

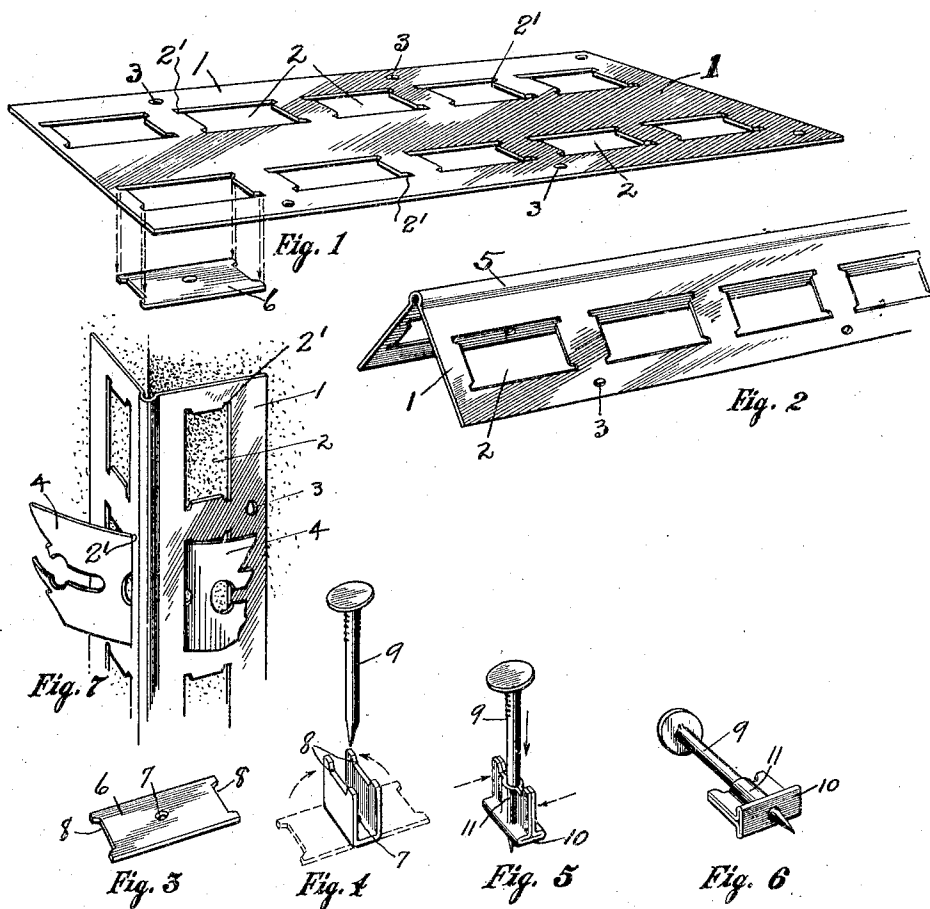
July 31, 1928.

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1,679,248

PROCESS OF MAKING CORNER BEADS AND NAIL SPACERS

Filed Oct. 2, 1925



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PROCESS OF MAKING CORNER BEADS AND NAIL SPACERS.

Application filed October 2, 1925. Serial No. 59,991.

Heretofore it has been the practice in making articles of this character to form the spacer out of metal stamped from a sheet with the result that there is much waste.

5 This is the case in making the spacing member shown in U. S. Patent No. 1,541,360, issued to me and Harry W. Hahn, June 9, 1925.

10 In making metal corner beads it has been the practice to stamp plaster-receiving holes in the strips of metal and then form the strip into the corner bead, with the result that the slugs or pieces stamped out of said strips in forming the plaster-receiving holes
15 are wasted, because they were not cut in a predetermined design or form for use.

20 I have conceived the idea of forming the holes in corner bead strips of special forms in order that the slug or piece stamped out of the sheet can be used to form a spacer for stucco nail, and thus eliminate waste in manufacturing corner beads and also in manufacturing spacers for stucco nails.

25 In order to explain my invention, I have shown on the accompanying sheet of drawings a strip of metal formed for corner bead service and a spacer formed out of the slug or piece stamped out of said strip of metal in order to make the plaster-receiving hole. In
30 the drawings illustrating one form or embodiment of the invention,—

Figure 1 is a perspective view of a strip of metal after being punched and before being formed into corner bead;

35 Figure 2 is a perspective view of the finished corner bead;

Figure 3 is a view of the piece stamped out of the strip, referred to as a slug;

40 Figure 4 shows the slug after the first action thereon of the dies with nail in position above, ready to be positioned for the next action;

Figure 5 shows the nail in position and the second action of the dies thereon;

45 Figure 6 is a perspective view of the finished stucco nail or fastening means; and

50 Figure 7 shows the corner bead in place and showing how the specially formed hole lends itself to receiving a fastening band of the same width.

