Oct. 8, 1963 W. L. BAKER 3,106,480

APPARATUS AND METHOD FOR APPLYING A STRIPED COAT OF PAINT TO A SHEET OF MATERIAL IN A SINGLE OPERATION

Filed Feb. 16, 1961 3 Sheets-Sheet 1

Fig. 1

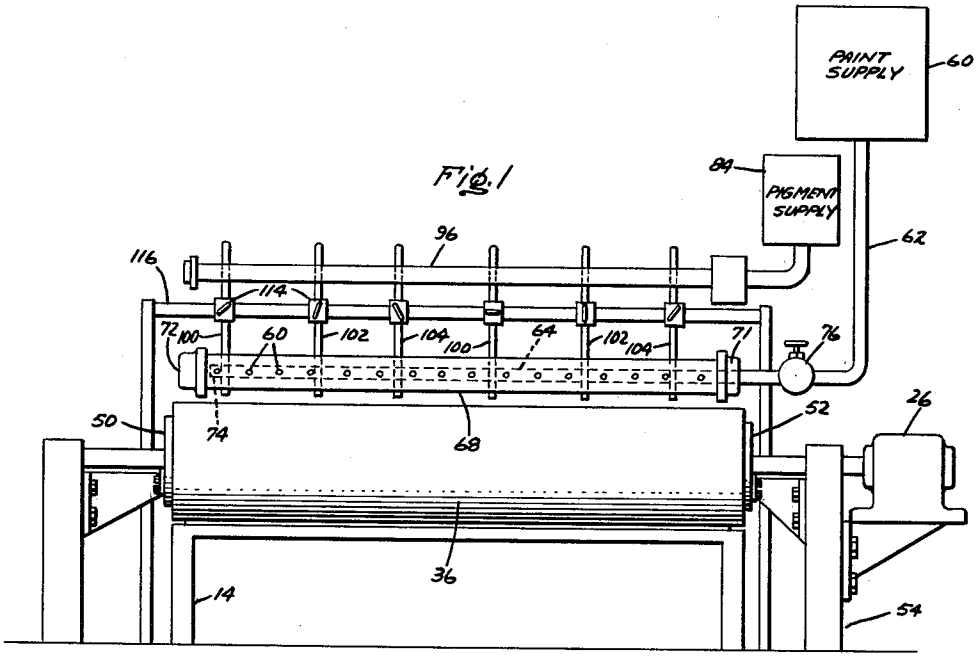
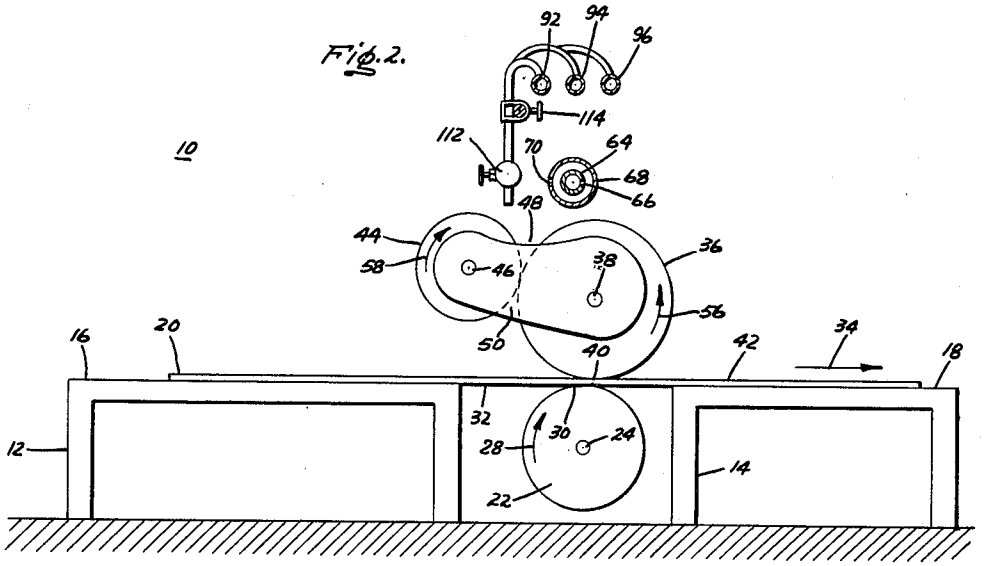


Fig. 2.



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Fig. 3.

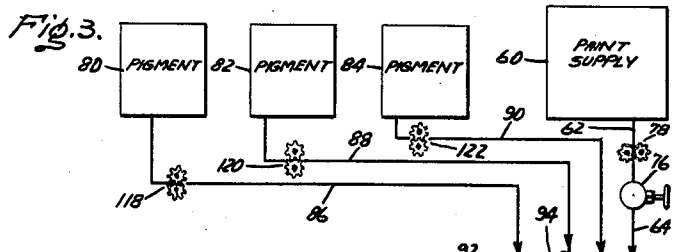


Fig. 4.

