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1,952,828

METHOD OF MAKING COMPOSITION ROOFING

Filed Nov. 14, 1928

Fig. 1.

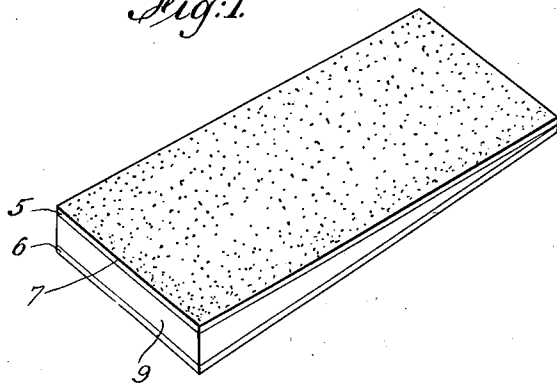


Fig. 2.

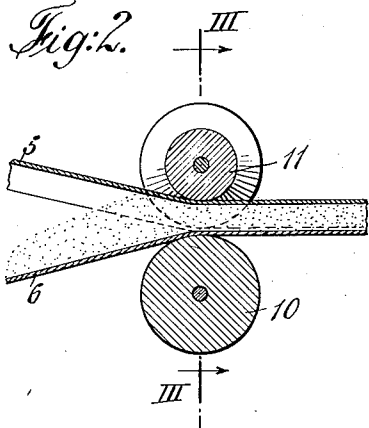


Fig. 3.

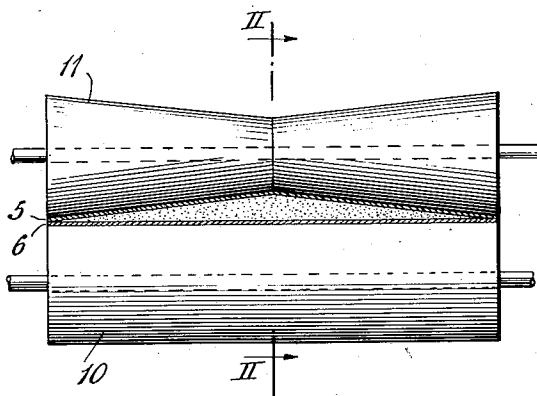
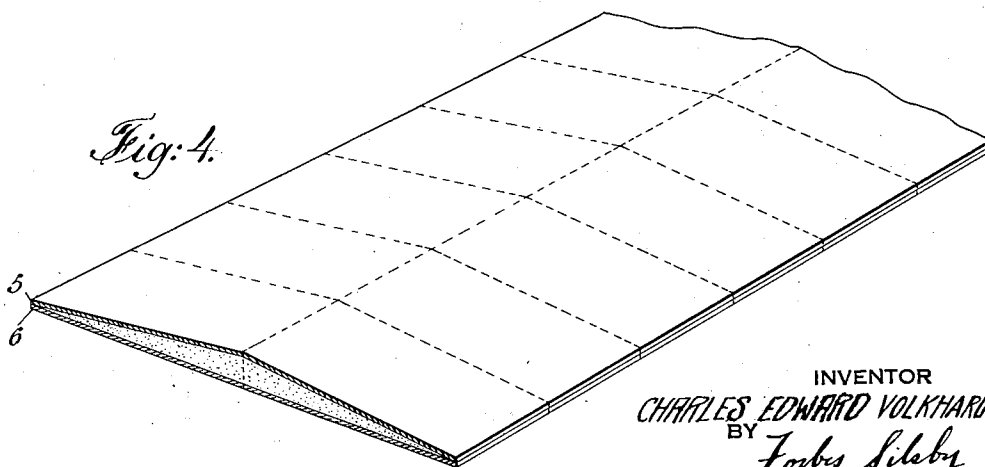


Fig. 4.



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METHOD OF MAKING COMPOSITION ROOFING

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6 Claims. (Cl. 154—2)

The present invention relates to roofing and has for an object to provide an improved tapered composition shingle and an improved method of manufacturing the same.

The nature and objects of the invention will be better understood from a description of an illustrative embodiment for the purpose of which description reference should be had to the accompanying drawing forming a part hereof and in which—

Figure 1 is a perspective view of a finished shingle embodying the invention, the thickness of the several plies of the material being shown exaggerated;

Figure 2 is a central sectional view taken on the line 2—2 of Fig. 3 showing a set of rolls used in the process of manufacturing the shingle;

Figure 3 is a sectional view taken on the line 3—3 of Fig. 2 showing the rolls in elevation, and

Figure 4 is a perspective view indicating the manner of cutting the complete strip into individual shingles.

