Sept. 24, 1935. L. DE F. HOKERK 2,015,382

METHOD OF MAKING WASTE AND DESK BASKETS

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Fig. 1.

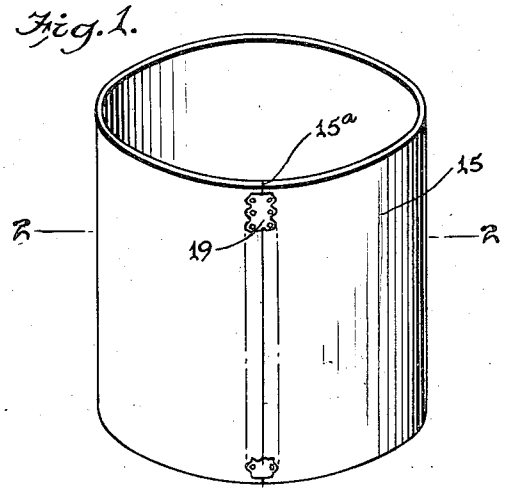


Fig. 2.

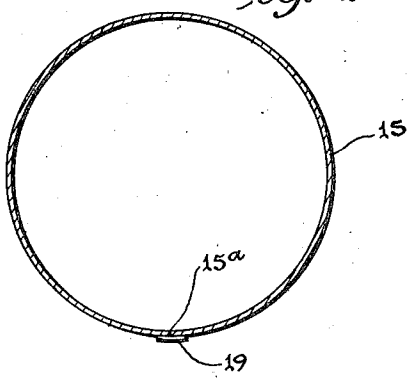


Fig. 3.

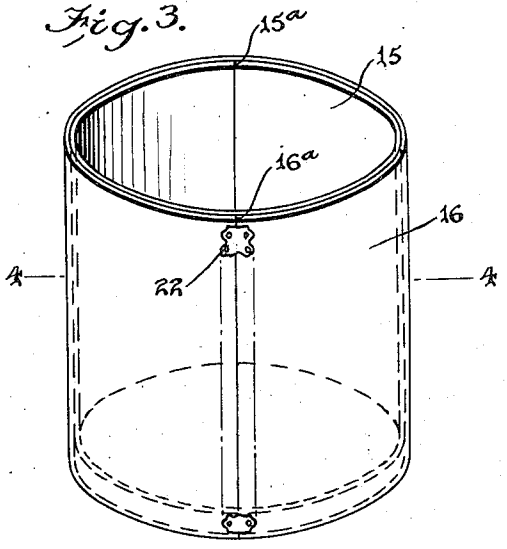


Fig. 5.

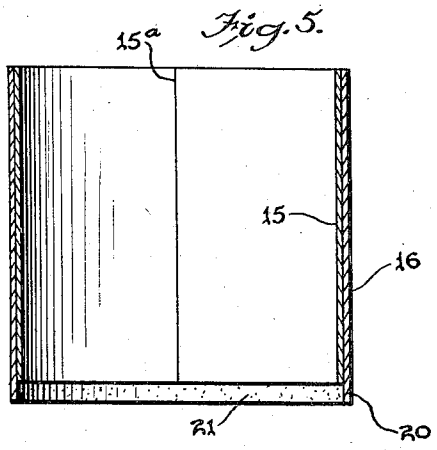


Fig. 4.

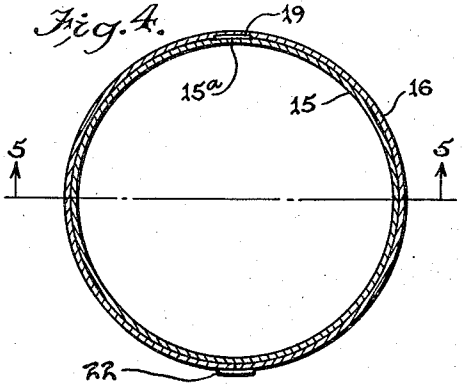
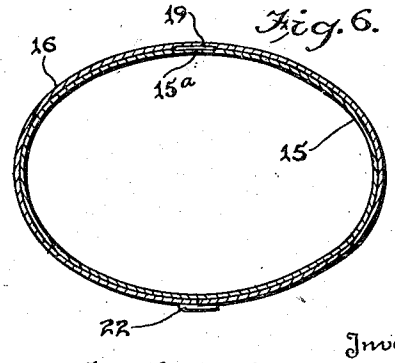


Fig. 6.



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Fig. 7.