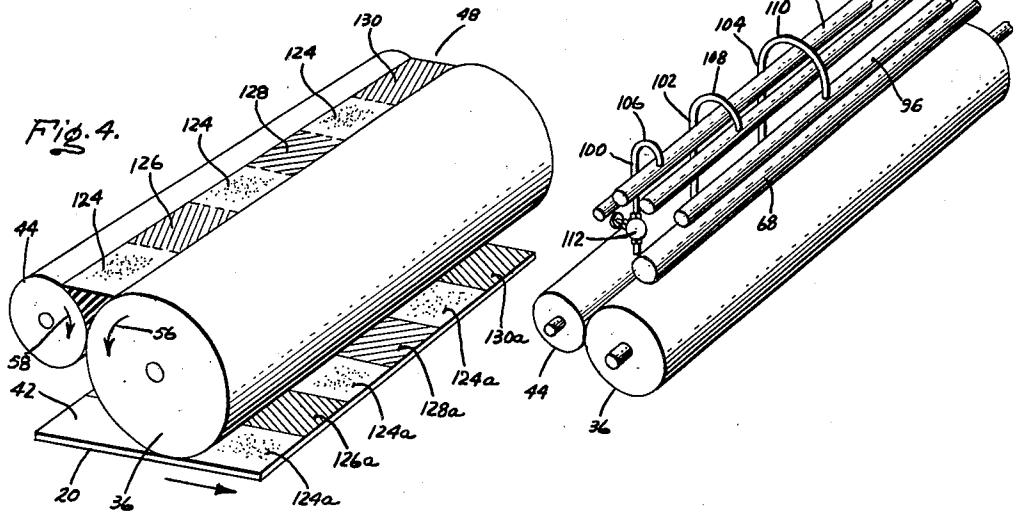
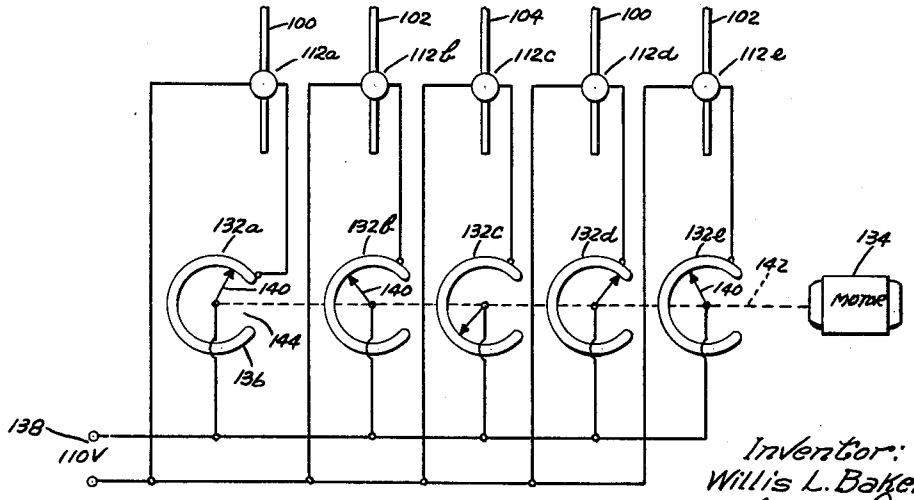


Fig. 5.



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Filed Feb. 16, 1961 3 Sheets-Sheet 3

Fig. 6.

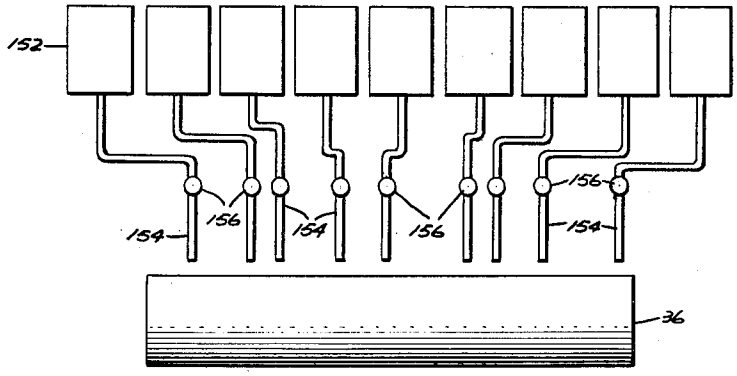
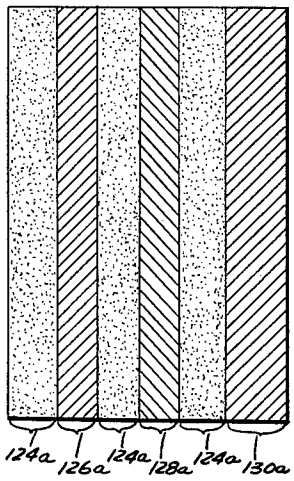


Fig. 7.



