

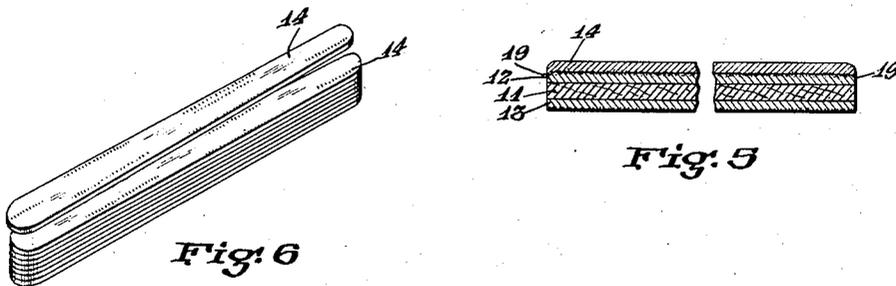
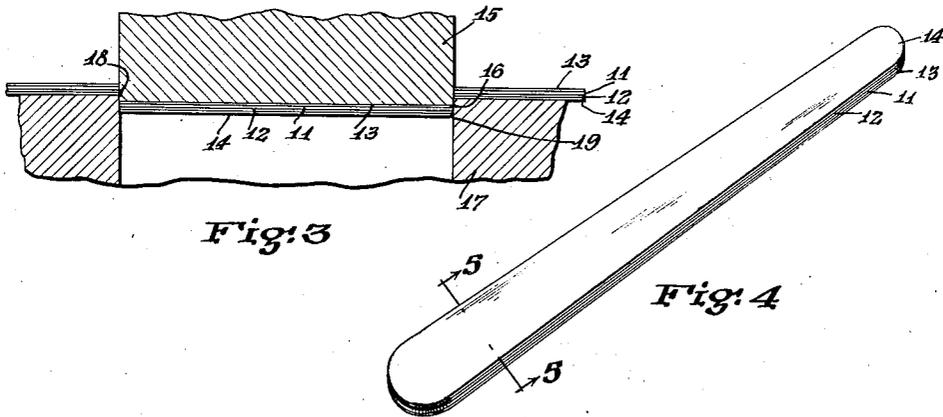
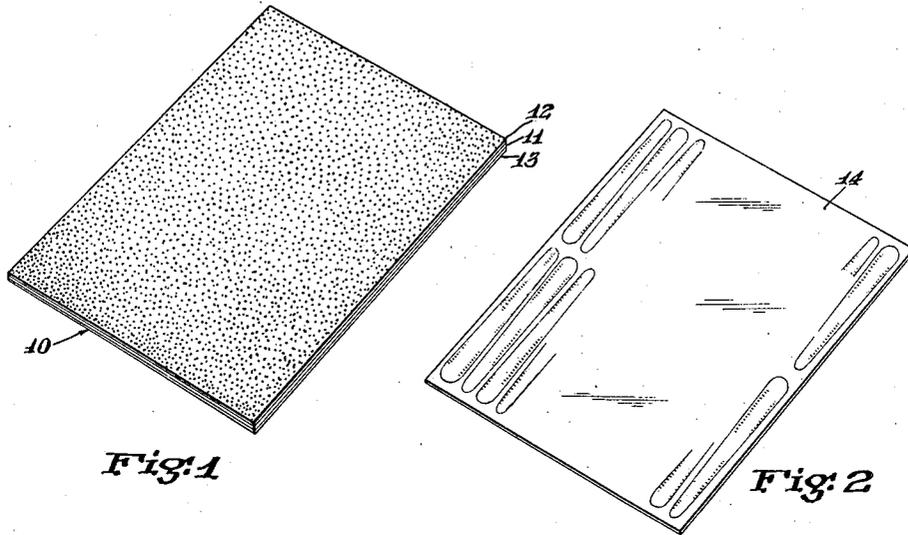
Dec. 19, 1939.

