JIG FOR ASSEMBLING POCKET DOOR FRAMES

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The present invention relates in general to a pocket door frame adapted to be built into a wall, or the like, adjacent a doorway, and adapted to receive and conceal a sliding door when the latter is in its open position.

More particularly, the invention relates to a fixture or jig for assembling pocket door frames quickly and easily from prefabricated parts.

As background, the portion of a pocket door frame to be assembled in the jig of the invention includes: a back or bumper jamb; two sets of paired spreaders embracing and extending perpendicularly from the bumper jamb and having ends abutting and secured to opposite sides thereof; two channel-shaped split-jamb stiffeners telescoped over the opposite ends of the spreaders of the respective sets; and two split jams abutting the respective stiffeners substantially in alignment with the spreaders of the respective sets, the split jams and their stiffeners being secured to the spreaders. As a sliding door used with such a pocket door frame is opened, it moves between the split jams and their stiffeners into the space between the two sets of paired spreaders, opening movement of the door being limited by engagement with a bumper or the bumper jamb.

A pocket door frame of the foregoing nature is, of course, installed in an upright position with the bumper and split jams substantially vertical. However, the jig of the invention assembles the parts of the pocket door frame with the frame rotated approximately 90° into a position wherein the bumper and split jams are generally horizontal and wherein the bumper jamb is below the split jams. For terminological convenience, the ends of the bumper and split jams and the ends to the split-jamb stiffeners which are lowest when the pocket door frame is upright, and the edges of the spreaders which are lowest under such conditions, will be referred to as their lower ends and edges, respectively, even when the pocket door frame is oriented generally horizontally in the jig of the invention.

The invention contemplates, and general objects thereof are to provide, a pocket-door-frame assembly jig which includes: an upright supporting structure; a generally horizontal lower positioning means mounted on the supporting structure and having means for supporting the bumper jamb and one end of each of the spreaders; locating means on the lower positioning means and engageable with the edges and one end of the bumper jamb and with one edge of each spreader for locating the bumper jamb and the one end of each spreader in assembled relation; a generally horizontal upper positioning means mounted on the supporting structure above the lower positioning means; a plurality of spacer means on the upper positioning means and each engageable by adjacent sides of the spreaders of one pair adjacent the other ends thereof to space same apart; and a plurality of pairs of holding means on the upper positioning means for holding means for holding the respective pairs of spreaders against the spacer means, respectively.

An important object of the invention is to provide a jig of the foregoing nature wherein the holding means for holding the respective pairs of spreaders against the respective spacer means comprises pairs of spring clips or spring clip means which resiliently clamp the spreaders against the spacer means. With this construction, the spreaders are automatically held in place against the spacer means, which are preferably spacer blocks, upon insertion into the corresponding clips, which is an important feature.

Another important object is to provide a jig of the character outlined wherein the locating means mentioned is engageable by the lower end of the bumper jamb and the lower edges of the spreaders, the lower ends of the split jams and their stiffeners similarly being engageable with an end stop or stop means on the upper positioning means. With this construction, the positioning of the various parts of the pocket door frame is effected with reference to the lower ends or edges of the various parts, as opposed to the upper ends or edges thereof. Consequently, the lower edges of the spreaders of the lowest pair are automatically positioned flush with the lower ends of the bumper and split jams and the split-jamb stiffeners, a positional relationship which is standard in a pocket door frame of the type under consideration. This standard positional relationship is automatically achieved with the jig of the present invention despite width variations in the spreaders of the lowest pair, which is an important feature.

Another object of the invention is to provide a jig which may be used to assemble pocket door frames of various widths by providing means for mounting the lower positioning means on the supporting structure of the jig of various distances below the upper positioning means, the latter remaining fixed.

Another object is to provide a jig which is a self-contained, free-standing unit requiring no supporting means other than the supporting structure and the upper and lower positioning means mentioned. A related object is to locate the various parts of the jig which engage the various parts of the pocket door frame forwardly of the upright supporting structure for the upper and lower positioning means so that, upon assembly, the finished pocket door frame may be removed from the jig readily without interference by the upright supporting structure and without any necessity for removing any parts of the upper and lower positioning means, or for any auxiliary supporting means thereof.

