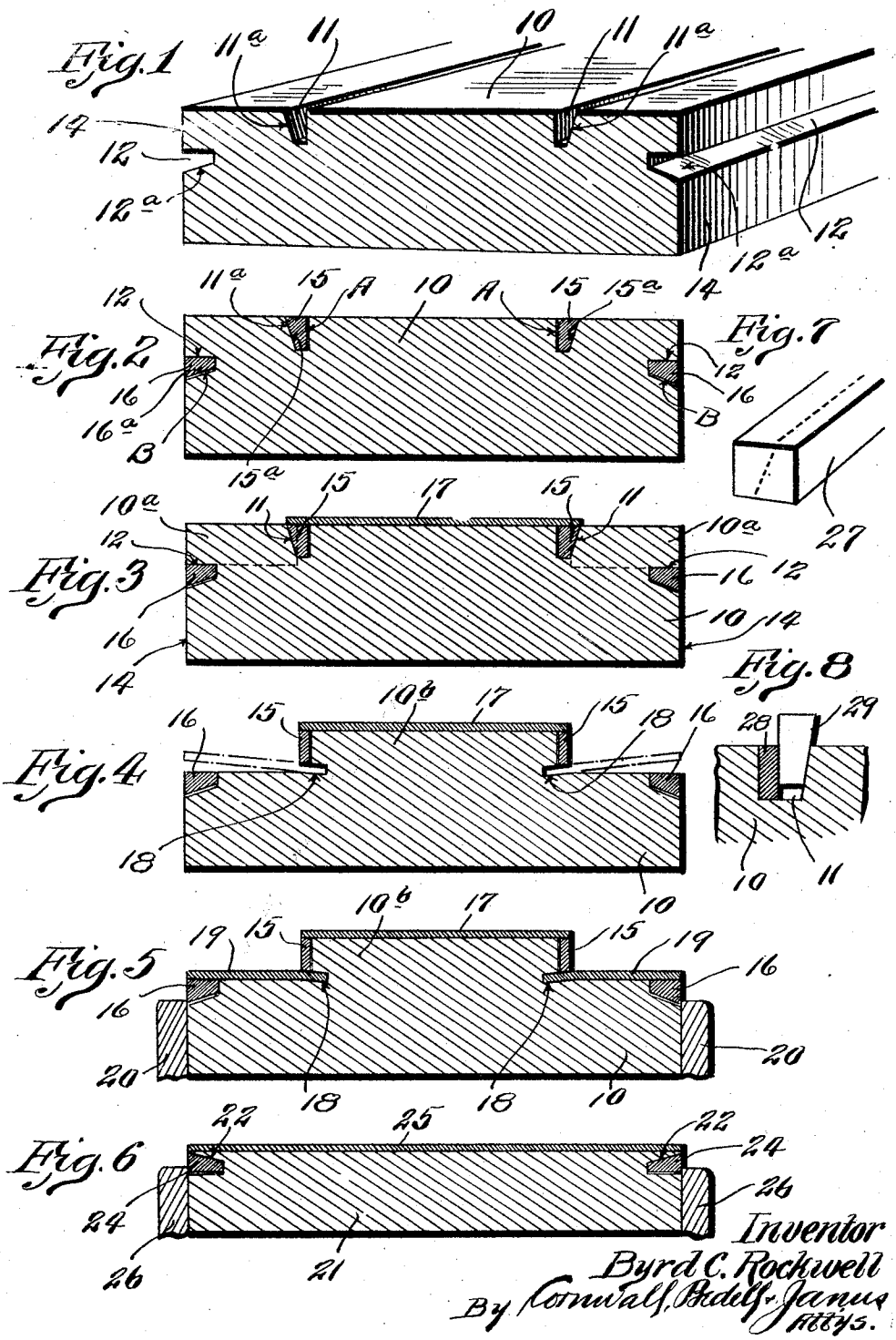
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METHOD OF MANUFACTURING VENEERED LUMBER

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METHOD OF MANUFACTURING VENEERED LUMBER.

Application filed January 30, 1924. Serial No. 689,508.

To all whom it may concern:

Be it known that I, BYRD C. ROCKWELL, a citizen of the United States, residing at St. Joseph, Missouri, have invented a certain new and useful Improvement in Methods of Manufacturing Veneered Lumber, of which the following is a specification, such as will enable others skilled in the art to which it appertains to make and use the same.

