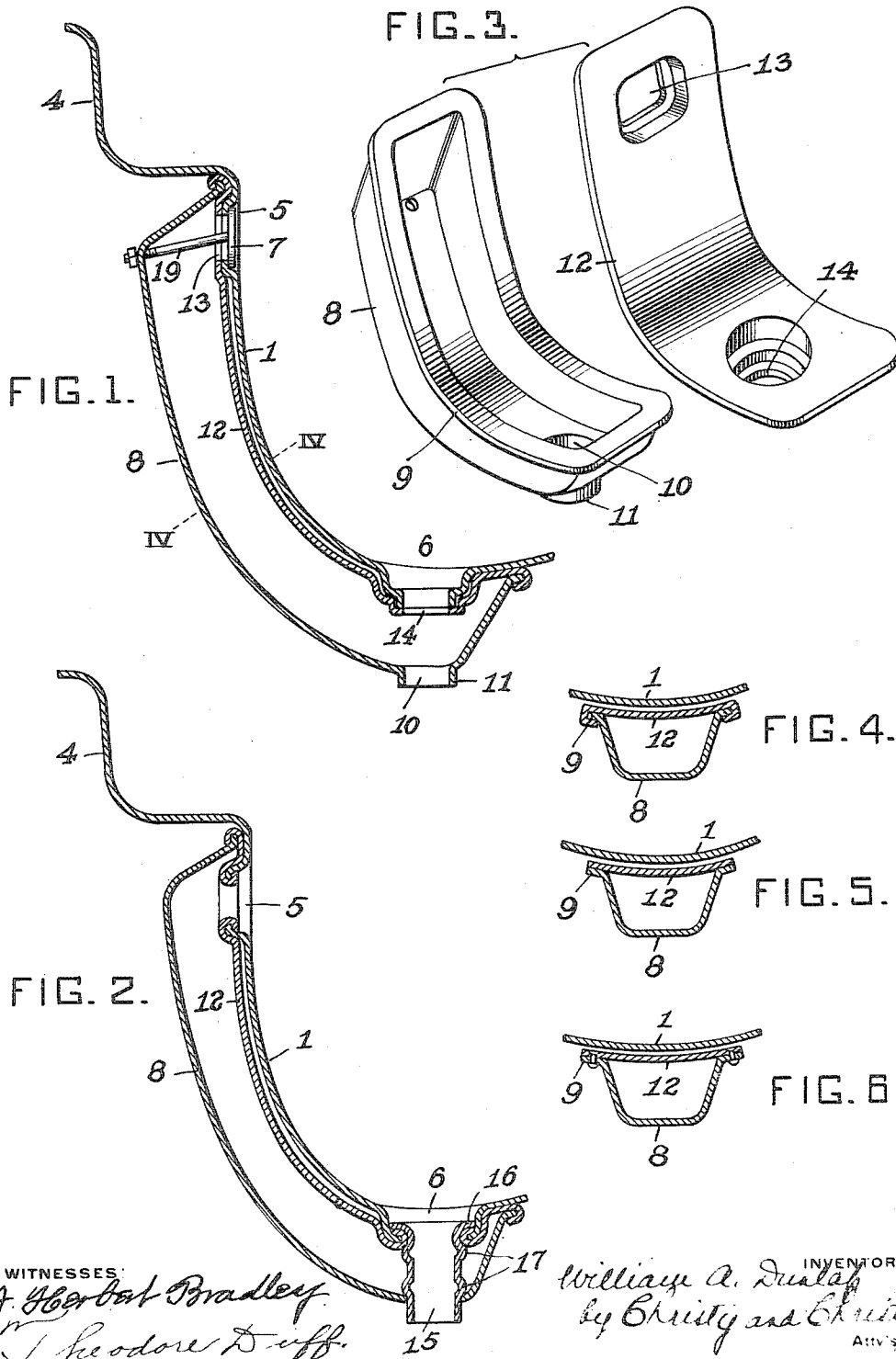


W. A. DUNLAP.
MANUFACTURE OF BASINS, &c.
APPLICATION FILED NOV. 10, 1909.

1,051,394.

Patented Jan. 28, 1913.



WITNESSES:
J. Herbert Bradley
Theodore Duff

INVENTOR
William A. Dunlap
by *Christy and Christy*
ATTY'S

UNITED STATES PATENT OFFICE.

WILLIAM A. DUNLAP, OF PITTSBURGH, PENNSYLVANIA.

MANUFACTURE OF BASINS, &c.

1,051,394.

Specification of Letters Patent.

Patented Jan. 28, 1913.

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To all whom it may concern:

Be it known that I, WILLIAM A. DUNLAP, residing at Pittsburgh, in the county of Allegheny and State of Pennsylvania; a citizen of the United States, have invented or discovered certain new and useful Improvements in Manufacture of Basins, &c., of which improvement the following is a specification.

The invention described herein relates to certain improvements in basins for lavatories, kitchens, etc., of the class or kind forming the subject matter of an application Ser. No. 431,387 filed by me May 6, 1908, and is hereinafter more fully described and claimed.

In the accompanying drawings forming a part of this specification Figure 1 is a sectional elevation of a basin embodying my improvement. Fig. 2 is a sectional view of a portion of the basin illustrating a modification in the structure. Fig. 3 shows perspective views of the parts of the overflow pipes, and Fig. 4 is a transverse section on a plane indicated on the line IV—IV Fig. 1. Figs. 5 and 6 are similar sectional views showing modifications in the method of joining together the two parts of the overflow pipe.

