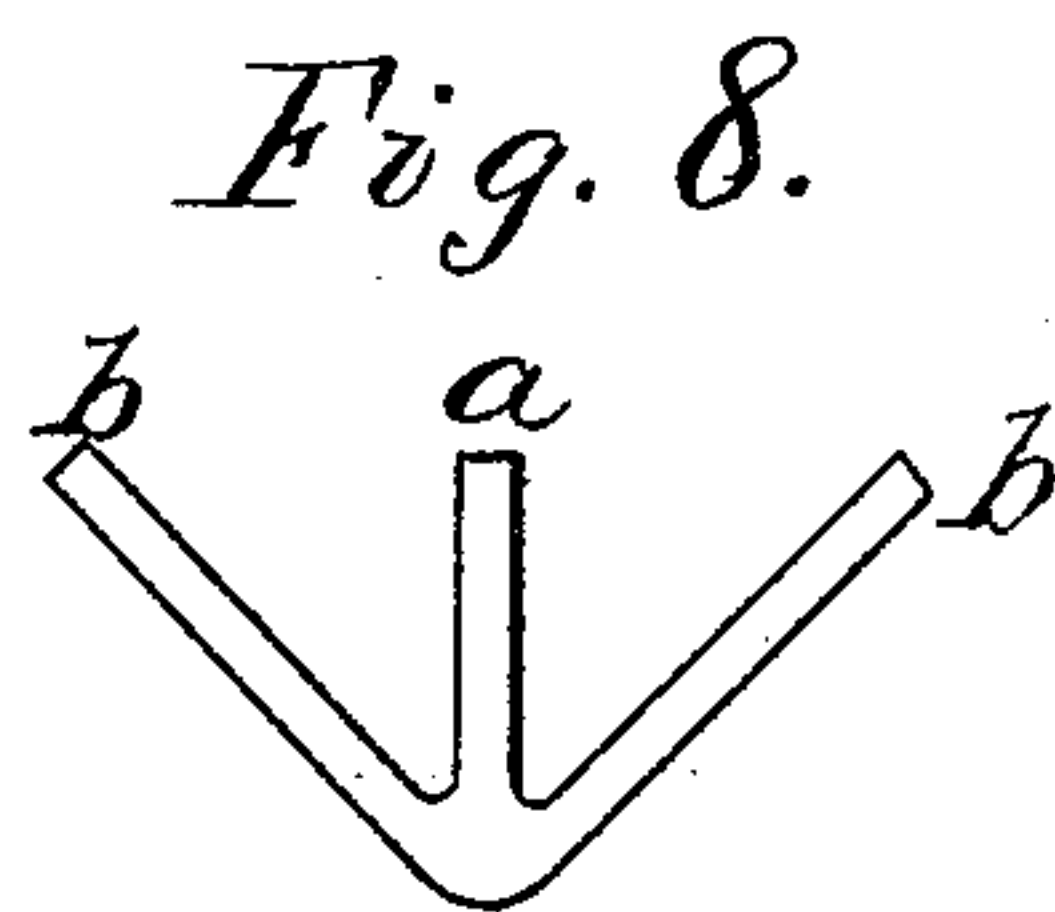
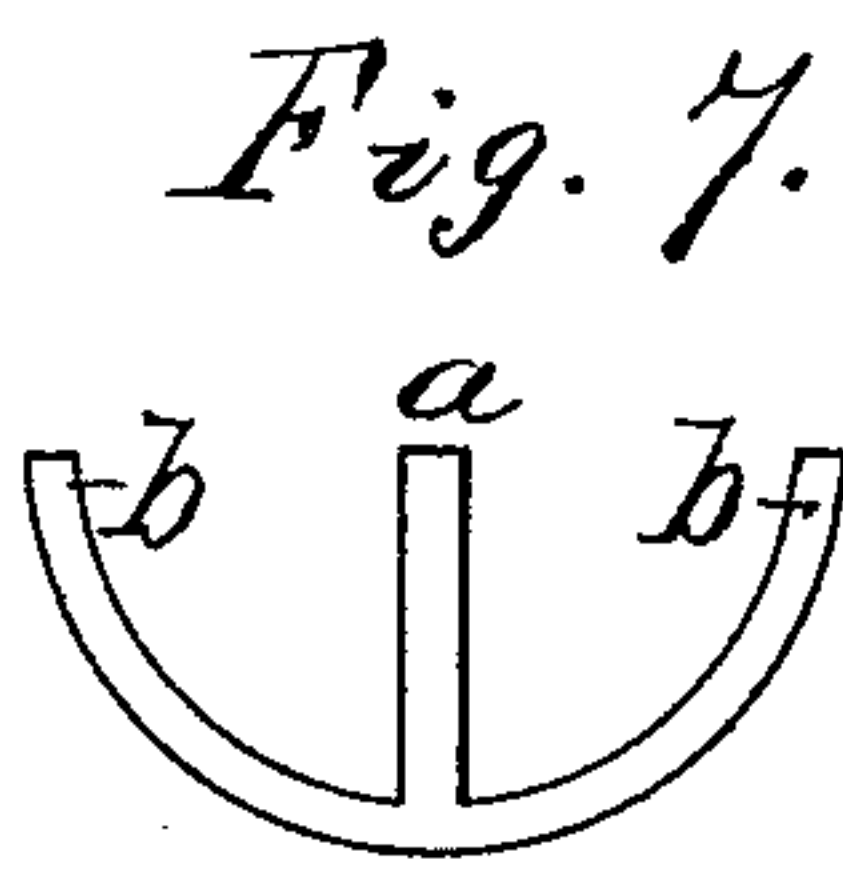
