

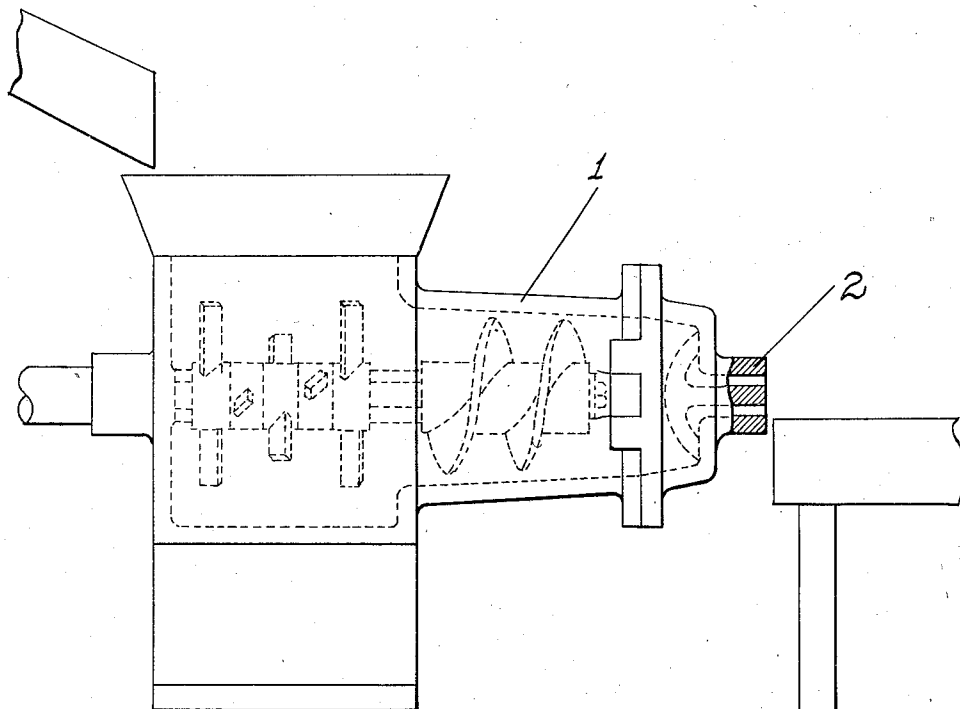
Sept. 21, 1926.

J. F. MAKOWSKI

1,600,552

METHOD OF MAKING PLASTER TILE

Filed Feb. 16, 1926



INVENTOR

J.F. Makowski

BY *Benny J. Webster*
ATTORNEY

Patented Sept. 21, 1926.

1,600,552

UNITED STATES PATENT OFFICE.

JOHN F. MAKOWSKI, OF STOCKTON, CALIFORNIA, ASSIGNOR TO CALIFORNIA CEDAR PRODUCTS COMPANY, OF STOCKTON, CALIFORNIA, A CORPORATION.

METHOD OF MAKING PLASTER TILE.

Application filed February 16, 1926. Serial No. 88,575.

This invention relates to the making of wall tile or the like, particularly that type used in the construction of corridor and partition walls in class A fire proof buildings.

5 It is essential that such walls be fairly rigid and stiff, and yet in the interest of economy of space it is essential that they be as thin as possible and usually the corridor walls are four inches thick and the partition walls are
10 about two inches thick. Also the walls must be hollow for the reception of plumbing, wiring and the like.

The most common practice of making such wall today is either with small channel
15 iron studs to which metal lath is attached and the whole plastered over, or hollow gypsum plaster blocks or tile are made and laid together to form the wall. My invention is directed to the art or method of
20 making the tile as a substitute for those methods now commonly practiced.

The type or tile or block now commonly used is made of calcined gypsum plaster which are made in molds where they are allowed to harden and set and dry in the
25 molds before they can be handled. This requires that usually they must be made at a plant distant from the building where they are to be used, and then transported to the building as required. This makes
30 the cost of making, handling and the naturally resulting breakage very high.

It is the aim of my invention, therefore, to make the tile or blocks by pressing the wet mixture through a shaping die directly
35 at the building and ready for use immediately upon the building as fast as delivered by the machine if so desired. In this way the cost of making will be materially reduced, the cost of handling entirely eliminated, and the labor cost of installation can likewise be much reduced as
40 will appear, and very little, if any, breakage will be encountered.

45 A further object of my invention has been to work out a simple and inexpensive method and yet one which will be exceedingly effective for the purpose for which it is devised.

50 These objects I accomplish by means of such type of machine and method of compounding the plastic mixture and working the same through the die as will fully appear by a perusal of the following specification and claims.

In the drawing similar characters of reference indicate corresponding parts in the several views:

Fig. 1 is a diagrammatic outline of one type of machine which can be used in the
60 making of the tile. However the particular machine used or the particular shape of tile is immaterial as many modifications of these can be indulged in without departing from the spirit of the invention.

65 In carrying out the construction of my improved tile I take fifty per cent, by volume, of calcined gypsum and fifty per cent of sawdust or like filler material. I then add to this pottery clay in the approximate
70 proportion of twenty five per cent clay in the total of the final product. I also add any of the known retarding elements such as liquid glue or the like to retard the setting of the mass when wet for from one
75 to four hours. The whole is then mixed in water to form a heavy mass of a consistency of stiff pottery clay so that when pressed together it can be handled without being depressed with the fingers or normal contact
80 with each other or other objects.

The mass thus formed is then fed into a pottery press 1 or like machine which forces it through a die or mold 2 of any shape desired. The blocks or tile thus formed can
85 be then set aside to harden and set or may be immediately used in the wall as the clay in the mass will cause them to hold their shape and form until they have thoroughly set, hardened and dried.

90 The clay, in addition to giving the body or consistency to the finished block or tile adds the necessary "slip" to allow the mass to be pressed through the die. Without this or some other substance mixed with the calcined gypsum or cement the resistance of the mass to the pressure of the machine and against the sides of the die and core would be such as to cause the mass to separate and also the pressure might possibly break the
100 machine.

In practice instead of making the block or tile of calcined gypsum as the setting material, cement may be used if that character of block or tile is desired.

105 From the foregoing description it will be readily seen that I have produced such a device as substantially fulfills the objects of the invention as set forth herein.

While this specification sets forth in de- 110

tail the present and preferred construction of the device, still in practice such deviations from such detail may be resorted to as do not form a departure from the spirit of the invention, as defined by the appended claims.

Having thus described my invention what I claim as new and useful and desire to secure by Letters Patent is:

- 10 1. The method of making a building block or tile including first establishing a plastic mixture comprising a setting material such as calcined gypsum or the like, a fibrous filler material such as sawdust or the like,
- 15 and a clay all mixed with water and then forcing the mixture through a shaping die to form the block or tile.

2. The method of making a building block

or tile including first establishing a plastic mixture from which the same are to be made, such mixture including an ingredient to allow the mixture to slip through a shaping die, and then forcing the mixture through a shaping die to form the block or tile.

- 25 3. The method of making a building block or tile consisting in mixing calcined gypsum and clay or the like with water to form a mass of the consistency of wet pottery clay, forcing the same through a shaping die while wet to form the block or tile and then allowing it to set, harden and dry.
- 30

In testimony whereof I affix my signature.

JOHN F. MAKOWSKI.