

Oct. 2, 1951

T. H. RYALL

2,569,831

METHOD OF MAKING BEVELLED SIDING

Filed Nov. 19, 1949

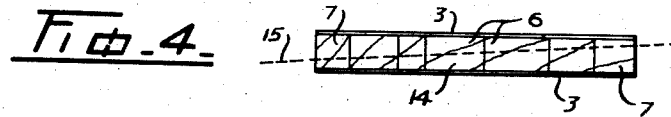


Fig. 2.

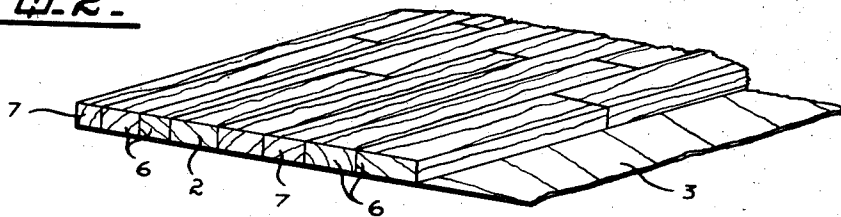


Fig. 3.

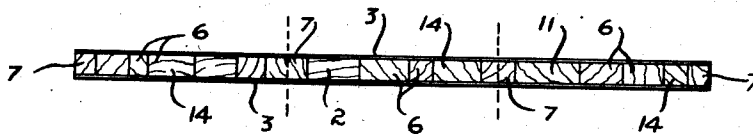


Fig. 6.

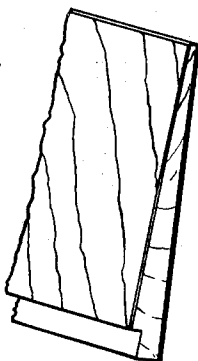


Fig. 1.

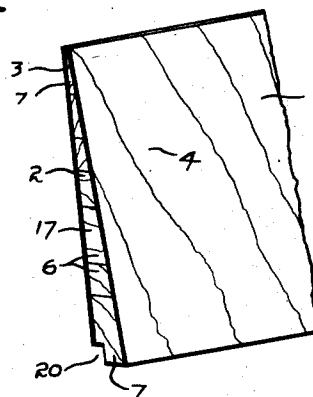
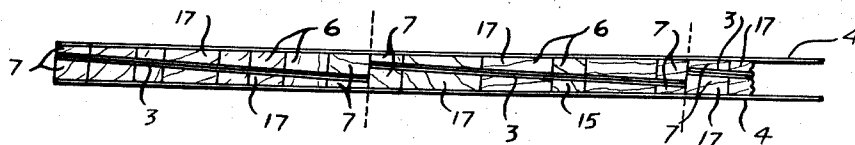


Fig. 5.



INVENTOR  
THOMAS HERBERT RYALL

*James O. Carter*  
ATTORNEY

## UNITED STATES PATENT OFFICE

2,569,831

## METHOD OF MAKING BEVELLED SIDING

Thomas Herbert Ryall, New Westminster, British  
Columbia, Canada

Application November 19, 1949, Serial No. 128,375

4 Claims. (Cl. 154—118)

1

2

My invention relates to improvements in bevelled siding and method of producing same.

The most popular siding for houses and other buildings is produced from cedar and it is an essential that the exposure face of the siding shall be of clear or high grade lumber. With the heavy demand for cedar and the rapid depletion of the forests, it is becoming very difficult and economically impossible to meet the demands of the trade for high grade cedar siding made in the conventional way. Even with high grade lumber it is not possible to provide a siding which is wholly free from transverse warpage, causing a concave depression to develop along the exposure face of some of the boards, either before or shortly after erecting in the building.

The invention is designed to provide a siding with a core formed of cheap lumber and having two face plies of veneer cross banded upon the core. The face plies of the contemplated veneer are preferably of cedar of high and medium quality, the outer exposure ply being free from imperfections and the backing of medium quality stock, so that the cost of the raw material may be very considerably less than that necessary in the manufacture of the conventional product. A further object is to provide against checking longitudinally of the grain of siding of greater width than eight inches. A still further object is to provide a means for manufacturing a siding as a plywood structure wherein the gluing operations can be carried out in standard presses and the glue line set by any desired process.

Referring to the drawings:

Figure 1 is a perspective view of a piece of bevelled siding made according to the invention.

Figure 2 is a perspective view showing a core being applied to a veneer sheet.

Figure 3 is a perspective view showing a completed panel from which the bases of a plurality of lengths of siding are to be cut.

Figure 4 is an end elevational view of a board preparatory to resawing.

Figure 5 is an end elevational view of a plurality of boards to which are collectively applied the backing veneer.

Figure 6 is a perspective view of a modified form of the invention.

In the drawings like characters of reference indicate corresponding parts in each figure.

