

M. A. OWENS.

PROCESS OF PREPARING MOLDINGS FOR ENAMELING.

No. 171,629.

Patented Dec. 28, 1875.

Fig. 2.

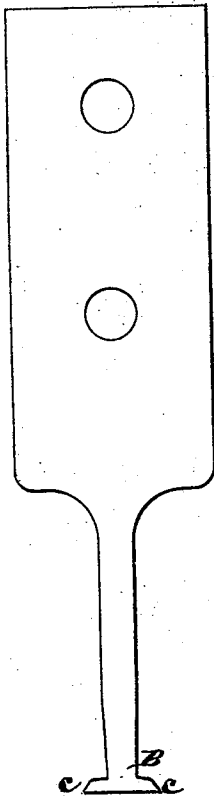


Fig. 1.

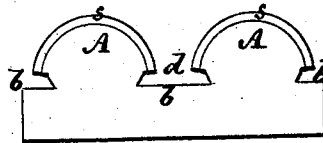


Fig. 3.

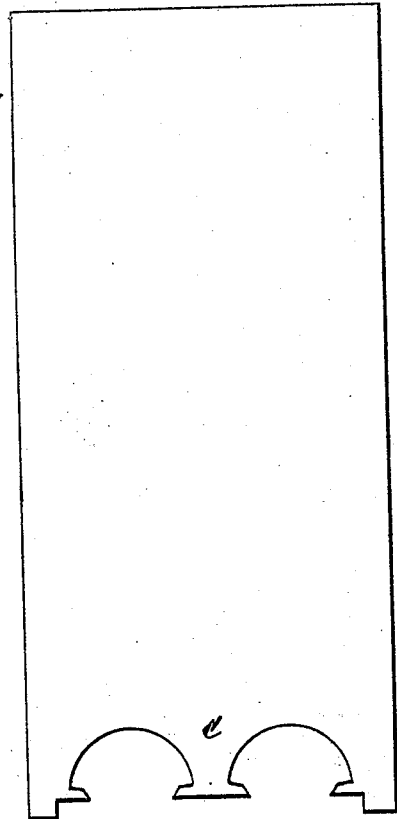
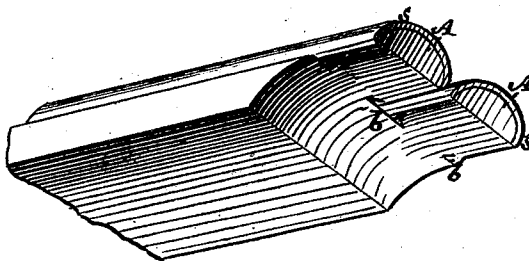


Fig. 4.



Witnesses.

John Decker.

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By his Attorneys,
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UNITED STATES PATENT OFFICE.

MICHAEL A. OWENS, OF BROOKLYN, NEW YORK.

IMPROVEMENT IN PROCESSES OF PREPARING MOLDINGS FOR ENAMELING.

Specification forming part of Letters Patent No. **171,629**, dated December 28, 1875; application filed July 1, 1875.

To all whom it may concern:

Be it known that I, MICHAEL A. OWENS, of Brooklyn, in the county of Kings and State of New York, have invented a new and useful Improvement in Preparing or Dressing Moldings; and I do hereby declare that the following is full, clear, and exact description thereof, reference being had to the accompanying drawing, which forms part of this specification.

This invention, while applicable to the preparing or dressing of moldings which are not intended to be enameled, is more especially designed to the preparing or dressing of enameled moldings, and will here be described more particularly with reference to the latter.

