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PROCESS OF MANUFACTURE OF MASONRY SIMULATING MATERIAL

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Fig. 2.

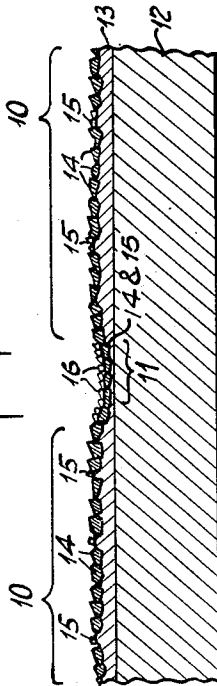


Fig. 1.

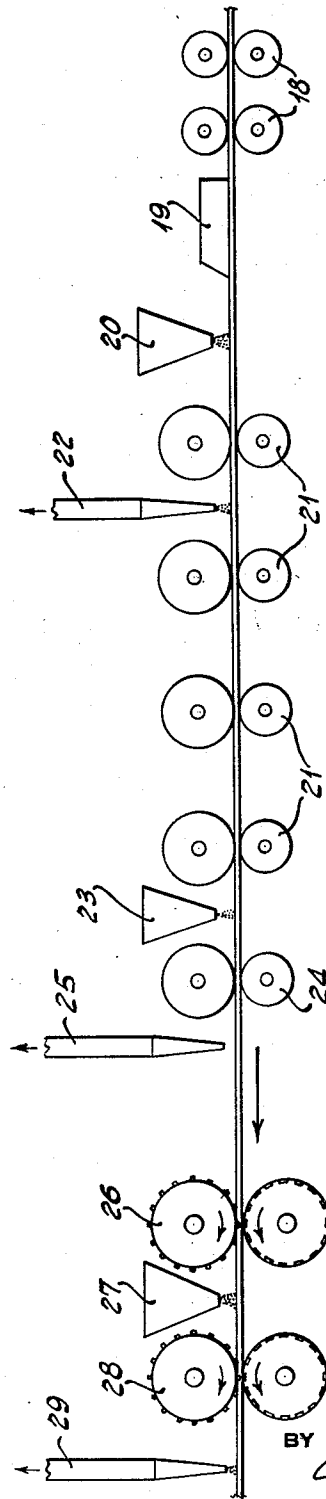
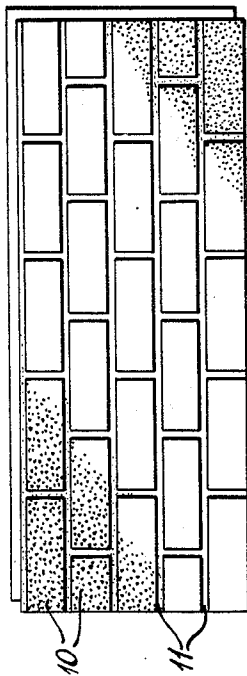


Fig. 3.

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PROCESS OF MANUFACTURE OF MASONRY SIMULATING MATERIAL

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2 Claims. (Cl. 117—9)

This invention relates to masonry simulating material, and particularly to siding material for covering the walls of buildings, in the form of a base, coated with a plastic coating material, and surfaced with granules designed to simulate masonry, such as bricks having mortar joints between them.

Difficulty has been experienced heretofore in the manufacture of material of this character in obtaining a good simulation of masonry such as brick. In the normal production of colored mortar joint insulated siding panels, the saturated board is coated with the proper coating material, slated, and then passed through a series of press rolls. During the pressing operation, minute quantities of coating are extruded between the slate granules, resulting in an unlimited number of adhesion points. These extrusions in the production of black mortar joint products are of no detriment. Following the pressing stage, the mortar lines are first produced in black by forcing the base granules into the coating with a hot embossing roll. A contrasting granule is then dropped over the entire panel and same are then pressed into the mortar lines by a second embossing roll. Excess slate is then removed by a suction system; however, a thorough removal is not possible since a small percentage of this slate adheres to the coating peaks extruded between these brick face slate granules, thus resulting in color dilution of the brick faces.

It is, therefore, an object of the present invention to provide an improved mortar joint masonry simulating material in which the masonry simulated areas are not diluted with mortar simulating material.

It is a further object of the present invention to provide an improved masonry simulating material of two colors distinctively separate from each other.

It is a further object of this invention to provide an improved colored mortar joint insulated brick siding free from color dilution of the brick faces by the mortar joint slate.

It is a further object of the present invention to provide an improved process for manufacturing colored mortar joint masonry simulating material in which two colors are distinctively separate from each other.

