Oct. 9, 1962 I. RICHER 3,057,461

GARMENT BOX

Filed May 26, 1960 3 Sheets-Sheet 1

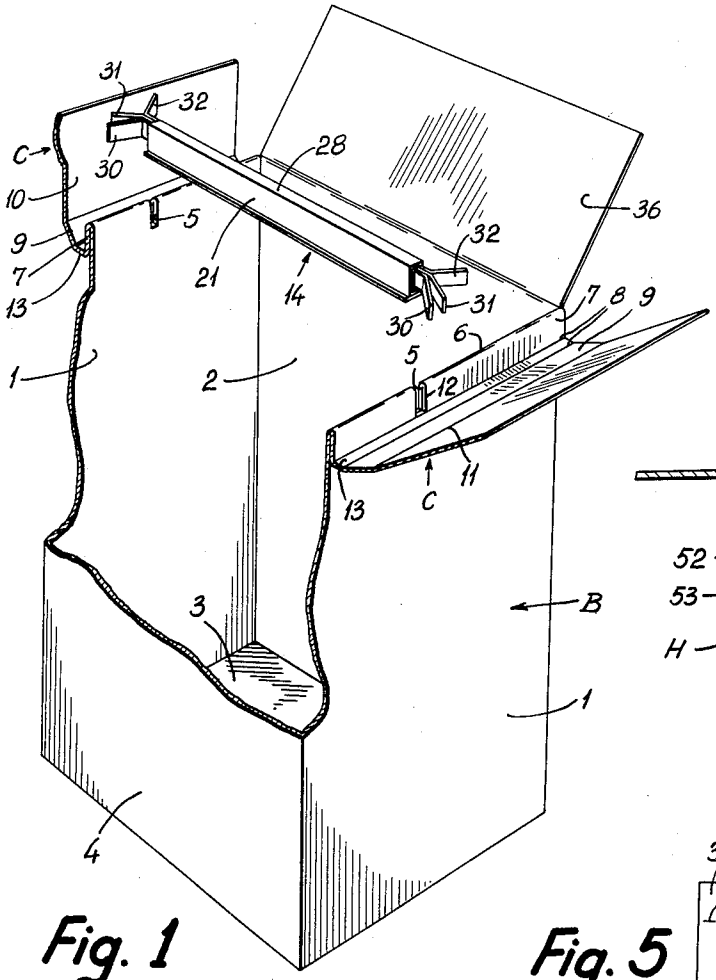


Fig. 1

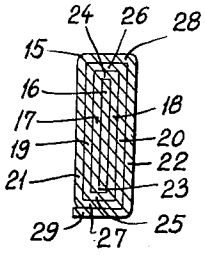


Fig. 4

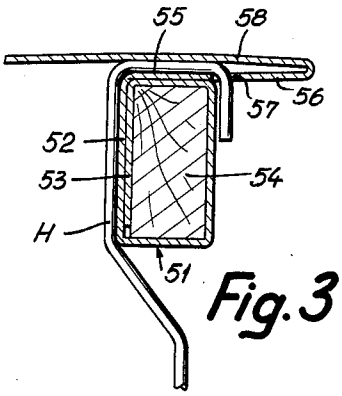


Fig. 3

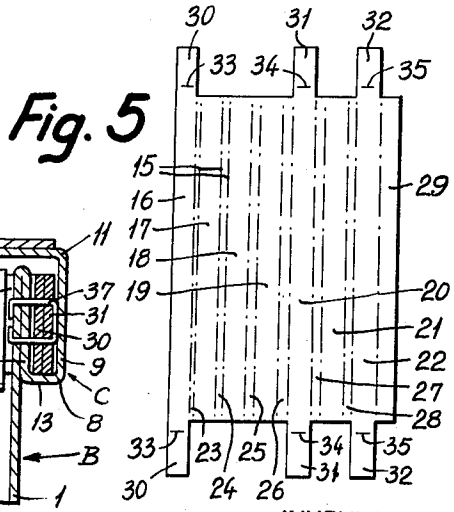


Fig. 5

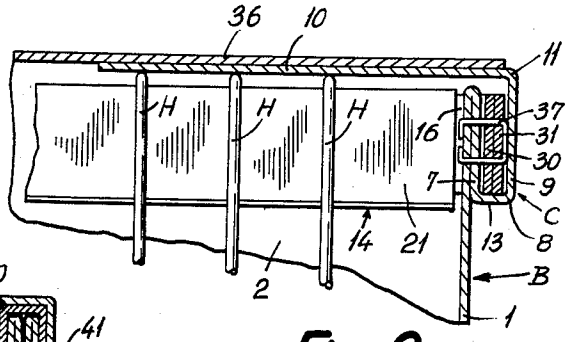


Fig. 2

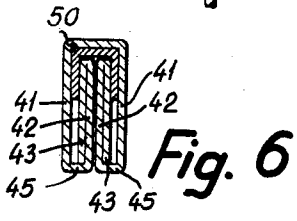


Fig. 6

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GARMENT BOX

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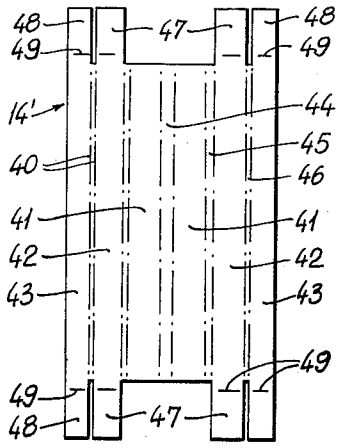


Fig. 7

