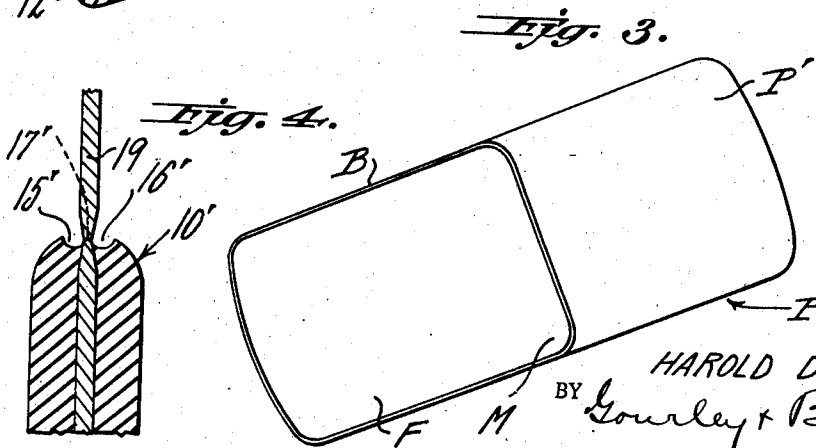
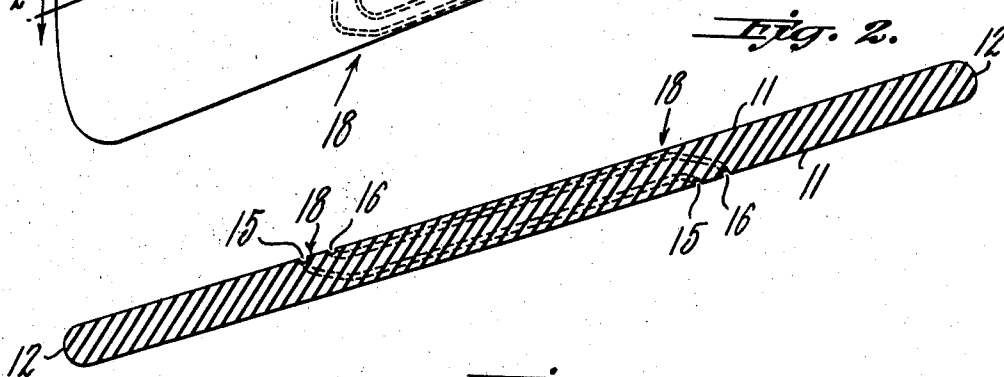
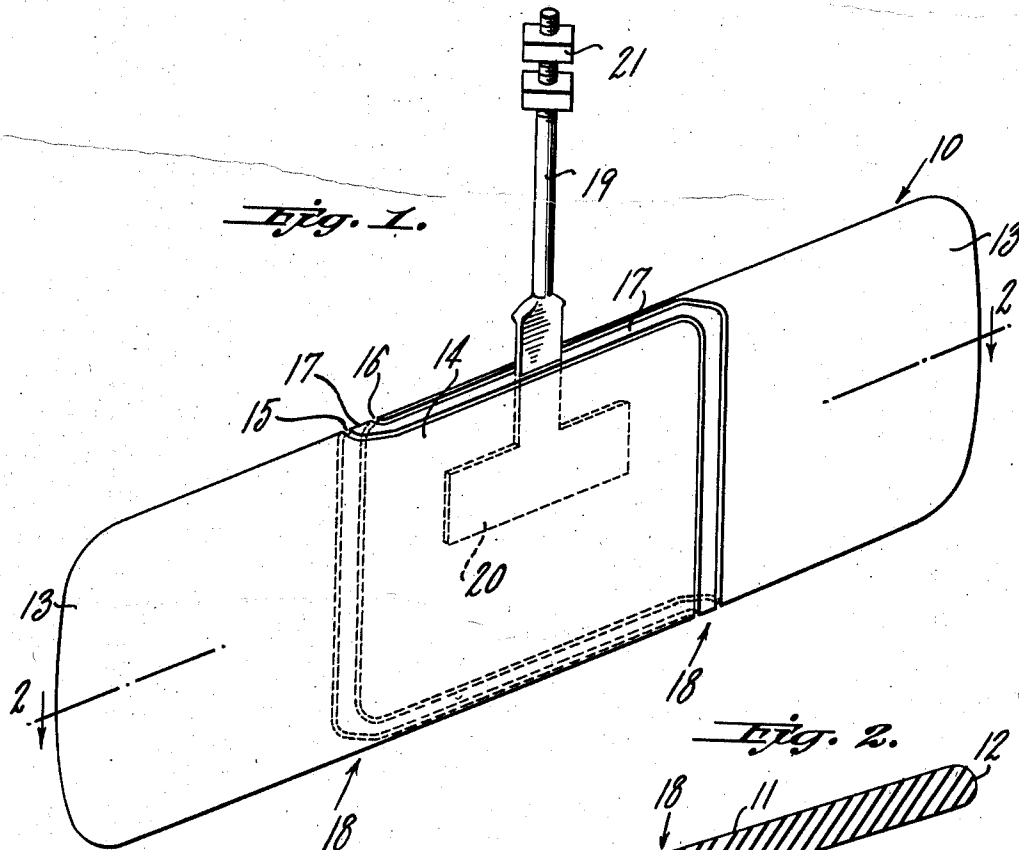


