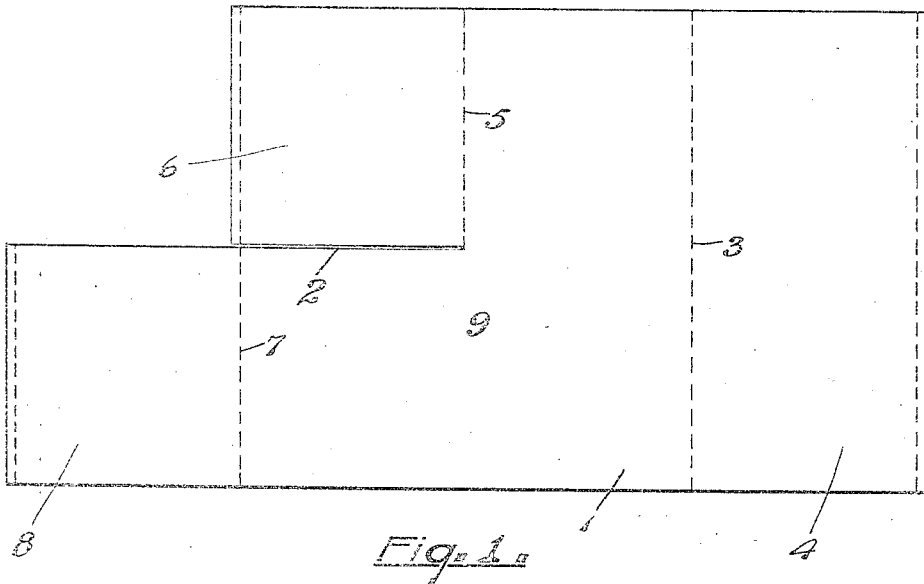
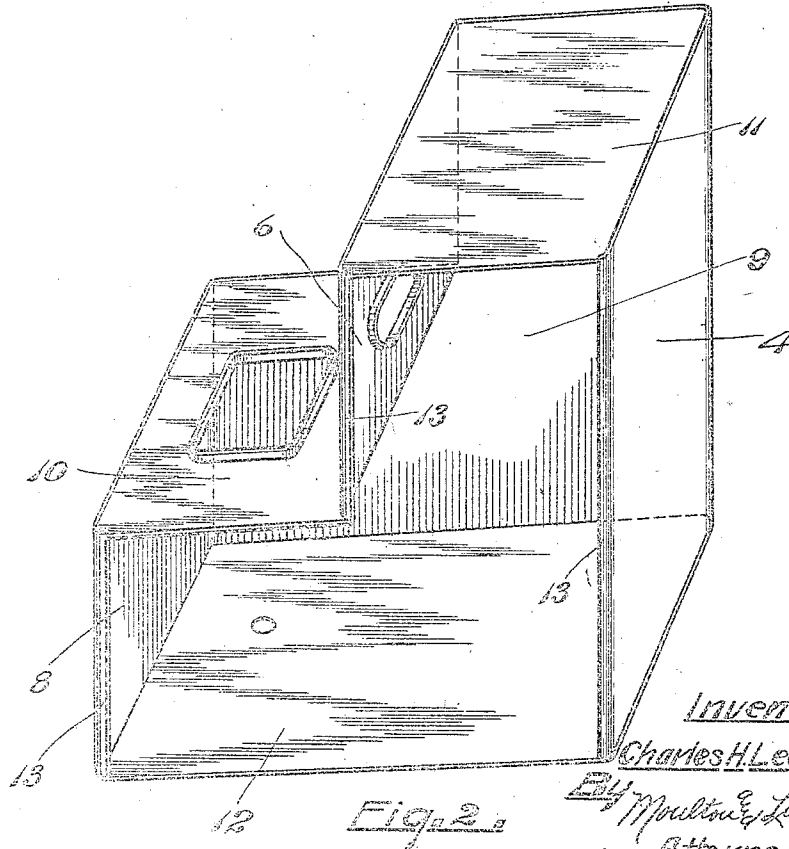


C. H. LEONARD.
 REFRIGERATOR CONSTRUCTION.
 APPLICATION FILED JULY 6, 1916.

1,238,413.

Patented Aug. 28, 1917.



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UNITED STATES PATENT OFFICE.

