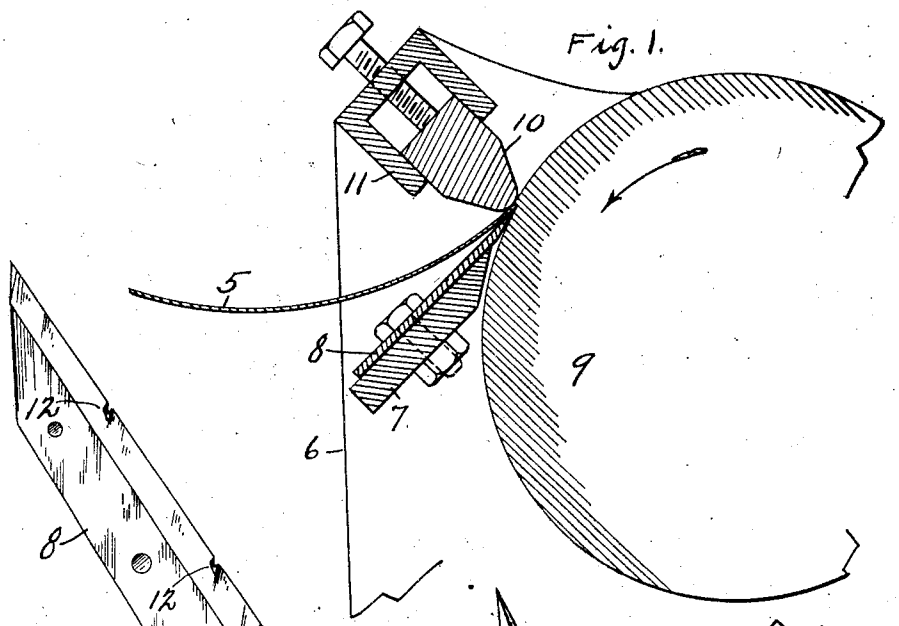


Fig. 1.

Fig. 2.



Fig. 3

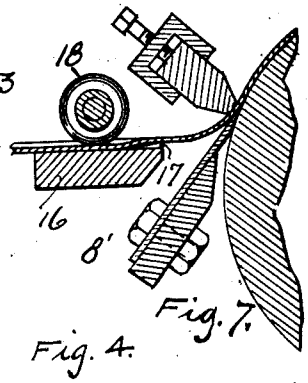


Fig. 7.

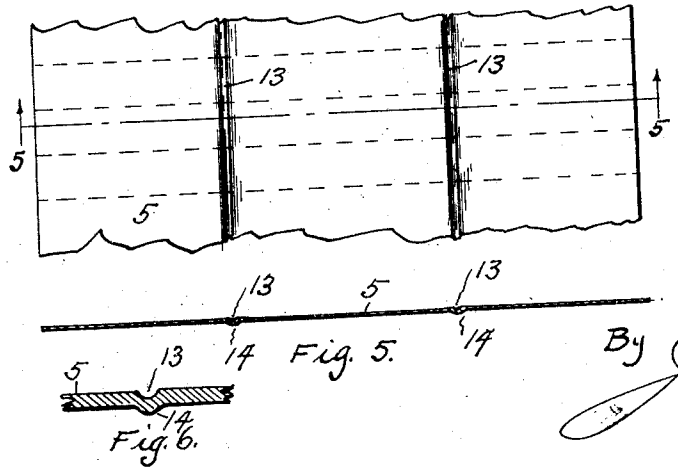


Fig. 4.

Fig. 5.

Fig. 6.

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SCORED VENEER AND METHOD AND MEANS OF MAKING SAME.

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This invention relates to the method and means for making and scoring veneers to be used in the manufacture of baskets, boxes, crates and the like containers such as are in common use for holding fruits, vegetables, and the like.

The object of the invention is to provide the score lines upon which the veneers are bent to form the corners of the containers, without reducing the thickness and so weakening the veneers on said lines as to cause them to break in use, as frequently happens where the usual scoring is done by cutting part way through the veneer sheet from one side without reenforcing it on the other.

A further object is to accomplish my improved scoring simultaneously with the cutting of the veneer from the log, by the aid of the same knife that severs the veneer from the log, and while under the influence of the pressure bar of the veneer machine.

