

DEFENSIVE PUBLICATION

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939 O.G. 7

T939,001
PRESSING

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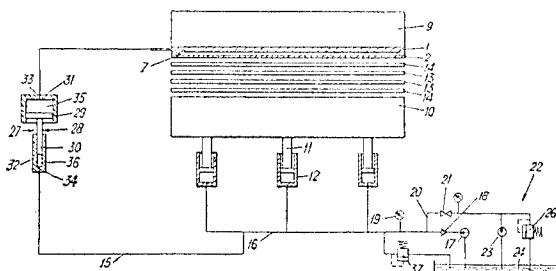
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51,487/71

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U.S. Cl. 100—38

4 Sheets Drawing. 42 Pages Specification



A method of making a pressed article including the step of pressing a workpiece and at least one resilient liquid-filled cushion plate between the platens of a press and heating, or optionally cooling, the workpiece and cushion plate during the pressing operation is disclosed. The pressing operation is accomplished such that the volume of liquid in the chamber of the cushion plate is maintained substantially constant by providing means responsive to the pressure within the cushion plate to accept the increase in volume of liquid brought about by the thermal expansion of the liquid filling the chamber in the heated embodiment, or to introduce additional liquid into the closed chamber when the pressing is conducted and the workpiece is cooled.

The disclosed resilient cushion plate includes a pair of continuous metal sheets spaced apart from each other in a substantially parallel manner, at least one of the sheets being relatively thin and flexible. The sheets are sealed together around their peripheries to define an inner chamber which can be completely filled with a liquid and the plate is provided with an entrance leading into the chamber positioned so as to not interfere with the pressing operation. The entry port permits the filling of the chamber with liquid and provides for communication to and from the chamber for accommodating the expansion or contraction of liquid within the chamber, depending upon pressing conditions. The invention is particularly adapted for pressing sheets of plastics materials and an apparatus for conducting the method is also described.

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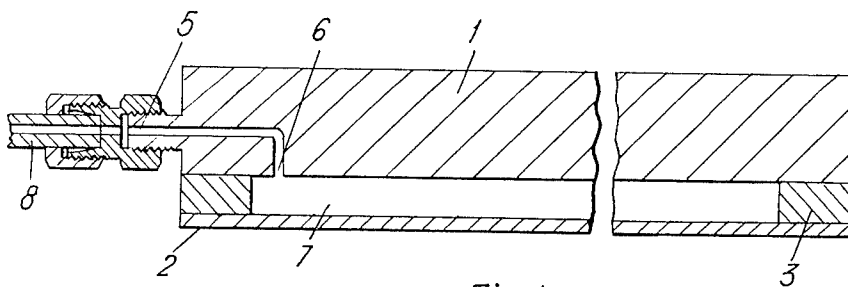


Fig. 1.

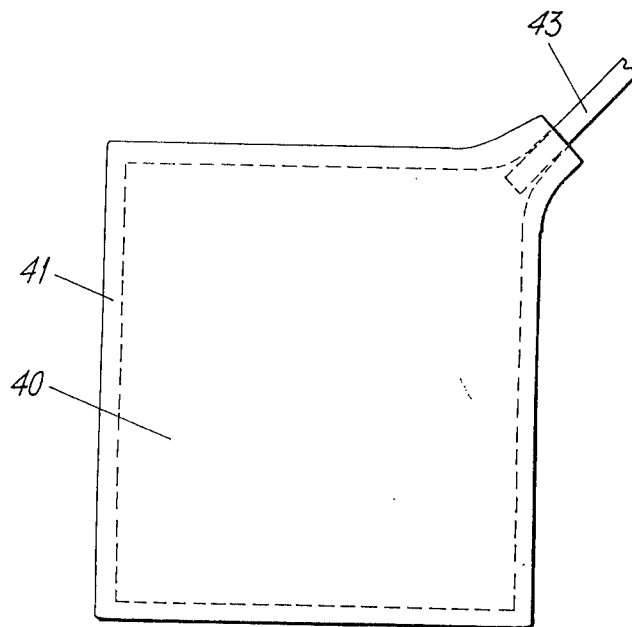


Fig. 3.

