July 4, 1933. J. STANITZ 1,916,910

PROCESS OF MAKING SINKS, WASHBASINS, AND THE LIKE

Filed Dec. 7, 1932 2 Sheets-Sheet 1

Fig. 1.

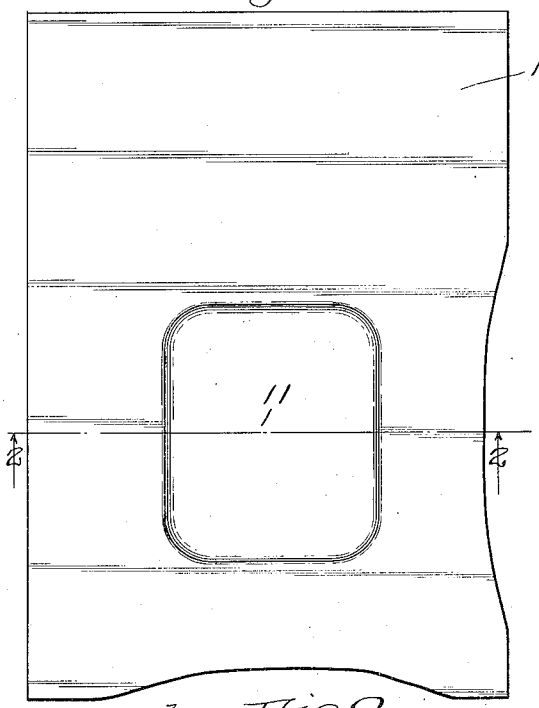


Fig. 2.

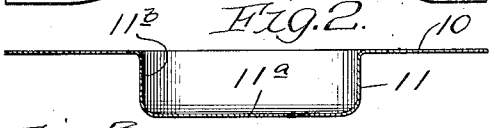


Fig. 3.

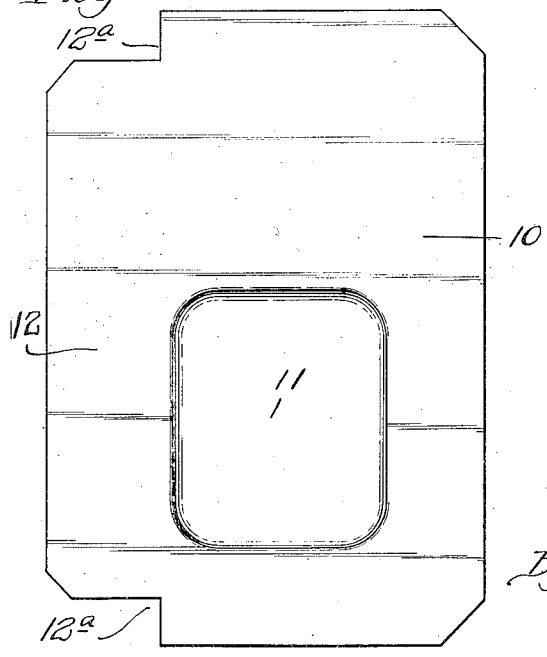


Fig. 4.

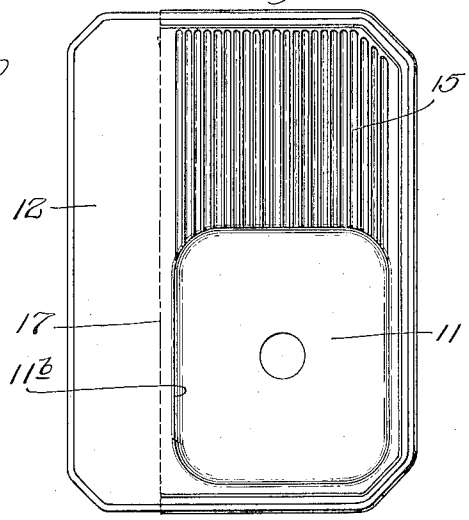


Fig. 5.

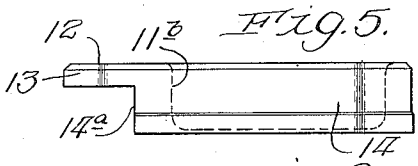


Fig. 6.

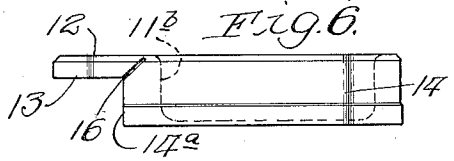


Fig. 7.

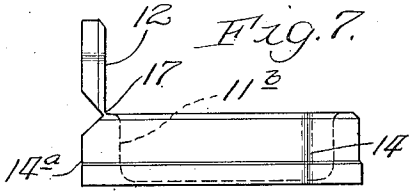
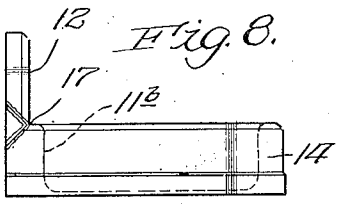


Fig. 8.



