Feb. 22, 1927. 1,618,796

T. BAKER

COMBINED METAL AND FIBER GASKET

Filed July 8, 1926

Fig. 1.

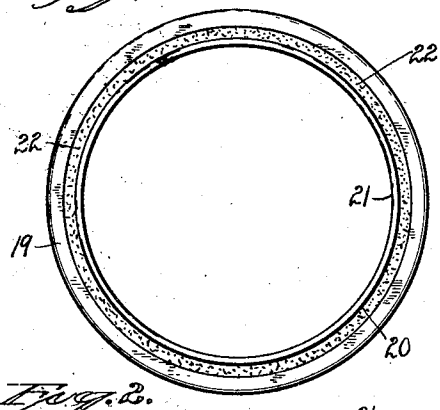


Fig. 2.

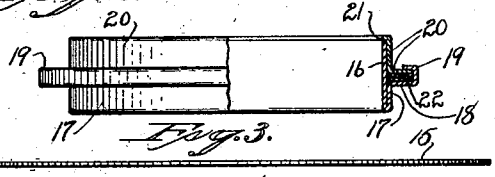


Fig. 3.

Fig. 4.



Fig. 5.



Fig. 6.

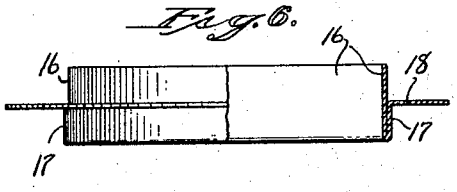


Fig. 7.

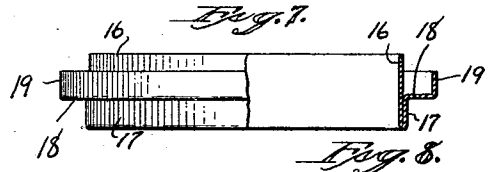


Fig. 8.

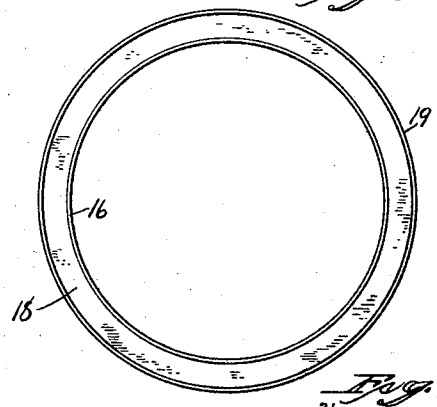


Fig. 9.

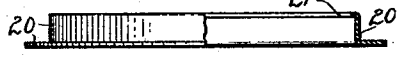


Fig. 10.

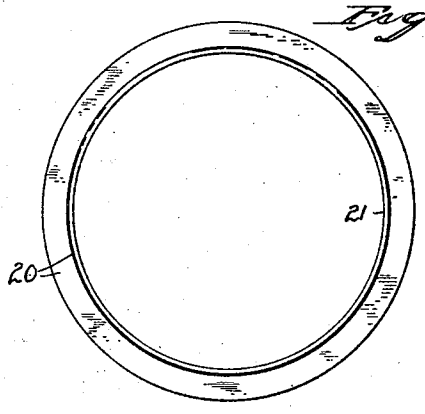


Fig. 11.

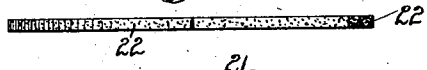
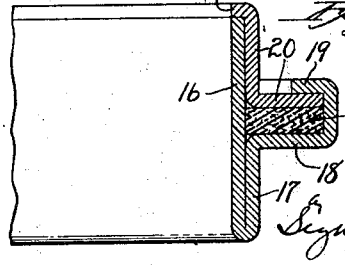


Fig. 12.



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UNITED STATES PATENT OFFICE.

THOMAS BAKER, OF WATERBURY, CONNECTICUT, ASSIGNOR TO CHASE COMPANIES, INC., OF WATERBURY, CONNECTICUT, A CORPORATION.

COMBINED METAL AND FIBER GASKET.