Another object of the invention is to provide a jig wherein the upper ends of the spaced blocks are recessed to permit insertion of the adjacent flanges or flange portions of the channel-shaped stiffeners between the spacer blocks and the corresponding spreaders. This construction permits the spring clips to maintain the spreaders clamped against the respective spacer blocks even after the stiffeners are telescoped over the corresponding ends of the spreaders.

A further object is to provide means on the upper positioning means for retaining the split jams in their assembled positions on their stiffeners and respectively adjacent opposite sides of the spacer blocks.

Still another object of the invention is to provide a jig wherein the stop means engageable with the lower ends of the split jams and their stiffeners is movably connected to the upper positioning means so that it may be moved aside to permit the attachment of a split-jamb spacer to the lower ends of the split jams prior to removal of the assembled pocket door frame from the jig.

Another and important object of the invention is to provide a jig having staple-gun locating means thereon at all locations where stapling together of various parts of the pocket door frame is required, such locating means automatically positioning a staple gun correctly for the various stapling operations required.

The foregoing objects, advantages, features and results of the present invention, together with various other objects, advantages, features and results thereof which will be evident to those skilled in the art to which the inven-
tion relates in the light of this disclosure, may be achieved with the exemplary embodiment of the invention described in detail hereinafter and illustrated in the accompanying drawings, in which:

FIG. 1 is a top plan view of a pocket-door-frame assembly jig of the invention;

FIG. 2 is a front elevational view of the jig with pocket-door-frame parts therein in broken lines;

FIG. 3 is a perspective view on a reduced scale of a portion of a pocket door frame which the jig of the invention is used to assemble;

FIGS. 4 and 5 are enlarged, fragmentary sectional views respectively taken along the arrowed lines 4—4 and 5—5 of FIG. 2;

FIG. 6 is a fragmentary perspective view of a portion of the jig of the invention; and

FIG. 7 is an exploded perspective view of the jig of the invention.

Referring initially to FIG. 3 of the drawings, illustrated therein is a portion of a pocket door frame 10 to be assembled by the invention. The frame 10 includes a back or bumper jamb 12 having a plurality of pairs of horizontal spreaders 14 secured thereto in vertically spaced relation, and a lowermost spreader 14 at each pair receive the bumper jamb 12 therebetween and respectively abut and are secured to opposite edges thereof. Telescoped over the opposite ends of the respective sets of spreaders 14, i.e., the two spreader sets on opposite sides of the bumper jamb 12, are laterally spaced, channel-shaped split-jamb stiffeners 16, preferably of metal. Abutting the respective stiffeners 16 substantially in alignment with the respective sets of spreaders 14 are split jamb 18, the respective stiffeners and split jamb being secured to the spreader sets. The various parts are secured together by nailing, stapling, or the like. Stapling will be considered hereinafter with the understanding that an equivalent fastening technique may be used. To maintain the lateral spacing of the split jambs 18 during handling, shipment, and the like, temporary spacers 20 are secured thereto in any suitable manner, as by stapling.

The jig 22 includes an upright supporting structure shown as consisting of two horizontally spaced uprights 24 having suitable bases 26. Mountable on the uprights 24 in various vertical positions is a generally horizontal lower positioning means 28. The purpose of making the lower positioning means 28 mountable on the uprights 24 in various vertical positions is to accommodate pocket door frames of different widths. The lower positioning means 28 may be secured to the uprights 24 in various ways, as by bolts secured by wheel nuts 30, FIG. 7.

As will be described, the lower positioning means 28 properly positions the bumper jamb 12 and the corresponding ends of the spreaders 14. The opposite ends of the spreaders 14, the stiffeners 16 and the split jambs 18 are all properly positioned by a generally horizontal upper positioning means 32 permanently secured to the uprights 24.