The numeral 1 indicates a piece of siding, see Figure 1, which consists of a core 2 to which is secured a backing veneer 3 and a face veneer 4. The core is formed of strips 6 and 7, which are

preferably rectangular in cross section and are of unequal length to provide for appropriate breaking of the end joints, as shown in Figure 2. The strips 6 may be of common stock, but the strip 7 should be a better grade of lumber since they will be in part exposed in the finished siding.

In the process of manufacturing, a sheet of backing veneer 3 is laid down as a base for the structure and the grain of said backing veneer is preferably vertical to the lower edge of the siding. Each sheet of veneer 3 is of a width of a predetermined number of pieces of siding 1, as for instance, to make up a panel 11 to be cut into four pieces of siding blanks of eight inch width, would require the veneer to be thirty-two inches in width and of a length equal to the desired length of the siding, for instance, say sixteen feet. Glue is applied to the core in any appropriate manner and the core strips 6 and 7 are laid down upon the backing veneer, said core extending the length of the veneer. The strips 6 and 7 are so spaced that at each side edge of the veneer a strip 7 is laid and at every eight inches of the width of the veneer, assuming the finished siding to be eight inches, another strip 7 is centred. When all the strips are laid in side by side abutting relation, a second backing veneer sheet 3 is applied thereto with glue and the panel 11 is subjected to appropriate heat and pressure to set the glue. Obviously any other suitable means may be used for bonding the parts together. The panel 11 is then cut longitudinally along the centre of the inner strips 7 as indicated in dotted line in Figure 3, making narrow panels 14 as shown in Figure 4. The narrow panels 14 are then cut diagonally along the dotted line 15 of Figure 4, to form battered two ply boards 17, these boards are then turned over and put together in pairs with their backing veneer 3 in contact with each other and with their sawn faces spaced apart and parallel to each other. The stacks of pairs of boards 17 are arranged side by side as shown in Figure 5 and are applied by gluing to a sheet of face veneer 4 and a second sheet of face veneer is secured to the upper surface of the assembled boards. The panel so formed is placed in the press and the glue set, then on removal from the press the face veneers 4 are sawn longitudinally at the joints shown in dotted line in Figure 5, when the process is completed.

If desired, the lower edge of each piece of siding is rebated as at 20, Figure 1, to provide an overlap of one piece of siding over the upper edge of the piece next below.

While the backing veneer is here described as

applied as a primary operation, it will be understood that it may equally well be applied as the final gluing operation.

It will be obvious that the core may be made from a single board of rectangular cross section and the core divided as before described.

What I claim as my invention is:

1. The method of making bevelled siding which consists of forming a core of lengths of relatively rectangular material laid in side by side relation, applying a veneer to opposite faces of the core and dividing the core diagonally edgewise between the veneers and applying a second veneer to the faces formed by dividing the core.

2. The method of making bevelled siding which consists of forming a core having a narrow edge and a wider edge, said core being formed with lengths of relatively narrow material laid in side by side relation and securing veneer to opposite surfaces of the core by adhesive.

3. The method of making bevelled siding which consists of applying to a length of veneer a core formed of a plurality of strips of narrow cross sectionally rectangular material laid in side by side relation, applying a second veneer to the core so made, dividing the core lengthwise by sawing diagonally between the veneers, separating the units so made and applying a further veneer to the sawn faces of the divided core pieces.

4. The method of making bevelled siding which consists of applying to a sheet of veneer of a width at least twice the width of the finished siding to be produced a plurality of cross sectionally rectangular strips laid lengthwise of said

sheet and in side by side relation to form a core, covering the core with a sheet of veneer of substantially the same area as the first named sheet to produce a laminated panel, sawing said panel into bases substantially equal in width to the siding to be made, sawing each of the bases diagonally between the veneers to produce a pair of siding bases, applying to a third sheet of veneer a plurality of siding bases laid side by side with the sawn faces of the bases in contact with said third veneer sheet, stacking on the previously veneered side of each of the bases so placed a second siding base with its sawn face uppermost to form stacks of bases, said stacked bases being laid with their sawn faces in a plane parallel to the third sheet of veneer, applying a fourth sheet of veneer onto the upper face of the stacked siding bases and cutting said third and fourth veneer sheets along the line intersecting the stacks of siding bases.

THOMAS HERBERT RYALL.

#### REFERENCES CITED

The following references are of record in the file of this patent:

#### UNITED STATES PATENTS

| Number    | Name      | Date          |
|-----------|-----------|---------------|
| 808,998   | Loetscher | Jan. 2, 1906  |
| 1,444,611 | Johansson | Feb. 6, 1923  |
| 1,976,171 | Hutchings | Oct. 9, 1934  |
| 2,232,075 | Nevin     | Feb. 18, 1941 |
| 2,291,650 | Robinson  | Aug. 4, 1942  |
| 2,390,087 | Fink      | Dec. 4, 1945  |