

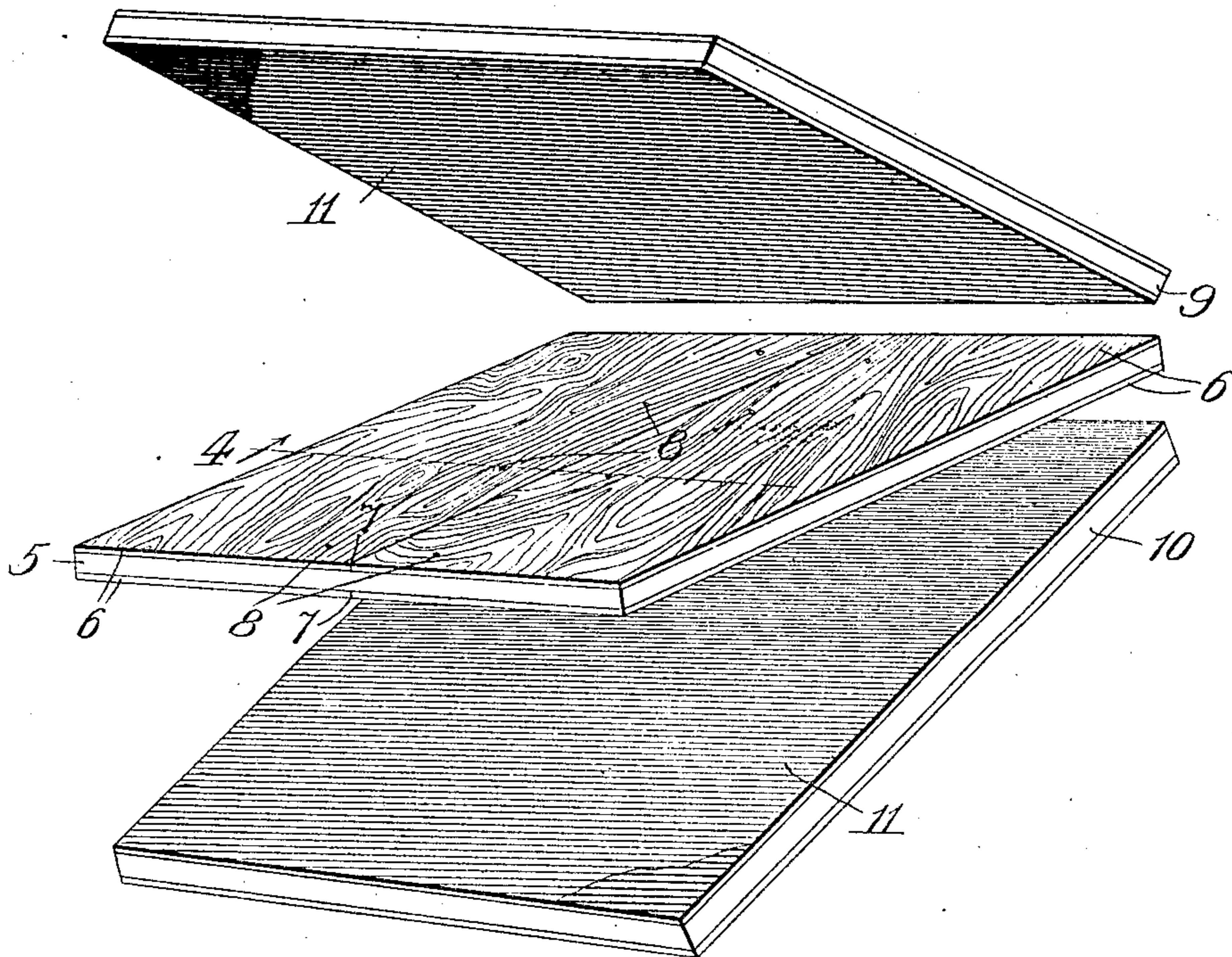
No. 882,203.

PATENTED MAR. 17, 1908.