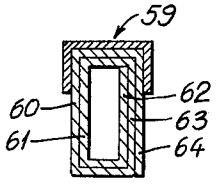


Fig. 8

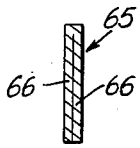


Fig. 9

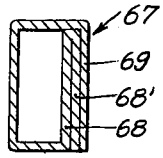


Fig. 10

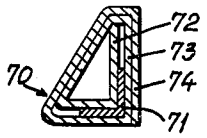


Fig. 11

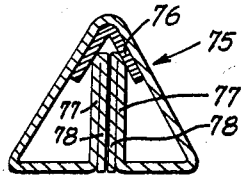


Fig. 12

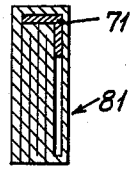
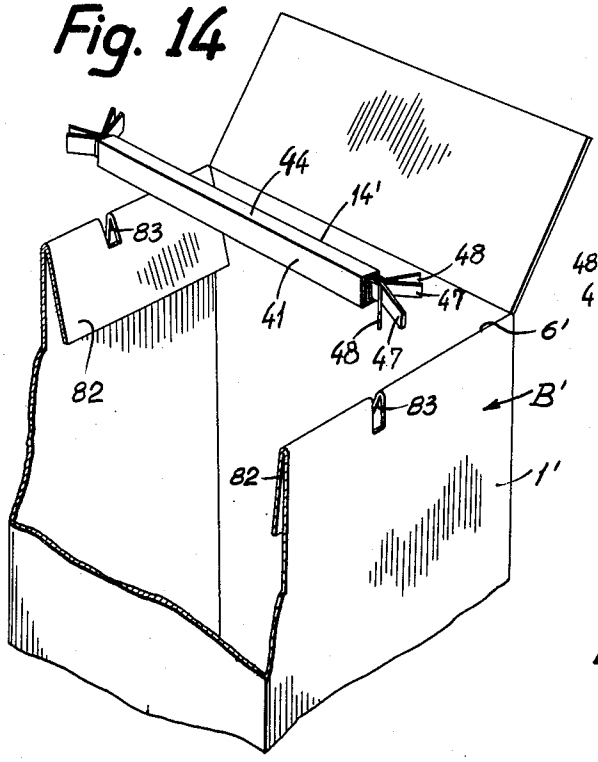


Fig. 13

Fig. 14



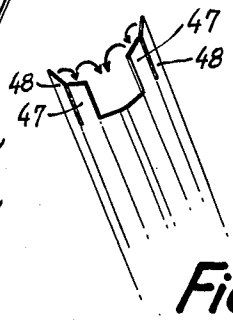


Fig. 15

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GARMENT BOX

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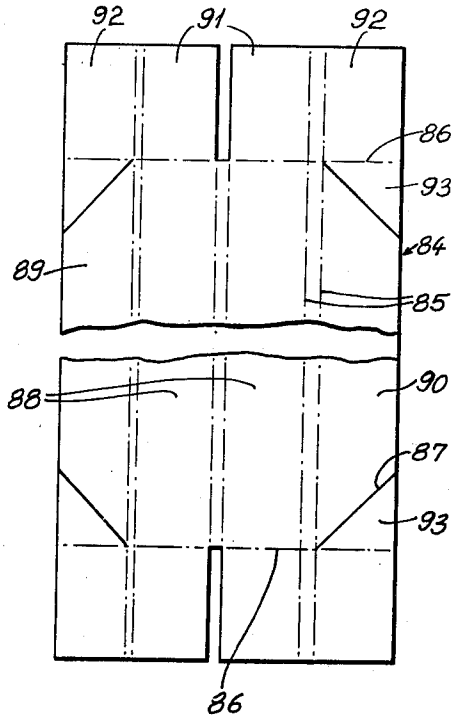