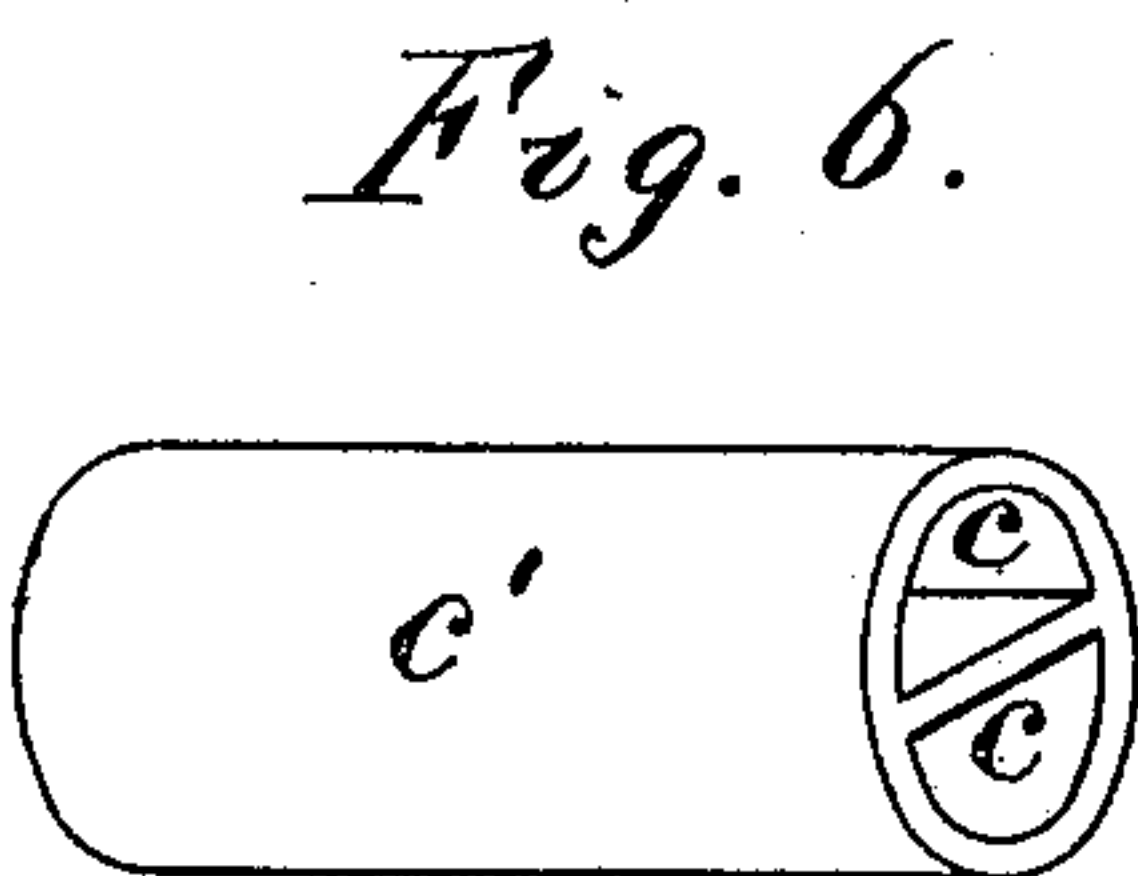
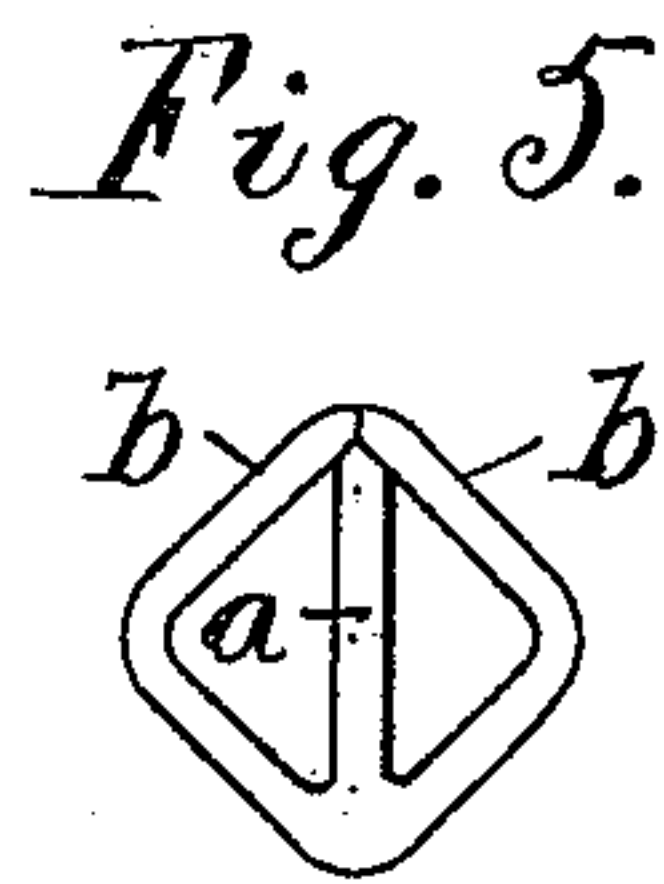
