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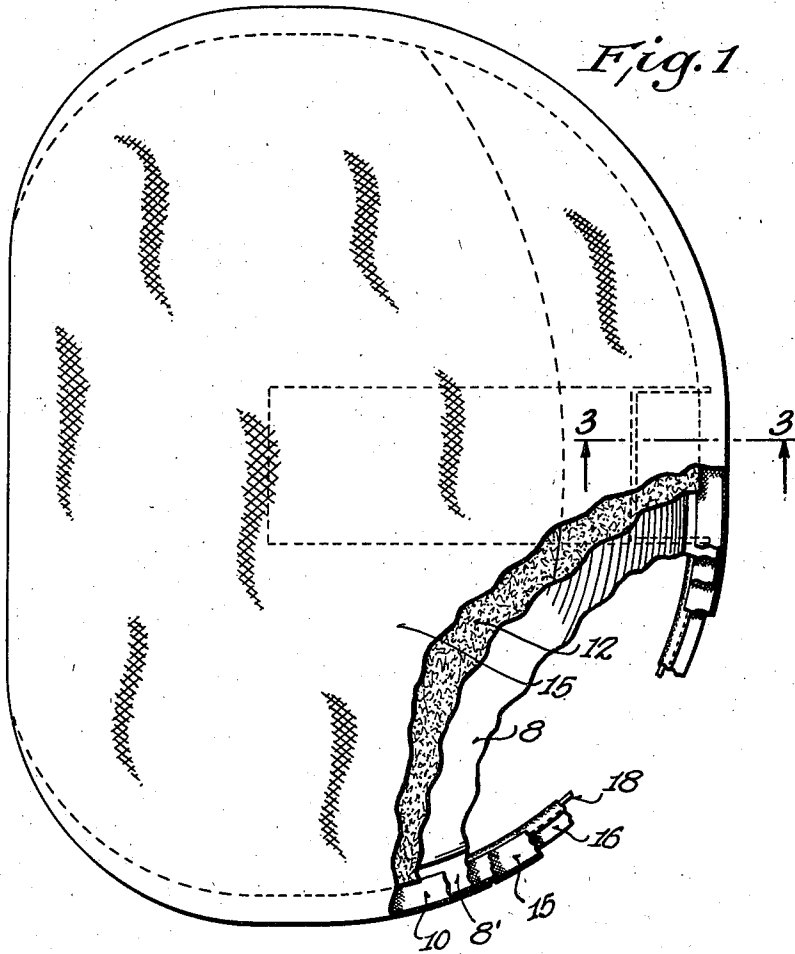
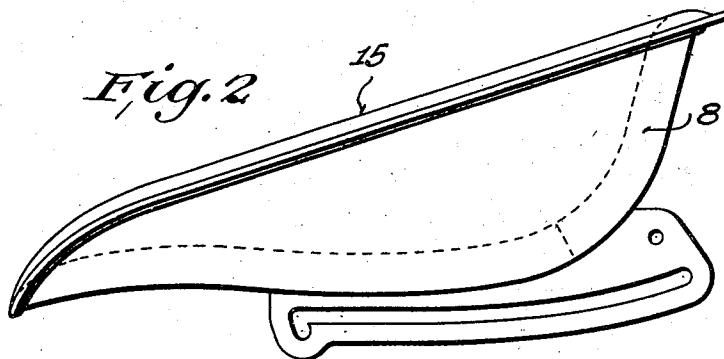
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CUSHIONED SEAT AND METHOD OF MAKING THE SAME