Fig. 18

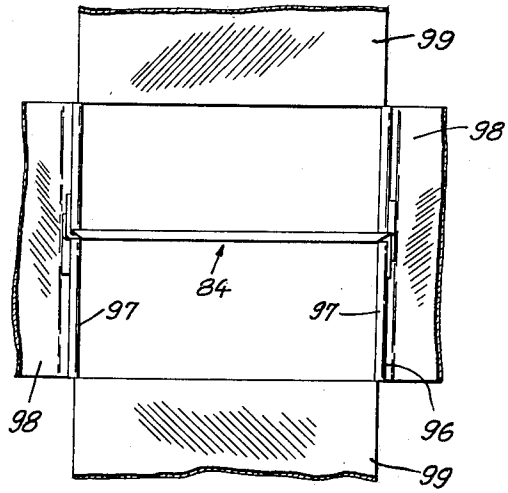


Fig. 16

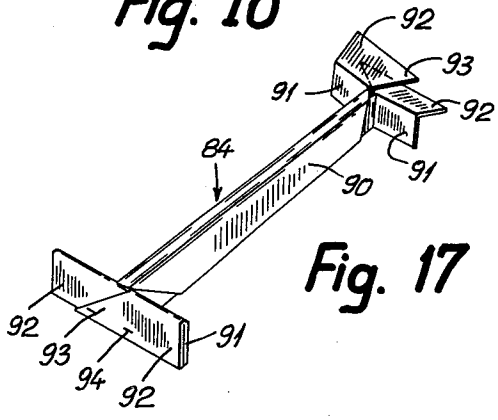


Fig. 17

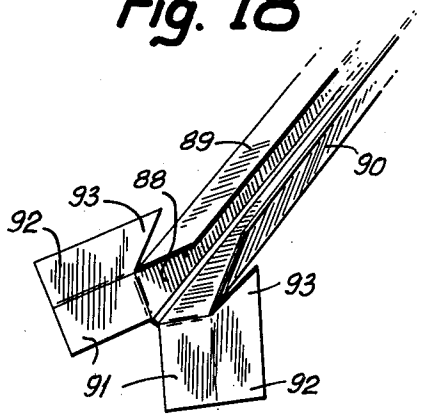


Fig. 19

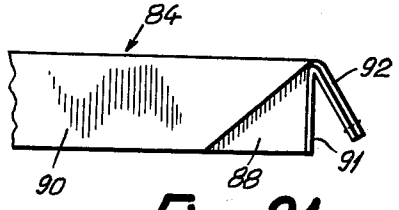


Fig. 21

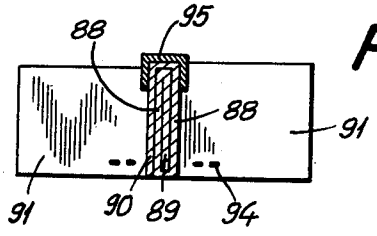


Fig. 20

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United States Patent Office

3,057,461
Patented Oct. 9, 1962

3,057,461

GARMENT BOX

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Filed May 26, 1960, Ser. No. 32,049
27 Claims. (Cl. 206—7)

The present invention relates to shipping containers or garment boxes made of corrugated fibreboard, and more particularly to a new and improved manner of suspending garments in such a box.

In conventional shipping containers or garment boxes of the type in which a transversely extending suspension bar for hangers is supported by a pair of opposed side walls of the box, the bar is always supported on the top edge of said opposed side walls; for example, Canadian Patent 538,441, my own U.S. Patent No. 2,827,160 and my co-pending patent applications Serial Nos. 7,787, and 7,915, both filed February 10, 1960, describe such arrangement.

I have now found that the resistance to collapse of the side walls and bar under impact is greatly increased when the suspension bar is resting and is supported by the side walls at points spaced downwardly from the top edge of said side walls.

Accordingly, the main object of the present invention resides in the provision of a garment box having a greatly improved resistance to impact.

A very important object of the present invention resides in the manner of supporting a hanger bar on the side walls of a container in a plane below the level of the top edges of the container side walls by means of the bar passing through slits made in the upper edges of said container side walls and having no part straddling or overlying said top edges.

Another object of the invention resides in the provision of a garment box having a hanger suspension bar which is of simplified construction and facilitates suspending of the hangers thereon.

Another object of the invention resides in the provision of a suspension bar for a garment box made of fibreboard material and reinforced by a rigid unit made of metal, wood, or the like.