These and other objects are attained by the present invention which relates to an improved colored mortar joint masonry simulating material having masonry simulating surface areas containing both coarse and fine granules of a masonry color and mortar joint simulating areas having a surface of fine granules of a different color, and to a method of producing it.

In order to produce a colored mortar joint insulated siding panel free of color dilution, the saturated board is coated and slated in a manner similar to that employed in the prior art. However, after passing through a series of press rolls, but before reaching the last press roll, a fine slate of the same color as the base slate is applied over the entire panel face by means of a roll-type hopper or a vibratory feeder. This fine slate application thoroughly masks any coating extrusions between the coarse slate

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granules, and fills all voids between the coarse granules, thus sealing any exposed coating. Excess fine masking slate is then removed by suction after one press stage. Following this, the embossing operation is performed in a manner similar to the method of the prior art, except that all of the mortar joint granules which do not remain in the mortar lines are removed, since there is no tendency for these granules to adhere to the brick face, since any exposed coating has been masked.

While substitutions and variations may be made within the scope of the claims, a preferred embodiment of the invention is disclosed in the drawings in which:

Fig. 1 is a view, partly in detail, of a colored mortar joint insulated brick siding panel;

Fig. 2 is an enlarged fragmentary cross section of a part of the panel shown in Fig. 1; and

Fig. 3 is a diagrammatic view of a coating apparatus adapted to carry out the process of the invention.

With reference to Fig. 1, there is shown a panel of colored mortar joint brick having insulated siding having brick simulating portions 10 and mortar simulating portions 11. Fig. 2 shows an enlarged fragmentary section of the panel shown in Fig. 1. The view shows two portions of brick simulating portions 10 and a mortar joint simulating portion 11. There is shown the fiberboard base 12 with the plastic asphalt coating 13, in which is embedded the coarse brick simulating granules 14. Intermingled with these granules are fine brick simulating granules 15, and in the mortar simulating areas 11, there is a surface of fine particles of mortar simulating granules 16.

The apparatus shown diagrammatically at Fig. 3 begins with coater feed rolls 18, to which is fed the asphalt impregnated fiberboard. At coater 19, there is applied the relatively thick layer of plastic asphalt and at hopper 20 the board has its surface covered with the coarse granules of masonry simulating material. The board then passes through a series of press rolls 21, and after the first press roll, there is a suction nozzle 22 to remove excess granules. After the several pressing rolls, there are places where the asphalt has come to the surface, and there is therefore provided a hopper 23 for applying the fine masonry simulating granules which cover any exposed asphalt. This is followed by another press roll 24, and another suction nozzle 25, from which a board goes to the hot embossing rolls 26, where the mortar joint design is pressed into the board. The pressure of these hot rolls submerges the masonry simulating granules and brings asphalt to the surface at the embossed lines. The fine mortar simulating granules are applied from hopper 27. Cold embossing rolls 28 press the granules into place, and excess granules are removed by suction nozzle 29. The board thus produced has a clean appearance of distinctively separate colored brick areas and mortar colored areas.

While the granules may be selected from wide varieties of materials such as crushed brick and sand, they are preferably slate, which is colored with pigments to the desired shade. The terms coarse and fine, as used herein, will be understood by those skilled in the art. However, the fine particles are about half the size of the coarse particles. A preferred colored mortar joint insulated brick siding has coarse brick slate of 11 mesh, fine brick slate of 28 mesh and mortar slate joint of 22 mesh.

In the above description of colored mortar joint brick insulating siding, it will be understood that a stone simulating siding, having mortar joints or other simulations could be used as well. Furthermore, the invention is not limited to insulation board, but can be applied to paper siding or other masonry simulating materials.

What I claim is:

1. A process for manufacturing an improved colored mortar joint masonry simulating material which comprises coating a base with a plastic material, applying

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coarse masonry simulating particles, pressing said coarse masonry simulating particles into the plastic material, applying fine masonry simulating particles of the same color, pressing said fine masonry simulating particles into the surface of the material, embossing mortar line patterns on the material, applying fine mortar simulating particles of a color different from the masonry simulating particles and pressing said fine mortar simulating particles into the embossed mortar line patterns.

2. A process for manufacturing an improved colored mortar joint insulated brick siding which comprises coating an impregnated insulation board with plastic asphalt, applying coarse brick simulating particles, pressing said coarse brick simulating particles into the plastic asphalt, applying fine brick simulating particles of the same color, pressing said fine brick simulating particles into the surface

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of the material, embossing mortar line patterns on the material, applying fine mortar simulating particles of a color different from the brick simulating particles and pressing said fine mortar simulating particles into the embossed mortar line patterns.

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