

Fig. 1.

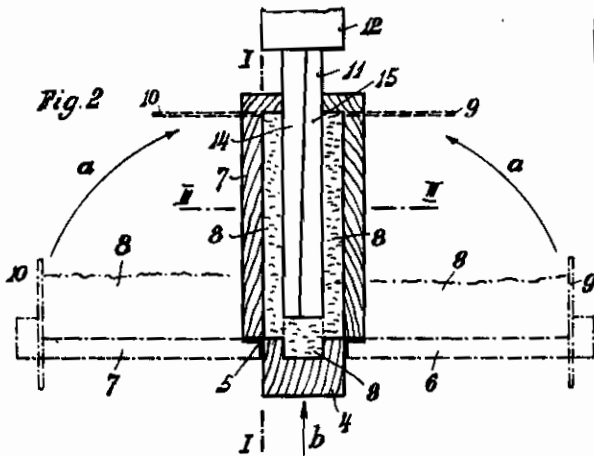


Fig. 2.

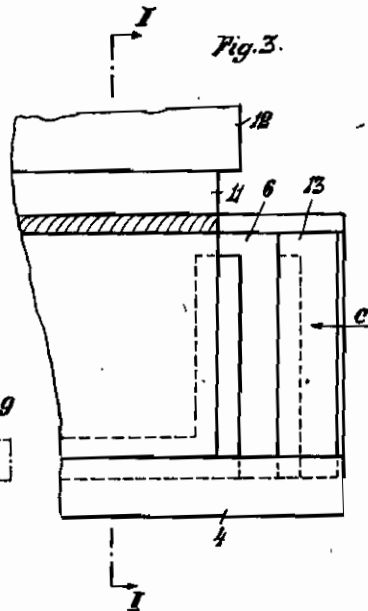
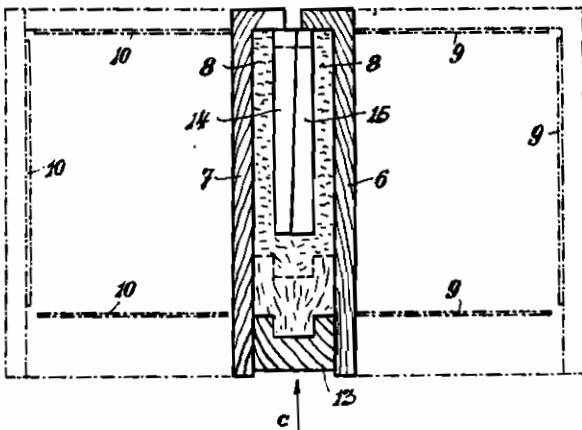


Fig. 3.

Fig. 4.



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ALIEN PROPERTY CUSTODIAN

PROCESS FOR THE MANUFACTURE OF HOLLOW BODIES

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This invention relates to a process for the manufacture of hollow bodies for building purposes, which bodies are made of some moldable material, for example, some porous building material, such as wood wool, wood fibres, wood chips, peat wool and the like, bound together by some adhesive. Although this process is not confined to the manufacture of hollow bodies of some definite shape, the said process will be now explained in connection with the manufacture of a molded body consisting of two sheets parallel to, and spaced from, one another and interconnected by a cross beam of angular shape interconnecting the two plates so that the said beam will by a certain length extend beyond the said plates, the said plates and beam forming one piece.

In the drawing, Fig. 1 is a perspective view of such hollow body according to the invention. The said body consists of prismatic plates 1 and 2, parallel and adjacent to, and spaced from, one another, an angular beam interconnecting the said plates 1 and 2.

The process for the manufacture of such body may be seen from Figs. 2 to 4, Fig. 2 showing on line II—II of Fig. 3 a section of the mold, in which the body is formed. Fig. 3 is a section on line I—I of Fig. 2 and shown in elevation. Fig. 4 is a plan section on line III—III of Fig. 2.

The mold is formed of a beam 4 which, for example, is made from wood and on which plates 6 and 7 are pivoted at 5. For the purpose of forming the body, the mold is opened, the plates 6 and 7 getting into the position shown in dotted lines in Fig. 2. The said plates will thus lie horizontally, so that the material 8 previously produced by mixing its ingredients may be poured out upon the three parts 4, 6 and 7 of the mold. If the layer of material poured out is of substantial height, care must be taken to prevent material from laterally escaping. For that purpose, the plates 6 and 7 are provided with slits through which sheets 9 and 10 are passed. The material is thereby laterally delimited. For the formation of the space between plates 1 and 2, a core 11 consisting of two parts 14, 15, is placed

into the mold. Such parts are preferably formed like wedges and so that they are provided with a gradient of cotter extending in two directions vertical to each other, as shown in Figs. 2 and 4. Such formation of the core is chosen in order to facilitate decomposition of the mold. The core is retained within the mold by a clamping device 12 not specified and not shown in respect of its details. These preparations having been made, compression of the material is effected by turning upward the side parts 6 and 7 of the mold about the axis of rotation 5, so that their position becomes vertical, as shown in Figs. 2 to 4, parts 6 and 7 enclosing core 11. When the mold is closed, the sheets 9 and 10 are adjacent to the core 11 and in this position are forced backward through the slits engaging them. The mold being closed, these sheets may be removed from the said slits. While the mold is being closed or after such closing, compression of the material below the core may be effected. Such compression may take place in two manners, one of which is indicated by arrows *b* in Fig. 2. The closed mold is forced against the retained core 11, so that this core will be displaced relatively to the mold and the material 8 compressed accordingly and that until the desired shape of the body is attained.

The other possible course is to place the core into the mold, so that it may be displaced therein, and forced into the mold upward by means of a die not shown in the drawing, the mold remaining in its place.

When forming the body according to Fig. 1, it is necessary during compression, to exert pressure to the material in the direction *c* shown by arrows in Fig. 3. For that purpose, a beam 13 is loosely inserted between the fixed plates 6 and 7. This beam is displaced in a horizontal direction so that it may better penetrate into the depth of the mold. Pressure in direction *c* may be dispensed with in the case of bodies which are to be given another shape, without thereby altering the nature of the invention.

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