

A METHOD FOR MANUFACTURING A HEAT INSULATING SASH
BAR

The present invention relates to a method of manufacturing a heat insulating sash bar for a window sash or, more particularly, to a method of manufacturing a heat insulating sash bar of which remarkably improved heat insulation is obtained between two face plates of the sash bar, one for facing the inside of the room and the other for facing the outside of the room, connected with two connecting members made of heat insulating material in such a manner as to form a hollow space surrounded by the face plates and the heat insulating connecting members.

As is well known, many of the modern window sashes are framed with sash bars made of a metal such as aluminium and shaped by extruding in the form of bar materials. When such window sashes are to be used in severe climatic conditions, there may be a problem in the use of an integrally shaped metal-made sash bar in respect of the heat insulation between the inside of the room and the outside of the room since the conduction of heat through the integrally shaped sash bars is considerable due to high heat conductivity of aluminum or the like metal of which the sash bar is made.

In this connection, it is desirable that the two oppositely positioned face plates forming the sash bar, one for facing inside of the room and the other for facing the outside of the room, are not integral but are isolated thermally from each other with connecting members made of a heat

insulating material. However, such a sash bar has hitherto been manufactured only with great consumption of time and labour in comparison with an integral metal-made sash bar which can be manufactured by a very efficient process of extrusion and the like alone and the dimensional accuracy of such a heat insulating sash bar is sometimes unsatisfactory depending on the skill of the workers.

It is believed possible by means of the present invention to provide a novel and very efficient method for the manufacture of the heat insulating sash bar of the above described type having a hollow space in the cross section thereof.

Another believed possibility of the invention is to provide a method capable of giving a high dimensional accuracy to the heat insulating bar of the above described type.

According to the invention there is provided a method of manufacturing a heat insulating sash bar comprising two oppositely positioned face members of the sash bar, one for facing inside of a room and the other for facing outside of the room, connected with a connecting member made of a heat insulating material which comprises the steps of:

inserting the connecting member made of a heat insulating material into a channel of a metal-made integral bar material formed by connecting two oppositely positioned face members with a connecting part to form at least one said channel on one side thereof;

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securely fixing the connecting member made of a heat
insulating material to both of the face members by
caulking the face members into the connecting member;
removing longitudinally at least partly the connecting
part of the bar material whereby to thermally isolate
5 the face members from each other by not being connected
with the metal-made connecting part; forming a
longitudinally extending hollow space and a channel within
the bar material; and
filling the thus formed channel with a heat insulating
10 material.

The invention will be described by way of example
with reference to the accompanying drawings, wherein:-

Figures 1a to 1e illustrate respectively
successive steps of a preferred form of the inventive
15 method, showing the cross section of the sash bar at
each step;

Figure 2 is a perspective view of the connecting member
made of a heat insulating material used in the sash bar
illustrated in Figures 1a to 1e;

20 Figures 3a to 3d illustrate respectively successive
steps of a preferred form of the inventive method, showing
the cross section of the sash bar at each step; and

Figure 4 is a perspective view of the connecting
member made of a

heat insulating material used in the sash bar illustrated in Figures 3a to 3d.

Figure 1a is a cross section of a bar integrally made of a metal such as aluminum. The cross section of this bar is, as a whole, approximately H-shaped, being composed of two oppositely positioned face members 1,10 and a connecting part 20 connecting the face members 1,10 at about the centre lines thereof. The connecting part 20 partitions the space between face plates 2,12 of the respective face members 1,10 into two channels 30,40. In other words, each of the channels 30,40 is formed with the connecting part 20 as the bottom and the face plates 2,12 of the face members 1,10 as side walls, respectively.

Each of the face members 1,10 is provided with the respective face plate 2 or 12 and two inwardly extending flanges 3,4 or 13, 14 along the peripheries and further provided with a shelf-like intermediate flange 5 or 15. Each of the flanges 3,13 has a cross section something like a triangle surrounded by the face 3a or 13a extending perpendicular to the face plate 2 or 12 and downwardly extending wedge-like face 3b or 13b.

The connecting part 20 is also provided with two protrusions 22,22 on one surface 21a along the edges of the plate 21. Each of the protrusions 22,22 also has a triangular cross section with a ridgeline facing the flange 3 or 13.

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As is shown in Figure 1b, an elongated connecting member 50 made of a heat insulating material is inserted into the first channel 30 of the H-form bar in the longitudinal direction thereof and is securely fixed by bending inwardly and caulking the flanges 3,13 to the face members 1,10.