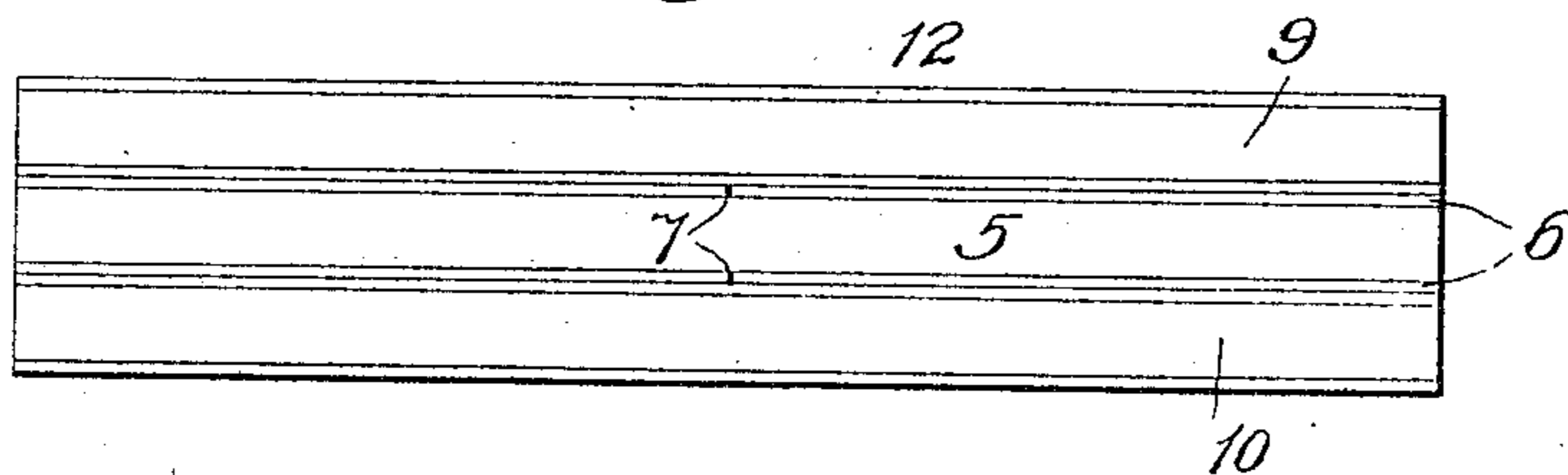
W. J. KELLY.  
METHOD OF VENEERING.  
APPLICATION FILED OCT. 12, 1907.

2 SHEETS—SHEET 1.

*Fig. 1*



*Fig. 2.*



Witnesses:

*John Enders,*  
*Ed. L. Gaylord,*

Inventor:

