

Oct. 31, 1933.

B. S. VAUGHAN

1,933,232

FABRICATED TABLE AND METHOD OF MAKING THE SAME

Filed March 9, 1931.

2 Sheets-Sheet 1

Fig. 1

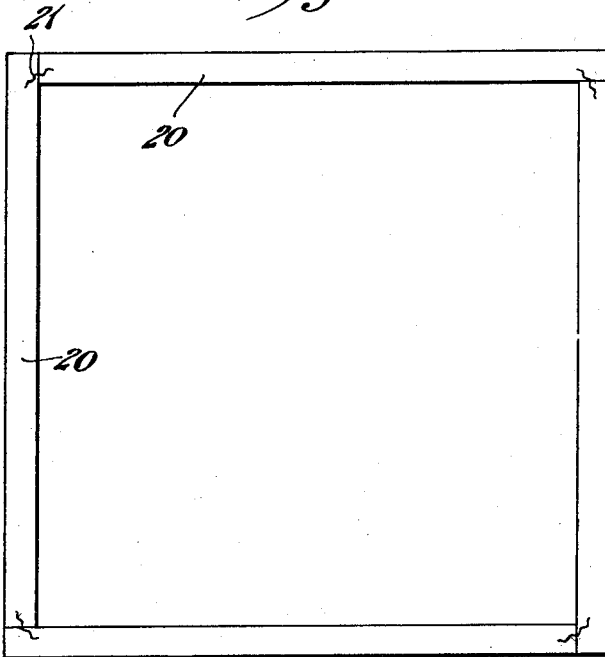


Fig. 3

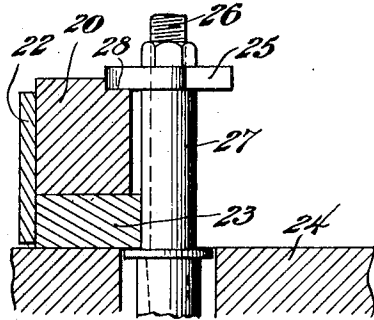


Fig. 2

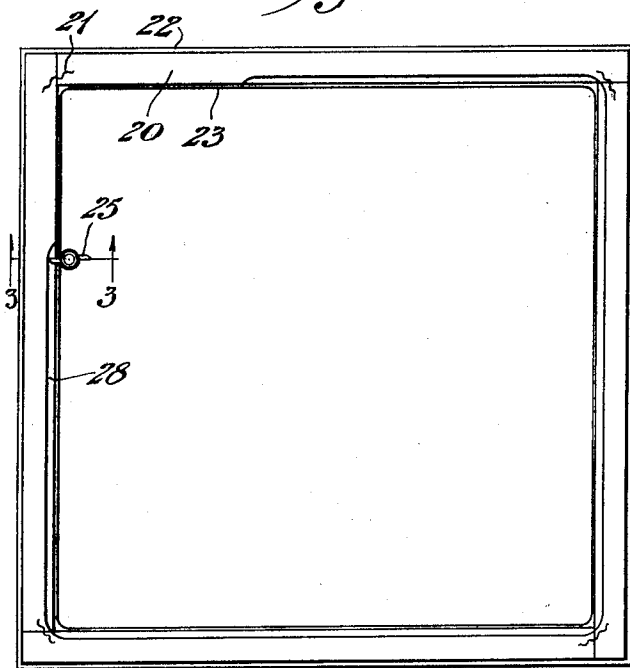
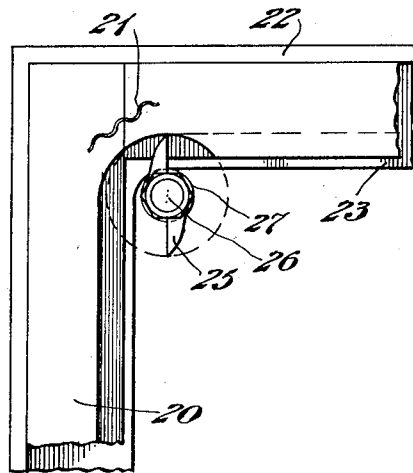


