

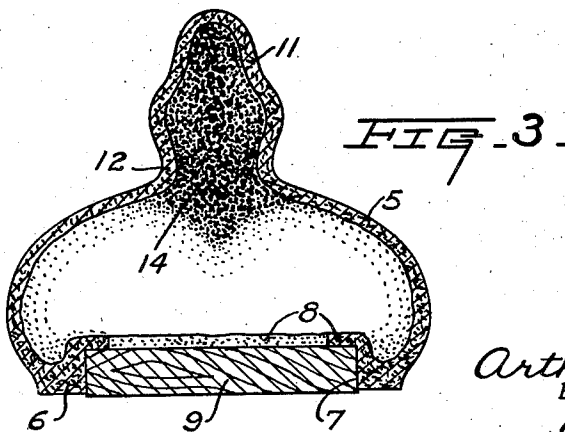
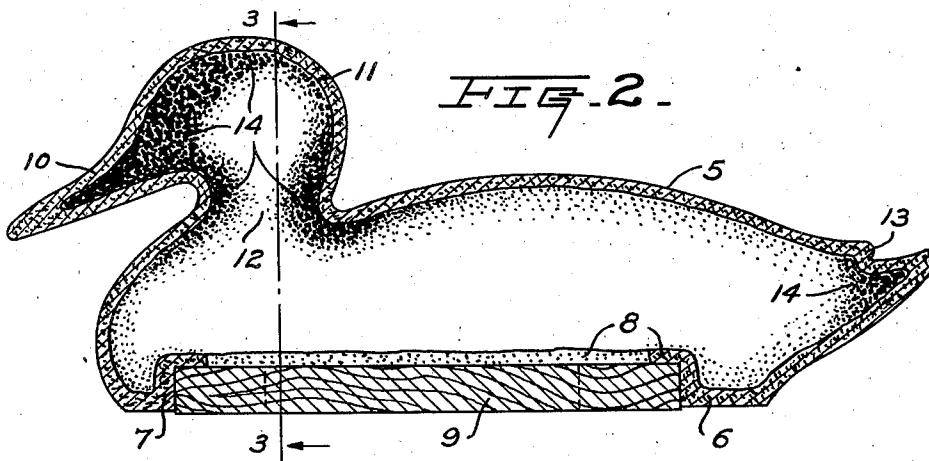
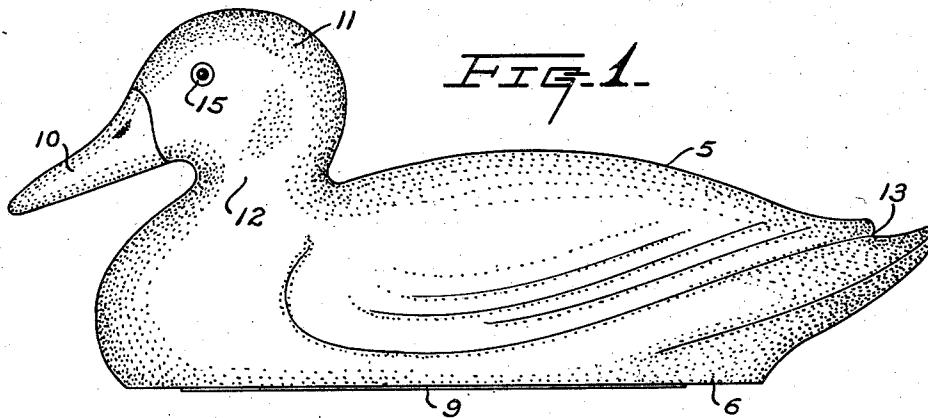
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2,453,758

ART OF MANUFACTURING AQUATIC DECOYS

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ART OF MANUFACTURING AQUATIC
DECOYS

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2 Claims. (Cl. 43-3)

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This invention relates in general to improvements in the art of producing hunters' decoys, and relates more specifically to an improved aquatic decoy and to an improved mode of manufacturing the same from fibrous pulp or the like.

It has heretofore been proposed as shown and described in Patent No. 2,247,450, granted July 1, 1941, to construct aquatic hunters' decoys from molded fibrous pulp or the like, and thousands of these decoys have in fact been manufactured and used with great success. These pulp decoys are formed in molds with the aid of suction applied through the molding or forming surfaces, and the molded hollow bodies or shells are subsequently water-proofed and painted to simulate various kinds of birds and especially water fowl. While the molded pulp shells thus produced are of relatively uniform thickness and strength throughout their entire areas and may be uniformly coated and impregnated with water-proofing material, it has been found that after the decoys have been in use for some time and have frequently been subjected to water for extended periods of time, certain portions thereof are liable to become water-logged and weakened sufficiently to cause breakage, especially at the bills, heads, necks, and tail portions. While various attempts have heretofore been made to overcome this annoyance, none were entirely satisfactory, but I have discovered that the difficulty may be effectively eliminated by coating the pulp shells of such aquatic decoys at the troublesome areas, with heavy water repellant and reinforcing material such as hot asphalt or the like.

It is therefore the primary object of my present invention to provide an improved aquatic molded pulp decoy and an improved method of producing the same, whereby a strong and extremely durable product results and the life of the decoys is prolonged indefinitely even when subjected to severest uses.

Another object of the invention is to provide simple and effective means for increasing both the strength and water-repellant quality of molded pulp decoys, without materially increasing the weight, cost of manufacture, or degrading the aesthetic appearance thereof.