*William J. Kelly*  
*By Dyrenforth, Lee, Chritton & Will*  
*Attys.*

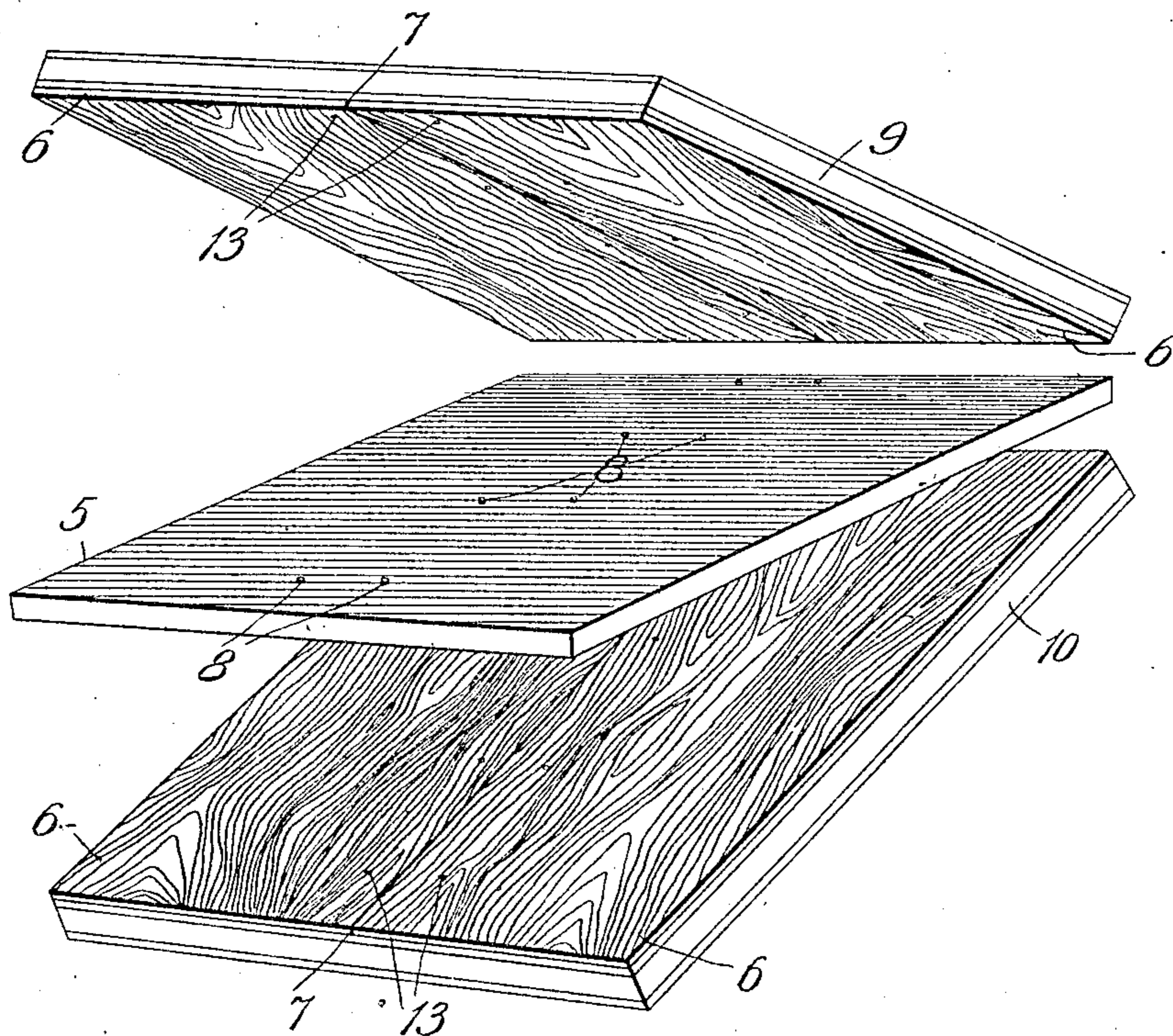
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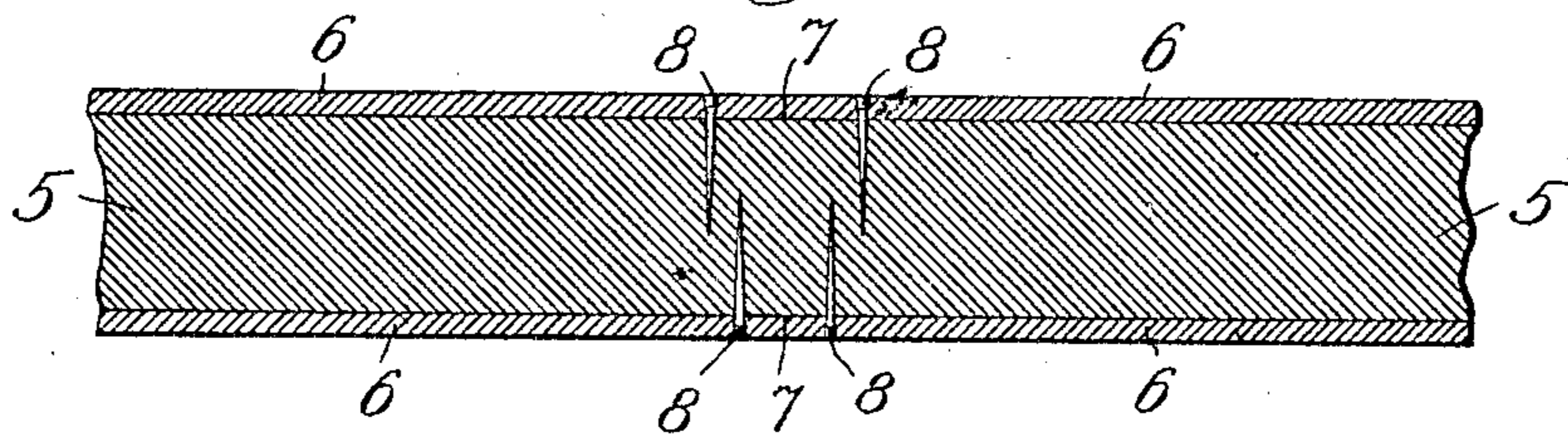
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2 SHEETS—SHEET 2.