Fig. 4



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2 Sheets-Sheet 2

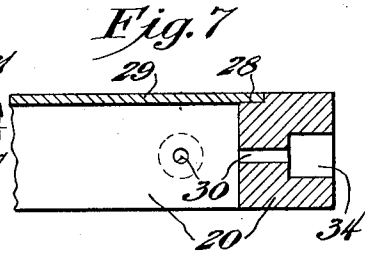
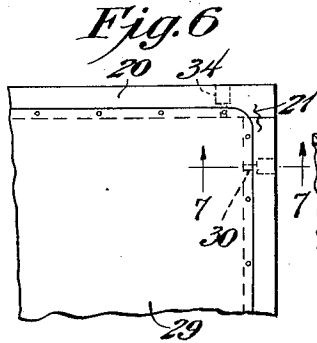
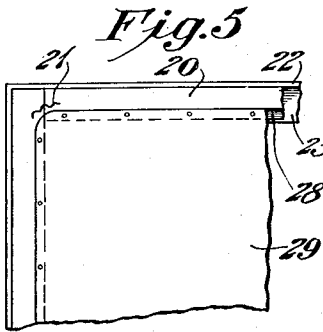


Fig. 8

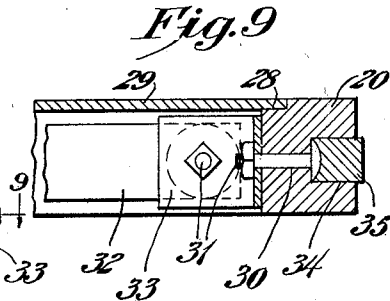
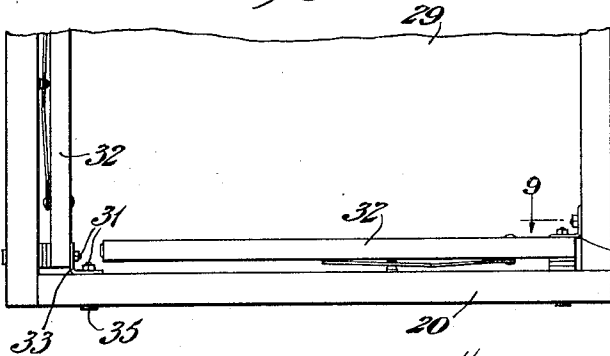


Fig. 9

Fig. 10

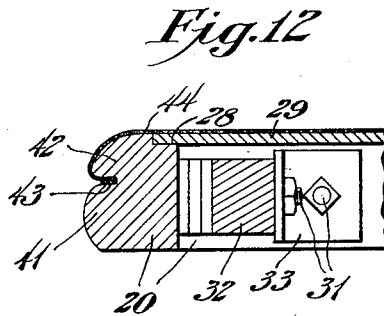
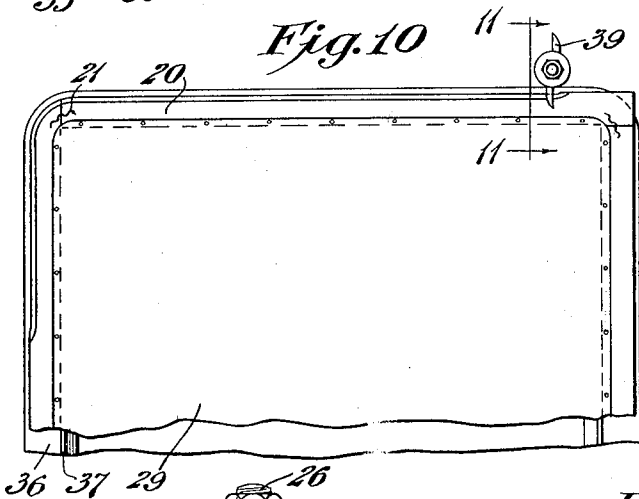
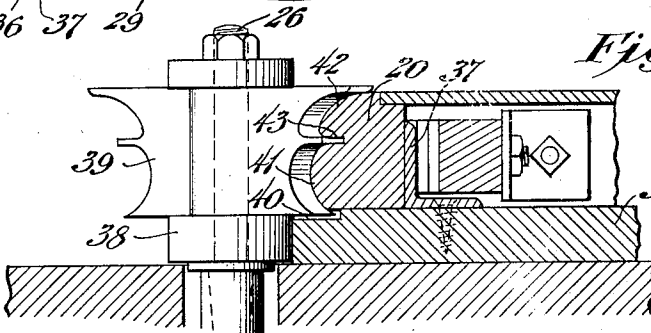


Fig. 12

Fig. 11



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FABRICATED TABLE AND METHOD OF MAKING THE SAME

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Application March 9, 1931. Serial No. 521,304

7 Claims. (Cl. 144-309)

This invention relates to card tables and the like and aims, among other objects, to provide an improved fabricated table top as well as a new method of making it so as to lower the cost of production and produce a better finish of exposed wood parts.