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July 4, 1933. J. STANITZ 1,916,910

PROCESS OF MAKING SINKS, WASHBASINS, AND THE LIKE

Filed Dec. 7, 1932 2 Sheets-Sheet 2

Fig. 9.

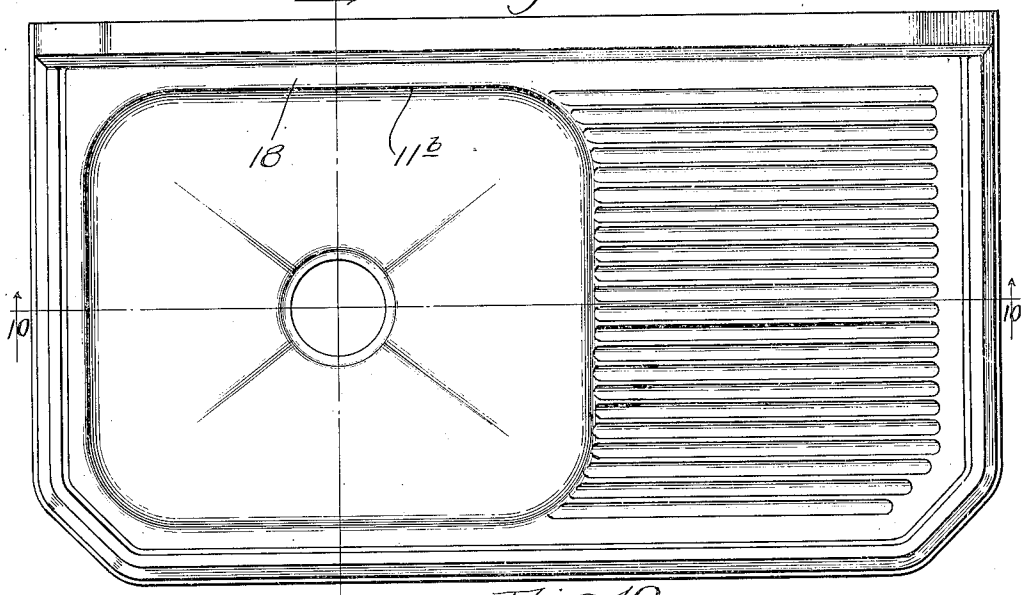


Fig. 10.

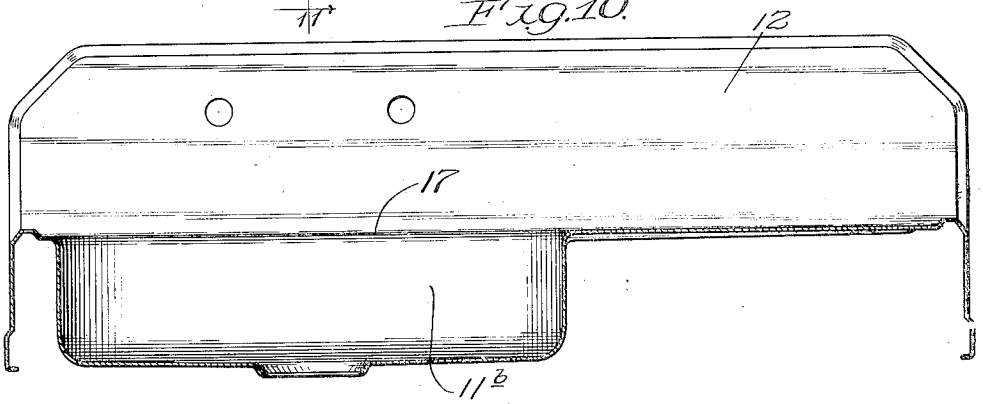
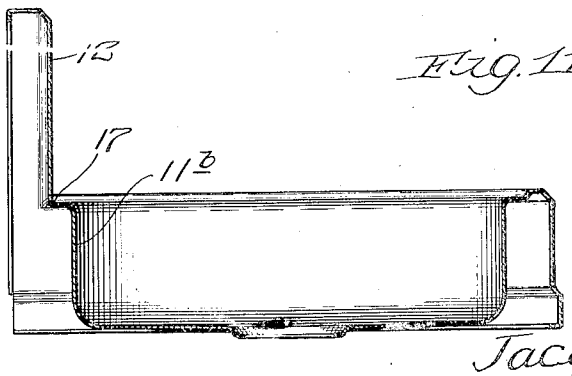


Fig. 11.