Yet another important object of the present invention resides in a modification specially designed for light weight garments.

Still another object of the invention resides in the provision of a suspension bar provided with means for positively locking the hanger hooks in position.

Yet another important object of the present invention resides in the provision of a hanger bar which can be sold in blank form and readily and easily folded by the user into bar form.

The foregoing and other important objects of the present invention will become more apparent during the following disclosure, and by referring to the drawings, in which:

FIGURE 1 is a partially cut away perspective view of a garment box with one embodiment of the suspension bar;

FIGURE 2 is a partial cross-section of the assembled bar and box;

FIGURE 3 is a cross-section of a second embodiment of the hanger bar provided with a hanger locking flap;

FIGURE 4 is a cross-section of the hanger bar of FIGURE 1;

FIGURE 5 is a plan view of the blank for making the bar of FIGURES 1 and 4;

FIGURE 6 is a cross-section of a third embodiment of the bar;

FIGURE 7 is a plan view of the blank for making the bar of FIGURE 6;

FIGURES 8 to 13 are cross-sections of additional embodiments of the hanger bar;

FIGURE 14 is a partial exploded perspective view of a modified box with the hanger bar of FIGURES 6 and 7;

FIGURE 15 is a partial perspective view showing how the blank of FIGURE 7 is folded to form the bar of FIGURE 14;

FIGURE 16 is a top partial plan view of the box of FIGURE 1 provided with still another embodiment of the suspension bar of the invention;

FIGURE 17 is a perspective view of the bar of FIGURE 16, one end being shown partially folded;

FIGURE 18 is a plan view of the blank for making the bar of FIGURE 17;

FIGURE 19 is a partial perspective view of the partially folded blank;

FIGURE 20 is a cross-section through the center of the bar of FIGURE 17; and

FIGURE 21 is a partial side elevation of the same bar, the outer flaps being partially folded.

Referring now more particularly to the drawings in which like reference characters indicate like elements throughout, reference character B indicates a garment shipping container entirely made of corrugated fibreboard and comprising a pair of opposed side walls **1**, a back wall **2** and a bottom **3**. The front of the box may be closed in any manner desired and may have for instance a front wall **4**, partially shown.

In accordance with the invention, it is essential that a pair of slits **5** be made in the top portion of the side walls **1** in registering relationship, said slits downwardly extending from the top edge **6** of side walls **1**.

A wing forming a supporting channel member C and closure flap **10** is integrally connected to side walls **1** by the folded line formed at the top edge **6** of said side walls **1**. Channel member C is formed by leg **7**, double fold line **8** and leg **9**, the closure flap **10** being connected to leg **9** by fold line **11**. Each leg **9** is provided with a slit **12** registering with the contiguous slit **5**. Slits **5** and **12** extend downwardly to the bottom **13** of the channel defined by double fold line **8**.

The suspension bar **14**, shown in FIGURE 1, is made from the blank shown in FIGURE 5; this blank consists of corrugated fibreboard of generally rectangular shape provided with longitudinally extending fold lines **15**, the spacing of which gradually increases to define flanges **16**, **17**, **18**, **19**, **20**, **21** and **22** of gradually increasing width with intervening webs **23**, **24**, **25**, **26**, **27**, **28** and **29**, also of increasing width but narrower than the flanges. Flanges **16**, **20** and **22** are provided with integrally connected flaps **30**, **31** and **32** at both ends of said flanges connected along transverse fold lines **33**, **34** and **35** respectively which are spaced from the ends of the flanges devoid of flaps.

The blank of FIGURE 5 is folded over itself about the longitudinal fold lines **15**, such as to present the cross-section, shown in FIGURE 4, the flange **16** being inside and the web **29** being outside; thus the blank forms the bar **14** of substantially rectangular cross section and of elongated shape from the ends of which project the flaps **30**, **31** and **32** which are inserted on edge through the registering slits **5** and **12** of box B; the flaps are contiguous up to the transverse fold lines **33** to **35** and are then bent or folded at substantially right angles with one flap on one side, and the remaining flaps on the opposite side, such that said flaps rest at their bottom edge mainly on the bottom **13** of externally disposed channel C and if desired partially on the bottom of the slits **5** and **12**.

Because flaps **30**, **31** and **32** are solely connected to the bar at the transverse fold lines **33** to **35** and are otherwise free of any connection to the main body of the bar, the bar is thus supported at points spaced downwardly from

the top edges 6 of the box, namely, at the bottom of the channel C and partially at the bottom of slits 5 and 12. Hanger hooks H can be easily suspended on the bar which is of rectangular section with the hook overlying the top web of the bar. When the garments and hanger hooks have been placed within the box, the closure flaps 10 are then folded back over the hangers, as shown in FIGURE 2, and the closure flap 36 from the back wall 2 is folded over closure flaps 10. The box can be stapled, gummed, taped or strapped to maintain the same in closed position.

