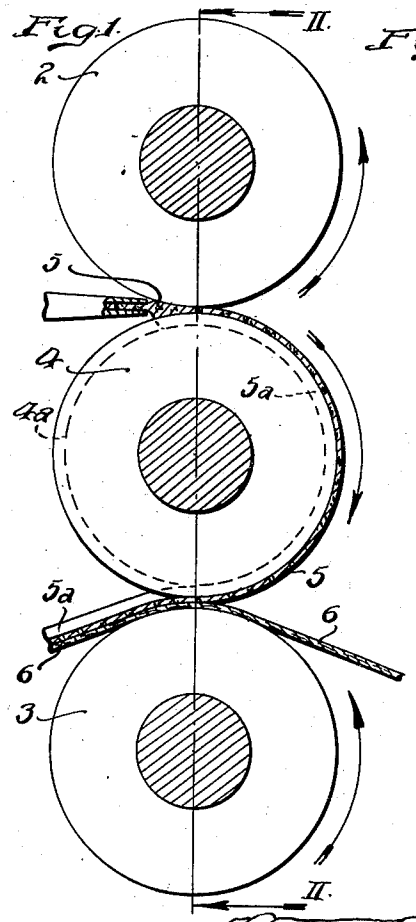
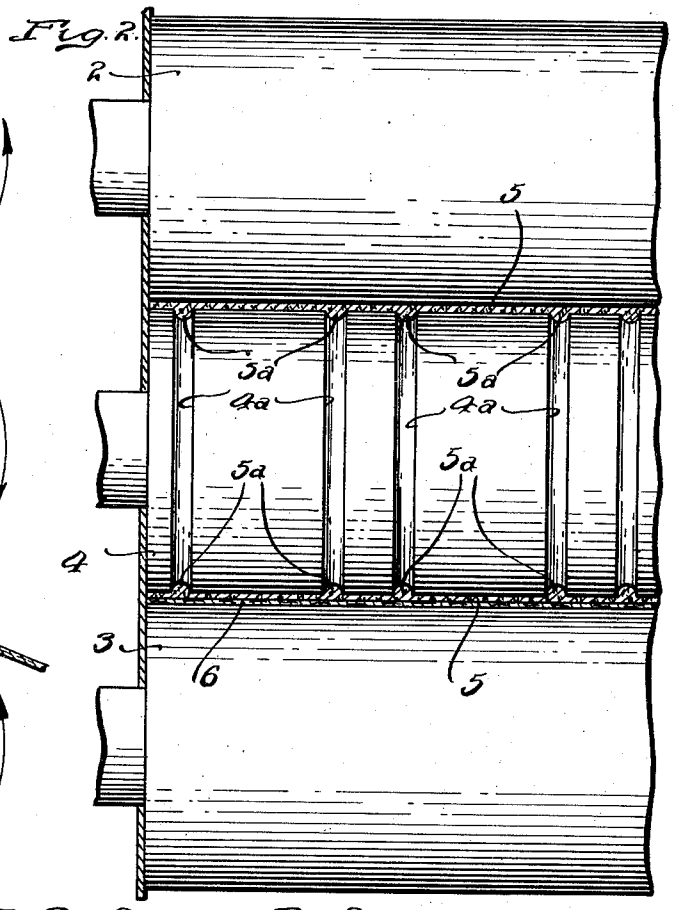
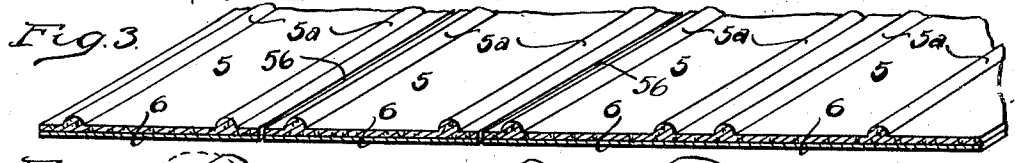
Sept. 7, 1937. E. F. TANNEWITZ 2,092,432

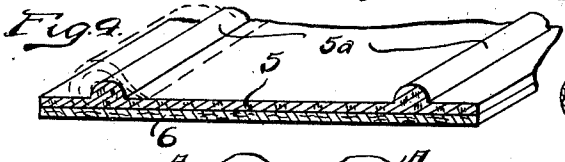
WINDOW MOUNTING

Filed July 7, 1932









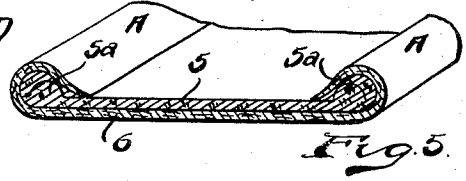
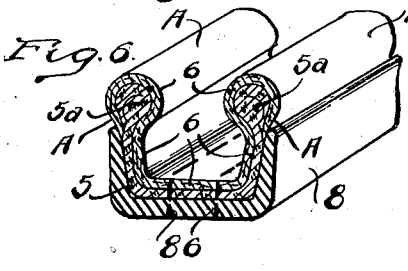


Fig. 5.