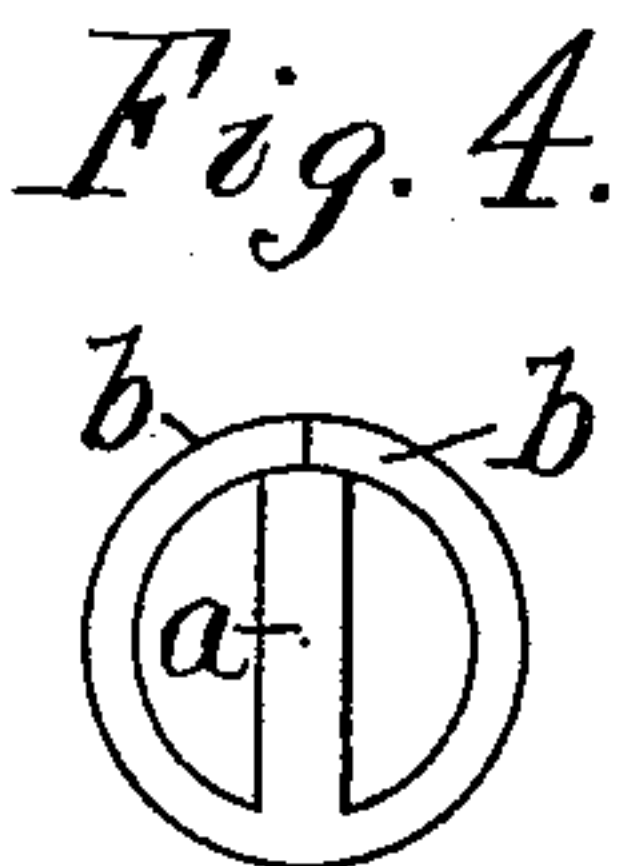