The flaps of the suspension bar can be left free within the supporting channel C, or be stapled by staples 37 passing through flaps 30, 31 and 32 and through legs 7 and top portion of side walls 1 of the box.

Because of the multi-layer construction of the bar 14, the latter has an overall thickness greater than the thickness of the contiguous flaps 30, 31 and 32, thus the bar has resistance to laterally exerted forces.

The downward pressure of the weight of the garment suspended on the bar 14 is directly supported by the bottom 13 of the channel C; the resisting forces exerted are distributed through leg 7 to a substantial length of the top edge 6 of the side wall, thereby considerably improving resistance to impact.

Staples 37 when used, positively prevent the flaps 30, 31 and 32 from sliding inwardly through the slits, should the bar partially collapse under impact.

The suspension bar can be made in accordance with various modifications all characterised by the fact that they have freely extending flaps for insertion through slits 5 and 12 and for folding outwardly at the exterior of the side wall and being also characterised by the fact that there are no parts of the bar directly resting on the top edges 6 of the side walls.

FIGURES 6, 7 and 14 show a bar 14' of symmetrical construction. The blank, shown in FIGURE 7, is of generally rectangular shape having longitudinally extending fold lines 40 defining two symmetrical portions on each side of the central fold lines and constituted by flanges 41, 42 and 43, central web 44 and webs 45 and 46. Flaps 47 and 48 depend respectively from flanges 42 and 43 on both sides of the central web 44, and are integrally connected to their associated flanges by transverse fold lines 49. The blank of FIGURE 7 is folded inwardly in accordance with the arrows, as shown in FIGURE 15, starting from the outside flanges 43, so as to form a bar, the cross-section of which is shown in FIGURE 6, such that flaps 47 and 48 depend from the four contiguous internal layers formed by flanges 42 and 43, thus the flaps can be folded about their transverse fold lines 49 at right angles to the long axis of the bar in two oppositely directed pairs, as shown in FIGURE 14. This bar can thus be inserted in slits 5 and 12 of the box B of FIGURE 1, to rest at the bottom 13 of the channel C.

For heavy garments, an inverted metal channel 50 can be easily inserted just underneath the central web 44 and in direct contact with the inside of flanges 41, as shown in FIGURE 6, to considerably reinforce the corrugated fibreboard bar 14'. The channel can be replaced by an angle bar, such as angle bar 71 of FIGURE 13, if so desired. A metal channel or angle bar can be used also in combination with any of the bars of the invention. The metal channel 50 can be also fitted on top of the fibreboard bar as shown at 59 in FIGURE 8; this applies for any bar of the invention, and will hold the flanges of the bar together.

FIGURE 3 is a cross section of a bar 51 made from a blank to provide a rectangular hollow bar, each of the contiguous flanges 52 and 53 of which are provided with end flaps at both ends thereof. The bar may be left hollow or be provided with a reinforcing wooden bar 54 inserted therethrough. The top web 55 is conveniently extended, as shown at 56, and provided with a longitudinally extending slot 57 adjacent one side of the bar for receiving the hook of hanger hooks H. The extension 56 is integrally connected to a hook locking flap 58 which will be maintained on the top of the hook to prevent disengagement of the same from the bar 51 being held downwardly by the closure of the box. Instead of the wooden bar 54, a metal channel 50 or an angle bar 71 may be used with the bar of FIGURE 3.

FIGURE 8 shows a cross section of another modification of the suspension bar made from one blank provided with longitudinally extending fold lines and wound over itself to provide a rectangular cross section. In this case, the end flaps can depend from the two contiguous flanges 60 and 61 or from two or more of the contiguous flanges 62, 63 and 64.

FIGURE 9 shows a cross section of a bar 65 which is preferably made of sheet metal providing two contiguous flanges 66 forming an inverted U and each flange having at both ends thereof an end flap bent at right angles. This bar 65 may be made also of fibreboard for supporting light weight garments.

FIGURE 10 is a cross section of a suspension bar 67, of generally rectangular cross section and hollow and wherein the three contiguous flanges 68, 68', 69 are provided with end flaps. A channel or angle iron can be inserted within said bar or a wooden bar 54.

FIGURE 11 shows a bar 70 of triangular cross section and which may be provided with an angle bar 71 made of metal. In this case, the end flaps depend from the ends of two or three of the contiguous flanges 72, 73 and 74.

