July 17, 1956 J. BRUCE 2,754,575

METHOD OF MAKING A FLEXIBLE GLASS-RUN CHANNEL

Filed Nov. 24, 1953

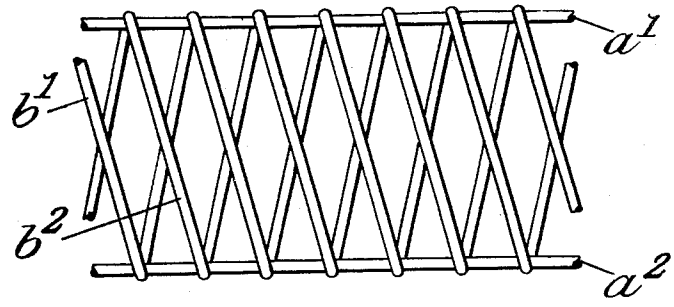


Fig. 1.

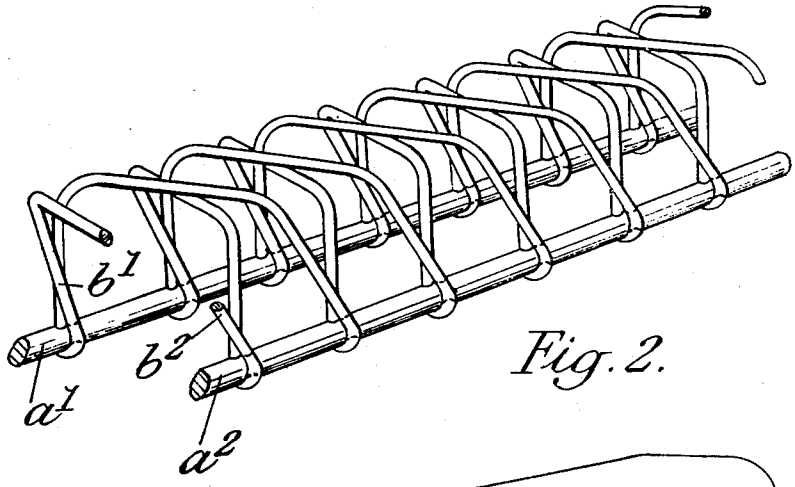


Fig. 2.

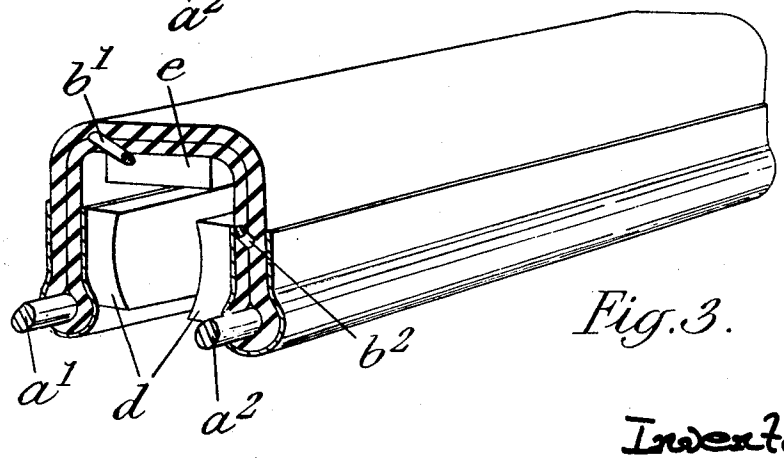


Fig. 3.

Inventor:
John Bruce
By Eugene + Purdy
Attorneys

United States Patent Office 2,754,575 Patented July 17, 1956

2,754,575

METHOD OF MAKING A FLEXIBLE GLASS-RUN CHANNEL

John Bruce, Northmoor, England, assignor of one-half to Sidney Leigh, Shillingford, England

Application November 24, 1953, Serial No. 394,128

2 Claims. (Cl. 29—460)

This invention relates to a method of manufacturing glass-run channels, primarily intended for the windows of automobiles and the like.

Such channels commonly consist of rigid channel bars, lined for instance with rubber and felt; but where the outline of the glass or like panel is not rectilinear it is advantageous to make the channel of a material that can be bent, and that will then retain the shape that is so imparted to it.

According to the present invention a simple and convenient form of the channel is produced by the method of placing two straight wires of fairly heavy gauge, preferably of iron or steel, parallel to one another at a suitable distance from each other, passing a wire of lighter gauge to and fro round them in zigzag formation, and keeping it in position, bending the flat strip thus obtained into channel form, eneveloping the channel thus formed with the usual lining and finally bending it into any curved form, as may be required.

The original spacing between the parallel foundation wires depends upon the size of the cross-section desired.

Referring to the accompanying drawing showing one mode of carrying the invention into effect,

Figure 1 shows the formation of the original strip comprising the zigzag wire around the two stouter wires;

Figure 2 shows the bending of the strip into the channel form; and

Figure 3 is a perspective view of the finished channel.

Referring to the drawing, a^1, a^2 are two wires of fairly heavy gauge which are placed parallel to each other at the required distance, according to the size of the channel to be shaped. b^1, b^2 are two wires of lighter gauge which are placed in zigzag formation around the stouter wires a^1, a^2. These zigzag wires are started to be placed from one end of the parallel wires, keeping the successive turns fairly close together and proceeding progressively to the other end. In order to keep these wires in position, the stouter wires are serrated to receive the zigzag formation. After the wire foundation has thus been produced, as shown in Figure 1, the same is bent over a former to form a channel, as shown in Figure 2.

The glass-run channel is finished, as shown in Figure 3, by enveloping the bent frame shown in Figure 2 with a lining of rubber c, to which there is applied a lining of moquette d and a felt lining e. The channel thus completed is capable of being bent into any curved form, according to the profile of the window to which it is to be applied.

The cross-section of the channel may be rectangular or rounded, as required. Flanged channels and double channels may be similarly produced, additional foundation wires being provided where necessary.

I claim:

1. A method of manufacturing a flexible glass-run channel for the windows of automobiles and the like which consists in holding two straight metal wires, serrated at intervals along their length and of fairly heavy gauge, parallel to one another at a suitable distance apart, winding a wire of lighter gauge to and fro in zigzag formation between the straight wires and around the serrations therein to maintain the straight wires in position, bending the wire foundation thus produced over a former to form a channel, enveloping the bent foundation with a lining material such as rubber and bending the channel longitudinally into any curved form as may be required.

2. A method as set forth in claim 1 including the step of also lining the interior of the channel with suitable material such as felt and moquette as required.

References Cited in the file of this patent

UNITED STATES PATENTS

2,021,972	Vogt	Nov. 26, 1935
2,026,973	Greene	Jan. 7, 1936
2,216,105	Balfe	Oct. 1, 1940