The lower positioning means 28 comprises a member 34 having a flat top surface 36 which serves as a means for supporting the bumper jamb 12 and the adjacent ends of the spreaders 14. Provided on the top surface 36 of the member 34 are locating means engageable by the lower end of the bumper jamb 12 and with the lower edges of the spreaders 14 for properly locating the bumper jamb and the adjacent ends of the spreaders relative to each other.

The aforementioned locating means includes an end stop 38 at one end of the member 34 and engageable by the lower end of the bumper jamb 12 and by the lower edges of the lowest spreaders 14, as shown in FIG. 2 of the drawings. With this construction, the lower edges of the lowest spreaders 14 are flush with the lower end of the bumper jamb 12 irrespective of the widths of the lowest spreaders, which is an important feature.

The bumper jamb 12 is held against lateral movement by placing it on the top surface 36 of the member 34 between two rows of stops 40 arranged in pairs. The lower edges of each pair of spreaders 14 above the lowest pair are engageable with the ends of the respective stops 40, of the corresponding pair of spreaders, which are the furthest from the end stop 38, as shown in FIG. 2 of the drawings. Thus, the stops 38 and 40 serve to properly locate the bumper jamb and the corresponding ends of the spreaders 14 relative to each other.

The positioning means 32 includes a horizontal bar 42, secured to the uprights 24 adjacent upper ends. Projecting forwardly from the bar 42 are brackets 44 carrying spacer means or blocks 46 for spacing apart the stiffeners 16, the split jambs 18 and the corresponding ends of the spreaders 14. Also secured to the brackets 44 and embracing the respective blocks 46 are U-shaped brackets 48, FIG. 1, each having two arms respectively adapted to clamp the respective spreaders 14 of the corresponding pair against opposite sides of the corresponding block 46. It will be understood, of course, that the blocks 46 and spring clips 48 are so located relative to the member 34 that when the spreader ends associated with the bumper jamb 12 are properly positioned, the spreaders associated with the split jambs 18 are clamped against the blocks 46 by the spring clips 48. Also, when the spreader ends associated with the split jambs 18 are inserted into the respective spaces between the blocks 46 and the arms of the spring clips 48, the lower edges thereof engage the connecting portions of the spring clips to properly locate the spreader ends in question relative to the split jambs 18 and the stiffeners 16 therefor.

The bracket 44 which is located at the same end of the jig 22 as the end stop 38 carries an end stop 50 engageable by the lower ends of the stiffeners 16 and the split jambs 18 and located in the same vertical plane as the end stop 38. Thus, the lower end of the bumper jamb 12, the lower edges of the spreaders 14 of the lowest pair, and the lower ends of the stiffeners 16 and the split jambs 18 are all flush when these parts of the pocket door frame 10 are placed in the jig 22.

As shown in FIG. 6 of the drawings, the end stop 50 is mounted on a pivot 52 so that it may be swung aside for access to the lower ends of the split jambs 18 and the lower edges of the corresponding spreader ends. This permits nailing, or otherwise securing, a jamb spacer, not shown, to the lower ends of the split jambs 18 and the corresponding spreader ends of the lowest spreader pair. Such a jamb spacer is normally secured after the bumper jamb 12, spreaders 14, stiffeners 16 and split jambs 18 have been assembled in a manner to be described.

As best shown in FIG. 4 of the drawings, the sides of the spacer blocks 46 which are engageable by the corresponding spreader ends are provided at their upper ends with recesses 54 to permit the insertion of the corresponding flange portions of the stiffeners 16 as such stiffeners are telescoped over the corresponding spreader ends.

At least one of the brackets 44 carries a bracket 55 having supports 56 for the split jambs 18 when they are placed on the stiffeners 16, as shown in FIG. 4 of the drawings, and which keeps them from falling off the stiffeners prior to securing. While only one of the split-jamb supporting brackets 55 is shown, it will be understood that two or more may be used.

Operation

The jig 22 is a portable free-standing fixture which
may be placed anywhere without any necessity for any auxiliary supporting means. All that is required to ready the jig 22 for use is to place the lower positioning means 28 in the proper vertical position for the particular pocket-door-frame width to be dealt with, if it is not already in such position.