FIGURE 12 shows a suspension bar 75 of triangular cross section made of corrugated fibreboard and reinforced by angle iron 76. The end flaps depend from the four contiguous flanges 77 and 78 which are symmetrically arranged at the center of the bar.

FIGURE 13 shows a cross section of another bar 81 made of corrugated fibreboard of generally rectangular cross section and with the internal flanges folded in accordion like fashion. The end flaps depend from the four internal flanges and additional flaps might also depend from the external flanges.

If desired, an angle bar 71 or a channel metal bar 50 may be inserted through the unit to further reinforce the same.

FIGURES 16 to 21 inclusive show another embodiment of the suspension bar in accordance with the invention. The blank for the bar 84 is shown in FIGURE 18 and consists of a generally rectangular piece of corrugated fibreboard provided with longitudinally extending spaced parallel fold lines 85 and transverse fold lines 86 near the ends of the blank. Inclined slits 87 are made in the blank starting from the junction of the outermost fold lines 85 and transverse fold lines 86 and inwardly directed to open at the outer longitudinal edges of the blank. The fold lines define two central flanges 88 and outer flanges 89 and 90 with intervening webs, central flaps 91 separate from each other by a slit and outer flaps 92 each provided with a bevel extension 93 inwardly of fold lines 86.

The blank is folded, as shown in FIGURE 19, along the longitudinal fold lines 85 by winding the blank over itself and disposing the flange 89 inwardly and wrapping the remaining flanges around the same so that the outermost concentric flanges 88 and 90 and their interconnecting top web form an inverted channel member encasing the remainder of the flanges and webs as clearly shown in FIGURE 20. The flaps 91 are then bent at right angles to the main part of the bar along transverse fold lines 86 so as to extend in opposite directions on each side of the main body of the bar and in a transverse plane with respect to said body. Finally, the flaps 92 are bent down about the extensions of the fold lines 85 connecting flaps 91 and 92 and laid flat against the outer faces of flaps 91 and stapled thereto by means of staples 94. Thus, the bevel extensions 93 overlap each other

as clearly shown in FIGURE 17, and as staples **94** pass through both the overlapping extensions **93**, rigid securing and interlocking of the oppositely directed flaps is obtained so as to resist upward pressure exerted at the ends of said flaps.

Preferably, a metal channel member **95** is fitted over the top web and outermost flanges **88** and **90** along the whole length of the bar to reinforce the latter and hold its flanges together.

When seen in plan view, the bar has a double T-shape formation with a central leg and transverse end legs. This bar is inserted in the slits made at the upper edges of the side walls of a box **96** similar to the box of FIGURE 1, the box **96** being provided with side walls **97** which are slit at their top edge and which have depending wings **98** forming a channel having a bottom corresponding to bottom **13** of FIGURE 1, and on which rest the bottom edges of the flaps **91**, **92** of the suspension bar **84**. The box **96** may be provided with closure flaps **99** corresponding to closure flaps **36** of FIGURE 1.

The suspension bar **84** can also be used in association with a box such as that of FIGURE 14 whereby the end flaps **91**, **92**, will extend on the outside of the side walls of the box and the ends of the central leg will rest directly in the bottom of the slits **83**.

It is to be noted that the flaps **91** and **92** when partially folded, as shown in FIGURE 21, with the flaps **92** stapled together, form an inverted U-shaped member transversely extending with respect to the main leg of the bar and adapted to straddle the top edge portion of the side walls of the box, in this case no slit would be required to be made in said sidewalls.

The suspension bar **84** has a rectangular cross sectional shape and the outer flanges form an inverted channel encasing the remainder of the flanges to form a rigid bar; because of the interlocking of flaps **92** by overlapping bevel extensions **93**, the transverse end legs of the bar are very rigid and will not tend to open up under load, thus the bar **84** can be used for heavy weight garments, especially when provided with the metal channel **95**.

Any one of the several embodiments of the suspension bar in accordance with the invention may be used in association with the box B, of FIGURE 1, and also in association with the box B′ illustrated in FIGURE 14. The side walls **1′** of said box B′ have a top edge **6′** from which depend flaps **82** which are turned inwardly and extend downwardly within the box. The top portion of side walls **1′** and flaps **82** are provided with registering slits **83** for receiving the end flaps of any one of the suspension bars. In this embodiment, the bar is directly supported at the bottom of the slits **83** which forms a sufficiently strong support for light weight garments. Here again the bar is not supported by the top edge **6′** of the side walls **1′**.

Any one of the suspension bars may be inserted in the slits of box B or B′ and their end flaps left loose within channel C or stapled to the box. In the case of box B′, the end flaps may be stapled or taped to the outside of the box.

