

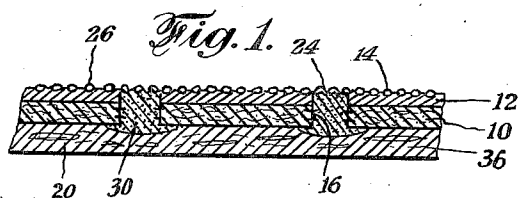
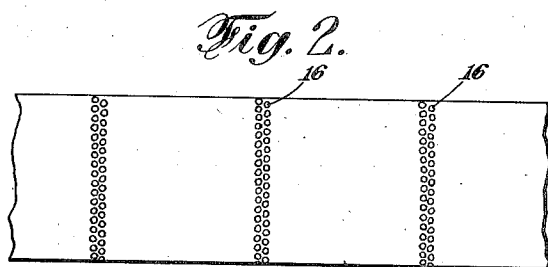
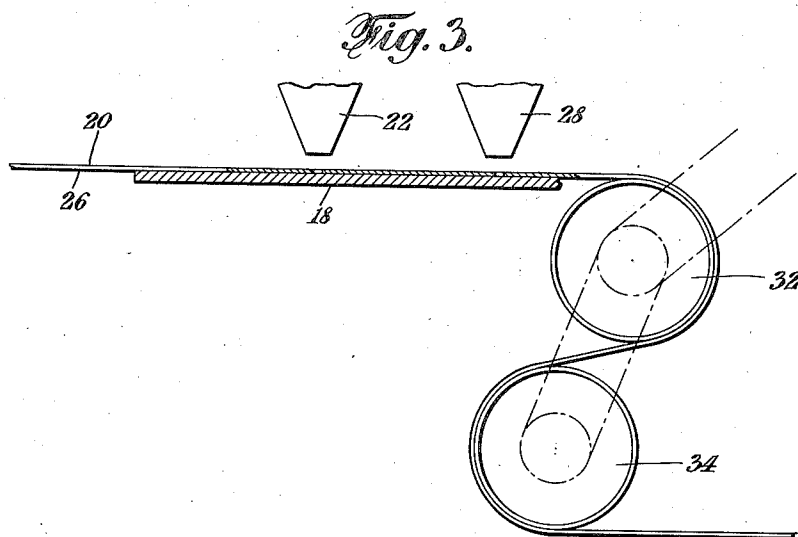
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ROOFING AND BUILDING MATERIAL AND CREATION OF EFFECTS THEREON

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ROOFING AND BUILDING MATERIAL AND
CREATION OF EFFECT THEREON

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16 Claims. (Cl. 154—2)

This invention relates to improvements in the method of producing varied effects upon building materials and is a division of my copending application Serial Number 443,603, filed April 11, 1930, which is now Patent 1,913,666, dated June 13, 1933.

It is one of the objects of this invention to provide an improved method of producing building material such as used for roofing and siding purposes, said method resulting in an article which is weatherproof, fireproof, durable and otherwise well adapted for building purposes.

A further object of this invention is to provide a novel method of producing building material by means of which various design effects and lines of demarcation can be created.

Another object of this invention is to provide roofing material in which portions of the web have been removed and in which the portions are filled with other material to form contrasting effects.

A still further object of this invention is to create sharp outlines of designs by perforating a sheet of roofing material and filling in from the back of the sheet mineral particles of a contrasting color from those on the face of the sheet.

With the above and other objects in view, the invention consists of the improved method and all its parts and combinations as set forth in the claims, and all equivalents thereof.

In the accompanying drawing in which the same reference numerals designate the same parts in all of the views:

Fig. 1 is a sectional view of a portion of material produced by the improved method,

Fig. 2 is a plan view of a strip of material constructed in accordance with the method illustrated in Fig. 1, and

Fig. 3 is a diagrammatic view of the apparatus used in producing the material shown in Fig. 1.

In carrying out the improved method, I utilize an ordinary web comprising a fibrous base 10 and apply to its surface an adhesive coating 12, for instance, a bituminous material. The adhesive coating is thereafter preferably covered with a layer of mineral surfacing 14, for instance, crushed slate. In order to create the design effects the web with or without the mineral surfacing is run through suitable means for forming a plurality of offset perforations 16 extending through the entire web. These perforations are made along desired lines or in desired areas to produce various effects. For instance, in Fig. 2 the lines extend transversely of the strip to create an effect of a plurality of individual shingles.

The perforations are preferably filled with material having an effect in contrast with that of the remainder of the surface. This may be accomplished conveniently by passing the perforated web, which has already been or is to be covered with a layer of mineral surfacing over a platform 18 with the back 20 of the web facing upwardly. Depending upon the surface desired on the material which fills the perforations, a hopper 22 may deposit into the perforations crushed mineral material 24 of a different color or other contrasting effect from that used or to be used on the face 26 of the web. Another hopper 28 may deposit a material 30 which may be a hydraulic cement, for instance, Portland cement, alone, or mixed with asbestos fibres or the like or a mixture of cement and an adhesive material, for instance, asphalt, into the perforations to hold the mineral material in place.