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WINDOW MOUNTING

Edward F. Tannewitz, Detroit, Mich., assignor to The Detroit Gasket and Manufacturing Company, Detroit, Mich., a corporation of Michigan

Application July 7, 1932, Serial No. 621,221

16 Claims. (Cl. 154—2)

My invention relates to window mounting such as shown in my Patent Number 1,670,321, of May 22, 1928, and objects of my improvements are to reduce the cost of manufacturing the same and to produce a better article.

I accomplish this object in the way and by the means illustrated in the accompanying drawing, in which:

Figure 1 is a diagrammatic side elevation of a series of rolls and illustrating the process of my invention.

Figure 2 is a section on the line II, II, Figure 1.

Figure 3 is a perspective view of a portion of the sheet formed by the apparatus of Figures 1 and 2, showing its front edge in section.

Figure 4 is a view similar to Figure 3 showing a portion of one of the strips into which the sheet of Figure 3 is cut.

Figure 5 is a view similar to Figure 4 showing the side edges of the strip turned over to adapt the same to be combined with the base-strip to form the run and complete the channel strip.

Figure 6 is a perspective view of the channel strip embodying my invention the front end being shown in section.

2, 3, and 4 are forming rolls with axes in a vertical plane. The rolls 2 and 3 have plain cylindrical surfaces and the roll 4 has grooves 4*a* formed around its periphery. These grooves are located in pairs intermediate the ends of the roll and the grooves of each pair are at a distance apart equal to the two edge portions of the severed strips that are turned over in forming the bead for the run, as hereinafter described. The grooves at the ends are located one half this distance from the end of the roll.

The distance between the pairs of grooves and between the end pairs and the end grooves is equal to the breadth of the channel-run-strip between its thickened edges, as hereinafter described.

5 is a sheet of cushion material formed from a mass of plastic material by passing the same between the rollers 2, 3, and 4, as illustrated in Figures 1 and 2. This material is made up of comminuted cork held together by a suitable binder.

6 is a sheet of felt. This sheet is fed between the rollers 3 and 4, as illustrated and the plastic material is fed between the rollers 2 and 4 and passes between the rollers 3 and 4 above the sheet 6, as illustrated in Figure 1, and is formed into a sheet by the action of the rolls 2 and 4. The upper surface of the cloth or felt 6 is provided with an adhesive cement and as the rolls press the sheet 5 against said surface it is firmly united thereto.

The plastic material 5, as it passes between the rolls 2 and 4 is compressed into the grooves 4*a* so that ridges 5*a* are formed thereon of approximately semi-cylindrical shape in cross section.

After passing through the rolls, as above described, the plastic cushion material and felt is formed into a composite sheet illustrated in Figure 3, having the cork 5 with the ridges 5*a* upon one side and the felt sheet 6 upon the other side. This composite sheet is now divided into strips by cutting the same longitudinally between the ridges 5*a* of each pair, as illustrated at 56 in Figure 3. The strip thus formed is illustrated in Figure 4.

The edges are now turned over the ridges 5*a*, 5*a*, as illustrated in broken lines in Figure 4, forming the construction illustrated in Figure 5 having thickened edges constituting beads *a*, *a*. This strip is then placed in the cavity of the base-strip 8, as illustrated in Figure 6, and secured therein by stitches 86 or otherwise, the beads *a*, *a*, coming adjacent to the edges of the base-strip 8 and forming the window-channel-run which I have designated, as a whole, by the letters A, A. This brings the resilient and durable cushion cork material against the inner surface of the base-strip 8 and with the overlapping felt covering the beads *a*, *a*, so that when the glass is interposed between said beads it engages against the felt and the felt is resiliently held in shape by the cork.

What I claim is:

1. In a process of forming a strip to be used in making a window-channel-run, passing a plastic material between rolls and forming a sheet having integral spaced parallel longitudinal ridges in connection with a sheet of felt so that the two shall be united together to form a composite sheet with the two materials upon opposite surfaces, and the ridges exposed on one of said surfaces, folding said composite sheet into substantially U-shape, and forming said ridges into bead portions at the entrance opening of the channel.

2. In a process of forming a strip to be used in making a window-channel-run, passing a plastic material between rolls and forming a sheet therefrom with spaced parallel longitudinal ridges along its sides in connection with a sheet of felt so that the two shall be united together to form a composite sheet with the two materials upon opposite surfaces, and the ridges exposed on one of said surfaces, folding said composite sheet into substantially U-shape, and forming said

ridges into bead portions at the entrance opening of the channel.

3. In a process of forming a strip to be used in making a window-channel-run, passing a plastic material between rolls to form a sheet therefrom with ridges along its sides in connection with a sheet of felt so that the two shall be united together to form a composite sheet with the two materials upon opposite surfaces, and turning the edges of said composite strip over said ridges.