Any one of the bars described provide for ease in suspending the hanger hooks, the latter overlying the bar, as clearly shown in FIGURE 3.

All the hanger bars have the common feature of having end flaps disposed in a vertical plane, and preferably contiguous, and inserted within the narrow slits at the top portion of the box side walls, said end flaps being adapted to be folded along the outside of the side walls of the box and in oppositely extending directions on both sides of the slits. In the case of the box B the weight of the garments is mainly supported by the bottom of the channel C and partially by the bottom of the slits. In the case of box B′, the weight is entirely supported at the bottom of the slits. In all cases, no part of the suspension bar rests on the top edge of the side walls.

Thus, although little reference has been made to metal hanger bars in the foregoing description, it should be noted that the principle according to the present invention of supporting the hanger bar in a plane below the top edges of the container side walls can apply to any type of hanger bars having no part overlying said top edges.

The suspension bars of the invention are held together either through their insertion into the slits of the side walls, or by adhesive tape wound around the same, or by the channel bar **59** of FIGURE 8 when such a bar is used.

All the bars of the present invention have longitudinal flanges and intervening webs which are wound over themselves such that the outermost concentric flanges and webs form an inverted generally channel shaped member which encases the remainder of the flanges and webs to form a very rigid bar even when entirely made of corrugated fibreboard. For extra strength the corrugated fibreboard bar is combined with a reinforcing member, namely members **50**, **54**, **59**, **71**, **76** or **95** as described hereinabove.

While preferred embodiments in accordance with the present invention have been illustrated and described, it is understood that various modifications may be resorted to without departing from the spirit and scope of the appended claims.

What I claim is:

1. A suspension bar made of corrugated fibreboard for supporting garment hangers in a garment box, said bar adapted to be supported by a pair of opposed side walls of a garment box, said bar constituted by a plurality of elongated flanges integrally united along longitudinal fold lines by intervening elongated coextensive webs, said flanges and webs folded about said fold lines to form an exterior tubular envelope encasing and holding together the remaining flanges disposed therein, said webs and flanges adapted to extend in a horizontal and in a vertical plane respectively ot confer rigidity to said bar both in a horizontal and in a vertical plane, and flaps integrally united to said flanges along transverse fold lines at each end of said bar, and folded at substantially right angles to said bar, being oppositely directed and lying in a transverse plane with respect to said bar.

2. A suspension bar as claimed in claim 1, wherein the flanges provided with said flaps are contiguous.

3. A suspension bar for supporting garment hangers in a garment box, said bar adapted to be supported by a pair of opposed side walls of a garment box, said bar constituted by a plurality of elongated flanges and intermediate elongated webs united and folded along longitudinal fold lines, and flaps integrally united to said flanges along transverse fold lines at each end of said bar, and folded at substantially right angles to said bar being oppositely directed and lying in a transverse plane with respect to said bar, said flanges lying side by side and said webs disposed transversely to said flanges, whereby said bar has a thickness greater than the total thickness of said flaps, the outermost flanges and web of said bar defining an inverted generally channel shaped member encasing the remainder of said flanges.

4. A suspension bar as claimed in claim 3, wherein the flanges provided with said flaps are contiguous and said flaps are separate from one another.

5. A suspension bar as claimed in claim 3, entirely made of corrugated fibreboard.

6. A suspension bar for supporting garment hangers in a garment box, said bar adapted to be supported by a pair of opposed side walls of a garment box, said bar made of corrugated fibreboard and constituted by a plurality of elongated flanges united along longitudinal fold lines by intervening elongated coextensive webs, said flanges and webs folded about said fold lines to form an exterior tubular envelope encasing and holding together the remaining flanges disposed therein, said webs and flanges extending in planes at an angle with respect to

each other to confer rigidity to said bar in both said planes, and flaps united to said flanges along transverse fold lines at each end of said bar, and folded at substantially right angles to said bar to be oppositely directed and lie in transverse plane with respect to said bar, said bar reinforced by a rigid bar coextensive with said flanges, said rigid bar extending in both said planes and in contact with at least one flange and one web.

7. A suspension bar as claimed in claim 6, wherein the reinforcing bar consists of an angle iron.

8. A suspension bar as claimed in claim 6, wherein said reinforcing bar consists of a sheet metal channel member.

9. A suspension bar as claimed in claim 8, wherein said channel member fits over the top and sides of said fibreboard bar and holds the sides together.

