C. H. HUSTON.

METAL ARTICLE AND METHOD OF JOINTING THE SAME.

APPLICATION FILED APR. 3, 1918.

1,369,109. Patented Feb. 22, 1921.

Fig. 1.

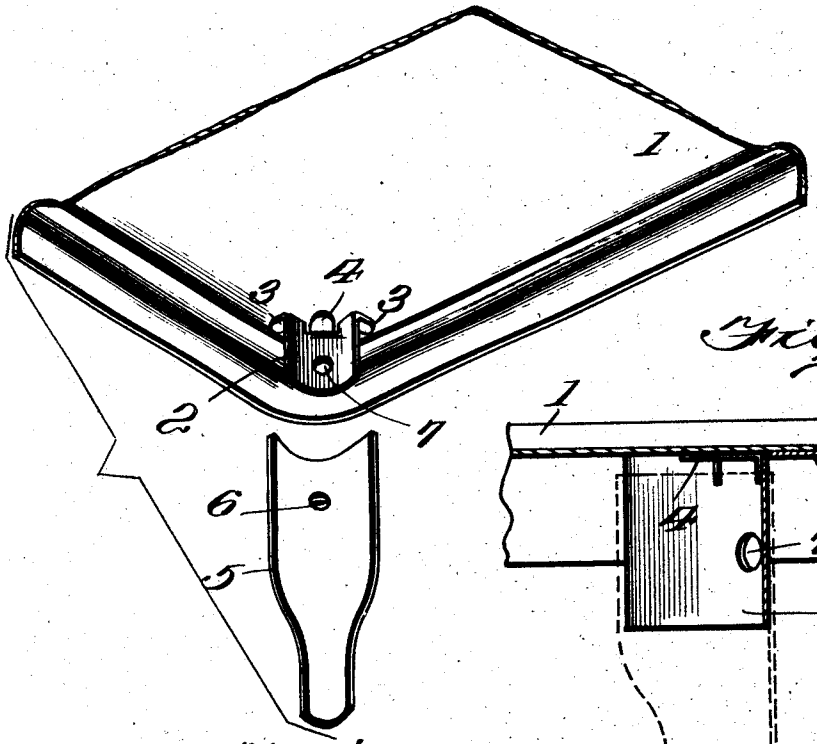


Fig. 2.

Fig. 3.

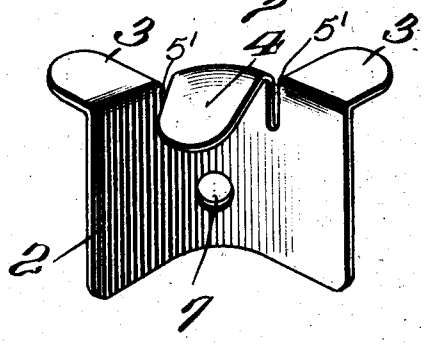
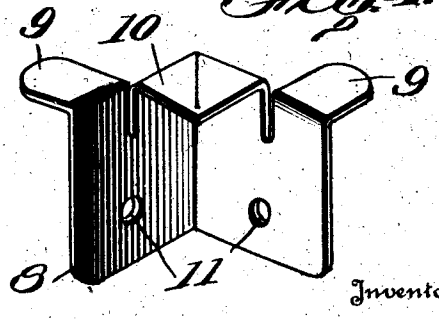


Fig. 4.



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METAL ARTICLE AND METHOD OF JOINTING THE SAME.

1,369,109. Specification of Letters Patent. Patented Feb. 22, 1921.

Application filed April 3, 1918. Serial No. 226,548.

To all whom it may concern:

Be it known that I, CLAUDIUS H. HUSTON, a citizen of the United States, residing at Chattanooga, in the county of Hamilton and State of Tennessee, have invented certain new and useful Improvements in Metal Articles and Methods of Jointing the Same, of which the following is a specification.

One of the great disadvantages of metallic utensils, where legs or connections are fastened by means of a weld union, is the buckling or distortion of the metal adjacent to the connection, thereby rendering the appearance of the part objectionable, uneven and unsanitary.