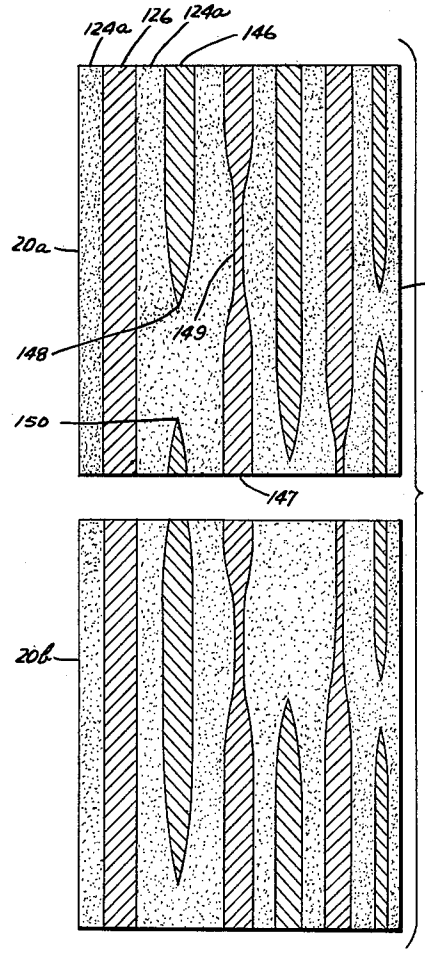


Fig. 8.

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3,106,480

APPARATUS AND METHOD FOR APPLYING A STRIPED COAT OF PAINT TO A SHEET OF MATERIAL IN A SINGLE OPERATION

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Filed Feb. 16, 1961, Ser. No. 89,818
18 Claims. (Cl. 117—43)

This invention relates generally to apparatus and methods for applying a decorative coating upon a sheet of material, and more particularly to apparatus and methods for applying a striped coat of paint to one surface of a sheet of material in a single operation.

In the funiture and home building industries, sheets of construction material, such as plywood, hardboard, etc. are extensively employed and such sheets are commonly prefinished with a decorative coating of paint; such coating of paint is conventionally applied by means of a paint-applying roller and a cooperating doctor or metering roller, the paint being fed to the well or trough defined between the rollers and thus applied to the paint-applying roller and in turn to the sheet which is moved past the roller in rolling engagement therewith. There are applications in which it is desirable to provide a sheet of construction material having a striped coating of paint of different colors and in the past, it has been necessary to perform as many paint-applying operations on the sheet as there were different color stripes, i.e. if a base color with stripes of three different colors were provided on the sheet, four separate paint-applying operations were required. It would therefore be highly desirable to provide an apparatus and method by which a striped coat of paint of different colors could be applied to the sheet of material in a single operation.

It is accordingly an object of my invention to provide apparatus for applying a striped coat of paint of different colors to one surface of a sheet of material in a single operation.

Another object of my invention is to provide a method for applying a striped coat of paint of different colors to one surface of a sheet of material in a single operation.

I have discovered that when paint is continuously and simultaneously fed to a paint-applying roller in adjoining and discrete bands of different colors, a striped coat of paint of different colors is provided with little appreciable lateral blending of one color stripe into the next when the roller is rotated at a speed and the paint is fed thereto at a rate such that no appreciable lateral blending of the color bands on the roller occurs prior to application to the sheet.

In the drawings:

FIG. 1 is an end view of the preferred embodiment of the apparatus of my invention;

FIG. 2 is a side view, partly in section, further illustrating the apparatus of FIG. 1;

FIG. 3 is a view partly in perspective and partly schematic still further illustrating the apparatus of the previous figures;

FIG. 4 is a fragmentary view in perspective useful in explaining the method of my invention;

FIG. 5 is a schematic illustration of a modification of my invention;

FIG. 6 is a schematic view of another modification of my invention;

FIG. 7 is a plan view of a sheet of construction material having a striped coating of paint of different colors applied thereto in accordance with the apparatus and method of my invention; and

FIG. 8 is a view of two successive sheets of construction material having random stripes of different color applied thereto with the apparatus of FIG. 5.