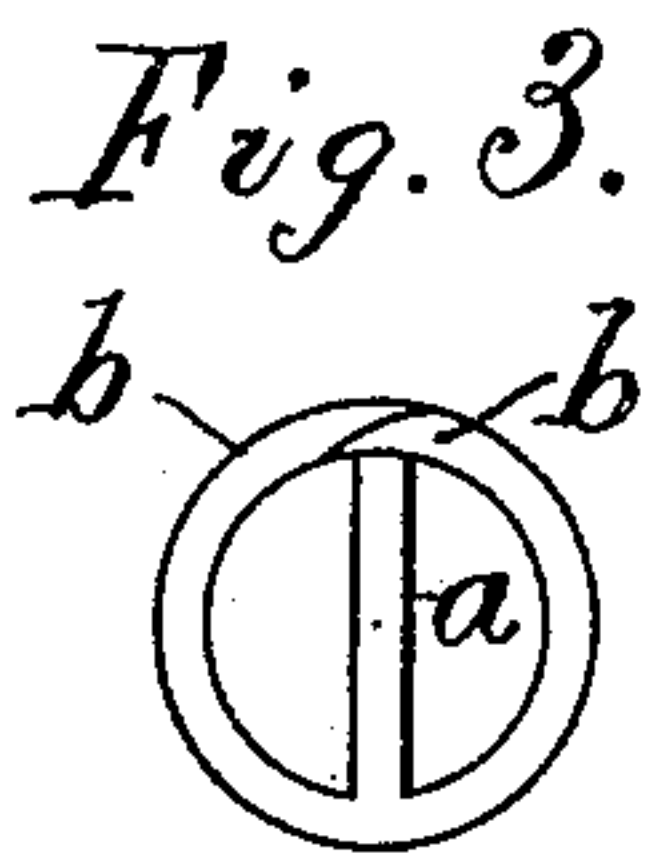
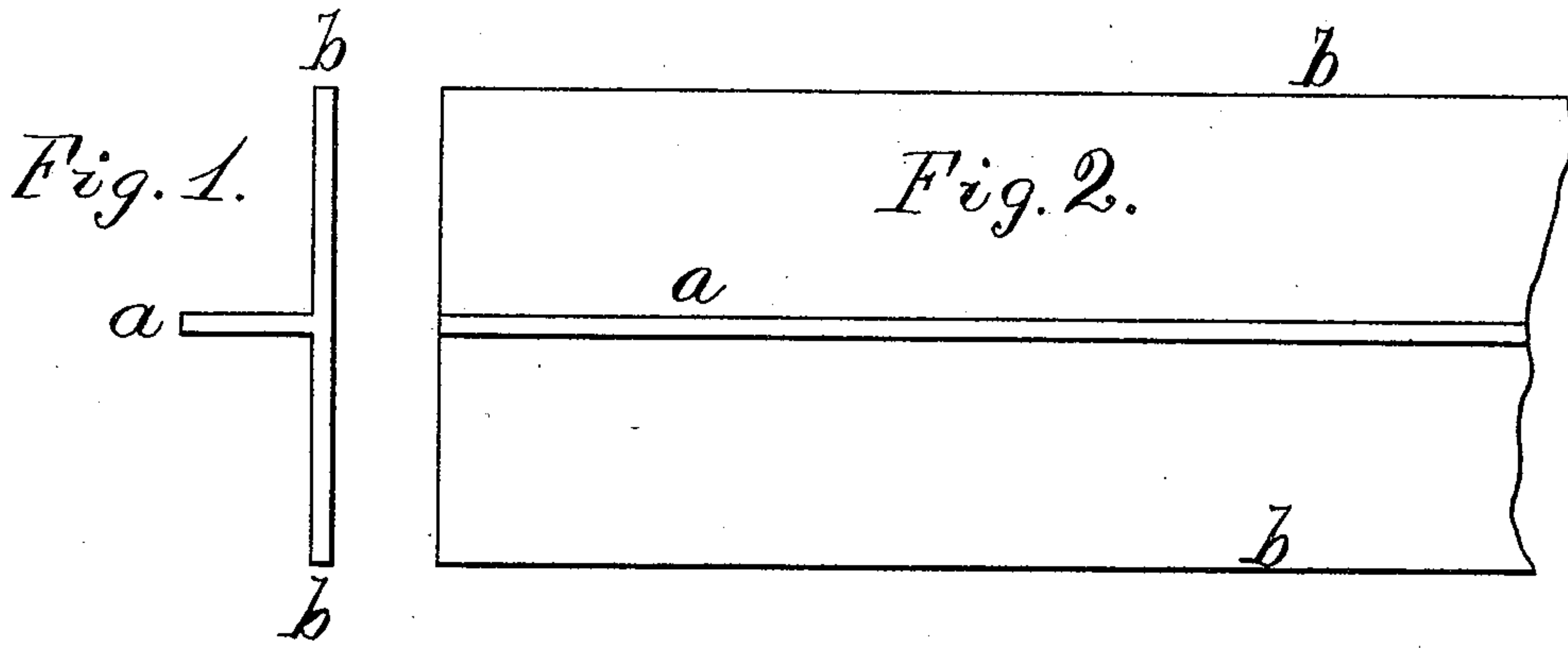