In assembling the pocket door frame 10, the first step is to place the bumper jamb 12 on the top surface 36 of the member 34 between the two rows of stops 40 and with its lower end against the end stop 38. The spacers 14 are then placed in the jig 22 with one end resting on the top surface 36 of the member 34 in engagement with the corresponding one of the stops 38 and 40 and the corresponding edge of the bumper jamb, and with the other end thereof inserted all the way into the space between the corresponding spacer block 46 and spring clip 48. The spring clips 48 automatically hold the spacers 14 in their correct positions. Then, the stiffeners 16 are telescoped over the respective sets of corresponding spacer ends and the split jams 18 are placed on the respective stiffeners, the lower ends of the stiffeners and split jams being seated against the end stop 50, which is in its closed position under such conditions.

It might be pointed out at this juncture that since the various parts are located relative to each other in the foregoing manner using their lower ends of edges as reference points, the jig 22 is readily useable with pocket door frames 16 of different heights. With a frame of greater height, the upper ends of the bumper jamb 12, the stiffeners 16 and the split jams 18 merely project farther to the right, as viewed in FIG. 2 of the drawings.

With the bumper jamb 12, spacers 14, stiffeners 16 and split jams 18 all properly located relative to each other by the jig 22 in the foregoing manner, all that remains to be done is to secure the various parts together. This is preferably done by stapling, using a conventional staple gun 58, FIG. 4.

An important feature of the invention is that the jig 22 includes staple-gun locators in the form of pins 60 each receivable in a V-notch 62 in a locating element 64 secured to the staple gun 58. Thus, by placing the staple gun 58 in such a position that one of the pins 60 is seated in the V-notch 62, the gun is automatically located properly to drive a staple at the corresponding location. As best shown in FIG. 7 of the drawings, locating pins 60 project laterally from opposite sides of the member 34 at the locations where staples are to be driven through the spacers 14 into the bumper jamb 12. Similarly, locating pins 60 project upwardly from the spacer blocks 46 at the locations where staples are to be driven through the split jams 18 and stiffeners 16 into the spacers 14. In this connection, it might be pointed out that the stiffeners 16 may either be provided with staple holes at the proper points, or they may be made of sheet metal thin enough that the staples may be driven directly through the metal.

As will be apparent, as the result of the provision of the locating pins 60, the various parts of the pocket door frame 10 may be stapled together very rapidly with the staple gun 58. Preferably, the spacers 14 on both sides of the pocket door frame 10 are stapled to the bumper jamb 12 first. Then, the split jams 18 and stiffeners 16 are stapled to the spacers 14, the operator using one hand to clamp the split jams 18 against the corresponding sides of the spacer blocks 46 and the other hand to support the staple gun 58. The foregoing completed, the temporary spacers 20 are stapled in place and, if a jam spacer at the lower ends of the split jams 18 is required, this may be stapled or nailed in place very easily by swinging aside the pivoted end stop 50.

The assembled pocket door frame 10 may be removed from the jig 22 simply by lifting it slightly to clear the stops 40 and then sliding it to the right, as viewed in FIG. 2 of the drawings, until the spacers 14 disengage the spring clips 48. The completed frame 10 is then free to be lifted clear of the jig 22.

Although an exemplary embodiment of the invention has been described herein for purposes of illustration, it will be understood that various changes, modifications and substitutions may be incorporated in such embodiment without departing from the spirit of the invention as defined by the claims which follow.

