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BY A. P. C.

B. AAS
METHOD FOR THE CUTTING OF THE BEVEL ON
HULL PLANKS IN CARVEL BUILT VESSELS
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Fig. 1

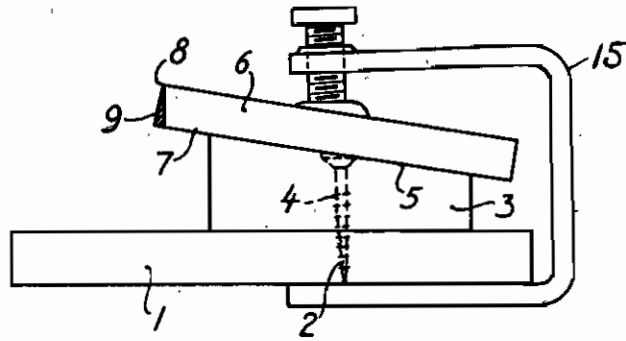


Fig. 2

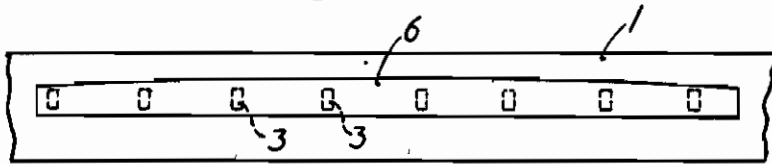
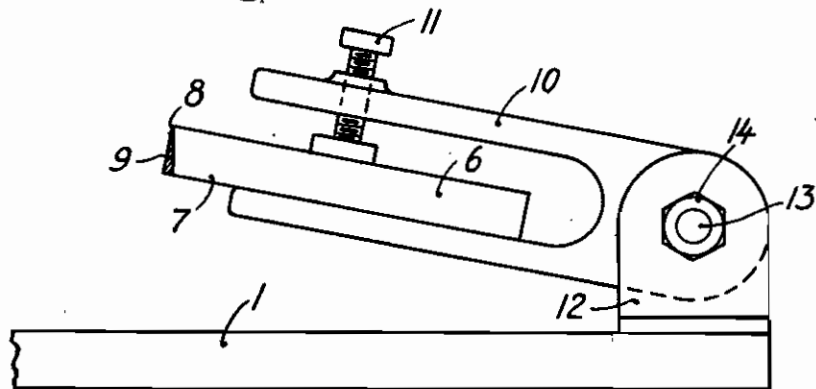


Fig. 3



Bjarne Aas
By
Haton, Cole, Grindle & Haton
ATTORNEYS

ALIEN PROPERTY CUSTODIAN

METHOD FOR THE CUTTING OF THE BEVEL ON HULL PLANKS IN CARVEL BUILT VES- SELS

Bjarne Aas, Fredrikstad, Norway; vested in the
Allen Property Custodian

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The usual method of cutting the bevel on hull planks in carvelbuilt vessels is to first mark the bevel angles on a board and then by means of a gauge control the different bevel angles along the planks as they are cut, the planks being clamped down to a bench in a vertical position.

The method according to the present invention is characterised therein that the planks when the bevel is to be formed by planing or other working method is clamped to a table or the like at an angle relatively to the same corresponding to the bevel angle of the plank at every point along the length of the plank, so as to allow the continuous bevel form to be obtained by means of a tool, the cutting edge or edges of which is or are perpendicular to the said table. If a tool is used the edge or edges of which is or are at another angle to the table, this must be considered at the determination of the angle at which the plank is to be clamped to the table or support. Conveniently the plank is clamped on wooden blocks or in clips spaced at suitable intervals along the table, for instance in accordance with the frame spacing of the vessel, the blocks or clips being so adjusted that the plank when clamped, is situated at angles to the table corresponding to the bevel angle at each individual point.

In order to enable the tool to be passed continuously along the length of the plank during the cutting, the edge of the plank is arranged so as to extend freely outwards from the blocks or clips.

The cutting or planing may be carried out by hand or by means of a planing machine or may, if desired, be carried out by means of a cutter or another suitable tool, and the cutting may be completed in one operation.

The accompanying drawing illustrates schematically some embodiments of arrangements suitable for the carrying out of the method according to the invention.

The figures 1 and 2 illustrate the use of blocks arranged on a table for securing the plank in the desired position relatively to the table. 1 designates the table which is provided with holes 2 in places where it is desired to locate blocks 3. The blocks are secured to the table 1 by means of screws or nails 4. The top surfaces 5 of the blocks 3 are inclined relatively to the table 1 corresponding to the bevel angle to which the plank 6 is to be cut at that particular point. The plank is clamped against the surfaces 5 by means of clamping frames 7 or other suitable means, and a portion 8 of the plank extends freely beyond the blocks 3, whereby the cutting tool may be passed along the whole length of the plank unhindered by the blocks. The portion 9 of the plank which is to be cut away in order to obtain the bevel form is bounded by a line extending perpendicularly from the edge 10 of the plank of the table 1, and may be cut away by means of a tool passed along the table and having its cutting edge perpendicular to the same. The operation may also conveniently be carried out by means of a rotating mechanical tool. As each individual block adjusts the plank at an angle corresponding to the bevel at that particular point of the same, a continuous smooth surface of correct bevel angles along the whole length of the plank is obtained.

As shown in figure 3 the plank 6 may be fastened in clamping frames 10 with screws 11, each clamping frame being pivoted on a support 12 by means of a pin 13, the support being secured to the table 1, for instance by means of screws. The clamping frames 10 then are adjusted so that the plank 6 at each frame is adjusted according to the bevel angle in relation to the table 1, and is then locked in this position for instance by means of a nut 14. The cutting is carried out in the manner described in connection with the figures 1 and 2.

BJARNE AAS.