(No Model.)

J. J. HOGAN.  
PARTITIONED PIPE.

No. 459,908.

Patented Sept. 22, 1891.



Attest:  
J. C. Fischer.  
S. H. Sommer

Inventor.  
J. J. Hogan, per  
Crane & Miller, atty

# UNITED STATES PATENT OFFICE.

JOHN J. HOGAN, OF BROOKLYN, ASSIGNOR TO THE HOGAN ENGINEERING COMPANY, OF NEW YORK, N. Y.

## PARTITIONED PIPE.

SPECIFICATION forming part of Letters Patent No. 459,908, dated September 22, 1891.

Application filed August 31, 1889. Renewed March 9, 1891. Serial No. 384,374. (No model.)

*To all whom it may concern:*

Be it known that I, JOHN J. HOGAN, a citizen of the United States, residing at Brooklyn, Kings county, New York, have invented certain new and useful Improvements in Partitioned Pipes, fully described and represented in the following specification and the accompanying drawings, forming a part of the same.

The object of this invention is to furnish a cheap and strong pipe with partition extended longitudinally through its bore, by which construction it is adapted to convey two separate fluids or to conduct gas and electric wires separately to their destination.

In this invention a blank of T shape is first formed, with the lateral webs nearly twice as wide as the transverse web. The lateral webs are then bent with their edges adjacent to the edge of the transverse web, and are finally secured to one another and to such web by welding, brazing, soldering, or othersuitable means. The pipe may be made of round, square, corrugated, or any other desired form externally, and the edges of the lateral webs may be either scarfed or butted where they are joined together.

The construction will be understood by reference to the annexed drawings, in which—

Figure 1 is an end view of the T-shaped blank; Fig. 2, a view of the same, looking toward the transverse web; Fig. 3, an end view of a round pipe formed by scarfing the edges of the lateral webs and securing them together upon the edge of the transverse web. Fig. 4 is an end view of a similar pipe formed by butting the edges of the lateral web together and securing them upon the transverse web. Fig. 5 is an end view of a partitioned pipe of square form externally, and Fig. 6 is a perspective view of the completed pipe. Figs. 7 and 8 are alternative sections of the T-shaped blank.

In Figs. 1 and 2, *a* is the transverse web, and *b* the lateral webs, each of which is in my invention made of sufficient width to bend into a semicircle and lap upon the edge of the web *a*. The edges of the webs *b* may be scarfed and overlapped, as shown in Fig. 3, or they may be butted together, as shown in Figs. 4 and 5. The pipe may be made of metal adapted only for soft solder, or of copper,

brass, and harder materials adapted for brazing. The pipe may also be made of iron, in which case the transverse web *a* may be formed heavier—that is, thicker—than the webs *b*, to sustain the pressure required in welding the edges of the lateral webs thereon, if required. Such welding is preferably effected by heating the entire blank to a suitable temperature, either before or after the lateral webs are bent in semicircular shape, and the blank, when thus heated, is passed through a die or between rolls adapted to compress the edges of the lateral webs upon the transverse web, to unite the edges of the three webs securely together. The operation of such rolls or dies is well known in the art, and the bending of the webs to bring their edges in contiguity may be effected by such rolls or dies during the welding operation, or the lateral webs may be bent with their edges in contact before they are heated. The lateral webs may be partially bent when the blank is first formed, and thus adapted more readily for bending, with their edges in contiguity, as shown in Fig. 7, where the lateral webs are partly curved for subsequent shaping into a round pipe, and in Fig. 8, where the lateral webs are shown inclined to the transverse web at an angle of forty-five degrees, to facilitate their formation into a square pipe, like that shown in section in Fig. 5, where the lateral webs are butted against the transverse web. The pipe *c'* when completed appears, as shown in Fig. 6, with a solid partition connected rigidly, with its opposite sides extending lengthwise of the pipe, dividing its interior into two longitudinal spaces *c*. By making one of the webs *b* wider and the other narrower than they are shown in Fig. 1 the partition may be located somewhat at one side of the center, if it be desired to form unequal spaces within the pipe; but the process of bending the lateral webs and securing them upon the transverse web would be the same in such case.

As the article which I have invented is dependent upon the method described herein, the process and product are inseparable, and both are therefore claimed herein.

Having thus set forth my invention, what I claim herein is—

1. The process of making partitioned pipes,



which consists in first forming a blank of T-section with the lateral webs wider than the transverse web; secondly, bending the edges of the lateral webs over upon the edge of the transverse web, and, thirdly, securing the edges of the lateral and transverse webs together, substantially as herein set forth.

2. A partitioned pipe consisting in a transverse web formed with two integral lateral webs having their edges bent upon the edge

of the transverse web and secured thereto, substantially as set forth.

In testimony whereof I have hereunto set my hand in the presence of two subscribing witnesses.

JOHN J. HOGAN.

Witnesses:

CHARLES W. CHAPIN,  
WM. F. M. ROGERS.