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The connecting member 50 has a configuration as illustrated in Figure 2 by a perspective view. That is, it is an elongated bar having top and bottom surfaces 51,52, left and right surfaces 53,54 and end surfaces 55,55 to give an approximately rectangular cross section as a whole. Two grooves 56,56 each having a V-shaped cross section are provided on the top surface 51 of the connecting member 50 to fit and be engaged with the triangular protrusions 22, 22 when the connecting member 50 is inserted into the channel 30 of the bar with H-form cross section. Similarly, two grooves 57,57 each having a V-shaped cross section are formed on the bottom surface 52 of the connecting member 50 along the peripheries of the bottom surface 52. It is preferable that the connecting member 50 is provided with a through-hole 58 extending in the longitudinal direction. This hollow space 58 in the connecting member 50 contributes to an improvement of heat insulation and to a decrease of the weight of the sash bar.

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The connecting member 50 should be highly heat insulating and heat resistant as well as mechanically strong enough to ensure rigidity of the finished sash bar and preferable material for the connecting member 50 is a thermosetting synthetic resin or certain kinds of

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ceramic materials. It is preferable that at least one of the side surfaces of the V-shaped grooves 57 is provided with a strip 59' of elastic pad made of a soft flexible synthetic resin or a rubber in order to enhance the caulking effect by bending the flanges 3,13 into the grooves 57,57. In this manner, the connecting member 50 is securely fixed to the face members 1, 10 by virtue of the engagement of the protrusions 22,22 and the V-shaped grooves 56,56 and caulking of the flanges 3,13 into the grooves 57,57 with resilience of the elastic pad 59',59'.

In the next place, a cutter 60 is inserted into the second groove-like channel 40 of the H-wise bar material and the central portion of the connecting bar 20 is cut off by the cutter 60 and removed to disconnect the face members 1,10. Thus, the face members 1,10 are connected together only through the heat insulating connecting member 50 and not by an aluminum part so that the face members 1,10 are thermally isolated from each other. In this case, the relative position of the face members 1 and 10 is kept unchanged owing to the secure fixing of them to the connecting member 50.

The next step is to put a sheet- or board-like material 61 on and bridging the shelf-like flanges 5,15 to span over the hollow space 62 formed with the connecting member 50 below the narrowed groove-like channel 40.

The last step is filling of the thus formed channel 40

with a heat insulating material 63 as is shown in Figure 1e.

Referring now to Figures 3a to 3d, Figure 3a shows a bar integrally shaped by extrusion, having a U-shaped cross section as a whole composed of two face members 1,10 connected at each periphery thereof by a connecting part 20 to form a channel 31 with the connecting part 20 as the bottom and the face members 1,10 as the side walls. Similarly to the first embodiment illustrated in Figures 1a to 1e, each of the face members 1,10 is formed of a face plate 2 or 12 provided with a flange 3 or 13 having a triangular cross section at the free periphery and two intermediate flanges 5,6 or 15,16, of which the flange 6 or 16 close to the peripheral flange 3 or 13 also has a triangular cross section with a ridge facing toward the peripheral flange 3 or 13.

In this case, the heat insulating connecting member 50 to be inserted into the channel 31 between the face plates 2 and 12 and between the peripheral and intermediate flanges 3,13 and 6,16 has a configuration illustrated in Figure 4 by a perspective view. The general cross sectional configuration is about the same as that of the corresponding member shown in Figure 2 with the V-shaped grooves 56,56 and 57,57 to engage with the triangular intermediate flanges 6,16 and peripheral triangular flanges 3,13 caulked thereinto except that a fin-like supporting plate 59 is provided above the top surface 51 of the main body of the member 50. The height of this fin-like supporting plate 59 above the top surface 51 should be such that,

when the connecting member 50 is inserted into the channel 31 of the aluminum-made bar material as is shown in Figure 3b, the upper surface of the fin-like supporting plate 59 is approximately in contact with the lower surfaces of the intermediate shelf-like flanges 5,15 to form a hollow space 62 surrounded by the top surface 51 of the connecting member 50, face plates 2,12, shelf-like intermediate flanges 5,15 and the fin-like supporting plate 59. Optionally, the height of the fin-like supporting plate 59 above the top surface 51 of the body of the connecting member 50 may be somewhat larger than above described so that the fin-like supporting plate 59 is in contact with the upper surface of the shelf-like intermediate flanges 5, 15 at the lower surface thereof to form a slightly larger hollow space 62 as well.

