

[54] **HOLLOWWARE CONSTRUCTION**

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[51] Int. Cl. **B65d 7/44**

[58] Field of Search 220/73, 74, 85; 164/98

[56] **References Cited**

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[57] **ABSTRACT**

An article of hollowware and a method of making same wherein the hollowware has a peripheral flange and a peripheral ornamental mount is cast onto said flange, said ornamental mount being located on the top surface of said flange and extending outwardly of the peripheral edge thereof, the bottom surface of said ornamental mount being substantially flush with the bottom surface of said flange and having integral means for receiving the edge of the flange in imbedded relation therein in order to maintain said ornamental mount securely attached to said flange.

2 Claims, 3 Drawing Figures

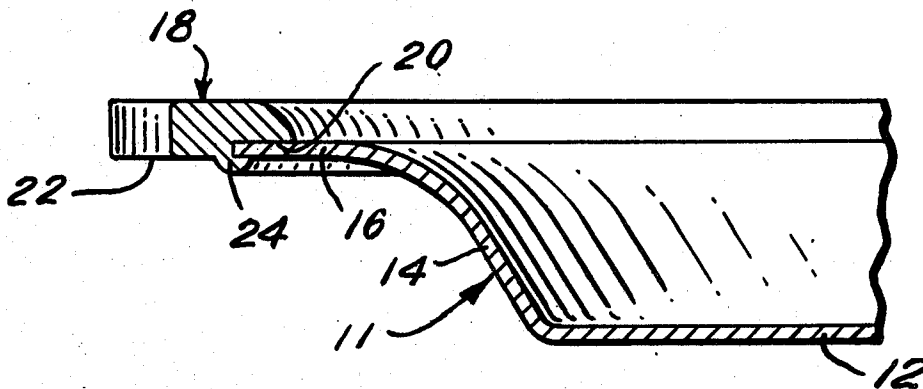


Fig. 1.

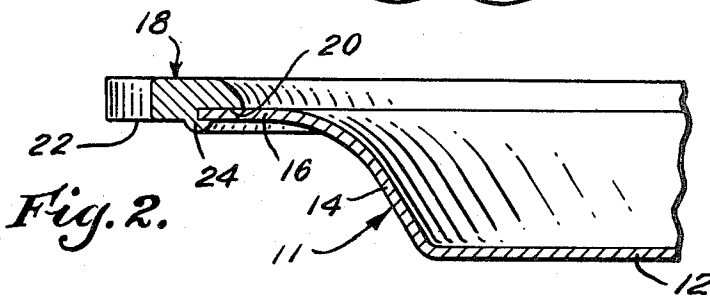
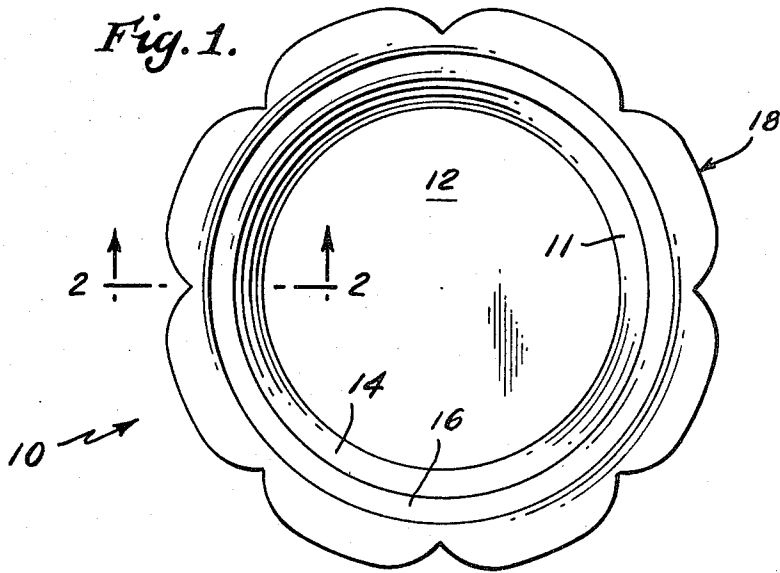


Fig. 2.