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UNITED STATES PATENT OFFICE

JACQUES STANITZ, OF WARREN, OHIO, ASSIGNOR TO THE YOUNGSTOWN PRESSED STEEL COMPANY, OF WARREN, OHIO, A CORPORATION OF OHIO

REISSUED JAN 6 - 1942

PROCESS OF MAKING SINKS, WASHBASINS, AND THE LIKE

Application filed December 7, 1932. Serial No. 646,207.

This invention relates to improvements in the process of forming sheet metal into sinks, wash basins and the like, of the type which are provided with a comparatively high back lying in a plane substantially at right angles to the plane of the top of the sink or basin.

By the exercise of my improved process, sinks, wash basins, and the like, can be quickly and cheaply formed from a single piece or blank of sheet metal.

Heretofore, in the forming of such devices from a single piece of sheet metal, difficulty has been encountered in the step of bending the back up into its vertical position. The first step in the manufacture of devices of the kind referred to from sheet metal is the drawing down of the fluid-receiving bowl. This bowl is ordinarily provided with a substantially vertical back wall. Consequently, there is a right angle bend at the upper edge of the wall. It has been found that if the splash-back is bent upwardly to a vertical position at or very near the upper edge of the back wall of this bowl, the metal is likely to be fractured or objectionable bulging or wrinkling may occur. The principal feature of my invention is the provision of a method of manufacture which eliminates this objection.

In the accompanying drawings, I have shown the sink as it appears during the various stages of manufacture. In these drawings—

Figure 1 is a top plan view of a blank or sheet of metal from which the sink or basin is formed, showing the fluid-receiving bowl drawn therein; Fig. 2 is a view taken as indicated by the line 2 of Fig. 1; Fig. 3 is a view similar to Fig. 1 showing the blank trimmed for the succeeding operations; Fig. 4 is a top plan view showing the apron, panels and drain grooves formed and, also, the flange for the back; Fig. 5 is an end view of the sink partly formed as shown in Fig. 4; Fig. 6 is a view similar to Fig. 5 showing the notching of the flanges to permit the bending up of the splash-back; Fig. 7 is a view similar to Fig. 6 showing the back bent upwardly into its vertical position; Fig. 8 is a view similar to Fig. 7 showing pieces welded in the flange on the back; Fig. 9 is a top plan view of the finished sink; Fig. 10 is a view taken as indicated by the line 10 of Fig. 9; and Fig. 11 is a view taken as indicated by the line 11 of Fig. 9.

As shown in the drawings, 10 may indicate a substantially rectangular blank of sheet metal from which the completed sink is to be formed. In Fig. 1, the fluid-receiving bowl 11 is shown as already completely drawn or formed in the blank. The bottom of this bowl is indicated by 11^a and the back wall thereof by 11^b.

After the formation of the fluid-receiving bowl, the blank is trimmed as shown in Fig. 3, principally by making the edges straight, beveling the corners, and cutting the notches 12^a, 12^a to define the back 12 and leave sufficient metal for formation of the apron around the sink.

The sink is then formed as shown in Fig. 4. That is, the flange 13 is formed on the back and the apron 14 is drawn down around the sink. The drain grooves 15 may also be formed. It is to be particularly noted, however, that the apron 14 extends some distance back of the plane of the back wall 11^b of the fluid-receiving bowl 11. As shown in Fig. 5, the back edge of the apron 14 is indicated by 14^a. It will be seen that this lies some distance back of the plane of the wall 11^b.

The flange 13 on the back is then notched, as indicated by 16, where it joins the apron 14. The back 12 is then bent up into vertical position on the line 17. It is to be particularly noted that this line 17 lies back of the plane of the back wall 11^b of the fluid-receiving bowl. This leaves a horizontal shelf 18 back of the fluid-receiving bowl and in front of the splash-back. If the back 12 is bent up on a line lying substantially in the same plane as the back wall 11^b, there is very likely to be a fracture, bulging or wrinkling of the metal at the line of the bend. When the bowl is formed, a right angle bend is made at the top of the back wall of the bowl. If the back is bent up along this line, this causes a straightening of this bend, which is very likely to either weaken or fracture the metal or cause distortion of the same. By

bending the back wall up on the line 17 lying back of the upper edge of the back wall 11^b, this is avoided.

The foregoing detailed description has been given for clearness of understanding only, and no unnecessary limitations should be understood therefrom, but the appended claim should be construed as broadly as permissible, in view of the prior art.

What I regard as new, and desire to secure by Letters Patent, is:

The process of forming sinks, wash basins, and the like, with a splash-back, which consists in drawing down an integral sheet of metal to form the fluid-receiving bowl, leaving at one side sufficient metal to form the back; and bending the back upwardly to a substantially vertical position along a line lying back of the plane of the back wall of the fluid-receiving bowl.

In witness whereof, I have hereunto set my hand, this 29th day of November, 1932.

JACQUES STANITZ.