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2 Sheets-Sheet 1



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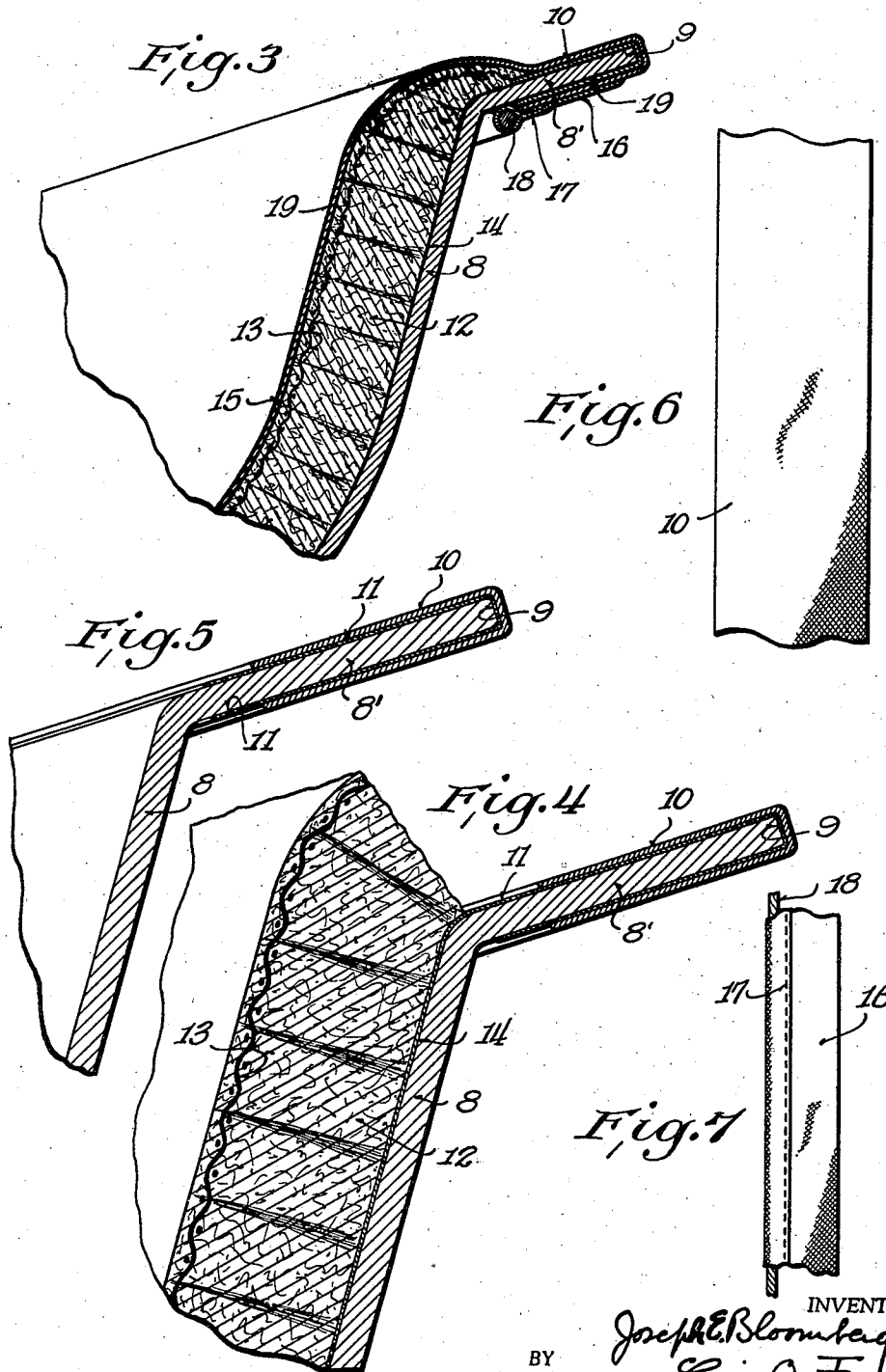
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CUSHIONED SEAT AND METHOD OF MAKING THE SAME

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UNITED STATES PATENT OFFICE

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CUSHIONED SEAT AND METHOD OF
MAKING THE SAMEJoseph E. Bloomberg, Milwaukee, Wis., assignor
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Application December 30, 1939, Serial No. 311,889

4 Claims. (Cl. 155—184)

The invention relates to cushioned seats and a method of making the same.

The object of the invention is to provide a new and improved cushion structure for metal seats, more particularly deeply dished metal seats and an expeditious method of producing this structure and particularly to simplify the method heretofore proposed by me in my prior U. S. application Serial No. 123,140, filed January 30, 1937, which issued as Patent No. 2,246,662 on June 24, 1941, of securing the covering over the cushion and to the edge portion of the seat. More particularly, according to the present invention, an anchor and wear strip is provided which is cemented directly to the edge of the metal seat, thus doing away with the riveting and the subsequent stitching operations of the prior application and the leather binding thereof, and the covering is cold-vulcanized to this strip and to a marginal and finishing strip having a non-stretching edge.

A further object of the invention is to provide an upholstered metal seat in which all stitching, tacks, rivets, nails, and the like have been eliminated.

The invention further consists in the several features hereinafter set forth and more particularly defined by claims at the conclusion hereof.

In the drawings:

Fig. 1 is a plan view of a seat embodying the invention, parts being broken away;

Fig. 2 is a side elevation view of the seat;

Fig. 3 is a detailed sectional view taken on the line 3—3 of Fig. 1;

Fig. 4 is an enlarged detailed sectional view, similar to Fig. 3, with parts broken away and parts omitted;

Fig. 5 is a detailed vertical sectional view through the seat during one stage of manufacture;

Fig. 6 is a plan view of a portion of the wear strip;

Fig. 7 is a plan view of a portion of the binder strip.