4. In a process of forming strips to be used in making a window-channel-run, passing a plastic material between rolls to form a sheet having spaced integral parallel longitudinal ridges in connection with a sheet of felt so that the two shall be united together to form a composite sheet with the two materials upon opposite surfaces, said sheets being of the width of a plurality of the strips required and then cutting said sheet to form strips of the width required.

5. In a process of forming strips to be used in making a window-channel-run, passing a plastic material between rolls to form a sheet therefrom with spaced parallel longitudinal ridges in connection with a sheet of felt so that the two shall be united together to form a composite sheet with the two materials upon opposite surfaces and the ridges exposed on one of said surfaces, said sheets being of the width of a plurality of the strips required and then cutting said sheet to form strips of the width required, said ridges being properly relatively arranged and extending from the plastic sheet, substantially as and for the purpose described.

6. In a process of forming a strip to be used in making a window-channel-run forming a sheet of plastic material with spaced pairs of ridges along its sides upon one surface of a sheet of felt and causing it to adhere thereto so that the two shall be united together to form a composite sheet with the two materials upon opposite surfaces, and turning the edges of said composite strip over said ridges.

7. In a process of forming strips to be used in making a window-channel-run forming a sheet of plastic material with longitudinal ridges thereon upon one surface of a sheet of felt so that the two shall be united together to form a composite sheet with the two materials upon opposite surfaces, said sheets being of the width of a plurality of the strips required and then cutting said sheet to form strips of the width required, said ridges protruding from the plastic sheet and being properly relatively arranged, for the purpose described and turning the adjacent edges of the composite strips over said ridges.

8. In a window channel strip a base-strip of U-shape in cross section, a sheet of cushion material extending along the inner surfaces of said base-strip with its edges enlarged and forming integral beads extending above the edges of said base-strip, a sheet of felt extending along the inner surfaces of said sheet of cushion material, and having its edges turned over the edges of said cushion material.

9. In a process of forming a strip to be used in making a window channel run, passing a plastic material between rolls, one of which is provided with a circumferential, coaxial groove to form a sheet therefrom with an integral ridge along its side in connection with a sheet of felt so that the two shall be united together to form a composite sheet with the two materials upon opposite surfaces and said ridge exposed on one of said surfaces.

10. A window channel strip comprising a U-shaped base, a layer of cushion material having integral bead portions disposed above the edges of said base, said layer of cushion material abutting the interior of said base, and a layer of felt enclosing the exposed area of said cushion material and turned-over said beads, the ends of said felt layer engaged between the adjacent portions of the edges of the base and said cushion layer.

11. The process of forming a strip to be used in making a window channel run, which comprises forming a sheet of plastic material having a substantially smooth surface on one side and on the other side transversely arranged parallel ridges in spaced pairs, the respective pairs of ridges being relatively widely spaced apart and combining the sheet with a layer of felt and adhering the same to the substantially smooth surface of the sheet, and cutting the composite sheet between the ridges of each pair to form strips of the required width.

12. A window channel comprising a base of U-shape, a sheet of cushion material extending along the inner surface of said base strip and having an integral substantially solid bead formed thereon at each edge, said cushion material having a bottom and sides coextensive with said base and said beads extending above the adjacent edges of the base.

13. A process of making a window channel run consisting in passing a plastic material between rolls and forming a sheet having integral spaced parallel longitudinal ridges in connection with a sheet of felt so that the two shall be united together to form a composite sheet with the two materials upon opposite surfaces and the ridges exposed on one of said surfaces, cutting said sheet to form a strip with one of said ridges adjacent to each edge and forming said strip into a U-shape in cross section with said ridges at the outer edges thereof.

14. The process of forming a strip to be used in making a window channel run which comprises feeding a plastic mass to a forming instrumentality and simultaneously forming from the plastic mass a sheet having a substantially smooth surface on one side and parallel ridges on the opposite side, said ridges being formed in pairs and the pairs being widely spaced apart relative to the spacing between each of the ridges of a pair, combining the sheet with a layer of fabric and uniting the same to the smooth surface of said sheet, severing the sheet between the ridges of each pair to form channel strips, and folding the edges of the strips upon said ridges to form beads.

15. In a window channel strip, the combination of a base-strip of U-shape in cross section, and a sheet of plastic cushion material extending along the inner surface of said base-strip and having an integral bead formed thereon at each edge above the edges of said base-strip, said base strip confining the cushion sheet below said beads and secured to the cushion sheet.

16. In a window channel strip a base-strip of U-shape in cross section, a sheet of cork composition extending along the inner surface of said base-strip with its edges enlarged and forming solid integral beads extending above the edges of said base-strip, a sheet of felt extending along the inner surface of said composition sheet, and having its edges turned over the edges of said composition.

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