Other aims and advantages of the invention will appear in the specification when considered in connection with the accompanying drawings, wherein:

Fig. 1 is a plan view of a table top frame and illustrating the first step of the improved method;

Fig. 2 is a top plan view showing a rabbet being formed around the inside of the frame;

Fig. 3 is a section taken on the line 3-3 of Fig. 2, and drawn on a larger scale;

Fig. 4 is a fragmentary plan view on a larger scale than Fig. 2 and showing the rabbet being cut at a corner of the frame;

Fig. 5 is a fragmentary top plan view showing a top board applied to the frame;

Fig. 6 is a fragmentary top plan view showing bolt holes adjacent to one corner of the frame;

Fig. 7 is an enlarged sectional view taken on the line 7-7 of Fig. 6;

Fig. 8 is a fragmentary bottom plan view showing hinged legs secured to the frame;

Fig. 9 is an enlarged sectional view taken on the line 9-9 of Fig. 8;

Fig. 10 is a fragmentary top plan view showing the process of forming a molded or shaped outer edge;

Fig. 11 is an enlarged sectional view taken on the line 11-11 of Fig. 10; and

Fig. 12 is a fragmentary sectional view showing a covering applied to the top.

In the manufacture of card table tops having wooden frames, it has been the custom to shape the frame pieces before they are assembled and to secure them together at their corners. Many frames have mitre joints which have to be fitted very carefully. In either case, the joints are not well made and frequently the frame members are bowed so that the finished tables are imperfect. Moreover, the old methods involved a great many more or less costly operations which limit production. This invention aims to provide a new method of making improved, fabricated table tops whereby they will present a uniform finish without any defective corner joints.

In the drawings, successive steps in the process of making a card table top are illustrated. In Fig. 1, plain wooden frame pieces 20 having squared ends are suitably secured together at the corners preferably by means of corrugated nails

21 near the insides. The joints are all lapped in the same direction so that the grain of the wood is substantially continuous around the frame.

The assembled frame pieces are next placed in a template having vertical flanges 22 and base flanges 23 which are a little wider than the frame pieces and present straight inside edges having rounded corners. The template carrying the frame is placed on the table 24 of a shaper carried in a rotary cutter 25 on a vertical spindle 26. The cutter is secured against the end of a spacer sleeve 27 of the proper height to enable it to cut a rabbet 28 around the inner edge of the frame. The inside edges of the template parts 23 bear against the sleeve 27 as the frame is moved about the cutter in a counter-clockwise direction (Fig. 4) to make the rabbet in one continuous operation. At the corners, the rabbet is rounded on the same center of curvature as the curved corner portions of the template part 23.

While the frame is still in the template, the table top 29 made of pulp board, ply-wood or other suitable material is fitted in the rabbet and nailed or screwed down, as shown in Fig. 5. The upper face of the top is preferably flush with the upper faces of the frame. The frame is thus rigidly braced so that it can be removed from the template without being racked or distorted due to bending strains.

The frame is next removed from the template and holes 30 are drilled or bored in the side frame members near the corners to receive rivets or bolts 31 for securing folding legs 32 inside of the frame. However, it may be desirable in some instances, to bore the holes before the frame is assembled in the first template. Herein, the legs are similar to those disclosed in my Patent 1,705,047. One of the bolts 31 passes through a leg and through the flange of an angle bracket which is secured to the inner face of one of the side frame members for the other bolt. In this example, the side frames have counter-bores to receive the rivet or bolt heads and, after the bolts are inserted, the counter-bores are plugged up with wooden plugs 35 (Fig. 9).

After the legs are applied and the plugs are inserted in the counter-bores, the legs are all folded and the table is set on another template consisting of a base frame 36 and upstanding flanges 37 secured thereto and arranged to engage the inside faces of the frame members 20. These flanges are not continuous, but are interrupted or cut away so as not to interfere with the leg bolts and brackets.

Referring to Fig. 11, the base members 36 of the template extend slightly beyond the outer edges of the side frame members and have straight edges with rounded corners to engage a spacer sleeve 38 for the double molding cutter 39 secured to the shaper spindle 26 in the same manner as was the rabbeting cutter 25. In this instance, the outer edges of the template members 36 have rabbets 40 on their upper faces to provide adequate clearance for the cutter to do its work on the outer edges of the table frame.

