

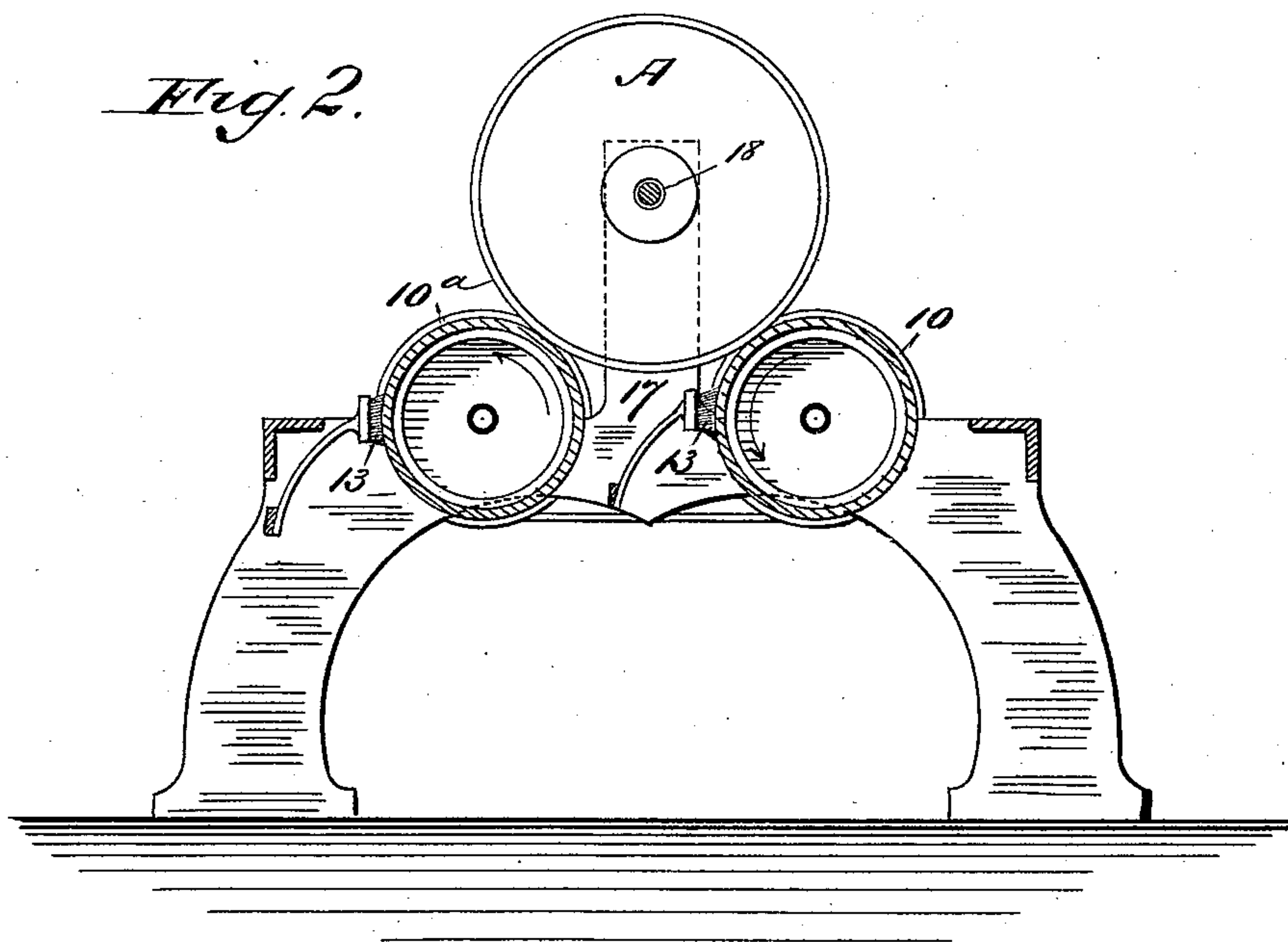
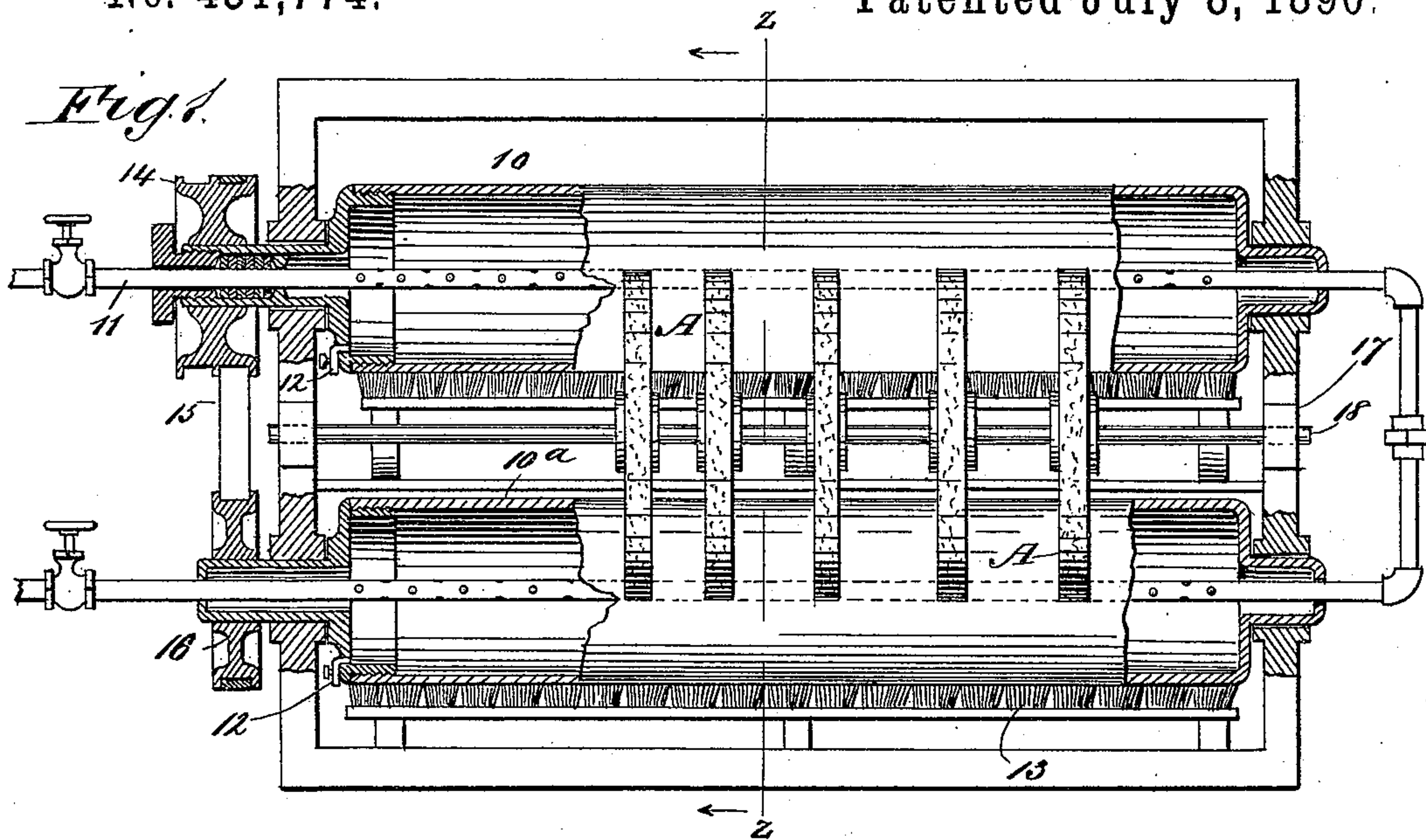
(No Model.)