When desired, the separate deposition of the mineral particles may be omitted and the perforations may be filled from hopper 28 with the cement, etc., which may or may not contain the mineral particles.

The material may be pressed into place in any suitable manner, for instance, by passing around rollers 32 and 34 and an additional backing strip 36, preferably of material similar to that of the fibrous base 10 may be added to cover up the perforations.

If desired, at any suitable time, a coating of hydraulic cement may be applied over the surfaced side 26 in order to produce other pleasing effects.

It can be seen from the foregoing description that many different effects may be produced on the outer surface of the finished article and that many changes may be made in the article and process of making same. It is therefore desired that the invention be construed including equivalents and as broadly as the claims taken in conjunction with the prior art may allow.

I claim:

1. The method of producing building material comprising forming apertures in desired areas through a fibrous web, and filling said apertures from the side opposite the finished face of the web with a filler contrasting in appearance with said face and causing said filler to be interlocked with the fibres of said apertures.

2. The method of producing building material comprising forming apertures in desired areas through a fibrous web, filling said apertures from the side opposite the finished face of the web with a filler contrasting in appearance with

said face applying pressure to the filler in said apertures and interlocking said filler to the fibres adjacent the walls of said apertures.

3. The method of producing building material comprising forming apertures in desired areas through a fibrous web, filling said apertures from the side opposite the finished face of the web with a filler contrasting in appearance with said face and thereafter mounting the web on a base layer to cover the filler.

4. The method of producing building material comprising forming apertures in desired areas through a fibrous web, filling said apertures from the side opposite the finished face of the web with a filler contrasting in appearance with said face, pressing said filler in the apertures to anchor said filler to the fibres thereof and mounting the web on an additional sheet layer.

5. The method of producing building material comprising forming a plurality of perforations in desired areas through a fibrous composition sheet, feeding a substance which will contrast in appearance with the surface of the sheet into said perforation from the other side of said sheet and directly pressing said substance into position to cause anchorage thereof to the fibrous sheet.

6. The method of producing building material comprising forming a plurality of perforations in desired areas through a mineral surfaced fibrous sheet, feeding hydraulic cement into said perforations from the side opposite the surfaced side of the sheet and causing anchorage of the cement with the fibrous walls of said perforations.

7. The method of producing building material comprising forming a plurality of perforations in desired areas through a sheet of mineral surfaced saturated fabric moving said sheet with the side opposite the surfaced side uppermost and adjacent means for supplying hydraulic cement and feeding hydraulic cement into said perforations.

8. The method of producing building material comprising forming a plurality of perforations in desired areas through a sheet of mineral surfaced fibrous material, feeding into said perforations from the side opposite the surfaced side of the sheet, a mixture comprising hydraulic cement and an aggregate and causing anchorage of said mixture with the fibres in said perforations.

9. The method of producing building material comprising forming a plurality of perforations in desired areas through a sheet of mineral surfaced saturated composition material, feeding into said perforations from the side opposite its surfaced face mineral particles which will contrast in appearance with the surfaced face, and applying from the same side a binding substance to hold said particles in position.

10. The method of producing building material comprising forming a plurality of perfora-

tions in desired areas through mineral surfaced saturated composition sheet, feeding into said perforations from the side opposite its surfaced face mineral particles which will contrast in appearance with the surfaced face, and applying from the same side a binding substance to hold said particles in position, and mounting the sheet on a base layer.

11. The method of producing building material comprising forming a plurality of perforations in desired areas through a sheet of mineral surfaced saturated fabric, inserting crushed mineral of a different color from that used for surfacing the fabric in the rear of said perforations, and applying a binding substance to the rear of the perforations to hold the crushed mineral in position.

12. The method of producing building material comprising forming a plurality of perforations in desired areas through a sheet of mineral surfaced saturated fabric, inserting crushed mineral material of a different color from that used for surfacing the fabric in the rear of said perforations, applying a binding substance to the rear of the perforations to hold the crushed mineral in position, and mounting the material on an additional sheet of fabric to close the perforations.

13. The method of producing building material comprising forming a plurality of perforations in desired areas through a sheet of mineral surfaced saturated fabric feeding into said perforations from a side of the sheet, a material contrasting in appearance with the face of the sheet and applying pressure to said material from the same side and causing anchorage thereof to the sheet.

14. The method of producing building material comprising forming a plurality of perforations in desired areas through a sheet of mineral surfaced saturated fabric, feeding hydraulic cement into said perforations and anchoring said cement to the fabric wall of said perforations.

15. The method of producing designs on building material comprising forming a plurality of perforations in desired areas through a fibrous sheet feeding a filler of contrasting effect to the sheet in the perforations and causing interlocking thereof with the fibrous walls of said perforations.

16. A method of making building material comprising the steps of applying an adhesive layer to a fibrous base, applying a surface roughening material, forming a plurality of perforations in desired areas, filling said perforations from the side opposite the surfaced face with a material contrasting in appearance with said surfaced face and pressing said material into position and interlocking said material with the fibres of said perforations.

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