This invention relates generally to an improved method of manufacturing veneered lumber and more particularly to the method of manufacturing veneered door jambs.

The objects of the invention are to provide veneered door jambs and the like which are durable, can be manufactured at low cost and have the appearance of the more expensive door jambs made of solid high grade lumber, and to provide a method of manufacturing said door jambs, which method can be easily practiced and is highly efficient.

Further objects of the invention are to provide a method of manufacturing veneered lumber wherein to a core or body portion of low grade lumber are applied veneer sections of high grade lumber and the whole is then properly finished or dressed so as to leave clear veneer edge portions and a finished veneer face portion or portions.

Still further objects of the invention are to provide an improved method of manufacturing veneered lumber consisting in forming grooves in the face and edges of a core or body portion of low grade lumber, inserting in said grooves veneer strips of high grade material, one of the walls of each groove being formed beveled whereby the glue face of the veneer strip is wedged and held under pressure against the glue wall of the groove, applying a veneer face section to the face portion of said core body, and then dressing the composite lumber so as to finish and leave exposed said veneer edge strips and said face veneer portion.

With these and other objects in view, my invention consists in certain novel features of construction and arrangement of parts, hereinafter more fully described and claimed, and illustrated in the accompanying drawings, in which—

Figure 1 is a perspective detail view of a core or body portion of low grade material with the grooves formed longitudinally in the face and edges thereof.

Figure 2 is a cross section showing the veneer edge strips glued in position in said grooves.

Figure 3 is a similar view showing the door stop face veneer section secured in position thereon.

Figure 4 shows the core body channeled or rabbeted at its edges and the door stop veneer edge strips and veneer face section dressed.

Figure 5 is a cross section through the completed door jamb and showing the veneer face sections applied to the rabbeted portions of the core body.

Figure 6 is a detail view of a modified form of door jamb.

Figure 7 is a perspective detail view showing how the edge veneer strips are made.

Figure 8 is a detail view showing a modified method of securing the edge veneer strips in position.

The present invention relates particularly to the manufacture of door jambs and it is the purpose of the invention to provide a method whereby door jambs can be manufactured out of stock of inferior grade of lumber and have their face portions and the exposed portions of their edges finished with veneer material of high grade lumber.

Referring by numerals to the accompanying drawings, 10 indicates a body or core section of the door jambs formed of sound lumber of inferior grade. The face and edges of this core section are provided with grooves 11 and 12, respectively, which are longitudinally formed therein. Grooves 11 are spaced a suitable distance from the edges 14 of the core section and their outer walls are formed sloping inwardly and downwardly as indicated at 11^a. Grooves 12 are spaced a suitable distance inwardly from the face of the core section and their walls remote from said face are formed sloping inwardly as indicated at 12^a.

Veneer edge strips 15 are placed in grooves 11 and are secured therein by a suitable adhesive applied to the straight or inner sides of said strips and to the inner walls of said grooves as indicated at A. These strips are preferably formed wedge shaped having in-

clined sides 15ª which are designed to co-operate with the sloping walls 11ª of grooves 11. Thus when the strips are placed in their respective grooves the wedging co-action of the inclined walls 11ª and sides 15ª forces under pressure the glue faces of the strips in close contact with the glue walls of the grooves, thereby forming a secure and neat joint.

In a similar manner veneer edge strips 16 are secured in positions in grooves 12 formed in the edges 14 but in this case the glue is applied to the sloping faces 16ª of strips 16 and the inclined walls 12ª of grooves 12 as indicated at B. A door stop face veneer section 17 is now applied by a suitable adhesive to the face of core section 10, said face veneer section extending between the strips 15 and having its side edges terminating flush with the outer edges of said strips as indicated in Figure 3. The remaining portions 10ª of the face of said core member are now removed by channeling or rabbeting as indicated in dotted lines in Figure 3. The depth of these channels is arranged so as to remove sufficient material from the edges of said core body so as to form a door stop 10ᵇ and expose the unglued faces of edge strips 16 as shown in Figure 4. In width the channels extend inwardly a sufficient distance to permit the dressing or finishing of the unglued inclined faces of the face strips 15 and of the edges of the face veneer section 17 as shown in Figure 4. Thus the door stop portion 10ᵇ is provided on its face with a face veneer section 17 while the edges of said door stop portion have secured thereto the dressed portions of face strips 15.