F. KOHNLE.

METHOD OF FINISHING EMERY POLISHING WHEELS.

No. 431,774.

Patented July 8, 1890.



WITNESSES:

F. M. Ardle.
C. Sedgwick

INVENTOR:

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UNITED STATES PATENT OFFICE.

FREDERICK KOHNLE, OF DAYTON, OHIO.

METHOD OF FINISHING EMERY POLISHING-WHEELS.

SPECIFICATION forming part of Letters Patent No. 431,774, dated July 8, 1890.

Application filed November 11, 1889. Serial No. 329,883. (No model.)

To all whom it may concern:

Be it known that I, FREDERICK KOHNLE, of Dayton, in the county of Montgomery and State of Ohio, have invented a new and Improved Method of Finishing Emery Polishing-Wheels, of which the following is a full, clear, and exact description.

Prior to my invention emery polishing-wheels of the class used by electroplaters and other metal-polishers were manufactured by applying glue and emery to the peripheral faces of the hubs or wheel-bodies, then rolling the wheels to evenly spread the emery and force it into the glue, and finally hanging the wheels up to dry; but this process is exceedingly unsatisfactory, inasmuch as the wheels are not always true, and inasmuch as it takes a number of hours for the emery and glue to dry properly. It is to obviate the objections above pointed out that I have adopted the method forming the subject-matter of this application.

The invention consists, essentially, in applying the glue and emery and in then revolving the freshly-coated wheel in contact with a heated cylinder or cylinders, all as will be hereinafter more fully explained, and specifically pointed out in the claim.

Reference is to be had to the accompanying drawings, forming a part of this specification, in which similar figures of reference indicate corresponding parts in both views.

Figure 1 is a plan view, in partial section, of a machine arranged for use in carrying out my invention; and Fig. 2 is a cross-sectional view on the line *z z* of Fig. 1.

In the drawings, 10 and 10^a represent cylinders that are heated, preferably, by steam introduced through a pipe 11, which enters the cylinder 10 and is carried through the said cylinder and back through the cylinder 10^a, the pipe-sections within the cylinders being per-

forated, as shown. Each cylinder is provided with a drip-cock 12, and in connection with each cylinder I arrange brushes 13, which act to clear the peripheral faces of the cylinders. A driving-belt runs in engagement with a pulley 14, which controls the cylinder 10, and upon one section of the pulley 14, I mount a belt 15, which drives a pulley 16, that controls the cylinder 10^a. At either end of the frame in which the cylinders are mounted I arrange standards 17, that are adapted to receive a rod or bar 18, upon which the emery-wheels are mounted during the time that they are being operated upon.

The machine above described is the construction which I prefer to employ; but it will of course be understood that the cylinders might be heated by gas or otherwise.

In operation a coating of emery and glue is applied to the peripheral faces of the wheels, which wheels are shown at A, and the wheels so coated are mounted upon the rod or bar 18, the parts being so proportioned that the peripheral faces of the coated wheels will just rest upon the cylinders 10 and 10^a. Then, if the cylinders be revolved, the wheels A will also be revolved and the emery and glue will be evenly spread thereon and quickly dried and the emery forced into the glue.

Having thus fully described my invention, I claim as new and desire to secure by Letters Patent—

The herein-described method of finishing emery-coated wheels, which consists in applying a coating of glue and emery to the peripheral face of the wheel and in then revolving the wheel in contact with a heated cylinder, substantially as described.

FREDERICK KOHNLE.

Witnesses:

H. H. PRUGH,
G. G. PRUGH.