Referring now to FIGS. 1 to 3 of the drawings, the apparatus of the preferred embodiment of my invention, generally indicated at 10, comprises two spaced-apart supporting frames 12 and 14 having coplanar horizontally disposed work supporting surfaces 16 and 18 for supporting sheet 20 of construction material to be painted. A conventional conveying roller 22 is provided disposed between frames 12 and 14 and mounted for rotation about a horizontal axis 24 by driving motor 26 through suitable gearing (not shown) in the direction shown by the arrow 28. The top peripheral surface 30 of roller 22 engages the bottom surface 32 of sheet 20 so as to advance the same transversely of axis 24 in the direction shown by the arrow 34.

A conventional paint-applying roller 36 is provided mounted for rotation about the horizontal axis 38 parallel with and spaced above axis 24, the bottom peripheral surface 40 of roller 36 engaging the top surface 42 of sheet 20 thereby to apply paint thereto. Paint-applying roller 36 is likewise driven by motor 26 at the same linear speed as roller 22. Paint-applying roller 36 may be covered with suitable paint-applying material, such as carpeting, as is well known to those skilled in the art. A doctor roller 44 is provided mounted for rotation about axis 46 spaced from and parallel with axis 38, doctor roller 44 engaging the side of paint-applying roller 36 thereby defining an upwardly facing, continuous, i.e. uninterrupted paint-receiving well or trough 48 therebetween. Dam plates 50, 52 respectively engage the sides of rollers 36 and 44 closing the ends of the trough 48 and the assembly comprising rollers 22, 36 and 44 is supported by frame 54. The apparatus thus far described in conventional in the trade for painting a sheet construction material and thus need not be further described. It will be readily seen that the paint-applying roller 36 is rotated in the direction shown by the arrow 56 and that the doctor roller 44 necessarily rotates in the direction shown by the arrow 58 thereby to cause paint in the trough 48 to be applied to the paint-applying roller 36 and in turn to be applied to the top surface 42 of sheet 20 as it moves in the direction 34.

In accordance with my invention, I have provided a reservoir 60 for paint of a base color, such as off white or light buff. A suitable conduit 62 is provided connected to reservoir 60 and having a portion 64 extending above paint-applying roller 36 and parallel with axis 38 thereof. Conduit portion 64 has a plurality of closely spaced openings 66 formed therein along a line parallel with the axis of portion 64, openings 66 being generally disposed in a plane parallel with that of sheet 20 and facing in the direction 34, openings 66 further extending generally across roller 36, as best seen in FIG. 1. A generally tubular manifold member 68 concentrically surrounds conduit portion 64, being slightly longer than the extent of openings 66, manifold member 68 being attached to the outer periphery of conduit portion 64 at its end 70 and being closed at its other end 72, end 74 of conduit portion 64 likewise being closed. In the illustrated embodiment, manifold member 68 is provided with an elongated slot 70 generally extensive in length with the extent of openings 66 in conduit portion 64, slot 70 being generally coplanar with openings 66 but facing in the direction opposite from direction 34. Conduit portion 64, manifold member 68 and slot 70 therein are disposed so as to discharge paint into the well or trough 48 and it will be observed that paint supplied from reservoir 60 through conduit 62 flows out of the openings 66 in the inner conduit portion 64 into manifold member 68 and in turn out of the elongated slot 70 into trough 48 throughout the length thereof. A suitable valve 76

is provided in conduit 62 and it may also be desirable to provide a suitable pump 78 in conduit 62 so as to force the base color paint from reservoir 60 through conduit 62, inner conduit portion 64, and manifold member 68.

A plurality of pigment reservoirs 80, 82 and 84 are provided for respectively supplying pigments of different colors which when mixed or blended with the base paint in trough 48 will provide the desired different colored stripes on surface 42 of sheet 20. Pigment reservoirs 80, 82 and 84 are respectively connected to conduits 86, 88 and 90 in turn respectively having portions 92, 94 and 96 extending generally above conduit portion 64 and manifold member 68 and parallel therewith. One or more discharge conduits 100, 102 and 104 are respectively connected to pigment conduit portions 92, 94 and 98 by upwardly extending reverted bends 106, 108 and 110, discharge conduits 100, 102 and 104 extending downwardly to discharge pigments from reservoirs 80, 82 and 84 into well or trough 48 at predetermined spaced intervals. Each of the discharge conduits 100, 102 and 104 may have a suitable valve 112 therein. Discharge conduits 100, 102 and 104 are adjustably supported for selective transverse movement by means of suitable clamps 114 on supporting bar 116, and reverted bend portions 106, 108 and 110 are preferably formed of suitable flexible tubing to accommodate such movement.

Since the pigments in reservoirs 80, 82 and 84 are very viscous, it is desirable to provide suitable pumps 118, 120 and 122 in the conduits 86, 88 and 90 respectively for forcing the pigments under pressure through the conduits and into the trough 48. It will be comprehended that the reverted bends 106, 108 and 110 are provided to prevent drainage of pigment from the conduit portions 92, 94 and 98 when the pumps 118, 120 and 122 are inactive, thus permitting abruptly shutting-off or terminating any one of the color stripes; this feature is highly desirable in connection with the embodiment of FIG. 5 discussed hereinafter.