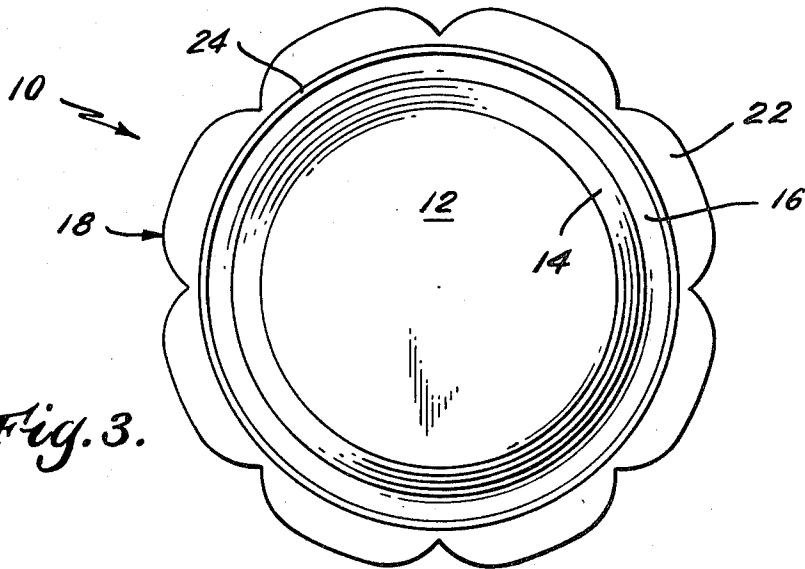


Fig. 3.

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HOLLOWWARE CONSTRUCTION

BACKGROUND OF THE INVENTION

In the manufacture of articles of hollowware, it is well known to cast an ornamental mount and then attach it to the peripheral flange of the article of hollowware whereby the flange of the hollowware assumes an ornamental appearance that would be relatively difficult and expensive to form as an integral part of the flange per se. Expressed differently, more expensive articles of hollowware will normally have an ornamental pattern engraved or formed directly on the flange of the article, but since this is a difficult and expensive procedure, it has been found to be desirable and more economically feasible to cast an ornamental mount and then affix the ornamental casting to the flange of the article.

One well known and often used technique for securing the cast ornamental mount to the flange of the article of hollowware is to provide the flange with an excess peripheral edge that extends outwardly of the ornamental mount throughout the entire periphery of the latter, it being understood that the mount is positioned on the upper surface of the flange and then the mount may be soldered at its inner and outer edges to the flange, after which the excess portion of the flange is trimmed off. This soldering operation, and the trimming off of the excess flange, particularly where the outer periphery of the ornamental mount is of an intricate configuration, represent time consuming and expensive manufacturing operations and for this reason this particular technique of attaching the ornamental mount to the flange of the article of hollowware is disadvantageous. Also, where the excess flange is trimmed a raw edge results that requires expensive and time consuming hand finishing, i.e., the resulting raw edge must be sanded and polished by hand.

Attempts have been made to overcome the above problems by casting the ornamental mount right on to the peripheral edge of the hollowware flange, with the flange edge being embedded within the cast mount. This type of technique has generally proven to be satisfactory, except that the mount is undesirably bulky in that it extends above and below the plane of the hollowware flange, which not only results in a needless waste of material, but also results in an appearance which makes it readily recognizable that the ornamental mount is a separate casting, thus detracting from the ornamental appeal of the article.

SUMMARY OF THE INVENTION

The present invention overcomes the disadvantages of the techniques discussed hereinbefore, even though the present invention still utilizes the basic idea of a cast ornamental mount. However, the present invention eliminates expensive soldering and trimming operations altogether, and still results in a general appearance that closely simulates the final appearance of the article wherein the cast ornamental mount is soldered onto the top surface of the hollowware flange.

In accomplishing this, the ornamental mount is cast directly onto the top surface of the hollowware flange, with a portion of the mount extending outwardly from the peripheral edge of the flange for its entire periphery and with the bottom surface of the mount being substantially flush and coextensive with the bottom surface

of the flange with the exception of a relatively small and inconspicuous bead that is cast as an integral part of the mount on the bottom surface thereof, said bead receiving the peripheral edge of the hollowware flange whereby the latter is imbedded therein in order to securely attach the mount to the hollowware flange.

It is therefore a primary object of this invention to provide means for securing a cast ornamental mount to the peripheral flange of an article of hollowware wherein expensive soldering and trimming operations are eliminated but wherein the finished article nevertheless assumes basically the same appearance as where a cast ornamental mount is soldered to the upper surface of the flange of the article of hollowware and the excess flange of the article is then subsequently trimmed.

Another object is the provision of an article of hollowware of the character described wherein the ornamental mount is cast directly onto the peripheral edge of the flange of the article of hollowware but wherein the finished article belies the fact that the ornamental mount is a separate casting.