Oct. 8, 1940.

H. D. RICE
DEPOSITION FORM
Filed July 8, 1937

2,216,985



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UNITED STATES PATENT OFFICE

2,216,985

DEPOSITION FORM

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mesne assignments, to United States Rubber
Company, New York, N. Y., a corporation of
New Jersey

Application July 8, 1937, Serial No. 152,585

2 Claims. (Cl. 18—41)

This invention relates to a deposition form for simultaneously making a pouch on each end thereof.

Heretofore pouches have been made by depositing in the conventional manner on only one end of a deposition form a coating of rubber derived from an aqueous dispersion of rubber. An excess of coating is deposited on the form to provide a marginal coating around the mouth of the pouch and where the pouch is formed with a flap for closing the mouth a still greater excess marginal coating of rubber coating is deposited on the form around the mouth and flap. The excess marginal coating is removed to produce a smooth edge around the mouth or mouth and flap. In such prior practice the excess marginal coating constitutes considerable waste material and only one pouch is produced on a form at one time.

In accordance with the present invention a double end deposition form is used and a rubber coating derived from an aqueous dispersion of rubber is deposited on each end during the same depositing operation. The ends of the form conform to the shape of the pocket portion of the pouch and the intermediate portion of the form is provided with a surface formation which extends around the form between the mouth or mouth and flap edges of the pouches deposited thereon to separate, outline and produce reinforcing beads on the edges of the respective pouches.

The surface formation for producing the beads on the pouches may comprise an abruptly rising ridge, which forms corners between the sides of the ridge and the contiguous deposition surface, which is the subject matter of an application of Graham G. Wanless, Serial No. 152,587, filed July 8, 1937, or such surface formation may comprise parallel grooves formed in the surface of the form for producing the beads. A handle is connected to the body of the form. In order to prevent the handle from making indentations in the edges of the pouches where it enters the surface of the form, it is desirable to space the reinforcing grooves so that the handle can enter the surface between them. The grooves may be placed relatively close together and any such indentation may be minimized by making the handle relatively thin where it passes through the ridge which separates the grooves.

After the coating of rubber deposited on the deposition form has dried, it is severed between the beads, and the two pouches are removed from the form, one from each end. In the event the bead forming surfaces are separated by an inter-

vening space the rubber material which bridged this space is trimmed along the beads after the pouches are removed from the form. In the practice of this invention a reduction in waste material and a greater production of pouches are effected because the strip separating the beads is relatively narrow and two pouches are produced at the same time on one form.

The foregoing advantages and other important features of this invention will be more clearly understood by referring to the following description and the accompanying drawing in which:

Fig. 1 is an isometric view of a deposition form embodying this invention;

Fig. 2 is a cross-sectional view of the form on line 2—2 of Fig. 1;

Fig. 3 is an isometric view of a pouch produced on such form, and

Fig. 4 is a fragmentary cross-sectional view of a modification of the form shown in Figs. 1 to 3 and taken longitudinally through the form handle.