We claim:

1. A jig for assembling a pocket door frame which includes a bumper jamb embraced by paired horizontal spacers extending perpendicularly from the bumper jamb and having first ends abutting opposite edges thereof, two laterally spaced, channel-shaped split-jamb stiffeners telescoped over the opposite, second ends of the respective sets of spacers which are on opposite sides of the bumper jamb, and two split jams respectively abutting the stiffeners substantially in alignment with the spacers of the respective sets, said jig assembling the pocket door frame rotated into a generally horizontal position with the bumper jamb below the stiffeners and split jams and with the upper and lower edges of the spacers oriented generally vertically, said jig including in combination:

(a) an upright supporting structure;
(b) a generally horizontal lower positioning means mounted on said supporting structure and having means for supporting the bumper jamb and said first end of each of the spacers;
(c) locating means on said lower positioning means and engageable with the edges and one end of the bumper jamb and with one edge of each spacer for locating the bumper jamb and said first end of each spacer in assembled relation with said first ends of the spacers of each pair respectively adjacent the respective edges of the bumper jamb;
(d) a generally horizontal upper positioning means mounted on said supporting structure above said lower positioning means;
(e) a plurality of spacer means on said upper positioning means and each engageable by adjacent sides of the spacers of one pair adjacent the second ends thereof to space same apart; and
(f) a plurality of pairs of spring clip means on said upper positioning means for resiliently clamping the respective pairs of spacers against said spacer means, respectively.

2. A jig for assembling a pocket door frame which includes a bumper jamb embraced by paired horizontal spacers extending perpendicularly from the bumper jamb and having first ends abutting opposite edges thereof, two laterally spaced, channel-shaped split-jamb stiffeners telescoped over the opposite, second ends of the respective sets of spacers which are on opposite sides of the bumper jamb, and two split jams respectively abutting the stiffeners substantially in alignment with the spacers of the respective sets, said jig assembling the pocket door frame rotated into a generally horizontal position with the bumper jamb below the stiffeners and split jams and with the upper and lower edges of the spacers oriented generally vertically, said jig including in combination:

(a) an upright supporting structure;
(b) a generally horizontal lower positioning means mounted on said supporting structure and having means for supporting the bumper jamb and said first end of each of the spacers;
(c) locating means on said lower positioning means and engageable with the edges and the lower end of the bumper jamb and with the lower edge of each spacer for locating the bumper jamb and said first end of each spacer in assembled relation with said first ends of the spacers of each pair respectively adjacent the respective edges of the bumper jamb;
(d) a generally horizontal upper positioning means
mounted on said supporting structure above said lower positioning means; (e) a plurality of spacer means on said upper positioning means and each engageable by adjacent sides of the spreaders of one pair adjacent the second ends thereof to space same apart; and (f) a plurality of pairs of holding means on said upper positioning means for holding the respective pairs of spreaders against said spacer means, respectively.

3. A jig for assembling a pocket door frame which includes a bumper jamb embraced by paired horizontal spreaders extending perpendicularly from the bumper jamb and having first ends abutting opposite edges thereof, two laterally spaced channel-shaped split-jamb stiffeners telescoped over the opposite, second ends of the respective sets of spreaders which are on opposite sides of the bumper jamb, and two split jams respectively abutting the stiffeners substantially in alignment with the spreaders of the respective sets, said jig assembling the pocket door frame rotated into a generally horizontal position with the bumper jamb below the stiffeners and split jams and with the upper and lower edges of the spreaders oriented generally vertically, said jig including in combination:

(a) an upright supporting structure;
(b) a generally horizontal lower positioning means mounted on said supporting structure and having means for supporting the bumper jamb and said first end of each of the spreaders;
(c) locating means on said lower positioning means and engageable with the edges and one end of the bumper jamb and with one edge of each spreader for locating the bumper jamb and said first end of each spreader in assembled relation with said first ends of the spreaders of each pair respectively adjacent the respective spreaders of said pair adjacent the second ends thereof to space same apart;
(d) a plurality of spacer means on said upper positioning means and each engageable by adjacent sides of the spreaders of one pair adjacent the second ends thereof to space same apart;
(e) a plurality of pairs of holding means on said upper positioning means for holding the respective pairs of spreaders against said spacer means, respectively; and
(f) means for mounting said lower positioning means on said supporting structure various distances below said upper positioning means to accommodate various pocket-door-frame widths.