Referring now in detail to the drawings, 1, designates a strip or sheet of metal, having been run through a stamping machine and stamped with the predetermined form or de-

sign of holes, 2, 2, therein, and also the nail
55 holes, 3, for nailing the article to the structure, as indicated in Fig. 7, where a corner bead, as illustrated in Fig. 2, is shown applied to the corner of a structure. It will be noted that the openings 2 are provided
60 with corner recesses 2'. It will be noted, too, that the special form of hole, 2, makes a very efficient provision for using a nailing strip, such as 4, where there is necessity or
65 advantage in using such a strip, said strip being of a width corresponding to the longest dimension of said hole and fitting into the corners of the same in such a way as to prevent relative movement and making a very
70 efficient means for securing the corner bead in place, as illustrated in Fig. 7. The corner bead complete is designated, 5, and is formed from the sheet or strip shown in Fig. 1, after said strip has been punched as indicated. When the nailing strip 4 is used, its edges
75 may be inserted in the corner recesses 2', as shown in Fig. 7, to assist in holding the strip in place.

I will now describe the use of this special slug, or piece, 6, stamped out of the strip 1,
80 to form the holes, 2, 2, which become plaster-receiving holes in the corner bead. As said strip is moved through the proper dies for the punching operation, said slugs fall therefrom in a form to be used in the formation
85 of a spacer for a stucco or furring nail, with a hole, 7, therein, as indicated in Fig. 3. The slugs are then moved to the press and the first operation folds said slug in the manner indicated in Fig. 4, into a substantial
90 U-shape. The opposite ends of said slug have the recesses 8, 8, formed therein in the original stamping operation, and for a purpose hereinafter set forth. The next step in the method of forming the article as
95 shown in Fig. 5, is the insertion of a nail, 9, into the hole, 7, between the sides of the U-shape form, whereupon dies come together on the opposite sides thereof and press said sides around the nail, forming the fold into
100 a flat bearing foot, 10, crosswise of the plane of the meeting sides. The structure, thus formed is of T-shape with the sides folded toward the head of the nail, or with the nail extending through the stem portion of said
105 T-shape, as will be clear from Figs. 5 and 6. Attention is called to the fact that this form of fastening means is stronger than the one

shown in the patent hereinbefore referred to, for the reason that there is a bead-like form around the nail and longitudinally thereof, as at 11, while the bearing foot, 10, is double
5 thickness, pressed together tightly and is transversely of the bead-like form 11, as will be clear. The recesses, 8, 8, in the meeting edges of said structure, receive the wire to be held and when the nail is driven home, the
10 head of the nail bridges said recesses and holds the wire therein, in a manner which will be clearly understood by those versed in the art to which this invention appertains. So far as I am aware, I am the first to
15 conceive of the idea of preventing waste in the formation of such articles as those described herein by providing a predetermined and specially formed hole in an article which must be provided with holes in order to perform the function for which it is made, and
20 thus making possible the use of the piece or slug cut out in forming such hole for making another article, such as a spacer for a furring or stucco nail. The waste in connection with forming spacers is also prevented, for heretofore it has been necessary to stamp out the blanks or slugs and waste the portions of the sheet or strip from which they are stamped. By forming the holes in
30 the corner bead, or such other articles as must be provided with holes, so that the piece or slug stamped therefrom will be usable for another article, it making no particular difference as to the form of the hole
35 in the corner bead just so it is sufficient to receive plaster in this case, I have made an important improvement in the art of manufacturing corner bead and spacers for stucco or furring nails, and believe that invention
40 is involved in the method, as well as in the

improved article itself, and while I have shown and described my invention in connection with the manufacture of corner bead and spacers for stucco or furring nails, I do not limit the invention to the exact showing
45 made for illustrative and explanatory purposes, except as I may be limited by the here-to appended claims.

I claim:

1. The process of making a corner bead 50 which consists in stamping a strip of sheet metal to form two rows of openings there-through, and bending the same longitudinally between said rows of openings to form a corner bead, the part cut out from each
55 opening being designed to be folded into a nail spacer, said openings being of rectangular form with the corners extended slightly in the line of one of the sides to form spaced lugs on said part to be bridged
60 by the head of a nail, substantially as shown and described.

2. The process of making a corner bead which consists in stamping a strip of sheet metal to form two rows of openings there-
05 through, and bending the same longitudinally between said rows of openings to form a corner bead, the part cut out from each opening being designed to be folded into a nail spacer, said openings being of rectangular
70 form with the corners extended slightly in the line of opposite parallel sides to form spaced lugs on said part to be bridged by the head of a nail, substantially as shown and
75 described.

Signed at Los Angeles, Los Angeles County, California, this 25th day of September, 1925.

CHARLES E. KEAS.