*Fig. 3.*



*Fig. 4.*



Witnesses:

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E. S. Gaylord.

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# UNITED STATES PATENT OFFICE.

WILLIAM J. KELLY, OF CLINTON, IOWA.

## METHOD OF VENEERING.

No. 882,203.

Specification of Letters Patent.

Patented March 17, 1908.

Application filed October 12, 1907. Serial No. 397,130.

*To all whom it may concern:*

Be it known that I, WILLIAM J. KELLY, a citizen of the United States, residing at Clinton, in the county of Clinton and State of Iowa, have invented a new and useful Improvement in Methods of Veneering, of which the following is a specification.

My invention relates, more particularly, to an improvement on a commonly-practiced method of applying veneer, which involves the following-described procedure:

Sheets of veneer to be jointed are first applied flatwise with their edges abutting upon a surface of a "form", which is usually a mere flat piece of board, and small tacks or brads are driven at intervals through the sheets near their contiguous edges and into this form to temporarily hold them together. The tacks are only driven partway so as to leave their heads projecting, in order that they may be readily drawn. Glue is then spread upon the veneer-sheets along the joint between them, which is thereupon covered by a strip of tape, paper, or the like, cemented in place by the glue and affording a secure fastening, when the glue has set, for the joint during the handling of the joined veneer-sheets in applying them to the glue-coated surface to be veneered and drying them upon the latter under pressure. The tacks are then drawn and the joined sheets are removed from the form and applied upon the glue-coated surface of the piece to be veneered termed a "core", and which may be a board of laminated wood. It is usual to veneer both sides of such cores in the same way as that described of veneering one side. A plurality of the veneered cores, before the glue sets, are stacked in a press with thin strips of zinc covering the taped joints to prevent the glue on them from cementing together the opposing surfaces. When the work has been dried under the pressure to which it is subjected in the press, it is removed therefrom, the zinc strips are taken away and the tapes are stripped off, whereupon the veneer-surfaces at the joints are subjected to the abrading action of sand-rolls to remove the dried glue and any remnant of tape that may not have yielded to the stripping. The procedure thus described presents various objections, among which may be mentioned that it is troublesome and expensive, requiring skilled workmen; that the glue tends to clog and thus impair

the abrading-rolls, and that the abrading tends to mar the surface acted upon. All these objections are overcome by my invention, which greatly facilitates the work, enabling it to be performed by unskilled hands, avoids the use of glue on the joints and of the tapes and zinc strips referred to, and thus renders any abrading operation unnecessary.