At any rate, both of the face members 1,10 are securely fixed to the connecting member 50 by the engagement of the triangular intermediate flanges 6,16 with the V-shaped grooves 56,56 and the triangular peripheral flanges 3,13 with the V-shaped grooves 57,57 by caulking thereinto with the aid of the elastic pads 59',59'.

Thereafter, the center portion of the connecting part 20 is cut off with a cutter 60 and removed as is shown in Figure 3c to form a longitudinally extending aperture 23 and a channel 41 with the supporting plate 59 and the shelf-like intermediate flanges 5,15 as the bottom and the face plates 2,12 as the side walls, respectively. In this manner, the face members 1,10 are thermally isolated from each other

as connected with no aluminum-made connecting part but only with the connecting member 50 made of a heat insulating material.

The final step of the method is, as is illustrated in Figure 3d, filling the groove-like channel 41 with a heat insulating material 63.

The above described second embodiment of the inventive method has advantages in several aspects over the first embodiment illustrated in Figures 1a to 1e. For example, in the first embodiment, the blade of the cutter 60 shown in Figure 1c sometimes reaches the top surface 51 of the connecting member 50 to more or less shave off the material of the connecting member 50 because the top surface 51 of the connecting member 50 is in intimate contact with the lower surface 21 of the connecting part 20 while, in the second embodiment such misuse of the cutter 60 cannot take place since the connecting part 20 to be cut off with the cutter 60 is positioned well above the top surface 51 or the fin-like supporting plate 59 of the heat insulating connecting member 50. In addition, the step of putting a sheet-like supporting member 61 on and bridging the flanges 5,15 in the first embodiment can be omitted because the single step of inserting the connecting member 50 into the U-shaped bar material simultaneously serves to form the bottom of the channel 41 with the fin-like supporting plate 59 brought into contact with the shelf-like intermediate flanges 5,15 so that the manufacturing process of the heat insulating sash bar is simplified

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Instead of cutting off part of the connecting part 20 with a cutter 60 as is described in the above embodiment, an alternative way is that the connecting part 20 be provided in advance with two parallel incision lines in the longitudinal direction and the portion between the incision lines be removed by merely tearing it off without using a cutting tool.

In spite of the very much simplified process for manufacturing the sash bar, the product sash bar has a high dimensional accuracy because the two oppositely positioned face members 1, 10, which have been positioned in the starting bar material not always with a high dimensional accuracy, are thermally isolated from each other by removing at least part of the connecting part 20 over the whole length thereof only after they are securely fixed by caulking to one and the same connecting member 50 having inherently a high dimensional accuracy inserted into the channel 30 or 31 therebetween. Furthermore impregnation of the channel 40 or 41 with the heat insulating material 63 can be performed after the face members 1, 10 have been securely fixed to the connecting member 50 to finish the product sash bar so that the time for the manufacture of the sash bar is

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greatly shortened in comparison with the conventional method in which cutting off of the connecting part is performed only after the heat insulating material filling the channel has been fully solidified taking a considerably long time.

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Claims:-

1. A method of manufacturing a heat insulating sash bar comprising two oppositely positioned face members of the sash bar, one for facing inside of a room and the other for facing outside of the room, connected with a connecting member made of a heat insulating material which comprises the steps of:

inserting the connecting member made of a heat insulating material into a channel of a metal-made integral bar material formed by connecting two oppositely positioned face members with a connecting part to form at least one said channel on one side thereof;

securely fixing the connecting member made of a heat insulating material to both of the face members by caulking the face members into the connecting member;

removing longitudinally at least partly the connecting part of the bar material whereby to thermally isolate the face members from each other by not being connected with the metal-made connecting part; forming a longitudinally extending hollow space and a channel within the bar material; and

filling the thus formed channel with a heat insulating material.

2. The method of claim 1 wherein each of the oppositely positioned face members of the bar material has a flange having an approximately triangular cross section and the connecting member has a groove having an approximately V-shaped cross section in such a position



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that the flange in the face member is engaged with the ~~groove~~
groove when the connecting member is inserted into the channel of the
bar material and the face member is caulked into the
5 connecting member at the flange.

3. The method as claimed in claim 1 or 2 wherein the
connecting part of the bar material has at least one
protrusion having an approximately triangular cross section
and the connecting member has at least one groove having
10 an approximately V-shaped cross section in such a position
that the protrusion in the connecting part is engaged
with the groove in the connecting member when the
connecting member is inserted into the groove-like portion
of the bar material.