I accomplish the above, and other objects which will hereinafter appear and which will be covered by the appended claims, by the means illustrated in the accompanying drawing, in which—

Fig. 1 is a conventionalized representation in vertical section of a veneer-cutting machine, showing a cutter-bar, knife and pressure-bar, with a log in the machine under the operation of the knife. Fig. 2 is a perspective view of a veneer-cutting knife embodying my improvements, the view showing the beveled side of the knife. Fig. 3 is a view in perspective of a portion of the other side of the knife from that shown in Fig. 2. Fig. 4 is a plan view of a veneer with my improved scoring, showing the outside of the veneer as it comes from the log. Fig. 5 is a section on the line 5—5 of Fig. 4. Fig. 6 is a fragment of the latter on a larger scale, and Fig. 7 is a vertical section of a portion of a veneer machine equipped to bend the veneer to form a channel on one side and a bead on the other.

Like characters of reference indicate like parts in the several views of the drawing.

Referring to Fig. 1, 6 is the veneer mill frame, 7 a cutter bar to which a cutting knife 8 is removably secured. A log 9 softened by soaking and steaming in the usual manner is rotatably mounted in the frame 6 and the usual means (not shown) is provided for constantly moving the cutter-bar so its knife will shave or peel a veneer 5, of the desired thickness, off of the log as the latter rotates. The fiber of the log is compressed on the cutting line by a pressure bar 10 adjustably mounted in a holder 11, and the usual means (not shown) is provided for maintaining a uniform pressure of the pressure bar against the log as the diameter of the log is decreased.

All of the above devices are well known and in common use, with the exception of a novel formation of the cutting-edge of the knife, which involves the imparting of a short semi-circular bend 12, therein, at all places where a scoring of the veneer-product is desired.

In practice this bending is accomplished after first drawing the temper of the knife-edge only where the bends are to be made; there, by hammering, or by pressure applied by the aid of a tool similar to that used for setting saw-teeth, or by any other suitable means, the edge is bent in a short half-circle, as shown. The center-knife may then be re-tempered if desired, but in practice I have found that not to be necessary.

A knife having scoring-bends 12, as shown, and as above described, cuts a half-round channel 13 in the log surface where the scoring-bends occur, and the wood thus removed remains on the resulting veneer as an integral, correspondingly shaped, half-round rib 14 directly opposite a corresponding channel on the other side of the veneer, made by the same knife in peeling off the preceding layer. This is illustrated in Fig. 5, and still better in Fig. 6, where it will be seen that the channel extends only about half way through the veneer thickness, making a favorable score for a corner bend in that direction, and that the rib on the opposite side reenforces the material on the outside of the corner and keeps it from breaking down under pressure of a load, as at the bottom bend where the sides of a basket are turned at more than right angles to form an integral bottom, and the baskets filled with apples, onions, or the like are stacked, one above the other in transportation and storage.

A veneer of the same cross-section, that is, with a channel on one side and a bead opposite it on the other is made by bending the fibers of the veneer instead of shearing some of them as previously described. This operation is illustrated in Fig. 7 where the knife 8′ has a straight cutting edge without the bends 12 but the veneer passes over a

table 16 having a channel 17 into which a power-driven roller 18 presses the veneer, thereby forming a corresponding channel on the roller-side and a bead opposite it on the other side of the veneer.

Having thus fully described my invention, what I claim is—

1. A scored veneer having cutout channels on one side and cutout beads on the other of corresponding size and shape, said veneer having straight unscored and unbeaded portions between said channel-beads of suitable areas to form container members when the veneer is bent at the channel-beads.

2. A veneer having cut-out channels on one side and cutout beads on the other formed out of the material obtained by the formation of a channel in a veneer cut from the same log, said veneer having straight unscored and unbeaded portions between said channel-beads of suitable areas to form container members when the veneer is bent at the channel-beads.

3. A method of scoring veneers which consists of forming a channel in the log by the veneer cutting knife as the veneer is cut and leaving the cut-out material integral with that side of the veneer which was nearest to the center of the log.

4. The method of cutting and scoring veneers which consists in softening a log by steaming and soaking it, then forming scoring bends in the cutting edge of a veneer cutting knife, then rotating the softening log, then applying pressure longitudinally of the log to its periphery, and then progressively feeding the knife toward the center of rotation of the log under said pressure at a rate to peel off a veneer of the desired thickness.

In testimony whereof I affix my signature.

GEORGE W. TALBOT.