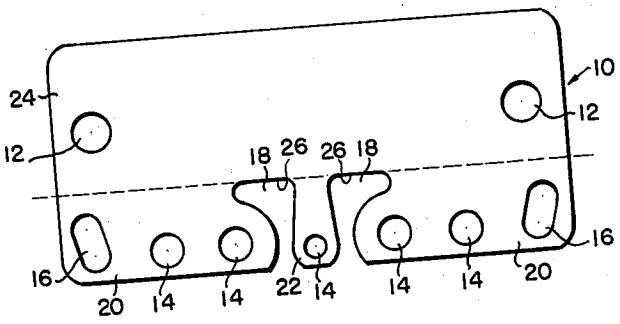
July 3, 1962 J. HOLTZ 3,041,708

METHOD OF MAKING A BRACKET

Filed June 23, 1960

FIG. 1



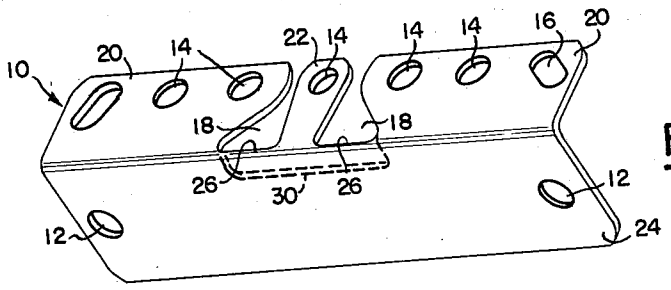
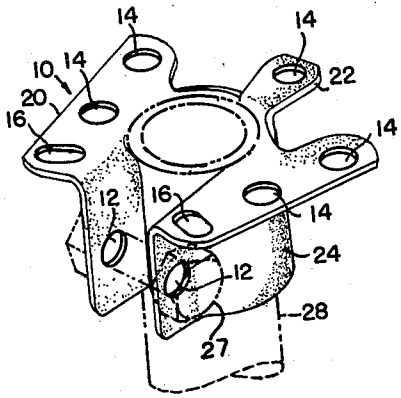


FIG. 2

FIG. 3



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3,041,708
Patented July 3, 1962

3,041,708

METHOD OF MAKING A BRACKET

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Filed June 23, 1960, Ser. No. 38,347
1 Claim. (Cl. 29—150)

This invention relates to a method of making a bracket which is adapted for fastening a leg to a chair seat, or to a table top, and for similar purposes.

In order to reduce shipping and storage costs, it is the practice to ship a table, or a chair, or the like, in at least a partly dismantled condition, that is, with the legs detached from the table top, or chair seat.

The object of the invention is to produce an improved method of making a bracket of the type set forth which will be inexpensive to produce, which will be easy to use and which will have the necessary rigidity.

The full nature of the invention will be understood from the following specification and the accompanying drawing, in which:

FIG. 1 is a top plan view showing the first step in making the bracket.

FIG. 2 is a perspective view showing an intermediate step in making the bracket.

FIG. 3 is a perspective view of the completed bracket.

According to my invention, the bracket is made of any suitable material, such as cold rolled steel, which is sufficiently rigid, which can be easily stamped and punched, and which is malleable enough to be bent from the flat condition of FIG. 1, first to the position of FIG. 2 and then to the position of FIG. 3.

The first step in making the bracket is to stamp out blank **10** of the desired thickness, size and shape and, simultaneously, to punch holes **12** near the short edges of the blank, holes **14**, elongated openings **16** and generally triangular recesses **18** near the edge of a long side of said blank, to produce marginal portions **20** and central tab **22**.

The next step is to bend the blank along the broken line in FIG. 1 to produce an elongated section which includes marginal portions **20** and tab **22** and which is disposed at a substantially right angle position relative to the remaining body portion **24** of the blank. It will be noted that marginal portions **20** and tab **22** contain holes **14** and openings **16**, and that in the finished bracket the marginal portion and the central tab are co-planar.

The third step in making the bracket is to bend the body portion **24** of the blank around a mandrel, not shown, into the generally cylindrical form shown in FIG. 3, and to dispose marginal portions **20** on either side of central tab **22**. It will be noted that the space between tab **22** and each of the adjacent marginal portions **20** is a function of the length of the base **26** of the corresponding recess **18**.

To use the bracket, the upper end **28** of a table or chair leg is inserted in the cylindrical portion of the bracket, and a bolt **27** is passed through openings **12** and tightened slightly to hold the leg in position. Marginal portions **20** and tab **22** are then presented to the under side of the table top, or chair seat, and are secured in position by screws passing through holes **14**. The leg **28** is then pushed tightly up against the under side of the table top

or chair seat, and the bracket is tightly clamped about the upper end of the leg.

The provision of elongated openings **16** permits predrilling of the table top or chair seat for receiving the screws which pass through holes **14** and **16**, thus facilitating the assembly operation for the householder, who only needs to register holes **14** with the holes in the table top or chair seat and to apply the fastening screws. It will be noted that in the completed bracket, holes **16** are elongated in the direction in which the sides of the cylindrical portion of the bracket move in response to the tightening of bolt **27**. This permits the bracket to be clamped about the leg even after the bracket has been fully secured in position. In other words, the bracket may be completely fastened to the underside of a table top, or chair seat, so that the purchaser need only insert the upper end of the leg into the bracket and tighten bolt **27**. The leg may be made of pipe, or of rod stock, or of wood, etc.

I have discovered that by providing the triangular recesses with their bases **26** disposed along the bend line of the blank, I can provide additional tab **22**, which gives the bracket a three-point support, by first bending the blank to the position of FIG. 2 and then to the position of FIG. 3. This two-step bending of the blank makes it unnecessary to cut the blank out, as at **30**, and therefore the bracket is not weakened.

What I claim is:

The method of making a bracket for fastening a leg to an article of furniture which method includes

taking a substantially rectangular blank **10**,

punching spaced, substantially triangular segments out of one long side of said blank to produce an isolated, central tab **22**,

punching a hole **14** near the outer edge of said tab,

punching linearly aligned holes **14**, **16** near the edge of the marginal portions **20** on either side of said tab,

punching symmetrical holes **12** near the edges of the opposite short sides of said blank,

bending said tab and said adjacent marginal portions in one direction along a line passing through the junction of said tab with the remaining portion of said blank to form an elongated section which includes said tab and said marginal portions and which is disposed substantially normal to the remaining portion **24** of the blank,

and reverse bending said remaining portion **24** to form a collar for receiving the leg,

with said elongated section extending radially outwardly from said collar for fastening to a flat surface of an article of furniture.

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