It is therefore the object of this invention to provide means for fastening the legs, brackets or connections of the utensil to the base by a weld union and at the same time leaving the surface of the part perfectly smooth and free from visible means of connection and objectionable contraction and expansion strain.

It is another object of this invention to provide means for the removal of the legs or parts from the utensil without interfering with the permanent connection between the utensil and connecting brackets.

With these and other objects in view, which will appear as the nature of the invention is better understood, the invention consists in the novel features hereinafter described, illustrated in the accompanying drawings and more particularly pointed out in the appended claims.

Referring to the drawings:

Figure 1 is a perspective of the underside of a portion of a table top showing the fastening means connected thereto, and the upper portion of a leg to be connected therewith.

Fig. 2 is a section through the fastening member and the table top, and showing the same connected therewith.

Fig. 3 is a perspective of the fastening member.

Fig. 4 is a modified form of the fastening member.

As embodied in the accompanying drawing, 1 represents a portion of a metal top to which is connected on the underside thereof, a number of brackets, 2, to correspond with the number of leg strips required to complete the table. The depth of the bracket 2 is sufficiently long to telescope the upper portion of the leg strip 5, and when fastened together by means of a bolt passing through the holes 6 and 7, will form a rigid support for the table top 1.

Referring to the bracket 2, Fig. 3, the upper portion of the same is provided with perpendicular slots 5′ which form a number of strips. The strips are turned over in a horizontal plane, with each adjoining one going in the opposite direction and forming tongues such as 3 and 4, or all going in one direction with clearance between each tongue, to allow for contraction and expansion. It will be noted that these tongues are in no way connected, being isolated from each other by means of the slots 5′.

The weld union between the bracket 2 and the table top 1 is localized through these tongues upon the application of an electric current, gas, or other artificial heat and pressure, in the usual manner.

By this method of forming the tongues in straddle or zig-zag form and making each one a separate spot weld in itself, a comparatively large area of contact is derived, while at the same time, the small heating surface contained in each tongue, I have found in practice to be not sufficiently great to effect the state of the metal in the utensil, thus obviating any appreciable expansion or contraction of the metal and allowing the surface to remain in its smooth original state.

While I have shown the bracket to be curved in section, the same method of forming the tongues on the upper end thereof may be used in any form of bracket to correspond with the design of the leg or part to be attached, for instance, in Fig. 4. I have shown the bracket 8 of angle shape, with the tongues 9 and 10 formed in a similar manner to the lugs 3 and 4 of the bracket 2. The bolt holes 11 may be used for the same purpose as the hole 7 in bracket 2.

While I have shown the leg strip or part connected to the bracket by means of a bolt, this connection may be formed by a weld union, or I may prefer to make the bracket

2 to form the upper portion of the leg strip itself and be connected direct to the utensil.

What I claim and desire to secure by Letters Patent is:

1. The method of connecting a metal plate and a metal strip together consisting in forming tongues at one end of the metal strip, bending the tongues substantially at right angles to said strip without bending said strip, placing the tongues in contact with said plate, and applying electric heating current and pressure to the plate and tongues welding the same directly together.

2. The method of connecting a metal plate and a metal strip together consisting in forming a plurality of spaced tongues at one end of the strip without bending the latter, bending one of the tongues in one direction substantially at right angles to said strip without bending said strip, bending another tongue in the opposite direction substantially at right angles to the strip, placing the tongues in contact with said plate, and applying electric heating current and pressure to the tongues and plate welding the same directly together.

3. A metal article comprising a metal strip provided at one end with a plurality of spaced tongues which extend substantially at right angles to said strip, said tongues being spaced apart to the point of the angle and a sheet metal part integrally united with said tongues by a welded joint.

4. A sheet metal table comprising a top, a plurality of bracket strips located on the under side of the top and each provided with a plurality of spaced tongues which are bent substantially at right angles to said strip, said tongues being spaced apart to the point of the angle, said tongues being integrally united with said top by welded joints, and legs secured to the bracket strips.

In testimony whereof I have set my hand.

CLAUDIUS H. HUSTON.