The shingle to be described for the purposes of illustrating the invention is shown in perspective in Fig. 1 as consisting of two plies of roofing fabric 5 and 6 between which is a tapered body of asphalt 9 preferably of a quality having a melting point of approximately 220° F., which will impart considerable rigidity to the finished shingle. The roofing fabric 5 or 6 is the material commonly referred to as prepared or mineral surfaced roofing, which is roofing felt saturated and coated with tar, asphalt or other bituminous material to which may be applied a fine granulated mineral coating such as crushed slag, or the like.

The top layer 5 would preferably be mineral surfaced as indicated by the stippling 7, while the bottom layer 6 would preferably be of the same general type of roofing but without mineral surfacing.

The invention provides an improved method of making the shingle which comprises combining two strips of roofing fabric with an intermediate body of asphalt. As shown, diagrammatically, in Figs. 2 and 3, the asphalt, preferably continuously fed from a hopper or other container (not shown) is interposed between two continuously moving sheets of roofing fabric 5, 6 which are rolled together between a lower straight roller 10 and an upper formed or shaped roller 11. Rollers 10 and 11 are so positioned as to roll the strip to a transversely tapered form, the center being of the thickness of the butts of the shingles to be made and the edges being as thin as practically possible. Roller 11 may be shaped to form

the strip to a transversely tapered form so that three, four or more transversely tapered strips are formed.

If desired sheets 5 and 6 may be roofing felt saturated but uncoated, and the asphalt and mineral surfacing may be applied to sheet 5 and the seal back coating and mica or dust to the bottom of sheet 6 after the sheets 5 and 6 have been bonded by the tapered body of asphalt. The strip may then be severed longitudinally to form two transversely tapered roofing sections and if strip or single shingles are desired these sections are cut to form individual shingles, as indicated in Fig. 4 or strip shingles as will be readily understood.

While a preferred embodiment of the invention has been shown and described, it will be understood that various changes in the details thereof may be made and this invention is not to be limited to the disclosure herein but only by the scope of the appended claims.

I claim:

1. The method of making tapered composition shingles which comprises continuously feeding two long strips of roofing felt in spaced relation, continuously inserting between said strips a body of asphalt, compressing and molding the strips and asphalt to form a transversely tapered long shingle strip and severing said strip longitudinally and transversely to form shingles.

2. The method of making tapered composition shingles which comprises introducing between two long strips of roofing fabric and of a width equal to twice the length of a shingle a body of asphalt, compressing and molding the strips and asphalt to a form thick at the center and transversely tapered toward both edges, severing said strip longitudinally to form two transversely tapered sections and cutting the sections transversely to form shingles, substantially as described.

3. The method of making tapered composition shingles which comprises introducing between two long strips of roofing felt saturated with waterproofing material and of a width equal to twice the length of a shingle a body of asphalt, compressing and molding the strips and asphalt to a form thick at the center and transversely tapered toward both edges, applying to one face a coating of adhesive waterproofing material and a coating of granulated mineral material and to the opposite face a coating of mica, severing said strip longitudinally to form two transversely tapered sections and cutting the sections transversely to form shingles, substantially as described.

4. The method of making tapered composition

shingles which comprises continuously feeding two long strips of roofing felt saturated with waterproofing material and of a width equal to twice the length of a shingle, continuously introducing between said strips a body of asphalt having a melting point of approximately 220° F., compressing and molding the strips and asphalt to a form thick at the center and transversely tapered toward both edges, applying to one face of the thus molded strips a coating of adhesive waterproofing material and a coating of granulated mineral material and to the opposite face a coating of mica, severing said strip longitudinally to form two transversely tapered shingle strip sections and cutting the sections transversely to form shingles.

5. The method of making a tapered roofing strip which comprises continuously feeding two long sheets of roofing fabric in spaced relation, con-

tinuously inserting bituminous material between said sheets and compressing and molding said sheets and bituminous material to form a transversely tapered long roofing strip, and cutting said roofing strip into shingles.

6. The method of making tapered composition shingles which comprises introducing between two strips of roofing fabric each of a width greater than the length of the shingles a body of bituminous material, compressing and molding the strips and bituminous material to a form thick at points longitudinally of the strips and transversely tapered from such points toward both edges, severing said strip longitudinally to form transversely tapered sections and cutting the sections transversely to form tapered shingles.

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