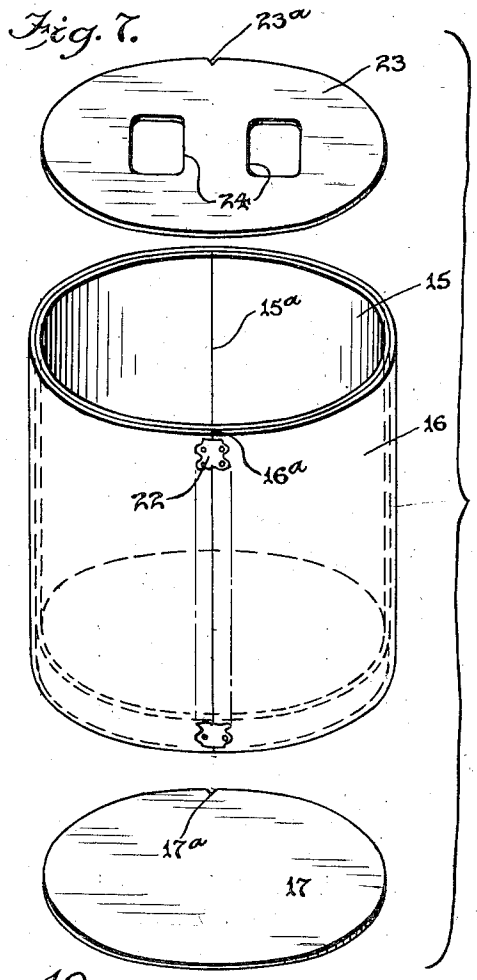


Fig. 8.

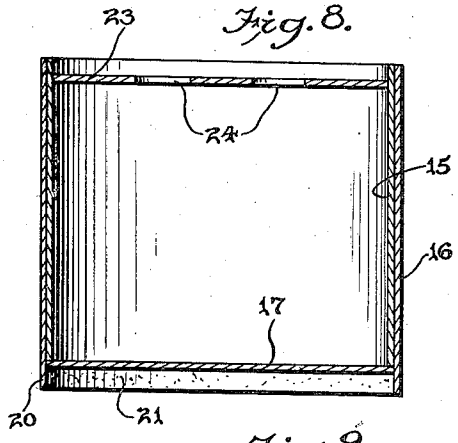


Fig. 9.

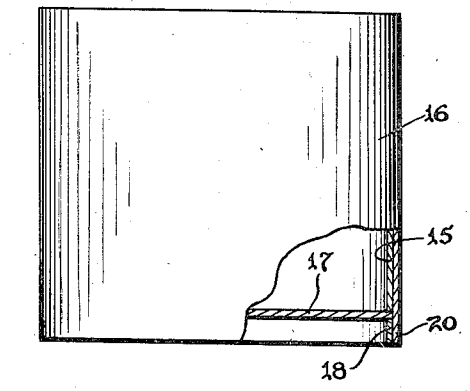


Fig. 10.

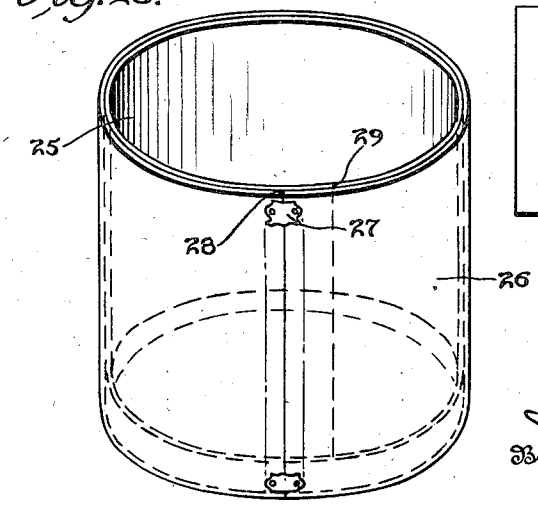
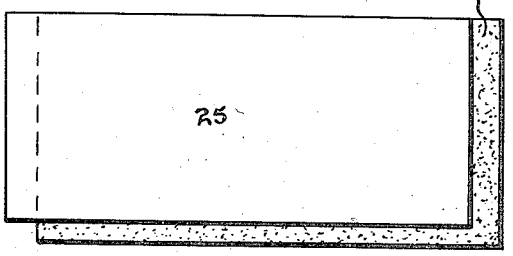


Fig. 11.



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METHOD OF MAKING WASTE AND DESK BASKETS

Lynde De F. Hokerk, Utica, N. Y.