Referring now to FIG. 4, introduction of the base color paint from reservoir 60 and the different color pigments from reservoirs 80, 82 and 84 into the well or trough 48 defined between the paint applying roller 36 and the doctor roller 44 results in the formation of adjoining discrete sections of paint, such as sections 124 of base color and sections 126, 128 and 130 of respectively different colors provided by the different color pigments in the reservoirs 80, 82 and 84. It is well known of course that when two different fluids are in contact they will disperse or blend into each other over a period of time and thus it would normally be expected that when different colored pigments from reservoirs 80, 82 and 84 are introduced into the base color paint in trough 48 at spaced apart intervals, they would immediately blend together, especially by virtue of the rotation of rollers 36 and 44, thus to provide paint in trough 48 of a uniform color resulting from the mixture of the pigment colors with the base color paint. However, I have found that surprising, introduction of the different colored pigments from reservoirs 80, 82 and 84 into the base color paint trough 48 results in the provision of adjoining quite discrete sections of paint of different colors, i.e. base color sections 124, and sections 126, 128 and 130 having a color resulting from the mixing of the respective pigments with base color paint, these different color sections being applied to the roller 36 in adjoining discrete color bands and in turn being applied to surface 42 of sheet 20 as adjoining discrete stripes 124*a* of the base color and 126*a*, 128*a* and 130*a* of colors resulting from the different color pigments in reservoirs 80, 82 and 84. I attribute this surprising result to the fact that the base color paint and pigments in the trough 48 are continuously and simultaneously applied to the periphery of roller 36 and in turn to the surface 42 of sheet 20 before any appreciable lateral blending of the different colors of paint in the trough 48 can occur. The base color paint and pigments are fed to trough 48 in a manner to maintain a sufficient depth of paint in the trough. Thus, valves 76 and 112 may be of the solenoid actuated type and simultaneously actuated in intermittent fashion to maintain the desired level of paint in trough 48. Alternatively, base color paint and pigments may be continuously introduced into trough 48 with the rate of flow controlled to maintain the level of paint in trough 48 within the desired limits. It is an important aspect of my invention that the paint in trough 48 must be applied to roller 36 and in turn to the sheet of material very soon after introduction of the paint into the trough; if the paint is allowed to stand in trough 48 for any appreciable length of time, the adjacent different colored sections will begin to blend one into the other. With vinyl base paint, it has been found that the base color paint and pigments cannot stand in trough 48 for any longer than 20 minutes without undesirable lateral blending occurring. This time will obviously vary with different types of paint and pigments.

With vinyl base color paint having a viscosity of 85 Kreb units, rollers 36, 44 and 22 may be rotated at a peripheral liner speed on the order of 72 feet per minute, thus of course advancing sheet 20 in the direction 34 at the same rate of speed, the base color paint is fed to trough 48 at a rate of approximately ¾ gallon per minute for continuous operation of the machine, i.e. coating one sheet after another, and the pigment is fed at a rate of approximately 1/20 gallon per minute. With the foregoing roll speeds and paint and pigment supply speeds, in the case of 4' by 8' plywood sheets, a coating of from two to three mils thickness is applied, and I have provided stripes of different colors from ½ inch to 48 inches wide with the width of overlap or blending between adjacent stripes on the sheet being no more than ⅛ inch. I have found that other roll speeds between 15 and 150 linear feet per minute may be employed. The rate of base color paint and pigment feed to trough 48 obviously varies depending on whether the apparatus is operated continuously or intermittently.

It would seem that even after the paint has been applied in discrete stripes to the surface 42 of sheet 20, more blending between adjacent stripes will occur prior to final drying of the paint. I have found, however that drying time is not at all critical, and while I dry the painted sheets in hot forced air for 35 minutes, I have found that they can be air dried without any perceptible difference in the degree of blending between adjacent stripes of different colors. I attribute this to the fact that the coating applied to the sheet is very thin with a resulting minute area of contact between adjacent stripes of different colors which thus provides a very low rate of lateral dispersion or blending and further to the fact that vehicle in the paint rapidly soaks into the plywood as well as evaporating into the air, and the paint immediately begins to dry inwardly from the outer surface thus inhibiting transverse blending of the different color stripes on the sheet.

In FIG. 7 there is shown a sheet of construction material having a striped coating of paint of different colors applied in accordance with my invention. It will be readily comprehended that different numbers of stripes of different widths may be applied with the apparatus and method described above.

