W. WALLICK.

Apparatus for Enamelling Moldings.

No. 163,825. Patented May 25, 1875.

FIG. 8.

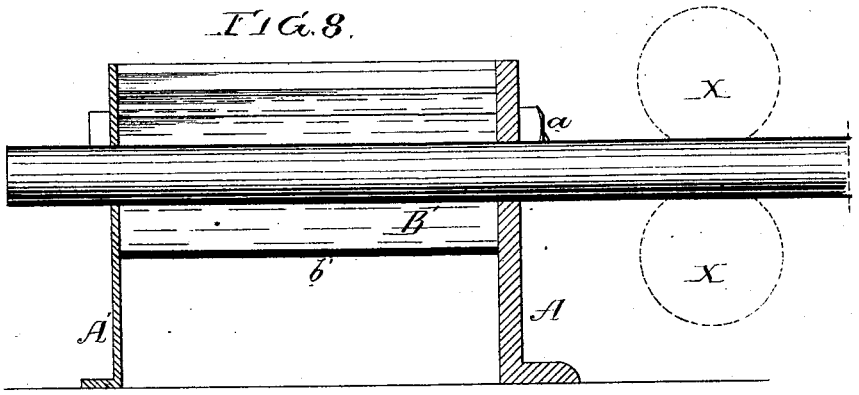


FIG. 9.

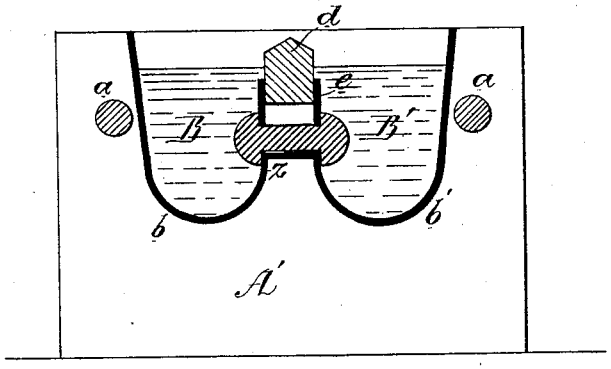


FIG. 1.

FIG. 2.

FIG. 5.

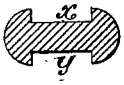
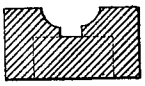


FIG. 7.

FIG. 3.

FIG. 6.

FIG. 4.



Witnesses, Hubert Howson
Thomas M'Ilvain

Washington Wallick
by his Attys.
Howson & Howson

UNITED STATES PATENT OFFICE.

WASHINGTON WALLICK, OF PHILADELPHIA, PENNSYLVANIA.

IMPROVEMENT IN APPARATUS FOR ENAMELING MOLDINGS.

Specification forming part of Letters Patent No. **163,825**, dated May 25, 1875; application filed October 16, 1874.

To all whom it may concern:

Be it known that I, WASHINGTON WALLICK, of Philadelphia, Pennsylvania, have invented certain Improvements in the Manufacture of Enameled Moldings, of which the following is a specification:

The object of my invention is a rapid and economical production of enameled moldings of the character shown in Figures 1, 2, and 3 of the accompanying drawing; and this object I attain in the manner and by the apparatus described hereafter.

In order that my invention may be thoroughly understood it will be advisable to refer to the mode ordinarily practiced of making enameled moldings of this class.

In making the molding, Fig. 2, for instance, it is usual to take a strip of wood of the form shown in Fig. 7 and pass it several times through what is well known as the marcher-box, the strip resting on the bottom of the reservoir containing the enameling composition. After the proper number of coats of enamel have been given to the strip the latter is cut away from the under side to the line 1 2, and the strip is then planed away by hand, so as not to disturb the enamel, until nothing remains but the two rounded moldings.

In making moldings like Fig. 3, according to the usual practice, a strip of wood of the form shown in Fig. 4 is first made, and after its upper surface has been enameled by passing it through the marcher-box, a longitudinal recess (shown by dotted lines) is cut in the back of the strip, first by a planing-machine, and then by a hand-plane, until nothing remains but the two enameled strips, like that shown in Fig. 3.

It will be observed that in neither of these cases can feed-rollers be used for passing the strips through the marcher-box without disturbing the coats of enamel, on which the upper feed-roller must bear.

The main aim of my invention has been to so construct an enameling-box and so form the strips of wood that feed-rollers may be employed to pass the strips through the reservoir containing the enameling composition.

For enameled moldings like Figs. 1 and 2, for instance, I prepare a strip of wood, Fig. 5, with a groove, *x*, above for receiving the upper feed-roller, and a groove, *y*, below for receiving the lower feed-roller, and then pass the strip through an enameling-box of peculiar construction, so that the rounded edges only are coated, and when these edges have received the proper number of coats I sever the strip, so as to produce either of the moldings, Figs. 1 and 2.

For making moldings like Fig. 3 I prepare a strip of the form shown by Fig. 6, so that upper and lower feed-rollers may be used to force the strip through the enameling-box.

After the edges of the strip have been properly enameled I sever it in the middle, thereby producing two moldings like Fig. 3.

The box by which the enamel is applied to these strips is illustrated in the vertical section, Fig. 8, and transverse vertical section, Fig. 9, of the accompanying drawing, the box being, in the present instance, arranged for enameling the strip, Fig. 5.

A and A′ are two plates, which are confined by suitable bolts *a a*, two bent plates, *b b′*, forming, under the circumstances explained hereafter, two reservoirs, B B′, for containing the fluid or semi-fluid enameling composition. The distance between the turned-up portion *z* of one plate, *b*, and that of the other plate is equal to the width of the groove *y* of the strip, Fig. 5. A permanent longitudinal bar, *d*, extends from the plate A to the plate A′, and to each side of this bar is secured a plate, *e*, of metal, the distance across the bar and its two plates being equal to the width of the groove *x* of the strip, Fig. 5, against the edges of which groove the said plates bear.

In each of the plates A and A′ there is an opening, conforming in shape and dimensions to that of the strip, Fig. 5, and these openings bear such relations to the turned-up edges of the plates *b b′* and to the bar *d* that the strip, when introduced into the box, will be in the position shown in Fig. 9, so that no parts of the strip, excepting the rounded edges, are exposed to the enameling composition. After thus passing the end of the strip of molding through the openings in the plates A A′, the composition may be introduced into the reservoirs B B′, for all avenues for the escape of the fluids are cut off by the strip itself.

Feed-rollers X X (shown in dotted lines) may be used for forcing strip after strip through the enameling-box, the said rollers in no way interfering with the different coatings of enamel, because they are never in contact with the enameled surfaces.

In other words, the enameling-box is separated into two reservoirs, partly by a permanent partition and partly by the strip, which is passed through the box so that the edges only of the strip are exposed to the enameling composition, one edge to the composition in one compartment and the other edge to that in the other compartment.

I claim as my invention—

An enameling-box divided into two compartments by a slotted partition, and having openings at the ends in a line with the slot in the partition, all substantially as and for the purpose set forth.

In testimony whereof I have signed my name to this specification in the presence of two subscribing witnesses.

WASHINGTON WALLICK.

Witnesses:
HUBERT HOWSON,
HARRY SMITH.