4. A jig for assembling a pocket door frame which includes a bumper jamb embraced by paired horizontal spreaders extending perpendicularly from the bumper jamb and having first ends abutting opposite edges thereof, two laterally spaced, channel-shaped split-jamb stiffeners telescoped over the opposite, second ends of the respective sets of spreaders which are on opposite sides of the bumper jamb, and two split jams respectively abutting the stiffeners substantially in alignment with the spreaders of the respective sets, said jig assembling the pocket door frame rotated into a generally horizontal position with the bumper jamb below the stiffeners and split jams and with the upper and lower edges of the spreaders oriented generally vertically, said jig including in combination:

(a) an upright, free-standing supporting structure;
(b) a generally horizontal lower positioning means mounted on said supporting structure and having means for supporting the bumper jamb and said first end of each of the spreaders;
(c) locating means on said lower positioning means and engageable with the edges and one end of the bumper jamb and with one edge of each spreader for locating the bumper jamb and said first end of each spreader in assembled relation with said first ends of the spreaders of each pair respectively adjacent the respective edges of the bumper jamb;
(d) a generally horizontal upper positioning means mounted on said supporting structure above said lower positioning means; (e) a plurality of spacer means on said upper positioning means and each engageable by adjacent sides of the spreaders of one pair adjacent the second ends thereof to space same apart; and (f) a plurality of pairs of holding means on and spaced forwardly from said upper positioning means and each engageable by adjacent sides of the spreaders of one pair adjacent the second ends thereof to space same apart; and (g) said spacer means being recessed at their upper ends to permit insertion of flange portions of the stiffeners between said spacer means and the corresponding spreaders.

5. A jig for assembling a pocket door frame which includes a bumper jamb embraced by paired horizontal spreaders extending perpendicularly from the bumper jamb and having first ends abutting opposite edges thereof, two laterally spaced, channel-shaped split-jamb stiffeners telescoped over the opposite, second ends of the respective sets of spreaders which are on opposite sides of the bumper jamb, and two split jams respectively abutting the stiffeners substantially in alignment with the spreaders of the respective sets, said jig assembling the pocket door frame rotated into a generally horizontal position with the bumper jamb below the stiffeners and split jams and with the upper and lower edges of the spreaders oriented generally vertically, said jig including in combination:

(a) an upright supporting structure;
(b) a generally horizontal lower positioning means mounted on said supporting structure and having means for supporting the bumper jamb and said first end of each of the spreaders;
(c) locating means on said lower positioning means and engageable with the edges and one end of the bumper jamb and with one edge of each spreader for locating the bumper jamb and said first end of each spreader in assembled relation with said first ends of the spreaders of each pair respectively adjacent the respective spreaders of said pair adjacent the second ends thereof to space same apart;
(d) a plurality of spacer means on said upper positioning means and each engageable by adjacent sides of the spreaders of one pair adjacent the second ends thereof to space same apart;
(e) a plurality of pairs of holding means on said upper positioning means for holding the respective pairs of spreaders against said spacer means, respectively; and
(f) means for mounting said upper positioning means on said supporting structure various distances above said lower positioning means to accommodate various pocket-door-frame widths.

6. A jig for assembling a pocket door frame which includes a bumper jamb embraced by paired horizontal spreaders extending perpendicularly from the bumper jamb and having first ends abutting opposite edges thereof, two laterally spaced, channel-shaped split-jamb stiffeners telescoped over the opposite, second ends of the respective sets of spreaders which are on opposite sides of the bumper jamb, and two split jams respectively abutting the stiffeners substantially in alignment with the spreaders of the respective sets, said jig assembling the pocket door frame rotated into a generally horizontal position with the bumper jamb below the stiffeners and split jams and with the upper and lower edges of the spreaders oriented generally vertically, said jig including in combination:

(a) an upright supporting structure;
(b) a generally horizontal lower positioning means mounted on said supporting structure and having
means for supporting the bumper jamb and said first end of each of the spreaders; 
(e) locating means on said lower positioning means and engageable with the edges and one end of the bumper jamb and with one edge of each spreader for locating the bumper jamb and said first end of each spreader in assembled relation with said first ends of the spreaders of each pair respectively adjacent the respective edges of the bumper jamb; 
(d) a generally horizontal upper positioning means mounted on said supporting structure above said lower positioning means; 
(e) a plurality of spacer means on said upper positioning means and each engageable by adjacent sides of the spreaders of one pair adjacent the second ends thereof to space same apart; 
(f) a plurality of pairs of holding means on said upper positioning means for holding the respective pairs of spreaders against said spacer means, respectively; 
(g) said spacer means being recessed at their upper ends to permit insertion of flange portions of the stiffeners between said spacer means and the corresponding spreaders; and 
(h) means on said upper positioning means for retaining the split jambs on the stiffeners and respectively adjacent opposite sides of said spacer means.