Application December 10, 1934, Serial No. 756,906

3 Claims. (Cl. 93—39)

The present invention relates generally to receptacles of the nature of waste or desk baskets and is more particularly an improved method of manufacturing waste or desk baskets having for its primary object the production of a graceful article of pleasing appearance, considerable strength and substantial durability, in a simple economical manner which avoids the necessity of using expensively prepared materials and promotes certain refinements in the making thereof insuring uniformity of all baskets made strictly in accordance with the improved method.

Other objects as well as the resulting advantages of the improved method will more clearly appear in the course of the following description thereof in detail, reference being had to the accompanying drawings, which form a part of this specification, and in which,

Figure 1 is a perspective view showing the cylinder formed as a result of the first formative step toward the making of the basket body.

Figure 2 is a horizontal section taken on line 2—2 of Fig. 1.

Fig. 3 shows the basket body assembly complete.

Fig. 4 is a sectional view taken on line 4—4 of Fig. 3.

Fig. 5 is a vertical section taken on line 5—5 of Fig. 4.

Fig. 6 is a top plan view with the body shaped to oval form by the insertion of the ovate bottom piece.

Fig. 7 shows the body, bottom piece and drying template or form piece exploded in perspective to show certain features entering into their assembly.

Fig. 8 is a vertical sectional view showing the exploded parts of Fig. 7 in assembled form.

Fig. 9 is a side view of the basket of Fig. 8, partly broken away.

Fig. 10 is a perspective view showing a basket assembled in accordance with a slightly modified method; and

Fig. 11 is a plan view of the two body layers superimposed prior to formation of the body according to the modified method.

Referring now to these figures, a waste or desk basket of oval form in cross or horizontal section such as shown in Figures 8 and 9, has its body composed of inner and outer walls or layers 15 and 16 of cardboard material in closely adhering relation, and is provided with a base or bottom piece 17 interfitting the outer wall or layer 16 and abutting the lower edge of the somewhat shorter inner wall or layer 15, with or without an internal reinforcing bottom edge strip 18 adhering to the lower inner surface of the outer layer 16 below the base 17.

According to the invention the basket, constituted as above, is formed by initially bending a rectangular section of cardboard to form a cylinder as in Figure 1, which subsequently constitutes the inner layer 15 of the body. The ends of the cardboard section are brought snugly together in this operation to form a vertical joint 15ª which may be secured by a metallic strip fastener 19 or by an adherent strip of gummed paper, cloth or other material.

The next step is to form around the cylinder of Fig. 1, a second cylinder constituting the outer layer 16, for which purpose a second section of similar material must be utilized of sufficiently greater length to permit of snugly joining the ends thereof around the inner cylinder or layer 15 in the form of a vertical joint 16ª which is preferably diametrically opposed to the joint 15ª, as seen in Figs. 3, 4, and 6. Previous to its assembly around the inner layer 15, the outer layer 16 is coated over its entire inner surface with a suitable adhesive which subsequently brings about its firm adhesion to the inner layer and it will be noted that with the upper edges of the two layers in flush relation, the lower edge of the outer layer depends below the corresponding edge of the inner layer in the form of an extension indicated at 20 in Fig. 5 and bearing upon its inner face a portion of the adhesive above mentioned as indicated at 21 in said figure.

The joint 16ª formed by the abutting ends of the outer layer 16 is secured by a metallic strip fastener 22 or a gummed strip of other material and the body of the basket is at this time complete though not as yet in final shape. The method proceeds with sufficient promptness with the insertion of the oval base or bottom piece 17 and an upper temporary drying template or form 23 to avoid drying of the adhesive 21 in the meantime.

Thus while the adhesive is still tacky and the body layers 15 and 16 still freely flexible, the bottom piece 17 whose circumference equals that of the outer surface of the inner layer 15 and the inner surface of the outer layer 16, is forced into the lower extension 20 and as it is so forced against the lower edge of the inner layer 15, it drags with its edge a portion of the adhesive 21 sufficient to cause effective adherence thereof with the bottom edge of the inner layer as well as with the inner surface of the extension 20 of the outer layer.

Immediately after insertion of the bottom piece 17, a template or drying form 23 is inserted with-

in the upper open end of the body as plainly seen in Figs. 7 and 8, member **23** being the same shape as the bottom piece **17** so as to insure uniformity in the oval shape of the body from top to bottom. However, since it is quite possible to axially shift or misplace one of these parts relative to the other, the bottom piece **17** and the drying form **23** are provided with similarly positioned side notches **17a** and **23a**, as seen in Fig. 7 and as they are associated with the body they are properly oriented by alining the notches **17a** and **23a** with the opposite ends of either the joint **15a** of the inner layer **15** or the joint **16a** of the outer layer **16**.