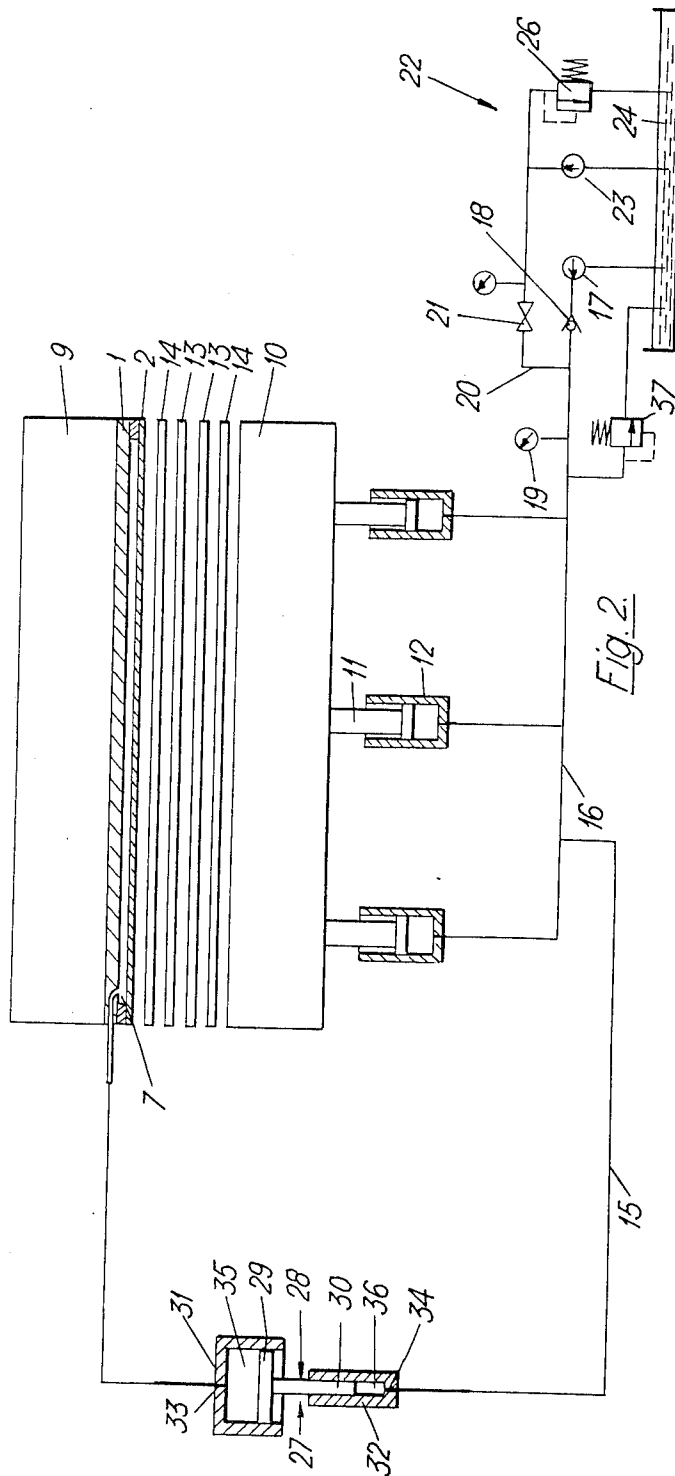
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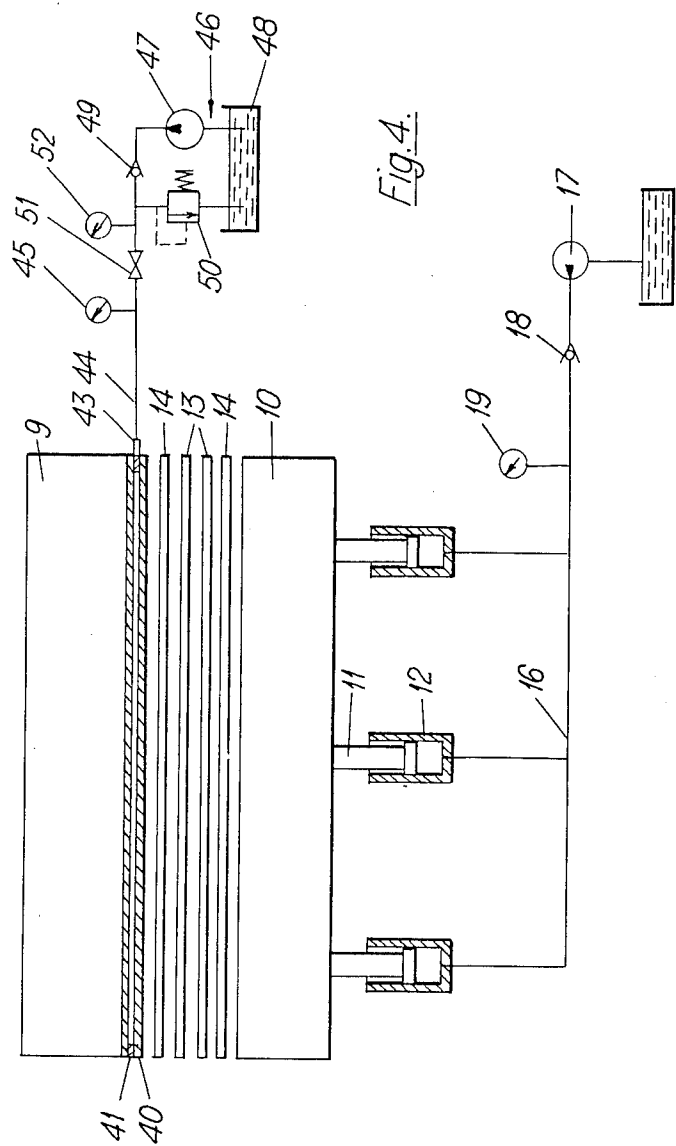


Fig. 4.