The cutter 39 is specially shaped to produce a compound molded edge around the table frame. Referring to Figs. 11 and 12, it will be observed that a bottom portion 41 of the mold is somewhat wider than upper portion 42. The upper portion is cut back and rounded on a relatively large radius so as to merge into the top surface of the table. In the process of cutting the compound mold, which may be of any suitable shape, the table is turned in a counter-clockwise direction so as to avoid having the cutters cut across the grain in the ends of the side frame members. The two parts 41 and 42 are separated by a kerf 43 to receive the selvages of a cover 44 made of suitable material, the edges being forced into the kerf by means of a tool or instrument. If desired, a piece of wire may be used.

In Fig. 12, a small sectional view of a finished table is illustrated. It will be observed that the lower portion 41 of the compound molded edge projects beyond the other portion 42 of the mold and beyond the cloth cover. This enables the table to be stood on its edge on a floor and dragged or slid about without damaging the cover, as the exposed portion will withstand the wear. Thus, a covered table top of this type will last for a considerable period without being torn by abrasion or rubbing on the floor.

From all of the foregoing description, it will be seen that the process of assembling composite table tops and folding legs is greatly simplified. The operations may be performed in a fraction of the time required to perform the old and well known operations necessary in making mitre joint frames and assembling the tops on them. Furthermore, the corner portions of the tables are all uniform and present the same molded edges as the side portions. There are no sharp corners to injure delicate fabrics of ladies' garments. Furthermore, the complete assembly is very strong because all of the parts are accurately cut and fitted.

Having thus described the preferred steps in practicing the method and a table top produced thereby, it is to be understood that the invention is not limited by the particular description thereof. Therefore, the appended claims are not to be construed as being strictly limited to the particular disclosure.

What is claimed is:

1. That method of making composite table tops which is characterized by joining plain wooden pieces at their ends to form a frame; setting the frame in a template; producing a continuous rabbet around the inside of the frame at the top while it is in the template; securing a top within the rabbet; setting the frame and top in another template; and shaping a continuous mold around the outer edges of the frame members.

2. That method of making composite table tops which is characterized by joining plain wooden pieces at their ends to form a frame; setting the frame in a template; producing a continuous rabbet around the inside of the frame at the top while it is in the template; securing a top within the rabbet; setting the frame and top in another template; shaping a continuous mold and groove on the outer edges of the frame members; and securing the edges of a flexible top cover in the groove.

3. That method of making composite table tops which is characterized by joining plain wooden pieces at their ends with lap joints to form a frame, the joints overlapping in the same direction around the frame; setting the frame in a template; producing a continuous rabbet around the inside of the frame at the top while it is in the template; securing a top within the rabbet; setting the frame and top in another template; and shaping a continuous mold around the outer edges of the frame members.

4. That method of making composite table tops which is characterized by joining plain wooden pieces at their ends to form a frame; setting the frame in a template having a guiding inner edge; placing the template on a shaper table and guiding it to move about a rabbet cutter to produce a rabbet on the inner edge of the frame; securing a top board to the frame within the rabbet; and, subsequently, shaping the outer edges of the frame to produce a mold.

5. That method of making table tops which is characterized by assembling a frame of plain side rails having lap joints at the ends with ends overlapping in the same direction around the frame; forming a continuous rabbet on the inside of the top portion of the frame by means of a shaper; inlaying a top board in the rabbet; and producing a continuous molded outside edge having rounded corner portions by holding the frame against a revolving shaper cutter and rotating the frame continuously in one direction.

6. That method of making table tops which is characterized by assembling a frame of plain side rails having lap joints at the ends with ends overlapping the same direction around the frame; forming a continuous rabbet on the inside of the top portion of the frame by means of a shaper; securing a top board in the rabbet; setting the frame and top on a template and cutting a continuous double mold and groove on the outside edges of the frame members in one operation; and securing a flexible cover on the top and to the side edges in said continuous groove.

7. That method of making card tables which is characterized by assembling plain wooden side frame members; cutting a rabbet on the inside edges of the assembled frame in one operation; securing a top board in the rabbet; drilling counter-bored bolt holes through the frame adjacent to the corners; securing folding legs to the inside of the frame by means of bolts passing through said openings; plugging up the counter-bores of the bolt holes; folding the legs in the frame; producing a continuous mold and groove on the outer edges of the frame members in one operation; applying a top covering to the table; and securing its edges in said groove.

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