Sheets of material having striped coatings in different pastel colors applied thereto with the apparatus and method of my invention have been found to be particularly useful as a base material for applying printed wood grain patterns as more fully described and illustrated in my co-pending application Serial Number 90,072, filed February 17, 1961. Here, it has been found desirable to provide a more random pattern of stripes and to accomplish this, I show in FIG. 5 apparatus in which valves 112*a* through 112*e* connected respectively in pigment dis-

charge lines 100, 102 and 104 are of the electrically actuated type. Here valves 112*a* through 112*e* are sequentially energized and deenergized by means of rotary switches 132*a* through 132*e* driven by a suitable drive motor 134. It will be seen that each of the switches 132*a* through 132*e* is provided with a semi-circular conductive portion 136 having one end connected to the actuating coil of the respective valve, the other side of the respective actuating coil being connected to one side of a source of suitable energizing potential 138. Rotatable sliding elements 140 of each of the switches 132*a* through 132*e* slidingly engage the conductive elements 36 and are connected to the other side of the source 138. The rotatable elements 140 are ganged, as at 142 and driven by motor 134, and it will be readily seen that so long as an individual rotatable element 140 is contacting its respective conductive element 136, the respective valve 112 will be energized and thus open to permit discharge of pigment into the trough 48. However, when the respective rotatable element 140 is in the space 144 between the ends of conductive element 136, the respective operating coil of the respective valve 112 will be deenergized and thus the valve will be closed. The result of the employment of the valve switching arrangement shown in FIG. 5 is to provide successive sheets 20*a* and 20*b* as shown in FIG. 8 with a random striped pattern. Thus, for example valve 112*a* may control a supply of pigment from the discharge conduit 100 to provide color stripe 146 on the finished sheet. It will be seen that so long as the rotatable element 140 of switch 132*a* is engaging the conductive element 136, valve 112*a* will be opened so as to discharge pigment from discharge 100 to provide stripe 146. However, when the rotatable element 140 reaches the space 144 between the ends of conductive element 136, valve 112*a* will be closed thus terminating the discharge of pigment from conduit 100 and in turn terminating stripe 146, as at 148. When rotatable element 140 is again driven onto conductive element 136 of switch 132*a* by motor 134, valve 112*a* will again be opened thus again to initiate stripe 146, as at 150. Valve 112*b* may control color stripe 147 and be arranged so as not to be completely shut off when sliding element 140 of switch 132*b* is in space 144 thereof so as to provide narrow stripe 149 connecting the wider portions of stripe 147. It will be seen that rotatable elements 140 of each of the switches 132*a* through 132*e* are angularly displaced thus to provide the apparent random pattern of the different colored stripes on successive sheets 20*a* and 20*b* as clearly seen in FIG. 8. Continuous stripe 126 may also be provided by a valve not actuated by motor 134.

Referring now to FIG. 6, rather than mixing base color paint and different color pigments in the well or trough 48 defined by the paint applying roller 36 and doctor roller 44 as in the case of the embodiment of FIGS. 1 through 3 inclusive, it may be found desirable to mix the pigments and base color paint to provide the desired different color paints and thus, in FIG. 6 I show a plurality of paint reservoirs 152 for receiving premixed paint of the desired different colors. The paint reservoirs 152 are respectively connected to paint discharge conduits 154 which discharge into well or trough 48 with the predetermined desired spacing, as shown. Each of the discharge lines 154 preferably has a valve 156 therein for shutting off the supply of paint of a particular color and thus, the sequential arrangement shown in FIG. 5 may be employed in the embodiment of FIG. 6.

It will now be seen that I have provided an apparatus and method for providing a striped coating of different colors on a sheet of material in a single operation whereas in the past it has been considered necessary to provide a separate paint applying operation for each different colored stripe.

While I have illustrated and described a specific embodiment of my invention, further modifications and improvements will occur to those skilled in the art and I desire therefore in the appending claims to cover all modifications which do not depart from the spirit and scope of my invention.

What is claimed is:

1. Apparatus for applying a striped coat of paint to one surface of a sheet of material in a single operation comprising: means for supporting said sheet and for advancing the same; an elongated paint-applying roller adapted to engage said one surface of said sheet; means for rotating said roller thereby to apply said coat of paint on said surface; paint applying means defining an elongated trough having opposite ends and which is open between the ends thereof for accommodating a quantity of paint and continuously applying the same to said roller; and means for introducing paint into said trough in engaging discrete sections of different colors.

2. Apparatus for applying a striped coat of paint to one surface of a sheet of material in a single operation comprising: means for supporting said sheet and for advancing the same; an elongated paint-applying roller adapted to engage said one surface of said sheet; means for rotating said roller thereby to apply said coat of paint on said surface; means engaging said roller substantially throughout the length thereof for continuously applying paint thereto, said paint applying means defining an elongated continuous trough with said roller for accommodating a quantity of paint to be applied to said roller and continuously feeding the same thereto; said trough having opposite ends and being open from one end to the other thereof, and means for introducing paint into said trough in engaging discrete sections of different colors.