The general object of the invention is to furnish the moldings in a neatly-finished manner, and more rapidly and economically than has heretofore been done, but it more especially has in view giving to the base edges of the moldings, in the ordinary process of preparing or dressing the latter, a clean and sharp finish without having recourse to sand-papering the under sides of the moldings after the latter have been sawed or planed from the board or strip on which they are projected preparatory to separating them. A further object of the invention, as applied to enameled moldings, is to prevent the dulling of the tool or tools which are employed to separate the moldings and to remove the latter from the surplus wood on which they are projected. To these ends the invention consists in making an under cut in the body of the wood beneath each base edge of the molding, so that, although the moldings may be formed in groups arranged to occupy parallel relations with each other, each molding is perfectly and smoothly finished as regards its base edges, and the latter are distinct projections from the surplus wood precisely as if the moldings were made singly or separately the one from the other, and the after reduction of the surplus wood and separation of the moldings are made without impairing the smooth finish given by the undercut to the base edges of the moldings. Furthermore, by said undercut, as applied to the production of enameled moldings, not only is the enamel, by a suitable construction of the gages or preparing irons, prevented from

entering the grooves which separate the moldings in a group, but the enamel is carried clean under or down to the base edges of the moldings, and may be of the same thickness at said edges as at any other part, so that no after burnishing will remove it from the edges. This is a great advantage over merely tapering off the layer or covering of the enamel toward the bottom of the recesses or grooves, as in another patented arrangement in which no undercut in the wood is made, but the gages or preparing irons are merely constructed to thin off the enamel at the base edges of the moldings. The undercuts which I make may either be straight or beveled, and may be made while the molding is passing through the molding-mill, or (that is, in the case of enameled moldings) they can be made in the preparing-machine during the process of sizing.

Figure 1 shows a vertical transverse section of a group or pair of enameled moldings in the course of construction and having my invention applied. Fig. 2 is a view of a tool for making the undercuts beneath the base edges of the moldings; and Fig. 3, a view of a gage or preparing iron used in laying on the enamel constructed to accord with the invention. Fig. 4 is a view showing the group of moldings in the course of having the surplus wood reduced to separate them.

A A are the moldings, of which there may be any number, arranged side by side, or in parallel relation with each other on the upper surface of a strip before said moldings, after being enameled, are separated by removing the necessary amount of stock or surplus wood from beneath them. Said moldings may be of any desired shape in their transverse section, and be undercut at either or both of their base edges. These undercuts *b* may be made by a tool, B, entering the grooves *d* between the moldings A, and formed with lateral cutting edges or wings, *c*, which are constructed to enter beneath the base of each molding, and virtually to separate the latter at their base for any given distance at their edges from the body of the wood beneath them. In other respects the process of constructing the enameled moldings is the same as that ordinarily pursued, excepting as regards the

construction of the guides, gages, or preparing irons C, which are not only shaped to correspond with the cross-section of the molding, but also to enter the undercuts *b* beneath the bases of the moldings, or the tool B may be dispensed with, and the preparing-iron C be constructed to make or scrape the undercut *b*, as well as to distribute the enamel over the molding and down to or beneath the edge or edges of the base of the molding; but in either case it is necessary that an undercut, *b*, be made in the wood extending beneath the base of the molding, so that the enamel will make a clean cover of the base edge or edges, and preferably of the same thickness at said edges as at any other part of the molding. After the moldings have been passed through the preparing-irons, and the base or surplus portion of the wood subsequently removed by sawing or planing, as heretofore practiced for the purpose of detaching the moldings, it will be found that not only are the base edges of the moldings free from all raggedness by reason of the undercut *b*, but that said edges are fully covered by the enamel without any necessity for tapering off the latter at said edges, and all sandpaper-

ing of the under sides of the bases of the molding is avoided. This is due to the undercut *b*, which likewise prevents the enamel dulling the tool employed in making the reduction of the wood or removal of the surplus stock to separate the moldings, as shown in Fig. 4.

I claim—

1. The method herein described of preparing enameled molding by forming a recess or undercut under the lower edges of the same, leaving said moldings attached to the wood from which they are formed by a shank to allow the moldings to be separated by cutting the shank without defacing or cutting through the enamel, substantially as herein set forth and shown.

2. In moldings for enameling, the undercuts *b* on the strip below the grooves *d*, which separate the parallel rows, said undercuts extending underneath the base edges of the moldings, substantially as and for the purposes herein described.

MICHAEL A. OWENS.

Witnesses:

HENRY T. BROWN,
MICHAEL RYAN.