10. The combination of a fibreboard shipping container having vertical slits opening at the top edge of opposed side walls thereof, with a suspension bar for garment hangers, said suspension bar constituted by a plurality of elongated flanges at least the end portions of at least two of said flanges disposed in a substantially vertical plane, said flanges united along longitudinal lines, and end sections united along transverse lines to said flanges at each end of said bar, said end portions of said two flanges inserted within said slits to extend to the exterior face of said side walls, said end sections applied against said exterior face of said side walls in opposite directions on both sides of said slits, said bar being devoid of any portion extending over the top edge of said side walls, whereby said bar is supported by said side walls in a plane below the top edges of said side walls.

11. The combination as claimed in claim 10, wherein said bar is supported by the bottom of said slits.

12. The combination of claim 10, further including a wing integrally connected to the top edge of each side wall and folded to form a channel member having a slit made in the leg of said channel member next to said side wall and registering with the slit of said side wall, said end sections extending within said channel member and resting on the bottom of said channel member.

13. The combination as claimed in claim 10, wherein said flanges include flanges transversely spaced from the flanges provided with said flaps and intervening webs uniting said flanges of said two groups of flanges to provide said bar with a thickness greater than the combined thickness of the portions of the flaps extending through said slits.

14. The combination as claimed in claim 10, wherein said flanges include flanges transversely spaced from the flanges provided with said flaps and intervening webs uniting said flanges of said two groups of flanges to provide said bar with a thickness greater than the combined thickness of the portions of the flaps extending through said slits, the outermost flanges and interconnecting web of said bar defining an inverted generally channel shaped member encasing the remainder of said webs and flanges, said bar being made of fiberboard.

15. The combination as claimed in claim 10, wherein said bar is made of sheet metal.

16. The combination of claim 10, wherein said bar is made of fiberboard and is reinforced by a rigid member coextensive with the flanges of said bar.

17. The combination of claim 10, wherein said bar has a hanger hook locking flap integrally united to the top of said bar and foldable over hanger hooks supported on said bar.

18. The combination as claimed in claim 13, wherein said bar is made of fibreboard.

19. The combination as claimed in claim 16, wherein said rigid member consists of a channel sheet metal member.

20. The combination as claimed in claim 16, wherein said rigid member consists of an angle iron.

21. The combination as claimed in claim 16, wherein said rigid member consists of a solid bar of rectangular cross section.

22. The combination as claimed in claim 19, wherein said channel member fits over the top and sides of said bar and holds said bar together.

23. The combination of a fiberboard shipping container having vertical slits opening at the top edge of opposite side walls thereof, with a suspension bar for garment hangers, said suspension bar constituted by a plurality of elongated flanges integrally united along longitudinal fold lines by intervening elongated coextensive webs, said flanges and webs folded about said fold lines to form an exterior tubular envelope encasing and holding together the remaining flanges disposed therein, said webs and flanges extending in planes at an angle with respect to each other to confer rigidity to said bar in both said planes, at least two of said flanges disposed in a substantially vertical plane, and flaps integrally united along transverse fold lines to said flanges at each end of said bar, said two flanges inserted within said slits to extend to the exterior face of said side walls, said flaps applied against said exterior face of said side walls in opposite directions on both sides of said slits, said bar being devoid of any portion extending over the top edge of said walls, whereby said bar is supported by said side walls in a plane below the top edges of said side walls.

24. A suspension bar for supporting garment hangers in a garment box, said bar adapted to be supported by a pair of opposed side walls of a garment box, said bar made of corrugated fibreboard and constituted by a plurality of elongated flanges united and folded along longitudinal fold lines, and flaps united to said flanges along transverse fold lines at each end of said bar and folded at substantially right angles to said bar to be oppositely directed and lie in a transverse plane with respect to said bar, said bar reinforced by a rigid channel member coextensive with said flanges.

25. A suspension bar as claimed in claim 24, wherein said channel member fits over the top and sides of said fiberboard bar and holds the sides together.

26. The combination of a fibreboard shipping container having vertical slits opening at the top edge of opposed side walls thereof, with a suspension bar for garment hangers, said bar made of fibreboard and constituted by a plurality of elongated flanges at least two of which are disposed in a substantially vertical plane, said flanges united and folded along longitudinal fold lines, and flaps integrally united along transverse fold lines to said flanges at each end of said bar, said two vertical flanges inserted within said slits to extend to the exterior face of said side walls, said flaps folded against said exterior face of said side walls in opposite directions on both sides of said slits, said bar being devoid of any portion extending over the top edge of said side walls whereby said bar is supported by said side walls in a plane below the top edges of said side walls, said bar being reinforced by a rigid channel member coextensive with the flanges of said bar.

27. The combination as claimed in claim 26, wherein said channel member fits over the top and sides of said bar and holds said bar together.

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