Referring to the drawings, the numeral 8 designates a seat body of stamped sheet metal which is deeply dished and curved for comfort and has a flanged edge portion 8' whose edges 9 due to stamping are relatively sharp. Over the edge portion of this metal body I secure a wear and anchor strip 10 which is cemented to said body by a coating of naphtha-rubber cement 11 or other suitable adhesive. The anchor strip 10 is of heavy canvas, cut on the bias and placed over the edge in the form of a U-shaped band extending

around the seat body. After cementing this strip to the body, these parts are allowed to stand for a considerable time until the cement has set, for example a period of twelve hours.

The cushioning material 12 may be of any suitable kind such as any suitable animal or vegetable fiber or rubber such as sponge rubber. Where animal or vegetable fibers are used, they are preferably felted together in any suitable manner. The cushioning material herein shown is hair felt in which the fibers are felted together by a needle-punching process during which they are also needled to a piece of woven fabric 13 which is usually an open mesh burlap. This cushioning material 11 with the burlap side up is secured by naphtha cement 14 to the metal seat body and extends over the entire seat cavity and projects slightly over the flanged edge portion 8' thereof. This cushioning material may be secured to the seat body by cementing it thereto at the same time that the anchor strip 10 is secured to said body, that is, the cement 11 and 14 are parts of the same general coating.

Thereafter a covering 15 of heavy duck canvas has one side coated with a latex rubber cement which coated side is laid down over the top of the cushioning material and then directly after stripped therefrom leaving a coating of latex on the burlap covered side of the cushioning material as well as on the canvas. Then these cement coated parts are allowed to stand until they become tacky, and then in this condition the cover is applied to cement coated side of the cushion, first at its center, and then outwardly along the sides, and then pressed against said material by a heavy weight. While thus weighted, the covering is stretched and drawn over the edge of the seat and brought down into adhesive engagement with both sides of the anchor strip while drawing it over the edge of the seat.

A marginal strip 16 is formed of fabric, such as canvas, cut on the bias, and turned over on one edge and stitched down at 17 over a reinforcing member 18 such as a relatively non-stretchable cord or wire which acts to form a bead on one edge of the strip. This strip with the beaded edge innermost is secured by latex adhesive to the part 19 of the cover, and with its ends brought together the beaded edge forms a relatively non-stretchable binder for the outer edge portion of the seat. Thereafter the covering 15 and the strip 16 are given a heavy coating of latex which is allowed to stand and become rubber by cold vulcanization, making the seat completely waterproof, and then this rubber coated

seat structure is given a finish coating of pyroxylin lacquer.

With the above construction the reinforcing member 18 acts to hold the marginal strip 16 against removal, and this in turn is so firmly bonded to the turned over edge of the covering 15 and the anchor strip 10 that it holds all these parts against removal even though the cement bond between the seat body and the strip 10 fails, and this has been demonstrated by actual tests. Thus after the parts forming the edge are cemented together, the member 18 prevents them from slipping off or being pulled off of said edge. It is also to be noted that the strips 10 and 16 are cut on the bias so that when cemented down they will readily stretch or give to conform to the curvature of the seat body.

I desire it to be understood that this invention is not to be limited to any particular form or arrangement of parts except in so far as such limitations are included in the claims.

What I claim as my invention is:

1. In a seat, the combination of a dished metal seat body, a fabric wear strip cemented to the outer edge of said body on both sides of said edge, cushioning material secured to said body, and a covering of flexible material adhesively secured to said cushioning material and to both sides of said wear strip.

2. In a seat, the combination of a dished metal seat body, a fabric wear strip cemented to the outer edge of said body on both sides of said

edge, cushioning material secured to said body, a covering of flexible material adhesively secured to said cushioning material and to both sides of said wear strip and having its outer edge folded over the edge of said seat body, and a marginal strip having an inner edge portion forming a relatively non-stretchable binder edge secured to the outer edge of said covering.

3. In a seat, the combination of a dished metal seat body, a fabric wear strip cemented to the outer edge of said body on both sides of said edge, cushioning material secured to said body, a covering of flexible material adhesively secured to said cushioning material and to both sides of said wear strip and having its outer edge portion folded over the edge of said seat body, and a marginal fabric strip secured to said outer edge portion of said covering and having a non-stretchable cord enclosed in the inner edge thereof.

4. In a seat, the combination of a dished metal seat body, a fabric wear strip cemented to the outer edge of said body on both sides of said edge, cushioning material for said body, a covering of flexible material extending over said cushioning material and adhesively secured to both sides of said wear strip, and relatively non-stretchable binder means secured to the under side of said covering to hold said covering in place on said seat body even if said wear strip should become loosened from said body.

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