E. STUCK.

METHOD OF FORMING THE SHEET METAL BARRELS OF WINDING ROLLERS.

APPLICATION FILED MAY 29, 1913.

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Fig. 1.

Fig. 2.

Fig. 3.

Fig. 4.

Fig. 5.

Witnesses:

Ernest Stuck,

Inventor

Attorneys

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UNITED STATES PATENT OFFICE.

EVERETT STUCK, OF SYRACUSE, NEW YORK, ASSIGNEE TO OLIVER M. EDWARDS, OF
SYRACUSE, NEW YORK.

METHOD OF FORMING THE SHEET-METAL BARRELS OF WINDING-ROLLERS.


Application filed May 29, 1913. Serial No. 770,612.

To all whom it may concern:

Be it known that I, EVERETT STUCK, of Syracuse, in the county of Onondaga and State of New York, have invented a certain

new and useful Method of Forming the Sheet-Metal Barrels of Winding-Rollers, of which the following is a specification.

This invention relates to winding rollers and has for its object a method for forming the sheet metal barrels thereof; and it consists in the steps hereinafter set forth and claimed.

In describing this invention reference is had to the accompanying drawing in which like numerals designate corresponding parts in all the views.

Figure 1, is a perspective view, partly broken away of a roller constructed in accordance with my invention.

Figs. 2, 3, and 4 are detail views illustrating the operations used in forming the sheet metal barrel of my roller.

Fig. 5 illustrates the barrel in cross-section.

This winding roller comprises a sheet metal barrel 1 which is formed up out of a strip 2, having a lengthwise corrugation 3, extending into the barrel, the corrugation being located between the side edges of the strip and arranged to form an external peripheral channel. The edges of the strip are united when the strip is rolled into cylindrical form.

In the illustrated form of my invention, the corrugation is in the form of a loop in cross-section and one side, as 4, of the corrugation 3, is formed higher than the opposite side, as shown in Fig. 2, and the upper margin of the higher side, that is the margin at the base of the higher side of the loop, together with the portion of the strip, adjacent said base are compressed into position to overhang the bottom of the channel formed by the corrugation, as shown in Fig. 3, thereby forming a contracted entrance 5, for the channel which entrance is substantially flush with periphery of the barrel as seen in Figs. 4 and 5.

After the channel with its contracted entrance has been formed, the portions or flanges of the strip on opposite sides of the corrugation are rolled arcuate and the meeting edges 6, 7 thereof united in any suitable manner, as by the lock seam joint 8.

Usually a flat blank is corrugated with one side of the corrugation higher than the other as illustrated in Fig. 2 and a rod 9 is laid in the corrugation and the wall of the higher side of the corrugation rolled into the position shown in Fig. 3 to form the contracted entrance. The rod is then removed, and the strip rolled into cylindrical form and the meeting side edges of the strip united.

The channel formed by the corrugation is for the purpose of holding connecting pieces to which are attached chains, cords, or other means for connecting a window or curtain to the roller, as will be understood by those skilled in the art. Heretofore the channel or corrugation has been formed at the meeting edges of the side of the strip, but a roller constructed as herein described is more easily and economically manufactured.

What I claim is:

1. The method of forming the sheet metal barrels of winding rollers from flat strips comprising, forming the strip with a lengthwise corrugation, one side of which is higher than the other side, compressing the high side of the corrugation together with the adjacent portion of the strip, toward the other side of the corrugation so that a channel is formed, the entrance of such channel formed by the corrugation, being contracted and flush with the outer face of the strip, rolling the portions of the strip on opposite sides of the corrugation into cylindrical form, and uniting the meeting edges thereof, substantially as and for the purpose set forth.

2. The method of forming the sheet metal barrels of winding rollers from flat strips comprising forming the strip with a lengthwise corrugation, one side of which is higher than the other side and also bending the side margins of the flat strip one upwardly and the other downwardly, compressing the high side of the corrugation together with the adjacent portion of the strip toward the other side of the corrugation forming a
channel, rolling the portions of the strip on opposite sides of the corrugation into cylindrical form and interlocking said margins, substantially as and for the purpose described.

In testimony whereof, I have hereunto signed my name in the presence of two at-testing witnesses, at Syracuse, in the county of Onondaga, in the State of New York, this 30th day of April, 1913.

EVERETT STUCK.

Witnesses:
E. W. Edwards,
S. Davis.

Copies of this patent may be obtained for five cents each, by addressing the "Commissioner of Patents, Washington, D. C."