Other objects, features and advantages of the invention shall become apparent as the description thereof proceeds when considered in connection with the accompanying illustrative drawings.

DESCRIPTION OF THE DRAWINGS

In the drawings which illustrate the best mode presently contemplated for carrying out the present invention:

FIG. 1 is a top plan view of an article of hollowware embodying my invention;

FIG. 2 is an enlarged section taken on line 2—2 of FIG. 1; and

FIG. 3 is a bottom plan view thereof.

DESCRIPTION OF THE INVENTION

Referring now to the drawings, there is shown generally at 10 an article of hollowware comprising a tray 11 having a bottom wall 12, a peripheral side wall 14, which side wall terminates in an outwardly extending peripheral flange 16. It will be understood that although the article 10 is illustrated as being a tray, the instant invention is applicable to any article of hollowware comprising a peripheral flange of the general nature of the flange 16, as illustrated. The article 10 may be constructed of any suitable metallic material, although usually it is constructed of a non-ferrous alloy such as brass or copper. The only thing that is important is that the tray be constructed of a metallic material that has a melting point higher than that of casting metal, for reasons hereinafter to become apparent.

Secured to the peripheral flange 16 is an ornamental mount 18, it being noted that the mount 18 extends around the entire periphery of the article 10 and extends outwardly from the marginal edge of flange 16 throughout the entire periphery of the latter. Specifically, the mount 18 has a bottom surface portion 20 which is positioned on the top surface of flange 16 and the mount 18 further has a bottom surface portion 22 which is substantially flat and which extends outwardly from the edge of flange 16 in substantially the same plane as the bottom surface of said flange. Integrally formed on the bottom surface 22 of mount 18 is a bead

24 which, as will be noted most clearly in FIG. 2, overlaps the outer edge of flange 16 whereby the latter is imbedded therein to effect the desired securement between mount 18 and flange 16. As will be seen most clearly in FIG. 3, the bead 24 is circular and extends completely around the periphery of mount 18.

In manufacturing the article 10, the metallic tray 11 is positioned in a mold and then the mount 18 is cast directly thereon, it being understood that the bead 24 is simultaneously cast so as to receive the edge of flange 16 in the manner illustrated and described. The bead 24 need only be large enough to receive the edge of flange 16, it being noted that the flange extends approximately half way across the bead for maximum securement. The mount 18 may be cast of any desired casting material, such as lead antimony or a high tin alloy, and it will be obvious that the mount may be cast to any desired ornamental configuration. After being removed from the mold, the article 10 is finished and plated, the final form of the article having an attractive and finished appearance and one which belies the fact the the mount 18 is a separate casting, since the bottom edge of the mount is substantially flush with the bottom edge of the flange 16 except for the relatively small and inconspicuous bead 24.

Thus it will be seen that the construction of article 10 and the method of making same, eliminates the highly skilled soldering operation that is involved where the mount 18 is soldered to the top surface of flange 16 and also eliminates the intricate trimming operation involved in such a procedure. The casting of the mount 18 directly onto the flange 16, as per the instant invention, can be performed by relatively unskilled labor, thus greatly expediting the manufacture of the article 10, while at the same time reducing the manufacturing

cost of same, even though the finished article very closely approaches the appearance of the finished article wherein the mount is soldered onto the top of the flange and then the excess portion of the flange is trimmed away.

While there is shown and described herein certain specific structure embodying the invention, it will be manifest to those skilled in the art that various modifications and rearrangements of the parts may be made without departing from the spirit and scope of the underlying inventive concept and that the same is not limited to the particular forms herein shown and described.

What is claimed is:

1. In an article of hollowware having a peripheral flange, an ornamental mount fixedly and immovably secured to said flange and extending continuously therearound, said mount being positioned on the upper surface of said flange and extending outwardly from the marginal edge thereof, the portion of said mount that extends outwardly from said flange having a substantially flat bottom surface that is substantially flush with the bottom surface of said flange, and integral means on the bottom surface of said mount located intermediate the inner and outer edges thereof, the marginal edge of said flange being imbedded in said means to effect securement of said mount on said flange, said means extending below the bottom surface of said mount a distance just sufficient to receive the marginal edge of said flange, the mass of said means being relatively insignificant when compared with the remainder of said mount, whereby said means is relatively inconspicuous.

2. In the article of hollowware of claim 1, said integral means comprising a continuous bead.

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