7. A jig for assembling a pocket door frame which includes a bumper jamb embraced by paired horizontal spreaders extending perpendicularly from the bumper jamb and having first ends abutting opposite edges thereof, two laterally spaced, channel-shaped split-jamb stiffeners telescoped over the opposite, second ends of the respective sets of spreaders which are on opposite sides of the bumper jamb, and two split jambs respectively abutting the stiffeners substantially in alignment with the spreaders of the respective sets, said jig assembling the pocket door frame rotated into a generally horizontal position with the bumper jamb below the stiffeners and split jambs and with the upper and lower edges of the spreaders oriented generally vertically, said jig including in combination:
(a) an upright supporting structure; 
(b) a generally horizontal lower positioning means mounted on said supporting structure and having means for supporting the bumper jamb and said first end of each of the spreaders; 
(c) locating means on said lower positioning means and engageable with the edges and one end of the bumper jamb and with one edge of each spreader for locating the bumper jamb and the lower edges of each spreader for locating the bumper jamb and said first end of each spreader in assembled relation with said first ends of the spreaders of each pair respectively adjacent the respective edges of the bumper jamb; 
(d) a generally horizontal upper positioning means mounted on said supporting structure above said lower positioning means; 
(e) a plurality of spacer means on said upper positioning means and each engageable by adjacent sides of the spreaders of one pair adjacent the second ends thereof to space same apart; 
(f) a plurality of pairs of holding means on said upper positioning means for holding the respective pairs of spreaders against said spacer means, respectively; and 
(g) movable stop means on said upper positioning means and engageable by the lower ends of the stiffeners and the split jambs and movable into a position out of engagement therewith.

9. A jig for assembling a pocket door frame which includes a bumper jamb embraced by paired horizontal spreaders extending perpendicularly from the bumper jamb and having first ends abutting opposite edges thereof, two laterally spaced, channel-shaped split-jamb stiffeners telescoped over the opposite, second ends of the respective sets of spreaders which are on opposite sides of the bumper jamb, and two split jambs respectively abutting the stiffeners substantially in alignment with the spreaders of the respective sets, said jig assembling the pocket door frame rotated into a generally horizontal position with the bumper jamb below the stiffeners and split jambs and with the upper and lower edges of the spreaders oriented generally vertically, said jig including in combination:
(a) an upright supporting structure; 
(b) a generally horizontal lower positioning means mounted on said supporting structure and having means for supporting the bumper jamb and said first end of each of the spreaders; 
(c) locating means on said lower positioning means and engageable with the edges and one end of the bumper jamb and with one edge of each spreader for locating the bumper jamb and said first end of each spreader in assembled relation with said first ends of the spreaders of each pair respectively adjacent the respective edges of the bumper jamb; 
(d) a generally horizontal upper positioning means mounted on said supporting structure above said lower positioning means; 
(e) a plurality of spacer means on said upper positioning means and each engageable by adjacent sides of the spreaders of one pair adjacent the second ends thereof to space same apart; 
(f) a plurality of pairs of holding means on said upper positioning means for holding the respective pairs of spreaders against said spacer means, respectively; and 
(g) stop means on said upper positioning means and engageable by the lower ends of the stiffeners and the split jambs.
pairs of spreaders against said spacer means, respectively; and
2) staple-gun locating means on said upper and lower positioning means for positioning a staple gun to drive staples through the split jambs and stiffeners into the spreaders and through the spreaders into the bumper jamb.

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