In rabbeting the core body 10, undercut grooves 18 are formed below face strips 15. These grooves extend inwardly and are slightly inclined downwardly and serve to receive the inner edges of the jamb face veneer sections 19 which are glued to the faces of the rabbeted portions as shown in Figure 5 and have their outer edges overlying the edge strips 16 and terminate flush with the outer face thereof. These outer faces, as well as the outer edges of said veneer sections 19, are then dressed and finished in proper manner.

Finishing strips 20 may now be applied to the edges of the core section so as to cover the exposed portions of said core member, the edges and side finishing strips adjoining the outwardly presented faces of edge strips 16 as shown in Figure 5.

In Figure 6 the door jamb is shown without the door stop portion. The core member 21 is provided with grooves 22 in its edges adjacent to its face, in which grooves are secured edge strips 24. A face veneer strip 25 is then applied to the face of said core member and finishing strips 26 are secured to the edges of said core member with their outer edges arranged adjacent to the outwardly presented faces of edge strips 22.

In Figure 7 a section of high grade material 27 is shown which is cut diagonally along the dotted line to form the wedge-shaped veneer strips.

In Figure 8 the veneer edge strips 28 instead of being formed wedge-shape in cross section are formed rectangular and are secured in position in the grooves of the core member 10 by means of removable wedges 29. This modified method is particularly desirable where it is desired to avoid waste incidental to dressing the veneer strips and the face portion of the core member.

I claim:

1. The method of manufacturing veneered lumber consisting of forming longitudinally disposed grooves in a core body of low grade lumber, gluing finishing veneer strips in said grooves to form the exposed edges of the veneered lumber, and applying a face veneer section to the face of said core body with the side edges of said face veneer section flush with the outer faces of said veneer strips.

2. The method of manufacturing veneered lumber consisting in forming longitudinal grooves in a core section of low grade lumber, securing therein veneer strips of finishing material, securing a veneer face portion to the face of said core body with the edges of said face veneer section adjoining said veneer strips.

3. The method of manufacturing veneered lumber consisting in forming longitudinal grooves in a core section of low grade lumber, securing therein veneer strips of finishing material, securing a veneer face portion to the face of said core body with the edges of said face veneer section adjoining said veneer strips, and dressing the veneer portions of the finished lumber.

4. The method of manufacturing veneered lumber consisting in forming longitudinally disposed grooves in the walls of a core member, securing veneer strips of finishing lumber in said grooves, applying a face veneer section of finishing lumber to said core body, the edges of said face veneer section being arranged adjacent to the outer faces of said veneer strips.

5. The method of manufacturing veneered lumber consisting in forming longitudinal grooves in the face and the edges of a core body of inferior lumber, applying veneer strips of finishing lumber in said grooves, rabbeting the sides of said core body, said rabbeted portions being co-extensive with the veneer strips arranged in the face and sides of said core body and applying face veneer sections to said core body, the edges of said face veneer sections overlying the edges of the respective veneer strips.

6. The method of manufacturing veneered lumber consisting in forming longitudinal grooves in the face and sides of a core body, securing veneer edge strips in said grooves, applying a veneer section to a portion of the face of said core body, rabbeting the remaining portions of the face of said core body, said rabbeted portions extending adjacent to the respective veneer edge strips, and applying face veneer sections to the rabbeted portions of said core body.

7. The method of manufacturing veneered lumber consisting in forming longitudinal grooves in the face and the edges of a core body, each of said grooves having an inwardly inclined wall, gluing veneer edge strips in said grooves, said strips being placed under pressure during the gluing process by virtue of the inclined walls of said grooves, and applying a face veneer section to the face of said core body.

8. The method of manufacturing veneered lumber consisting in forming longitudinal grooves in the face and edges of a core body of low grade lumber, securing veneer edge strips in said grooves, applying a face veneer section to a portion of the face of said core body, said veneer section being co-extensive with the veneer strips arranged in the face of said core body, rabbeting the remaining face portions of said core body, said rabbeted portions extending adjacent to said veneer strips, and applying face veneer sections to the faces of the rabbeted portions of said core body, there being undercut grooves formed in said core body to receive the inner edges of the last mentioned face veneer sections.

In testimony whereof I hereunto affix my signature this 21st day of January, 1924.

BYRD C. ROCKWELL.