3. The combination of claim 2 wherein said engaging means is a doctor roller.

4. Apparatus for applying a striped coat of paint to one surface of a sheet of material in a single operation comprising: means for supporting said sheet and for advancing the same; an elongated paint-applying roller adapted to engage said one surface of said sheet; means for rotating said roller thereby to apply said coat of paint on said surface; means engaging said roller substantially throughout the length thereof for continuously applying paint thereto, said paint applying means defining an elongated continuous trough with said roller for accommodating a quantity of paint to be applied to said roller and continuously feeding the same thereto; said trough having opposite ends and being open therebetween, and a plurality of means at spaced intervals along said trough for respectively introducing paint of different colors thereto in engaging discrete sections.

5. Apparatus for applying a striped coat of paint to one surface of a sheet of material in a single operation comprising: means for supporting said sheet and for advancing the same; an elongated paint-applying roller adapted to engage said one surface of said sheet; means for rotating said roller thereby to apply said coat of paint on said surface; means engaging said roller substantially throughout the length thereof for continuously applying paint thereto, said paint applying means defining an elongated continuous trough with said roller for accommodating a quantity of paint to be applied to said roller and continuously feeding the same thereto; said trough having opposite ends and being open therebetween, a plurality of reservoirs respectively for paint of different color; and a plurality of conduit means respectively connected to said reservoirs and discharging into said trough at spaced intervals therealong thereby to introduce said different colors of paint thereto in adjoining discrete sections.

6. Apparatus for applying a striped coat of paint to one surface of a sheet of material in a single operation comprising: means for supporting said sheet and for advancing the same; an elongated paint-applying roller adapted to engage said one surface of said sheet; means

for rotating said roller thereby to apply said coat of paint on said surface; means engaging said roller substantially throughout the length thereof for continuously applying paint thereto, said paint applying means defining an elongated continuous trough with said roller for accommodating a quantity of paint to be applied to said roller and continuously feeding the same thereto; said trough having opposite ends and being open therebetween, a first reservoir for paint of a base color; first conduit means connected to said first reservoir and having a plurality of discharge openings therein for continuously introducing said base color paint into said trough throughout the length thereof; at least one reservoir for pigment of a color different from said base color; and second conduit means connected to said last-named reservoir for discharging said different color pigment into said trough at a predetermined location therealong simultaneously with introduction of said base color paint thereto thereby to provide a discrete section of paint of said different color in said trough.

7. The combination of claim 6 wherein said first conduit means comprises an inner conduit connected to said first reservoir and having a portion extending parallel with said roller and trough and spaced therefrom, said portion having a plurality of spaced discharge openings formed therein along a line parallel with the axis of said portion, and an outer member surrounding said conduit portion and having an opening formed therein on the side of said portion remote from said discharge openings, said conduit means being disposed so that said outer member opening discharges paint therefrom into said trough.

8. The combination of claim 6 wherein said second conduit means comprises a first conduit connected to said last-named reservoir and having a portion extending parallel with said roller and trough and spaced therefrom, and a second conduit connected to said first conduit portion by a reverted bend and discharging into said trough, and further comprising pump means cooperating with said first reservoir and first conduit for introducing said pigment into said trough under pressure, said reverted bend being disposed to prevent drainage of pigment from said second conduit into said trough when said pump means is inactive.

9. The combination of claim 5 further comprising valve means respectively connected in at least some of said conduit means for controlling the flow of paint therein, and means for respectively opening and closing said valve means in a predetermined sequence thereby to provide a random striped pattern on said sheet.

10. The combination of claim 5 further comprising electrically actuated valve means respectively connected in at least some of said conduit means for controlling the flow of paint therein, and switching means coupled to said valve means for respectively actuating the same in a predetermined sequence thereby to provide a random striped pattern on said sheet.

11. Apparatus for applying a striped coat of paint to one surface of a sheet of material in a single operation comprising: means for supporting said material; means for advancing said material; a paint applying roller; means for rotating said roller thereby to apply said coat of paint on said one surface; a doctor roller engaging said paint-applying roller substantially throughout its length and rotating therewith at the same speed but in opposite directions, said doctor roller defining an elongated continuous trough with said paint applying roller for accommodating a quantity of paint and continuously feeding the same thereto; dam means cooperating with said rollers for respectively closing the ends of said trough; said trough being open between its ends, a plurality of reservoirs respectively for paint of different colors; and a plurality of conduits respectively connected to said reservoirs and discharging into said trough at spaced intervals therealong thereby to introduce said different colors of paint thereto in adjoining discrete sections.