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2,183,930

EMERY BOARD AND ASSEMBLED UNIT OF THE SAME

Filed July 1, 1938



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2,183,930

EMERY BOARD AND ASSEMBLED UNIT OF THE SAME

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Application July 1, 1938, Serial No. 216,899

1 Claim. (Cl. 51—185)

This invention relates to emery boards and assembled units thereof and more particularly to a method of providing each emery board with a protective paper coating without the use of adhesive.

A further object of the invention is the provision of an improved form of an assembly of emery boards so that in such assembly each side of the emery board coated with an abrasive is protected from contact with another abrasive surface, so that such emery boards may be assembled, shipped and stored without damage to the sensitive abrasive surfaces of the individual emery boards.

Further objects of the invention will be apparent from the specification and drawing in which

Fig. 1 is a perspective view of the sheet from which the individual emery boards are cut without the protective paper covering superimposed thereon.

Fig. 2 is a perspective view of the protective paper covering the individual emery boards, the paper sheet being the same size as the emery board sheet.

Fig. 3 is a schematic view in cross-section of the operation of die-cutting simultaneously the sheet shown in Fig. 1 and the sheet shown in Fig. 2.

Fig. 4 is a perspective view of the individual emery board with superimposed protective paper covering thereon after the operation of die-cutting is finished.

Fig. 5 is a sectional view along the line 5—5 of Fig. 4.

Fig. 6 is a perspective view of a nest of emery boards with superimposed protective covers showing how such nested units are marketed and assembled in cartons.

10 indicates the emery board blank itself, which is made of a wood veneer base 11 coated on one side with a garnet abrasive 12 and on the opposite side with a silica abrasive 13.

For convenience in manufacture, such abrasive materials are attached to the opposite sides of the base veneer 11 in the form of thin paper coated with the abrasive itself in the form of fine particles.

14 represents the paper protective covering. After the blank shown in Fig. 1 is made, the sheet 14 is superimposed thereon without the use of any adhesive. The paper sheet naturally adheres lightly to the rough surface of the emery board sheet. The combination of emery board and protective paper thereon are then subjected to a die-cutting operation illustrated in Fig. 3; 15 is the male die having the cutting edge 16; 17 being the female die having the cutting edge 18.

In the operation of simultaneously cutting the paper sheet and the emery board, it is expected to have the paper sheet under the emery board so that in the cutting operation, the edge of the paper 14 is slightly turned over the edge of the surface 13 of the emery board. The turned edge of the paper is designated as 19.

The pressure of the die with the slight turning of the edge of the paper is sufficient to cause a firm adherence between the paper and the emery board so that the paper forms a permanent, fixed, protective covering for the emery board and by overlaying a series of emery boards upon each other, as shown in Fig. 6, each abrasive surface is shielded from immediate contact with another abrasive surface, so that in handling or shipping, the delicate abrasive surface of the emery board will not be injured but will retain its original abrasive quality. Upon the paper sheet 14, appropriate advertising materials, directions and so forth can be printed as illustrated in Figs. 2, 4 and 6.

Fig. 4 illustrates the individual emery board as a completed product as used in commerce and from which the protective paper may be readily removed without the use of any tool or the like by lifting same with the finger from the edge of the emery board itself.

It will be apparent from the drawing that the invention herein consists not in the improvement of the individual emery board itself as far as its original abrasive character is concerned, but rather in a method of providing such emery boards with protective paper coverings, where such covers will fit exactly, and where such covers may be applied and will remain in place without the use of any adhesive or the like.

It should be also noted that for the protective paper covering, a light but strong paper should be used; such paper being sufficiently flexible so as to be firmly adherent to the surface of the emery board.

Having fully described my invention, what I claim is:

A method of manufacturing emery boards comprising the steps of providing a non-elastic sheet of material with abrasives on both sides thereof, superimposing a protective paper sheet of equal size upon the abrasive sheet, simultaneously die-cutting the superimposed sheets with the paper sheet under the abrasive sheet, the edges of said paper sheet being turned upwardly during the cutting operation so that the edges of said paper sheet will graspingly contact the peripheral edges of the abrasive sheet.

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