In the practice of my invention the bowl together with the roll 2, apron 3 and back piece 4 are preferably formed integral from a sheet of metal, preferably sheet steel by stamping or other suitable method known in the art. As a portion of the stamping operation or subsequent thereto outlets 5 and 6 are formed by projections or otherwise. The outlet 5 which will be hereafter termed overflow is formed near to the top of the basin, and the outlet 6, hereafter termed the discharge is formed at the lowest point of the basin. In forming these outlets it is preferred to form enlargements thereof at the inner ends to provide seats for the reception of the strainer 7 and the stopper to the discharge outlet. Provision is made for connecting the overflow with the main discharge pipe leading to the sewer by means of a tube, preferably conforming in curvature of the bowl and arranged outside of the latter. In the present construction this tube or connection is formed of sheet metal or of the same material as that from which the bowl is formed, and for convenience of manufacture the tube is formed in two sections. One, the trough-shaped sec-

tion is stamped up from a sheet of metal and preferably provided with a flange 9 extending around the open side as shown in Fig. 3. At the lower end of this trough shaped piece a discharge outlet 10 is formed which when the tube is in position will be in alinement with the discharge outlet 6 from the bowl. In the construction shown in Figs. 1 and 3 the discharge opening is so formed as to provide a nipple 11 for connection with the waste pipe. This tubular connection 8 is completed by a strip 12 of sheet metal bent to conform to the curve of the trough-shaped portion 8, and provided adjacent to its ends with openings 13 and 14, so arranged that when the tube is applied to the bowl these openings will be in alinement with the overflow and discharge outlets of the bowl. In forming these openings in the strip 12 recesses or depressions are formed around the opening for the reception of the metal projecting on the under face of the bowl and formed in shaping the seats 5 and 6 around these outlets. The purpose of this construction is to insure a close fitting of the tube to the bowl. The strip 12 may be secured on the trough-shaped portion 8 by bending the edges of the strip 12 around the flanges 9 of the trough-shaped portion as shown in Fig. 4. This connection of the two sections of the tube may be rendered more secure by welding the turned over strip to the trough, or the strip may be welded to the trough without any turning over of the edges thereof, as shown in Fig. 5 or further the strip may be riveted to the flanges 9 as shown in Fig. 6. After the tube has been completed in the manner described it may be secured to the bowl by welding or in any suitable manner known in the art. As for example in lieu of welding the tube may be held in place by folding the metal at the edges of the openings 13 and 14 around the edges of the overflow and discharge outlets of the bowl as shown in Fig. 2. In lieu of forming a nipple 11 integral with the trough-shaped portion 8 as shown in Fig. 1 a section of tube 15 may be inserted to the discharge opening in the bowl, a tube being held therein in any suitable manner, as by a flange 16 and by swells or enlargements 17 as shown in Fig. 2. This tube section should extend sufficiently far below the outflow connection to permit of the arrangement of the waste pipe thereon.

After the bowl has been thus completed a suitable protective coating, preferably enamel is applied thereon, the coating being in a liquid form so that all of the surface both inner and exterior will be completely covered by a continuous uniform coating which will not only protect the surface, but will also completely and hermetically seal all the joints. The strainer 7 may be held in position by any suitable means, but preferably in such manner as to permit of its easy removal, as for example the strainer is provided with a stem 19 extending back through the wall of the overflow tube and has its projecting end threaded for the reception of a retaining nut.

I claim herein as my invention:

1. A basin, sink, etc., formed of sheet metal and provided with over-flow and discharge openings in combination with a tube formed of longitudinal sections suitably shaped from sheet metal and welded together and secured to the basin, etc., in such manner as to connect the over-flow and discharge openings, the basin and tube having all exterior and interior surfaces covered by a continuous coating of enamel.

2. The combination with a vessel having a main outlet opening and an overflow outlet opening, of an overflow conduit, and an independent intermediate attaching base secured to the vessel and to the conduit, substantially as set forth.

3. The combination with a pressed metal vessel having a main outlet opening and an overflow outlet opening, of an overflow conduit of pressed metal, and an intermediate attaching base of pressed metal secured to the vessel by engaging flanges thereof surrounding the outlet openings, and to the conduit by flanges bent into holding engagement with the edges of the conduit, substantially as set forth.

4. The combination with a pressed metal vessel having a main outlet opening and an overflow outlet opening, of an attaching base having corresponding openings and secured to the vessel at said openings by engaging flanges, and a conduit having its

edges bent to connect with the edges of the base, substantially as set forth.

5. The combination with a pressed metal vessel having a main outlet opening and an overflow outlet opening, of a pressed metal conduit communicating with the main outlet and connected with the overflow outlet by an intermediate apertured base having its edge portions surrounding the aperture connected with the edges of the vessel and its outer edges connected with the edges of the conduit respectively, substantially as set forth.

6. The combination with a pressed metal vessel having a main outlet opening and an overflow outlet opening, of a pressed metal conduit communicating with the overflow outlet, and connected with the main outlet by an intermediate apertured base having its edge portions surrounding the aperture connected with the edges of the vessel and its outer edges connected with the edges of the conduit respectively, with an outlet nipple extending through said outlet opening and the wall of the conduit and secured thereto, substantially as set forth.

7. The combination with a vessel having a main outlet opening, and an overflow outlet opening, of an open-front overflow conduit of pressed metal, and means for securing the front portions of said conduit around the main and overflow outlet openings and for completing the inclosure of the conduit space, substantially as set forth.

8. The combination with a vessel having a main outlet opening and an overflow outlet opening, of an open-front overflow conduit of pressed metal, means for securing the terminal portions of said conduit to the vessel around said openings and for closing the intermediate circulation space of the conduit, and an outlet nipple incorporated in the main opening, substantially as set forth.

In testimony whereof, I have hereunto set my hand.

WILLIAM A. DUNLAP.

Witnesses:

ALICE A. TRILL,
FRANCIS J. TOMASSON.