12. The combination of claim 11 wherein said supporting means is horizontally disposed, wherein said advancing means comprises a conveying roller mounted for rotation about a first horizontal axis, the top peripheral surface of said conveying roller lying in the plane of said supporting surface thereby to engage the bottom surface of said sheet, wherein said paint-applying roller is mounted for rotation about a second axis spaced above and parallel with said first axis, the bottom peripheral surface of said paint-applying roller being adapted to engage the top surface of said sheet, wherein said doctor roller is mounted for rotation about a third axis spaced from and parallel with said second axis whereby said trough is disposed transversely of said sheet on the side of said roller remote therefrom, and wherein said conduit means is disposed above said trough.

13. Apparatus for applying a striped coat of paint to one surface of a sheet of construction material in a single operation comprising: a horizontally disposed material-supporting surface; a conveying roller mounted for rotation about a first horizontal axis, the top peripheral surface of said roller lying in the plane of said supporting surface thereby to engage the bottom surface of said sheet; means for rotating said conveying roller thereby to advance said sheet across said supporting surface; a paint-applying roller mounted for rotation about a second axis spaced above and parallel with said first axis, the bottom peripheral surface of said paint applying roller being adapted to engage the top surface of said sheet; means for rotating said paint applying roller thereby to apply said coat of paint on said top surface of said sheet; a doctor roller engaging said paint applying roller substantially throughout its length and mounted for rotation about a third axis spaced from and parallel with said paint-applying roller, said doctor roller defining an elongated continuous trough with said paint-applying roller for accommodating a quantity of paint and continuously feeding the same thereto; dam means cooperating with said rollers for respectively closing the ends of said trough; said trough being open between its ends, a first reservoir for paint of a base color; a first conduit connected to said first reservoir and having a portion extending above said paint applying roller in spaced parallel relationship, said portion having a plurality of spaced paint discharge openings formed therein along a line parallel with the axis of said portion and in a plane generally parallel with the plane of said supporting surface; and an outer member enclosing said first conduit portion and having an opening formed therein on the side of said portion remote from said discharge openings for discharging paint from said first reservoir into said trough throughout the length thereof; pump means in said first conduit for forcing paint under pressure from said first reservoir through said discharge openings; a plurality of other reservoirs respectively for pigments of color different from said base color; other conduits respectively connected to said other reservoirs and having portions extending above said paint-applying roller in spaced parallel relationship; still other conduits respectively connected to said other conduits by reverted bends and arranged to discharge pigments into said trough at spaced intervals therealong simultaneously with the introduction of said base color paint thereto thereby to provide adjoining discrete sections of paint of different colors in said trough; and other pump means respectively in said other conduits for forcing pigments under pressure from said other reservoirs through said other conduits, said reverted bends being disposed to prevent drainage of pigment from said other conduits into said trough when said other pump means are inactive.

14. The method of applying a striped coat of paint to one surface of a sheet of material in a single operation comprising the steps of: feeding paint into a trough in engaging discrete sections of different colors; continuously rotating a paint-applying roller in engagement with

the paint in said trough; and advancing said sheet past said roller in rolling engagement therewith before said color sections blend into each other whereby said paint is applied thereto; said paint having a viscosity, said roller being rotated at a speed and said paint being fed to said trough at a rate such that discrete color stripes of paint are applied to said sheet.

15. The method of applying a striped coat of paint to one surface of a sheet of material in a single operation comprising the steps of: feeding paint in engaging discrete sections of different colors into a continuous trough defined between a paint-applying roller and a doctor roller in rolling engagement therewith; rotating said roller whereby said paint in discrete sections is continuously applied thereto from said trough; advancing said sheet past said roller in rolling engagement therewith whereby said paint is applied thereto; said paint having a viscosity, said roller being rotated at a speed and said paint being fed to said trough at a rate such that discrete color stripes of paint are applied to said sheet.

16. The method of applying a striped coat of paint to one surface of a sheet of material in a single operation comprising the steps of: feeding a base color paint throughout the length of a trough defined between a paint applying roller and a doctor roller in rolling engagement therewith; feeding pigment of at least one color different from said base color into said trough at a predetermined point therealong simultaneously with said base color paint feeding thereby to provide a discrete section of paint of said different color in said trough; rotating said roller whereby said paint is continuously applied thereto from said trough; advancing said sheet past said roller in rolling engagement therewith whereby said paint is applied thereto; said paint having a viscosity, said roller being rotated at a speed and said paint being fed to said trough at a rate such that discrete color stripes of paint are applied to said sheet.

17. The method of claim 16 wherein a plurality of different colors of pigment are simultaneously fed to said trough at spaced locations therealong thereby to provide adjoining discrete sections of different color in said trough.

18. The method of claim 17 comprising the steps of sequentially terminating and initiating the feeding of certain pigments thereby to provide a random striped pattern on said sheet.

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