Since the template or drying form is simply a temporary feature to be removed when the basket has thoroughly dried, it is provided with finger openings **24** facilitating its removal.

According to the foregoing the inner and outer layers of the basket body are separately assembled and secured as in Figs. 1 and 3, but it is quite possible to avoid this by placing the blank **25** for the inner layer flatwise in offset relation upon the gummed surface of the blank **26** of the outer layer as in Fig. 11 and then bending the two layers at one operation into cylindrical form and securing the same by an external fastener **27** for the joint **28** of the outer layer, leaving the joint **29** of the inner layer unconnected, if desired, except for its adhesion to the inner surface of the outer layer.

The extension **20** may be varied in either method so that it is just equal to the thickness of the bottom piece **17** in which case it will, when assembled, be flush with the lower edge of extension **20**, or it may extend materially below the bottom piece, as shown in Figs. 8 and 9. In the latter event it may be desired to reinforce the extension by an internal reinforcing strip **18** and where such is employed as in Fig. 9 it is to be understood sufficient tacky adhesive **21** remains on the extension **20** to insure adhesion of the strip **18** as applied.

What is claimed is:—

1. The hereindescribed method of manufacturing an oval shaped waste or desk basket, which consists in utilizing body forming inner and outer layers of material of such length that the ends of each will abut, when the layers are in circumjacent relation, the outer layer being somewhat wider than the inner layer so that it projects at one edge beyond the corresponding edge of the inner layer and forms an extension of a single layer, coating the inner surface of the outer layer including its said extension with an adhesive, forming a cylindrical body with the two layers in face to face relation and adhering to one another and the joint of the abutting ends of the inner layer exposed interiorly of the body, applying an additional fastening means to the abutting ends of the outer layer, fitting a previously shaped oval base or bottom piece within the extension of the outer body layer and at the same time orienting said member by alining a mark at its edge with the joint of the inner body layer, pressing said bottom inwardly, axially of the body against the adjacent edge of the inner layer while the adhesive coating of the outer layer is sufficiently tacky for the edge of the bottom member to drag a portion of said adhesive therewith to insure its adherence to the said edge of the inner layer as well as to the inner surface of the extension of the outer layer, applying a reinforcing strip internally against the extension of the outer layer in adherence therewith by reason of the remaining adhesive thereon and of a width to extend from the bottom member to the free edge of said extension, and inserting a removable oval template within the open end of the body and orienting the same by alining a mark at its edge, corresponding to the mark of the bottom member, with the joint of the inner body layer, and finally permitting the box to dry before removing said template.

2. The hereindescribed method of manufacturing a shaped oval waste or desk basket which consists in first utilizing body forming inner and outer layers of material of such length that the ends of each will abut when the layers are in circumjacent relation, the outer layer being somewhat wider than the inner layer so that it projects at one edge beyond the corresponding edge of the inner layer and forms an extension of a single layer, coating the inner surface of the outer layer including its said extension, with an adhesive, forming a generally cylindrical body with the two layers in closely adherent face to face relation and the abutting end joints staggered, applying a supplemental fastening to the abutting end joint of the outer layer, fitting a previously shaped oval bottom piece within the extension of the outer body layer and at the same time orienting said member by alining a mark at the edge thereof with the end joint of one of said body layers, pressing said bottom piece inwardly, axially of the body against the adjacent edge of the inner layer while the adhesive coating of the outer layer is sufficiently tacky for the edge of the base member to drag a portion of said adhesive therewith to insure its adherence to the said edge of the inner layer as well as the inner surface of the extension of the outer layer, and finally before drying, applying a removable oval template within the open end of the body and orienting the same by alining a mark at its edge, corresponding to the mark of the bottom piece, with the same body layer end joint as the bottom member.

3. The hereindescribed method of manufacturing a waste or desk basket which consists in forming a tubular body of inner and outer layers of cardboard material of which the outer layer is internally coated with adhesive and is extended at one end beyond the respective end of the inner layer to thereby expose a portion of its inner surface, applying a bottom piece, the circumference of which equals the inner circumference of the outer body layer, and then forcing the said bottom piece within the said extended portion of the outer layer and against the adjacent edge of the inner layer to thereby drag a portion of the adhesive coating with the edge of the bottom piece and insure its adherence with the said edge of the inner layer as well as the inner surface of the said extended portion of the outer layer.

LYNDE DE F. HOKERK.