These and other objects and advantages of the invention will be apparent from the following description.

A clear conception of the specific mode of carrying on commercial exploitation of my invention, may be had by referring to the drawing accompanying and forming a part of this specification

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wherein like reference characters designate the same or similar parts in the various views.

Fig. 1 is a side elevation of one of my improved aquatic molded pulp decoys, specifically simulating a swimming duck;

Fig. 2 is a central longitudinal vertical section through the duck decoy of Fig. 1; and

Fig. 3 is a transverse vertical section through the same decoy, taken along the line 3-3 of Fig. 2.

Although the improvement has been shown and described herein as having been specifically applied to a typical molded fibrous pulp duck decoy, it is not my desire or intention to unnecessarily restrict the utility by virtue of this specific embodiment, since the invention is more generally applicable to various types of aquatic fowl and other decoys made of relatively light moldable material such as news-print pulp or papier-mâché.

Referring to the drawing, the typical aquatic fowl decoy specifically shown, comprises in general a light but sturdy hollow molded body or shell 5 of approximately uniform thickness throughout and being formed of fibrous pulp to simulate the body of a floating duck having a flat base 6 provided with an extensive opening or recess 7 therein. The upper portion of this recess 7 is bounded by a continuous inwardly extending flange 8 formed integral with the body shell 5, and a wooden closure plate 9 is snugly confined within the recess 7 and coacts along its top with the flange 8 while the bottom surface of the plate is substantially flush with the lower surface of the base 6. The exterior of the body shell 5 is fairly smooth and is painted or otherwise decorated to simulate the specific type of bird which it represents, but the entire interior of this body is relatively rough and unfinished. In accordance with the present improvement, local areas of the rough interior of the body 5, such as the bill 10, head 11, neck 12 and tail 13, are preferably provided with a rather heavy protective coating 14 of relatively hard, tenacious, and water-repellant material such as asphalt, and the plate 9 may be firmly cemented or otherwise secured within the recess 7 and to the flange 8.

When producing these improved reinforced pulp decoys in accordance with my improved method, the body shells 5 are first molded in suction molds in a well known manner with the recesses 7 open for access to the body interiors. The internal local areas of the unfinished bodies 5 are then coated as desired with hot asphalt which may be applied in coatings 14 of suitable

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thickness in any convenient manner. The entire shell 5 should thereafter be coated and impregnated with other effective water-proofing liquid so as to make the bodies water resistant. The closure plates 9 after having been properly formed of wood or the like, and painted, should subsequently be firmly and snugly cemented within the recesses 7 and against the internal flanges 8, the latter providing stops for accurately positioning the plates 9. Finally the exteriors of the decoys should be appropriately painted and the eyes 15 may be applied to the heads 11 in any convenient manner, thus producing durable and exceedingly light and attractive completed decoys.

From the foregoing detailed description, it should be apparent that my present invention provides an improved aquatic molded pulp decoy which is light and durable in construction, and a simple but effective method of producing the same. The body shells 5 may be rapidly and effectively manufactured with standard suction molding equipment, and subsequently thoroughly reinforced and strengthened by the application of the local internal coatings 14 of asphalt or the like, and these coatings also serve to additionally protect the local areas against possible weakening and softening due to water logging. The open recesses 7 permit quick and convenient internal application of the coatings 14, and these recesses may be subsequently tightly sealed by the closure plates 9; and the additional water-proofing and decorative painting of the entire assemblages, most effectively protects these decoys against possible damage and deterioration by exposure to water or other moisture. The application of the internal reinforcing coatings 14 also protects the shells 5 against easy perforation by shot, and furthermore makes the interiors of the decoys extremely resistant to absorption of water which may enter the bodies through shot holes or other crevices produced by hard usage. The addition of the asphalt coatings 14 does not objectionably increase the total weight of the improved decoys, but has been found to materially increase the strength and ultimate life thereof; and the added cost due to the addition of the reinforcing coatings, is negligible. It is also to be noted that the improved decoys are entirely devoid of metal and are perfectly balanced to maintain an upright position primarily by the use of the relatively heavy wood plates 9 which close the recesses 7.

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It should be understood that it is not desired to limit this invention to the exact details of construction or to the precise sequence of steps involved in the method, herein shown and described, for various modifications within the scope of the appended claims may occur to persons skilled in the art.

I claim:

1. A molded pulp aquatic decoy comprising, a hollow molded fibrous shell having a continuous wall of substantially uniform thickness throughout and having an opening therein through which the fibrous material is admitted during molding, said wall forming the main body portion having weakened local portions projecting therefrom, asphalt coatings thickly applied to the interior surface of said shell at the local areas of weakness of said projecting portions to reinforce and waterproof the same, said asphalt being introduced to the shell interior through said opening, and means for sealing said opening.

2. A molded pulp aquatic decoy comprising, a hollow molded fibrous shell having a continuous wall of substantially uniform thickness throughout and having an opening therein through which the fibrous material is admitted during molding, said wall forming the main body portion having points of abrupt curvature forming weakened areas, asphalt coatings thickly applied to the interior surface of said shell at the local areas of weakness of said points of abrupt curvature to reinforce and waterproof the same, said asphalt and said waterproofing material being introduced to the shell interior through said opening, and a plate sealing said opening.

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