Application filed July 8, 1926. Serial No. 121,129.

Fig. 1 is a plan view of my improved gasket;

Fig. 2 is an edge view thereof, partly in section;

Fig. 3 is an edge view of the disk-blank, from which the metal body of the gasket is formed;

Fig. 4 is a view partly in edge elevation and partly in section of the said blank as initially cupped;

Fig. 5 is a similar view after the cupped central portion of the blank shown by Fig. 4 has been reversely cupped;

Fig. 6 is a similar view showing the reversely-cupped central portion of the blank as cut out and the remaining parts expanded and folded upon each other;

Fig. 7 is a similar view, showing the metal body of the gasket as completed, ready for the reception of the fiber washer and complementary metal cap;

Fig. 8 is a plan view thereof;

Fig. 9 is a view partly in edge elevation and partly in section of the metal gasket-cap;

Fig. 10 is a plan view thereof;

Fig. 11 is a view partly in edge elevation and partly in section of the fiber washer of the gasket; and

Fig. 12 is a broken sectional view on an enlarged scale of the gasket as completed.

My invention relates to an improvement in that class of gaskets commonly known in the trade as "copper asbestos gaskets," the object being to reduce the cost of producing such gaskets by reducing the number of their parts and simplifying the assemblance thereof.

With these ends in view, my invention consists in a gasket of the character mentioned, having certain details of construction as will be hereinafter described and pointed out in the claims.

In carrying out my invention as herein shown, I first take a metal disk 15, preferably of copper, though I do not limit myself to the use of any one metal or metal composition. This disk 15 is drawn by one or more usual drawing operations into the cupped form shown by Fig. 4. The cupped blank shown by Fig. 4 is then subjected to one or more drawing operations, whereby its central portion is reversely cupped, as shown by Fig. 5. The reversely-cupped blank now has its central portion cut away, after which it is expanded and folded upon itself into the form shown by Fig. 6. The partly-developed blank now comprises an inner ring 16, an outer half-ring 17 folded up against the outer periphery of half of the ring 16, and a bearing-flange 18 offsetting at a right angle from the half-ring 17, so as to lie in a plane at a right angle to the axis of the ring 16. The outer edge of the bearing-flange 18 is turned upwardly at a right angle to produce the retaining-flange 19, shown by Fig. 7, which shows the metal body of the gasket ready for assemblance with the two remaining elements of the gasket,—namely, the metal cap 20, which is angular in cross-section and is, by preference, formed with an inwardly-turned lip 21, and the fiber ring or washer 22, which may be of asbestos or any other suitable material.

In assembling these three gasket-elements, the fiber washer 22 is positioned upon the bearing-ring 18 within the flange 19 thereof. The cap 20 is then set over the said washer or ring, and the edge of the retaining-flange 19 turned over upon the outer edge of the cap, as shown in Figs. 1, 2 and 12.

The gasket as thus produced contains but two metal parts and these parts are of such character that they are readily and accurately assembled.

I have described my improved gasket as a copper asbestos gasket, which is the usual trade name, but I would have it understood that I do not limit myself to the use of copper or asbestos, as any equivalents thereof may be employed without departing from my invention.

I claim:

1. As a new article of manufacture, a copper asbestos gasket, consisting of a metal body comprising an inner ring, an integral outer half-ring folded upon the outer periphery of the said inner ring, and an integral bearing-and-retaining flange offsetting from the said half-ring; a metal cap of angular cross-section adapted to fit over the said inner ring of the said body, and a fiber washer interposed between the said bearing-flange and cap, and the cap being held in place by a lip formed by turning the edge of the retaining-flange over upon the said cap.

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2. A method of producing copper asbestos gaskets, consisting in first cupping and then reversely cupping a metal disk-blink, then cutting out the bottom of the cup and further shaping the blank to form an internal ring, an external half-ring and an offsetting bearing-and-retaining flange, then positioning a fiber washer upon the said bearing-flange, and then placing a metal cap upon the said washer and folding the edge of the retaining-flange over the said cap.

In testimony whereof, I have signed this specification.

THOMAS BAKER.