To practice my improved method, the veneer sheets are applied on a "form", to which they are fastened with brads, or the like, as heretofore, though the brads are fully driven to bring their outer ends flush with the veneer-surface. Both sides of the form usually have the veneer-sheets thus applied to them. Thereupon the form with the veneer-sheets upon it is applied to the glue-coated surface of a core to cause adherence thereto of the veneer. A stack of cores having glued to their surfaces the veneered sheets on their forms is then placed in a press and dried; and on their removal the forms are stripped or torn off, one at a time, from the sheet-veneer surfaces to which they are nailed, this operation pulling the brads, or most of them, through the veneer, leaving unobjectionable minute holes therein. Should any of the brads fail of pulling through by the described stripping action, and thus remain in the veneer, they may be subsequently pulled out by means of pliers. Most, if not all, of them, however, will thus pull through and remain in the form, from which they may be readily drawn to prepare the form for repeated use. This method is illustrated in the accompanying drawing, in which

Figure 1 is a partly-broken perspective view in the nature of a diagram, showing the "form" with the veneer-sheets upon it and the "cores" with their glue-coated surfaces on opposite sides of the "form"; Fig. 2, a view in elevation of the "form" between two "cores"; Fig. 3, a perspective view like that presented in Fig. 1, showing the "cores" stripped from the "form" to separate therefrom the veneer-sheets, and Fig. 4, a section taken at the line 4 on Fig. 1 and viewed in the direction of the arrow.

The "form" is shown as a rectangular flat-surfaced board 5, on each side of which are applied two sheets 6, 6, of veneer in a manner to abut them along their adjacent edges and form the joint-line at 7, near which brads 8

are driven at intervals through the sheets into the "form" to cause their heads to extend flush, or approximately so, with the outer surfaces of the sheets, as represented in Fig. 4. The material to be veneered is represented as rectangular boards 9 and 10, affording the "cores", shown to be of the same shape as the "form" and which are usually made up of laminated wood. The glue with which each surface of the "cores" to be veneered is coated is represented at 11 in Fig. 1. When the glued surfaces of two "cores" are applied to the opposite veneer-carrying sides of a form 5, a "set" 12 will be produced, such as is represented in Fig. 2, each "set" thus consisting of a "form" with veneer-sheets nailed to its opposite surfaces, interposed between the glue coated surfaces of two "cores". Such "sets" are stacked, in any desired number, in the ordinary press used for the purpose, to be dried therein while under subjection to the necessary pressure while the glue is setting. On releasing the pressure and removing the work from the press, the "cores" are pulled away from the "form", thereby stripping the heads of the nails 8 (if they have heads, though headless fasteners may be used) through the veneer, leaving unobjectionable minute holes 13 in the latter, the nails clinging to the "form" and projecting from its surfaces, as represented of one of such surfaces in Fig. 3, whence they may be conveniently drawn to adapt the "form" to be used again.

35 The saving over the former method of veneering hereinbefore explained, due to my improvement is very great, its practical application having demonstrated a saving in labor alone of seven and one-half dollars on every thousand feet of veneer handled, besides the saving in glue and tapes, and that

in sand-paper and the labor in running the stock through the abrading machine, which add materially to the amount specified.

What I claim as new, and desire to secure by Letters Patent, is—

1. The method of veneering, which consists in applying sheets of veneer with their edges contiguous to a form-surface and nailing them thereto at intervals along their said edges, applying the veneer-carrying surface of said form to the glue-coated surface of a core to be veneered, subjecting the veneer on said core-surface to pressure and drying, and stripping the form from the veneer.

2. The method of veneering, which consists in applying sheets of veneer with their edges contiguous to a form-surface and nailing them thereto at intervals along said edges by driving nails flush, or approximately flush, with the veneer-surface, applying the veneer-carrying surface of said form to the glue-coated surface of a core to be veneered, subjecting the veneer on said core-surface to pressure and drying, and stripping the form from and thereby drawing the nails through the veneer.

3. The method of veneering, which consists in applying sheets of veneer with their edges contiguous to opposite sides of a form and nailing them thereto at intervals along said edges, applying the veneer-carrying surfaces of said form to the glue-coated surfaces of cores to be veneered, subjecting a stack of said cores with the interposed forms to pressure and drying, and stripping the forms from and thereby drawing the nails through the veneer.

WILLIAM J. KELLY.

In presence of—

R. C. LANGAN,  
J. C. LANGAN.