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REFRIGERATOR CONSTRUCTION.

1,238,413.

Specification of Letters Patent.

Patented Aug. 28, 1917.

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To all whom it may concern:

Be it known that I, CHARLES H. LEONARD, a citizen of the United States of America, residing at Grand Rapids, in the county of Kent and State of Michigan, have invented certain new and useful Improvements in Refrigerator Construction; and I do hereby declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it appertains to make and use the same.

This invention relates to refrigerator linings of sheet metal and a method of constructing the same from a sheet of metal so that an exceptionally strong and rigid structure is produced with no waste of material in the forming of the same. It is the object and purpose of my invention to produce a substantially L-shaped sheet metal refrigerator lining formed as a single unit with the minimum of material and of the maximum strength and rigidity. To these ends I have made my invention, detailed description of which follows; reference being had to the accompanying drawing in which:

Figure 1 is an elevation of the blank from which the major portion of the lining is made and,

Fig. 2 is a perspective view of said lining. Like reference characters refer to like parts in the views of the drawing.

In the construction of the lining a sheet of metal 1 is used and is slit at a point between the sides thereof as indicated at 2 substantially one-half of the length of the sheet. A portion of the metal is cut away as shown in the upper left hand corner in Fig. 1 and the plate thus formed is bent substantially on the vertical line 3 forming one vertical side 4 of the lining. It is then bent on the line 5 which extends vertically at right angles to and from the inner end of the slit 2 heretofore mentioned, there being in this manner formed a partial side 6 parallel to the side 4. The metal is then bent substantially upon the line 7 making the side 8 which is also parallel to the side 4 but spaced a greater distance therefrom than is the side 6. The back 9 which is left after the metal has been bent is substantially L-shaped the sides 4, 6, and 8 being integral therewith and projecting forwardly therefrom. The upper edge of the side 8 and the lower edge of the side 6 lie in the same horizontal plane and are connected by a

plate 10 which in practice is that part of the plate removed at the upper left hand corner as shown at Fig. 1 in forming the blank from which the lining is made. To complete the lining a top 11 is secured between the upper edges of sides 4 and 6 and the upper edge of the vertical leg of the L-shaped back 9 and a bottom 12 is secured between the lower edges of sides 4, 8, and the lower edge of the back 9. The members 10, 11, and 12 may be fastened in place in any suitable manner such as by soldering, brazing or the like. I prefer also to bend the forward edges of the sides 4, 6, and 8 inwardly toward each other as shown at 13 though this is not an essential feature and comprises no essential part of my invention.

A refrigerator lining thus formed may be made from sheet metal without waste and at the same time is of exceptional strength and rigidity due to the fact that the side 6 is integral with and bent forward from the back 9 whereby a distortion of the side in a downward direction is a practical impossibility. Sheet metal linings of this character are enameled and in the process of enameling subject to intense heat. The construction outlined is one fully capable of sustaining this heat and there is no warping or sagging of the reentrant portion of the L-shape due to the fact that the side 6 is integrally connected with the back. Heretofore it has been customary to construct the bottom, sides and top portions from a continuous sheet of metal not having any integral connection with the back which is supplied as a separate piece such method and the product formed thereby being defective on account of the lack of inherent strength such as is present in my invention as outlined.

I claim:—

1. The method of constructing an L-shaped refrigerator lining which consists in providing a rectangular sheet of metal, then slitting it for a portion of its length between the upper and lower side edges thereof and removing a section from the end of the part above said slit, then bending a side forward the full height of the sheet, then bending sides forward from the parts above and below the slit, said side bent from the part above the slit being bent forward at the end of said slit, and the side bent from the part below the slit being positioned farther from

the first side than said side from the part above the slit, and then providing top and bottom members and securing them in place to complete the lining.

5 2. The method of constructing an L-shaped refrigerator lining which consists in providing a rectangular sheet of metal, then slitting it for a portion of its length between the upper and lower edges thereof and removing a section from the end of the part
10 above said slit, then bending a side forward

the full height of the sheet, then bending the part above the slit forward at the inner end of the slit, and the part below the slit forward substantially at the outer end of the
15 slit, and then welding a bottom and two top members in place between the back and sides to complete the lining, substantially as described.

In testimony whereof I affix my signature. 20

CHARLES H. LEONARD.