This invention is illustrated in reference to a deposition form 10 as shown in Figs. 1, 2 and 4 for producing a pouch P (Fig. 3) having a pocket portion P' and a mouth M and a flap F for closing same, the edges of which are provided with a reinforcing bead B. The form may be made of hard vulcanized rubber, aluminum or other suitable material. It is provided with opposite side deposition surfaces 11 and opposite edge deposition surfaces 12 extending between and contiguous to the side surfaces 11, which surfaces are adapted to be completely covered with a rubber coating deposited thereon from an aqueous dispersion of rubber to produce a pouch P on each of the opposite ends 13 of the form, the pocket P' of the respective pouches being formed on the opposite ends 13 and the mouth M and flap F being formed on the intermediate portion 14 of the form. A surface formation is formed on the intermediate portion 14 to produce the bead B on the mouth and flap of each pouch and to indicate the line of separation between the pouches.

As illustrated in Figs. 1 and 2, the surface formation comprises a pair of parallel grooves 15 and 16 separated by a narrow strip 17 extending across the opposite side deposition surfaces 11 at off-set positions 18 and along the edge deposition surfaces 12 between the two positions 18. The deposited rubber collects in the groove 15 and forms the bead B on the pouch which is deposited on the left end of the form as viewed in Fig. 1. The groove 16 forms the bead B on the pouch deposited on the right end of the form 10 as viewed

in Fig. 1. The strip 17 is made sufficiently wide to receive an attaching handle 19 which extends through the strip surface 17 and into the body of the form 10 and is anchored therein by a foot 20.

5 Nuts 21 are threaded on the handle 19 for securing it to a mechanical means for carrying the form through a dipping or spraying bath.

As illustrated in Fig. 4 the bead forming grooves 15' and 16' may be placed close to each other so that their adjacent top edges terminate in a common edge or very narrow ridge 17'. The handle 19' is connected to the form through the common edge 17' and is made as thin at the surface of the form 10' as the minimum limit of necessary strength will permit in order to avoid, as far as possible, indentations being formed in the beads B by the handle 19'. The edge 17' in this case, may be made sufficiently sharp to sever the rubber deposited thereon between the beads 20 by running a metal roller along the edge. In this manner the subsequent trimming of the rubber from the beads B after the removal of the pouches P may be eliminated.

The rubber coating may be deposited on the form in the conventional manner by either dipping or spraying the form with a suitably compounded aqueous dispersion of rubber. After the desired thickness of coating has been coagulated and dried on the form it is severed along the strip 30 17 or common groove edge 17' so as to separate the two pouches. The pouches may then be removed from the ends of the form. In the event the form shown in Figs. 1 and 2 is employed the excess rubber which bridged the space between the beads B is trimmed along the beads B after the removal of pouches.

The distance between the offset positions 18 may be made of the desired length to produce a flap of any desired length, or the distance may be made equal to zero and thereby produce 40 pouches on each end without any flap.

The term "rubber" as used herein means rubber or rubber compositions containing suitable compounding ingredients either dispersed with or contained in the coagulated rubber derived 45 from such dispersion.

While the preferred modification of this invention has been shown and described herein it will be understood that the changes in the details as

shown may be made without departing from the spirit of the invention or the scope of the appended claims.

Having thus described my invention, what I claim and desire to protect by Letters Patent is: 5

1. An elongated deposition form for simultaneously forming on each end thereof a pouch having a pocket and a flap attached to the mouth of the pocket for closing same, said form having contiguous side and edge deposition surfaces, the 10 opposite ends of said form being shaped to form the pocket portions of the pouches, and the intermediate portion of said form being adapted to form the flap portions of said pouches, said intermediate portion of said form having spaced 15 parallel grooves in the surface thereof extending across the opposite sides of said form at off-set positions and extending along the opposite edges of said form between said off-set positions to provide the line of separation between the pouches 20 along the edges of the flaps and the mouth openings of the pouches and to produce a bead along the edges of said pouches, and a handle connected to said deposition surfaces at a position between said grooves. 25

2. An elongated deposition form for simultaneously forming on each end thereof a pouch having a pocket and a flap attached to the mouth of the pocket for closing same, said form having contiguous side and edge deposition surfaces, the 30 opposite ends of said form being shaped to form the pocket portions of the pouches, and the intermediate portion of said form being adapted to form the flap portions of said pouches, said intermediate portion of said form having parallel 35 grooves in the surface thereof extending across the opposite sides of said form at off-set positions and extending along the opposite edges of said form between said off-set positions to produce beads on said pouches, said grooves having a relatively narrow ridge extending therebetween to provide the line of separation between the 40 pouches along the edges of the flaps and the mouth openings of the pouches, and a handle connected to said deposition surfaces by a relatively thin connection extending through and along said narrow ridge. 45

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